

	<b>PROCESS PARAMETER CHART (VALIDATION)</b>						DATE:	
							SHIFT:	
Customer :-						FORM NO:		
Part Name :-						Machine :-		
No. of cavities :-						Shot Weight :-		
Raw Material :-						Part Weight :-		
Material Grade :-						Pre heating Temperaturure :-		
Colour :-						Pre heating Time :-		
Master batch Added :-						Mold Cooling Required :-		
Master batch % :-						Mold Heating Required :-		
Mold Height :-						Total Cycle Time :-		
<b>Barrel Temperature :-</b>								
	Hot Runner	Nozzle	MH4	MH3	MH2	MH1	Feed	Oil
°C								
Tolerance	± 10	± 10	± 10	± 10	± 10	± 10	± 10	± 10
<b>Process Optimisation :-</b>								
Pressure (Bar)	Injection	Hold	Back / Retraction	Special Instructions :-				
Tolerance	± 10	± 5	± 5	Suck Back :-				
Speed (mm / sec)	Injection	Hold	Screw / Refill	Retraction :-				
Tolerance	± 10	—	± 5	Ejector :-				
Time (Sec.)	Injection	Hold	Cooling	Ejector Stroke (mm) :-		Ejector Count (strokes):		
Tolerance	± 0.1	± 1	± 1					
Shot Stroke (mm)	Refill End	Hold Start	Suck Back End					
Tolerance	± 5	± 2	± 2					
Result of Validation :-								
OPERATOR:-								
REVALIDATION DUE DT.:								
OPERATOR SIGN:-								
SIGN PRD SUP :					SIGN PRD I/C :			
Perpared & Approved by :					Customer Sign:			



Divine  
Toolings

## FIRST PIECE APPROVAL REPORT

FORM NO:	Date:
Material:	Shift :
Mat. Grade:	M/c No:
Mast. Batch:	Operator :

Part Name :-

Part No:-

Customer :-

Process Approval	Description	Specified	Toll.	Actual	Description	Specified	Toll.	Actual	Description	Specified	Toll.	Actual
	Total Cycle Time		±5 Sec		Feed Zone Temp.		±10		Screw Speed/Refill		±5	
	Mould Heating Temp.		±5°C		Oil Temp.		±10		<b>Time (Sec)</b>			
	Hot Runner Temp.		5°C		<b>Process Optimisation</b>				Injection Time		±0.1	
	<b>Barrel Temp. (°C)</b>				Inj. Pressure (bar)		±10		Holding Time		±1	
	Nozzle Temp.		±10		Holding Pressure (bar)		±5		Cooling Time		±1	
	MH 4		±10		Back Pressure (bar)		±5		<b>Shot Stroke (mm)</b>			
	MH 3		±10		<b>Speed (mm / sec)</b>				Refill End		±5	
	MH 2		±10		Inj. Speed		±10		Hold Start		±2	
	MH 1		±10		Holding Speed		±10		SuckBack End		±2	

**Visual Parameters :**

1	free from short	free from patch mark	free from glass	free from ejector	
2	free from burn mark	free from black spot	free from glass	free from ejector	Calender update
3	free from sink mark	free from colour	free from flash	free from oil mark	Remarks
4	free from silver mark	free from flow mark	free from bubble		
5	free from weld line	free from damage			

Sr. No	Parameter	Specification	Tol.	Check Method	Observations								Remark	
1	Dimension			Vernier Caliper										
2	Dimension			Vernier Caliper										
3	Dimension			Vernier Caliper										
4	Dimension			Vernier Caliper										
5	Dimension			Vernier Caliper										
6	Dimension			Vernier Caliper										
7	Dimension			Vernier Caliper										
8	weight			weigh balance										
9	Fitment with			Reference sample										

PREPARED BY:

APPROVED BY: