STREAMLINE CONTROLS PVT.LTD.

OPERATING MANUAL FOR CONTROL SYSTEM OF INJECTION MOLDING MACHINE

INJkon Rainbow X

BUSINESS MISSION



Streamline Controls Pvt. Ltd. (SCPL) is in the business of providing electronic & computerized Automation solution for different industries so as to enhance the quality and productivity. Our motto is to provide indigenous, reliable and proven products & hence to ensure consistent Performance. Our concept of value to the customers is to supply indigenous control systems Designed with latest technology, developed through extensive R & D, incorporating state of Art technology (world technology trend), manufactured under strictest quality control system And duly tested, at competitive prices, delivered in time and supported by service teams.

We feel it to be our responsibility to ensure that our business operates at a reasonable profit, as profit provides opportunity for R&D, growth and job security. Therefore we are dedicated to profitable growth - growth as a company and growth as an individual.

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PREFACE

INJkon is multi-functionally controller incorporating micro controller, making it most versatile and cost effective solution optimally designed to best suit the automation needs of injection molding machines.

For laterusage and maintenance of control system, detail study of this operating manual will berecommended.

Features & Specifications are subject to change without prior notice.

Safety Guidelines

Although utmost care is taken while designing the hardware and the software to ensure the safety during interlock conditions in various operations of the machine, SCPL does not undertake any responsibilities for any damage to the human and or the machine. It is therefore strongly recommended to ensure adherence to all the safety standards while designing and operating the machine.

SCPLstrongly recommends following safety measures to ensure the safety of the human & or machine.

- Whenever the human or human body part is expected to interrupt the moving machine part, cut off all the energy electrical, hydraulic and mechanical.
- The moving parts must be covered with guards.
 SCPL provides continuous monitoring of two guards during the mould close operation front & back.
 The open guard condition, in addition to the PLC monitoring, must also be linked todisconnection of hydraulic and electrical connection to the mould close operation.
- For the machines designed deliberately with minimum or no safety, are made to operate without safety guards. Although SCPL strongly denies such operation, following recommendations are made to ensure best possible safety from the logic of PLC.
 - SCPL strongly denies use of N/C contact in cycle start input.
 - In Semi mode, N/C contact mal function can initiate a fresh cycle, i.e. mould closing, which in the machines without guards can be prone to fatal accidents.
 - SCPL recommends use of two cycle start push buttons with N/O contact, wired in series in the front guard input of the PLC. This will ensure that the operator presses both the push buttons continuously till full mold close, keeping his both hands busy and thereby avoiding his hands in mold close path, and probable fatal accident.
- Light curtain sensors are advised to use, which can be connected to PLC emergency or auto break input. This prevents mold close operation, as long as operator body part is within the light curtain range, logically.
- Hydraulic dump valve is also recommended in the series of mold close operation. Either open guard or separately provided foot switch in conjunction with dump valve, can prevent mold close operation, ensuring safety.
- Emergency push button must be located at one or multiple locations on & around the machine, in such a way that the operator can immediately reach it to stop machine operation, whenever the need arises. Again SCPL recommends electrical disconnection in addition to logical safety provided by the PLC.
- Only skilled and well trained person must be allowed to operate the machine & PLC, who is well aware of safety
 requirements and associated risk with the operation of the machine & PLC. For semi auto operation, It is never advisable
 to allow operator to operate the machine & PLC, continuously beyond average working hours, in odd hours like night
 shifts, adverse ambient light etc.



<u>સુરક્ષામાર્ગદર્શિકા</u>

ઇન્જેક્શનમોલ્ડિંગમશીનનાધણાઓપરેશનમાંઇન્ટરલોકપરિસ્થિતિવખતેસુરક્ષામાટેપી.એલ.સીનાહાર્ડવેરતથાસોફ્ટવેરબનાવવામાં ધણીકાળજીરાખવાછતાંકોઈપણમશીનપાર્ટ્સઅથવા

અનેમાણસનેલગતાનુકશાનનાઅમોસ્ટ્રીમલાઈનકંટ્રોલ્સપ્રાઇવેટલિમિટેડજવાબદારનથી.

તેનામાટેઅમોમશીનબનાવવાતશાચલાવવામાટેનાસુરક્ષાનિયમોનોઅમલશાયતેનીસખતભલામણકરીએછીએ.

SCPL નીચેનાસુરક્ષાનિયમોનોકડકઅમલથાયતેનીસખતભલામણકરેછે.

૧.જયારેમાણસઅથવાતોતેનાશરીરનોકોઈપણભાગયાલુઇન્જેકશનમશીનમાંવચ્ચેઆવવાજતોહોયત્યારેબધાજઈલેક્ટ્રીકલ મીકેનીકલતથાહાઈડ્રોલીકઉર્જાસ્ત્રોતબંધથઇજવાજોઈએ.

૨. મશીનનાહલનચલનથતાંપુર્જાજેમકેમોલ્ડક્લોઝદરવાજાથીઢાંકેલાહોવાજજોઈએ.

SCPLનીકોઈપણપીએલસીઆગળતથાપાછળનાદરવાજાનીસ્થિતિનેમોલ્ડક્લોઝઓપરેશનદરમિયાનસતતચકાસણીકરેછે. દરવાજાખુલ્લાહોવાનીસ્થિતિમાંમોલ્ડક્લોઝદરમિયાનપી.એલ.સીનીચકાસણીઉપરાંતઈલેક્ટ્રીકલતથાહાઈડ્રોલીકઉર્જાસ્ત્રોતબંધથાય તેમુજબનીવ્યવસ્થાઅચૂકકરવીજોઈએ.

૩. જેમશીન (વર્ટીકલઇન્જેક્શનમોલ્ડિંગમશીન) જાણીજોઈનેજરાપણઅથવાનહીવતસુરક્ષાપ્રમાણે, એટલેકેઆગળ/ પાછળદરવાજાવગરબનાવેલહોયતેનીઅમો SCPL હિમાયતકરતાનથી, તેમછતાંતેવામશીનમાટેઅમોનીચેદર્શાવેલસુરક્ષાવિષયકકડકસૂયનોનોઅમલકરવાનીભલામણકરીએછીએ.

> SCPLસાઇકલસ્ટાર્ટઈનપુટતરીકેઇલેક્ટ્રિકલN/Cકોન્ટેક્ટકદીનહિવાપરવાનીસલાહઆપેછે.

- સેમીઓટોમોડમાં, N/C કોન્ટેક્ટનાખામીયુકતકાર્યથીફરીથીનવીસાઇકલશરુથઇજવાનીસંભાવનારહેલીછે. જેમકેમોલ્ડક્લોઝથવો ., કેજેદરવાજાવગરનામશીનમાંમોટોજીવલેણઅકસ્માતકરાવીશકેછે.
- > SCPL બેસાઇકલસ્ટાર્ટપુશબટનકેજેમાં N/O

કોન્ટેક્ટવાપરેલહોયતથાતેબંનેસીરીઝમાંઆગળનાદરવાજાનાપી.એલ.સીઈનપુટમાંલગાવેલહોવાજોઈએતેવુંસુચનકરેછે , જેથીમશીનઓપરેટરનેબંનેસાઇકલસ્ટાર્ટપુશબટનમોલ્ડક્લોઝથાયનહિત્યાંસુધીદબાવીરાખવાપડશેજેથીજીવલેણઅકસ્માતથવા નીસંભાવનાનિવારીશકાયછે.

૪. SCPLપ્રકાશનાપડદાવાળાસેન્સર (Light Curtain) વાપરવાનીસલાહઆપેછે, જેપી.એલ.સીનાઈમરજન્સીકોન્ટેક્ટઅથવાતોઓટોસાઇકલબ્રેકઈનપુટસાથેકનેકટકરીશકાયછે. જેમશીનઓપરેટરનાશરીરનાકોઈપણઅંગપ્રકાશનાપડદાવાળાસેન્સર (Light Curtain)નાવિસ્તારમાંઅવતાજમોલ્ડક્લોઝઓપરેશનનેબંધકરીદેછે.

પ. અમેહ્નઇડ્રોલિકડમ્પવાલ્વકેજેમોલ્ડક્લોઝનાવાલ્વનીસીરીઝમાંલગાવવાશીમળતીસુરક્ષાનીપણભલામણકરીએછીએ. ઓપનગાર્ડઅથવાઅલગશીમુકેલ Foot સ્વીચ(પગવડેદબાવવાનીસ્વીચ) નેડમ્પવાલ્વસાથેલગાવવાશીસુરક્ષાનીજરૂરીયાતવખતેમોલ્ડક્લોઝરોકીશકાયછે.

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ઈમરજન્સીપુશબટનનેમશીનમાંએકઅથવાએકકરતાવધારેજગ્યાએલગાવવાથીઓપરેટરતેનીઅકસ્માતસમયનીસ્થિતિમાંજલ્દીથી તેનેદબાવીનેમશીનરોકીશકેછે.ફરીવખત SCPL પી.એલ.સીદ્રારામળતીસુરક્ષાઉપરાંતઈલેક્ટ્રીકલજોડાણકાપવાનીભલામણકરેછે. ૭.

ફક્તકુશળતથાતાલીમબદ્ધમાણસોનેજમશીનતથાપી.એલ.સીનેઓપરેટકરવાદેવાકેજેઓમશીનતથાપી.એલ.સીનાસંચાલનનેલગ તાજોખમતથાતેનેલગતીસુરક્ષાજરૂરીયાતથીવાકેક્હોય. સેમીઓટોમોડનીકામગીરીવખતેઓપરેટરેક્યારેપણસરેરાશકામનાકલાકોઉપરાંતરાતપાળીતથાખરાબપ્રકાશનીસ્થિતિમાંસતતકામ કરવાનુંસલાહભર્યુંનથી.



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			stre				
			3 TIN	N • WO			
(1)	FUNCTIO						
(-/	(1)	MOLD SAFETY					
	(2)	HEAT ON FUNCTION					
	(3)	HAND					
	(4)	SEMI AUTO					
	(5)	FULLY AUTO					
	(6)	DIESET					
	(7)	PURGE					
(M)	DIMENSION DRAWING:						
(N)	WIRING D	DIAGRAM:					

(A) **SPECIFICATIONS:**

Input	
Power:	
Voltage	24 V DC ± 1%
Control:	
Thermocouple	J / K type Isolated
Proximity/Limit	NPN (NO type)
Switches	10-30 Vdc 50 mA Max.
Output	For 24 V DC -1.5 Amp Max- MOSFET Driver Output
Environment	
Temperature	0ºC to 55ºC
Humidity	5 to 95% RH non-condensing
•	
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(B) INTRODUCTION

INJkon is a complete proven & reliable control system for Injection Molding Machine. System consists of three units.

- (1) MMI unit
- (2) Combi card
- (3) SMPS

(1) Operating Panel:

This is small lightweight Display unit with Touch Screen TFT Color Display &soft touch keypad. This unit is connected toCombi Card via 15core factory assembled flexible cable.

(2) Combi Card:

Combi Card Consist of Different Terminals,

You can wire Digital Input, Digital Output, Analog Output, Analog Input, Thermocouples to the Terminal.

This package has some obvious advantages over existing conventional Electrical Systems. This occupies lesser Spacethan conventional system. The simplicity of wiring from solenoids to systems or limit switches to system and From Thermocouples to system makes it easier and less time consuming for commissioning. This system has no movingParts, so periodical maintenance is drastically reduced and there for reliability is definitely improved. Function like suckback ON-OFF, Heating ON-OFF and Cycle Time Interlock makes this system much more superior then the conventional system.

(C) FEATURES

- Inherently reliable Micro controller based technology 8051 / 100 MHz CPU.
- Offers up to 64 digital inputs, Up to 64 digital outputs, 8 Analog Inputs, 10 Analog Output, 8-zone time Proportional controlled Temperature Controllers, 2 Zone % Heat control, timers, Extensive feather touch membrane keypad for user interface for manual/Semi auto/fully auto functions of the machine.
- Latest E²PROM Technology ensures security of programmed parameters.
- User friendly programming through an extensive membrane keypad for easy operator interface (Details of

Manual mode operations available is appended on separate sheet)

- Five digits batch counter to count Number of Pieces & Six digit Totalizer counter.
- Six digits hour counter.
- Bad Pcs Counting as per Cushion__mm.
- Multi shot ejector Function up to 5 Shots Timer Based.
- Limit Settable of pressure, Speed, AN3& AN 4 in Config Page.
- Mold Spray Function.
- Cushion Function.
- Adaptive temperature functions for temperature.
- Facility for counting cycle time helpful in production analysis.

STREAMLINE CONTROLS PVT.LTD.

Three different operating programs for Hydraulic Ejector operations provide to suit the operational needs

With various molds.

- Provide 3 Core operation and all of 3 cores are independently work as per select operating mode in Core IN & OUT function.
- Four different operating programs for Air Ejector operations provide to suit the operational needs with various molds.
- Thermocouple "Open" & "Reverse" conditions are self detected and are displayed as "Open" and "Rev" respectively.
- Programmable High & Low limits for all temperature zones.
- Automatic cold junction compensation for Thermocouple inputs.
- Mold Safety interlock provided in case of abnormal pressure rise while the mold is getting closed (For that pressure

Switch input has to be provided in case of limit switch.)

- Inbuilt interlocks for Low & High temperature, Front and/or Back guards, Maximum Cycle Time, Emergency stop, etc.
- Built in 200 sets of mold memory Alpha numeric data entry base.
- Graphics Image Moveable & All Function Page.
- USB Feature Available.
- ✤ All Page Help Available.
- Operating Input/output diagnosis.
- Central lubrication control with precisely On/Off timer or number of cycle base.
- Data logging & analysis for last 100 interlocks history, Hourly production for last running 24 hours, and Monthly

production for last 30 running days.

(D) SCPL SCOPE OF SUPPLY

- 1. MMI (Man Machine Interface)
- 2. Mounting Clamp
- 3. Combi Card
- 4. Inter connecting cables.
- 5. SMPS.
- 6. CD (Operating Manual, IO List)

(E) PROGRAMMING OF THE SYSTEM

The PLC Controller will be programmed as per given Input output List / Sequence of the Injection Molding Machine.





() ()	Streamline Controls Private Limited							
Streamline Contro	INJKon Manufactured By ols Private Limited Gandhinagar,Gujarat,India							
For PLC Complaint/Repairs Contact : Customer Care : 9328808665/9328808669								
Version Code :	V1.08							
Sequence Code :	IX10810800001							
Graphics Code :	V1.08							
Help 🥐	www.streamlinecontrols.com	Home						



(F) OPERATING PANEL DESCRIPTION



Screen Page : MONITOR

This is the monitor screen, it will come up after the startup screen. In this screen you can see the movement of the machine in graphic form, Also, you can see the actual position of the machine (in mm), the mold memory name, the actual graphic motion of the speed and pressure, motor on off indication, lubrication on off indication.



• Touch menu key bar

This is the touch menu bar where you can see the different touch keys, this menu key contains a parameter corresponding to the function, and the information for each key is as follows.





Press the "MONITOR" Key at the bottom of the touch screen . The MONITOR Page screen appears.



Press the "MOLD"Key at the bottom of the touch screen. The MOLD Page screen appears.



Press the "CORE"Key at the bottom of the touch screen. The CORE Page screen appears.



Press the "EJECTOR"Key at the bottom of the touch screen. The EJECTOR Page screen appears.



Press the "TEMP."Key at the bottom of the touch screen. The TEMP Page screen appears.



Press the "CARRIAGE"Key at the bottom of the touch screen. The CARRIAGE Page screen appears.



Press the "SCREW"Key at the bottom of the touch screen. The SCREW Page screen appears.



Press the "FAST SETTING"Key at the bottom of the touch screen. The FAST SETTING Page screen appears.



Press the "NEXT"Key at the bottom of the touch screen. The NEXT page menu key appears.





Press the "PREVIOUS"Key at the bottom of the touch screen. The PREVIOUS Page menu key appears.



Press the "CONFIG"Key at the bottom of the touch screen. The CONFIG Page screen appears.



Press the "CALI.AI"Key at the bottom of the touch screen. The CALI.AI Page screen appears.



Press the "CALI.AO"Key at the bottom of the touch screen. The CALI.AO Page screen appears.



Press the "CALI TEMP."Key at the bottom of the touch screen. The CALI TEMP Page screen appears.



Press the "INPUT"Key at the bottom of the touch screen. The INPUT Page screen appears.



Press the "OUTPUT"Key at the bottom of the touch screen. The OUTPUT Page screen appears.





INTERLOCK

Press the "INTERLOCK"Key at the bottom of the touch screen. The INTERLOCK Page screen appears.



Press the "HOURL"Key at the bottom of the touch screen. The HOURLY production Page screen appears.



Press the "DAILY"Key at the bottom of the touch screen. The DAILY Production Page screen appears.



Press the "SHOT MONITOR"Key at the bottom of the touch screen The SHOT MONITOR Page screen appears.



Press the "MEMORY"Key at the bottom of the touch screen. The MEMORY Page screen appears.



Press the "USB"Key at the bottom of the touch screen. The USB Page screen appears.





Press the "INDEX"Key at the bottom of the touch screen. The INDEX Page screen appears.



Press the "ABOUT US"Key at the bottom of the touch screen. The ABOUT US Page screen appears.



Press the "PRO.DATA"Key at the bottom of the touch screen. The PRO.DATA Page screen appears.



Press the "BRIGHTNESS"Key at the bottom of the touch screen. The BRIGNTNESS Page screen appears.



Press the Left Arrow Key At the top of the page screen. The Previews page screen appears.



Press the Right Arrow Key At the top of the page screen. The Next page screen appears.



Press the Alarm Key At the bottom of the page screen. To Reset the alarm



Press the heat key At the Bottom of the page screen. To heat on/off



Press the Healp Key At the bottom of the page screen. The Help Page Screen appears.

Manual key

This is the manual keys the information for each key is as follows.







Slide Key Push for activate of Slide In action manually. Push for activate of Slide Out action manually.





Air 1,2,3,4 Option Key Push for activate of Air 1,2,3,4 Option action manually.



Motor On Key Push this to Start Hydraulic Motor Motor Off Key Push this to Stop Hydraulic Motor



Configure 1,2,3,4 Option Key Push for activate of F1 1,2,3,4 Option action manually. Push for activate of F2 1,2,3,4 Option action manually.



Hand key Operating Machine by Manual Key.



Semi Auto Key Operating Machine in semi-auto recyclig and re-started by front safety door open and close again.



Die Set Key For Select mold adjustment function. In this mode fast approach function is not activate for mold open & close.



Purge Key Push for select Purge Mode.



Auto Key Operate machine in fully automatic production mode. To be Operate AUTO DIESET function in Die Set mode.

Note:- Mold Height +& Mold Height – Manually work in Dieset Mode.

(1)

2

CLEAR

Enter Password

0-9999

1



1

2

3

CLEAR



If you are setting this parameter for the first time, you will need to enter a password, so the keypad as per image 1 will open. What level of password to put in it is blinked in red color in action box at the bottom of the screen?

Mold Close

- 2. Now use 0 to 9 digits to enter the password, and then press enter. Now you can change the parameter.
- 3. Now if you press the parameter (Mold Close Slow1 AN3), the keypad will open as per image 3, now set the parameter with numeric key and press enter, So that parameter will be saved there.
- 4. Here "clear" key is used to parameter value zero in key pad display. And "ESC" key is used to close the keypad.
- 5. Use "INC(+)" and "DEC (-)" key if you want to change the parameter shown in image 2 (Safety =on).

(G) MANUAL MODE OF OPERATIONS



1	Mold Open	13	Mold Close
2	Carriage Forward	14	Carriage backward
3	Ejector Forward	15	Ejector Backward
4	Injection	16	Refill
5	Core in (I)	17	Core Out (I)
6	Suck Back	18	Spare key
7	Core in (II)	19	Core Out (II)
8	Airiet Punch	20	Airjet cavity
9	Core in (III)	21	Core Out (III)
10	Gate Open	22	Gate Close
11	Mold Height (+)	23	Mold Height (-)
12	Motor on	24	Motor Off

(H) Precautions to prevent damage from human and machine, we recommend to strictly obey the following safety procedures.

- Equipment must be operating under correct power. (Install a voltage stabilizer or CVT while need)
- Earth terminal must be connected to qualified terminal.
- All electrical elements with EARTH terminal, it is necessary for users to connect with the EARTH terminal.
- The high power cables should be separated from the low power cables to avoid interferes.
- To prevent fire or hazard shock, do not expose the unit to rain or moistly place.
- Please understand the operating process before use.
- When system shut down, wait 10seconds for re-start.
- Thermocouples used for this system must be isolated (ungrounded) Fe/k or CR/L type.
- The wiring of each zone starting from thermocouple of heater must be verified.
 For ex: first zone thermocouple must be connected to first channel of the system and heater of first zone must be connected to heater 1 of the system.
- The limit switch and solenoids wiring must be done as per given wiring diagram.
- If the proximity switches are used then use NPN-NO, PNP-NO type proximity switches (customer require).
- While using Incremental Encoder for positioning single phase UPS is must be required for control supply.

(I) SETTING PROCEDURES

Screen Page: MOLD 1/5

MOLD



(1)Press" MOLD v key once on the bottom of the Touch Screen.

(2) NowScreen Page: **MOLD 1/5** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit. (If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

MOLD 1/5 page and list of parameter is given below.

- 🖑	HA	ND		MOLD 1/5		03/1	2/20	19 🛣 10	:10:54
<	M	Mold mm 0000.0		Screw mm 000.0	1	Ejector mm 000.0	♣	Ton mm 000.0	$\overline{\mathbf{N}}$
	S	Speed (%) 100) P	Pres. (bar) 060	%	AN 3 000	%	AN 4 000	

M	Mold Close									
	Slow 1	Fast	Slow 2	Safety 1	Safety 2	Ton 1	Ton 2			
Speed(%)	030	030	030	030	030	030	030			
Pres.(bar)	030	030	030	030	030	030	030			
Posi(mm)	0200.0	0150.0	0140.0	0120.0	0110.0	100.0	100.0			
Time(sec)	01.0				03.0	01.0	01.0			
Delay(sec)]					01.0				

			Mold	Open		
	Slow 3	Slow 2	Fast	Slow 1	Dcomp2	Dcomp1
Speed(%)	030	030	030	030	030	030
Pres.(bar)	030	030	030	030	030	030
Posi(mm)	0250.0	0230.0	0200.0	0050.0	050.0	050.0
Time(sec)				01.0	01.0	01.0
Delay(sec)						01.0



Ninecon.

