

**QUALIFY FORM**

Product Name	24LPHP110
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	10/25/2017

Tool Number	GN24LP	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	53.80	55.3	55.30
Final Part(s) Weight (g)	566.160	569.0	571.850

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 %	175V	Mold Gate Temp °F	350	Fill Only Time	3.28						
Nozzle Body %	90V	Mold Fixed ½ °F	350	Fill Only Weight	558.0						
Adapter (NH)	630	Mold Moving ½ °F	290	Steel Temp. "A" Side °F	349						
Barrel Front (H4)	730	Stripper or other °F		Steel Temp. "B" Side °F	335						
Barrel Center (H3)	730	Nozzle Tip Information		Melt Temp. °F	764						
Barrel Center (H2)	730	Type GP, FT, NYL	gp	Valve Gate	VG1						
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.	6.20	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	80.00	PrePullbck before stro		Transfer							
Injection Press 2	95.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3	80.00	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	35.00	Position 3 Gate/HB/Man							
Injection Velocity 1	10.00	Screw recovery % 2	60.00	Position 4 Gate/HB/Man							
Injection Velocity 2	95.00	Back Pressure 1	70.00	Position 5 Gate/HB/Man							
Injection Velocity 3	80.00	Back Pressure 2	15.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	35.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.	0.40								
Injection Change Pos 1	6.00	Screw positon after SB	6.26								
Injection Change Pos 2	0.50	Screw recovery time	20.58								
Injection Change Pos 3		Cooling time secs	35.00								
Injection Change Pos 4		Mold protect press	85.00								
Trans mode lvsh/lps	IVSH	Mold protect time	5.00								
Trans pos in.	0.10	Clamp tonnage	300								
lps PSI		Injection pressure gauge	1900								
Inj PSI at transfer	1900	Holding 1 gauge psi	300								
Injection time act. secs.	3.14	Holding 2 gauge psi	300								
Hold Press 1 %	10	Back pressure gauge psi	375								
Hold Press 2 %	10	Back pressure gauge psi	200								
Hold Time 1	1.00	Final Cushion	0.07								
Hold Time 2											
Injection Hold Time	12.00										