

**VALIDATING FORM**

Product Name	120CWP148
Material Number	11100
Material Description	RSN CLR MKRN 2856-550042/
Date Created	09/01/2018

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	40.30	41.8	41.80
Final Part(s) Weight (g)	313.430	315.0	316.580

Tool Number	120CWP	
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: 715					
Nozzle Tip %	5	Mold Gate Temp °F		Fill Only Time	2.79						
Nozzle Body %	5	Mold Fixed ½ °F	120	Fill Only Weight	305.0						
Adapter (NH)	620	Mold Moving ½ °F	180	Steel Temp. "A" Side °F	120						
Barrel Front (H4)	620	Stripper or other °F		Steel Temp. "B" Side °F	180						
Barrel Center (H3)	620	Nozzle Tip Information		Melt Temp. °F	595						
Barrel Center (H2)	620	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	600	Length OAL (in.)	2 3/4	Open Delay							
		Orifice Size (in.)	1/4	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.	2.50	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	60.00	PrePullbck before stro		Transfer							
Injection Press 2	90.00	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	680	670	660				
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	90.00	Screw recovery % 2		Position 4 Gate/HB/Man							
Injection Velocity 2	95.00	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	2.40	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.	0.35	Clamp tonnage									
lps PSI		Injection pressure gauge									
Inj PSI at transfer		Holding 1 gauge psi									
Injection time act. secs.	2.79	Holding 2 gauge psi									
Hold Press 1 %	20	Back pressure gauge psi									
Hold Press 2 %		Back pressure gauge psi									
Hold Time 1		Final Cushion									
Hold Time 2											
Injection Hold Time	10.00										