

# HAITIAN

## VALIDATING FORM

Product Name	21157CBP180
Material Number	11187
Material Description	RSN 6719 HDPE (INJ/MTC)
Date Created	09/08/2017

Tool Number	21157CB#2	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	1.50

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	53.00	54.5	54.50
Final Part(s) Weight (gm)	1684.540	1693.0	1701.470

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	75	Fill Only Time	5.00
Nozzle Body %		Mold Fixed ½ °F	65	Fill Only Weight	1635.0
Adapter 1 (HT1)	460	Mold Moving ½ °F	65	Steel Temp. "A" Side °F	104
Barrel Front (HT2)	515	Stripper or other °F		Steel Temp. "B" Side °F	109
Barrel Center (HT3)	520	Nozzle Tip Information		Melt Temp. °F	479
Barrel Center (HT4)	520	Type GP, FT, NYL		Valve Gate	VG1
Barrel Center (HT5)	515	Length OAL (in.)	0.00	Open	Tm/Pos
Barrel Center (HT6)	510	Orifice Size (in.)	0.00	Time	
Barrel Center (HT7)	500	Nozzle Body Information		Pos	
Barrel Rear (HT8)	475	Length OAL (in.)	0.00	Close	Tm/Pos
				Time	
				Pos	
Injection Profile	Set	Recovery & Clamp Profile		Hold	On/Off
Shot size in.	7.40	Suckback Before Pos	0.50	Delay	
Injection Change Pos 1	0.90	Screw Start Delay	0.50	Active	
Injection Change Pos 2		Charge Position 1		Hot Tip Controller	Box 1
Injection Change Pos 3		Charge Position 2		Position 1 Gate/HB/Man	400
Injection Change Pos 4		Charge Pressure 1	1500	Position 2 Gate/HB/Man	400
Injection Press 1	1950	Charge Pressure 2		Position 3 Gate/HB/Man	450
Injection Press 2	1400	Charge Flow 1	99	Position 4 Gate/HB/Man	450
Injection Press 3		Charge Flow 2		Position 5 Gate/HB/Man	450
Injection Press 4		Back Pressure 1	100.0	Position 6 Gate/HB/Man	
Injection Press 5		Back Pressure 2	100.0	Start-Up Instructions / Comments	
Injection Flow 1	50	Suckback After Pos	1.10		
Injection Flow 2	13	Screw Positon After SB	8.69		
Injection Flow 3		Screw charge Time			
Injection Flow 4		Cooling time secs	20.0		
Injection Flow 5		Mold protect press	350		
Inj Position threshold		Mold Protect Flow	40		
Inj Pressure threshold	0.55	Mold protect time			
InjectionTime threshold		Clamp High Press PSI	2000		
Inj PSI at transfer	1169	Clamp High Press Flow	35		
Injection time act. secs.	5.00	Injection pressure gauge	1726		
Hold Press 1 PSI	600	Holding 1 gauge psi	592		
Hold Press 2 PSI	600	Holding 2 gauge psi	592		
Hold Flow 1	25	Back pressure gauge psi	145		
Hold Flow 2	25	Back pressure gauge psi			
Hold Time 1	1.00				
Hold Time 2	10.00				
Final Cushion mm	11.00				

Machine Number: HT1502