Page		Message Of	Function	Parameter -	Parameter	Description	Operating	Part Of
Sr No	Name	Parameter	Description	Description	Parameter	Range	Password	Memory
	Nume	On Screen	Description	Description	Туре	nunge	Level	MOUN
	MOLD 1/5		With select Position in type From mold fully open position to this position mold moves slow in close direction.	Set Mold close slow 1 function over operating position.	Position	0000.0 – 2000.0mm	User	Yes
1		Close Slow1		Set Close Slow1 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Close Slow1 function operating Speed proportional output	Speed	000% – 100%	User	Yes
	MOLD 1/5	Close Fast	With select Position in type From mold Close Slow1 position to this position mold moves Fast in close direction.	Set Mold close fast function over operating position.	Position	0000.0 – 2000.0mm	User	Yes
2				Set Close Fast function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Close Fast function operating Speed proportional output	Speed	000% – 100%	User	Yes
				Set Close Slow2 function over operating position.	Position	0000.0 – 2000.0mm	User	Yes
3	MOLD 1/5	Close Slow2	With select Position in type From mold Close Fast position to this position mold moves Slow in close direction.	Set Close Slow2 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
	へい			Set Close Slow2 function operating Speed proportional output	Speed	000% – 100%	User	Yes

4	MOLD 1/5	Safety1 End	With select Position in type From mold Close Slow2 position to this position mold moves Slow in close direction. Here mold safety time observe position if in settable mold safety time actual position is not reach safety 2 end position than create IL Mold Safety Time Over and mold gets open.	Set Mold close Safety 1 function over operating position. Set Close Safety 1 function operating pressure proportional output Set Close Safety 1 function operating Speed proportional output	Position Pressure Speed	0000.0 – 2000.0mm 000 – 255Bar 000% – 100%	User User	Yes
5	MOLD 1/5	Safety2 End		Set Close Safety 2 function over operating position. Set Close Safety 2 function operating pressure proportional output Set Close Safety 2 function operating	Position Pressure Speed	0000.0 – 2000.0mm 000 – 255Bar	User User User	Yes Yes
				Speed proportional output Set Close Safety function operating time.	Time	100% 00.0 – 99.9Sec	User	Yes
6	MOLD 1/5	Lock Ton 1	Locking Tonnage1. After completion of mold safety stage operate locking delay as per its set delay and then applying tonnage for moving platen fully close.	Set locking tonnage1 function over operating position.	Position	000.0 – 999.9mm	User	Yes
	5							

				Set locking			ali	Vas
				tonnage 1 function operating pressure proportional output	Pressure	000 – 255Bar	User MM	M · WO
	MOLD 1/5			Set locking tonnage 1 function operating Speed proportional output	Speed	000% - 100%	User	Yes
				Set locking tonnage 1 function operating delay.	Delay	00.0- 10.0Sec	User	Yes
				Set locking tonnage 1 function operating time.	Time	00.0 – 99.9	User	Yes
	MOLD 1/5	Lock Ton 2	Locking Tonnage 2. After completion of locking tonnage stage 1 applying tonnage 2 for moving platen fully close.	Set locking tonnage 2 function over operating position.	Position	0000.0 – 2000.0mm	User	Yes
7				Set locking tonnage 2 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set locking tonnage 2 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				Set locking tonnage 2 function operating time.	Time	00.0 – 99.9 Sec	User	Yes
8	MOLD 1/5	Slow Open3	With select Position in type From mold Slow Open2 position to this position mold moves Slow in open direction and stop on set position.	Set Slow Open 3 (Open End) function over operating position.	Position	0000.0 – 3000.0mm	User Level	YES

Q	MOLD			Set Slow Open 3 function operating pressure proportional output	Pressure	000– 255Bar	User Level	YES 72
5	1,5			Set Slow Open 3 function operating Speed proportional output	Speed	000% - 100%	User Level	YES
10			With select Position in type From mold Fast Open position to this position mold moves Slow in open direction.	Set Slow Open 2 function over operating position.	Position	0000.0 – 3000.0mm	User Level	YES
	MOLD 1/5	Slow Open2		Set Slow Open 2 function operating pressure proportional output	Pressure	000– 255Bar	User Level	YES
				Set Slow Open 2 function operating Speed proportional output	Speed	000% – 100%	User Level	YES
		Fast Open	With select Position in type From mold Slow Open1 position to this position mold moves Fast in open direction.	Set Fast Open function over operating position.	Position	0000.0 – 3000mm	User Level	YES
11	MOLD 1/5			Set Fast Open function operating pressure proportional output	Pressure	000– 255Bar	User Level	YES
				Set Fast Open function operating Speed proportional output	Speed	000% – 100%	User Level	YES
12			With select Position in type From mold	Set Slow Open 1 function over operating position.	Position	0000.0 – 3000.0mm	User Level	YES
	MOLD 1/5	Slow Open1	fully close position to this position mold moves slow in open direction.	Set Slow Open 1 function operating pressure proportional output	Pressure	000– 255Bar	User Level	YES

				Set Slow Open 1 function operating Speed proportional output Set Slow Open 1 function operating Time	Speed Time	000% - 100% 00.0 - 99.9Sec	User Level	YES
				Decompression Function. Set decompression function over operating position.	Position	000.0 – 3000 mm	User Level	YES
				Set decompression function operating pressure proportional output	Pres0073u re	000– 255Bar	User Level	YES
	ΜΟΙ D	Decompress	This function is use in RAM type	Set decompression function operating Speed proportional output	Speed	000% – 100%	User Level	YES
13	1/5	ion	injection molding machine to reduce tonnage pressure.	Decompression delay time. This time is for ram type machine only. This time operate only in semi or fully auto mode cycle. This time should be run if AFTER INJ option select in DECMP OPT [refer Pg19:Mold Open (2/3)]. Set	Delay	00.0 – 99.9Sec	User Level	YES
		$\boldsymbol{\varsigma}$		function operating Time	Time	99.9Sec	User Level	
	5							

Ň

Screen Page: MOLD 2/5

MOLD



(1)Press" (1)Pre

(2) NowScreen Page: **MOLD 2/5** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit.

(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

Mold 2/5page and list of parameter is given below.

- U	HAND		MOLD 2/5			10 03/12/2019			:10:54
	M	Mold mm 0000.0		Screw mm 000.0	1	Ejector mm 000.0	- 	Ton mm 000.0	
	S	Speed (%) 100	Ρ	Pres. (bar) 060	%	AN 3 000	%	AN 4 000	

	Mold Close									
- 14	Slow 1	Fast	Slow	2	Safety 1	Safety 2	Ton 1	Ton 2		
AN 3(%)	030	030	030		030	030	030	030		
AN 4(%)	030	030	030)	030	030	030	030		
Safety		on		Т	otal Time		010.0			
Fast Appro	ach)	on		(M	old Close	Boost	t) 0			

	Mold Open								
	Slow 3	Slow 2	Fast	Slow 1	Dcomp2	Dcomp1			
AN 3(%)	030	030	030	030	030	030			
AN 4(%)	030	030	030	030	030	030			

Fast Approach	on	(Total Time	010.0
		Mold Open Boost	0

Alarm							Не	lp ?
Action	1						He	at 🚈
	-		I	ţ		4000	₽₩S	7
MONITOR	MOLD	CORE	EJECTOR	TEMP.	CARRIAGE	SCREW	FAST SETTING	NEXT

		Message			Parameter I	Description	Operation	Part Of	
Sr No	Page	Of	Function	Parameter	Darameter		Deceword	Memory	
	Name	Parameter	Description	Description	Type	Range		S.C	
		On Screen			туре		Level M	M. WO	
				Set Close Slow1				Yes	
				operating AN2		000% –	llsor		
				proportional	ANS	100%	User		
1	MOLD	Close		output					
-	2/5	Slow1		Set Close Slow1				Yes	
	7 -			function		0000/			
				operating AN4	AN4	000% -	User		
				proportional		100%			
				output					
				Set Close Fast				Yes	
				function		000% -			
				operating AN3	AN3	100%	User		
				proportional					
2	MOLD	Close Fast		Output				Vec	
	2/5			Set Close Fast				res	
				operating ANA		000% –	llsor		
				proportional		100%	User		
				output					
				Set Close Slow2				Yes	
				function		0000/			
	MOLD	10LD Close		operating AN3	AN3	000% - 100%	User		
			Close		proportional		100%		
3				Close		output			
5	2/5	Slow2		Set Close Slow2				Yes	
				function		000% –			
				operating AN4	AN4	100%	User		
				proportional					
				Sot Close				Voc	
				Safety1				165	
				function		000% -			
				operating AN3	AN3	100%	User		
				proportional					
	MOLD	Safety 1		output					
4	2/5	End		Set Close				Yes	
				Safety1					
				function	AN4	000% –	User		
				operating AN4		100%	••••		
				proportional					
				output				Voc	
				Set Close				res	
	MOLD	Safety 2		function		000% -			
5	2/5	End		operating AN3	AN3	000% – 100%	User		
				proportional					
				output					
U									

6	MOLD	Lock Top 1		Set Locking tonnage1 function operating AN3 proportional output	AN3	000% – 100%	User 3	Yes of the second
0	2/5			Set Locking tonnage1 function operating AN4 proportional output	AN4	000% - 100%	User	Yes
7	MOLD	Lock Top 2		Set Locking tonnage2 function operating AN3 proportional output	AN3	000% - 100%	User	Yes
/	2/5	LOCK TON 2		Set Locking tonnage2 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
8	MOLD 2/5	Safety	See Functional Description	Select Mold close safety function enable (on) or disable (off).	Function	On/Off	Level 1	Yes
9	MOLD 2/5	Fast Approach	With on of this function Slow-Fast- Slow sequence done during Mold Close function. With off of this function Mold Close moves only in Slow motion.	Fast Approach function on/off.	Function	On/Off	Level1	Yes
10	MOLD 2/5	Total Time		Total time for mold close function. If mold close time is exceed from total time at that time system come in hand mode & display IL.MOLD CLOSE TIMER OVER.	Time	00.0 – 99.9sec	Level 2	Yes
11	MOLD 2/5	Mold Close Boost	Select various type of pump selection with close function as per output	Select Mold Close Boost option.	Number	0-5	Level 1	Yes

			selection provide in sequence table. With boost selection 0 to 3 provide fix output selection. With boost selection 4 pump selection very with set pressure proportional output. With boost selection 5 pump selection very with set Speed proportional output.	Set flow			stres. M	Meco Cos
12	MOLD 2/5	Slow Open3		Set Slow Open3 function operating AN3 proportional output Set Slow Open3 function	AN3	000% - 100%	User Level	YES
				operating AN4 proportional output	AN4	000% – 100%	User Level	
12	MOLD	Slow		Set Slow Open2 function operating AN3 proportional output	AN3	000% – 100%	User Level	YES
15	2/5	Open2		Set Slow Open2 function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
14	MOLD	East Open		Set Fast Open function operating AN3 proportional output	AN3	000% – 100%	User Level	YES
	2/5			Set Fast Open function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
15	MOLD 2/5	Slow Open1		Set Slow Open1 function operating AN3 proportional output	AN3	000% – 100%	User Level	YES

				Set Slow Open1 function operating AN4 proportional output	AN4	000% – 100%	User Level	YES OF
16	MOLD	Decompres		Set decompression function operating AN3 proportional output	AN3	000% - 100%	User Level	YES
10	2/5	sion		Set decompression function operating AN4 proportional output	AN4	000% - 100%	User Level	YES
17	MOLD 2/5	Fast Approach	With on of this function Slow-Fast- Slow sequence done during Mold Open function. With off of this function Mold Open moves only in Slow motion.	Fast Approach function on/off.	Function	On/Off	User Level	YES
18	MOLD 2/5	Total Tim	If mold open time is exceed from total time then system come in hand mode & display ILMOLD OPEN TIMER OVER.	Set Total time for mold open function.	Timer	00.0 – 99.9Sec	Level 2	YES
19	MOLD 2/5	Boost	Select various type of pump selection with open function as per output selection provide in sequence table. With boost selection 0 to 3 provide fix output selection. With boost selection 4 pump selection very with set pressure proportional output. With boost selection 5 pump selection very with set Speed proportional out	Select Mold Open Boost option.	Number	0-5	Level1	YES

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1.00

Screen Page: MOLD 3/5

MOLD

¹ key once on the top of the Touch Screen. (1)Press"

(2) NowScreen Page: **MOLD 3/5** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit. (If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

0000.0 Speed (%)

100

(5) On pressing ENTER key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

> MOLD 3/5 03/12/2019 🛣 HAND 10:10:54 Mold mm Ejector mm Screw mm Ton mm L.

000.0

Pres. (bar)

060

Ρ

Mold 3/5page and list of parameter is given below.

%

0.000

AN 3

000

000.0

AN 4

000

%

Intensifier										
Speed(%)	030	Open	Open Intensifier Off							
Pres.(bar)	030	030 Parallel Intensifier Off								
Time(sec) 00.0 Parallel Intensifier Time 1.0										
AN 3(%)	030 (Parallel Intensifier Low Limit) 000.0									
AN 4(%)	000	Parall	el Intensifier High Lim	it	99	9.9				
Decompres	ssion Opti	ion	Mold Opn		Molo	l Spray				
Thermoset	Thermoset Open Time 0.0 Time 01.0									
Close IL To	olerance (r	mm)	000.0	Co	unt	000				

Alarm						He	elp ?
Action						He	at 🛲
		4	ŧ		4	₽ ₽ \$	7
MONITOR	MOLD CORE	EJECTOR	TEMP.	CARRIAGE	SCREW	FAST SETTING	NEXT

STREAMLINE CONTROLS PVT.LTD.

		Message			Parameter I	Description	Operating	Part Of
Sr No	Page Name	Of Parameter On Screen	Function Description	Parameter Description	Parameter Type	Range	Password Level	Memory
			This function is use in RAM type	Set Open Intensifier function operating pressure proportional output	Pressure	000– 255Bar	User Level	YES
		Open		Set Open Intensifier function operating Speed proportional output	Speed	000% - 100%	User Level	YES
1	MOLD 3/5	Intensifier Open Intensifier	machine to reduce tonnage pressure.	Set Open Intensifier function operating Time	Time	00.0 – 99.9 Sec	Level 1	YES
				Set Open Intensifier function operating AN3 proportional output	AN3	000% – 100%	User Level	YES
				Set Open Intensifier function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
2	MOLD 3/5	Intensifier	With on of this function intensifier sequence done after completion of decompression. With off of this function Mold Open Slow1 start after decompression.	Intensifier functions on/off.	Function	On/Off	Level1	YES
3	MOLD 3/5	Parallel Intensifier	This function operate parallel to mold open function	Parallel Intensifier function on/off.	Function	On/Off	Level 1	Yes
4	MOLD 3/5	Parallel Intensifier Time		Set Parallel Intensifier function operating time.	Time	00.0 – 99.9 sec	Level 1	Yes

5	MOLD 3/5	Parallel Intensifier Low Limits		Set Parallel Intensifier function operating low limit.	Position	000.0 – 999.9	Level 1 3	MM • WO
6	MOLD 3/5	Parallel Intensifier High Limits		Set Parallel Intensifier function operating high limit.	Position	000.0 – 999.9	Level 1	Yes
7	MOLD 3/5	Decompres sion Option	If select Mold Open than decompression start on completion of cooling time. If select After Injection than decompression start on completion of injection function	Select Decompression function operating sequence.	Function	Mold Open/Aft er Injection	Level1	YES
8	MOLD 3/5	Thermo set open time		Set Thermo set option function operating time.	Time	0.0 – 9.9	Level 1	Yes
9	MOLD 3/5	Close IL Tolerance	After mold fully close if close actual position exceed from this set position than system stop all function and create interlock.	Set Close Interlock Tolerance position.	Position	0000.0- 0010.0	Level 1	Yes
10	MOLD	Mold Spray	After set count output turn ON before mold close	Set Mold Spray function operating time.	Time	00.0 – 99.9 Sec	Level1	Yes
	373		in auto cycle as per time set	Set Mold Spray function Count.	Count	000 – 999	Level1	Tes
				Page 34 of 155				

Screen Page: MOLD 4/5

MOLD

(1)Press" (1)Press

(2) NowScreen Page: **MOLD 4/5** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit. (If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

Mold 4/5 page and list of parameter is given below.

	HAND		MOLD 4/5		03/12/201			19 🛣 10	:10:54
<	Ŋ	Mold mm 0000.0		Screw mm 000.0	4	Ejector mm 000.0	- 	Ton mm 000.0	
	S	Speed (%) 100	Ρ	Pres. (bar) 060	%	AN 3 000	%	AN 4 000	

	Gate	Close	Gate	Open	Shutter		
-U∐-	Fast	Slow	Fast	Slow	Close	Open	
Speed(%)	030	030	030	030	030	030	
Pres.(bar)	030	030	030	030	030	030	
AN 3(%)	030	030	030	030	030	030	
AN 4(%)	030	030	030	030	030	030	
Time(sec)					00.0		
Delay(sec)						00.0	
Auto Die C	nf.Time (S	00.0					

Alarm							He	elp ?
Action	1						He	eat 🛲
D			I	ţ	-6	-	F¢S	♪
MONITOR	MOLD	CORE	EJECTOR	TEMP.	CARRIAGE	SCREW	FAST SETTING	NEXT

	Daga	Message Of Parameter On Screen	Function Description	Damanatan	Parameter Description		Operating	Part Of Memory
Sr No	Page Name			Parameter Description	Parameter Type	Range	Password Level 4	MA . WO
1	MOLD 3/5	Gate Close Fast		Set Front Safety Gate Fast Close function operating pressure proportional output	Pressure	000 – 255Bar	Level 1	Yes
				Set Front Safety Gate Fast Close function operating Speed proportional output	Speed	000% - 100%	Level 1	Yes
				Set Front Safety Gate Fast Close function operating AN3 proportional output	AN3	000% – 100%	Level 1	Yes
				Set Front Safety Gate Fast Close function operating AN4 proportional output	AN4	000% – 100%	Level 1	Yes
				Set Front Safety Gate Slow Close function operating pressure proportional output	Pressure	000 – 255Bar	Level 1	Yes
2	MOLD 3/5	Gate Close Slow		Set Front Safety Gate Fast Close function operating Speed proportional output	Speed	000% – 100%	Level 1	Yes
				Set Front Safety Gate Slow Close function operating AN3 proportional output	AN3	000% – 100%	Level 1	Yes
G		1			1	I	1	
				Set Front Safety			Level 1	Yes
---	------	-----------	---	----------------------	----------	------------------	---------	---
				, Gate Slow Close			Û	í Co
				function		000% -	Str	S.C
				operating AN4	AN4	100%	n,	hin allo
				proportional				1701 0 0
				output				
				Set Front Safety			Level 1	Yes
				Gate Fast Open				Yes Yes
				function				
				operating	Pressure	000 –		
				pressure		255Bar		
				, proportional				
				output				
				Set Front Safety			Level 1	Yes
				Gate Fast Open				
				function		000% -		
				operating Speed	Speed	100%		
				proportional				
3	MOLD	Gate Open		output				
	3/5	Fast		Set Front Safety			Level 1	Yes
				Gate Fast Open				
				function		000% –		
				operating AN3	AN3	100%		
				proportional				
				output				
				Set Front Safety			Level 1	Yes
				Gate Fast Open				
				function		000% -		
			A	operating AN4	AN4	100%		
				proportional				
				output				
				Set Front Safety			Level 1	Yes
				Gate Slow Open				
				function		000		
				operating	Pressure	000 - 255 Par		
				pressure		ZOODdi		
				proportional				
				output				
				Set Front Safety			Level 1	Yes
	MOID	Gate Open		Gate Slow Open				
4	3/5	Slow		function	Speed	000% –		
	575	510 00		operating Speed	Speed	100%		
				proportional				
				output				
				Set Front Safety			Level 1	Yes
				Gate Slow Open				
				function	AN3	000% –		
				operating AN3		100%		
				proportional				
				output				

				Set Front Safety Gate Slow Open function operating AN4 proportional	AN4	000% – 100%	Level 1	Yes or
5		Shutter Close	After mold safety step over & before starting Tonnage function shutter close function on	output Shutter Close function. Set Shutter Close function operating pressure proportional output	Pressure	000 – 255Bar	Level 1	Yes
			till to receive shutter close input.	Set Shutter Close function operating Speed proportional output	Speed	000% – 100%	Level 1	Yes
				Set Shutter Close function operating AN3 proportional output	AN3	000% – 100%	Level 1	Yes
				Set Shutter Close function operating AN4 proportional output	AN4	000% – 100%	Level 1	Yes
				Set Shutter Close operating delay time.	Delay	00.0 – 99.9 Sec	Level 1	Yes
			After decompression function over start	Shutter Open function. Set Shutter Open function operating pressure proportional output	Pressure	000 – 255Bar	Level 1	Yes
6		Shutter Open	and over on it shutter open function take place till receive shutter	Set Shutter Open function operating Speed proportional output	Speed	000% – 100%	Level 1	Yes
			open input.	Set Shutter Open function operating AN3 proportional output	AN3	000% – 100%	Level 1	Yes
C	0							

	Set Shutter Open function operating AN4 proportional output	AN4	000% – 100%	Level 1 an	Yes 7
	Set Shutter Open operating delay time.	Delay	00.0 – 99.9 Sec	Level 1	Yes

Screen Page: MOLD 5/5





(1)Press" key once on the top of the Touch Screen.

(2) NowScreen Page: **MOLD 5/5** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit. (If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.



 HAND			MOLD 5/5 🗰 03/12/2019 🔀 10					:10:54
N	Mold mm 0000.0		Screw mm 000.0	1	Ejector mm 000.0	♣	Ton mm 000.0	
S	Speed (%) 100	Ρ	Pres. (bar) 060	%	AN 3 000	%	AN 4 000	

		M	old		Auto Dieset					
- 19	Close	Open	Height+	Height-	Height+	Height-				
Speed(%)	030	030	030	030	030	030				
Pres.(bar)	030	030	030	030	030	030				
AN 3(%)	030	030	030	030	030	030				
AN 4(%)	000	000	000	000	000	000				

Mold Height (mm)	0050	Required Tonnage	0200
Auto Dieset	Off	Mold Close Time	01.0

Mold Height Boost 00

Alarm							He	lp ?
Action	1						He	at 🚈
Û	×		4	ţ	-6	-	F‡	♪
MONITOR	MOLD	CORE	EJECTOR	TEMP.	CARRIAGE	SCREW	FAST SETTING	NEXT



					Param	eter	m	Part Of
Sr	Page	Message Of		Parameter	Descri	otion	Operating	Memory
No	Name	Parameter	Function Description	Description	Parameter		Password	S.C.
		On Screen			Туре	Range	Level 4	MM · WO
				Set Mold Close				Yes
				function				
				operating	Droccuro	000 -		
				pressure	Flessule	255Bar	Level 1	
				proportional				
			Mold moves in close	output				
			direction in slow	Set Mold Close				Part Of Memory word evelPart Of Memory yemory YesVel 1YesVel 1Yes
1		Mold Close	motion in Die Set	Tunction	Speed	000% –		
	5/5		AUTO and FULLY AUTO	operating speed	speed	100%	Level I	
			mode in this mode.	output				
			mode in this mode.	Set Mold Close				Yes
				function	\sim	0000/		
				operating AN3	AN3	000% -	Level 1	
				proportional		100%		
				output				
				Set Mold Close				Yes
				function	A N I A	000% –	Laural 4	
				operating AN4	AN4	100%	Level 1	
				proportional				
				Set Mold Open				Yes
				function				105
				operating	D	000 -	1	
				pressure	Pressure 255Bar Level 1			
				proportional		255Bar		
				output			Level 1 Yes Level 1	
				Set Mold Open				Yes
			Mold moves in open	function	Const	000% –		
			direction in slow	operating Speed	Speed	100%	Level 1	
2	MOLD	Mold Open	motion in Die Set					
2	5/5	Mold Open	mode. Disable SEMI	Set Mold Open				Yes
			AUTO and FULLY AUTO	function		0000/		
			mode in this mode.	operating AN3	AN3	000% -	Level 1	
				proportional		100%		
				output				
				Set Mold Open				Yes
				function		000% –		
				operating AN4	AN4	100%	Level 1	
				proportional				
			Increase distance	Set Mold Height				Yes
			between moving	Maximum				
	MOLD	Male	platen and fix platen	function		000		
3			with help of this	operating	Pressure	000 – 255Bar	Level 1	
	5/5		function. This function	pressure				
			is use in only toggle	proportional				
			type machine.	output				

				Set Mold Height Maximum function operating Speed proportional output	Speed	000% - 100%	Level 1 m	Yes Ar
				Set Mold Height Maximum function operating AN3 proportional output	AN3	000% - 100%	Level 1	Yes
				Set Mold Height Maximum function operating AN4 proportional output	AN4	000% – 100%	Level 1	Yes
				Set Mold Height Minimum function operating pressure proportional output	Pressure	000 – 255Bar	Level 1	Yes
4	MOLD	Mold Height-	Decrease distance between moving platen and fix platen with help of this function	Set Mold Height Minimum function operating Speed proportional output	Speed	000% – 100%	Level 1	Yes
	575		This function is use in only toggle type machine.	Set Mold Height Minimum function operating AN3 proportional output	AN3	000% – 100%	Level 1	Yes
				Set Mold Height Minimum function operating AN4 proportional output	AN4	000% – 100%	Level 1	Yes
5	MOLD 5/5	Auto Die set	Auto die height adjustment and also set locking tonnage with use of this feature. This feature is use for toggle type machine only.	Select Auto Die set function On/Off. With press FULL AUTO key in die set mode start auto die set function.	Function	On/Off	Level 1	Yes
6	MOLD 5/5	Mold close Time	Mold close time for die set mode only. This time operate parallel	Set mold close time for auto die set mode only.	Time	00.0- 99.9Sec		Yes

			to mold close function and if mold is not fully close during this time over than mold gets open and adjust mold height maximum.				Level 1	MA · WOS
7	MOLD 5/5	Mold Ht Boost	Select various type of pump selection with mold height function as per output selection provide in sequence table. With boost selection 0 to 3 provide fix output selection. With boost selection 4 pump selection very with set pressure proportional output. With boost selection 5 pump selection very with set Speed proportional output.	Select Mold Height Boost option.	Number	0-5	Level 1	Yes

X

INJKon Rainbow X Manual

Screen Page: CORE 1/3

CORE



(1)Press" core v key once on the bottom of the Touch Screen.

