

JSW 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.	MacGuire Setting		
Cert. Part(s) Weight (gm) :				Cycle Time (sec) :			Runner Weight (gm)		
				Shot Weight (gm) :					
Standardization Info	Min.	Mid.	Max.						
Certified Cycle Time :									
Final Part(s) Weight (g									

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						
Nozzle Tip %		Mold Gate Temp °F		Fill Only Time		Machine Number:					
Nozzle Body %		Mold Fixed ½ °F		Fill Only Weight							
Adapter (NH)		Mold Moving ½ °F		Steel Temp. "A" Side °F							
Barrel Front (H4)		Stripper or other °F		Steel Temp. "B" Side °F							
Barrel Center (H3)		Nozzle Tip Information		Melt Temp. °F							
Barrel Center (H2)		Type GP, FT, NYL		Valve Gate	VG1	VG2	VG3	VG4			
Barrel Rear (H1)		Length OAL (in.)		Open Delay							
		Orifice Size (in.)		Open Time							
		Nozzle Body Information		Adv Cls Tm							
		Length OAL (in.)		Close Delay							
Injection Profile	Set	Recovery & Clamp Profile		Close Time							
Shot size in.		PrePullbk(PB2)speed		Inj HP End							
Injection Press 1		PrePullbk before stro		Transfer							
Injection Press 2		Screw Start Delay		Hot Tip Controller	Box 1	Box 2	Box 3	Box 4	Box 5	Box 6	
Injection Press 3		Screw Chg Position 1		Position 1 Gate/HB/Man							
Injection Press 4		Screw Chg Position 2		Position 2 Gate/HB/Man							
Injection Press 5		Screw recovery % 1		Position 3 Gate/HB/Man							
Injection Velocity 1		Screw recovery % 2		Position 4 Gate/HB/Man							
Injection Velocity 2		Back Pressure 1		Position 5 Gate/HB/Man							
Injection Velocity 3		Back Pressure 2		Position 6 Gate/HB/Man							
Injection Velocity 4		PostPullback(PB1)speed		Start-Up Instructions / Comments							
Injection Velocity 5		Post Pullback stroke in.									
Injection Change Pos 1		Screw positon after SB									
Injection Change Pos 2		Screw recovery time									
Injection Change Pos 3		Cooling time secs									
Injection Change Pos 4		Mold protect press									
Trans mode lvsh/lps		Mold protect time									
Trans pos in.		Clamp tonnage									
lps PSI		Injection pressure gauge									
Inj PSI at transfer		Holding 1 gauge psi									
Injection time act. secs.		Holding 2 gauge psi									
Hold Press 1 %		Back pressure gauge psi									
Hold Press 2 %		Back pressure gauge psi									
Hold Time 1		Final Cushion									
Hold Time 2											
Injection Hold Time											