

Version No.

VALIDATING FORM

Product Name	66HP150
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	05/23/2019

Tool Number	GN66PAN#2
Resin/Additive Number	
Resin/Additive Descrip	
	Std.
	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	29.10	30.6	30.60
Final Part(s) Weight (g)	269.940	271.3	272.660

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: 41					
Nozzle Tip %	100	Mold Gate Temp °F	200	Fill Only Time	4.23						
Nozzle Body %	100	Mold Fixed ½ °F	350	Fill Only Weight	267.3						
Adapter (NH)	650	Mold Moving ½ °F	300	Steel Temp. "A" Side °F	308						
Barrel Front (H4)	690	Stripper or other °F	300	Steel Temp. "B" Side °F	353						
Barrel Center (H3)	690	Nozzle Tip Information		Melt Temp. °F	767						
Barrel Center (H2)	690	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	690	Length OAL (in.)	2	Open Delay							
		Orifice Size (in.)	1/8	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	6	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	3.25	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	65.00	PrePullbk before stro		Transfer							
Injection Press 2	95.00	Screw Start Delay	1.00	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3	75.00	Screw Chg Position 1	1.50	Position 1 Gate/HB/Man							
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	20.00	Position 3 Gate/HB/Man							
Injection Velocity 1	5.00	Screw recovery % 2	99.00	Position 4 Gate/HB/Man							
Injection Velocity 2	95.00	Back Pressure 1	325.00	Position 5 Gate/HB/Man							
Injection Velocity 3	5.00	Back Pressure 2	200.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	20.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.25								
Injection Change Pos 1	3.25	Screw positon after SB	3.53								
Injection Change Pos 2	0.35	Screw recovery time	12.31								
Injection Change Pos 3		Cooling time secs	16.00								
Injection Change Pos 4		Mold protect press	65.00								
Trans mode lvsh/lps	lvsh	Mold protect time	5.00								
Trans pos in.	0.20	Clamp tonnage	200								
lps PSI	2000	Injection pressure gauge	2000								
Inj PSI at transfer	2000	Holding 1 gauge psi	750								
Injection time act. secs.	4.23	Holding 2 gauge psi									
Hold Press 1 %	40	Back pressure gauge psi	300								
Hold Press 2 %		Back pressure gauge psi	200								
Hold Time 1		Final Cushion	0.14								
Hold Time 2											
Injection Hold Time	7.00										

Validated by: