

VALIDATING FORM

Product Name	LT16152
Material Number	11114K
Material Description	RSN SAN 3301 KUMHO
Date Created	12/19/2017

Tool Number	16OZLAGTUMBLER	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certifield Cycle Time :	29.50	31.0	31.00
Final Part(s) Weight (g)	719.390	723.0	726.620

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: H404					
Nozzle Tip %		Mold Gate Temp °F		Fill Only Time	3.00						
Nozzle Body %	25	Mold Fixed ½ °F	150	Fill Only Weight	718.0						
Adapter 1 (EX)	25	Mold Moving ½ °F	100	Steel Temp. "A" Side °F	130						
S/H Heat (EX)		Stripper or other °F		Steel Temp. "B" Side °F	92						
Barrel Head (EX)		Nozzle Tip Information		Melt Temp. °F	410						
Barrel Front (EX7)		Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Center (EX6)	405	Length OAL (in.)	2 3/4	Open							
Barrel Center (EX5)	415	Orifice Size (in.)	7/32	Close							
Barrel Center (EX4)	430	Nozzle Body Information		PSI							
Barrel Center (EX3)	440	Length OAL (in.)		Delay							
Barrel Center (EX2)	440										
Barrel Rear (EX1)	420										
Injection Profile	Set	Recovery & Clamp Profile		Gas Assist	C1	C2	C3	C4			
Shot size in.	180.0	Pre-Pullback mm/s		Delay (Sec)							
Injection Velocity mm/s	35	Pre-Pullback Stroke m		Hold (Sec)							
Injection Velocity mm/s	40	Screw Start Delay		Exhaust (Sec)							
Injection Velocity mm/s	35	Screw Chg Position		Pressure 1 (PSI)							
Injection Velocity mm/s		Screw Recovery RPM	100	Time (Sec)							
Injection Velocity mm/s		Screw Recovery RPM	130	Pessure 2 (PSI)							
Injection Change Pos 1	158.0	Back Pressure 1	240.0	Time (Sec)							
Injection Change Pos 2	40.0	Back Pressure 2	220.0	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Change Pos 3		Post Pullback mm/s	20.00	Position 1 Gate/HB/Man	510	510	510				
Injection Change Pos 4		Post Pullback Stroke	8.00	Position 2 Gate/HB/Man	510	510					
Trans Pos. mm	33.00	Screw positon after SB	188.00	Position 3 Gate/HB/Man	510	510					
Injection Press Limit		Screw recovery time	9.32	Position 4 Gate/HB/Man	510	510					
Inj PSI at transfer		Cooling time secs	16.0	Position 5 Gate/HB/Man	510	510					
Injection time act. secs.	3.00	Mold protect press	50	Position 6 Gate/HB/Man	510	510					
Hold Press 1 PSI	450	Mold protect time		Start-Up Instructions / Comments							
Hold Press 2 PSI	375	Clamp tonnage	400								
Hold Press 1 secs	5.00	Injection pressure gauge	1302								
Hold Press 2 secs	3.00	Holding 1 gauge psi	450								
Final Cushion mm		Holding 2 gauge psi	375								
		Back pressure gauge psi									
		Back pressure gauge psi									