OPERATING MANUAL FOR CONTROL SYSTEM OF INJECTION MOLDING MACHINE

INJkon SC12

INJkon 11/1.0

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 later usage and maintenance of control system, detail study of this operating manual will be recommended.

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.
SCPL strongly 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 to disconnection 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>સુરક્ષા માર્ગદર્શિકા</u>

ઇન્જેક્શન મોલ્ડિંગ મશીન ના ઘણા ઓપરેશન માં ઇન્ટરલોક પરિસ્થિતિવખતે સુરક્ષા માટે પી.એલ.સી ના હાર્ડવેર તથા સોફ્ટવેર બનાવવામાં ઘણી કાળજી રાખવા છતાં કોઈપણ મશીન પાર્ટ્સ અથવા / અને માણસ ને લગતા નુકશાન ના અમો સ્ટ્રીમ લાઈન કંટ્રોલ્સ પ્રાઇવેટ લિમિટેડ જવાબદાર નથી. તેના માટે અમોમશીનબનાવવા તથા ચલાવવા માટે ના સુરક્ષા નિયમો નો અમલ થાય તેની સખત ભલામણ કરીએ છીએ.

SCPL નીચેના સુરક્ષા નિયમો નો કડક અમલ થાય તેની સખત ભલામણ કરેછે.

૧.જયારે માણસ અથવા તો તેના શરીર નો કોઈ પણ ભાગ ચાલુ ઇન્જેકશન મશીન માં વચ્ચે આવવા જતો હોય ત્યારે બધા જ ઈલેક્ટ્રીકલ , મીકેનીકલ તથા હાઈડ્રોલીક ઉર્જા સ્ત્રોત બંધ થઇ જવા જોઈએ.

૨. મશીનનાહલન ચલન થતાં પુર્જાજેમ કે મોલ્ડ ક્લોઝ દરવાજા થી ઢાંકેલા હોવા જ જોઈએ.

SCPLની કોઈ પણ પી એલ સી આગળતથા પાછળ ના દરવાજાની સ્થિતિ ને મોલ્ડ ક્લોઝ ઓપરેશન દરમિયાન સતત ચકાસણી કરેછે.

દરવાજા ખુલ્લા હોવા ની સ્થિતિ માં મોલ્ડક્લોઝ દરમિયાન પી.એલ.સી ની ચકાસણી ઉપરાંત ઈલેક્ટ્રીકલ તથા હાઈડ્રોલીક ઉર્જા સ્ત્રોત બંધ થાય તે મુજબ ની વ્યવસ્થા અચૂક કરવી જોઈએ.

૩. જે મશીન (વર્ટીકલ ઇન્જેક્શન મોલ્ડિંગ મશીન) જાણી જોઈ ને જરાપણઅથવા નહીવત સુરક્ષા પ્રમાણે, એટલે કે આગળ/ પાછળ દરવાજા વગર બનાવેલ હોય તેની અમો SCPL હિમાયત કરતા નથી, તેમ છતાં તેવામશીન માટે અમોનીચે દર્શાવેલ સુરક્ષા વિષયક કડક સૂચનો નો અમલ કરવા ની ભલામણ કરીએ છીએ.

- SCPLસાઇકલ સ્ટાર્ટ ઈનપુટ તરીકે ઇલેક્ટ્રિકલ N/C કોન્ટેક્ટકદીનહિ વાપરવા ની સલાહ આપે છે.
- સેમી ઓટો મોડ માં, N/C કોન્ટેક્ટ ના ખામીયુકત કાર્ય થી ફરીથી નવી સાઇકલ શરુ થઇ જવાની સંભાવના રહેલી છે. જેમકે મોલ્ડ ક્લોઝ થવો ., કે જે દરવાજા વગર ના મશીન માં મોટો જીવલેણ અકસ્માત કરાવી શકે છે.
- SCPL બે સાઇકલ સ્ટાર્ટ પુશ બટન કે જેમાં N/O કોન્ટેક્ટ વાપરેલ હોય તથા તે બંનેસીરીઝમાં આગળ ના દરવાજા ના પી.એલ.સી ઈનપુટ માં લગાવેલ હોવા જોઈએ તેવું સુચન કરે છે , જેથી મશીન ઓપરેટર ને બંને સાઇકલ સ્ટાર્ટ પુશ બટન મોલ્ડ ક્લોઝ થાય નહિ ત્યાં સુધી દબાવી રાખવા પડશે જેથી જીવલેણ અકસ્માત થવા ની સંભાવના નિવારી શકાય છે.

૪. SCPLપ્રકાશ ના પડદા વાળા સેન્સર (Light Curtain) વાપરવા ની સલાહ આપે છે, જે પી.એલ.સી ના ઈમરજન્સી કોન્ટેક્ટ અથવા તો ઓટો સાઇકલ બ્રેક ઈનપુટ સાથે કનેકટ કરી શકાય છે. જે મશીન ઓપરેટર ના શરીર ના કોઈપણ અંગપ્રકાશ ના પડદા વાળા સેન્સર (Light Curtain) ના વિસ્તાર માં અવતાજ મોલ્ડ ક્લોઝ ઓપરેશન ને બંધ કરી દે છે.

૫. અમે હાઇડ્રોલિકડમ્પ વાલ્વ કે જે મોલ્ડ ક્લોઝ ના વાલ્વ ની સીરીઝ માં લગાવવા થી મળતી સુરક્ષા ની પણ ભલામણ કરીએ છીએ. ઓપન ગાર્ડ અથવા અલગ થી મુકેલ Foot સ્વીચ(પગ વડે દબાવવા ની સ્વીચ) ને ડમ્પ વાલ્વ સાથે લગાવવા થી સુરક્ષા ની જરૂરીયાત વખતે મોલ્ડ ક્લોઝ રોકી શકાય છે.

૬. ઈમરજન્સી પુશ બટન ને મશીન માં એક અથવા એક કરતા વધારે જગ્યા એ લગાવવા થી ઓપરેટર તેની અકસ્માત સમય ની સ્થિતિ માં જલ્દી થી તેને દબાવી ને મશીન રોકી શકે છે.ફરી વખત SCPL પી.એલ.સી દ્વારા મળતી સુરક્ષા ઉપરાંત ઈલેક્ટ્રીકલ જોડાણ કાપવા ની ભલામણ કરે છે.

૭. ફક્ત કુશળ તથા તાલીમબદ્ધ માણસો ને જ મશીન તથા પી.એલ.સી ને ઓપરેટ કરવા દેવા કે જેઓ મશીન તથા પી.એલ.સી ના સંચાલન ને લગતા જોખમ તથા તેને લગતી સુરક્ષા જરૂરીયાત થી વાકેફ હોય.

સેમી ઓટો મોડની કામગીરી વખતે ઓપરેટરે ક્યારેપણ સરેરાશ કામ ના કલાકો ઉપરાંત રાતપાળી તથા ખરાબ પ્રકાશ ની સ્થિતિ માં સતત કામ કરવા નું સલાહ ભર્યું નથી.

CONTENTS

(L)	**FUNCTIONAL DESCRIPTION OF:**	
	(1)	**MOLD SAFETY**
	(2)	**HEAT ON FUNCTION**
	(3)	**HAND**
	(4)	**SEMI AUTO**
	(5)	**FULLY AUTO**
	(6)	**DIESET**
	(7)	**PURGE**
(M)	**DIMENSION DRAWING:**	
(N)	**WIRING DIAGRAM:**	

(A) SPECIFICATIONS:

Input	
Power:	
Voltage	24 V DC ± 1%
Control:	
Thermocouple	J / K type Isolated
Proximity/ Limit Switches	NPN (NO type)
	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

(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 to Combi Card via 15 core 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 Space than 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 moving Parts, so periodical maintenance is drastically reduced and there for reliability is definitely improved. Function like suck back 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 E^2PROM 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.
- Three different operating programs for Hydraulic Ejector operations provide to suit the operational needs With various molds.

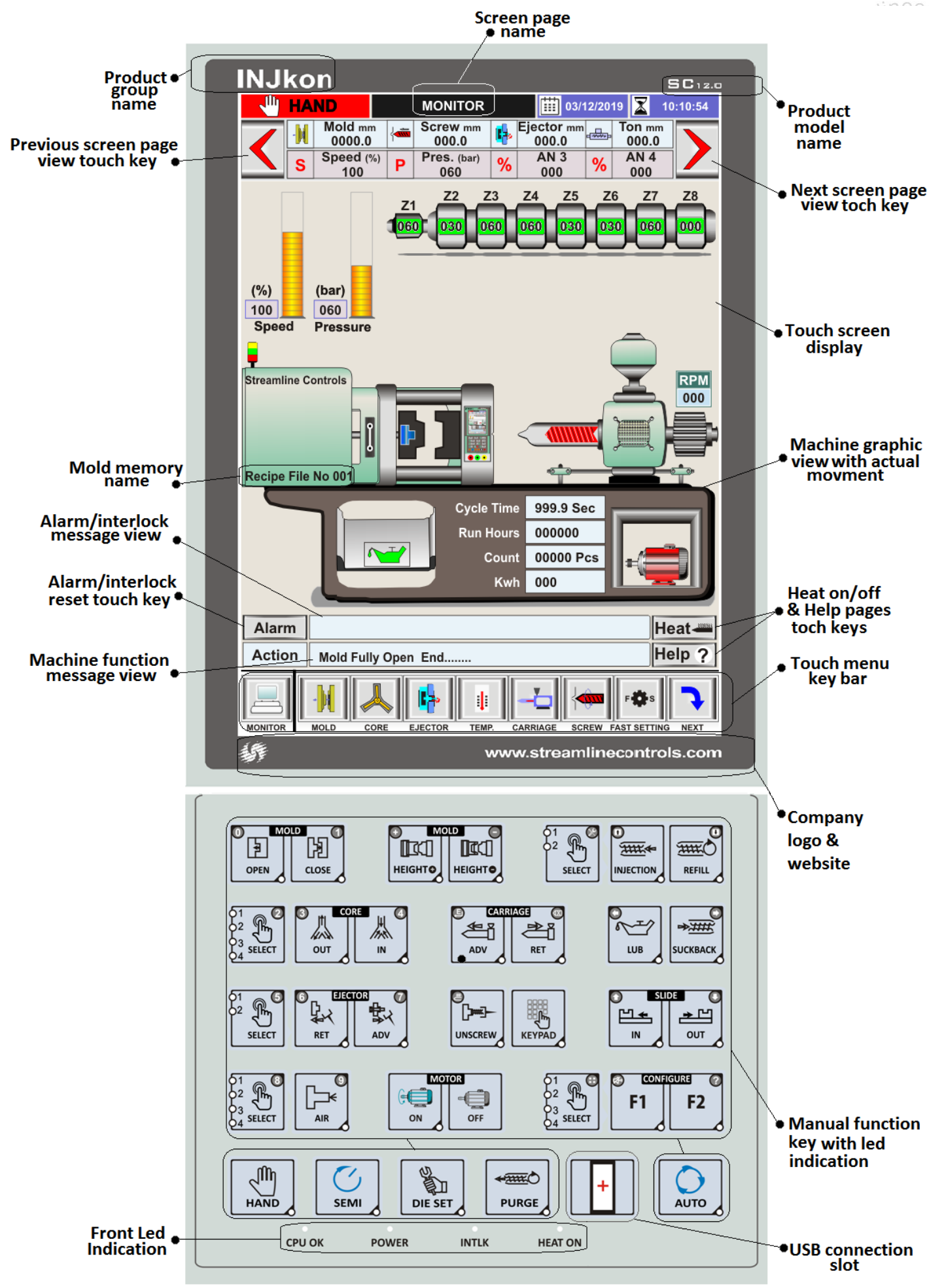
- Provide 3 Core operation and all of 3 cores are independently work as per select operating mode in Core IN & OUT function.
- Four different operating programs for Air Ejector operations provide to suit the operational needs with various molds.
- Thermocouple "Open" & "Reverse" conditions are self detected 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

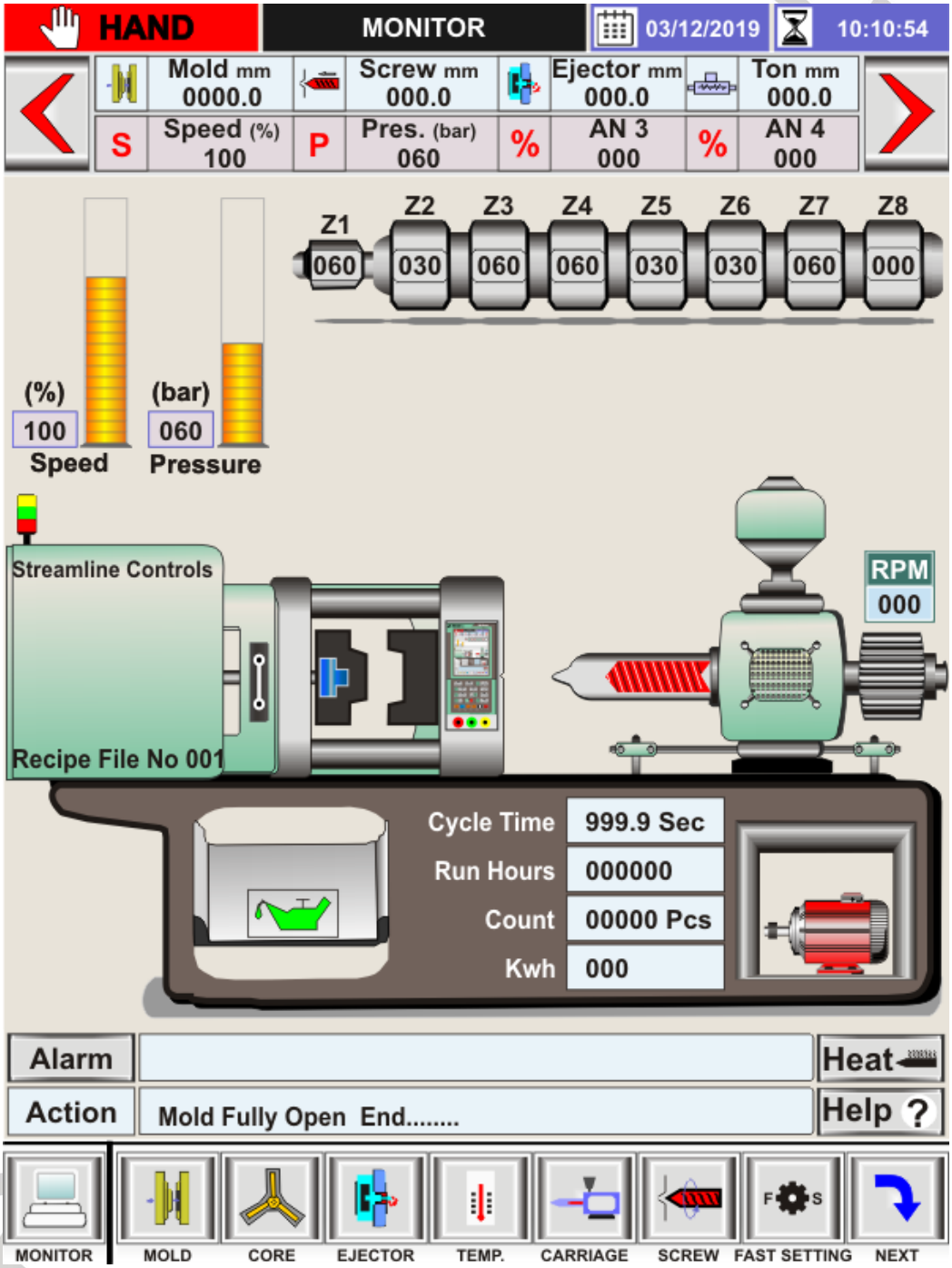
The PLC Controller will be programmed as per given Input output List / Sequence of the Injection Molding Machine.


Screen page name
Product group name
Previous screen page view touch key
Product model name
Next screen page view toch key
Touch screen display
Machine graphic view with actual movment
Mold memory name
Alarm/interlock message view
Alarm/interlock reset touch key
Heat on/off & Help pages toch keys
Machine function message view
Touch menu key bar
Company logo & website
Manual function key with led indication
Front Led Indication
USB connection slot
INJkon
SC 12.0
HAND
MONITOR
03/12/2019
10:10:54
Mold mm 0000.0
Screw mm 000.0
Ejector mm 000.0
Ton mm 000.0
Speed (%) 100
Pres. (bar) 060
AN 3 000
AN 4 000
Z1 Z2 Z3 Z4 Z5 Z6 Z7 Z8
060 030 060 060 030 030 060 000
(%) 100 Speed
(bar) 060 Pressure
Streamline Controls
RPM 000
Recipe File No 001
Cycle Time 999.9 Sec
Run Hours 000000
Count 00000 Pcs
Kwh 000
Alarm
Heat
Action
Mold Fully Open End.....
Help ?
MONITOR MOLD CORE EJECTOR TEMP. CARRIAGE SCREW FAST SETTING NEXT
www.streamlinecontrols.com
MOLD OPEN CLOSE
MOLD HEIGHT HEIGHT
SELECT INJECTION REFILL
CORE OUT IN
CARRIAGE ADV RET
LUB SUCKBACK
EJECTOR RET ADV
UNSCREW KEYPAD
SLIDE IN OUT
AIR
MOTOR ON OFF
CONFIGURE F1 F2
HAND SEMI DIE SET PURGE AUTO
CPU OK POWER INTLK HEAT ON

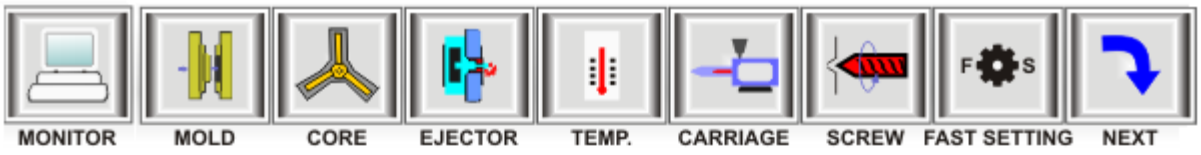
(F) OPERATING PANEL DESCRIPTION

Screen Page : MONITOR

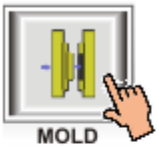
This is the monitor screen , it will come up after the startup screen. In this screen you can see the movement of the machine in graphic form, Also, you can see the actual position of the machine (in mm), the mold memory name, the actual graphic motion of the speed and pressure, motor on off indication,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



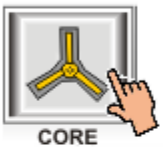
- **Touch menu key bar**
  This is the touch menu bar where you can see the different touch keys, this menu key contains a parameter corresponding to the function, and the information for each key is as follows.



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

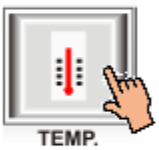


Press the "MOLD"Key at the bottom of the touch screen.
The MOLD Page screen appears.

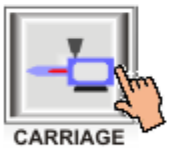


Press the "CORE"Key at the bottom of the touch screen.
The CORE Page screen appears.

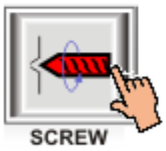
Press the "EJECTOR"Key at the bottom of the touch screen.
The EJECTOR Page screen appears.



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

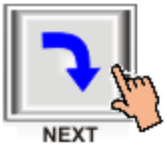


Press the "CARRIAGE"Key at the bottom of the touch screen.
The CARRIAGE Page screen appears.



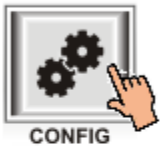
Press the "SCREW"Key at the bottom of the touch screen.
The SCREW Page screen appears.

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.

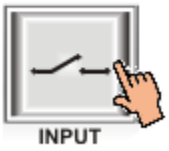


Press the "CONFIG"Key at the bottom of the touch screen.
The CONFIG Page screen appears.

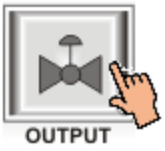
Press the "CALI.AI"Key at the bottom of the touch screen.
The CALI.AI Page screen appears.

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.

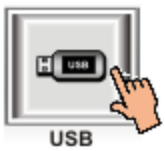
Press the "INTERLOCK"Key at the bottom of the touch screen.
The INTERLOCK Page screen appears.

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.

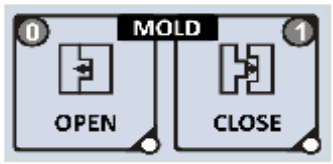
Press the Alarm Key At the bottom of the page screen.
To Reset the alarm

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

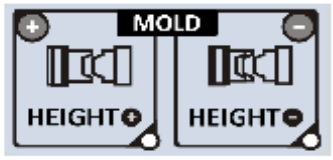
Press the Healp Key At the bottom of the page screen.
The Help Page Screen appears.

- **Manual key**

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



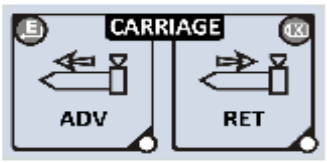
Mold Open Key
Push for activate of mold opening action manually.
Mold Close key
Push for activate of mold clamping action manually.



Mold Height + Key
Push for activate of Mold Height + action manually.
Mold Height - Key
Push for activate of Mold Height - action manually.

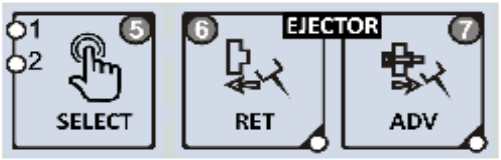
Injection Refill 1,2 Option Key
Push for activate of Injection 1,2 action manually.
Push for activate of Reffil 1,2, action manually.

Core In 1,2,3,4 Option Key
Push for activate of Core In 1,2,3,4 action manually.
Push for activate of Core Out 1,2,3,4 action manually.

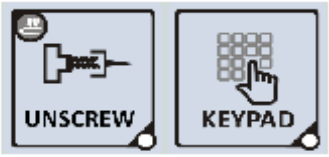


Carrage Forward Key
Push for activate of Carrage forward action manually.
Carrage Backward Key
Push for activate of Carrage Backward action manually.

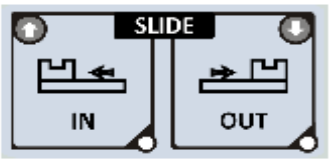
Lubrication Key
Push for activate of Lubrication action manually.
Suckback Key
Push for activate of Suckback action manually.



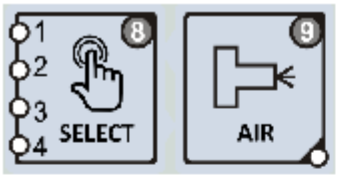
Ejectior forward Option Key
Push for activate of Ejector forward 1,2 action manually.
Ejectior backward Option Key
Push for activate of Ejector backward 1,2 action manually.



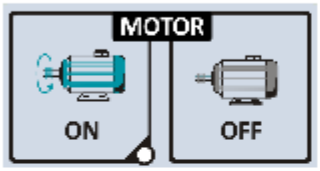
Unscrew Key
Push for activate of Unscrew action manually.
Kepad Key
Push for activate of Keypad action manually.



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.

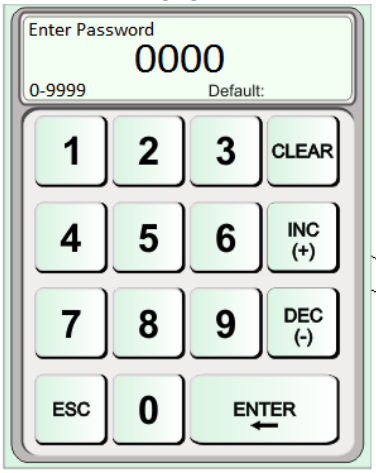
Auto Key
Operate machine in fully automatic production mode.
To be Operate AUTO DIESET function in Die Set mode.

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

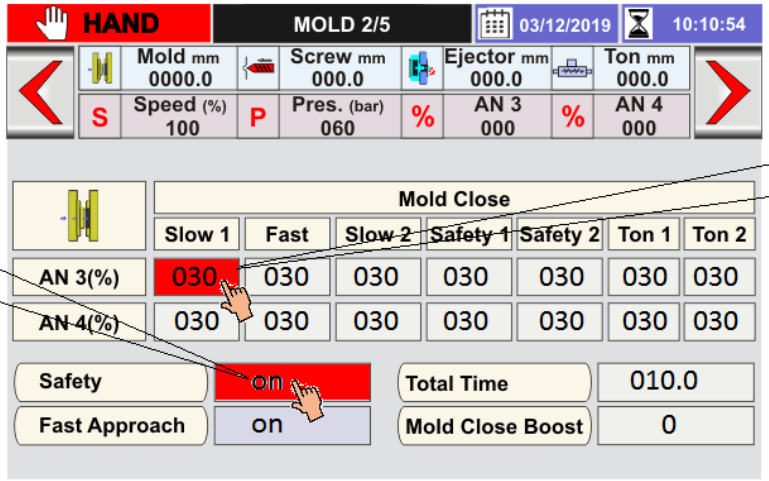
The information of mmi front led indication is as follows.

POWER: Which indicates that power has reached the mmi circuit.
CPU OK: Which Indicates that the circuit of mmi is working properly.
INTLK: The interlock led will turn on when the machine cycle or any function is not working properly.
HEAT ON: Which Indicates when heating is turned on.

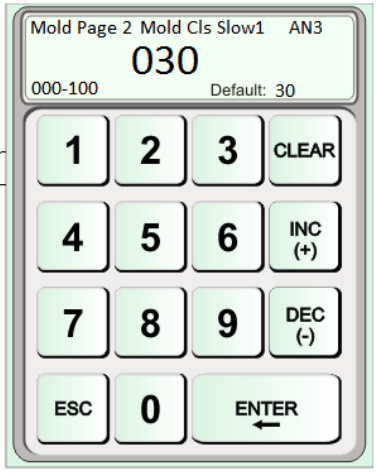
(1)



(2)



(3)



The following is the information on how to change the parameter in the screen page.

1. When you press on a parameter, the parameter box will turn red, and a small numeric keypad will open. 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?
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	Airjet 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

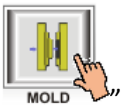
(H) Precautions to prevent damage from human and machine, we recommend to strictly obey the following safety procedures.

- 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 10 seconds 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 1of 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

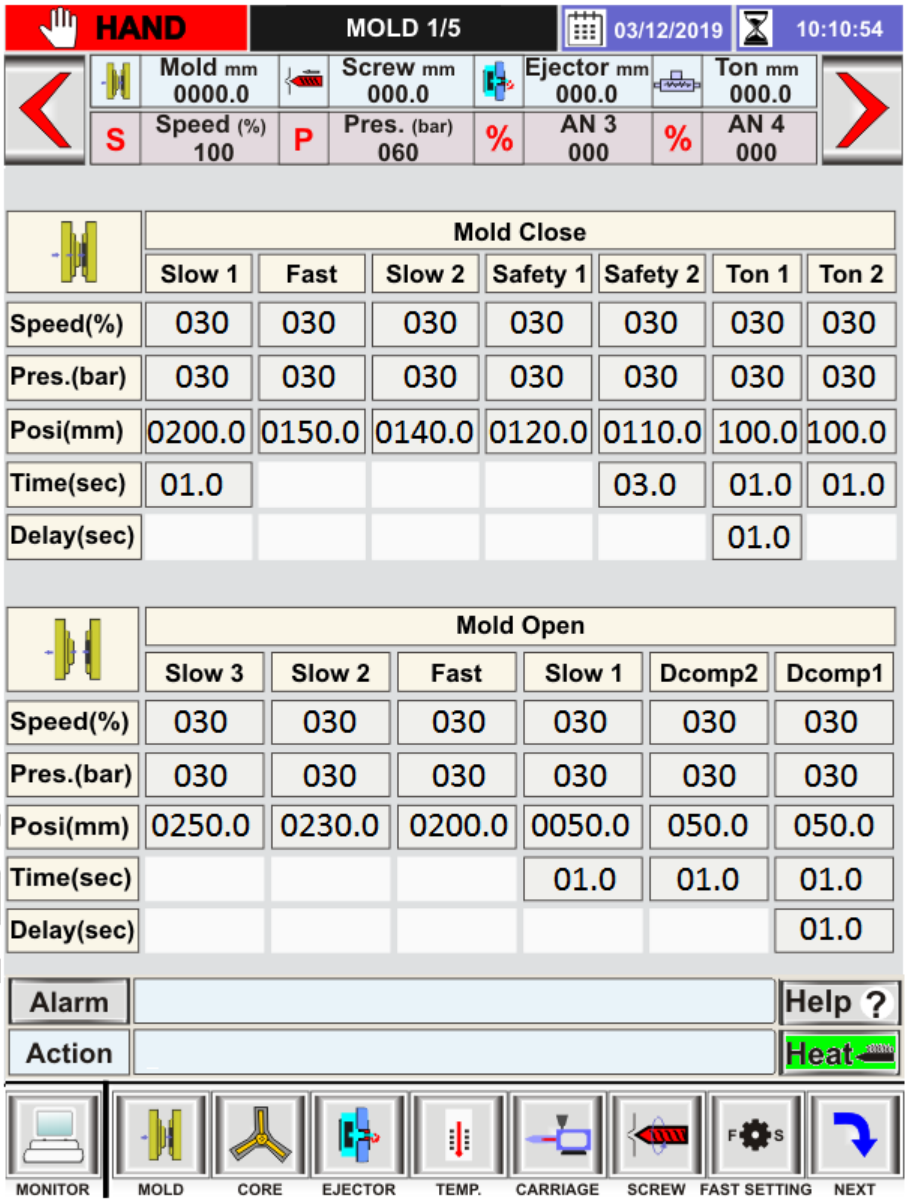
Screen Page: MOLD 1/5

MOLD

(1)Press" 

" key once on the bottom of the Touch Screen.
(2) Now Screen 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.



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	MOLD 1/5	Close Slow1	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
				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
2	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
				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
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 over operating position.	Position	0000.0 – 2000.0mm	User	Yes
				Set Close Slow2 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Close Slow2 function operating Speed proportional output	Speed	000% – 100%	User	Yes

				Set Mold close Safety 1 function over operating position.	Position	0000.0 – 2000.0mm	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 Close Safety 1 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Close Safety 1 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				Set Close Safety 2 function over operating position.	Position	0000.0 – 2000.0mm	User	Yes
5	MOLD 1/5	Safety2 End		Set Close Safety 2 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Close Safety 2 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				Set Close Safety function operating time.	Time	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

				Set locking tonnage 1 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
	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
7	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
				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

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

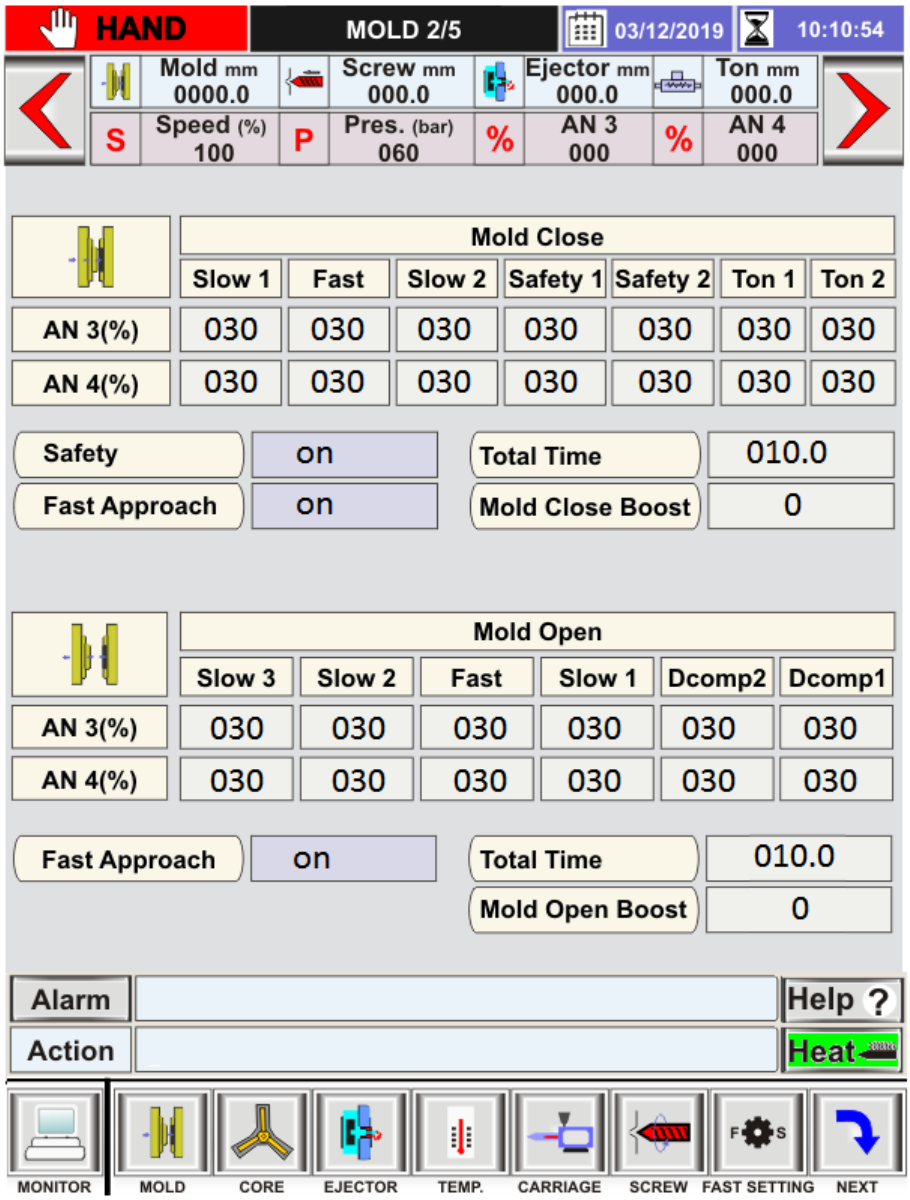
				Set Slow Open 1 function operating Speed proportional output	Speed	000% – 100%	User Level	YES
				Set Slow Open 1 function operating Time	Time	00.0 – 99.9Sec	User Level	YES
13	MOLD 1/5	Decompression	This function is use in RAM type injection molding machine to reduce tonnage pressure.	Decompression Function. Set decompression function over operating position.	Position	000.0 – 3000 mm	User Level	YES
				Set decompression function operating pressure proportional output	Pres0073ure	000– 255Bar	User Level	YES
				Set decompression function operating Speed proportional output	Speed	000% – 100%	User Level	YES
				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)].	Delay	00.0 – 99.9Sec	User Level	YES
				Set decompression function operating Time	Time	00.0 – 99.9Sec	User Level	YES

Screen Page: MOLD 2/5

MOLD

(1)Press"  " key once on the top of the Touch Screen.
(2) Now Screen 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 2/5 page and list of parameter is given below.



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	MOLD 2/5	Close Slow1		Set Close Slow1 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Close Slow1 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
2	MOLD 2/5	Close Fast		Set Close Fast function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Close Fast function operating AN4 proportional output	AN4	000% – 100%	User	Yes
3	MOLD 2/5	Close Slow2		Set Close Slow2 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Close Slow2 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
4	MOLD 2/5	Safety 1 End		Set Close Safety1 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Close Safety1 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
5	MOLD 2/5	Safety 2 End		Set Close Safety2 function operating AN3 proportional output	AN3	000% – 100%	User	Yes

6	MOLD 2/5	Lock Ton 1		Set Locking tonnage1 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Locking tonnage1 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
7	MOLD 2/5	Lock Ton 2		Set Locking tonnage2 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				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.					
12	MOLD 2/5	Slow Open3		Set Slow Open3 function operating AN3 proportional output	AN3	000% – 100%	User Level	YES
				Set Slow Open3 function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
13	MOLD 2/5	Slow Open2		Set Slow Open2 function operating AN3 proportional output	AN3	000% – 100%	User Level	YES
				Set Slow Open2 function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
14	MOLD 2/5	Fast Open		Set Fast Open function operating AN3 proportional output	AN3	000% – 100%	User Level	YES
				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

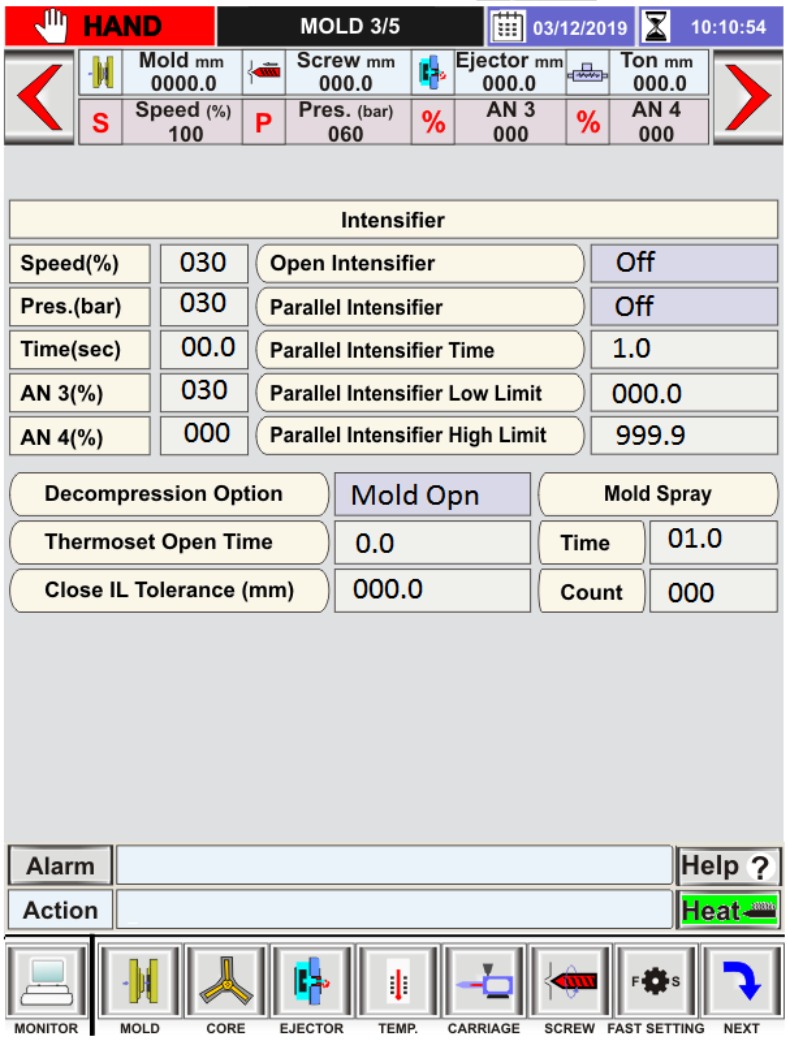
				Set Slow Open1 function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
16	MOLD 2/5	Decompression		Set decompression function operating AN3 proportional output	AN3	000% – 100%	User Level	YES
				Set decompression function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
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 IL..MOLD 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

Screen Page: MOLD 3/5

MOLD

(1)Press"  " key once on the top of the Touch Screen.
(2) Now Screen 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.
(5) On pressing **ENTER** key the set value will be saved. Alphanumeric Touch Key Pad disappears from The Screen.

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



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	MOLD 3/5	Open Intensifier Open Intensifier	This function is use in RAM type injection molding machine to reduce tonnage pressure.	Set Open Intensifier function operating pressure proportional output	Pressure	000– 255Bar	User Level	YES
				Set Open Intensifier function operating Speed proportional output	Speed	000% – 100%	User Level	YES
				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

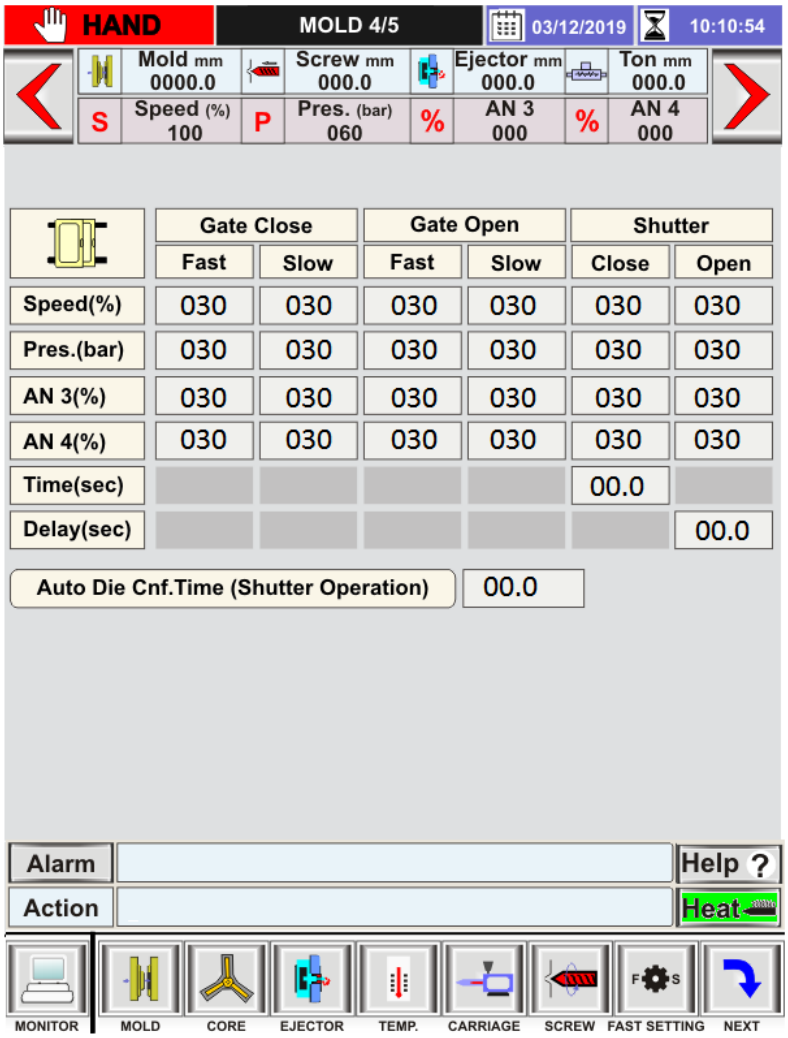
5	MOLD 3/5	Parallel Intensifier Low Limits		Set Parallel Intensifier function operating low limit.	Position	000.0 – 999.9	Level 1	Yes
6	MOLD 3/5	Parallel Intensifier High Limits		Set Parallel Intensifier function operating high limit.	Position	000.0 – 999.9	Level 1	Yes
7	MOLD 3/5	Decompression Option	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/After 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 3/5	Mold Spray	After set count output turn ON before mold close in auto cycle as per time set	Set Mold Spray function operating time.	Time	00.0 – 99.9 Sec	Level1	Yes
				Set Mold Spray function Count.	Count	000 – 999	Level1	Yes

Screen Page: MOLD 4/5

MOLD

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



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
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
2	MOLD 3/5	Gate Close Slow		Set Front Safety Gate Slow 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 Slow Close function operating AN3 proportional output	AN3	000% – 100%	Level 1	Yes

				Set Front Safety Gate Slow Close function operating AN4 proportional output	AN4	000% – 100%	Level 1	Yes
3	MOLD 3/5	Gate Open Fast		Set Front Safety Gate Fast Open function operating pressure proportional output	Pressure	000 – 255Bar	Level 1	Yes
				Set Front Safety Gate Fast Open function operating Speed proportional output	Speed	000% – 100%	Level 1	Yes
				Set Front Safety Gate Fast Open function operating AN3 proportional output	AN3	000% – 100%	Level 1	Yes
				Set Front Safety Gate Fast Open function operating AN4 proportional output	AN4	000% – 100%	Level 1	Yes
4	MOLD 3/5	Gate Open Slow		Set Front Safety Gate Slow Open function operating pressure proportional output	Pressure	000 – 255Bar	Level 1	Yes
				Set Front Safety Gate Slow Open function operating Speed proportional output	Speed	000% – 100%	Level 1	Yes
				Set Front Safety Gate Slow Open function operating AN3 proportional output	AN3	000% – 100%	Level 1	Yes

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

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

Screen Page: MOLD 5/5

MOLD

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

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

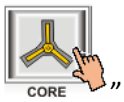
Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	MOLD 5/5	Mold Close	Mold moves in close direction in slow motion in Die Set mode. Disable SEMI AUTO and FULLY AUTO mode in this mode.	Set Mold Close function operating pressure proportional output	Pressure	000 – 255Bar	Level 1	Yes
				Set Mold Close function operating Speed proportional output	Speed	000% – 100%	Level 1	Yes
				Set Mold Close function operating AN3 proportional output	AN3	000% – 100%	Level 1	Yes
				Set Mold Close function operating AN4 proportional output	AN4	000% – 100%	Level 1	Yes
2	MOLD 5/5	Mold Open	Mold moves in open direction in slow motion in Die Set mode. Disable SEMI AUTO and FULLY AUTO mode in this mode.	Set Mold Open function operating pressure proportional output	Pressure	000 – 255Bar	Level 1	Yes
				Set Mold Open function operating Speed proportional output	Speed	000% – 100%	Level 1	Yes
				Set Mold Open function operating AN3 proportional output	AN3	000% – 100%	Level 1	Yes
				Set Mold Open function operating AN4 proportional output	AN4	000% – 100%	Level 1	Yes
3	MOLD 5/5	Mold Height+	Increase distance between moving platen and fix platen with help of this function. This function is use in only toggle type machine.	Set Mold Height Maximum function operating pressure proportional output	Pressure	000 – 255Bar	Level 1	Yes

				Set Mold Height Maximum function operating Speed proportional output	Speed	000% – 100%	Level 1	Yes
				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
4	MOLD 5/5	Mold Height-	Decrease distance between moving platen and fix platen with help of this function. This function is use in only toggle type machine.	Set Mold Height Minimum function operating pressure proportional output	Pressure	000 – 255Bar	Level 1	Yes
				Set Mold Height Minimum function operating Speed proportional output	Speed	000% – 100%	Level 1	Yes
				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	
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

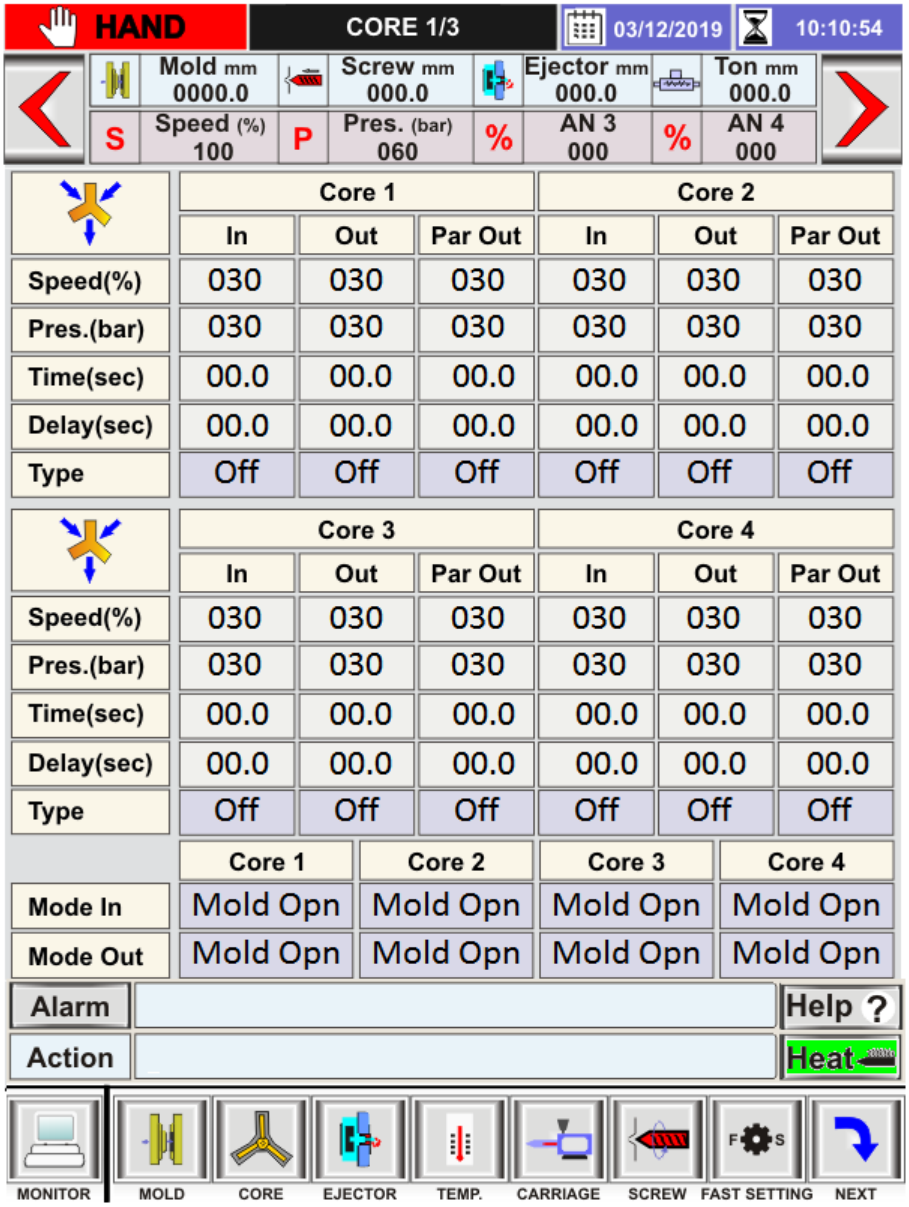
Screen Page: CORE 1/3

CORE

(1)Press" 

" key once on the bottom of the Touch Screen.
(2) Now Screen 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.

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



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	CORE 1/3	Core In	This function is use to move core 1 unit in to die.	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
				Set Core In 1 function operating time.	Timer	00.0-99.9Sec	User	Yes
				Select core 1 IN operating type. Core In 1 function is disable with **Off** selection Core In 1 function is over on limit switch or proxy switch input with **Ls** selection Core In 1 function is over on completion of set time with **Timer** selection	Type	Off Ls Timer	Level 1	Yes
2	CORE 1/3	Core Out	This function is use to pull out core 1 unit from die.	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
				Set Core Out 1 function operating time.	Timer	00.0-99.9Sec	User	Yes
				Select core 1 Out operating type. Core Out 1 function is disable with **Off** selection Core Out 1 function is over on limit switch or proxy switch input with **Ls** selection Core Out 1 function is over on completion of set time with **Timer** selection	Type	Off Ls Timer	Level 1	Yes

3	CORE 1/3	Partial Out	This function is use to pull out core 1 unit partially from die during cooling function.	Set Core Partial Out 1 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Core Partial Out 1 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				On completion of set delay time Core Partial Out 1 function take place. Its start after completion of injection function	Delay	00.0-99.9Sec	User	Yes
				Set Core Partial Out 1 function operating time.	Timer	00.0-99.9Sec	User	Yes
				Select core 1 Partial Out operating type. Core Partial Out 1 function is disable with **Off** selection Core Partial Out 1 function is over on limit switch or proxy switch input with **Ls** selection Core Partial Out 1 function is over on completion of set time with **Timer** selection	Type	On/Ls/Timer	Level 1	Yes
4	CORE 1/3	Cor2 In	This function is use to move core 2 unit in to die.	Set Core In 2 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Core In 2 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				On completion of set delay time Core In 2 function take place.	Delay	00.0-99.9Sec	User	Yes
				Set Core In 2 function operating time.	Timer	00.0-99.9Sec	User	Yes
				Select core 2 IN operating type. Core In 2 function is disable with **Off** selection Core In 2 function is over on limit switch or proxy switch input with **Ls** selection Core In 2 function is over on completion of set time with **Timer** selection	Type	Off/Ls/Timer	Level 1	Yes

5	CORE 1/3	Cor2 Out	This function is use to pull out core 2 unit from die.	Set Core Out 2 function operating pressure proportional output	Pressure	000 – 255Bar	User	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
				Set Core Out 2 function operating time.	Timer	00.0-99.9Sec	User	Yes
				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	Type	Off/Ls/Timer	Level 1	Yes
6	CORE 1/3	Par2 Out	This function is use to pull out core 2 unit partially from die during cooling function.	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
				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
				Set Core Partial Out 2 function operating time.	Timer	00.0-99.9Sec	User	Yes
				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	Type	Off/Ls/Timer	Level 1	Yes

				completion of set time with **Timer** selection				
7	CORE 1/3	Cor3 In	This function is use to move core 3 unit in to die.	Set Core In 3 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Core In 3 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				On completion of set delay time Core In 3 function take place.	Delay	00.0-99.9Sec	User	Yes
				Set Core In 3 function operating time.	Timer	00.0-99.9Sec	User	Yes
				Select core 3 IN operating type. Core In 3 function is disable with **Off** selection Core In 3 function is over on limit switch or proxy switch input with **Ls** selection Core In 3 function is over on completion of set time with **Timer** selection	Type	Off/Ls/Timer	Level 1	Yes
8	CORE 1/3	Cor3 Out	This function is use to pull out core 3 unit from die.	Set Core Out 3 function operating pressure proportional output	Pressure	000 – 255Bar	User	Yes
				Set Core Out 3 function operating Speed proportional output	Speed	000% – 100%	User	Yes
				On completion of set delay time Core Out 3 function take place.	Delay	00.0-99.9Sec	User	Yes
				Set Core Out 3 function operating time.	Timer	00.0-99.9Sec	User	Yes
				Select core 3 Out operating type. Core Out 3 function is disable with **Off** selection Core Out 3 function is over on limit switch or proxy switch input with **Ls** selection Core Out 3 function is over on completion of set time with **Timer** selection	Type	Off/Ls/Timer	Level 1	Yes

9	CORE 1/3	Par3 Out	This function is use to pull out core 3 unit partially from die during cooling function.	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
				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
				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	Type	Off/Ls/Timer	Level 1	Yes
10	CORE 1/3	Core4 In	This function is use to move core 1 unit in to die.	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
				Set Core In 4 function operating time.	Timer	00.0-99.9Sec	User	Yes
				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	Type	Off Ls Timer	Level 1	Yes

11	CORE 1/3	Core4 Out	This function is use to pull out core 1 unit from die.	Set Core Out 4 function operating pressure proportional output	Pressure	000 – 255Bar	User	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
				Set Core Out 4 function operating time.	Timer	00.0-99.9Sec	User	Yes
				Select core 4 Out operating type. 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	Type	Off Ls Timer	Level 1	Yes
12	CORE 1/3	Par4 Out	This function is use to pull out core 4 unit partially from die during cooling function.	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
				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
				Set Core Partial Out 4 function operating time.	Timer	00.0-99.9Sec	User	Yes
				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	Type	Off/Ls/Timer	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 Betwee n 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

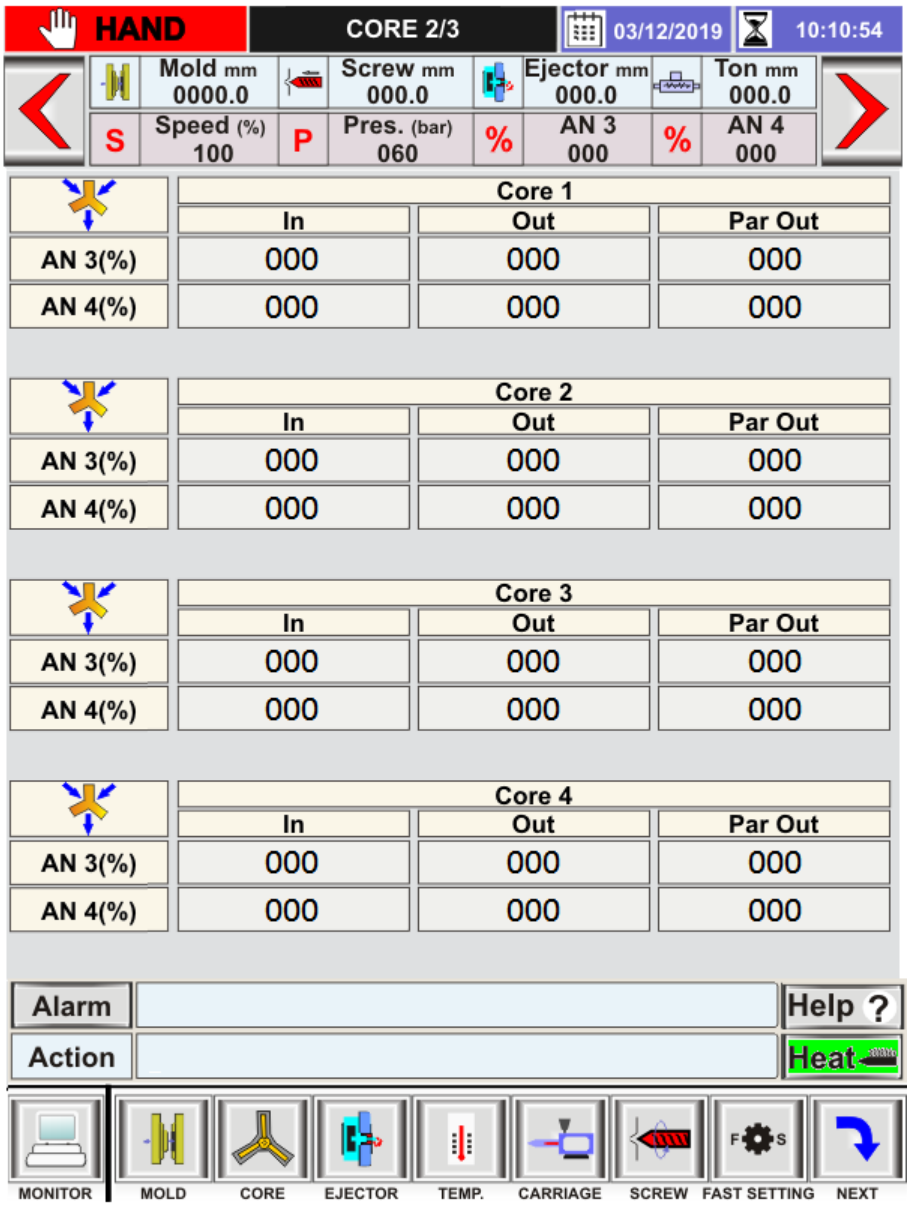
19	CORE 1/3	CORE 4 MODE In	Select core 4 in-operating sequence. On select sequence core in function start. When select **IN Between** sequence core in operation start on **CORE IN POSI**.	Same as CORE 1 MODE In description	MODE In	Mold Open Mold Close In Between Mold Lock	Level 1	Yes
20	CORE 1/3	CORE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

Screen Page: CORE 2/3

CORE

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

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



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	CORE 2/3	Core In		Set Core In 1 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Core In 1 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
2	CORE 2/3	Core Out		Set Core Out 1 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Core Out 1 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
3	CORE 2/3	Partial Out		Set Core Partial Out 1 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Core Partial Out 1 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
4	CORE 2/3	Cor2 In		Set Core In 2 function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
				Set Core In 2 function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes
5	CORE 2/3	Cor2 Out		Set Core Out 2 function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
				Set Core Out 2 function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes
6	CORE 2/3	Par2 Out		Set Core Partial Out 2 function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
				Set Core Partial Out 2 function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes

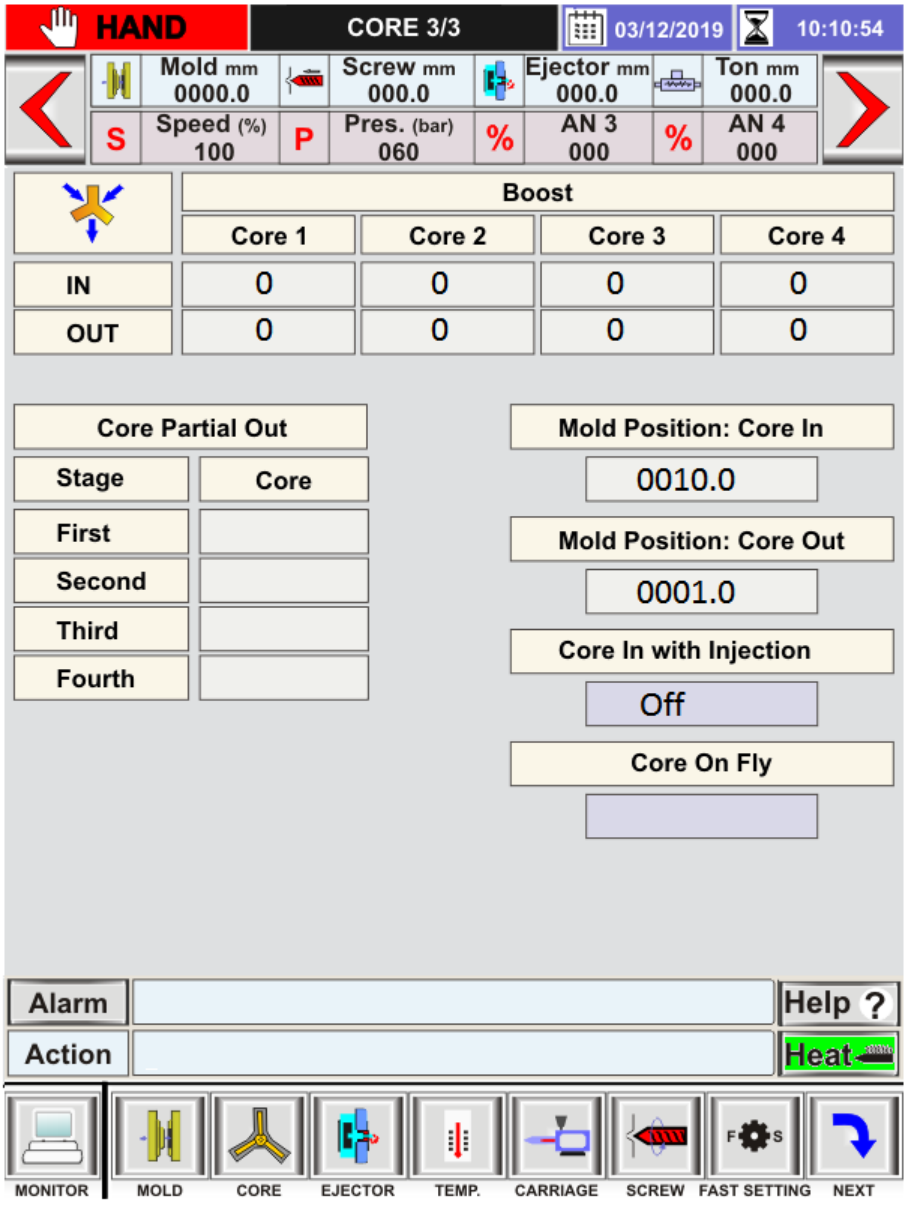
7	CORE 2/3	Cor3 In		Set Core In 3 function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
				Set Core In 3 function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes
8	CORE 2/3	Cor3 Out		Set Core Out 3 function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
				Set Core Out 3 function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes
9	CORE 2/3	Par3 Out		Set Core Partial Out 3 function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
				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) Now Screen 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.

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



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	CORE 3/3	BOST COR1	Select various type of pump selection with 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 In 1 boost option	Number	0-5	Level 1	Yes
				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 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 In 2 boost option	Number	0-5	Level 1	Yes
				Select Core Out 2 boost option	Number	0-5	Level 1	Yes
3	CORE 3/3	BOST COR3	Select various type of pump selection with 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 In 3 boost option	Number	0-5	Level 1	Yes
				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.					
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

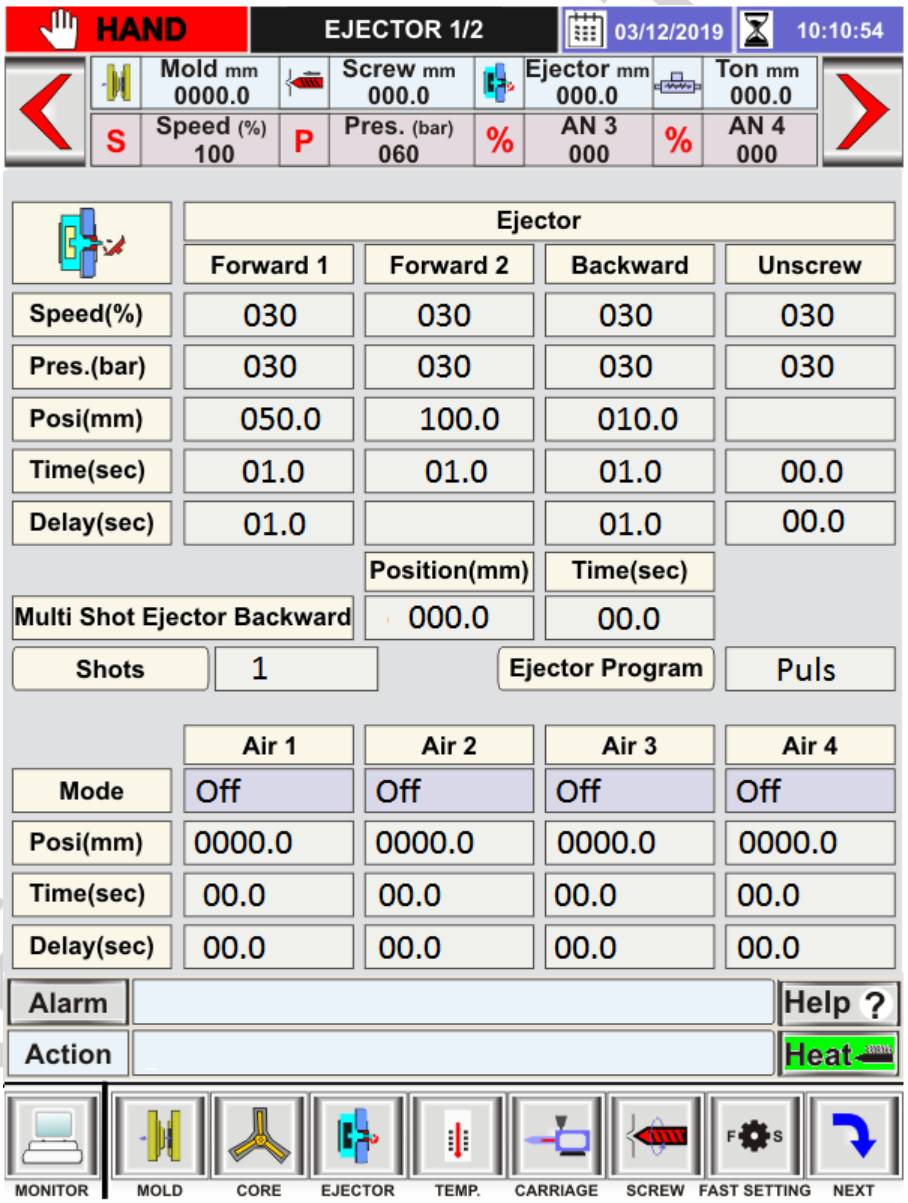
Screen Page: EJECTOR 1/2

EJECTOR

(1)Press" 

" key once on the bottom of the Touch Screen.
(2) Now Screen 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.

EJECTOR 1/2 page and list of parameter is given below



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	EJECTOR 1/2	Ejector Forward1	This function is use to throw out piece from punch side of die.	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
				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	Yes
				Set Ejector Forward 1function operating time.	Timer	00.0-99.9Sec	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 over operating position.	Position	000.0-999.9	User	Yes
				Set Ejector Forward 2 function operating pressure proportional output	Pressure	000–255Bar	User	Yes
				Set Ejector Forward 2 function operating Speed proportional output	Speed	000% – 100%	User	Yes

				Set Ejector Forward 2 function operating time.	Timer	00.0-99.9Sec	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 over operating position.	Position	000.0-999.9	User	Yes
				Set Ejector Backward function operating pressure proportional output	Pressure	000–255Bar	User	Yes
				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
4	EJECTOR 1/2	Unscrew	This function is use to unscrewing molded product from die	Set Unscrew function operating pressure proportional output	Pressure	000–255Bar	User	Yes
				Set Unscrew function operating Speed proportional output	Speed	000% – 100%	User	Yes
				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	Yes
5	EJECTOR 1/2	Position: Multi - shot Ejct Bkwd	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
			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 Open Position After Open After Injection	User	Yes
			Set Air 1 delay time to operate it		Delay	00.0-99.9Sec	User	Yes
			Set Air 1 time to do the function.		Time	00.0-99.9Sec	User	Yes
			Set Air 1 position to do the function with mold open position		Position	9999.0	User	Yes

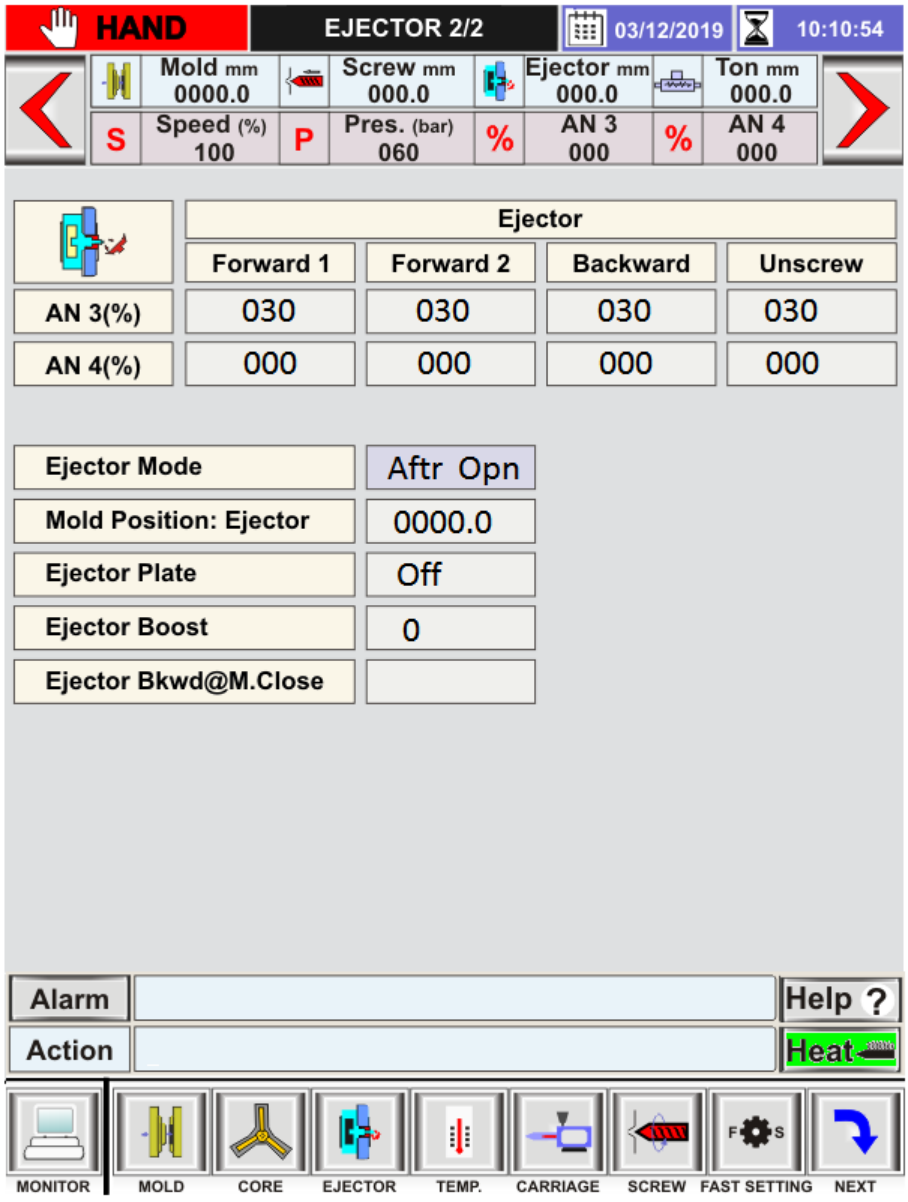
9	EJECTOR 1/2	Air 2	Set Air 2 function to operate it		Mode	With Open Open Position After Open After Injection	User	Yes
			Set Air 2 delay time to operate it		Delay	00.0-99.9Sec	User	Yes
			Set Air 2 time to do the function.		Time	00.0-99.9Sec	User	Yes
			Set Air 2 position to do the function with mold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

Screen Page: EJECTOR 2/2

EJECTOR

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

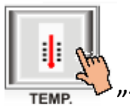


Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	EJECTOR 2/2	Ejector Forward1		Set Ejector Forward 1 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Ejector Forward 1 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
2	EJECTOR 2/2	Ejector Forward2		Set Ejector Forward 2 function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Ejector Forward 2 function operating AN4 proportional output	AN4	000% – 100%	User	Yes
3	EJECTOR 2/2	Ejector Backward		Set Ejector Backward function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Ejector Backward function operating AN4 proportional output	AN4	000% – 100%	User	Yes
4	EJECTOR 2/2	Unscrew		Set Unscrew function operating AN3 proportional output	AN3	000% – 100%	User	Yes
				Set Unscrew function operating AN4 proportional output	AN4	000% – 100%	User	Yes
5	EJECTOR 2/2	Ejector Mode	Select ejector operating mode. Here you can select ejector function operating position. At select position ejector function start. When select Open Position option ejector start on	Select ejector operating mode. Ejector function starts at mold fully open position With **After Open** selection. Ejector function starts with mold open function in **With Open**	Function	With Open Open Position After Open	Level 1	Yes

			set position in POSI.	selection. Ejector function starts at select position With **Open Position** selection.				
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

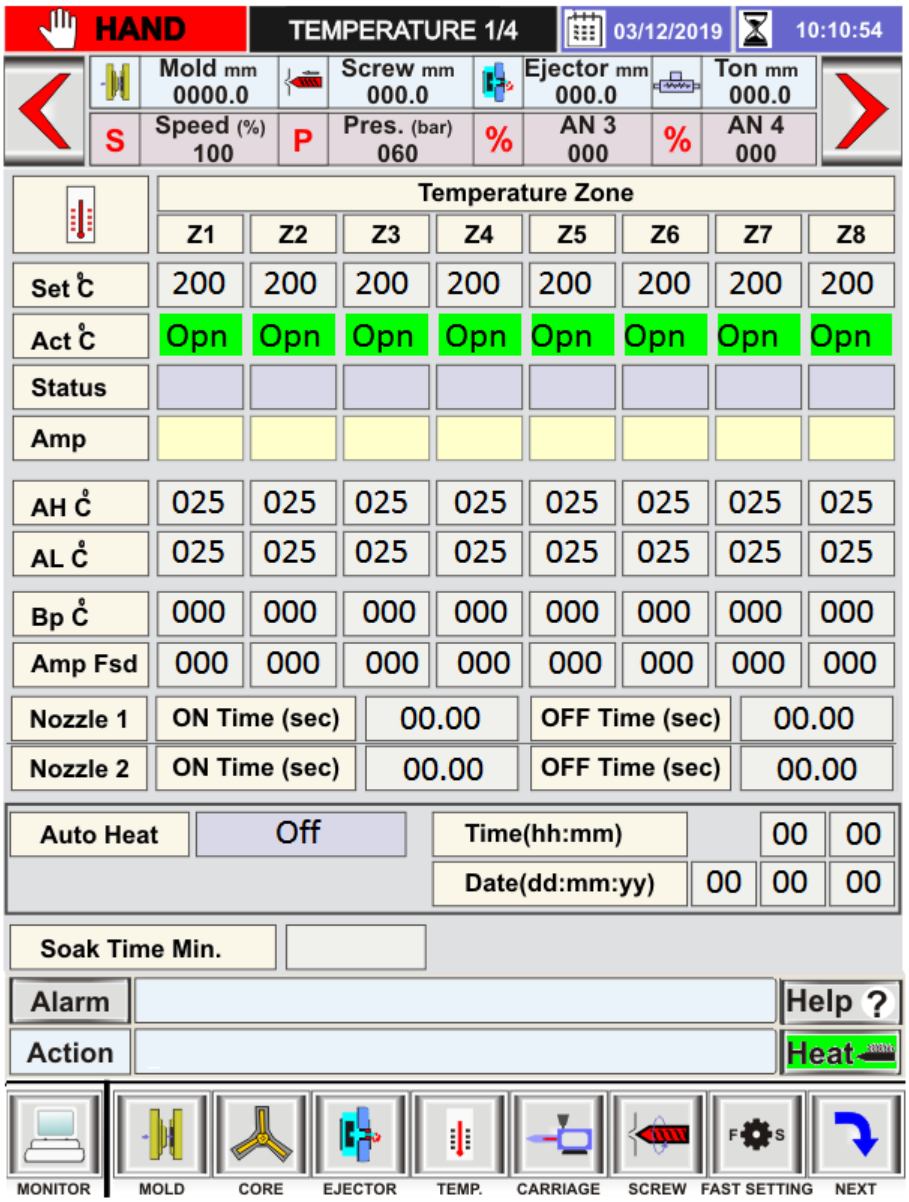
Screen Page: Temperature (1/4)

TEMPERATURE

(1) Press “ 

”Touch Key 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.

Temperature 1/4 page and list of parameter is as per given below.



List of Programmable Parameter:

Zone No.	Message	Description	Range	Default Value	Operating Password Level	Part Of memory
Z1	SET C>	Set temperature	0-999 C	200 C	User	YES
	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.	AmpFSD>	Ampere full scale reading	0-100	000	Level 1	NO
	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
Z2	SET C>	Set temperature	0-999 C	200 C	User	YES
	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.	AmpFSD>	Ampere full scale reading	0-100	000	Level 1	NO
	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
Z3	SET C>	Set temperature	0-999 C	200 C	User	YES
	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.	AmpFSD>	Ampere full scale reading	0-100	000	Level 1	NO
	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
Z4	SET C>	Set temperature	0-999 C	200 C	User	YES
	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.	AmpFSD>	Ampere full scale reading	0-100	000	Level 1	NO
	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
Z5	SET C>	Set temperature	0-999 C	200 C	User	YES
	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.	AmpFSD >	Ampere full scale reading	0-100	000	Level 1	NO
	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
Z6	SET C>	Set temperature	0-999 C	200 C	User	YES
	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.	AmpFSD >	Ampere full scale reading	0-100	000	Level 1	NO
	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
Z7	SET C>	Set temperature	0-999 C	200 C	User	YES
	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.	AmpFSD>	Ampere full scale reading	0-100	000	Level 1	NO
	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
Z8(Oil)	SET C>	Set temperature	0-999 C	200 C	User	YES
	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.	AmpFSD>	Ampere full scale reading	0-100	000	Level 1	NO
	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
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	YES
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

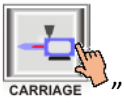
Zone No.	Message	Description	Range	Default Value	Operating Password Level	Part Of memory
NOZZEL 2	ON Time(sec)	The nozzle 2 heater will stay on for as long as the time is running.	00.00-99.9	00.00	User	YES
NOZZEL 2	OFF Time(sec)	The nozzle 2 heater will stay off for as long as the time is running.	00.00-99.9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

Note :- **Suppose Heater Current card Not Used then set All zone Amp FSd Value 0.**

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

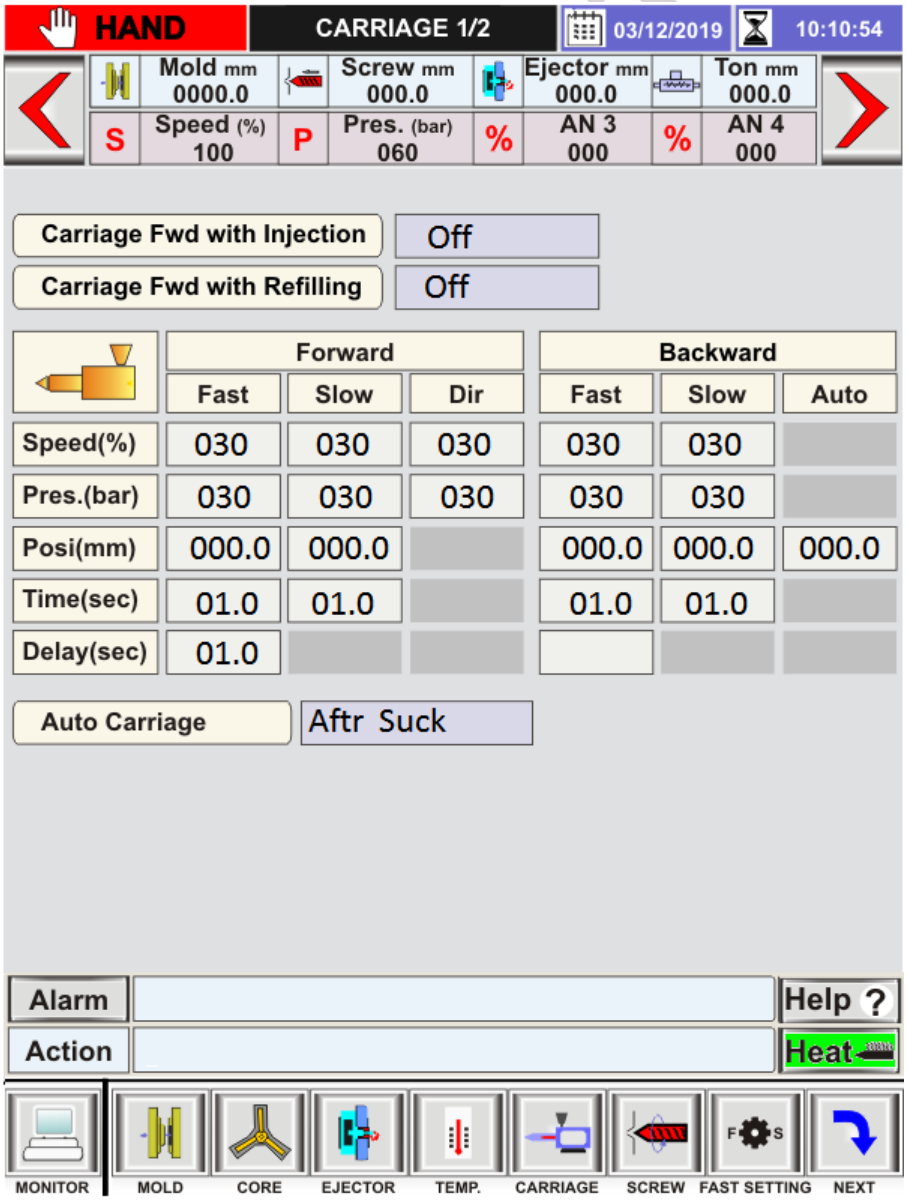
Screen Page: CARRIAGE 1/2

CARRIAGE

(1)Press" 

" key once on the top of the Touch Screen.
(2) Now Screen 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.

