

Trial-Lot Worksheet

ResinBridge

Qualifying an alternative resin grade or second source in the production mold

Sheet ____ of ____

1. Part and material

Part number	Mold / cavities
Press / tonnage	Trial date / shift
Incumbent grade	Incumbent lot no.
Trial grade	Trial lot no.
COA received for trial lot: [] Y [] N Values within spec: [] Y [] N	Data sheet on file: [] Y [] N Retain taken: [] Y [] N

2. Drying (per the trial grade's data sheet)

Dryer temp	Drying time (hr)	Dew point	Moisture after drying (%)
------------	------------------	-----------	---------------------------

3. Process settings

Setting	Incumbent	Trial	Notes / changes made
Barrel temps (rear / mid / front / nozzle)			
Melt temp (measured)			
Mold temp (A / B)			
Injection speed			
Fill time (s)			
Transfer position or pressure			
Pack pressure / time			
Hold pressure / time			
Cooling time (s)			
Cycle time (s)			
Part weight (g) / shot weight (g)			

4. First-article checks (measure after parts cool and condition)

Check	Spec	Incumbent	Trial	Pass / Fail
Critical dimension 1 (along flow)				[] P [] F
Critical dimension 2 (across flow)				[] P [] F
Warp / flatness				[] P [] F
Part weight				[] P [] F
Cycle time				[] P [] F
Appearance / color (delta E)				[] P [] F
Function / fit / assembly				[] P [] F
Impact or drop				[] P [] F
Flame (only if required)				[] P [] F
Heat aging / environmental (if required)				[] P [] F

5. Notes (defects seen, process window edges, parts kept)

--

6. Decision and sign-off

Decision: [] Go [] No-go [] Rerun / more data Customer approval or PPAP needed: [] Y [] N		
Quality (name / signature)	Engineering (name / signature)	Date