(2) NowScreen Page: **CORE 1/3** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit. (If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

th.							4/0		[[]]]	_			7	
	HA	NL			C	ORE	1/3			3/1:	2/20 [.]	19	<u> </u>	:10:54
	- N		lold mm 0000.0	-	So	rew: 000.	mm 0		Ejector n 000.0	nm		10n 00	mm 0.0	
	S	S	peed (%)	Р	Pr	'es. (bar)	%	AN 3		%	AN	4	
_		_	100	•		060			000		/0	00)0	
	K				Core	bre 1					Core 2			
	•	4	In		Ou	t	Par Out		In	_	•	Dut	Pa	r Out
Spee	ed(%)		030		03	0	0	30	030		0	30		030
Pres	.(bar))	030		03	0	0	30	030		0	30		030
Time	Time(sec) 00				00	.0	0	0.0	00.	0	0	0.0		0.0
Delay(sec) 00			00.0		00	.0	0	0.0	00.	0	0	0.0	(0.00
Туре	ТуреО				Of	f	C	off	Off		C	Off		Off
¥				c	Core	ə 3					Co	ore 4		
	<u>}`</u>		In		Out		Par	Out	In		(Dut	Pa	r Out
Spee	ed(%)		030		03	0	0	30	030		0	30		030
Pres	.(bar))	030		03	0	0	30	030		0	30		030
Time	(sec))	00.0		00	.0	0	0.0	00.	0	0	0.0	0	0.0
Dela	y(sec	:)	00.0		00	.0	0	0.0	00.	0	0	0.0	(0.0
Туре			Off		Of	f	C	off	Off		C	Off		Off
			Core	ə 1		C	Core	2	Co	re 3	3		Core	e 4
Mode	e In		Mold	Opr	n	Mo	ld C	Dpn	Molo	10	pn	N	lold	Opn
Mode	e Out	t	Mold	Opr	n	Mo	ld C	Dpn	Molo	0 1)pn	N	lold	Opn
Alar	m												He	elp ?
Acti	on												He	eat -
	1	MOL			JEC	TOR	TEM	P. 0				F K	s	NEXT

CORE 1/3 page and list of parameter is given below.

STREAMLINE CONTROLS PVT.LTD.

		Message			Parameter	Description	mlin	Part Of
Sr No	Page Name	Of Parameter On Screen	Function Description	Parameter Description	Parameter Type	Range	Password Level	Memory
				Set Core In 1 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Core In 1 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				On completion of set delay time Core In 1 function take place.	Delay	00.0- 99.9Sec	User	Yes
	CORE		This function is	Set Core In 1 function operating time.	Timer	00.0- 99.9Sec	User	Yes
1	1/3 Core	Core In	use to move core 1 unit in to die.	Select core 1 IN operating type. Core In 1 function is				Yes
				disable with Off selection Core In 1 function is over on limit switch or	Туре	Off Ls		
				proxy switch input with Ls selection Core In 1 function is		Timer		
				set time with Timer			Level 1	
				Set Core Out 1 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Core Out 1 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				On completion of set delay time Core Out 1 function take place.	Delay	00.0- 99.9Sec	User	Yes
	COPE		This function is	Set Core Out 1 function operating time.	Timer	00.0- 99.9Sec	User	Yes
2	1/3	Core Out	core 1 unit from die.	Select core 1 Out operating type. Core Out 1 function is disable with Off selection Core Out 1 function is		Off		Yes
		8		over on limit switch or proxy switch input with Ls selection Core Out 1 function is over on completion of set time with Timer	Туре	Ls Timer	Level 1	
				selection				

				Set Core Partial Out 1			amlin	Yes
				function operating	Pressure	000 -	tro	ols
				output		255Ddl	User	011109
				Set Core Partial Out 1				Yes
				function operating	Speed	000% –		
				Speed proportional	opeed	100%	Upor	
				Output On completion of set			User	Voc
				delay time Core Partial				105
				Out 1 function take	Delay	00.0-		
			This function is	place. Its start after	Delay	99.9Sec		
		Partial Out	use to pull out	completion of injection			lleen	
2	CORE		rtial t core 1 unit partially from die during cooling function.	function		00.0	User	Voc
5	1/3			function operating time.	Timer	99.9Sec	User	163
				Select core 1 Partial Out			••••	Yes
				operating type.				
				Core Partial Out 1				
				function is disable with				
				Core Partial Out 1				
				function is over on limit	Туре	On/Ls/Tim		
				switch or proxy switch		er		
				input with Ls selection				
				Core Partial Out 1				
				completion of set time				
				with Timer selection			Level 1	
				Set Core In 2 function		000 -		Yes
				operating pressure	Pressure	255Bar	User	
				proportional output				Vac
				operating Speed	Speed	000% –	User	res
				proportional output	opeed	100%	0.001	
				On completion of set		00.0-		Yes
				delay time Core In 2	Delay	99.9Sec	User	
				function take place.				Voc
				Set Core In 2 function	Timer	00.0-	User	163
	CORE		This function is	operating time.		99.9Sec		
4	1/3	Cor2 In	core 2 unit in	Select core 2 IN				Yes
			to die.	operating type.				
				disable with Off				
				selection				
		NY		Core In 2 function is		Off/Is/Tim		
				over on limit switch or	Туре	er	Level 1	
				proxy switch input with				
				Core In 2 function is				
	6			over on completion of				
				set time with Timer				
				selection				

				Set Core Out 2 function operating pressure proportional output	Pressure	000 – 255Bar	User amin	Yes
				Set Core Out 2 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				On completion of set delay time Core Out 2 function take place.	Delay	00.0- 99.9Sec	User	Yes
	CORE	Cor2 Out	This function is	Set Core Out 2 function operating time.	Timer	00.0- 99.9Sec	User	Yes
5	1/3		core 2 unit from die.	Select core 2 Out operating type. Core Out 2 function is disable with Off selection Core Out 2 function is over on limit switch or proxy switch input with Ls selection Core Out 2 function is over on completion of set time with Timer selection	Туре	Off/Ls/Tim er	Level 1	Yes
				Set Core Partial Out 2 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Core Partial Out 2 function operating Speed proportional output	Speed	000% – 100%	User	Yes
C	CORE	Dor? Out	This function is use to pull out core 2 unit	On completion of set delay time Core Partial Out 2 function take place. Its start after completion of injection function	Delay	00.0- 99.9Sec	User	Yes
0	1/3		die during	Set Core Partial Out 2 function operating time.	Timer	00.0- 99.9Sec	User	Yes
	Х S		function.	Select core 2 Partial Out operating type. Core Partial Out 2 function is disable with Off selection Core Partial Out 2 function is over on limit switch or proxy switch input with Ls selection Core Partial Out 2 function is over on	Туре	Off/Ls/Tim er	Level 1	Yes

				completion of set time			min	econz
				with Timer selection			e.	0
				Set Core In 3 function		000 -	tS.	Yes
				operating pressure	Pressure	255Bar	User M	N · WO
				proportional output				
				Set Core In 3 function		000% -		Yes
				operating Speed	Speed	100%	User	
				proportional output				
				On completion of set	Delay	00.0-	licor	Yes
				function take place	Delay	99.9Sec	User	
			This function is	Set Core In 3 function		00.0-		Yes
				operating time.	Timer	99.9Sec	User	103
7	CORE		core 3 unit in to die.	Select core 3 IN				Yes
,	1/3	Cor3 In		operating type.				
				Core In 3 function is				
				disable with Off				
				selection	\land			
				Core In 3 function is		Off/Ls/Tim er		
				over on limit switch or	Туре			
				proxy switch input with				
				Ls selection				
				Core In 3 function is				
				over on completion of				
				set time with Timer				
				Selection Set Core Out 2 function			Level 1	Vec
				operating pressure	Drossuro	000 –	llcor	res
					Tressure	255Bar	0361	
								Yes
				Set Core Out 3 function		000% – 100%		
			-	operating Speed	Speed		User	
				proportional output				
				On completion of set				Yes
				delay time Core Out 3	Delay	00.0-	User	
			This function is	function take place.		99.9560		
			use to pull out	Set Core Out 3 function	Timer	00.0-	llsor	Yes
0	CORE	Cor3 Out	core 3 unit	operating time.	TIME	99.9Sec	0361	
ð	1/3		from die.	Select core 3 Out				Yes
				operating type.				
				Core Out 3 function is				
				coloction				
				Core Out 3 function is				
				over on limit switch or	Type	Off/Ls/Tim		
				proxy switch input with	.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	er		
				Ls selection				
				Core Out 3 function is				
				over on completion of				
	6			set time with Timer				
				selection			Level 1	

			f F C S	Set Core Partial Out 3 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Core Partial Out 3 function operating Speed proportional output	Speed	000% – 100%	User	Yes
	0005		This function is use to pull out core 3 unit partially from die during cooling function.	On completion of set delay time Core Partial Out 3 function take place. Its start after completion of injection function	Delay	00.0- 99.9Sec	User	Yes
9	1/3	Par3 Out		Set Core Partial Out 3 function operating time.	Timer	00.0- 99.9Sec	User	Yes
				Select core 3 Partial Out operating type. Core Partial Out 3 function is disable with Off selection Core Partial Out 3 function is over on limit switch or proxy switch input with Ls selection Core Partial Out 3 function is over on completion of set time with Timer selection	Туре	Off/Ls/Tim er	Level 1	Yes
				Set Core In 4 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Core In 4 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				On completion of set delay time Core In 4 function take place.	Delay	00.0- 99.9Sec	User	Yes
			This function is	Set Core In 4 function operating time.	Timer	00.0- 99.9Sec	User	Yes
10	CORE 1/3	Core4 In	Core4 In Core4 In to die.	Select core 4 IN operating type. Core In 4 function is disable with Off selection Core In 4 function is over on limit switch or proxy switch input with Ls selection Core In 4 function is over on completion of set time with Timer selection	Туре	Off Ls Timer	Level 1	Yes

				Set Core Out 4 function operating pressure	Pressure	000 – 255Bar	User of the	Yes
				Set Core Out 4 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				On completion of set delay time Core Out 4 function take place.	Delay	00.0- 99.9Sec	User	Yes
			This function is	Set Core Out 4 function operating time.	Timer	00.0- 99.9Sec	User	Yes
11	CORE 1/3	Core4 Out	use to pull out core 1 unit from die.	unit operating type. Jie. Core Out 4 function is disable with Off selection Core Out 4 function is over on limit switch or proxy switch input with Ls selection Core Out 4 function is over on completion of set time with Timer selection		Off Ls Timer	Level 1	Yes
			This function is use to pull out	Set Core Partial Out 4 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Core Partial Out 4 function operating Speed proportional output	Speed	000% – 100%	User	Yes
	CORE			On completion of set delay time Core Partial Out 4 function take place. Its start after completion of injection function	Delay	00.0- 99.9Sec	User	Yes
12	1/3	Par4 Out	partially from die during	Set Core Partial Out 4 function operating time.	Timer	00.0- 99.9Sec	User	Yes
			cooling function.	Select core 4 Partial Out operating type. Core Partial Out 4 function is disable with Off selection Core Partial Out 4 function is over on limit switch or proxy switch input with Ls selection Core Partial Out 4 function is over on completion of set time with Timer selection	Туре	Off/Ls/Tim er	Level 1	Yes

13	CORE 1/3	CORE 1 MODE In	Select core 1 in-operating sequence. On select sequence core in function start. When select IN Between sequence core in operation start on CORE IN POSI .	Mold Open : During Mold Open function first start CORE IN function than MOLD CLOSE function take place. Mold Close : During Mold Close function first start MOLD CLOSE function than CORE IN function take place. In Between : During Mold Close function first start MOLD CLOSE function till to set CORE IN POSI and there stop MOLD CLOSE function than CORE IN function take place and than again start MOLD CLOSE function take place. Mold Lock :During mold lock function first start mold Lock then core In take Place	MODE In	Mold Open Mold Close In Between Mold Lock	Level 1	Yes
14	CORE 1/3	CORE 1 MODE Out	Select core 1 out-operating sequence. On select sequence core in function start. When select IN Between sequence core out operation start on CORE OUT POSI .	Mold Open : During Mold Open function first start MOLD Open function than CORE OUT function take place. Mold Close : During Mold Open function first start CORE OUT function than MOLD Open function take In Between : During Mold Open function first start MOLD Open function till to set CORE OUT POSI and there stop MOLD OPEN function than CORE OUT function take place and than again start MOLD OPEN function take place. Mold Lock : During mold lock function first start core out than Mold Lock function take place	MODE Out	Mold Open Mold Close In Between Mold Lock	Level 1	Yes

15	CORE 1/3	CORE 2 MODE In	Select core 2 in-operating sequence. On select sequence core in function start. When select IN Between sequence core in operation start on CORE IN POSI .	Same as CORE 1 MODE In description	MODE In	Mold Open Mold Close In Between Mold Lock	Level 1	Yes
16	CORE 1/3	CORE 2 MODE Out	Select core 2 out-operating sequence. On select sequence core in function start. When select IN Between sequence core out operation start on CORE OUT POSI.	Same as CORE 1 MODE Out description	MODE Out	Mold Open Mold Close In Between Mold Lock	Level 1	Yes
17	CORE 1/3	CORE 3 MODE In	Select core 3 in-operating sequence. On select sequence core in function start. When select IN Between sequence core in operation start on CORE IN POSI.	Same as CORE 1 MODE In description	MODE In	Mold Open Mold Close In Between Mold Lock	Level 1	Yes
18	CORE 1/3	CORE 3 MODE Out	Select core 3 out-operating sequence. On select sequence core in function start. When select IN Between sequence core out operation start on CORE OUT POSI.	Same as CORE 1 MODE Out description	MODE Out	Mold Open Mold Close In Between Mold Lock	Level 1	Yes

19	CORE 1/3	CORE 4 MODE In	Select core 4 in-operating sequence. On select sequence core in function start. When select IN Between sequence core in operation start on CORE IN POSI.	Same as CORE 1 MODE In description	MODE In	Mold Open Mold Close In Between Mold Lock	Level 1	Yes 2
20	CORE 1/3	CORE 4 MODE Out	Select core 4 out-operating sequence. On select sequence core in function start. When select IN Between sequence core out operation start on CORE OUT POSI.	Same as CORE 1 MODE Out description	MODE Out	Mold Open Mold Close In Between Mold Lock	Level 1	Yes

2

Screen Page: CORE 2/3

CORE



(1)Press" key once on the top of the Touch Screen.

(2) NowScreen Page: **CORE 2/3** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit. (If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

🛛 🖑 HAN	ID		CORE	2/3		03/	12/201	19 🛣 10):10:54
	Mold mm		Screw	mm 0	ц.	Ejector mm		Ton mm	
	Speed (%)	D	Pres.	bar)	0/	AN 3	0/	AN 4	
	100		060		/0	000	70	000	
×					Co	ore 1			
		ln		Out		<u> </u>	Par Out	<u>:</u>	
AN 3(%)		000			0	00		000	
AN 4(%)	0	000			0	00		000	
Core 2									
		In				Dut		Par Out	<u>:</u>
AN 3(%)		000			0	00		000	
AN 4(%)	0	000			0	00		000	
			,		Co	ore 3			
¥`		In				Dut	<u> </u>	Par Out	<u> </u>
AN 3(%)		00		000			000		
AN 4(%)	0	000			000			000	
					Co	ore 4	1		
¥		In				Dut		Par Out	<u> </u>
AN 3(%)		000			0	00		000	
AN 4(%)	0	000			0	00		000	
Alarm	Alarm Help ?								
Action								H	eat
				TEM					

CORE 2/3page and list of parameter is given below

STREAMLINE CONTROLS PVT.LTD.

6	Daga	Message		Deverseter	Param Descrii	eter otion	Operating	Part Of Memory
Sr No	Name	Parameter On Screen	Function Description	Description	Parameter Type	Range	Password Level	MA · WOS
1	CORE	Coroln		Set Core In 1 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
Ţ	2/3	Core m		Set Core In 1 function operating AN4 proportional output	AN4	000% - 100%	User	Yes
2	CORE	Corro Out		Set Core Out 1 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
2	2/3	Core Out		Set Core Out 1 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
2	CORE	Douting Out		Set Core Partial Out 1 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
5	2/3	Partial Out		Set Core Partial Out 1 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
	CORE	Cor2 In		Set Core In 2 function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
4	2/3			Set Core In 2 function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes
-	CORE	Cord Out		Set Core Out 2 function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
5	2/3	corz out		Set Core Out 2 function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes
	CORE			Set Core Partial Out 2 function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
D	2/3	Parz Out		Set Core Partial Out 2 function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes

-	CORE	Cor3 In		Set Core In 3 function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
/	2/3	Corsin		Set Core In 3 function operating AN4 proportional output	AN4	000% - 100%	User Level	Yes
0	CORE	Cor2 Out		Set Core Out 3 function operating AN3 proportional output	AN3	000% - 100%	User Level	Yes
0	2/3		br3 Out	Set Core Out 3 function operating AN4 proportional output	AN4	000% - 100%	User Level	Yes
0	CORE	Dar2 Out		Set Core Partial Out 3 function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
9	2/3	Par3 Out	Par3 Out	Set Core Partial Out 3 function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes

Screen Page: CORE 3/3

CORE



(1)Press" key once on the top of the Touch Screen.

(2) NowScreen Page: **CORE 3/3** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit. (If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.



Sr	Page	Message		Parameter	Parameter Description		Operating	Part Of Memory
No	Name	Parameter On Screen	Function Description	Description	Parameter Type	Range	Password Level	NM . WO?
			Select various type of pump selection with	Select Core In 1 boost option	Number	0-5	Level 1	Yes
1	CORE 3/3	BOST COR1	Core In1 and Core Out1 function as per output selection provide in sequence table. With boost selection 0 to 3 provide fix output selection. With boost selection 4 pump selection very with set pressure proportional output. With boost selection 5 pump selection very with set Speed proportional output.	Select Core Out 1 boost option	Number	0-5	Level 1	Yes
2	CORE 3/3	BOST COR2	Select various type of pump selection with	Select Core In 2 boost option	Number	0-5	Level 1	Yes
			Core In2 and Core Out2 function as per output selection provide in sequence table. With boost selection 0 to 3 provide fix output selection. With boost selection 4 pump selection very with set pressure proportional output. With boost selection 5 pump selection very with set Speed proportional output.	Select Core Out 2 boost option	Number	0-5	Level 1	Yes
			Select various type of pump selection with	Select Core In 3 boost option	Number	0-5	Level 1	Yes
3	CORE 3/3	BOST COR3	Core In3 and Core Out3 function as per output selection provide in sequence table. With boost selection 0 to 3 provide fix output selection. With boost selection 4 pump selection very with set pressure	Select Core Out 3 boost option	Number	0-5	Level 1	Yes

			proportional output. With boost selection 5 pump selection very with set Speed proportional output.				w.stree	MM · WO?
4	CORE 3/3	CORE IN Position	Select core in- operating mode &position. In MODE you can select core in function start position. At select position core in function start. When select in between position core in start on set position in POSI. The selection are common for all of three cores in	Select core in position for In Between option.	Position	0000.0- 2000.0	Level 1	Yes
5	CORE 3/3	CORE OUT Position	Select core out- operating mode & position. In MODE you can select core out function start position. At select position core out function start. When select in between position core out start on set position in POSI. The selection are common for all of three cores out	Select core out position for In Between option.	Position	0000.0- 2000.0	Level 1	Yes
6	CORE 3/3	Core In With Injection	Select all of three Cores In direction output operating action during injection time in semi auto & fully auto. This function is use to stop pull out core from die during injection function due to its high pressure	Select on to enable this function or off to disable this function	Function	On/Off	Level 1	Yes
	Ś			Page 59 of 155				

INJKon Rainbow X Manual

Screen Page: EJECTOR 1/2





(1)Press" EJECTOR " key once on the bottom of the Touch Screen.

(2) NowScreen Page: **EJECTOR 1/2** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit. (If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.



STREAMLINE CONTROLS PVT.LTD.

		Message			Parameter I	Description	Oneretie	Part Of
Sr No	Page Name	Of Parameter	Function Description	Parameter Description	Parameter	Bange	Password	Memory
110	Hume	On Screen		Description	Туре	nunge	Level	in allo?
				Set Ejector Forward 1 function over operating position.	Position	000.0- 999.9	User	Yes
				Set Ejector Forward 1 function operating pressure proportional output	Pressure	000– 255Bar	User	Yes
1	EJECTOR 1/2	Ejector Forward1	This function is use to throw out piece from punch side of die.	Set Ejector Forward 1 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				On completion of set delay time Ejector Forward 1 function take place. Its start as per option select in Ej Opt.	Delay	00.0- 99.9Sec	User	Memory Yes Yes Yes Yes Yes Yes Yes Yes Yes
				Set Ejector Forward 1function operating time.	Timer	00.0- 99.9Sec	User	Yes
				Set Ejector Forward 2 function over operating position.	Position	000.0- 999.9	User	Yes
2	EJECTOR 1/2	Ejector Forward2	This function is use to throw out piece from punch side of die.	Set Ejector Forward 2 function operating pressure proportional output	Pressure	000– 255Bar	User	Yes
		2		Set Ejector Forward 2 function operating Speed proportional output	Speed	000% – 100%	User	Yes
	5							

									0.00
				Set Ejector Forward 2 function operating time.	Timer	00.0- 99.9Sec	User	W.Strees	Yes
				Set Ejector Backward function over operating position.	Position	000.0- 999.9	User		Yes
				Set Ejector Backward function operating pressure proportional output	Pressure	000- 255Bar	User		Yes
3	EJECTOR 1/2	Ejector Backward	This function is use to throw out piece from punch side of die.	Set Ejector Backward function operating Speed proportional output	Speed	000% – 100%	User		Yes
				On completion of set delay time Ejector Backward function take place. Its start on completion of ejector forward 2 function	Delay	00.0- 99.9Sec	User		Yes
				Set Ejector Backward function operating time.	Timer	00.0- 99.9Sec	User		Yes
				Set Unscrew function operating pressure proportional output	Pressure	000– 255Bar	User		Yes
4	EJECTOR 1/2	Unscrew	This function is use to unscrewing molded product from dia	Set Unscrew function operating Speed proportional output	Speed	000% – 100%	User		Yes
	S		from die	On completion of set delay time Unscrew function take place. Its start on completion of decompression function	Delay	00.0- 99.9Sec	User		Yes

				Set Ejector Backward function operating time.	Timer	00.0- 99.9Sec	User J.	Yes of
	FIECTOR	Position:	Set Timer for more than one shot to do Ejector function.	Set Timer for Multi-shot In Ejector.	Timer	00.0- 99.9Sec	User	Yes
5	1/2	shot Ejct Bkwd	Set Position for more than one shot to do ejector backward function.	set position for multi-shot in Eject-backward	Position	000.0- 999.9	User	Yes
6	EJECTOR 1/2	Shots	This function is use to ejector forward and backward action multiple time in semi and full auto mode.	Select Ejector function's operating stroke.	Number	0-5	Level1	Yes
7	EJECTOR 1/2	Ejector Program	Select Ejector function's operating mode. If selection is FWRD then Ejector Forward only after mould gets fully open & in next cycle first of all ejector take backward & then all other function start. If selection is PULS then Ejector is operate Forward /Hold /Backward. If selection is OFF then Ejector is disable.	Select ejector operating program.	Function	Off Forward Plus	Level 1	Yes
8	EJECTOR 1/2	Air 1	Set Air 1 function to operate it		Mode	With Open Position After Open After Injection	User	Yes
			Set Air 1 delay time to operate it		Delay	00.0- 99.9Sec	User	Yes
		S	Set Air 1 time to do the function.		Time	00.0- 99.9Sec	User	Yes
		K	Set Air 1 position to do the function with mold open position		Position	9999.0	User	Yes
	6							

			Set Air 2 function to operate it	Mode	With Open Position After Open After Injection	User	m Yes
9	EJECTOR 1/2	Air 2	Set Air 2 delay time to operate it	Delay	00.0- 99.9Sec	User	Yes
			Set Air 2 time to do the function.	Time	00.0- 99.9Sec	User	Yes
			Set Air 2 position to do the function with mold open position	Position	9999.0	User	Yes
10	EJECTOR	Air 2	Set Air 3 function to operate it	Mode	With Open Position After Open After Injection	User	Yes
	1/2		Set Air 3 delay time to operate it	Delay	00.0- 99.9Sec	User	Yes
			Set Air 3 time to do the function.	Time	00.0- 99.9Sec	User	Yes
			Set Air 3 position to do the function with mold open position	Position	9999.0	User	Yes
11	EJECTOR	Air 4	Set Air 4 function to operate it	Mode	With Open Position After Open After Injection	User	Yes
	1/2		Set Air 4 delay time to operate it	Delay	00.0- 99.9Sec	User	Yes
			Set Air 4 time to do the function.	Time	00.0- 99.9Sec	User	Yes
		2	Set Air 4 position to do the function with mold open position	Position	9999.0	User	Yes
	6						

Screen Page: EJECTOR 2/2



EJECTOR

(1)Press" key once on the top of the Touch Screen.
(2) NowScreen Page: EJECTOR 2/2 is displayed on screen in first line.
(3)To change the parameter you have to press on the parameter digit. (If you change the parameter for the first time you will want password.)
(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.
Use INC (+) or DEC (-) key to on or off any function.
(5) On pressing ENTER key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

EJECTOR 2/2 page and list of parameter is given below

~

- 🖑	HA	ND	EJECTOR 2/2			03/1	10:10:54			
	M	Mold mm 0000.0		Screw mm 000.0	I	Ejector mm 000.0	↔	Ton mm 000.0		
	S	Speed (%) 100	Ρ	Pres. (bar) 060	%	AN 3 000	%	AN 4 000		

	Ejector								
	Forward 1	Forward 2	Backward	Unscrew					
AN 3(%)	030	030	030	030					
AN 4(%)	000	000	000	000					

Ejector Mode	Aftr Opn
Mold Position: Ejector	0000.0
Ejector Plate	Off
Ejector Boost	0
Ejector Bkwd@M.Close	

Alarm							Не	lp ?
Action							He	at 🚈
	-		•	ļ		-	₽₩S	7
MONITOR	MOLD	CORE	EJECTOR	TEMP.	CARRIAGE	SCREW	FAST SETTING	NEXT

		Message			Param	eter	an	Part Of				
Sr	Page	Of	Function	Parameter	Descri	otion	Operating	Memory				
No	Name	Parameter	Description	Description	Parameter		Password					
		On Screen			Туре	Range	Level 4	hm . WO				
				Set Ejector Forward				Yes				
				1 function		000%						
				operating AN3	AN3	100%	User					
				proportional		100%						
1	EJECTOR	Ejector		output								
	2/2	Forward1		Set Ejector Forward				Yes				
				1 function		000% -						
				operating AN4	AN4	100%	User					
				proportional								
				output								
				Set Ejector Forward				Yes				
				2 function	AN12	000% –	Lleen					
				operating AN3	ANS	100%	User					
		Figstor										
2	2/2	Eprward?		Set Fiector Forward				Voc				
	2/2	TOTWATUZ		2 function				165				
				operating AN4	ANA	000% –	User					
				proportional		100%	User					
				output								
				Set Eiector				Yes				
				Backward function								
				operating AN3	AN3	000% – 100%	User					
		Ejector Backward		proportional								
2	EJECTOR		Ejector Backward	Ejector Backward	Ejector Backward	Ejector output Backward Set Ejector	output			User User		
3	2/2						Backward		Set Ejector			
				Backward function		000%						
			operating AN4	AN4	000% -	User						
				proportional		10070						
				output								
				Set Unscrew				Yes				
				function operating	AN3	000% –	User					
	FIFETOD			AN3 proportional		100%						
4	EJECTOR	Unscrew		Output				Vaa				
	2/2			Set Unscrew		000%		res				
					AN4	100%	User					
						100%						
			Select elector	Select elector								
			operating mode.	operating mode.								
			Here you can	Ejector function								
			select ejector	starts at mold fully		With						
	FIFCTOR	Cierter.	function operating	open position With		Open						
5	EJECTOR	Ejector	ector position. At select After Open	After Open	Function	Upen	Level 1	Yes				
	2/2	wode	position ejector	selection.		POSITION						
			function start.	Ejector function		Open						
		, i i i i i i i i i i i i i i i i i i i	V F	F	V P		۲ ۱	When select Open starts with mold		Open		
						Position option	open function in					
	5		ejector start on	With								

			set position in POSI.	Open selection. Ejector function starts at select position With Open Position selection.			w stree	MM · WOS
6	EJECTOR 2/2	Mold: Position :Ejector	Select ejector- operating position. Here you can select ejector function start position during mold open function. At select position ejector function start.	Select ejector operating position	Position	0000.0- 9999.9	Level 1	Yes
7	EJECTOR 2/2	Ejector Plat		Enable or Disable Ejector Plate function operation.	Function	On/Off	Level 2	Yes
8	EJECTOR 2/2	Boost	Select various type of pump selection with Ejector function as per output selection provide in sequence table. With boost selection 0 to 3 provide fix output selection. With boost selection 4 pump selection very with set pressure proportional output. With boost selection 5 pump selection very with set Speed proportional output.	Select ejector boost option	Number	0-5	Level 1	Yes
9	EJECTOR 2/2	Ejector Bkwd@M. close		During cycle if ejector backward o/p need during mold close then this function to ON	Function	On/Off	Level 2	Yes
	5							

Screen Page: Temperature (1/4)

TEMPERATURE

amlinecon



"TouchKey once in Touch screen.

(2) Now, Screen Page: Temperature (1/4) is displayed on Touch screen.

(3)To change the parameter you have to press on the parameter digit.(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 numerical Touch keys.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.



	- 🖑	HAI	ND	TE	MPERATI	JRE 1/4		03/12/20 ⁻	19 🛣	10:10:54
	/	·M	Mold mr 0000.0	n (Screw n 000.0	nm 🎼	Ejector 000.0	mm 🚛	Ton mn 000.0	
	<u>\</u>	S	Speed (% 100	^{%)} P	Pres. (b) 060	^{ar)} <mark>%</mark>	AN 3 000	%	AN 4 000	
]			T	empera	ture Zor	e		
			Z1	Z2	Z3	Z4	Z5	Z6	Z 7	Z8
	Set c	;	200	200	200	200	200	200	200	200
	Act o	;	Opn	Opn	Opn	Opn	Opn	Opn	Opn	Opn
	Statu	IS								
	Amp									
	AH C	•	025	025	025	025	025	025	025	025
	AL Ĉ	ALĊ		025	025	025	025	025	025	025
	Bp Č	;	000	000	000	000	000	000	000	000
	Amp	Fsd	000	000	000	000	000	000	000	000
	Nozz	le 1	ON Tir	ne (sec	c) 00	0.00	OFF T	ime (se	c) 0	0.00
	Nozz	le 2	ON Tir	ne (sec	c) 00	0.00 OFF Time (s			c) 0	0.00
	Auto	o Hea	t	Off		Time	(hh:mm)	0	0 00
						Date	(dd:mm:	уу)	00 0	0 00
	Soa	k Tim	e Min.							
	Alar	m								Help ?
	Actio	on								Heat 🛥
					EJECTOR	TEMP. (F 🏟 s	
5										
					Dog	in CO of	155			

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List of Programmable Parameter:



Zone No.	Message	Description	Range	Default Value	Operating Password Level	Part Of memory
	SET C>	Set temperature	0-999 C	200 C	User	YES
Z1	ACT C>	Actual temperature				YES
	STAT>	Display Alarm Low & Alarm High online status			9	YES
	AL C>	Alarm low	0-999 C	025 C	Level 1	NO
	AH C>	Alarm High	0-999 C	025 C	Level 1	NO
Zone						NO
No.	AmpFSD>	Ampere full scale reading	0-100	000	Level 1	
	BP C>	Blower Point	0-200 Sec	005 C	Level 1	NO

Zone No.	Message	Description	Description Range Default Value		Operating Password Level	Part Of memory
	SET C>	Set temperature	0-999 C	200 C	User	YES
Z2	ACT C>	Actual temperature				YES
		Display Alarm Low & Alarm				YES
	STAT>	High online status				
	AL C>	Alarm low	0-999 C	025 C	Level 1	NO
	AH C>	Alarm High	0-999 C	025 C	Level 1	NO
Zone						NO
No.	AmpFSD>	AmpFSD> Ampere full scale reading		000	Level 1	
	BP C>	C > Blower Point		005 C	Level 1	NO

Zone No.	Message	Description	Range	Default Value	Operating Password Level	Part Of memory
	SET C>	Set temperature	0-999 C	200 C	User	YES
Z3	ACT C>	Actual temperature				YES
	STAT>	Display Alarm Low & Alarm High online status				YES
	AL C>	Alarm low	0-999 C	025 C	Level 1	NO
	AH C>	Alarm High	0-999 C	025 C	Level 1	NO
Zone						NO
No.	AmpFSD> Ampere full scale reading		0-100	000	Level 1	
	BP C>	Blower Point	0-200 Sec	005 C	Level 1	NO

Zone No.	Message	Description	Range	Default Value	Operating Password Level	Part Of memory
	SET C>	Set temperature	0-999 C	200 C	User	YES
Z4	ACT C>	Actual temperature				YES
	STAT>	Display Alarm Low & Alarm High online status				YES
	AL C>	Alarm low	0-999 C	025 C	Level 1	NO
	AH C>	Alarm High	0-999 C	025 C	Level 1	NO
Zone						NO
No.	AmpFSD>	Ampere full scale reading	0-100	000	Level 1	
	BP C>	Blower Point	0-200 Sec	005 C	Level 1	NO

Zone No.	Message	Description	Range	Default Value	Operating Password Level	Part Of memory
	SET C>	Set temperature	0-999 C	200 C	User M,	MYESWO
Z5	ACT C>	Actual temperature				YES
	STAT>	Display Alarm Low & Alarm High online status				YES
	AL C>	Alarm low	0-999 C	025 C	Level 1	NO
	AH C>	Alarm High	0-999 C	025 C	Level 1	NO
Zone	AmpFSD					NO
No.	>	Ampere full scale reading	0-100	000	Level 1	
	BP C>	Blower Point	0-200 sec	005 C	Level 1	NO

Zone No.	Message	Description	Range Default Value		Operating Password Level	Part Of memory
	SET C>	Set temperature	0-999 C	200 C	User	YES
Z6	ACT C>	Actual temperature				YES
	STAT>	Display Alarm Low & Alarm High online status			*	YES
	AL C>	Alarm low	0-999 C 🛛	025 C	Level 1	NO
	AH C>	Alarm High	0-999 C	025 C	Level 1	NO
Zone	AmpFSD					NO
No.	>	Ampere full scale reading	0-100	000	Level 1	
	BP C>	Blower Point	0-200 Sec	005 C	Level 1	NO

Zone No.	Message	Description	Range	Default Value	Operating Password Level	Part Of memory
	SET C>	Set temperature	0-999 C	200 C	User	YES
	ACT C>	Actual temperature				YES
77		Display Alarm Low & Alarm				YES
27	STAT>	High online status				
	AL C>	Alarm low	0-999 C	025 C	Level 1	NO
	AH C>	Alarm High	0-999 C	025 C	Level 1	NO
Zone						NO
No.	AmpFSD>	Ampere full scale reading	0-100	000	Level 1	
-	BP C>	Blower Point	0-200 Sec	005 C	Level 1	NO

Zone No.	Message	Description	Range	Default Value	Operating Password Level	Part Of memory	
	SET C>	Set temperature	0-999 C	200 C	User	YES	
Z8(Oil)	ACT C>	Actual temperature				YES	
		Display Alarm Low & Alarm				YES	
	STAT>	High online status					
	AL C> Alarm low		0-999 C	025 C	Level 1	NO	
	AH C>	Alarm High	0-999 C	025 C	Level 1	NO	
Zone						NO	
No.	AmpFSD>	Ampere full scale reading	0-100	000	Level 1		
	BP C>	Blower Point	0-200 Sec	005 C	Level 1	NO	
	5						

Zone No.	Message	Description	Range	Default Value	Operating Password Level	Part Of memory
NOZZEL 1	ON Time(sec)	The nozzle 1 heater will stay on for as long as the time is running.	00.00- 99.9	00.00	User	^M MXĘS W ^O
NOZZEL 1	OFF Time(sec)	The nozzle 1 heater will stay off for as long as the time is running.	00.00- 99.9	00.00	User	YES

Zone No.	Message	Description	Range	Default Value	Operating Password Level	Part Of memory
NOZZEL 2	ON Time(sec)	The nozzle 2 heater will stay on for as long as the time is running.	00.00- 99.9	00.00	User	YES
NOZZEL 2	OFF Time(sec)	The nozzle 2 heater will stay off for as long as the time is running.	00.00- 99.9	00.00	User	YES

Note :- Suppose Heater Current card Not Used then set All zone AmpFSdValue 0.

NO	Massaga	Description	Parameter De	escription	Operating	Part Of
NO.	wiessage	Description	Parameter Type	Range	Level	memory
21	AUTOHEAT: OFF	If set to on, auto heat function is enable.	Function	ON / OFF	Level 1	YES
22	AUTOHEAT:	Set auto heat on time.	Time Hour	00-23	Level 1	YES
	TIM:		Time Minute	00-59	Level 1	YES
23	AUTOHEAT:	Set auto heat on date.	Date	01-31	Level 1	YES
	DAT:		Month	01-12	Level 1	YES
			Year	01-99	Level 1	YES

X

INJKon Rainbow X Manual

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Screen Page: CARRIAGE 1/2





(1)Press" CARRIAGE " key once on the top of the Touch Screen.

(2) NowScreen Page: **CARRIAGE 1/2** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit.(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.



HAND			С	ARRIAGE 1	/2	03/1	12/201	19 🛣 10	:10:54
<	·M	Mold mm 0000.0		Screw mm 000.0	•	Ejector mm 000.0	♣	Ton mm 000.0	
	S	Speed (%) 100	⁾ P	Pres. (bar) 060	%	AN 3 000	%	AN 4 000	

Carriage Fwd with Injection	Off
Carriage Fwd with Refilling	Off

	Forward			Backward			
	Fast	Slow	low Dir Fast		Slow	Auto	
Speed(%)	030	030	030	030	030		
Pres.(bar)	030	030	030	030	030		
Posi(mm)	000.0	000.0		000.0	000.0	000.0	
Time(sec)	01.0	01.0		01.0	01.0		
Delay(sec)	01.0						
Auto Carriage Aftr			JCK]			

A1								la O
Alarm							не	ip ?
Action	1						He	at 🚈
			•	ţ		4	₽₩S	♪
MONITOR	MOLD	CORE	EJECTOR	TEMP.	CARRIAGE	SCREW	FAST SETTING	NEXT
Sr	Page	Message Of		Parameter	Parameter Description		Operating	Part Of Memory
----	-----------------	--	---	---	--------------------------	------------------	---------------------	-------------------
No	Name	Parameter On Screen	Function Description	Description	Parameter Type	Range	Password Level 4	im · wos
1	CARRIAGE 1/2	Carriage Forward with Injection	Select carriage forward direction output operating action during injection time in semi auto & fully auto. This function is use to stop leakage of material from nozzle during injection function due to its high pressure	Select on to enable this function or off to disable this function	Function	On/Off	Level 1	Yes
2	CARRIAGE 1/2	Carriage Forward with Refill	Select carriage forward direction output operating action during refill time in semi auto & fully auto. This function is use to stop leakage of material from nozzle during refill function due to its high pressure	Select on to enable this function or off to disable this function	Function	On/Off	Level 1	Yes
	CARRIACE	Carriage	Carriage forward fast	Set position for carriage forward fast function from Carriage backward end position.	Position	000.0- 999.9	User Level	Yes
3	1/2	Forward Fast	selection in function type	Set Carriage forward fast function operating pressure proportional output	Pressure	000- 255Bar	User Level	Yes
				Set Carriage forward fast function operating Speed proportional output	Speed	000% – 100%	User Level	Yes
	6			Set delay time before carriage forward fast function take place	Delay	00.0- 99.9Sec	Level 1	Yes

								2000
				Set carriage forward fast function operating time.	Timer	00.0- 99.9Sec	Level 1	Yes
				Set position for carriage forward end function from Carriage forward fast position.	Position	000.0- 999.9	User Level	Yes Yes Yes Yes Yes
4	CARRIAGE 1/2	Carriage Forward Slow	Carriage forward slow function. As per selection in function	Set Carriage forward slow function operating pressure proportional output	Pressure	000- 255Bar	User Level	Yes
			туре	Set Carriage forward slow function operating Speed proportional output	Speed	000% – 100%	User Level	Yes
				Set carriage forward slow function operating time.	Timer	00.0- 99.9Sec	Level 1	Yes
5	CARRIAGE 1/2	Carriage Forward Direction	The proportional output is enable if carriage forward with injection or refill option is enable Select carriage forward direction proportional output operating action during refill time in semi auto & fully auto.	Set carriage forward direction proportional pressure output during injection or refill time in semi auto & fully auto.	Pressure	000- 255Bar	User Level	Yes
	5			Set carriage forward direction proportional flow output during injection or refill time in semi auto & fully auto.	Speed	000% – 100%	User Level	Yes

				-	1		1	ineco
				Set position for carriage backward fast function from Carriage forward end position.	Position	000.0- 999.9	User Level	Yes Yes Yes Yes Yes Yes
	CAPPIACE	Carriago	Carriago backward	Set Carriage backward fast function operating pressure proportional output	Pressure	000- 255Bar	User Level Ves User Level Ves User Level 1 Level 1 Level 1 Level 1 Ves Level 1 Ves User Level Ves User Level Ves User Level Ves	Yes
6	1/2	Backward Fast	fast function. As per selection in function type	Set Carriage backward fast function operating Speed proportional output	Speed	000% – 100%	User Level	Yes
				Set delay time before carriage backward fast function take place	Delay	00.0- 99.9Sec	Level 1	Yes
				Set carriage backward fast function operating time.	Timer	00.0- 99.9Sec	Level 1	Yes
				Set position for carriage backward end function from Carriage backward fast position.	Position	000.0- 999.9	User Level	Yes
7	CARRIAGE 1/2	Carriage Backward Slow	Carriage forward slow functions. As per selection in	Set Carriage backward slow function operating pressure proportional output	Pressure	000- 255Bar	User Level	Yes
			Function type	Set Carriage backward slow function operating Speed proportional output	Speed	000% – 100%	User Level	Yes
	6			Set carriage backward slow function operating time.	Timer	00.0- 99.9Sec	Level 1	Yes

8	CARRIAGE 1/2	Carriage Backward Auto	Carriage backward stops position for auto mode. With enable auto carriage function carriage backward stop on this set position in every cycle.	Set carriage backward auto position. Always set it less than carriage backward end position.	Position	000.0- 999.9	User Level	Yes S
9	CARRIAGE 1/2	Auto Carriage	Select carriage backward operating action in semi auto & fully auto. With OFF selection carriage stays in forward direction only. With After Injection selection carriage backward delay start on completion of injection function and complete of delay time carriage backward function take place. With After Ref selection carriage backward delay start on completion of refill function and complete of delay time carriage backward function take place. With After Suck back selection carriage backward delay start on complete of delay time carriage backward delay start on completion of suckback2 function and complete of delay time carriage backward delay start on completion of suckback2 function and complete of delay time carriage backward function take place.	Select after which function carriage backward function take place.	Function	OFF AFTR INJ AFTR REF AFTR SUK	User Level	Yes
	5			Page 76 of 155				

1.11

Screen Page: CARRIAGE 2/2





(1)Press" (1)Pre

(2) NowScreen Page: **CARRIAGE 2/2** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit.(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.



CARRIAGE 2/2page and list of parameter is given below.

Sr No	Page	Message		Parameter	Param Descri	eter otion	Operating	Part Of Memory Yes Ves Ves Ves Ves
No	Name	Parameter On Screen	Function Description	Description	Parameter Type	Range	Password Level	M. WOS
	CARRIAGE	Carriage		Set Carriage forward fast function operating AN3 proportional output	AN3	000% - 100%	User Level	Part Of MemoryYesYesYesYesYesYesYes
	2/2	Forward Fast		Set Carriage forward fast function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes
2	CARRIAGE	Carriage		Set Carriage forward Slow function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
2	2/2	Slow		Set Carriage forward Slow function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes
2	CARRIAGE	Carriage		Set carriage forward direction proportional AN3 output during injection or refill time in semi auto & fully auto.	AN3	000% – 100%	User Level	Yes
5	2/2	Direction		Set carriage forward direction proportional AN4 output during injection or refill time in semi auto & fully auto.	AN4	000% – 100%	User Level	Yes
4	CARRIAGE 2/2	Carriage Backward Fast		Set Carriage backward fast function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes

				Set Carriage backward fast function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes Ar
5	CARRIAGE	Carriage Backward		Set Carriage backward slow function operating AN3 proportional output	AN3	000% - 100%	User Level	Yes
5	2/2	Slow		Set Carriage backward slow function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes
6	CARRIAGE 2/2	Boost	Select various type of pump selection with carriage function as per output selection provide in sequence table. With boost selection 0 to 3 provide fix output selection. With boost selection 4 pump selection very with set pressure proportional output. With boost selection 5 pump selection very with set Speed proportional output.	Select carriage boost option	Number	0-5	Level 1	Yes
7	CARRIAGE 2/2	Swivel	This function is use for move injection carriage unit from center position to one side of machine for maintenance. This function is operating only in HAND mode. If carriage swivel is on during SEMI/FULL auto cycle system gives interlock & come into hand mode & display ILUNIT SWIVEL NOT AT HOME	Carriage swivel function on/ off.	Function	On/Off	Level 1	Yes

MM.W

Screen Page: SCREW 1/5





(1)Press" screw key once on the top of the Touch Screen.

(2) NowScreen Page: **SCREW 1/5** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit.(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 numerical Touch keys.

Use INC (+) or DEC (-)key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

	🛛 🕛 HANI		SCREV	V 1/5	03/1	12/2019 🛣	10:10:54
		1old mm 0000.0	Screw 000.	^{mm} 🎼	Ejector mm 000.0	Ton n 000.	1m .0
	S S	peed (%) 100	P Pres. (^{bar)} %	AN 3 000	% AN 4	
				Inie	ection		
	{ 🗰	Stage 1	Stage 2	Stage 3	Stage 4	Hold 1	Hold 2
	Speed(%)	030	030	030	030	030	030
	Pres.(bar)	030	030	030	030	030	030
	Posi(mm)	000.0	000.0	000.0	000.0		
	Time(sec)	010.0	000.0	000.0	000.0	001.0	001.0
	Delay(sec)	01.0					
	Stage	1			Total	Time	010.0
			Refill / Suckback				
		Intrusion	Refill Dly	Refill 1	Refill 2	Suckbk 2	Cooling
	Speed(%)	030	030	030	030	030	030
	Pres.(bar)	030	030	030	030	030	030
	Posi(mm)			100.0	150.0	200.0	
	Time(sec)	000.0				01.0	010.0
	Delay(sec)	00.0	00.5			00.5	
	Dry Cycle	e 0	ff				Latch
	Alarm						Help ?
	Action						Heat 🛥
		D CORE	EJECTOR	TEMP.		REW FAST SET	
5							

SCREW 1/5 operation page and list of parameter is given below.

Ninecon.

Note:- Pressure, flow ,AN3& AN4 Maximum limit Can be set as per CONFIGURE 6/6 in Injection parameter .

MM .U.

List of Programmable Parameter:

		Message			Parameter I	Description	Operating	Part Of
Sr	Page	Of	Function	Parameter	Daramotor		Decouverd	Memory
No	Name	Parameter	Description	Description	Type	Range		
		On Screen			туре		Level	
1	SCREW	Stages	Select injection-	Select operating	Number	0-4	Level 1	YES
-	1/5	Juges	operating stage.	stage	of stage			
			Total time for		Timer	000.0 –	Level 1	YES
			injection function.			999.9		
			If injection time is				ngeLevelLevel 1YESD –Level 1YESD –Level 1YESD –UserYESJar –UserYESJar –UserYESG –UserYES6 –UserYES6 –UserYES99.9UserYES-99.9UserYES0 –UserYES99.9UserYES99.9UserYES99.9UserYES	
			exceed from total					
2	SCREW	Total Time	time at that time	Set total time for				
	1/5		system come in	injection function				
			hand mode &					
			display					
			TIIVIER OVER.	Sat Injustion Stage 1		000.0	llcor	VEC
				function over	Position	000.0 –	User	TES
				operating position	FOSICION	555.51111		
				Set Injection Stage-1	Pressure	000Bar -	llser	VES
				function operating	Tressure	255Bar	User	125
				pressure		20000		
				proportional output				
				Set Injection Stage-1	Speed	000% -	User	YES
			Injection Stage 1	function operating	•	100%		
			Injection stage 1	Speed proportional				
3		Stage 1	Function Work till	output				
	1/5		1 set position or	On completion of set			User	YES
			over the set time	delay time Injection				
			over the set time	Stage-1 function take				
				place. Its start on	Delay	00.0-99.9		
				completion of	20.07			
				Carriage Forward				
				function				
				Cat Injustian Stage 1	Timor	000.0	llcor	VEC
				operating time	Timer	0.000 – 000 000	User	TES
				Set Injection Stage-2		000.0-	llser	VES
				function over	Position	999 9mm	User	125
			7	operating position.	1 Obleton	555151111		
		AV	Injection Stage 2	Set Injection Stage-2	Pressure	000Bar –	User	YES
	CODENT		Injection stage 2	function operating		255Bar		
4	SCREW	Stage 2	Function work till	pressure				YES YES YES YES YES
	1/5		2 sot position or	proportional output				
			2 set position of	Set Injection Stage-2	Speed	000% –	User	YES
				function operating		100%		
				Speed proportional				
				output				

				Cat Inication Change 2	T :	000.0	line all	ng-cos
				Set Injection Stage-2	Timer	000.0 -	User	YES
				Set Injection Stage 2		999.9380	licor	VEC
				Set Injection Stage-3	Desition	000.0 -	User o.	TES
				function over	Position	999.9mm	N	W • W
5				operating position.	Duran	0000	11	
			Injection Stage 2	Set Injection Stage-3	Pressure	000Bar -	User	YES
			Injection stage 3	function operating		255Bar		
	SCDEW/		Function work till	pressure				
5	1/E	Stage 3	to roach the stage	proportional output		0000/		2450
	1/5		2 cot position or	Set Injection Stage-3	Speed	000% -	User	YES
			over the set time	function operating		100%		
			over the set time	Speed proportional				
				output		000.0		2450
				Set Injection Stage-3	Timer	000.0 -	User	YES
				operating time		999.9Sec		
				Set Injection Stage-4		000.0-	User	YES
				function over	Position	999.9mm	00001	. 20
				operating position.				
				Set Injection Stage-4	Pressure	000Bar –	User	YES
			Injection Stage 4	function operating	, ressure	255Bar	00001	. 20
			Injection stage 4	pressure		200001		
6	SCREW	Stage 4	Function work till	proportional output				
Ŭ	1/5	Stuge 1	to reach the stage	Set Injection Stage-4	Speed	000% -	User	YES
			4 set position or	function operating	opeed	100%	00001	. 20
			over the set time	Speed proportional		100/0		
				output				
				Set Injection Stage-4	Timer	000.0 -	User	YES
				operating time		999.9Sec		
				Set Injection Hold	Pressure	000Bar –	User	YES
				On-1 function		255Bar		
			Injection HOLD	operating pressure				
			ON 1	proportional output				
_	SCREW		Injection hold	Set Injection Hold	Speed	000% -	User	YES
/	1/5	Hold 1	Function work till	On-1 function		100%		
			to over the set	operating Speed				
			time on	proportional output				
				Set Injection Hold	Timer	000.0 -	User	YES
				On-1 operating time		999.9Sec		
				Set Injection Hold	Pressure	000Bar –	User	YES
				On-2 function		255Bar		
			Injection HOLD	operating pressure				
			ON 2	proportional output				
	SCREW		Injection hold	Sat Injection Hold	Speed	000%	llcor	VEC
8	1/5	Hold 2	Function work till	On 2 function	speed	100% -	User	TES
	, -		to over the set	onerating Speed		100/0		
			time on	nronortional output				
				Set Injection Hold	Timer	000.0-	llser	VES
				On-2 operating time	TITLET	900.0 -	0381	TES
					Drocouro	333.3260	llcor	VEC
				Set Intrusion function	FIESSULE	255Bar	0361	
9	SCREW	Intrusion		onerating pressure		200001		
	1/5			nronortional output				

			Set Intrusion function operating Speed proportional output	Speed	000% – 100%	User ami	YES
			Set Intrusion operating delay time	Delay	00.0 – 99.9Sec	User ^M M	YESU
			Set Intrusion operating time	Time	000.0 – 999.9Sec	User	YES
			Set Refill delay function operating pressure proportional output	Pressure	000 – 255Bar	User	YES
10	SCREW 1/5	Refill Delay	Set Refill delay function operating Speed proportional output	Speed	000% – 100%	User	YES
			Set Refill delay operating time	Time	00.0 – 99.9Sec	User	YES
			Set Refill-1 function over operating position.	Position	000.0 – 999.9mm	User	YES
11	SCREW 1/5	Refill 1	Set Refill-1 function operating pressure proportional output	Pressure	000 – 255Bar	User	YES
			Set Refill-1 function operating Speed proportional output	Speed	000% – 100%	User	YES
			Set Refill-2 function over operating position.	Position	000.0 – 999.9mm	User	YES
12	SCREW 1/5	Refill 2	Set Refill-2 function operating pressure proportional output	Pressure	000 – 255Bar	User	YES
			Set Refill-2 function operating Speed proportional output	Speed	000% – 100%	User	YES
			Set Suck back-2 function over operating position.	Position	000.0 – 999.9mm	User	YES
			Set Suck back-2 function operating pressure proportional output	Pressure	000 – 255Bar	User	YES
13	SCREW 1/5	Suck back 2	Set Suck back-2 function operating Speed proportional output	Speed	000% – 100%	User	YES
	Ś		On completion of set delay time Suck back- 2 function take place. Its start on completion of Refill function	Delay	00.0- 99.9Sec	User	YES

							11	
				Set Suck back-2	Time	00.0 –	User and	YES
				operating time		99.9Sec	Ű	0
				Set Cooling function	Pressure	000 –	User 📆	YES
				operating pressure		255Bar	MM	Moul
14	JUNE VV	Cooling		proportional output				
	1/5			Set Cooling function	Speed	000% –	User	YES
				operating Speed		100%		
				proportional output	Time	000.0 -	User	YES
				Set Cooling operating		999.9Sec		
				time.				
			To run machine in	Set Dry Cycle				Yes
15	SCREW	Dry cycle	semi mode	function to run in dry	Function	On/Off	l evel 1	
10	1/5		without refilling	cycle mode.	i diletion			
			function.					
	SCREW							
16	1/5	Latch						
	-							

INJKon Rainbow X Manual

MMOW)

Screen Page: SCREW 2/5





(1)Press" key once on the top of the Touch Screen.

(2) NowScreen Page: SCREW 2/5 is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit.(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.



SCREW 2/5 operation page and list of parameter is given below.

STREAMLINE CONTROLS PVT.LTD.

		Message			Parameter D	escription	Operating	Part Of
Sr No	Page Name	Of Parameter On Screen	Function Description	Parameter Description	Parameter Type	Range	Password Level	Memory
1	SCREW	Stage 1	Injection Stage 1 Injection stage 1 Function work till	Set Injection Stage-1 function operating AN3 proportional output1	AN3	000% - 100%	User Level	YES
	2/5	Stage 1	1 set position or over the set time	Set Injection Stage-1 function operating AN4 proportional output	AN4	000% - 100%	User Level	YES
2	SCREW	Stage 2	Injection Stage 2 Injection stage 2 Function work till	Set Injection Stage-2 function operating AN3 proportional output	AN3	000% - 100%	User Level	Part Of MemoryYESYESYESYESYESYESYESYESYESYESYESYESYESYESYES
2	2/5	Stage 2	2 set position or over the set time	Set Injection Stage-2 function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
2	SCREW	Stage 2	Injection Stage 3 Injection stage 3	Set Injection Stage-3 function operating AN3 proportional output	AN3	000% – 100%	User Level	YES
3	2/5	Stage 3	to reach the stage 3 set position or over the set time	Set Injection Stage-3 function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
	SCREW	6 1 1 1	Injection Stage 4 Injection stage 4 Function work till	Set Injection Stage-4 function operating AN3 proportional output	AN3	000% – 100%	User Level	YES
4	2/5	Stage 4	to reach the stage 4 set position or over the set time	Set Injection Stage-4 function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
5	SCREW		Injection HOLD ON 1 Injection hold	Set Injection Hold On-1 function operating AN3 proportional output	AN3	000% – 100%	User Level	YES
	2/5	Hold 1	Function work till to over the set time on	Set Injection Hold On-1 function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
6	SCREW 2/5	Hold 2	Injection HOLD ON 2 Injection hold Function work till to over the set time on	Set Injection Hold On-2 function operating AN3 proportional output	AN3	000% – 100%	User Level	YES

			_				1.1	200
				Set Injection Hold			-mil	YES
				On-2 function		000% -		0
				operating AN4	AN4	100%	User Lever	S.C
				proportional output			3M	m.uo
7	SCREW 2/5	Injection Boost	Select various type of pump selection with Injection function as per output selection provide in sequence table. With boost selection 0 to 3 provide fix output selection. With boost selection 4 pump selection very with set pressure proportional output. With boost selection 5 pump selection very with set Speed proportional output.	Select operating boost option	Number	0-5	Level 1	YES
			Select Time base	Make on to operate time base boost function	Mode	On/Off	Level 1	YES
8	SCREW 2/5	Single Boost	Boost option function. Delay time for injection boost function. On time for injection boost function.	On completion of set delay time Start boost on time. Its start on completion of Carriage Forward function	Delay	00.0- 99.9	User Level	YES
				Set boost on time	On Time	00.0- 99.9	User Level	YES
9	SCREW	Internier		Set Intrusion function operating AN3 proportional output	AN3	000% - 100%	User	YES
	2/5	intrusion		Set Intrusion function operating AN4 proportional output	AN4	000% – 100%	User	YES
10	SCREW	Ref Delay		Set Refill delay function operating AN3 proportional output	AN3	000% - 100%	User	YES
	2/5	Net Delay		Set Refill delay function operating AN4 proportional output	AN4	000% – 100%	User	YES

							1.1	2.2.2
	SCREW			Set Refill-1 function operating AN3 proportional output	AN3	000% – 100%	User	YES
	2/5	Refill 1		Set Refill-1 function operating AN4 proportional output	AN4	000% – 100%	User MM	YES
12	SCREW			Set Refill-2 function operating AN3 proportional output	AN3	000% - 100%	User	YES
12	2/5	Refiii 2		Set Refill-2 function operating AN4 proportional output	AN4	000% - 100%	User	YES
	SCDEW	Suck back		Set Suck back-2 function operating AN3 proportional output	AN3	000% - 100%	User	YES
13	2/5	2		Set Suck back-2 function operating AN4 proportional output	AN4	000% – 100%	User	YES
14	SCREW	Cooling		Set Cooling function operating AN3 proportional output	AN3	000% – 100%	User	YES
14	2/5	Cooling		Set Cooling function operating AN4 proportional output	AN4	000% – 100%	User	YES
15	SCREW 2/5	Intrusion	Enable or Disable intrusion function. When over shot wait is needed from barrel size at that time made on this function, In this function after unit forward in semi or auto cycle instead of injection function refill function is start for set intrusion time. After completion of on time injection function start.	Make on to operate intrusion function	Function	On/Off	Level 1	
16	SCREW 2/5	Combine Refill	Enable or disable Combine Refill option. When cooling time is less than refill time at that time for reducing cycle time made on this	Make on to operate combine refill function	Function	On/Off	Level 1	YES

			function. In this function after completion of cooling time				stres	mecone o o o o
			MOLD OPEN function start parallel to REFILL function &				5	
			complete the mold side whole cycle. After mold fully close					
			system wait for refill function over & on completion		0			
			place and repeat this sequence in			>		
17	SCREW 2/5	Back pres	Enable or Disable backpressure digital output during refill function.	Make on to operate digital output of back pressure	Function	On/Off	Level 1	YES
18	SCREW	Suck back		Set Suck back-2 function operating AN3 proportional output	AN3	000% – 100%	User	YES
	2/5	2		Set Suck back-2 function operating AN4 proportional output	AN4	000% – 100%	User	YES
19	SCREW 2/5	Refill Total Time	Total time for refill function. If refill time is exceed from total time at that time system come in hand mode & display ILREFILL TIMER OVER.	Set total time for refill function	Timer	000.0- 999.9	Level 2	YES
20	SCREW 2/5	Refill Boost	Select various type of pump selection with Refill function as per output selection provide in sequence table. With boost selection 0 to 3 provide fix output selection.	Select operating boost option	Number	0-5	Level 1	YES

S

			With boost				mil	necone
			selection 4 pump				D D	e co
			selection very				15.	S.C
			with set pressure				4 m	in allo
			proportional					/// • •
			output.					
			With boost					
			selection 5 pump					
			selection very					
			with set Speed					
			proportional					
			output.					
			Enable or Disable				Level 1	YES
		Back	backpressure	Make on to operate				
21	SCREW	pressure	digital output	digital output of	Function	On/Off		
	2/5	(%)	during refill	back pressure				
			function.					
			Select various					YES
			type of pump					
			selection with					
			Suck back function					
			as per output					
			selection provide					
			in sequence table.					
			With boost		/			
			selection 0 to 3					
			provide fix output					
	SCREW	Suck back	selection.	Select operating				
22	2/5	boost	With boost	boost option	Number	0-5	Level 1	
	2,5	50051	selection 4 pump	Soust option				
			selection very					
			with set pressure					
			proportional					
			output.					
			With boost					
			selection 5 pump	*				
			selection very					
			with set Speed					
			proportional					
			output.					

MOLD

CORE

EJECTOR

MONITOR

INJKon Rainbow X Manual

amlinec

MMOW)

Screen Page: SCREW 3/5

SCREW



(1)Press" key once on the top of the Touch Screen.

(2) NowScreen Page: **SCREW 3/5** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit.(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.



SCREW 3/5 operation page and list of parameter is given below.

TEMP.

CARRIAGE

SCREW FAST SETTING

NEXT

		Message			Parameter I	Description	Oneration	Part Of
Sr No	Page Name	Of Parameter On Screen	Function Description	Parameter Description	Parameter Type	Range	Password Level	Memory
				Set Pre Injection function over operating position.	Position	000.0 – 999.9mm	User	YES
			Pre Injection When AUTO CARRIAGE function is enable at that	Set Pre Injection function operating pressure proportional output	Pressure	000Bar – 255Bar	User	YES
1	SCREW 3/5	Pre- Injection	time before carriage forward function Injection function take place & Function work till to reach the Pre injection's set	Set Pre Injection function operating Speed proportional output	Speed	000% – 100%	User	YES
			position or over the set time.	Set Pre Injection operating time	Timer	000.0 – 999.9Sec	User	YES
				Set Pre Injection function operating AN3 proportional output	AN3	000% – 100%	User	YES
		N		Set Pre Injection function operating AN4 proportional output	AN4	000% – 100%	User	YES
		Y		Set Suck back-1 function over operating position.	Position	000.0 – 999.9mm	User	YES
2	SCREW 3/5	Suck back 1		Set Suck back-1 function operating pressure proportional output	Pressure	000 – 255Bar	User	YES

			Set Suck back-1 function operating Speed proportional output	Speed	000% – 100%	User	AM UUO
	SCREW 3/5		On completion of set delay time Suck back- 1 function take place. Its start on completion of injection function	Delay	00.0-99.9 Sec	User	YES
			Set Suck back-1 operating time Set Suck back-1 function operating AN3	Time AN3	00.0 – 99.9Sec 000% – 100%	User User	YES
			proportional output Set Suck back-1 function operating AN4 proportional	AN4	000% - 100%	User	YES
			output Set Intensifier function operating pressure proportional output	Pressure	000 – 255Bar	User	YES
			Set Intensifier function operating Speed proportional output	Speed	000% – 100%	User	YES
3	SCREW 3/5	Intensifier	On completion of set delay time Intensifier function take place. Its start on completion of Injection function	Delay	00.0- 99.9Sec	User	YES
			Set Intensifier operating time	Time	00.0 – 99.9Sec	User	YES
G	5		Set Intensifier function operating AN3 proportional output	AN3	000% – 100%	User	YES

			Set Intensifier			User	YES
			function			Û	10
			operating AN4	AN4	000% –	L.	IS.
			proportional		100%	The second	0
			output				
			Set Purge		000.0 -		No
			Injection		999.9mm		
			function over	Position	C	Level 2	
			operating				
			position				
			Set Purge	Pressure	000 -		No
			Injection	ricosure	255Bar	r	
			function				
			operating			Level 2	
			nressure				
			proportional				
			output				
			Set Purge	Sneed	000% -		No
			Injection	Speed	100%		
			function		100/0		
			operating				
4	SCREW	Injection	Speed				
	3/5	injection	proportional				
			output				
			Set Purge				No
			Injection				NO
			function		000% -		
			operating AN3	AN3	100%	Level 2	
			proportional		10078		
			proportional				
			Sot Durgo				No
			Injection				NO
			function		000% -		
			operating ANA	AN4	100%	Level 2	
			nronortional		10070		
			output				
			Sot Durgo	Timo	000.0-		No
			Injection time	Time		Level 2	NO
			Sot Durgo Rofill		000 0 -		No
			function over		990 amm		
			operating	Position	555.511111	Level 2	
			nosition				
			Sot Purgo Rofill	Drossuro	000 -		No
			function	riessure	255Bar		NO
	SCREW		operating		255681		
5	3/5		prossure			Level 2	
5		Refill	pressure				
		HCTIII -	outnut				
			Sat Durge Pofill	Snood	000%		No
			function	Sheen	100%		NU
9			onerating		10070		
			Snood			Level 2	
			proportional				
			proportional				
			ουιραί				

				Set Purge Refill function operating AN3 proportional output	AN3	000% – 100%	Level 2 5. M	MM · WO
				Set Purge Refill function operating AN4 proportional output	AN4	000% – 100%	Level 2	No
				Set Purge Refill time	Time	000.0 – 99.9Sec	Level 2	No
6	SCREW 3/5	Pre- Injection	Select pre injection function.	Make on to operate Pre injection function	Function	On/Off	Level 1	YES
7	SCREW 3/5	Suck back 1	Select Suck Back 1 function enable (on) or disable (off).	Make on to operate suck back-1 function	Function	On/Off	Level 1	YES
8	SCREW 3/5	Intensifier Charge	Enable or Disable intensifier function. If set to on, intensifier function is enable.	Make on to operate intensifier function	Function	On/Off	Level 1	YES
		Cycles		Set auto purge mode operating cycle.	Number	00-99	Level 2	No
9	SCREW 3/5	Total Time	This function is use to clean up injection barrel while you change material.	Total time for purge mode operation. If total time is exceed before completion of set cycles at that time system come in hand mode & display ILTOTAL TIMER OVER.	Timer	000.0- 999.9 sec	Level 2	No
C								
				Page 95 of 155				

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Screen Page: FAST SETTING





Press" FAST SETTING " key once on the top of the Touch Screen.

NowScreen Page: FAST SETTING is displayed on screen in first line.

This is the fast setting screen page, there is a much needed parameter in a single page.

FAST SETTING operation page and list of parameter is given below.

🚽 HAN	D	F	AST	SE	TTIN	G			03/1	12/201	9 🛣	10	:10:54
	Mold mm 0000.0 Speed (%)	 P	Scr 00 Pre	ew 00. s.	/ mm .0 (bar)	9	6 6	Ejector 000. AN	r mm 0 3	-≞	Ton m 000. AN 4	im 0 1	>
Mold Close	Slow 1	Fa	st		Slow 2	ור	Sa	afety 1	, Saf	etv 2	Ton	1	Ton 2
Speed(%)	030	03	0		030	٦ï	(030	030		030	Ť	030
Pres.(bar)	030	03	030		030	٦ï	(030	0	30	030	٦ŀ	030
Posi(mm)	0200.0	01	50.0		0140.0	i	01	20.0	01	10.0	0100.0		0100.0
Time(sec)	01.0					ľ			03	.0	01.0	٦ŀ	01.0
Mold Open	Slow 3	s	low 2	ור	Fas	t	٦	Slow	1	Dc	omp		
Speed(%)	030	03	30		030			030		03	0		
Pres.(bar)	030	03	30	٦i	030		٦	030		03	0		
Posi(mm)	0250.0	0	230.0	١	0200	0.0	٦	050.	.0	050	0.0		
Time(sec)		1		11			٦	01.0	,	01.	0		
Ejector	Forward 1	For	ward 2	2	Backw	/ai	ď						
Speed(%)	030	03	0		030								
Pres.(bar)	030	03	30		030								
Posi(mm)	050.0	10	0.0		010.	0							
Time(sec)	01.0			١	01.0								
Injection	Stage 1	S	Stage 2		Stag	e 3	•	Stage	e 4	Ho	ld 1	H	lold 2
Speed(%)	030	03	030		030			030		03	0	0	30
Pres.(bar)	030	03	030		030			030		03	0	(030
Posi(mm)	000.0	0	0.00		000.0			000.0					
Time(sec)	01.0	00).0		00.0)		00.0		0.	1	().1
Ref/Skback	Stage 1	St	age 2		Suckb	ad	k	Cooli	ng				
Speed(%)	030	03	0		030			030					
Pres.(bar)	030	03	0		030			030					
Posi(mm)	0100.0	150	0.0		200.0								
Time(sec)	01.0	00	0.0		00.0	_		10.0					
Alarm												He	elp ?
Action												He	at 🚢
			Бесто	R	ТЕМР		C		sc		F C	5 TING	NEXT

Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description
1	FAST SETTING	Mold close parameters	Go to MOLD 1/5 page	Go to MOLD 1/5 page
2	FAST SETTING	Mold open parameters	Go to MOLD 1/5 page	Go to MOLD 1/5 page
3	FAST SETTING	Ejector parameters	Go to EJECTOR 1/2 page	Go to EJECTOR 1/2 page
4	FAST SETTING	Injection parameters	Go to SCREW 1/5 page	Go to SCREW 1/5 page
5	FAST SETTING	Ref/Suck back parameters	Go to SCREW 1/5 page	Go to SCREW 1/5 page

Screen Page: CONFIGURE 1/6

CONFIGURE



(1)Press" CONFIG '' key once on the top of the Touch Screen.

(2) NowScreen Page: **CONFIGURE 1/6** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit.(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

CONFIGURE 1/6page and list of parameter is given below.

HAND			С	ONFIGURE 1	1/6	03/1	12/20	19 🛣 10	:10:54
	M	Mold mm 0000.0		Screw mm 000.0	1	Ejector mm 000.0	-	Ton mm 000.0	
	S	Speed (%) 100	⁾ P	Pres. (bar) 060	%	AN 3 000	%	AN 4 000	

Functio	ons	Reset Fun	ction	
Mold Side	Posi	Batch Counter	Off	
Injection	Posi	Totalizer	Off	
Refill	Posi Hourly Counter		Off	
Suckback	Posi	Production Data	Off	
Ejector	Ls	Interlock History	Off	
Tonnage1	Timer	Factory Reset	Off	
Tonnage2	Timer			
Decompression 1	Off	Calibrat	ion	
Carriage	Timer	Calibrate Off		
Decompression 2	Off	Preset On	Off	

	Disable A	N Para.			Machine Ty	pe	Horizo	ontal
								hr. 0
	Alarm						Не	ip ?
	Action						He	at 🚈
6		MOLD COR	E EJECTOR	TEMP.		SCREW	F S I	NEXT

amlineco

		Message			Parameter	Description		Part Of
Sr	Page Name	Of	Function Description	Parameter	Parameter	•	Password	Memory
No		Parameter		Description		Range	Level	
		On Screen			/1			
			and mold open			C		NO
			operating type. In					
			case use of Analog					
			input (Linear				2	
			Transducer or					
	CONFIGURE		Encoder) select POSI	Select mold		Position/		
1	1/6	Mold Side	(position) mode	side operating	Function	Ls	Level 2	
	_, .		operating type.	type				
			In case use of Digital					
			Input (Limit					
			Switches of Brovimity Switches)					
			select IS mode					
			operating type.					
			Select injection-					NO
			operating type.					
			In case use of					
			Analog input (Linear					
			Transducer or					
			Encoder) select POSI					
			(position) mode					
			operating type.					
2	CONFIGURE	Injection	In case use of Digital	Select Injection	Function	Position/		
2	1/6	injection	Switches or	operating type	FUNCTION	Ls/Timer	Level 2	
			Proximity Switches)	operating type.				
			select LS mode					
			operating type.					
			None of above two					
			operating type					
			feedback select					
			TIMR mode					
			operating type.					
			Select refill-					NU
			operating type. In					
			innut (Linear					
			Transducer or					
			Encoder) select POSI					
2	CONFIGURE	Dofill	(position) mode	Select refill	Function	Position/		
3	1/6	Refill	operating type.	operating type	FUNCTION	Ls	Level 2	
			In case use of Digital	operating type				
			Input (Limit					
			Switches or					
			Proximity Switches)					
			select LS mode					
1		1	operating type.	1	1	1	1	1

	1	1			1	1	11	1800
4	CONFIGURE 1/6	Suck back	Select suck back- operating type. In case use of Analog input (Linear Transducer or Encoder) select POSI (position) mode operating type. In case use of Digital Input (Limit Switches or Proximity Switches) select LS mode operating type. None of above two operating type feedback select TIMR mode operating type.	Select suck back function operating type.	Function	Position/ Ls/Timer	Level 2	NO 24 No.UO
5	CONFIGURE 1/6	Ejector	Select ejector- operating type. In case use of Analog input (Linear Transducer or Encoder) select POSI (position) mode operating type. In case use of Digital Input (Limit Switches or Proximity Switches) select LS mode operating type. None of above two operating type feedback select TIMR mode operating type.	Select ejector function operating type	Function	Position/ Ls/Timer	Level 2	NO
6	CONFIGURE 1/6	Tonnage I	Select tonnage1- operating type. In case use of Analog input (Pressure Transducer) select POSI (position) mode operating type. In case use of Digital Input (Limit Switches or Proximity Switches) select LS mode operating type. None of above two operating type	Select tonnage 1 function operating type.	Function	Position/ Ls/Timer	Level 2	NO

			feedback select TIMR mode operating type.				stree and	M · WOD
7	CONFIGURE 1/6	Tonnage II	Select tonnage2- operating type. In case use of Analog input (Pressure Transducer) select POSI (position) mode operating type. In case use of Digital Input (Limit Switches or Proximity Switches) select LS mode operating type. None of above two operating type feedback select TIMR mode operating type.	Select tonnage 2 function operating type.	Function	Position/ Ls/Timer	Level 2	NO
8	CONFIGURE 1/6	Decompre ssion 1	Select decompression- operating type. In case use of Analog input (Pressure Transducer) select POSI (position) mode operating type. In case use of Digital Input (Limit Switches or Proximity Switches) select LS mode operating type. None of above two operating type feedback select TIMR mode operating type. If decompression function is not available in machine then made it OFF.	Select decompression function operating type.	Function	Off/Positi on/Ls/Ti mer	Level 2	NO
	5							

10	CONFIGURE 1/6	Carriage	Select carriage- operating type. In case use of Digital Input (Limit Switches or Proximity Switches) select LS mode operating type. Otherwise select TIMR mode operating type. In case use of Analog input (Linear Transducer) select POSI (position) mode operating type.	Select carriage function operating type.	Function	Off/Positi on /Ls- Timer /Ls/Time r	Level 2	NO 2E S
11	CONFIGURE 1/6	Decompre ssion 2	This will come when the parameter version is updated.					
		RESET FUNCTION		6				
11	CONFIGURE 1/6	Batch Count	Batch counter reset enable (on) or disable (off). When put to on, reset the 5-digit batch counter reset to 0.	Make on to reset batch counter.	Function	On/Off	Level 1	NO
12	CONFIGURE 1/6	Totalizer	If set to on, totalize counter is reset to zero.	Make on to reset Totalizer counter.	Function	On/Off	Level 3	NO
13	CONFIGURE 1/6	Hour Count	If set to on, hour counter is reset to zero.	Make on to reset Hour counter.	Function	On/Off	Level 3	NO
14	CONFIGURE 1/6	Prod Data	Production data reset enable (on) or disable (off). Put on to reset daily and hourly production data.	Make on to reset production data.	Function	On/Off	Level 3	NO

15	CONFIGURE 1/6	Interlock History					the street	M · WO
16	CONFIGURE 1/6	Factory Reset					0	
		CALIBRATI ON			R			NO
17	CONFIGURE 1/6	Calibratio n	Select various type of calibration mode. I.e. Temperature, Analog Input, Analog Output	Select calibration mode which is under calibration	Function	Off/ Temp. /Analog IP /Analog OP	Level 2	NO
18	CONFIGURE 1/6	Preset On	When put to on load default home count in case of incremental encoder as an analog input.	Make on to load home count.	Function	On/Off	Level 2	NO
19	CONFIGURE 1/6	Machine Type	The graphics of the machine can be changed using this parameter. You can see it on the monitor page.			HORIZON TAL /VERTICA L	Level 2	NO
20	CONFIGURE 1/6	AN3 AN4 ON OFF	Using this parameter, the AN3 and AN4 parameters of all functions can be turned off.			On/Off	Level 2	NO

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INJKon Rainbow X Manual

Screen Page: CONFIGURE 2/6

CONFIGURE



(1)Press" (1)Pre

(2) NowScreen Page: CONFIGURE 2/6 is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit.(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

CONFIGURE2/6 page and list of parameter is given below.

ll)	HA	ND	CONFIGURE 2/6			03 /	03/12/2019 🛣		
	M	Mold mm 0000.0		Screw mm 000.0	•	Ejector mm 000.0	- 	Ton mm 000.0	
	S	Speed (% 100	⁾ P	Pres. (bar) 060	%	AN 3 000	%	AN 4 000	

Othe	r	Real Time	Clock			
Batch Counter	00000	Time (hh:mm)	10 10			
Cycle Delay	00.0	Date(dd/mm/yy)	03 12 19			
Cycle Time	01.0					
Screw PPR	01					
Thermocouple	Fe-K	Passwords				
Diag Test		Level 1	0000			
Load SD Cons		Level 2	1111			
Piece Fall	Off	Level 3	2222			
Piece Fall Time	00.0	Lock Delay(min)	00			
CT Ratio	000					

Alarm				Не	lp ?
Action				He	at 🚈
		II.		F S	

		Message			Param	eter	Operating	Part Of
Sr No	Page Name	Of Parameter On Screen	Function Description	Parameter Description	Descrij Parameter Type	Range	Password Level	Memory
1	CONFIGUR E 2/6	Batch Counter	Batch Counter preset value. The batch counter resets on reaching this Count. On overSpeed batch counter system comes into HAND mode. On setting value 00000 disables the counter.	Set batch count	Number	00000- 99999	Level 1	NO
2	CONFIGUR E 2/6	Cycle Delay	Set delay between two continues cycles in fully auto mode.	Set delay time between two cycle.	Timer	00.0- 99.9	User	NO
3	CONFIGUR E 2/6	Cycle Time	Set maximum cycle over time. If current cycle time is exceed then set cycle time then IL CYCLE TIME OVER occurs & system comes in HAND mode.	Set cycle time	Timer	000.0 – 999.9Se c	Level 1	NO
4	CONFIGUR E 2/6	Screw PPR	Set pulses per revolution of screw to measure screw RPM. Not more than 4 pulses per revolution	Set PPR to measure RPM	Number	0-5	Level 2	NO
5	CONFIGUR E 2/6	Thermoco uple	Selection provide for Fe-K or Cr-Al type thermocouple to measure barrel temperature.	Select thermocouple type	Function	Fe-K / Cr-Al	Level 2	NO
6	CONFIGUR E 2/6	Piece fall		For piece fall confirmation needed during cycle	Function	ON/OFF	Level 2	NO
7	CONFIGUR E 2/6	Piece fall Time		IF piece fall is done ON then upto this time if piece fall input is not sense then interlock comes and stop next	Timer	0- 99.9Sec	Level 2	NO

				cycle. This time start with mold open function			stree	inecont ols.
		REAL TIME CLOCK					Ч,	NOW
8	CONFIGUR	Time	Set current time in hour & minutes. HH: Shows hour MM: Shows minute	Set hour time	Time Hour	00-23	Level 2	
0	E 2/6	(HH:MM)	In first two digit set hour & in next two digit set minutes.	Set minute time	Time Minute	00-59	Level 2	NO
		Set current dat month & year.		Set date	Date		Level 2	NO
9	CONFIGUR	SET DATE	DD: Shows date MM: Shows month YY: Shows year	Set Month	Month		Level 2	NO
5	E 2/6	γ>	In first two digits set date, in next two digit set month & in next two digit set year.	Set year	Year		Level 2	NO
		PASSWOR DS						
		Level 1	Set password level 1 to protect software decided configures parameters at level 1.	Set password level 1	Number	0000- 9999	Level 3	NO
	CONFICUE	Level 2	Set password level 2 to protect software decided configures parameters at level 2.	Set password level 2	Number	0000- 9999	Level 3	NO
9	CONFIGUR E 2/6	Level 3	Set password level 3 to protect software decided configures parameters at all level.	Set password level 2	Number	0000- 9999	Level 3	NO
		Lock Delay	Set password lock delay. If there is no any data entry within this set time open any password level is lock automatically.	Set password lock delay	Timer	00-99	Level 3	NO
	5							

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Screen Page: CONFIGURE 3/6

CONFIGURE



(1)Press" (1)Pre

(2) NowScreen Page: **CONFIGURE 3/6** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit.(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

CONFIGURE 3/6page and list of parameter is given below.

HAND		ND	CONFIGURE 3/6			03/1	🗰 03/12/2019 🛣 10:10:54			
	N	Mold mm 0000.0		Screw mm 000.0	•	Ejector mm 000.0	- 	Ton mm 000.0		
	S	Speed (%) 100	Ρ	Pres. (bar) 060	%	AN 3 000	%	AN 4 000		

Lubrication							
On Time(sec)	01.0	After Pcs		0100			
Off Time(min)	01.0	Shots		1			
Lubrica	Accumulator						
Speed(%)	030	Auto	Min	000.0			
Pres.(bar)	030		Max	999.9			
An3(%)	030	Hand	Min	000.0			
An4(%)	030		Max	999.9			
		Charge Delay(sec)		05.0			
Energy Save Output		L					
Time(sec)	00.0						
Delay(sec)	00.0						
Motor Starter		Tonnage Ratings					
Off Time(sec)	00.0	Rated To	onnage	0000			
Star Delta(sec)	05.0	Pulses		0000			
Alarm Help ?							
Action Heat-							
MONITOR MOLD CORE EJECTOR TEMP. CARRIAGE SCREW FAST SETTING NEXT							

STREAMLINE CONTROLS PVT.LTD.

Sr	Sr Page Name	Message	Eunction	Parameter Description	Parameter Description		Operating	Part Of Memory
No		Parameter On Screen	Description		Parameter Type	Range	Password Level	NM . WOS
		LUBRICATI ON						
1	CONFIGUR E 3/6	After Pecs	With enter count here time base lubrication function is disable and auto cycle base lubrication is start.	Set auto cycle then after lubrication function make on.	Number	000-999	Level 1	NO
		On Time	Set lubrication on time.	Set lubrication on time.	Number	00.0- 99.9	Level 1	NO
		Off Time	Set lubrication off time.	Set lubrication off time.	Number	00.0- 99.9	Level 1	NO
		Shots	Set lubrication shots	6	Number	0-9	Level 1	NO
2	CONFIGUR E 3/6	GUR Lubrication This function is use to provide oil to machine.	This function is use	Set Lubrication function operating pressure proportional output	Pressure	000 – 255Bar	Level 2	No
				Set Lubrication function operating Speed proportional output	Speed	000% – 100%	Level 2	No
			Set Lubrication function operating AN3 proportional output	AN3	000% – 100%	Level 2	No	
				Set Lubrication function operating AN4 proportional output	AN4	000% – 100%	Level 2	No

C .

3	CONFIGUR E 3/6	Time	This is delay and on time for energy save output. Its delay time start with refill delay time and on completion of delay time one output goes on for set time and than goes off.	Set on time for energy save output	Timer	00.0- 99.9Sec	Level 2	NO OS.
		ES OP Delay		Set on delay for energy save output	Delay	00.0- 99.9Sec	Level 2	NO
4	CONFIGUR E 3/6	Off Time (sec)	This parameter is used when	Set on time for motor off	Timer	00.0- 99.9Sec	Level 2	NO
		Star Delta configured. (sec)	Set on time for star motor on	Timer	00.0- 99.9Sec	Level 2	NO	
5	CONFIGUR E 3/6	Accumulat or: Auto Min		Select Accumulator charging function minimum limit for AUTO mode only.	Position	000.0- 999.9	Level 3	NO
		Accumulat or: Auto Max		Select Accumulator charging function maximum limit for AUTO mode only.	Position	000.0- 999.9	Level 3	NO
		Accumulat or: Hand Min		Select Accumulator charging function minimum limit for HAND mode only.	Position	000.0- 999.9	Level 3	NO
		Accumulat or: Hand Max		Select Accumulator charging function maximum limit for HAND mode only.	Position	000.0- 999.9	Level 3	NO
	Accumulat or:Charge Delay	Set accumulator charge delay	Delay	00.0- 99.9	Level 3	NO 22 Mound		
--	---------------------------------	---------------------------------	-------	---------------	---------	----------------		
					S.			
			R	5				

Screen Page: CONFIGURE 4/6

CONFIGURE



" key once on the top of the Touch Screen. (1)Press"

(2) NowScreen Page: **CONFIGURE 4/6** is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit. (If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing ENTER key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

	HA	ND	C	ONFIGURE 4	/6	03/1	2/20	19 🛣 10	:10:54
/	M	Mold mm 0000.0		Screw mm 000.0	4	Ejector mm 000.0		Ton mm 000.0	
	S	Speed (% 100	^{,)} P	Pres. (bar) 060	%	AN 3 000	%	AN 4 000	

CONFIGURE 4/6 page and list of parameter is given below.

Transfer Of Digital Inputs									
Input 1 Off Old DI 00 - New DI 00									
Input 2	Off	Old DI	00	-	New DI	00			
Input 3	Off	Old DI	00	-	New DI	00			
Input 4	Off	Old DI	00	-	New DI	00			

Transfer Of Digital Outputs										
Output 1 Off Old DO 00 → New DO 00										
Output 2	Off	Old DO	00	-	New DO	00				
Output 3	Off	Old DO	00	-	New DO	00				
Output 4 Off Old DO 00 - New DO 0										



Gr		Message	Eurotion	Daramotor	Param Descrij	eter otion	Operating	Part Of Memory
No	Page Name	Parameter On Screen	Description	Description	Parameter Type	Range	Password Level	hw .mos
	CONFICUE	In1:Trans	If set to on, IN1 is active. Now old digital input (faulty) is transfer to new digital input (spare) place.	Make on to transfer digital input	Function	On/Off	Level 2	NO
1	E 4/6	Old DI	Enter old faulty digital input number.	Select faulty digital input number	Number	00-64	Level 2	NO
		New DI	Enter new spare digital input number.	Select spare digital input number where faulty input shift	Number	00-64	Level 2	NO
2	CONFIGUR E 4/6	In2:Trans	If set to on, IN2 is active. Now old digital input (faulty) is transfer to new digital input (spare) place.	Make on to transfer digital input	Function	On/Off	Level 2	NO
		Old DI	Enter old faulty digital input number.	Select faulty digital input number	Number	00-64	Level 2	NO
		New DI	Enter new spare digital input number.	Select spare digital input number where faulty input shift	Number	00-64	Level 2	NO
		In3:Trans	If set to on, IN3 is active. Now old digital input (faulty) is transfer to new digital input (spare) place.	Make on to transfer digital input	Function	On/Off	Level 2	NO
3	CONFIGUR E 4/6	Old DI	Enter old faulty digital input number.	Select faulty digital input number	Number	00-64	Level 2	NO
		New DI	Enter new spare digital input number.	Select spare digital input number where faulty input shift	Number	00-64	Level 2	NO
4	CONFIGUR E 4/6	In4:Trans	If set to on, IN4 is active. Now old digital input (faulty) is transfer to new digital input (spare) place.	Make on to transfer digital input	Function	On/Off	Level 2	NO
	Ś	Old DI	Enter old faulty digital input number.	Select faulty digital input number	Number	00-64	Level 2	NO

				Select spare			~	NOCODE
		New DI	Enter new spare digital input number.	digital input number where faulty input shift	Number	00-64	Level 2	ha wo
		Op1:Trans	If set to on, OP1 is active. Now old digital output (faulty) is transfer to new digital output (spare) place.	Make on to transfer digital output	Function	On/Off	Level 2	NO
5	CONFIGUR E 4/6	Old DO	Enter old faulty digital output number.	Select faulty digital output number	Number	00-64	Level 2	NO
		New DO	Enter new spare digital output number.	Select spare digital output number where faulty output shift	Number	00-64	l evel 2	NO
		Op2:Trans	If set to on, OP2 is active. Now old digital output (faulty) is transfer to new digital output (spare)	Make on to transfer digital output	Function	On/Off	Level 2	NO
6	CONFIGUR E 4/6	Old DO	Enter old faulty digital output number.	Select faulty digital output number	Number	00-64	Level 2	NO
		New DO	Enter new spare digital output number.	Select spare digital output number where faulty output shift	Number	00-64	Level 2	NO
		Op3:Trans	If set to on, OP3 is active. Now old digital output (faulty) is transfer to new digital output (spare) place.	Make on to transfer digital output	Function	On/Off	Level 2	NO
7	CONFIGUR E 4/6	Old DO	Enter old faulty digital output number.	Select faulty digital output number	Number	00-64	Level 2	NO
		New DO	Enter new spare digital output number.	Select spare digital output number where faulty output shift	Number	00-64	Level 2	NO
8	CONFIGUR E 4/6	Op4:Trans	If set to on, OP4 is active. Now old digital output (faulty) is transfer	Make on to transfer digital output	Function	On/Off	Level 2	NO

	to new digital output (spare) place.				strea	1000 xx 015.0
Old DO	Enter old faulty digital output number.	Select faulty digital output number	Number	00-64	۳, Level 2	NO WO
New DO	Enter new spare digital output number.	Select spare digital output number where faulty output shift	Number	00-64	Level 2	NO

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Screen Page: CONFIGURE 5/6

CONFIGURE



(1)Press" (1)Press

(2) NowScreen Page: CONFIGURE 5/6 is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit.(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

CONFIGURE 5/6 page and list of parameter is given below.

-	HA	ND	CONFIGURE 5/6			() 03/	03/12/2019 🛣 10:10:54		
	·M	Mold mm 0000.0		Screw mm 000.0	1	Ejector mm 000.0		Ton mm 000.0	
	S	Speed (%) 100) P	Pres. (bar) 060	%	AN 3 000	%	AN 4 000	

Functions	Acel	Decl	Functions	Acel	Decl		
Mold Close	0.00	0.00	Mold Open	0.00	0.00		
Decompression	0.00	0.00	Tonnage	0.00	0.00		
Ejector Forward	0.00	0.00	Ejector Backward	0.00	0.00		
Core In	0.00	0.00	Core Out	0.00	0.00		
Core 2 In	0.00	0.00	Core 2 Out	0.00	0.00		
Core 3 In	0.00	0.00	Core 3 Out	0.00	0.00		
Core 4 In	0.00	0.00	Core 4 Out	0.00	0.00		
Mold Height+	0.00	0.00	Mold Height-	0.00	0.00		
Gate Close	0.00	0.00	Gate Open	0.00	0.00		
Injection	0.00	0.00	Refill	0.00	0.00		
Suckback	0.00	0.00	Intensifier	0.00	0.00		
Carriage Forward	0.00	0.00	Carriage backward	0.00	0.00		
Unscrew	0.00	0.00	Open Intensifier	0.00	0.00		
Shutter Close	0.00	0.00	Shutter Open	0.00	0.00		
Alarm				F	lelp ?		
Action	Action Heat-						

		Message			Param	eter	an	Part Of
Sr	Daga Nama	Of	Function	Parameter	Descrip	otion	Operating	Memory
No	Page Name	Parameter On Screen	Description	Description	Parameter Type	Range	Level 4	hm . wo?
				Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in	Acel	0 -9.99 sec	Level 2	NO
1	CONFIGUR E 5/6	Mold Closed		mold closed function Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog	Decl	0-9.99 sec	Level 2	NO
				output maximum in mold closed function				
	CONFICUE	Descentions		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Decompression	Acel	0 -9.99 sec	Level 2	NO
2	E 5/6	sion		Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Decompression function	Decl	0-9.99 sec	Level 2	NO
3	CONFIGUR E 5/6	Ejector Forward		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Ejector Forward function	Acel	0 -9.99 sec	Level 2	NO

				Set Decl Value in			n	NO
				0 to 9.99 sec. to		0-9.99	l evel 2	100
				parameter set 0	Decl	Sec	T.	Is.
				to Set value	Deel	500	3	102
				then analog				MM • Or
				maximum in				
				Fiector Forward				
				function				
				Sot Acol Value in				NO
						0 0 00		NO
				0 10 9.99 Sec. 10	Acol	0-9.99	Level 2	
				parameter set u	Acei	sec		
				to set value				
				then analog				
				output				
				maximum in				
		a		Core IN				
4	CONFIGUR	Core IN		function				
	E 5/6			Set Decl Value in				NO
				0 to 9.99 sec. to		0-9.99	Level 2	
				parameter set 0	Decl	sec		
				to Set value				
				then analog				
				output				
				maximum in				
				Core IN				
				Function				
				Set Acel Value in				NO
				0 to 9.99 sec. to		0 -9.99	Level 2	
				parameter set 0	Acel	sec		
				to Set value				
				then analog				
				output				
				maximum in				
				Core 2 IN				
_	CONFIGUR	Core 2 IN		function				
5	E 5/6			Set Decl Value in				NO
				0 to 9.99 sec. to		0-9.99	Level 2	
				parameter set 0	Decl	sec		
				to Set value				
				then analog				
				output				
				maximum in				
				Core 2 IN				
				function				
				Set Acel Value in				NO
						م م م		NO
				0.000, 0.000, 0.000	Acel	50C	Leverz	
				to Set value	ALEI	360		
6	CONFIGUR	Core 2 IN		then analog				
0	E 5/6	COLED IN						
				mavimum in				
				CUTE 3 IN				
1			1	runction	1		1	

			Set Decl Value in			2	NOCODE
					0-9 99	Level 2	1000
			narameter set 0	Decl	0 J.JJ		IS.
			to Sot value	Deci	SEC	2	102
			to set value				NM • UX
			maximum in				
			Core 3 IN				
			function				
			Set Acel Value in				NO
			0 to 9.99 sec. to		0 -9.99	Level 2	
			parameter set 0	Acel	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Core 3 IN				
_	CONFIGUR	Core 4 IN	function				
/	E 5/6		Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			maximum in				
			Coro 2 IN				
			function				
			Set Acel Value in				NO
			Set Acervalue In		0 0 00		NU
			0 10 9.99 Sec. 10	0.001	0-9.99	Level 2	
			parameter set U	Acei	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Mold Height +				
		Mold	function				
		Height +	Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
	CONFIGUR		to Set value				
8	E 5/6		then analog				
	L 3/0		output				
			maximum in				
			Mold Height +				
			function				
		185 - 1960 - 1960 - 1960 - 1960 - 1960 - 1960 - 1960 - 1960 - 1960 - 1960 - 1960 - 1960 - 1960 - 1960 - 1960 -					

			Set Acel Value in			2	NOCODE
					مو مے م		NO
			narameter set 0	Acel	50C		is.
			to Sot value	ALEI	SEC	2	102
			then analog				NWO
		Cata					
	CONFICUE	Gale	function				
9		Closed					
	E 5/6		Set Decl Value in		0.0.00		NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Gate Closed				
			function				
			Set Acel Value in				NO
			0 to 9.99 sec. to		0 -9.99	Level 2	
			parameter set 0	Acel	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Injection				
10	CONFIGUR		function				
10	E 5/6	Injection	Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Injection				
			function				
			Set Acel Value in				NO
			0 to 9.99 sec. to		0 -9.99	Level 2	
			parameter set 0	Acel	sec		
			to Set value				
			then analog				
			output				
			maximum in				
		Suck back	Suck back				
10	CONFIGUR		function				
10	E 5/6		Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Suck back				
			Function				

-	1						ineco.
			Set Acel Value in			Su	NO
			0 to 9.99 sec. to		0 -9.99	Level 2	0
			parameter set 0	Acel	sec	5.	
			to Set value			Ч,	MM .UU
			then analog				
			output				
			maximum in				
		Carriage	Carriage				
		Forward	Forward				
11	CONFIGUR		function				
11	E 5/6		Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Carriage				
			Forward				
			function				
			Set Acel Value in				NO
			0 to 9.99 sec. to		0 -9.99	Level 2	
			parameter set 0	Acel	sec		
			to Set value				
			then analog				
			output				
			maximum in				
		Unscrew	Unscrew				
	CONFIGUR		function				
12	E 5/6		Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Unscrew				
			function				
			Set Acel Value in				NO
			0 to 9.99 sec. to		0 -9.99	Level 2	
			parameter set 0	Acel	sec		
			to Set value				
13	CONFIGUR	ShutterClo	then analog				
	E 5/6	sed	output				
			maximum in				
			Shutter Closed				
			function				
			Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	-
			parameter set 0	Decl	sec	_	
			to Set value				
			then analog				
			output				
			maximum in				

			Shutter Closed			0	Inecons
			function			Ť	0
						5	NO S
			Set Acel Value in		0 0 00	The second	NO
			0 to 9.99 sec. to	0.5.5	0-9.99	Level 2	
			parameter set U	Acei	sec		
			to Set value				
			then analog				
			output			0	
			maximum in				
			Mold Open				
14		Mold Open	function				
	E 5/6		Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Mold Open				
			function				
			Set Acel Value in				NO
			0 to 9.99 sec. to		0 -9.99	Level 2	
			parameter set 0	Acel	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Tonnage				
15	CONFIGUR	Tonnage	function				
	E 5/6		Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Tonnage				
			function				
			Set Acel Value in				NO
			0 to 9.99 sec. to		0 -9.99	Level 2	
			parameter set 0	Acel	sec		
			to Set value				
16	CONFIGUR		then analog				
	E 5/6		output				
			maximum in				
		Ejector	Ejector				
		Backward	Backward				
			function				

			Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Ejector Backward function	Decl	0-9.99 sec	Level 2	NOCONE Monos
	CONFIGUR		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core OUT function Set Decl Value in	Acel	0 -9.99 sec	Level 2	NO
17	E 5/6	Core OUT	0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core OUT function	Decl	0-9.99 sec	Level 2	
		Core 2 OUT	Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 2 OUT function	Acel	0 -9.99 sec	Level 2	NO
18	CONFIGUR E 5/6		Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 2 OUT function	Decl	0-9.99 sec	Level 2	NO

19	CONFIGUR Core E 5/6 OU	Core 3	Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 3 OUT function	Acel	0 -9.99 sec	Level 2	NO ON OS
19	E 5/6	OUT	Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 3 OUT function	Decl	0-9.99 sec	Level 2	NO
	CONFIGUR		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 3 OUT function	Acel	0 -9.99 sec	Level 2	NO
20	E 5/6	Core 4 Out	Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 3 OUT function	Decl	0-9.99 sec	Level 2	NO
21	CONFIGUR E 5/6	Mold Height -	Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in mold closed function	Acel	0 -9.99 sec	Level 2	NO
_	5						

			Sat Daal Valua in			~	NGCOA
			0 to 9.99 sec. to		0-9.99	Level 2	NO
			parameter set 0	Decl	sec		Is.
			to Set value			n,	han allo
			then analog				
			output				
			maximum in				
			Mold Hight -				
			function				
			Set Acel Value in				NO
			0 to 9.99 sec. to		0 -9.99	Level 2	
			parameter set 0	Acel	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Mold Height -				
		Gate Open	function				
			0 to 9.99 sec.				
			to parameter set				
			0 to Set value				
			then analog				
			output				
	CONFIGUR		maximum in				
22	E 5/6		Core 3 OUT				
	-,-		function				
			¥.				
			Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Gate Open				
			tunction				
			Set Acel Value in		0 0 00		NO
			0 to 9.99 sec. to	A	0-9.99	Level 2	
			parameter set 0	Acel	sec		
			to Set value				
			then analog				
	CONFIGUR	Defeur	output				
22		Retilling	maximum in				
	E 5/6		Kettiling function				NO
					0 0 00	Louis 2	NU
			U LU 9.99 SEC. TO	Deel	0-9.99	Level 2	
			to Set value	Deci	SEC		
			then analog				
1			ουιραί	1			

			maximum in Refilling			am	inecont
			function			J.S.	S.C
			Set Acel Value in			n,	NO UO
			0 to 9.99 sec. to		0 -9.99	Level 2	
			parameter set 0	Acel	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Intensifier				
23	CONFIGUR		Function				
	E 5/6		Set Decl Value in				NO
		Intensifier	0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Intensifier				
			function				NO
			Set Acel Value in		0 0 00		NO
			0 to 9.99 sec. to	A col	0-9.99	Level 2	
			to Set value	Acei	sec		
			to set value				
			maximum in				
		Carriage	Backward				
	CONFIGUR	Backward	function				
24	F 5/6	Buckwara	Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Carriage				
			Backward				
			function				
			Set Acel Value in				NO
		Open	0 to 9.99 sec. to		0 -9.99	Level 2	
		Instant	parameter set 0	Acel	sec		
	CONFIGUR		to Set value				
25	E 5/6		then analog				
			output				
			maximum in				
			function				
			TUTICUUT				

			Set Decl Value in			m	NO
			0 to 9.99 sec. to		0-9.99	Level 2	100
			parameter set 0	Decl	sec	J.S.	S.C
			to Set value			n,	nm.uo
			then analog				
			output				
			maximum in				
			Open Instant				
			function				
							NO
			Set Acel Value in				NO
			0 to 9.99 sec. to		0 -9.99	Level 2	
			parameter set 0	Acel	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Shutter Open				
26	CONFIGUR	Shutter	function				
	E 5/6	Open	Set Decl Value in				NO
			0 to 9.99 sec. to		0-9.99	Level 2	
			parameter set 0	Decl	sec		
			to Set value				
			then analog				
			output				
			maximum in				
			Shutter Open				
			function				

Screen Page: CONFIGURE 6/6

CONFIGURE



(1)Press" (1)Press

(2) NowScreen Page: CONFIGURE 6/6 is displayed on screen in first line.

(3)To change the parameter you have to press on the parameter digit.(If you change the parameter for the first time you will want password.)

(4) Alphanumeric Touch Key Pad appears on The Screen. Set required value using 0-9 Numerical Touch keys.

Use INC (+) or DEC (-) key to on or off any function.

(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

The pressure, flow, AN3, AN4 of each function can be locked with these parameters.

CONFIGURE 6/6 page and list of parameter is given below.

HAND			c	ONFIGURE	6/6	03/1	2/201	9 🛣 10	:10:54
	·M	Mold mm 0000.0		Screw mm 000.0	•	Ejector mm 000.0		Ton mm 000.0	
	S	Speed (%)) P	Pres. (bar)	%	AN 3	%	AN 4	

Functions	Speed(%)	Pres.(bar)	AN 3(%)	AN 4(%)
Mold Open	100	100	100	100
Mold Close	100	100	100	100
Ejector	100	100	100	100
Core	100	100	100	100
Mold Height	100	100	100	100
Gate	100	100	100	100
Injection	100	100	100	100
Refill	100	100	100	100
Suckback	100	100	100	100
Carriage	100	100	100	100
Tonnage	100	100	100	100



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		Message			Parameter [Description	n n n	Part Of
Sr	- ···	Of	Function	Parameter	_	•	Operating	Memory
No	Page Name	Parameter	Description	Description	Parameter	Range	Password	N.
		On Screen			Туре		Level	1102
		Undereen		This value				NO
				dofina tha				NO
				define the	D	000 255		
				maximum	Pressure	000-255	Level 3	
				permitted		Bar		
				pressure setting				
				in all mold Open				
				function				
				This value				NO
		Mold		define the				
		Open		maximum	Speed	000%-	Level 3	
1	CONFIGURE			nermitted		100%		
-	6/6			Sneed setting in		100/0		
				all mold Open				
				function				
								NO
				This value				NO
				define the				
				maximum	AN 3	000%-	Level 3	
				permitted AN 3		100%		
				setting in all				
				mold Open				
				function				
				This value				NO
				define the				
				maximum	AN4	000%-	Level 3	
				nermitted $\Delta N A$		100%	Levers	
				cotting in all		10070		
				setting in an				
				function				
				Tunction				
								NO
				dofino tho				NO
				mayimum	Droccuro	000 255		
					Pressure	000-255	Level 3	
				permitted		Bar		
				pressure setting				
				in all Mold				
				closed function				
				This value				NO
				define the				
	CONFIGURE			maximum	Speed	000%-	Level 3	
2	6/6			permitted		100%		
	0/0	Mold		Speed setting in				
		closed		all Mold closed				
				function				
				This value				NO
				define the				
				maximum		000%		
				normittad AN2		1000/0-	LEVELD	
				permitted ANS		100%		

			setting in all Mold closed function			stres	controls.
			This value			mmi	NO
			maximum	AN4	000%-	Level 3	
			permitted AN4		100%		
			setting in all				
			Mold closed				
			function				
			This value				NO
			define the	Dragourg	000 255		
			maximum	Pressure	000-255 Par	Level 3	
			prossure setting		Ddi		
			in all Fiector				
			function		r.		
			This value				NO
			define the				
			maximum	Speed	000%-	Level 3	
		Ejector	permitted		100%		
			Speed setting in				
2	CONFIGURE		all Ejector				
5	6/6		function				
			This value				NO
			define the				
			maximum	AN 3	000%-	Level 3	
			permitted AN 3		100%		
			setting in all				
			Ejector function				
			This value				NO
			define the		000%		
				AN4	100%	Level 5	
			setting in all		10070		
			Fiector function				
			This value				NO
			define the				_
			maximum	Pressure	000-255	Level 3	
			permitted		Bar		
			pressure setting				
			in all Core				
			function				
			This value				NO
4			define the	Crossel	0000/	Louis 2	
	6/6	Coro	maximum	Speed	100%-	Level 3	
		Core	Sneed setting in		100%		
			all Core				
			function				

			This value define the maximum permitted AN3 setting in all Core function	AN 3	000%- 100%	Level 3	NO 2000
			This value define the maximum permitted AN4 setting in all Core function	AN4	000%- 100%	Level 3	NO
			This value define the maximum permitted pressure setting in all Mold Height function	Pressure	000-255 Bar	Level 3	NO
	CONFIGURE	Mold Height	This value define the maximum permitted pressure setting in all Mold	Speed	000%- 100%	Level 3	NO
5	6/6		This value define the maximum permitted AN3 setting in all Mold Height	AN 3	000%- 100%	Level 3	NO
			This value define the maximum permitted AN4 setting in all Mold Height function	AN4	000%- 100%	Level 3	NO
6	CONFIGURE 6/6	Gate	This value define the maximum permitted pressure setting in all Gate function	Pressure	000-255 Bar	Level 3	NO
	5		This value define the maximum permitted Speed setting	Speed	000%- 100%	Level 3	NO

			in all Gate			min	econx
			function			6	-O
			This value			S.T	NO
			define the			mn	1 Juoi
			maximum	AN 3	000%-	Level 3	(1
			permitted AN3		100%		
			' setting in all				
			Gate function				
			This value				NO
			define the				
			maximum	AN4	000%-	Level 3	
			permitted AN4		100%		
			setting in all				
			Gate function				
			This value				NO
			define the				
			maximum	Pressure	000-255	Level 3	
			permitted		Bar		
			pressure setting				
			in all Injection				
			function				
			This value				NO
			define the				
			maximum	Speed	000%-	Level 3	
			permitted		100%		
		Injection	Speed setting in				
			all Injection				
7	CONFIGURE		function				
-	6/6		This value				NO
			define the		0000/		
			maximum	AN 3	000%-	Level 3	
			permitted AN3		100%		
			setting in all				
			function				
			This value				NO
			dofing the				NO
			maximum	A N/4	000%-		
			nermitted AN/		100%	Levers	
			setting in all		10070		
			Injection				
			function				
			This value				NO
			define the				
			maximum	Pressure	000-255	Level 3	
Q	CONFIGURE		permitted		Bar		
0	6/6		pressure setting				
		Refilling	in all Refilling				
			function				
			This value				NO
			define the	Connect	0000/		
			maximum	Speed	000%-	Level 3	
			permitted		100%		

				Speed setting in all Refilling function			stree	ocontols.
				This value define the			4MI	NO
				maximum permitted AN3	AN 3	000%- 100%	Level 3	
				setting in all				
				Refilling				
				Tunction This value				NO
				define the				NO
				maximum	AN4	000%-	Level 3	
				permitted AN4		100%		
				setting in all				
				Refilling				
				function				
				This value				NO
				define the		000 055		
				maximum	Pressure	000-255 Par	Level 3	
				permitted		Ddi		
				in all Suck back				
				function				
				This value				NO
				define the				
				maximum	Speed	000%-	Level 3	
				permitted		100%		
		SUCK DACK		Speed setting in				
	CONFIGURE							
9	6/6			This value				NO
	-, -			define the				
				maximum	AN 3	000%-	Level 3	
				permitted AN3		100%		
				setting in all				
				Suck back				
								NO
				define the				NO
				maximum	AN4	000%-	Level 3	
				permitted AN4		100%		
				setting in all				
				Suck back				
				function				
				inis value				NU
				maximum	Pressure	000-255	level 3	
10	CONFIGURE			permitted	i i coourc	Bar		
-	6/6	50 		pressure setting		-		
				in all Carriage				
				function				

		Carriage	This value define the maximum	Speed	000%-	Level 3	NO NO IS. C
			permitted Speed setting in all Carriage		100%	M	N. WO
			function				
			This value				NO
			define the		000%	Loval 2	
			nermitted AN3	AN 5	100%	Levers	
			setting in all		10070		
			Carriage				
			function				
			This value				NO
			define the				
			maximum	AN4	000%-	Level 3	
			permitted AN4		100%		
			setting in all				
			Carriage				
			function				NO
			define the				NU
			maximum	Pressure	000-255	ا مربوا ع	
			permitted	11035010	Bar		
			pressure setting		201		
			in all Tonnage				
			function				
			This value				NO
			define the				
			maximum	Speed	000%-	Level 3	
		Toppage	permitted		100%		
		Tonnage	Speed setting in				
	CONFIGURE		function				
11	6/6		This value				NO
	0,0		define the				
			maximum	AN 3	000%-	Level 3	
			permitted AN3		100%		
			setting in all				
			Tonnage				
			function				
			This value				NO
			define the	A N / A	000%	Loval 2	
			nermitted AN/	AN4	100%	Levers	
			setting in all		10070		
			Tonnage				
			function				

Page Screen: CALI.AI

The procedure for calibration of analog input is as follows.

- 1. Go to the calibration analog input screen page by pressing "CALI.AI" on Menu Key Bar.
- 2. If you are in another Menu Bar, otherwise pressing "next " or "Previews" key, And go to the "CALLAI"
- 3. So screen appears CALI.ANALOG IP&TEMP. There will be no changes in this screen, for that.
- 4. Go to the CONFIGURE 1/6 page by pressing "CONFIGURE" on Menu key bar.
- 5. Go to the calibration parameter and select CALI AI. (This parameter will be level 3 password protected),
- 6. Going back to the CALI.ANALOG IP&TEMP. Now you can change the parameter.
- Chanel select the function you want to calibrate (for example select "ch 0" for mold).
 For example, the opening stroke of the mold is 500, so we should calibration it.
- 8. now, to select Steps, if 20 steps are selected then 20 steps will come.
- 9. Now close the mold completely, using the mold close function key.
- 10. The value inside the count, which is shown. Put it inside the "actual" in 0 steps, and putting 0000 values inside the "set".
- 11. Now open the mold completely, using the mold open function key.
- 12. The value inside the count, which is shown. Put it inside the "actual" in 19 steps, and putting 500 values inside the "set".
- 13. Now, after inserting the first and last value of steps, press the "Default" key to set the value in between. so all the steps will be organized.

The steps in the middle of the Calibration can also be set one by one according to the different movement of the mold.

- 14. Go to the CONFIGURE 1/6 page by pressing "CONFIGURE" on Menu key bar.
- 15. Go to the calibration parameter and select OFF. (Turn OFF the calibration mode).
- 16. Now check the calibration by mould movement.
- 17. Similarly, the calibration of the screw, ejector can be done by channel number.

	Шн	AND	CA	LI.AN	IALOG IP 8	ТЕМР	03/1	2/2019 🛣	10:10:54	, Uh	HA	ND	CALI.	ANALOG	OUTPU	T 🗰 03/12/20	19 🛣 10:10:54
<		M Sp	old mm 0000.0 peed (%) 100	∕ ■	Screw mm 000.0 Pres. (bar) 060	Ejecto 000 % AN 00	or mm).0 3 0	Ton m 000. % AN 4 000		<	·M S	Mold m 0000.0 Speed (100	^m) /	Screw mn 000.0 Pres. (bar 060	" 📫 ^E	Ejector mm 000.0 AN 3 000 %	Ton mm 000.0 AN 4 000
Ste	ps 2	0	h 00	IP	MC	DLD				Sele	ct Si	tep 1	.1	Default		Pressure	
Stp	S	et	Actual	Stp	Set	Actual	Stp	Set	Actual	Step		%Set		Volt	Step	%Set	Volt
0	000	0.0	1500	7	0184.1	3670	14	0368.2	5840	0		000		00.00	5	050	05.00
1	002	6.3	1810	8	0210.4	3980	15	0394.5	6150	1		010		01.00	6	060	06.00
2	005	2.6	2120	9	0236.7	4249	16	0420.8	6460	2		020		02.00	7	070	07.00
3	007	8.9	2430	10	0263.0	4600	17	0447.1	6770	3		030		03.00	8	080	08.00
4	010)5.0	2740	11	0289.3	4910	18	0473.4	7080	4	L	040		04.00	9	090	09.00
5	013	1.5	3050	12	0315.6	5220	19	0500.0	7403	Selec	t Ch	00	O/P Vo	lt 00.00	10	100	10.00
6	015	57.8	3360	13	0341.9	5530		Count	1502								
	Defau	lt															
				Ten	nperature C	Calibration	1										
Cł	1-0 Ac	tual 1	Temp (01	-08)	177	Gain	0.90	Offset	68								
CI	1-0 Ac	tual 1	Temp (09	-16)		Gain		Offset									
	orm	1							Holp 2	Alore							Holp O
A	tion								Heat —	Actio	n						Heat-
Ŀ]	-))(} ↓	-6		F 🏟 s	~							-5	F 🗘 S

Page Screen: CALI.AO

The procedure for calibration of analog input is as follows.



- 1. Go to the calibration analog output screen page by pressing "CALI.AO" on Menu Key Bar.
- 2. If you are in another Menu Bar, otherwise pressing "next " or "Previews" key, And go to the "CALLAO
- 3. So screen appears CALI.ANALOG OUTPUT. There will be no changes in this screen, for that.
- 4. Go to the CONFIGURE 1/6 page by pressing "CONFIGURE" on Menu key bar.
- 5. Go to the calibration parameter Pressing on this parameter will open the touch keypad with "INC +"key,and select CALI AO. (This parameter will be level 3 password protected),
- 6. Going back to the CALI.ANALOG OUTPUT. Now you can change the parameter.
- Chanel select the function you want to calibrate (for example select "ch 0" for pressure).
 For example, if the machine's pressure is 100, the calibrator will look like this. Take any one function, for example carriage backward.
- 8. now, to select Steps, if 11 steps are selected then 11 steps will come.
- 9. Now perform the carriage backward function using the carriage backward function key.(at parameter value 100)
- 10. The value inside the "O/P voltage", which is shown. Put it inside the "volt" in 10 steps, and putting 000 values inside the "%set".
- 11. Now, after inserting the first and last value of steps, press the "Default" key to set the value in between. so all the steps will be organized.

The steps in the middle of the Calibration can also be set one by one according to the different value of pressure gauge.

- 14. Go to the CONFIGURE 1/6 page by pressing "CONFIGURE" on Menu key bar.
- 15. Go to the calibration parameter and select OFF. (Turn OFF the calibration mode).
- 16. Now check the calibration by function movement.
- 17. Similarly, the calibration of the Speed can be done by channel number.

Page Screen: CALI.TEMP.

Image of this page screen is same as ANALOG IP & TEMP.



- 2. If you are in another Menu Bar, otherwise pressing "next " or "Previews" key, And go to the "Output"
- Insert mili volt generator in zone 1 or link in zone 1(+ and -)of "Temperature section " and set 0 mV in it and verify the actual room temp. in "CH 0 ACT Temp " if not achieved Set " Offset "INC(+) / INC (-)" Key and press "Enter"
- 4. Set 10 mV thru mili volt generator Verify " CH 0 ACT Temp "
- If not achieved the said value (it should be 185*m.v + Room Temperature value) in " CH 0 ACT Temp ", set it in " Gain " Value [To toggle Gain / Offset by Up / Dnarrow key and Set Value by Select(+) / Cancel (-) Keys].
- 6. Once Gain Value set by INC(+) / INC (-) key press Enter for saving the "Gain "Value.
- 7. Press MONITOR touch key to exit CALI.TEMP mode.

Input Status screen

This is the input Status screen, in which you can see which input is on or off.

, the	HA	ND	INF	PUT STATU	IS (1)	03/12	2/2019 🛣	10:10:54						
	·M	Mold m 0000.	um 0 ∤ ∰	Screw mn 000.0	' 🎼 ^E	jector mm 000.0	Ton 1 000	nm .0						
	S	Speed 100	^(%) P	Pres. (bar 060	%	AN 3 000	% AN 000							
VIEV	V	MOD	Ξ											
	Digital Inputs													
0	01 02 03 04 05 06 07 08													
0	9	10	11	12	13	14	15	16						
1	7	18	19	20	21	22	23	24						
2	5	26	27	28	29	30	31	32						
3	33 34		35	36	37	38	39	40						
4	1	42	43	44	45	46	47	48						
4	9	50	51	52	53	54	55	56						
5	57	58	59	60	61	. 62	63	64						
			A	nalog / En	coder Ir	puts								
Al1	(0000	Al2	0000	AI3	0000	Al4	0000						
EI5	(0000	El6	0000	EI7	0000	EI8	0000						
A09		0000	A10	0000	A11	0000	A12	0000						
KEY	(DOFO	ADIE		RPM		FREQ.	3002						
Alarr	n							Help ?						
Actio	on							Heat-						

 N" 		A	ND	IN	PUT ST/	ATUS	(2)		03/12/20	19 🌋	10:10:54
/	•		Mold mm 0000.0		Screw 000.	/ mm .0	1	Ejector 000.0	mm 🚛	Ton mr 000.0	n 🔨
1		5	Speed (%) 100	Ρ	Pres. 060	(bar))	%	AN 3 000	%	AN 4 000	
VIE	W		MODE								
					Dig	jital li	nput	s			
No			Status	;		No		5	Status		
1		Fr	ont Gu	lar	d	14					
2		Ba	ack Gu	ard		15					
3	(Ca	ar Frwro	d E	nd	16					
4	(Ca	r Bkwr	d	End	17					
5	L	.0	cking C)ve	r	18					
6		E	mer Pre	ese	nt	19					
7		С	ore In	End	d	20					
8		С	ore Out	E	nd	21					
9	N	10	ld Ope	n E	Ind	22					
10						23					
11						24					
12						25					
13						26					
Ala	ırm										Help ?
Act	ion										Heat 🛲
										F ¢ s	

The following is how to show the digital inputs.

- 1. Go to the input Status by pressing " NPUT " on Menu Key Bar.
- 2. If you are in another Menu Bar, otherwise pressing "next" or "Previews" key, And go to the "Output"
- 3. So screen appears INPUT STATUS (1), this screen will simply show only digital input numbers only.
- 4. If you see a screen with inputs name please press next page " key on top of the touch screen, so a screen with inputs name will appear, and screen page shows with "INPUT STATUS (2)".
- 5. There is such a thing as input into a machine. Such as proximity switch, limits switch, linear, thermocouples sensor.
- 6. In page screen INPUT STATUS (1) you will see digital inputs number, analog input hex count, key code, Auto diset status, RPM status, thermocouple first zone frequency. This way you can also see "INPUT STATUS (2)" by pressing next page "arrow "key on top of the touch screen and press "down" arrow key to view next inputs.
- 7. Press MONITOR touch key to exit test mode.





• Output Status screen

This is the Output Status screen, in which you can see which output is on or off, and also output on or off one by one in test mode.

	Mold m Mold m 0000.		Screw mm 000.0 Pres. (bar)	US (1)	Ctor mm 000.0	/2019 X Ton 000	10:10:54	** <	HAND OUTPUT S	mm 0	(2) Ejector mm T 000.0 T	10:10:54 on mm 000.0 AN 4
		<u> </u>	060	%	000	000) / %	000 70	000
	NOD		Divital						Dig	ital Out	puts	
			Digital C	Jutputs				No	Status	No	Status	
01	01 02 03 04 05 06 07 08								Hostor 1 Out			
09	10	11	12	13	14	15	16	2	Heater 2 Out	15		
17	18	19	20	21	22	23	24	2	Heater 2 Out	15		
25	26	27	28	29	30	31	32	3	Heater 3 Out	16		
33	34	35	36	37	38	39	40	4	Heater 4 Out	17		
41	. 42	43	44	45	46	47	48	5	Heater 5 Out	18		
	3 50	51	52	53	54	55	56	6	Heater 6 Out	19		
	7 50	50	60	61	62	62	64	7	Heater 7 Out	20		
57	50	23	00	01	02	05	04	8	Heater 8 Out	21		
			Analog	Outputs				9	Mold Close Out	22		
A00	000	A01	000	A02	000	A03	000	10		23		
A04	000	A05	000	A06	000	A07	000	11		24		
A08	000	A09	000					12		25		
								13		26		\sim
Alarm							Help ?	Ala	'n			Help ?
Action							Heat-	Acti	on			Heat-
												F \$ S
MONITOR	MOLD	CORE E	JECTOR TE	MP. CARF	RIAGE SCRE	W FAST SE	TTING NEXT	MONITO	R MOLD CORE EJECTOR	TEMP.	CARRIAGE SCREW FAS	T SETTING NEXT

The following is how to turn on or off the digital and analog outputs



- 1. Go to the Output Status by pressing " on Menu Key Bar.
- 2. If you are in another Menu Bar , otherwise pressing "next " or "Previews" key, And go to the "Output"
- 3. So screen appears OUTPUT STATUS (1), this screen will simply show only digital output numbers only.



- 4. If you see a screen with output name please press next page " Key on top of the touch screen, so a screen with output name will appear, and screen page shows with "OUTPUT STATUS (2)".
- 5. This screen is for viewing outputs only, if you have to output on / off, then pressing on the "view page" will enable "test mode".
- The output can be turned on and off by pressing on the corresponding output number (in OUTPUT STATUS (1) Page) or name (in OUTPUT STATUS (2) Page).
- 7. In this screen you can also see analog output status, and also its turn on manually on test mode by simply press on respective parameter box at that time test mode must be on.
- 8. Press MONITOR touch key to exit test mode.

~

Page Screen: Interlock History





- 1. Press" **INTERLOCK** " key once on the bottom of the Touch Screen.
- 2. NowScreen Page: INTERLOCK HISORY is displayed on screen in first line.
- 3. It shows the interlock history of machine with date and time.

It is a one type of alarm system which activate when cycle or any other function does not operate properly because of those abnormal condition it indicate INTERLOCK



NO	Interlock Message	
00001	Mold is Not Opn Fully	Ľ
00001	03/12/19 10:11:54	
00000	Refill End	
00002	03/12/19 11:10:54	
00003		
00004		
00004		
00005		
00003		
00006		
00008		
00007		
00007		
Alarm	He	elp ?
Action	He	at 🚈
		♪
MONITOR	MOLD CORE EJECTOR TEMP. CARRIAGE SCREW FAST SETTING	NEXT

Following are the different interlock messages.

						9
		Interlocks Messages			Type Of Mo	ode
r.No.	Operation	On Screen	Description Of Messages			Fully
		on screen		Hand	Semi Auto	Auto
		ILMOLD OPEN END.	Mold fully open end	Y	Y	Ŷ
		ILMOLD IS NOT OPEN FULLY	Mold is not fully open		Y	Ŷ
			If both mold open and mold			
	Mold Open	IL.Mold OPN/CLS Limit ON	close input is present	Y	Ŷ	У
		IL_Mold Open Timer Over	Mold Open Total Time Over	у	У	У
		IL_Clamppres switch on	Clamp switch input present	Y	Y	Fully Fully Auto Y
		ILMOLD IS NOT FULLY CLOSED	Mold fully Close end		Y	Y
		ILMOLD SAFETY TIME OVER	Mold Safety time over	Y	Y	Y
		ILMOLD CLOSE TIMER OVER	Mold open close limits on	Y	Y	Fully Fully Y
2	Mold Close	ILLOCKING OVER	Mold is fully close	Y	Y	Y
		ILMOLD CLOSE TIMER OVER	Mold close total time over	Ŷ	Ŷ	Ŷ
		IL Safety Gate Interrupted		Ŷ	Ŷ	v
		IL MCIsSafety Sensor Break		v	· v	V
		IL.UNIT FORWARD FND REACHED	Carriage Forward End	, Y	Y Y	y V
3	Unit Forward		Nozzle guard input present	•	v	y V
			Carriage Backward End	v	y Y	у V
4	Unit Backward	II. Carriage Swivel not at home	Carriage swivel input is	Y	Y	у У
		II. Carriago Swivel Option Op	Option is done ON	v	v	ode Fully Auto Y <
			Temperature is low	T V	I V	r V
5	Injection		Temperature is High	T V	У	ř V
5	injection	IL. Injection End		У	У	ode Fully Auto Y <
				У	У	ode Fully Auto Y <
			Kellil Ella Tomporatura is law	У	У	ř V
6	Refill		Temperature is luich	У	У	ř V
			Cet refilling times	У	У	Y
		IL. refill timer over		Ŷ	Ŷ	Y
-	Cual: Daal:		Temperature is luich	У	У	ř V
/				y 	У	ř V
0				y 	У	Y V
ð	Ejector Forward	IL.EJECTOK FOKWARD END.	Ejector Forward end	У	У	Ŷ
9	Ejector Backward	ILEJECTOR BAKWARD END.	Ejector Backward end	У	У	Y
		ILEJECTOR IS NOT BAKWARD.	Ejector not back	у	у	Y
		ILEJECTOR PLATE BACK IS NOT PRESSED.	Ejector plate is not back	у	У	Y
10	Core in	IL_ mold not in core in position	Mold close position not present for core IN	у	у	Y
11	Core 1 In	IL. CORE 1 IN FND.	Core 1 in End	v	v	Y
			Mold OPN position not	,	7	•
	Core out	IL mold not in core out position	present for core out	У	У	Y
12	Core 1 Out	ILCORE 1 OUT END.	Core 1 out End	v	v	Y
		ILCORE 1 PARTIAL OUT END.	Core 1 not out	v	v	Y
13	Core 2 In	ILCORE 2 IN END.	Core 2 in End	v	v	Ŷ
14	Core 2 Out	ILCORE 2 OUT END.	Core 2 out End	v	y	Y
		ILCORE 2 PARTIAL OUT END.	Core 2 not out	v	v	Y
				1	,	

15	Core 3 In	IL. CORE 3 IN FND.	Core 3 in End	v	v	Yalin	econx
16	Core 3 Out	IL. CORE 3 OUT FND.	Core 3 out End	v	y V	ΰγ	
10		IL CORE 3 PARTIAL OUT END	Core 3 not out	v	y V	TY	
17	Core 4 In	IL.CORF 4 IN FND.	Core 4 in End	v	y V	YMA	n • WO-
18	Core 4 Out	IL.CORE 4 OUT END.	Core 4 out End	v	y V	Y	
		IL CORE 4 PARTIAL OUT END	Core 4 not out	v	y V	Ŷ	
	Mold Height		Mold Height minimum End	y V	y V	Y	
19	Min.	II Mold Height Min	Mold Height minimum	y V	y V	Ŷ	
	Mold Height	IL.MOLD HEIGHT MAXIMUM END.	Mold Height maximum End	v	v	Ŷ	
20	Max.	IL Mold Height Max.	Mold Height maximum	v	v	V	1
		ILTEMPERATURE IS LOW.	Temperature is low	V	v	, v	1
21	Temperature	IL. Thermocouple is open X	If any thermocouple is open	v	v	v	1
		ILTEMPERATURE IS HIGH.	Temperature is High	v	v v	, Ү	1
		ILOIL TEMPERATURE IS HIGH.	Oil temperature is high	v	y V	v	
			If heat key is On during	/	,	,	
		IL. Heat is OFF	injection	Y	Y	У	
22	Robot	IL Robot Time out	If robot function is ON			v	1
		IL Robot Not at Home Position	Robot Not home Position		v	, V	1
		IL Auto Purge Cycles Zero	If purge mode is ON		y V	Ý	1
23	Purge		If Purge mode is ON and		,		1
		IL_Auto Purge Max Tim Over	time is zero		У	У	
			Password 1 from machine	v			
		IL_18001.Contact Supplier	Manuf.	Y			
24	password	II 19002 Contact Supplier	Password 2 from machine	v			
24	passworu	IL_18002.Contact Supplier,	manuf.	T			
		II 18003 Contact Supplier	Password 3 from machine	v			
			Manuf.	У			
		II Auto Die set Fails: 1vl1	During Auto die set if input	v	v	v	
25	Auto Die set		not comes proper	y	У	,	
		IL_AutoDie set Fails:Lvl2		У	У	У	
26	Gate	IL_ Gate Open End	Gate Open End		У	У	
		IL_Gate Close End	Gate Close End		У	У	
		IL_Shutter Gap I/P On.	Shutter gap input is present	у	У	У	
		IL Shutter Close/Open Limit On	If both Shutter opn and				
			close input is present				
		IL_Shutter Not Closed	Shutter Not Close		У	У	
		IL_ Shutter Not Open	Snutter Not Open		У	У	
27	Shutter	IL_Pres Salety IP Operated			У	<u>у</u>	
		IL_Mold clamp Prot IP Present			У	<u>у</u>	
		IL_Mold clamp Prot1 IP Fall			У	<u> </u>	
20	Clida	LWold Clamp Protz IP Fail	Clida in End		у	<u> </u>	
29	Silue	AL Lubricatin Prostow			У	<u>у</u>	
		AL Filling End		У	У	у	
		AL Vari in Analog Vn		у	У	M	
		AL HeaterCurrent Card Abcent		v	У	<u>у</u>	
30	Alarm	AL Heater Current Low		y v	У	<u>у</u>	1
30		AL Heater/SSR Fail		y V	y V	<u>у</u>	4
				y V	y V	<u>у</u> У	1
				y V	y V	<u>у</u> У	
				y V	y V	<u>у</u> У	
				У	У	у	J

				у	у	Xalin	econz
		Al. Hopper Is Empty	Hopper input is present	У	У	©y	0
		Al. Lubrication Oil Level Lo	Lubrication level input present	у	У	YN WN	1.00
		ILFRONT GUARD OPEN.	Front door open	у	У	У	
		ILBACK GUARD OPEN.	Rear door open	у	У	у	
		ILTOTAL CYCLE TIME OVER.	Cycle time over	у	Y	у	
31	Common	ILEMERGENCY / MOTOR NOT AT DELTA.	Emergency press	у	у	У	
		ILHYDRAULIC MOTOR NOT AT DELTA.	Hydraulic motor not on Delta	у	У	У	
		IL _Single Phase Prevent On	Single phase input present	У	y	У	
		IL_ Oil Filter Clogged	Oil filter input present	У	у	У	
		IL _Lubrication .Motor Feedback Fail		У	У	У	
		IL _Batch Count Over	Set Batch reached	у	у	у	
		IL _Lock Cylinder Over Stork		у	у	У	
		IL_ 'Piece Fall Error!	Piece fall input not comes		у	у	
				y	У	у	

Page Screen: Hourly Production





- 1. Press" HOURLY " key once on the bottom of the Touch Screen.
- 2. NowScreen Page: HOURLY PRODUCTION is displayed on screen in first line.
- 3. In this page hourly production shows of 24 hours, current hours shots show differently in this page.

		HA	ND	н	OUF	RLY PRO	DDU	CTION	03	12/20	019 🛣	10:10:54
		·M	Mold	mm		Screw	mm D	1 E.	jector mr	n	Ton mm	
	$\boldsymbol{\leq}$	S	Speed	d (%)	Р	Pres. (bar)	%	AN 3	%	AN 4	
		_	10	0	-	060			000	1.0	000	
	No		Dat	e		Hour	F	Pcs	Bad P	cs	Kwh	
	0000	01	03/12	2/19	1	1:00	0	001	0000			
	0000	00	03/12	2/19	1	1:00	0	001	0000			
		- 4 - 12			02			T -	tel De d I][
		otali	zer						ital Bad I	'cs		
	Curr	ent l	Hrs	000		Bad P	'cs				Kwh	
9	Alar	m									ŀ	lelp ?
	Acti	on									ŀ	leat 🚈
		1	ul	Π	ТÌГ	al II		1	v ll	~		
				\land			1		-0 1	< <u>ům</u>	F D S	•
	MONITOR	2	MOLD	CORE	1	EJECTOR	TEM	P. CA	RRIAGE S	CREW	FAST SETTIN	IG NEXT

STREAMLINE CONTROLS PVT.LTD.

INJKon Rainbow X Manual

Page Screen: Daily Production





- 4. Press" HOURLY key once on the bottom of the Touch Screen.
- 5. NowScreen Page: **DAILY PRODUCTION** is displayed on screen in first line.
- 6. In this page whole day production shows of 30 days. Current day's production shows separately.

1	HA	ND	DAII		τιον	03/1	12/20 ⁻	19 🛣 10	:10:54
/	M	Mold mm 0000.0	י ל	Screw mm 000.0	1	Ejector mm 000.0	-	Ton mm 000.0	$\overline{\mathbf{x}}$
<u> </u>	S	Speed (% 100	⁶⁾ P	Pres. (bar) 060	%	AN 3 000	%	AN 4 000	

[No.	Date	•	Time	Pc	s	Bad Pcs	Kwh		
[00001	03/12	/19	00:00	000	2				
			=						_	
			=						- 1	
									- 1	
Ĺ									- 1	
										1
	Totali	zer	000	2		Tota	al Bad Pcs			
	Current I	Hrs 00	000	Bad F	Pcs			Kwh		
Г	Alarm								Help ?	5
	Action								Heat -	20
		-M		I	ļ		6	F 🎝 S		1
	MONITOR	MOLD	CORE	EJECTOR	TEMP.	CAR	RIAGE SCREW	FAST SET	TING NEXT	
				-						

Page Screen: Shot Monitor





- 1. Press" SHOT MON. " key once on the bottom of the Touch Screen.
- 2. NowScreen Page: SHOT MONITOR (1) is displayed on screen in first line.
- 3. Previous Shot (Injection Start, Injection End, Refilling Start, Mold open End) Position in xxx.mm Show in Page.



- 4. Press" key once on the top of the Touch Screen.
- 5. NowScreen Page: SHOT MONITOR (2) is displayed on screen in first line.
- 6. Previous Shot (Injection, Refilling, Mold closed, Safety, Mold open, PcOut) Total Cycle time show in Page.

	HA	ND	SH	ΟΤ ΜΟΝΙΤΟ	R (1))	12/20 ⁻	19 🛣 10	:10:54
	·N	Mold mm 0000.0)	Screw mm 000.0	4	Ejector mm 000.0		Ton mm 000.0	
<u> </u>	S	Speed (% 100	⁶⁾ P	Pres. (bar) 060	%	AN 3 000	%	AN 4 000	

Position (mm)									
No	Injection Start	Injection End	Refill Start	Mold Open End					
1	000.0	000.0	000.0	000.0					
2	000.0	000.0	000.0	000.0					
3	000.0	000.0	000.0	000.0					
4	000.0	000.0	000.0	000.0					
5	000.0	000.0	000.0	000.0					
6	000.0	000.0	000.0	000.0					
7	000.0	000.0	000.0	000.0					
8	000.0	000.0	000.0	000.0					
9	000.0	000.0	000.0	000.0					
10	000.0	000.0	000.0	000.0					

	HA	ND	SHOT MONITOR (2)			03/1	03/12/2019 🔀 10:10:54			
<	M	Mold mn 0000.0	n (Screw mm 000.0	4	Ejector mm 000.0		Ton mm 000.0		
	S	Speed (% 100	^{%)} P	Pres. (bar) 060	%	AN 3 000	%	AN 4 000		

Time (Sec)										
No	Injection	Refill	M.Close	M.Safety	M.Open	Pcs Out	Cy Time			
1	000.0	000.0	000.0	000.0	000.0	000.0	000.0			
2	000.0	000.0	000.0	000.0	000.0	000.0	000.0			
3	000.0	000.0	000.0	000.0	000.0	000.0	000.0			
4	000.0	000.0	000.0	000.0	000.0	000.0	000.0			
5	000.0	000.0	000.0	000.0	000.0	000.0	000.0			
6	000.0	000.0	000.0	000.0	000.0	000.0	000.0			
7	000.0	000.0	000.0	000.0	000.0	000.0	000.0			
8	000.0	000.0	000.0	000.0	000.0	000.0	000.0			
9	000.0	000.0	000.0	000.0	000.0	000.0	000.0			
10	000.0	000.0	000.0	000.0	0.000	000.0	000.0			





Page Screen: Memory



Press" key once on the bottom of the Touch Screen. NowScreen Page: **MEMORY** is displayed on screen in first line.

This is a mold memory setting screen page.

	MEMORY III 03/12/2019 X 10:10	:54
	Mold mm Screw mm Ejector mm Ton mm 0000.0 Image: Screw mm Image: Screw mm	>
Paste	File System File Read Esc	
	File Type	
Index	Sequence File Name	
001	Recipe (0).xls	- "
	Recipe (1).xls	
Alarm Action	Help Heat	?
	LD CORE EJECTOR TEMP. CARRIAGE SCREW FAST SETTING NE	X T




	Recipe (0).xls										
ſ	1	2	3 %	4	5	6 &	7	8	9 #	0=	
	Q	W	E	R	Т	Y	U	Ι	0	Р	
	Α	S	D	F	G	Н	J	к	L	:	+
	Z	X	С	V	В	N	М	,		-	
	E	SC	SH	IFT †		SP	ACE		•	ENTER	2

- 1. Go to mold memory setting page by pressing "MEMORY" on Menu Key Bar.
- 2. If you are in another Menu Bar, otherwise pressing "next" or "Previews" key, And go to the "MEMORY"
- 3. So screen appears MEMORY is displayed on screen in first line.
- 4. Now press the "System File Read" key to save the mold that is currently running.
- 5. Now a keypad like "Are you sure want load this file to system? (Image 4)" Will open. Press "Yes" to open it.
- 6. So "Recipe (0)" default mold memory name will appear on the screen.
- 7. Now pressing "Recipe (0)" opens a keypad like this (image 3), in which to press "RENAME".
- 8. So keyboard like this (image 5) will appear on the screen, now type the name of the mold, then presses enter.
- 9. Now the name of the mold memory will appear on the screen. All the molds can be saved as follows.
- 10. You can copy, paste, delete, and load the mold memory by pressing it on the mold memory name and using the keypad option as in image 3.

Page Screen: USB





🗏 HANI		USB	03	/12/2019 🛣 1	10:10:54
- M N	/lold mm 0000.0	Screw mm 000.0	Ejector mi	m Ton mm 000.0	
S S	peed (%) 100 P	Pres. (bar) 060	% AN 3 000	% AN 4 000	
		Sustam Fil	- Deed		
Paste	File	System Fil	e Read	ESC	
USB Status	Conne	cted	File Type		
Index		Sequenc	e File Name		
001	IC100100	0001			
002	IC100100	0002			
					1
					j
Alarm				H	elp ?
Action				H	leat-



Page Screen: INDEX





Press" key once on the bottom of the Touch Screen. NowScreen Page: **INDEX** is displayed on screen in first line. This is the index screen page. You can see a list of all screen pages here.

	INDEX 🗰 🔀	
Y PG DN		PG UP
NO.	Function Page	
1	About Us	
2	Index	
3	Calibration Analog Inputs & Temperature	
4	Calibration Analog Outputs	
5	Input Status (2)	
6	Output Status (2)	
7	Interlock History	
8	Hourly Production	
9	Daily Production	
10	Shot Monitor (2)	
11	Monitor	
12	Mold (5)	
13	Core (3)	
14	Ejector (2)	
15	Screw (5)	
16	Temperature (4)	
17	Carriage (2)	
18	Fast Setting	
19	Memory	
20	Configure (6)	
21	Robot	
22	USB	
23	Program Data	
24	Brightness	

Page Screen: ABOUT US



• Start up screen page

This is the Start up screen, when you first turn on the power of plc this screen first appears. You can also see this screen by pressing "about us" touch key.

In this screen you can see company information, customer care mobile number, Version Code, Machine Sequence Code and OEM information.

4	🐓 Streamlin	e Controls F	Private Limite	d
Strea	INJKo amline Controls Priv	on Manufacture ate Limited Gar	d By ndhinagar,Gujarat	,India
	For PLC Con	nplaint/Repairs	Contact :	
-	Version Code :	. 9526606005/	932000009	
	Sequence Code :			
		OEM Details		

Page Screen: PROG. DATA

This is the Program data changes list screen,

Alarm Action

MONITOR

MOLD

CORE

EJECTOR

In this page you can see the list of parameter changes. For example, let's take a parameter like 100 in the temperature zone 1, now we save 200, so the first parameter is 100 and the current parameter is 200.

^{II}) H	AND	PROGRAM	DATA 🛗 03	3/12/2019 🛣 1	0:1
	Mold mm 0000.0	Screw m 000.0	m 🥵 Ejector m 000.0	m Ton mm 000.0	
S	Speed (%) 100	P Pres. (ba	r) % AN 3 000	% AN 4 000	
		Deserver	Dete		
		Program	Data		
No	Previous Dat	ta Current Da	ta Date	Time	
					Ĩ.
	<u> </u>				
]
					1
					1
					1

TEMP.

CARRIAGE

Help ?

Heat-

NEXT

SCREW FAST SETTING

MMM .W

Page Screen: BRIGHTNESS

This is the brightness setting page. In which you can change the brightness of the lcd. It is as follows.

Increasing the lcd's brightness by pressing the "+" touch key. Decreasing the lcd's brightness by pressing the "-" touch key.



(L) FUNCTIONAL DESCRIPTIONS:

(1) Mold Safety:

n (In case of LS type

At the time of mould closing if the delay between mold safety1 position & mold safety2 position (In case of LS type selection mold safety start switch & mold safety end switch) is more than the set value of mould safety timer the cycle brakes here mould gets opened and machine comes into hand mode.

(2) Heat On function:

Heating on function can be enabled or disabled using **HEAT ON**, key. When heating on is active **HEATON** indicate in display. And all output of heater goes ON. When heating **ON** is indicate in display all heater outputs operate as per control action of temperature controller.

(3) HAND:

System (after power on) starts in HAND MODE. In this mode all the functions (like mould open, mould close, unit forward etc) can be done using different function keys.

For ex. :Mould can be opened using mould open key. When any interlock appears during cycle the machine transferred in to hand mode.

(4) SEMI AUTO:

On pressing SEMI AUTO key cycle starts.

Cycle stops after completion of one cycle. Here cycle can be restarted by opening and closing of front guard.

(5) AUTO:

On pressing **AUTO** key the auto cycle starts.

Here after completion of one cycle, cycle delay timer starts after completion of **cycle delay** cycle restarts.

(6) DIE SET:

On Pressing DIESET Key the Only work DIESET Mode.

(7) PURGE:

On Pressing **PURGE**Key the Work SEMI & AUTO cycle.

(M)DIMENSION DRAWING

:

mmi Dimension drawing











1000

Wiring Diagaram: Below is an example of how to do wiring.

(View Digital output name, digital input name, analog input name, analog output name and thermocouple input name according to programming sequence code.)



OUR PRODUCT RANGE

- Dedicated Controller for Plastic Injection molding Machines
- Dedicated Controller For Blow Molding Machine
- Dedicated Controller For Pet Stretch Molding Machine
- Dedicated Controller For Hopper Loader
- AC Servo Motor Drive
- DC Stepper Drive
- Dedicated Controller For Bag Making Machine
- Dedicated Controller For Sticker Labeling Machine
- Dedicated Controller For Grinding Machine
- Dedicated Controller For Dozing Application
- Dedicated Controller For Pad Printing Machine
- Dedicated Controller For Jet Dyeing Machine
- Application Specific Packages
- All Servo Pick & Place Robot For IMM
- Time/Temperature Based Profile Generator
- Multi Channel Temperature Controller
- 2/3/4 Axes Motion Controllers (Using DC stepper / AC Servo Drives).

AUTOMATION... PRODUCTIVITY THROUGH TECHNOLOGY

