

VALIDATING FORM

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|----------------------|-----------------------|
| Product Name | 44CW110 |
| Material Number | 11100 |
| Material Description | CLEAR POLYCARB |
| Date Created | 08/17/2018 |

| Standardization Info | Min. | Mid. | Max. |
|--------------------------|----------------|--------------|----------------|
| Certified Cycle Time : | | | |
| Final Part(s) Weight (g) | 497.500 | 500.0 | 502.500 |

| | | |
|------------------------|---------|-------|
| Tool Number | GN44PAN | |
| Resin/Additive Number | | |
| Resin/Additive Descrip | | |
| | | |
| | Std. | Cert. |
| | | |
| | | |

| | |
|------------------|--|
| Colorant Number | |
| Colorant Descrip | |
| Color Percentage | |
| MacGuire Setting | |

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: 717 | | | | |
|---------------------------|-------|--------------------------|-------|----------------------------------|-------|---------------------|-------|-------|-------|-------|
| Nozzle Tip % | 50 | Mold Gate Temp °F | 150 | Fill Only Time | 2.42 | | | | | |
| Nozzle Body % | 50 | Mold Fixed ½ °F | 180 | Fill Only Weight | 492.0 | | | | | |
| Adapter (NH) | 550 | Mold Moving ½ °F | 170 | Steel Temp. "A" Side °F | 185 | | | | | |
| Barrel Front (H4) | 620 | Stripper or other °F | | Steel Temp. "B" Side °F | 176 | | | | | |
| Barrel Center (H3) | 620 | Nozzle Tip Information | | Melt Temp. °F | 630 | | | | | |
| Barrel Center (H2) | 620 | Type GP, FT, NYL | gp | Valve Gate | VG1 | VG2 | VG3 | VG4 | | |
| Barrel Rear (H1) | 600 | Length OAL (in.) | 3 3/4 | Open Delay | | | | | | |
| | | Orifice Size (in.) | 7/32 | 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. | 4.00 | PrePullbk(PB2)speed | | Inj HP End | | | | | | |
| Injection Press 1 | 45.00 | PrePullbk before stro | | Transfer | | | | | | |
| Injection Press 2 | 85.00 | Screw Start Delay | | Hot Tip Controller | Box 1 | Box 2 | Box 3 | Box 4 | Box 5 | Box 6 |
| Injection Press 3 | | Screw Chg Position 1 | | Position 1 Gate/HB/Man | 530 | 530 | 500 | | | |
| Injection Press 4 | | Screw Chg Position 2 | | Position 2 Gate/HB/Man | | | | | | |
| Injection Press 5 | | Screw recovery % 1 | | Position 3 Gate/HB/Man | | | | | | |
| Injection Velocity 1 | 15.00 | Screw recovery % 2 | | Position 4 Gate/HB/Man | | | | | | |
| Injection Velocity 2 | 85.00 | Back Pressure 1 | | Position 5 Gate/HB/Man | | | | | | |
| Injection Velocity 3 | | Back Pressure 2 | | Position 6 Gate/HB/Man | | | | | | |
| Injection Velocity 4 | | PostPullback(PB1)speed | | Start-Up Instructions / Comments | | | | | | |
| Injection Velocity 5 | | Post Pullback stroke in. | | | | | | | | |
| Injection Change Pos 1 | 3.90 | Screw positon after SB | | | | | | | | |
| Injection Change Pos 2 | | Screw recovery time | | | | | | | | |
| Injection Change Pos 3 | | Cooling time secs | | | | | | | | |
| Injection Change Pos 4 | | Mold protect press | | | | | | | | |
| Trans mode lvsh/lps | IVSH | Mold protect time | | | | | | | | |
| Trans pos in. | 0.55 | Clamp tonnage | | | | | | | | |
| lps PSI | | Injection pressure gauge | | | | | | | | |
| Inj PSI at transfer | 1300 | Holding 1 gauge psi | | | | | | | | |
| Injection time act. secs. | 2.42 | Holding 2 gauge psi | | | | | | | | |
| Hold Press 1 % | 30 | Back pressure gauge psi | | | | | | | | |
| Hold Press 2 % | | Back pressure gauge psi | | | | | | | | |
| Hold Time 1 | | Final Cushion | | | | | | | | |
| Hold Time 2 | | | | | | | | | | |
| Injection Hold Time | 10.00 | | | | | | | | | |
| | | | | | | | | | | |