

Version No.

VALIDATING FORM

Product Name	12HP150
Material Number	11125A
Material Description	RSN ULTRASN NATURAL E30
Date Created	05/23/2019

Tool Number	GN12PAN#2	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	49.10	50.6	50.60
Final Part(s) Weight (g)	818.090	822.2	826.310

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	4.36												
Nozzle Body %	100	Mold Fixed ½ °F	320	Fill Only Weight	787.0												
Adapter (NH)	690	Mold Moving ½ °F	310	Steel Temp. "A" Side °F	331												
Barrel Front (H4)	720	Stripper or other °F	310	Steel Temp. "B" Side °F	321												
Barrel Center (H3)	720	Nozzle Tip Information		Melt Temp. °F	787												
Barrel Center (H2)	720	Type GP, FT, NYL	GP	Valve Gate	VG1							VG2	VG3	VG4			
Barrel Rear (H1)	700	Length OAL (in.)	2	Open Delay													
		Orifice Size (in.)	3/16	Open Time													
		Nozzle Body Information		Adv Cls Tm													
		Length OAL (in.)	6	Close Delay													
		Injection Profile		Set	Recovery & Clamp Profile		Close Time										
Shot size in.	5.20	PrePullbk(PB2)speed		Inj HP End													
Injection Press 1	40.00	PrePullbk before stro		Transfer													
Injection Press 2	95.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6							
Injection Press 3	95.00	Screw Chg Position 1	5.00	Position 1 Gate/HB/Man													
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man													
Injection Press 5		Screw recovery % 1	45.00	Position 3 Gate/HB/Man													
Injection Velocity 1	5.00	Screw recovery % 2	40.00	Position 4 Gate/HB/Man													
Injection Velocity 2	85.00	Back Pressure 1	70.00	Position 5 Gate/HB/Man													
Injection Velocity 3	75.00	Back Pressure 2	40.00	Position 6 Gate/HB/Man													
Injection Velocity 4		PostPullback(PB1)speed	25.00	Start-Up Instructions / Comments													
Injection Velocity 5		Post Pullback stroke in.	0.25														
Injection Change Pos 1	5.10	Screw positon after SB	5.55														
Injection Change Pos 2	0.60	Screw recovery time	20.00														
Injection Change Pos 3		Cooling time secs	28.00														
Injection Change Pos 4		Mold protect press	99.00														
Trans mode lvsh/lps	lvsh	Mold protect time	5.00														
Trans pos in.	0.22	Clamp tonnage	650														
lps PSI	1732	Injection pressure gauge	1732														
Inj PSI at transfer	1732	Holding 1 gauge psi	653														
Injection time act. secs.	4.36	Holding 2 gauge psi	449														
Hold Press 1 %	20	Back pressure gauge psi	289														
Hold Press 2 %	15	Back pressure gauge psi	128														
Hold Time 1	3.00	Final Cushion	0.20														
Hold Time 2																	
Injection Hold Time	10.00																
											Validated by:						

Validated by: