

Version No.

VALIDATING FORM

Product Name	64CW135
Material Number	11100
Material Description	CLEAR POLYCARB
Date Created	05/16/2019

Tool Number	GN64PAN	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	22.20	23.7	23.70
Final Part(s) Weight (g)	335.420	337.1	338.790

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: 413					
Nozzle Tip %	2	Mold Gate Temp °F		Fill Only Time	2.01						
Nozzle Body %	2	Mold Fixed ½ °F	180	Fill Only Weight	322.4						
Adapter (NH)	476	Mold Moving ½ °F	170	Steel Temp. "A" Side °F	186						
Barrel Front (H4)	590	Stripper or other °F		Steel Temp. "B" Side °F	172						
Barrel Center (H3)	610	Nozzle Tip Information		Melt Temp. °F	496						
Barrel Center (H2)	610	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	590	Length OAL (in.)		Open Delay							
		Orifice Size (in.)		Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)		Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	3.00	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	8000.00	PrePullbk before stro		Transfer							
Injection Press 2	21000.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3	21000.00	Screw Chg Position 1	1.00	Position 1 Gate/HB/Man	520	520	580				
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	65.00	Position 3 Gate/HB/Man							
Injection Velocity 1	0.75	Screw recovery % 2	65.00	Position 4 Gate/HB/Man							
Injection Velocity 2	2.00	Back Pressure 1	1200.00	Position 5 Gate/HB/Man							
Injection Velocity 3	2.00	Back Pressure 2	1000.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	200.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.35								
Injection Change Pos 1	3.35	Screw positon after SB	3.35								
Injection Change Pos 2	3.25	Screw recovery time	8.08								
Injection Change Pos 3	1.00	Cooling time secs	12.00								
Injection Change Pos 4		Mold protect press	27.00								
Trans mode lvsh/lps	lvsh	Mold protect time	1.00								
Trans pos in.	0.25	Clamp tonnage	250								
lps PSI		Injection pressure gauge	21540								
Inj PSI at transfer	22470	Holding 1 gauge psi	8000								
Injection time act. secs.	2.00	Holding 2 gauge psi	8000								
Hold Press 1 %	9000	Back pressure gauge psi	1200								
Hold Press 2 %	8000	Back pressure gauge psi	900								
Hold Time 1	1.50	Final Cushion	0.11								
Hold Time 2	1.50										
Injection Hold Time	8.00										

Validated by: