

## HAITIAN BLANK FORM

Product Name		Tool Number		Machine Number	
Material Number		Resin/Additive Number		Colorant Number	
Material Description		Resin/Additive Descrip		Colorant Descrip	
Technician Name :		Tool Cavities		Color Percentage	
Date Created			Std.	Cert.	
Cert. Part(s) Weight (gm) :		Cycle Time (sec) :			MacGuire Setting
		Shot Weight (gm) :			Runner Weight (gm)

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :			
Final Part(s) Weight (gm)			

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		Machine Number:						
Nozzle Tip %		Mold Gate Temp °F		Fill Only Time								
Nozzle Body %		Mold Fixed ½ °F		Fill Only Weight								
Adapter 1 (HT1)		Mold Moving ½ °F		Steel Temp. "A" Side °F								
Barrel Front (HT2)		Stripper or other °F		Steel Temp. "B" Side °F								
Barrel Center (HT3)		Nozzle Tip Information		Melt Temp. °F								
Barrel Center (HT4)		Type GP, FT, NYL		Valve Gate	VG1					VG2	VG3	VG4
Barrel Center (HT5)		Length OAL (in.)		Open	Tm/Pos					Tm/Pos	Tm/Pos	Tm/Pos
Barrel Center (HT6)		Orifice Size (in.)		Time								
Barrel Center (HT7)		Nozzle Body Information		Pos								
Barrel Rear (HT8)		Length OAL (in.)		Close	Tm/Pos	Tm/Pos	Tm/Pos	Tm/Pos				
				Time								
				Pos								
Injection Profile	Set	Recovery & Clamp Profile		Hold	On/Off	On/Off	On/Off	On/Off				
Shot size in.		Suckback Before Pos		Delay								
Injection Change Pos 1		Screw Start Delay		Active								
Injection Change Pos 2		Charge Position 1		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4				
Injection Change Pos 3		Charge Position 2		Position 1 Gate/HB/Man								
Injection Change Pos 4		Charge Pressure 1		Position 2 Gate/HB/Man								
Injection Press 1		Charge Pressure 2		Position 3 Gate/HB/Man								
Injection Press 2		Charge Flow 1		Position 4 Gate/HB/Man								
Injection Press 3		Charge Flow 2		Position 5 Gate/HB/Man								
Injection Press 4		Back Pressure 1		Position 6 Gate/HB/Man								
Injection Press 5		Back Pressure 2		Start-Up Instructions / Comments								
Injection Flow 1		Suckback After Pos										
Injection Flow 2		Screw Positon After SB										
Injection Flow 3		Screw charge Time										
Injection Flow 4		Cooling time secs										
Injection Flow 5		Mold protect press										
Inj Position threshold		Mold Protect Flow										
Inj Pressure threshold		Mold protect time										
InjectionTime threshold		Clamp High Press PSI										
Inj PSI at transfer		Clamp High Press Flow										
Injection time act. secs.		Injection pressure gauge										
Hold Press 1 PSI		Holding 1 gauge psi										
Hold Press 2 PSI		Holding 2 gauge psi										
Hold Flow 1		Back pressure gauge psi										
Hold Flow 2		Back pressure gauge psi										
Hold Time 1												
Hold Time 2												
Final Cushion mm												