

Version No.

VALIDATING FORM

Product Name	1014FF110
Material Number	11250
Material Description	RSN CP360H POLYPROPYLENE
Date Created	09/12/2017

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	26.41	27.9	27.91
Final Part(s) Weight (g)	495.510	498.0	500.490

Tool Number	1014FFSTACK	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	20328A
Colorant Descrip	CLR MC-80270PE BLACK
Color Percentage	1.00
MacGuire Setting	1.00

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							
Nozzle Tip %		Mold Gate Temp °F		Fill Only Time	3.90	Machine Number: H401					
Nozzle Body %		Mold Fixed ½ °F	65	Fill Only Weight	436.0						
Adapter 1 (EX)	420	Mold Moving ½ °F	65	Steel Temp. "A" Side °F	74						
S/H Heat (EX)	420	Stripper or other °F		Steel Temp. "B" Side °F	92						
Barrel Head (EX)	420	Nozzle Tip Information		Melt Temp. °F	421						
Barrel Front (EX7)	400	Type GP, FT, NYL		Valve Gate	VG1	VG2	VG3	VG4			
Barrel Center (EX6)	400	Length OAL (in.)	0.00	Open	135.0	135.0					
Barrel Center (EX5)	400	Orifice Size (in.)	0.00	Close							
Barrel Center (EX4)	395	Nozzle Body Information		PSI	120	120					
Barrel Center (EX3)	390	Length OAL (in.)	0.00	Delay							
Barrel Center (EX2)	385										
Barrel Rear (EX1)	380										
Injection Profile	Set	Recovery & Clamp Profile		Gas Assist	C1	C2	C3	C4			
Shot size in.	95.0	Pre-Pullback mm/s		Delay (Sec)							
Injection Velocity mm/s	75	Pre-Pullback Stroke m	3.00	Hold (Sec)							
Injection Velocity mm/s	35	Screw Start Delay	2.00	Exhaust (Sec)							
Injection Velocity mm/s	6	Screw Chg Position	50.0	Pressure 1 (PSI)							
Injection Velocity mm/s		Screw Recovery RPM	110	Time (Sec)							
Injection Velocity mm/s		Screw Recovery RPM	110	Pressure 2 (PSI)							
Injection Change Pos 1	85.0	Back Pressure 1	250.0	Time (Sec)							
Injection Change Pos 2	25.0	Back Pressure 2	250.0	Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Change Pos 3		Post Pullback mm/s		Position 1 Gate/HB/Man	550	550					
Injection Change Pos 4		Post Pullback Stroke		Position 2 Gate/HB/Man	550	550					
Trans Pos. mm	15.00	Screw position after SB	103.50	Position 3 Gate/HB/Man		550					
Injection Press Limit	2600	Screw recovery time	8.75	Position 4 Gate/HB/Man		550					
Inj PSI at transfer	2450	Cooling time secs	14.0	Position 5 Gate/HB/Man		550					
Injection time act. secs.	3.94	Mold protect press	1800	Position 6 Gate/HB/Man							
Hold Press 1 PSI	1100	Mold protect time		Start-Up Instructions / Comments							
Hold Press 2 PSI	1350	Clamp tonnage	400								
Hold Press 1 secs	3.00	Injection pressure gauge									
Hold Press 2 secs	3.00	Holding 1 gauge psi	1099								
Final Cushion mm	4.3	Holding 2 gauge psi	1320								
		Back pressure gauge psi	250								
		Back pressure gauge psi	250								
Validated by:											