

Version No.

QUALIFY FORM

Product Name	1014FF163
Material Number	11250
Material Description	RSN CP360H POLYPROPYLENE
Date Created	09/08/2017

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	26.41	27.9	27.91
Final Part(s) Weight (g)	495.510	498.0	500.490

Tool Number	1014FFSTACK	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	20530A
Colorant Descrip	163 RED MC-32098PP
Color Percentage	4.06
MacGuire Setting	2.00

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	
Nozzle Tip %		Mold Gate Temp °F		Fill Only Time	3.90
Nozzle Body %		Mold Fixed ½ °F	65	Fill Only Weight	436.0
Adapter 1 (EX)	420	Mold Moving ½ °F	65	Steel Temp. "A" Side °F	74
S/H Heat (EX)	420	Stripper or other °F		Steel Temp. "B" Side °F	92
Barrel Head (EX)	420	Nozzle Tip Information		Melt Temp. °F	421
Barrel Front (EX7)	400	Type GP, FT, NYL		Valve Gate	VG1 VG2 VG3 VG4
Barrel Center (EX6)	400	Length OAL (in.)	0.00	Open	135.0 135.0
Barrel Center (EX5)	400	Orifice Size (in.)	0.00	Close	
Barrel Center (EX4)	395	Nozzle Body Information		PSI	120 120
Barrel Center (EX3)	390	Length OAL (in.)	0.00	Delay	
Barrel Center (EX2)	385				
Barrel Rear (EX1)	380				

Machine Number: **H401**

Injection Profile	Set	Recovery & Clamp Profile	Gas Assist	C1	C2	C3	C4		
Shot size in.	95.0	Pre-Pullback mm/s		Delay (Sec)					
Injection Velocity mm/s	75	Pre-Pullback Stroke m	3.00	Hold (Sec)					
Injection Velocity mm/s	35	Screw Start Delay	2.00	Exhaust (Sec)					
Injection Velocity mm/s	6	Screw Chg Position	50.0	Pressure 1 (PSI)					
Injection Velocity mm/s		Screw Recovery RPM	110	Time (Sec)					
Injection Velocity mm/s		Screw Recovery RPM	110	Pressure 2 (PSI)					
Injection Change Pos 1	85.0	Back Pressure 1	250.0	Time (Sec)					
Injection Change Pos 2	25.0	Back Pressure 2	250.0	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5 Box 6
Injection Change Pos 3		Post Pullback mm/s		Position 1 Gate/HB/Man	550	550			
Injection Change Pos 4		Post Pullback Stroke		Position 2 Gate/HB/Man	550	550			
Trans Pos. mm	15.00	Screw position after SB	103.50	Position 3 Gate/HB/Man		550			
Injection Press Limit	2600	Screw recovery time	8.75	Position 4 Gate/HB/Man		550			
Inj PSI at transfer	1206	Cooling time secs	14.0	Position 5 Gate/HB/Man		550			
Injection time act. secs.	3.94	Mold protect press	1800	Position 6 Gate/HB/Man					
Hold Press 1 PSI	1325	Mold protect time		Start-Up Instructions / Comments					
Hold Press 2 PSI		Clamp tonnage	400						
Hold Press 1 secs	6.00	Injection pressure gauge	2507						
Hold Press 2 secs		Holding 1 gauge psi	1330						
Final Cushion mm	2.7	Holding 2 gauge psi							
		Back pressure gauge psi	250						
		Back pressure gauge psi	250						
				Validated by:					