

Version No.

**QUALIFY FORM**

Product Name	NT10152
Material Number	11114K
Material Description	RSN SAN 3301 KUMHO
Date Created	01/19/2018

Tool Number	100ZNPTTUMBLER	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :			
Final Part(s) Weight (g)	241.790	243.0	244.220

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: 314					
Nozzle Tip %	5	Mold Gate Temp °F		Fill Only Time	4.20						
Nozzle Body %	5	Mold Fixed ½ °F	130	Fill Only Weight	240.0						
Adapter (NH)	400	Mold Moving ½ °F	110	Steel Temp. "A" Side °F	110						
Barrel Front (H4)	460	Stripper or other °F		Steel Temp. "B" Side °F	98						
Barrel Center (H3)	450	Nozzle Tip Information		Melt Temp. °F	440	VG1	VG2	VG3	VG4		
Barrel Center (H2)	440	Type GP, FT, NYL		Valve Gate							
Barrel Rear (H1)	430	Length OAL (in.)	0.00	Open Delay							
		Orifice Size (in.)	0.00	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	0.00	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	3.50	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	40.00	PrePullbk before stro		Transfer							
Injection Press 2	70.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3	60.00	Screw Chg Position 1	2.80	Position 1 Gate/HB/Man	400	400	400	400	450		
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1	99.00	Position 3 Gate/HB/Man							
Injection Velocity 1	30.00	Screw recovery % 2	99.00	Position 4 Gate/HB/Man							
Injection Velocity 2	60.00	Back Pressure 1	40.00	Position 5 Gate/HB/Man							
Injection Velocity 3	40.00	Back Pressure 2	40.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed	20.00	Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.									
Injection Change Pos 1	3.30	Screw positon after SB	3.68								
Injection Change Pos 2	1.30	Screw recovery time	4.58								
Injection Change Pos 3		Cooling time secs	5.00								
Injection Change Pos 4		Mold protect press	15.00								
Trans mode lvsh/lps		Mold protect time	1.50								
Trans pos in.	0.73	Clamp tonnage	300								
lps PSI		Injection pressure gauge	1400								
Inj PSI at transfer		Holding 1 gauge psi	730								
Injection time act. secs.	4.19	Holding 2 gauge psi									
Hold Press 1 %	30	Back pressure gauge psi	200								
Hold Press 2 %		Back pressure gauge psi	250								
Hold Time 1		Final Cushion	648.00								
Hold Time 2											
Injection Hold Time	18.00										
				Validated by:							