

Version No.

QUALIFY FORM

Product Name	ESXRRP4R3151
Material Number	11252
Material Description	RSN PFSG722 PP COPOLYME
Date Created	09/04/2018

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :			
Final Part(s) Weight (g)	1914.380	1924.0	1933.620

Tool Number	ESXRRAILPNL4R30	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	20397A
Colorant Descrip	CLR MC-84398PP ELEM/G
Color Percentage	7.69
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: 726					
Nozzle Tip %	5	Mold Gate Temp °F	100	Fill Only Time	6.50						
Nozzle Body %	5	Mold Fixed ½ °F	100	Fill Only Weight	1895.0						
Adapter (NH)	400	Mold Moving ½ °F	85	Steel Temp. "A" Side °F	112						
Barrel Front (H4)	420	Stripper or other °F		Steel Temp. "B" Side °F	95	VG2	VG3	VG4	1.0	1.0	
Barrel Center (H3)	420	Nozzle Tip Information		Melt Temp. °F	405						
Barrel Center (H2)	410	Type GP, FT, NYL		Valve Gate	VG1						
Barrel Rear (H1)	400	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.	13.80	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	75.00	PrePullbck before stro		Transfer							
Injection Press 2		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	330	420	330	420	420	420	
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man	330	420	330	420	420	420	
Injection Press 5		Screw recovery % 1	85.00	Position 3 Gate/HB/Man							
Injection Velocity 1	45.00	Screw recovery % 2		Position 4 Gate/HB/Man							
Injection Velocity 2		Back Pressure 1	45.00	Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2	45.00	Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed		Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.		MATERIAL BLEND OF 11262 AND 11252 IS 50/50. MAGUIRE SETTING 4% IS 120							
Injection Change Pos 1		Screw positon after SB	14.40								
Injection Change Pos 2		Screw recovery time	33.00								
Injection Change Pos 3		Cooling time secs	45.00								
Injection Change Pos 4		Mold protect press	50.00								
Trans mode lvsh/lps	IVSH	Mold protect time	5.00								
Trans pos in.	1.50	Clamp tonnage	700								
lps PSI		Injection pressure gauge	770								
Inj PSI at transfer	6	Holding 1 gauge psi									
Injection time act. secs.	770.00	Holding 2 gauge psi									
Hold Press 1 %	18	Back pressure gauge psi									
Hold Press 2 %		Back pressure gauge psi									
Hold Time 1		Final Cushion	0.24								
Hold Time 2											
Injection Hold Time	14.00										
				Validated by:							