

Version No.

## **VALIDATING FORM**

**JSW** 

Product Name	10CWCHN135
Material Number	11100
Material Description	CLEAR POLYCARB
Date Created	09/06/2018

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	38.00	39.5	39.50
Final Part(s) Weight (g	539.290	542.0	544.710

Tool Number	GN10HCOVER#2				
Resin/Aditive Number					
Resin/Aditive Descrip					
	Std.	Cert.			

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Final Part(s) Weight (g	539.290	542.0 544.710								
ALL DATA	BELOW IS R	EFERENCE ONLY AND SET	TINGS CAN	I BE ADJUSTED IF REQUIR	ED IN ORDE	R TO MEET	PRODUC	T STANDAR	RDS	
Barrel Temperatures	Set	Mold Cooling Temps	Set	Reference Data	Set	Machine Number: <b>718</b>				
Nozzle Tip %	3	Mold Gate Temp °F		Fill Only Time	3.20					
Nozzle Body %	3	Mold Fixed ½ °F	200	Fill Only Weight	539.0					
Adapter (NH)	630	Mold Moving ½ °F	140	Steel Temp. "A" Side °F	195					
Barrel Front (H4)	670	Stripper or other °F		Steel Temp. "B" Side °F	145					
Barrel Center (H3)	670	Nozzle Tip Informa	ation	Melt Temp. °F	655					
Barrel Center (H2)	670	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4	Ī	
Barrel Rear (H1)	640	Length OAL (in.)	2 3/4	Open Delay						
	•	Orifice Size (in.)	7/32	Open Time						
		Nozzle Body Inform	Nozzle Body Information						1	
		Length OAL (in.)	6.0	Close Delay						
Injection Profile	Set	Recovery & Clamp	Profile	Close Time						
Shot size in.	4.00	PrePullbk(PB2)speed		Inj HP End						
Injection Press 1	10.00	PrePullbck before stro		Transfer						
Injection Press 2	88.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6
Injection Press 3		Screw Chg Position 1	3.00	Position 1 Gate/HB/Man	630	640				
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man						
Injection Press 5		Screw recovery % 1	55.00	Position 3 Gate/HB/Man						
Injection Velocity 1	10.00	Screw recovery % 2	50.00	Position 4 Gate/HB/Man						
Injection Velocity 2	75.00	Back Pressure 1	55.00	Position 5 Gate/HB/Man						
Injection Velocity 3		Back Pressure 2	55.00	Position 6 Gate/HB/Man						
Injection Velocity 4		PostPullback(PB1)speed	45.00	Start-Up Instructi	ions / Comi	ments				
Injection Velocity 5		Post Pullback stroke in.	0.20							
Injection Change Pos 1	3.80	Screw positon after SB	4.65							
Injection Change Pos 2		Screw recovery time	7.58							
Injection Change Pos 3		Cooling time secs	25.00							
Injection Change Pos 4		Mold protect press	75.00							
Trans mode lvsh/lps	IVSH	Mold protect time	10.00							
Trans pos in.	0.60	Clamp tonnage	285							
lps PSI		Injection pressure gauge	1000							
Inj PSI at transfer	1200	Holding 1 gauge psi	300							
Injection time act. secs.	3.20	Holding 2 gauge psi	284							
Hold Press 1 %	12	Back pressure gauge psi	350							
Hold Press 2 %	10	Back pressure gauge psi	300							
Hold Time 1	1.00	Final Cushion	0.24							
Hold Time 2										
Injection Hold Time	6.00			Validated by:						
1	1	1	1	1						

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