

Version No.

VALIDATING FORM

Product Name	26HP150
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	09/12/2018

Tool Number	GN26PAN#2
Resin/Additive Number	
Resin/Additive Descrip	
	Std.
	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :			
Final Part(s) Weight (g)	738.290	742.0	745.710

ALL DATA BELOW IS REFERENCE ONLY AND SETTINGS CAN BE ADJUSTED IF REQUIRED IN ORDER TO MEET PRODUCT STANDARDS

Barrel Temperatures	Set	Mold Cooling Temps	Set	Reference Data	Set	Machine Number: 725					
Nozzle Tip %	30	Mold Gate Temp °F	200	Fill Only Time	3.96						
Nozzle Body %	30	Mold Fixed ½ °F	300	Fill Only Weight	733.0						
Adapter (NH)	630	Mold Moving ½ °F	270	Steel Temp. "A" Side °F	312						
Barrel Front (H4)	725	Stripper or other °F		Steel Temp. "B" Side °F	276						
Barrel Center (H3)	740	Nozzle Tip Information		Melt Temp. °F	699						
Barrel Center (H2)	740	Type GP, FT, NYL	gp	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	710	Length OAL (in.)	2 3/4	Open Delay							
		Orifice Size (in.)	3/16	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	6.0	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	5.00	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	60.00	PrePullbk before stro		Transfer							
Injection Press 2	99.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3	99.00	Screw Chg Position 1	4.00	Position 1 Gate/HB/Man							
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	40.00	Position 3 Gate/HB/Man							
Injection Velocity 1	7.00	Screw recovery % 2	40.00	Position 4 Gate/HB/Man							
Injection Velocity 2	65.00	Back Pressure 1	55.00	Position 5 Gate/HB/Man							
Injection Velocity 3	55.00	Back Pressure 2	50.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	99.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.50								
Injection Change Pos 1	4.95	Screw positon after SB	5.61								
Injection Change Pos 2	3.00	Screw recovery time	17.80								
Injection Change Pos 3		Cooling time secs	26.00								
Injection Change Pos 4		Mold protect press	50.00								
Trans mode lvsh/lps		Mold protect time	5.00								
Trans pos in.	0.65	Clamp tonnage	717								
lps PSI		Injection pressure gauge	1455								
Inj PSI at transfer	1650	Holding 1 gauge psi	475								
Injection time act. secs.	3.96	Holding 2 gauge psi	400								
Hold Press 1 %	15	Back pressure gauge psi	250								
Hold Press 2 %	10	Back pressure gauge psi	175								
Hold Time 1	1.00	Final Cushion	0.51								
Hold Time 2											
Injection Hold Time	12.00										

Validated by: