

**CERTIFIED FORM**

Product Name	18269P148
Material Number	11187
Material Description	RSN 6719 HDPE (INJ/MTC)
Date Created	06/04/2019

Tool Number	18269CB	
Resin/Additive Number		
Resin/Additive Descrip		
	Std.	Cert.

Colorant Number	
Colorant Descrip	
Color Percentage	
MacGuire Setting	

Standardization Info	Min.	Mid.	Max.
Certified Cycle Time :	85.50	87.0	87.00
Final Part(s) Weight (g)	2210.890	2222.0	2233.110

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: 154					
Nozzle Tip %	100V	Mold Gate Temp °F	50	Fill Only Time	7.84						
Nozzle Body %	100V	Mold Fixed ½ °F	50	Fill Only Weight	2218.9						
Adapter (NH)	300	Mold Moving ½ °F	120	Steel Temp. "A" Side °F	88						
Barrel Front (H4)	440	Stripper or other °F	160	Steel Temp. "B" Side °F							
Barrel Center (H3)	440	Nozzle Tip Information		Melt Temp. °F							
Barrel Center (H2)	420	Type GP, FT, NYL	GP	Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)	400	Length OAL (in.)	3-5/8	Open Delay							
		Orifice Size (in.)	1/4	Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)	8-1/8	Close Delay							
		Injection Profile		Set	Recovery & Clamp Profile		Close Time				
Shot size in.	9.00	PrePullbk(PB2)speed		Inj HP End							
Injection Press 1	40.00	PrePullbck before stro		Transfer							
Injection Press 2	60.00	Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3	65.00	Screw Chg Position 1		6.00	Position 1 Gate/HB/Man						
Injection Press 4		Screw Chg Position 2			Position 2 Gate/HB/Man						
Injection Press 5		Screw recovery % 1		42.00	Position 3 Gate/HB/Man						
Injection Velocity 1	22.00	Screw recovery % 2		40.00	Position 4 Gate/HB/Man						
Injection Velocity 2	50.00	Back Pressure 1		20.00	Position 5 Gate/HB/Man						
Injection Velocity 3	40.00	Back Pressure 2		15.00	Position 6 Gate/HB/Man						
Injection Velocity 4		PostPullback(PB1)speed		60.00	Start-Up Instructions / Comments						
Injection Velocity 5		Post Pullback stroke in.		0.50							
Injection Change Pos 1	9.00	Screw positon after SB		9.54							
Injection Change Pos 2	7.00	Screw recovery time		45.36							
Injection Change Pos 3		Cooling time secs		48.00							
Injection Change Pos 4		Mold protect press		90.00							
Trans mode lvsh/lps	IVSH	Mold protect time		6.00							
Trans pos in.	0.90	Clamp tonnage		1300							
lps PSI	1000	Injection pressure gauge		1000							
Inj PSI at transfer	1000	Holding 1 gauge psi		400							
Injection time act. secs.	7.84	Holding 2 gauge psi		300							
Hold Press 1 %	20	Back pressure gauge psi		150							
Hold Press 2 %	15	Back pressure gauge psi		100							
Hold Time 1	4.00	Final Cushion		0.35							
Hold Time 2											
Injection Hold Time	18.00										