

VALIDATING FORM

Product Name	26HP150
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	05/23/2019

Tool Number	GN26PAN#2	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	49.50	51.0	51.00
Final Part(s) Weight (g)	760.180	764.0	767.820

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: 725					
Nozzle Tip %	100	Mold Gate Temp °F	200	Fill Only Time	3.82						
Nozzle Body %	75	Mold Fixed ½ °F	285	Fill Only Weight	750.8						
Adapter (NH)	650	Mold Moving ½ °F	225	Steel Temp. "A" Side °F	312						
Barrel Front (H4)	690	Stripper or other °F	225	Steel Temp. "B" Side °F	260						
Barrel Center (H3)	690	Nozzle Tip Information		Melt Temp. °F	770						
Barrel Center (H2)	690	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	680	Length OAL (in.)	2 3/4	Open Delay							
		Orifice Size (in.)	1/8	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	7	Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.	4.40	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	40.00	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	90.00	Screw Chg Position 1		4.00	Position 1 Gate/HB/Man						
Injection Press 4		Screw Chg Position 2			Position 2 Gate/HB/Man						
Injection Press 5		Screw recovery % 1		40.00	Position 3 Gate/HB/Man						
Injection Velocity 1	5.00	Screw recovery % 2		40.00	Position 4 Gate/HB/Man						
Injection Velocity 2	55.00	Back Pressure 1		70.00	Position 5 Gate/HB/Man						
Injection Velocity 3	30.00	Back Pressure 2		65.00	Position 6 Gate/HB/Man						
Injection Velocity 4		PostPullback(PB1)speed		20.00	Start-Up Instructions / Comments						
Injection Velocity 5		Post Pullback stroke in.		0.30							
Injection Change Pos 1	4.35	Screw positon after SB		4.77	Make sure not to exceed cushion set point in order to prevent black specks.						
Injection Change Pos 2	0.50	Screw recovery time		17.80							
Injection Change Pos 3		Cooling time secs		26.00							
Injection Change Pos 4		Mold protect press		99.00							
Trans mode lvsh/lps	lvsh	Mold protect time		5.00							
Trans pos in.	0.15	Clamp tonnage		700							
lps PSI	1558	Injection pressure gauge		1558							
Inj PSI at transfer	1558	Holding 1 gauge psi		445							
Injection time act. secs.	3.82	Holding 2 gauge psi		489							
Hold Press 1 %	15	Back pressure gauge psi		289							
Hold Press 2 %	20	Back pressure gauge psi		265							
Hold Time 1	2.00	Final Cushion		0.02							
Hold Time 2											
Injection Hold Time	10.50										