CAMBRO
TRUSTED FOR GENERATIONS™

JSW

Run Sheet - CONFIDENTIAL

Version No.

ECN APPROVED FORM

Product Name	RFS22PP190
Material Number	11160
Material Description	RSN R12C-01 CLARFD PP
Date Created	03/20/2019

Tool Number	RFS22#6		
Resin/Aditive Number			
Resin/Aditive Descrip			
		Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	43.50	45.0	45.00
Final Part(s) Weight (g	831.820	836.0	840.180

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

Barrel Temperatures	Set
Nozzle Tip %	40
Nozzle Body %	40
Adapter (NH)	400
Barrel Front (H4)	450
Barrel Center (H3)	450
Barrel Center (H2)	450
Barrel Rear (H1)	380

Mold Cooling Temps	Set
Mold Gate Temp °F	
Mold Fixed ½ °F	110
Mold Moving ½ °F	90
Stripper or other °F	
Nozzle Tip Information	
Type GP, FT, NYL	
Length OAL (in.)	0.00
Orifice Size (in.)	0.00
Nozzle Body Information	
Length OAL (in.)	0.00

Reference Data	Set
Fill Only Time	5.30
Fill Only Weight	829.0
Steel Temp. "A" Side °F	106
Steel Temp. "B" Side °F	83
Melt Temp. °F	446

Machine Number: **727**

Valve Gate	VG1	VG2	VG3	VG4
Open Delay				
Open Time				
Adv Cls Tm				
Close Delay				
Close Time				
Inj HP End				
Transfer				

Injection Profile	Set
Shot size in.	6.90
Injection Press 1	35.00
Injection Press 2	95.00
Injection Press 3	
Injection Press 4	
Injection Press 5	
Injection Velocity 1	10.00
Injection Velocity 2	70.00
Injection Velocity 3	
Injection Velocity 4	
Injection Velocity 5	
Injection Change Pos 1	6.50
Injection Change Pos 2	
Injection Change Pos 3	
Injection Change Pos 4	
Trans mode Ivsh/Ips	Ivsh
Trans pos in.	0.60
Ips PSI	
Inj PSI at transfer	
Injection time act. secs.	5.29
Hold Press 1 %	42
Hold Press 2 %	
Hold Time 1	
Hold Time 2	
Injection Hold Time	10.00

Recovery & Clamp Profile	
PrePullbk(PB2)speed	
PrePullbck before stro	
Screw Start Delay	
Screw Chg Position 1	
Screw Chg Position 2	
Screw recovery % 1	60.00
Screw recovery % 2	
Back Pressure 1	35.00
Back Pressure 2	
PostPullback(PB1)speed	99.00
Post Pullback stroke in.	0.70
Screw positon after SB	7.66
Screw recovery time	18.57
Cooling time secs	23.00
Mold protect press	50.00
Mold protect time	10.00
Clamp tonnage	700
Injection pressure gauge	
Holding 1 gauge psi	944
Holding 2 gauge psi	
Back pressure gauge psi	151
Back pressure gauge psi	
Final Cushion	0.07

Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6
Position 1 Gate/HB/Man	480	520				
Position 2 Gate/HB/Man						
Position 3 Gate/HB/Man						
Position 4 Gate/HB/Man						
Position 5 Gate/HB/Man						
Position 6 Gate/HB/Man						

Start-Up Instructions / Comments

Lid fit must be verified by Q.C.

Hot stamp foil 30397
Temp. 590 Time 1 Air Pressure 75

Validated by:

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