CARRIAGE 1/2 page and list of parameter is given below



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
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
3	CARRIAGE 1/2	Carriage Forward Fast	Carriage forward fast functions. As per selection in function type	Set position for carriage forward fast function from Carriage backward end position.	Position	000.0-999.9	User Level	Yes
				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
				Set delay time before carriage forward fast function take place	Delay	00.0-99.9Sec	Level 1	Yes

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

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

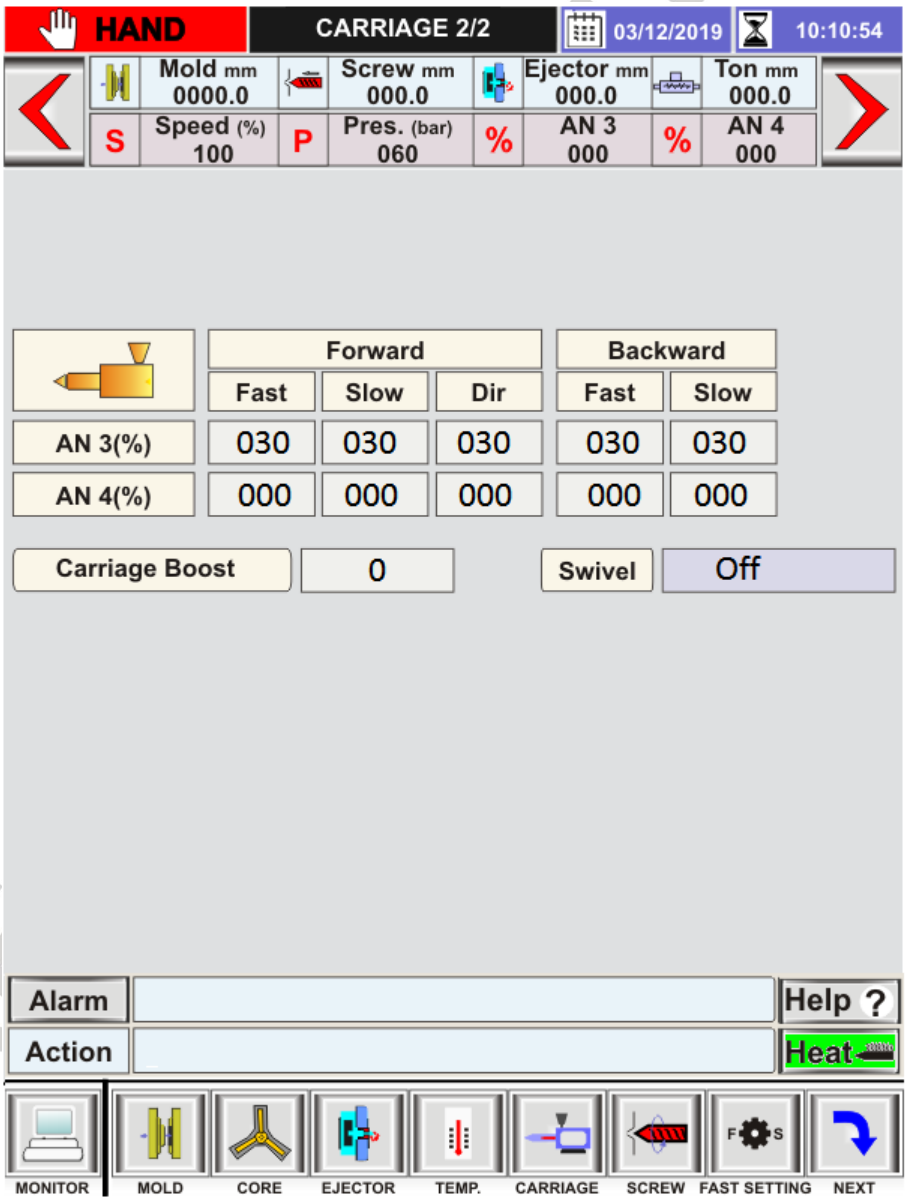
8	CARRIAGE 1/2	Carriage Backward Auto	Carriage backward stops position for auto mode. With enable auto carriage function carriage backward stop on this set position in every cycle.	Set carriage backward auto position. Always set it less than carriage backward end position.	Position	000.0-999.9	User Level	Yes
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 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

Screen Page: CARRIAGE 2/2

CARRIAGE

(1)Press"  " key once on the top of the Touch Screen.
(2) Now Screen 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 2/2 page and list of parameter is given below.

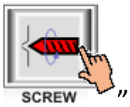


Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	CARRIAGE 2/2	Carriage Forward Fast		Set Carriage forward fast function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
				Set Carriage forward fast function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes
2	CARRIAGE 2/2	Carriage Forward Slow		Set Carriage forward Slow function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
				Set Carriage forward Slow function operating AN4 proportional output	AN4	000% – 100%	User Level	Yes
3	CARRIAGE 2/2	Carriage Forward Direction		Set carriage forward direction proportional AN3 output during injection or refill time in semi auto & fully auto.	AN3	000% – 100%	User Level	Yes
				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
5	CARRIAGE 2/2	Carriage Backward Slow		Set Carriage backward slow function operating AN3 proportional output	AN3	000% – 100%	User Level	Yes
				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 IL …UNIT SWIVEL NOT AT HOME…	Carriage swivel function on/ off.	Function	On/Off	Level 1	Yes

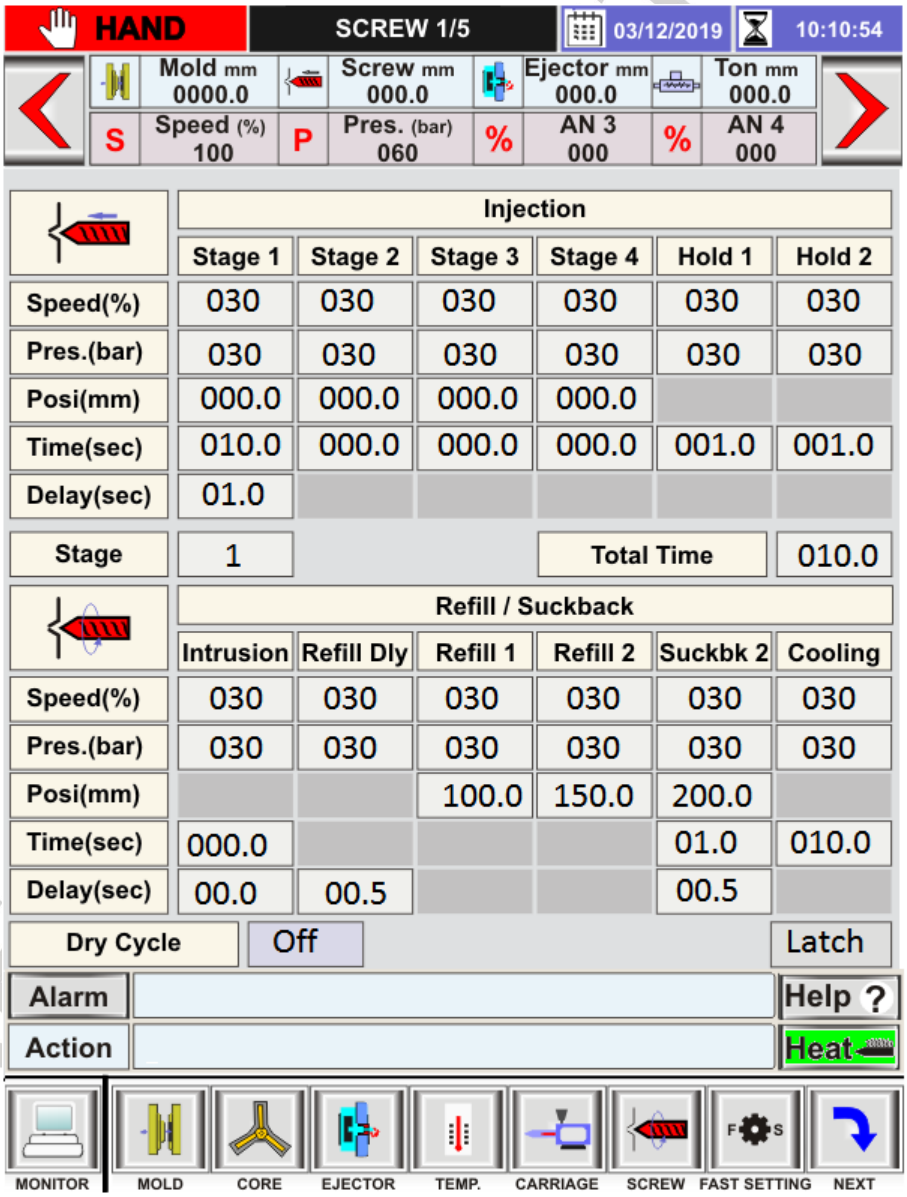
Screen Page: SCREW 1/5

SCREW



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

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



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

List of Programmable Parameter:

Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	SCREW 1/5	Stages	Select injection-operating stage.	Select operating stage	Number of stage	0 – 4	Level 1	YES
2	SCREW 1/5	Total Time	Total time for injection function. If injection time is exceed from total time at that time system come in hand mode & display IL..INJECTION TIMER OVER.	Set total time for injection function	Timer	000.0 – 999.9	Level 1	YES
3	SCREW 1/5	Stage 1	Injection Stage 1 Injection stage 1 Function work till to reach the stage 1 set position or over the set time	Set Injection Stage-1 function over operating position.	Position	000.0 – 999.9mm	User	YES
				Set Injection Stage-1 function operating pressure proportional output	Pressure	000Bar – 255Bar	User	YES
				Set Injection Stage-1 function operating Speed proportional output	Speed	000% – 100%	User	YES
				On completion of set delay time Injection Stage-1 function take place. Its start on completion of Carriage Forward function	Delay	00.0-99.9	User	YES
				Set Injection Stage-1 operating time	Timer	000.0 – 999.9Sec	User	YES
4	SCREW 1/5	Stage 2	Injection Stage 2 Injection stage 2 Function work till to reach the stage 2 set position or over the set time	Set Injection Stage-2 function over operating position.	Position	000.0 – 999.9mm	User	YES
				Set Injection Stage-2 function operating pressure proportional output	Pressure	000Bar – 255Bar	User	YES
				Set Injection Stage-2 function operating Speed proportional output	Speed	000% – 100%	User	YES

				Set Injection Stage-2 operating time	Timer	000.0 – 999.9Sec	User	YES
5	SCREW 1/5	Stage 3	Injection Stage 3 Injection stage 3 Function work till to reach the stage 3 set position or over the set time	Set Injection Stage-3 function over operating position.	Position	000.0 – 999.9mm	User	YES
				Set Injection Stage-3 function operating pressure proportional output	Pressure	000Bar – 255Bar	User	YES
				Set Injection Stage-3 function operating Speed proportional output	Speed	000% – 100%	User	YES
				Set Injection Stage-3 operating time	Timer	000.0 – 999.9Sec	User	YES
6	SCREW 1/5	Stage 4	Injection Stage 4 Injection stage 4 Function work till to reach the stage 4 set position or over the set time	Set Injection Stage-4 function over operating position.	Position	000.0 – 999.9mm	User	YES
				Set Injection Stage-4 function operating pressure proportional output	Pressure	000Bar – 255Bar	User	YES
				Set Injection Stage-4 function operating Speed proportional output	Speed	000% – 100%	User	YES
				Set Injection Stage-4 operating time	Timer	000.0 – 999.9Sec	User	YES
7	SCREW 1/5	Hold 1	Injection HOLD ON 1 Injection hold Function work till to over the set time on	Set Injection Hold On-1 function operating pressure proportional output	Pressure	000Bar – 255Bar	User	YES
				Set Injection Hold On-1 function operating Speed proportional output	Speed	000% – 100%	User	YES
				Set Injection Hold On-1 operating time	Timer	000.0 – 999.9Sec	User	YES
8	SCREW 1/5	Hold 2	Injection HOLD ON 2 Injection hold Function work till to over the set time on	Set Injection Hold On-2 function operating pressure proportional output	Pressure	000Bar – 255Bar	User	YES
				Set Injection Hold On-2 function operating Speed proportional output	Speed	000% – 100%	User	YES
				Set Injection Hold On-2 operating time	Timer	000.0 – 999.9Sec	User	YES
9	SCREW 1/5	Intrusion		Set Intrusion function operating pressure proportional output	Pressure	000 – 255Bar	User	YES

				Set Intrusion function operating Speed proportional output	Speed	000% – 100%	User	YES
				Set Intrusion operating delay time	Delay	00.0 – 99.9Sec	User	YES
				Set Intrusion operating time	Time	000.0 – 999.9Sec	User	YES
10	SCREW 1/5	Refill Delay		Set Refill delay function operating pressure proportional output	Pressure	000 – 255Bar	User	YES
				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
11	SCREW 1/5	Refill 1		Set Refill-1 function over operating position.	Position	000.0 – 999.9mm	User	YES
				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
12	SCREW 1/5	Refill 2		Set Refill-2 function over operating position.	Position	000.0 – 999.9mm	User	YES
				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
13	SCREW 1/5	Suck back 2		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
				Set Suck back-2 function operating Speed proportional output	Speed	000% – 100%	User	YES
				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

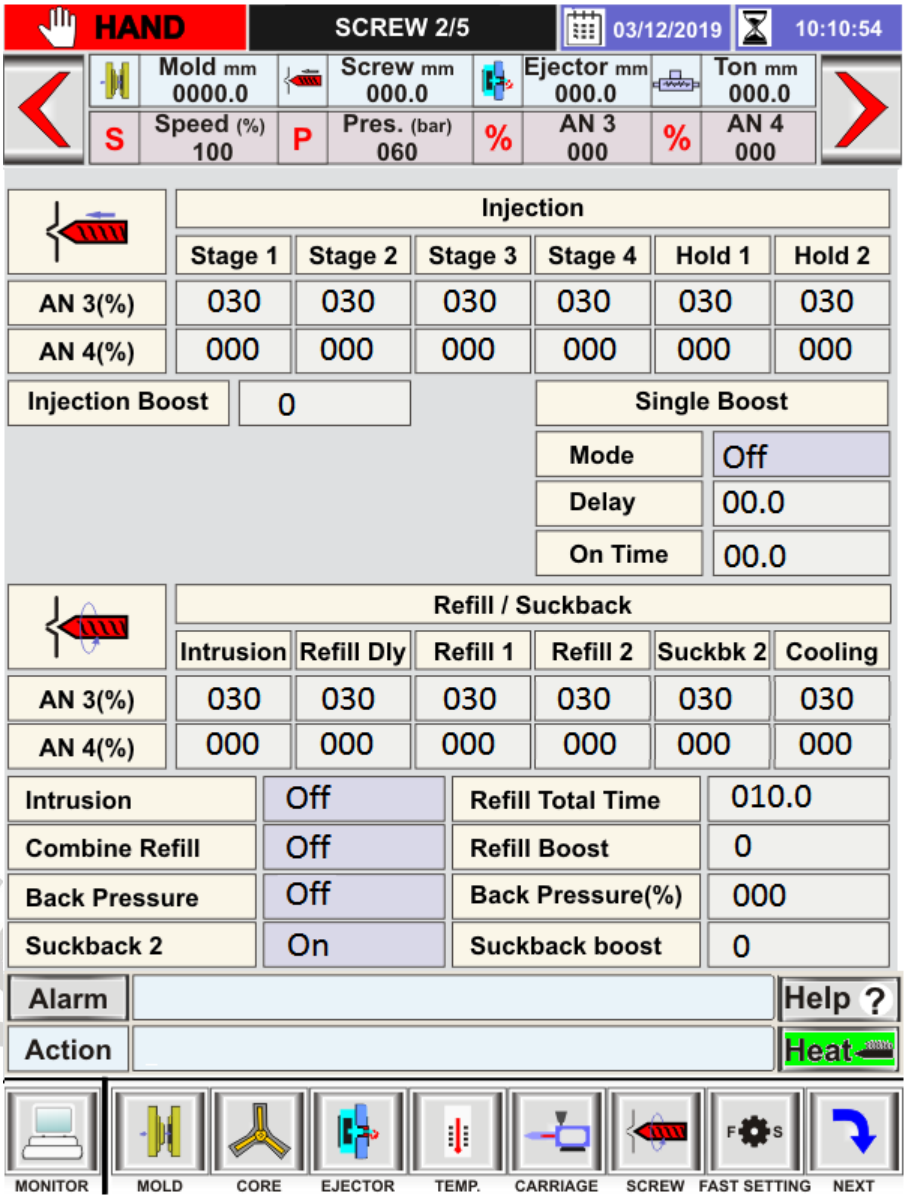
				Set Suck back-2 operating time	Time	00.0 – 99.9Sec	User	YES
14	SCREW 1/5	Cooling		Set Cooling function operating pressure proportional output	Pressure	000 – 255Bar	User	YES
				Set Cooling function operating Speed	Speed	000% – 100%	User	YES
				proportional output Set Cooling operating time.	Time	000.0 – 999.9Sec	User	YES
15	SCREW 1/5	Dry cycle	To run machine in semi mode without refilling function.	Set Dry Cycle function to run in dry cycle mode.	Function	On/Off	Level 1	Yes
16	SCREW 1/5	Latch						

Screen Page: SCREW 2/5

SCREW

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



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

				Set Injection Hold On-2 function operating AN4 proportional output	AN4	000% – 100%	User Level	YES
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
8	SCREW 2/5	Single Boost	Select Time base Boost option function. Delay time for injection boost function. On time for injection boost function.	Make on to operate time base boost function	Mode	On/Off	Level 1	YES
				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 2/5	Intrusion		Set Intrusion function operating AN3 proportional output	AN3	000% – 100%	User	YES
				Set Intrusion function operating AN4 proportional output	AN4	000% – 100%	User	YES
10	SCREW 2/5	Ref Delay		Set Refill delay function operating AN3 proportional output	AN3	000% – 100%	User	YES
				Set Refill delay function operating AN4 proportional output	AN4	000% – 100%	User	YES

11	SCREW 2/5	Refill 1		Set Refill-1 function operating AN3 proportional output	AN3	000% – 100%	User	YES
				Set Refill-1 function operating AN4 proportional output	AN4	000% – 100%	User	YES
12	SCREW 2/5	Refill 2		Set Refill-2 function operating AN3 proportional output	AN3	000% – 100%	User	YES
				Set Refill-2 function operating AN4 proportional output	AN4	000% – 100%	User	YES
13	SCREW 2/5	Suck back 2		Set Suck back-2 function operating AN3 proportional output	AN3	000% – 100%	User	YES
				Set Suck back-2 function operating AN4 proportional output	AN4	000% – 100%	User	YES
14	SCREW 2/5	Cooling		Set Cooling function operating AN3 proportional output	AN3	000% – 100%	User	YES
				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 MOLD OPEN function start parallel to REFILL function & complete the mold side whole cycle. After mold fully close function is over system wait for refill function over & on completion of refill function injection is taken place and repeat this sequence in every cycle.					
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 2/5	Suck back 2		Set Suck back-2 function operating AN3 proportional output	AN3	000% – 100%	User	YES
				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 IL..REFILL 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

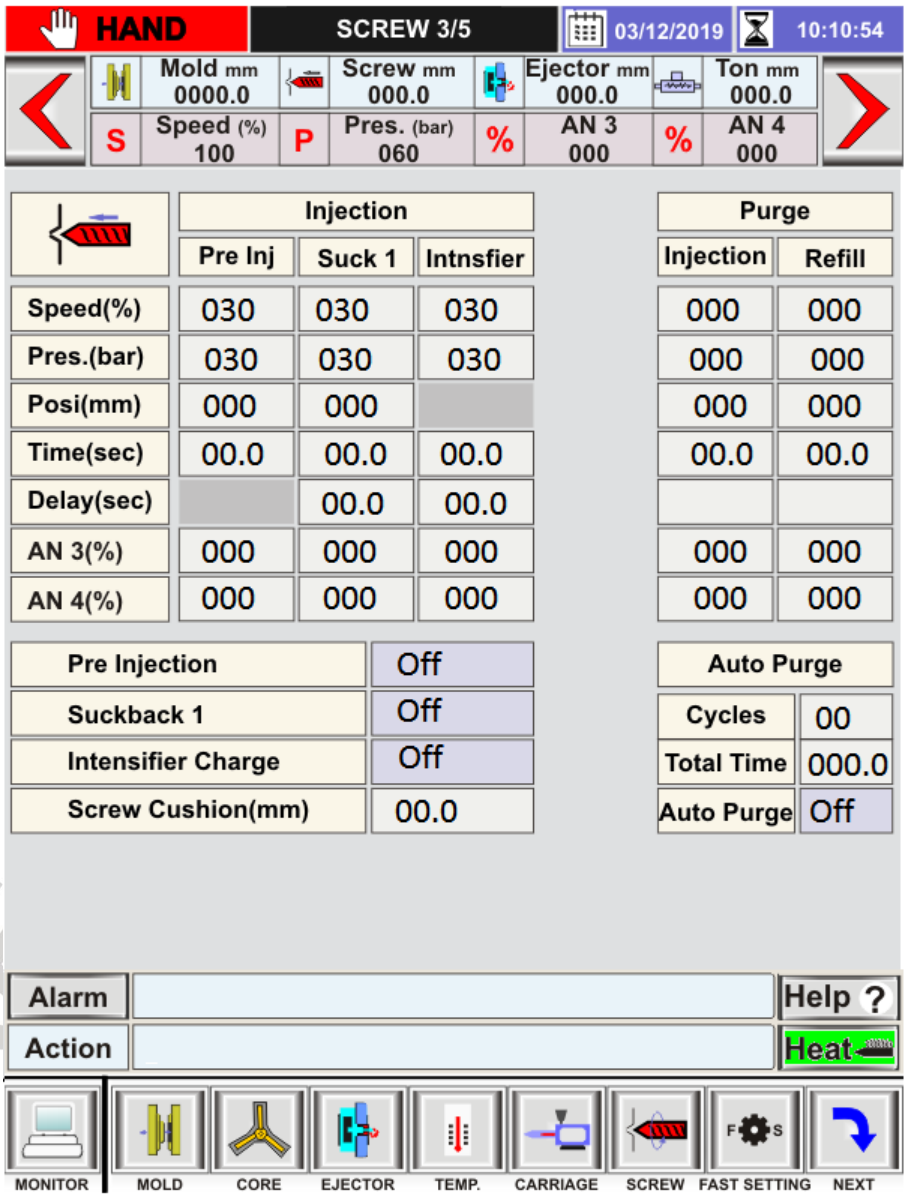
			With boost selection 4 pump selection very with set pressure proportional output. With boost selection 5 pump selection very with set Speed proportional output.					
21	SCREW 2/5	Back pressure (%)	Enable or Disable backpressure digital output during refill function.	Make on to operate digital output of back pressure	Function	On/Off	Level 1	YES
22	SCREW 2/5	Suck back boost	Select various 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 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

Screen Page: SCREW 3/5

SCREW

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



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	SCREW 3/5	Pre-Injection	Pre Injection When AUTO CARRIAGE function is enable at that time before carriage forward function Injection function take place & Function work till to reach the Pre injection's set position or over the set time.	Set Pre Injection function over operating position.	Position	000.0 – 999.9mm	User	YES
				Set Pre Injection function operating pressure proportional output	Pressure	000Bar – 255Bar	User	YES
				Set Pre Injection function operating Speed proportional output	Speed	000% – 100%	User	YES
				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
				Set Pre Injection function operating AN4 proportional output	AN4	000% – 100%	User	YES
2	SCREW 3/5	Suck back 1		Set Suck back-1 function over operating position.	Position	000.0 – 999.9mm	User	YES
				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	YES
	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	Time	00.0 – 99.9Sec	User	YES
				Set Suck back-1 function operating AN3 proportional output	AN3	000% – 100%	User	YES
				Set Suck back-1 function operating AN4 proportional output	AN4	000% – 100%	User	YES
3	SCREW 3/5	Intensifier		Set Intensifier function operating pressure proportional output	Pressure	000 – 255Bar	User	YES
				Set Intensifier function operating Speed proportional output	Speed	000% – 100%	User	YES
				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
				Set Intensifier function operating AN3 proportional output	AN3	000% – 100%	User	YES

				Set Intensifier function operating AN4 proportional output	AN4	000% – 100%	User	YES
4	SCREW 3/5	Injection		Set Purge Injection function over operating position.	Position	000.0 – 999.9mm	Level 2	No
				Set Purge Injection function operating pressure proportional output	Pressure	000 – 255Bar	Level 2	No
				Set Purge Injection function operating Speed proportional output	Speed	000% – 100%	Level 2	No
				Set Purge Injection function operating AN3 proportional output	AN3	000% – 100%	Level 2	No
				Set Purge Injection function operating AN4 proportional output	AN4	000% – 100%	Level 2	No
				Set Purge Injection time	Time	000.0 – 99.9Sec	Level 2	No
5	SCREW 3/5	Refill		Set Purge Refill function over operating position.	Position	000.0 – 999.9mm	Level 2	No
				Set Purge Refill function operating pressure proportional output	Pressure	000 – 255Bar	Level 2	No
				Set Purge Refill function operating Speed proportional output	Speed	000% – 100%	Level 2	No

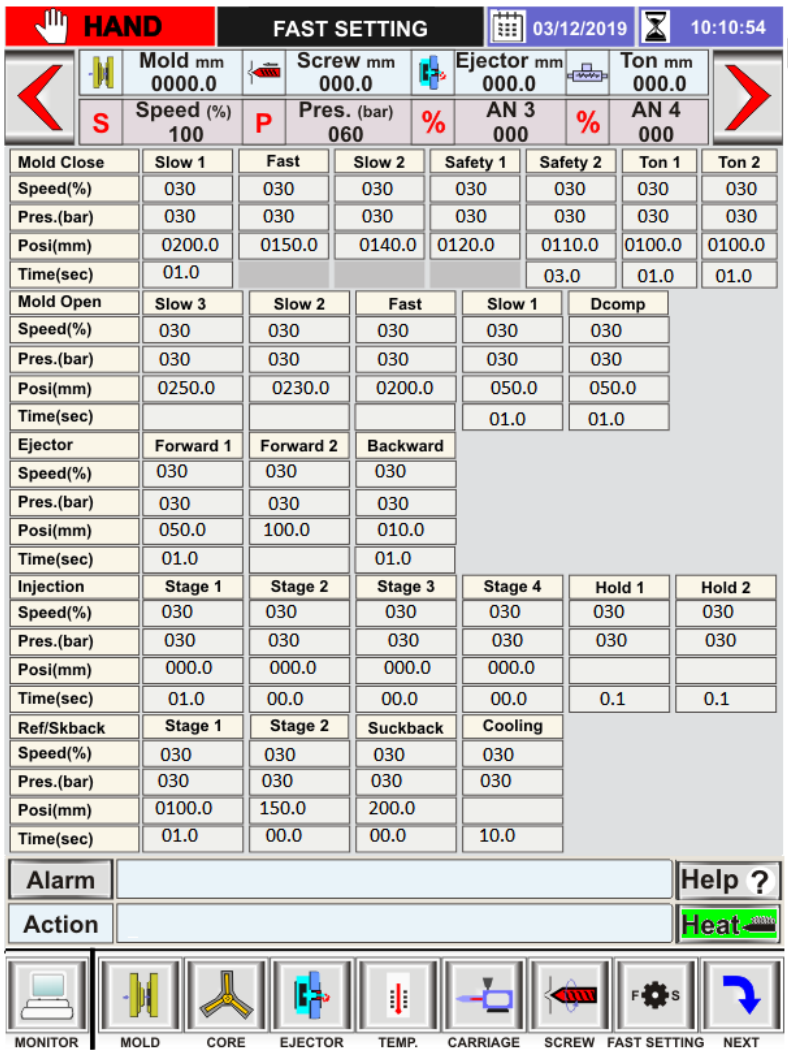
				Set Purge Refill function operating AN3 proportional output	AN3	000% – 100%	Level 2	No
				Set Purge Refill function operating AN4 proportional output	AN4	000% – 100%	Level 2	No
				Set Purge Refill time	Time	000.0 – 99.9Sec	Level 2	No
6	SCREW 3/5	Pre-Injection	Select pre injection function.	Make on 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
9	SCREW 3/5	Cycles	This function is use to clean up injection barrel while you change material.	Set auto purge mode operating cycle.	Number	00-99	Level 2	No
		Total Time		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 IL..TOTAL TIMER OVER.	Timer	000.0-999.9 sec	Level 2	No

Screen Page: FAST SETTING

Press" 

" key once on the top of the Touch Screen.
Now Screen 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.

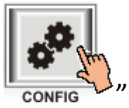
FAST SETTING operation page and list of parameter is given below.



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

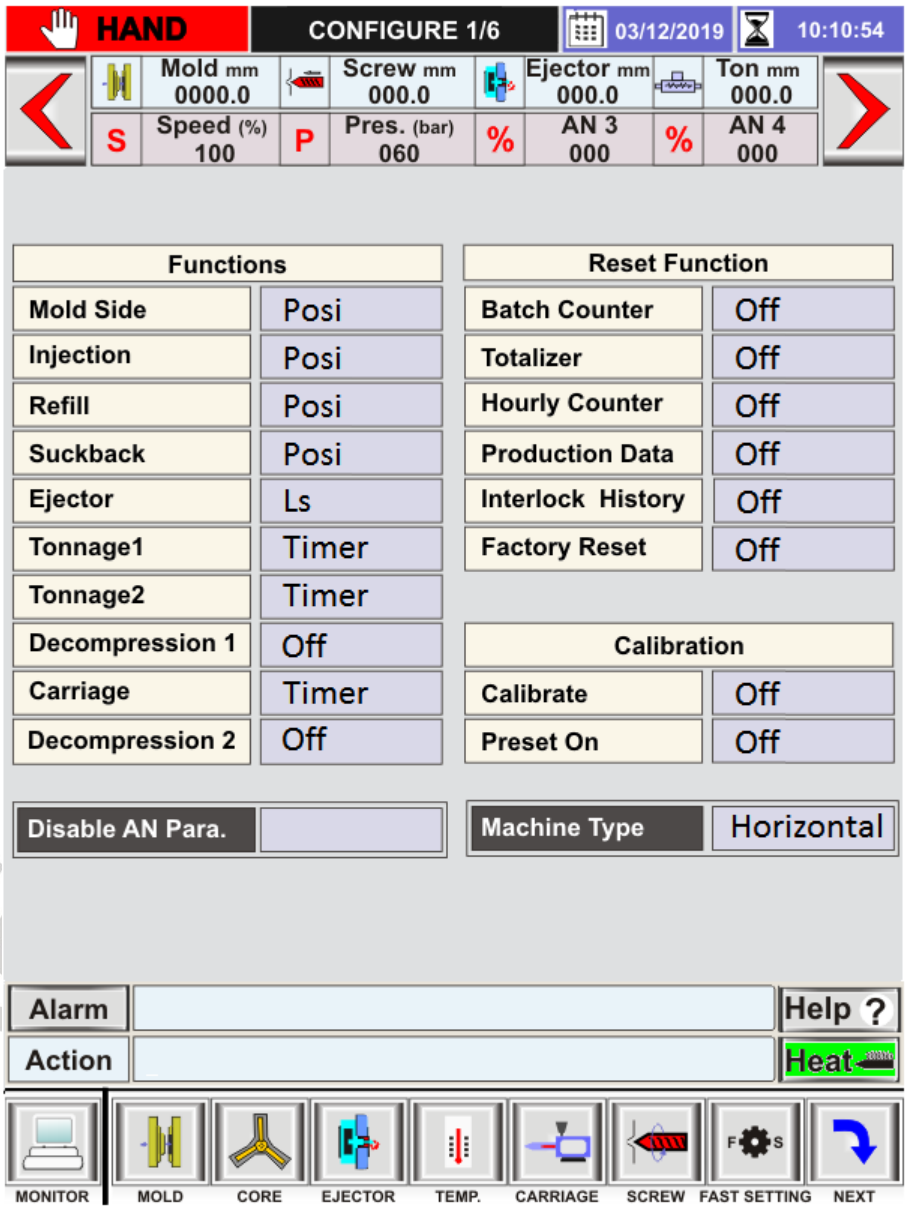
Screen Page: CONFIGURE 1/6

CONFIGURE

(1)Press" 

" key once on the top of the Touch Screen.
(2) Now Screen 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 1/6 page and list of parameter is given below.



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	CONFIGURE 1/6	Mold Side	Select mold close and mold open 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.	Select mold side operating type	Function	Position/ Ls	Level 2	NO
2	CONFIGURE 1/6	Injection	Select injection-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 injection function operating type.	Function	Position/ Ls/Timer	Level 2	NO
3	CONFIGURE 1/6	Refill	Select refill-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.	Select refill function operating type	Function	Position/ Ls	Level 2	NO

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
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.					
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	Decompression 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/Position/Ls/Timer	Level 2	NO

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/Position /Ls-Timer /Ls/Timer	Level 2	NO
11	CONFIGURE 1/6	Decompression 2	This will come when the parameter version is updated.					
		RESET FUNCTION						
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

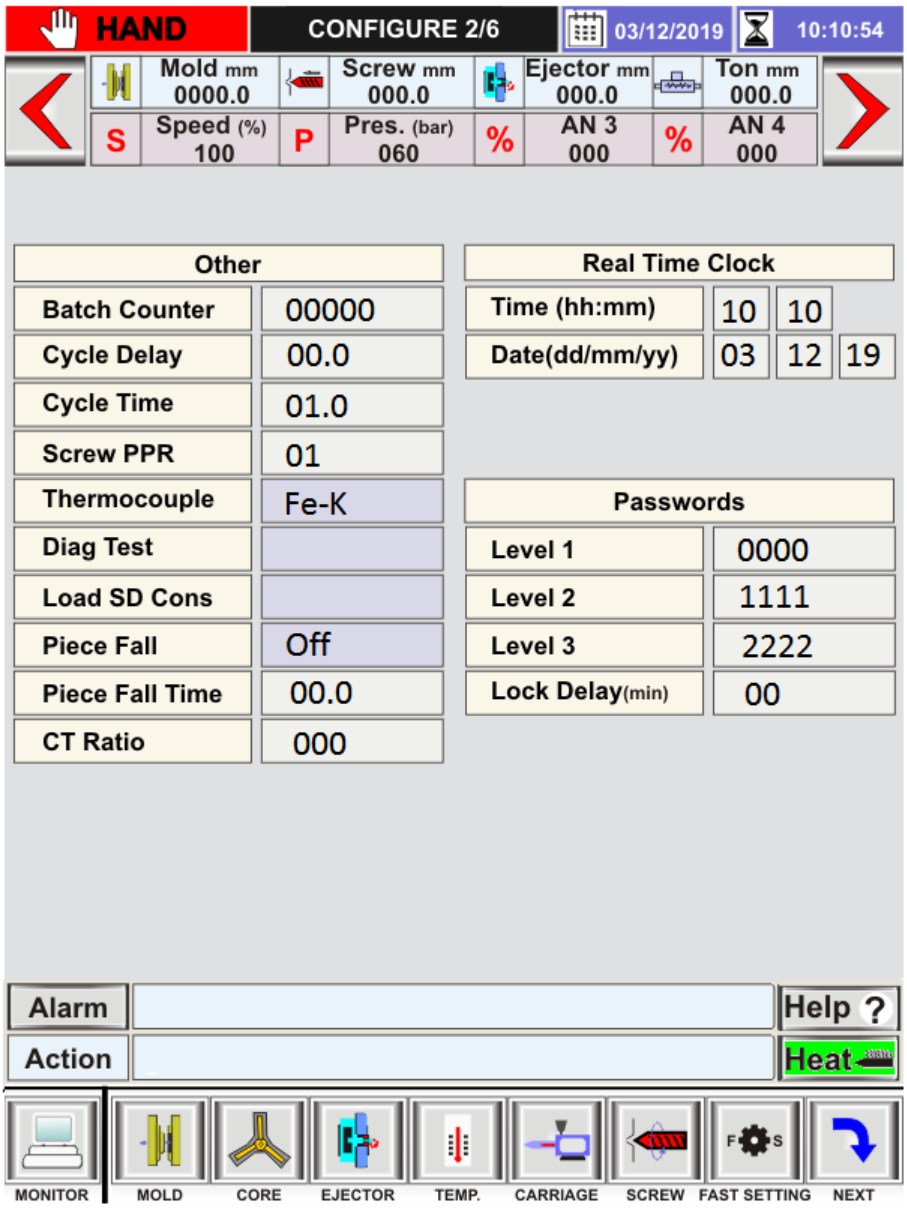
15	CONFIGURE 1/6	Interlock History						
16	CONFIGURE 1/6	Factory Reset						
		CALIBRATION						NO
17	CONFIGURE 1/6	Calibration	Select various type of calibration mode. I.e. Temperature, Analog Input, Analog Output	Select calibration mode which is under calibration	Function	Off/ Temp. /Analog IP /Analog 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.			HORIZONTAL /VERTICAL	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

Screen Page: CONFIGURE 2/6

CONFIGURE

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

CONFIGURE 2/6 page and list of parameter is given below.



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	CONFIGURE 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	CONFIGURE 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	CONFIGURE 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 – 999.9Sec	Level 1	NO
4	CONFIGURE 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	CONFIGURE 2/6	Thermocouple	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	CONFIGURE 2/6	Piece fall		For piece fall confirmation needed during cycle	Function	ON/OFF	Level 2	NO
7	CONFIGURE 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

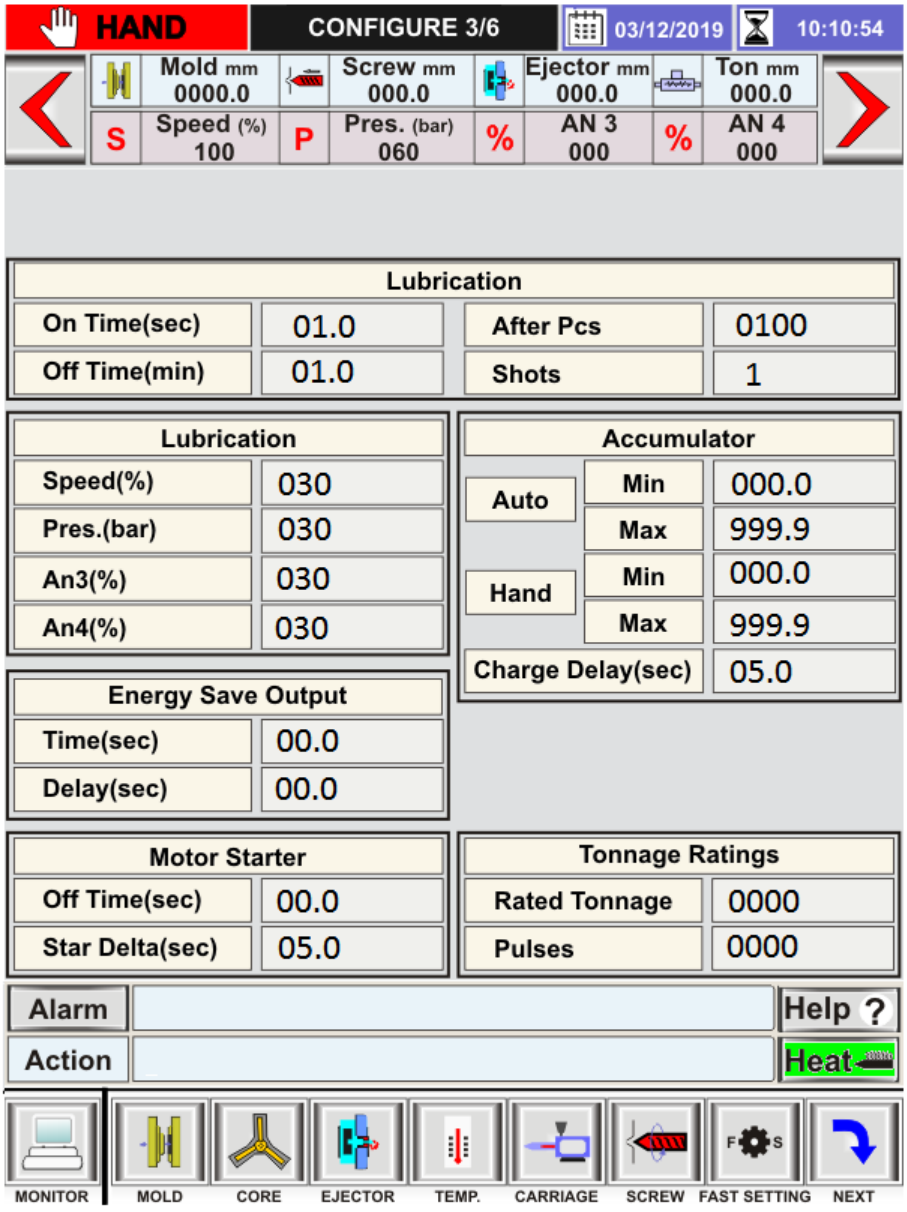
				cycle. This time start with mold open function				
		REAL TIME CLOCK						NO
8	CONFIGURE 2/6	Time (HH:MM)	Set current time in hour & minutes. HH: Shows hour MM: Shows minute In first two digit set hour & in next two digit set minutes.	Set hour time	Time Hour	00-23	Level 2	NO
				Set minute time	Time Minute	00-59	Level 2	NO
9	CONFIGURE 2/6	SET DATE <DD:MM:YY>	Set current date, month & year. DD: Shows date MM: Shows month YY: Shows year In first two digits set date, in next two digit set month & in next two digit set year.	Set date	Date		Level 2	NO
				Set Month	Month		Level 2	NO
				Set year	Year		Level 2	NO
		PASSWORDS						
9	CONFIGURE 2/6	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
		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
		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

Screen Page: CONFIGURE 3/6

CONFIGURE

(1)Press"  " key once on the top of the Touch Screen.
(2) Now Screen 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 3/6 page and list of parameter is given below.



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
		LUBRICATION						
1	CONFIGURE 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		Number	0-9	Level 1	NO
2	CONFIGURE 3/6	Lubrication	This function is use to provide oil to machine.	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

3	CONFIGURE 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
		ES OP Delay		Set on delay for energy save output	Delay	00.0-99.9Sec	Level 2	NO
4	CONFIGURE 3/6	Off Time (sec)	This parameter is used when hydraulic motor star delta is configured.	Set on time for motor off	Timer	00.0-99.9Sec	Level 2	NO
		Star Delta (sec)		Set on time for star motor on	Timer	00.0-99.9Sec	Level 2	NO
5	CONFIGURE 3/6	Accumulator: Auto Min		Select Accumulator charging function minimum limit for AUTO mode only.	Position	000.0-999.9	Level 3	NO
		Accumulator: Auto Max		Select Accumulator charging function maximum limit for AUTO mode only.	Position	000.0-999.9	Level 3	NO
		Accumulator: Hand Min		Select Accumulator charging function minimum limit for HAND mode only.	Position	000.0-999.9	Level 3	NO
		Accumulator: Hand Max		Select Accumulator charging function maximum limit for HAND mode only.	Position	000.0-999.9	Level 3	NO

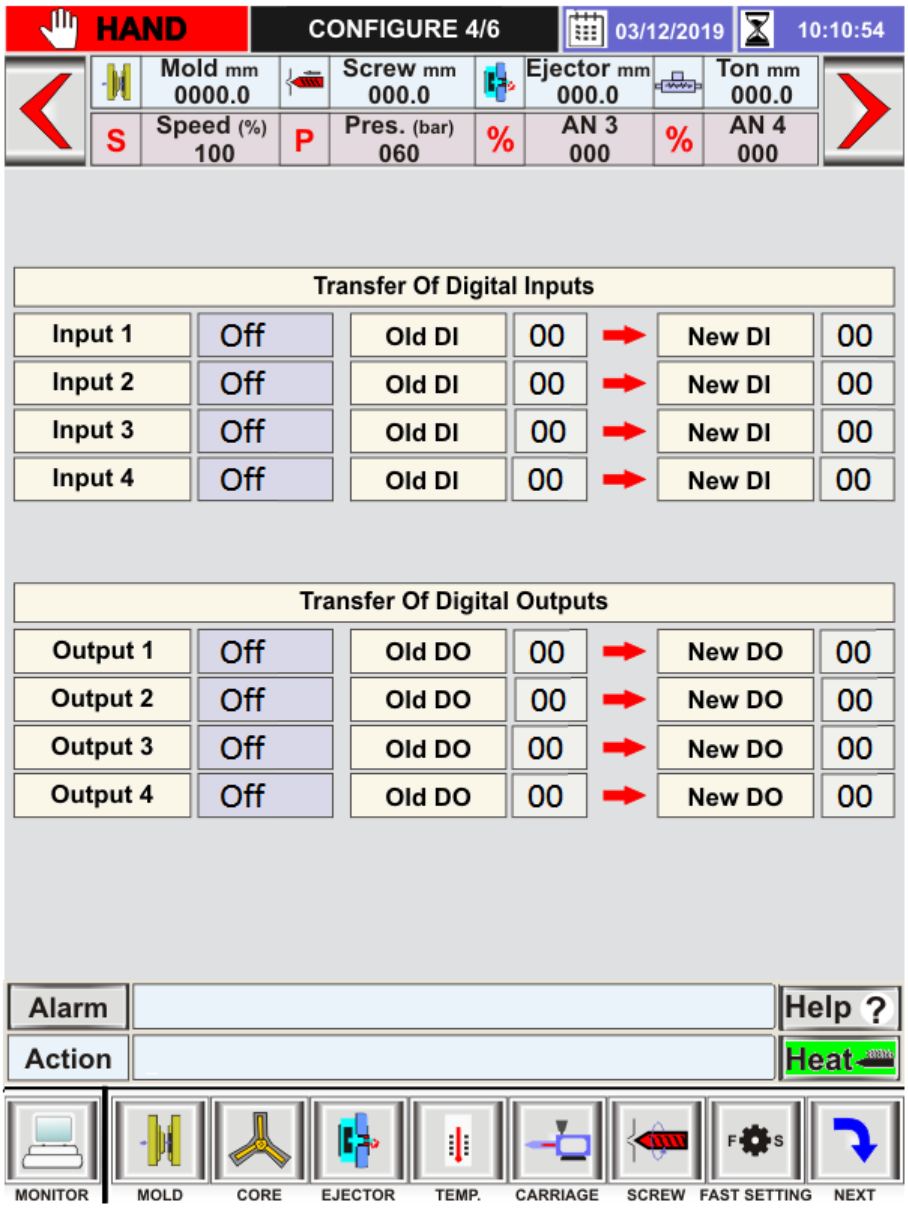
		Accumulator:Charge Delay		Set accumulator charge delay	Delay	00.0-99.9	Level 3	NO

Screen Page: CONFIGURE 4/6

CONFIGURE

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

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



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	CONFIGURE 4/6	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
		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	CONFIGURE 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
3	CONFIGURE 4/6	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
		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	CONFIGURE 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
		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
5	CONFIGURE 4/6	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
		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
6	CONFIGURE 4/6	Op2:Trans	If set to on, OP2 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
		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
7	CONFIGURE 4/6	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
		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	CONFIGURE 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

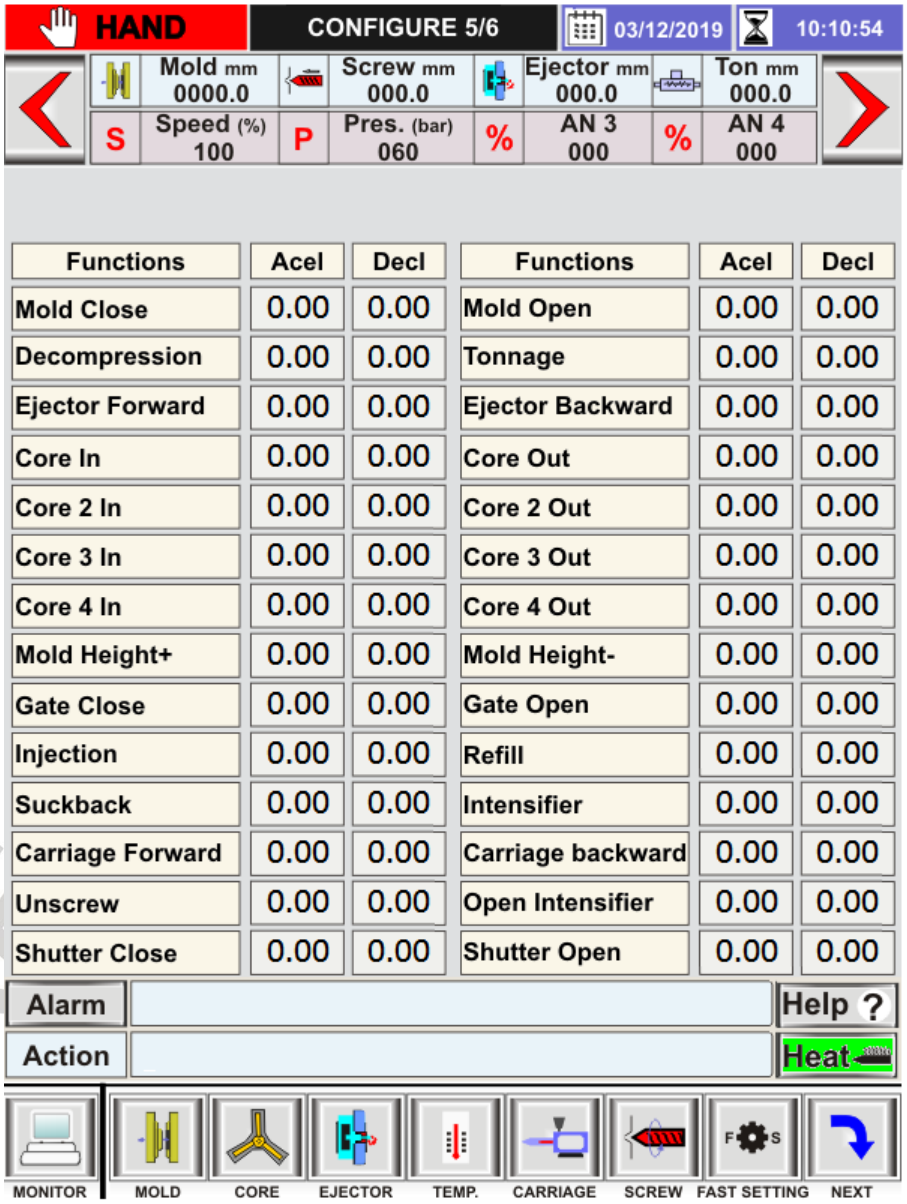
			to new digital output (spare) place.					
		Old DO	Enter old faulty digital output number.	Select faulty digital output number	Number	00-64	Level 2	NO
		New DO	Enter new spare digital output number.	Select spare digital output number where faulty output shift	Number	00-64	Level 2	NO

Screen Page: CONFIGURE 5/6

CONFIGURE

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



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	CONFIGURE 5/6	Mold Closed		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
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in mold closed function	Decl	0-9.99 sec	Level 2	NO
2	CONFIGURE 5/6	Decompression		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Decompression function	Acel	0 -9.99 sec	Level 2	NO
				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	CONFIGURE 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 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Ejector Forward function	Decl	0-9.99 sec	Level 2	NO
4	CONFIGURE 5/6	Core IN		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core IN function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core IN Function	Decl	0-9.99 sec	Level 2	NO
5	CONFIGURE 5/6	Core 2 IN		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 2 IN function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 2 IN function	Decl	0-9.99 sec	Level 2	NO
6	CONFIGURE 5/6	Core 3 IN		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 3 IN function	Acel	0 -9.99 sec	Level 2	NO

				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 3 IN function	Decl	0-9.99 sec	Level 2	NO
7	CONFIGURE 5/6	Core 4 IN		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 3 IN function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 3 IN function	Decl	0-9.99 sec	Level 2	NO
8	CONFIGURE 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 Height + function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Mold Height + function	Decl	0-9.99 sec	Level 2	NO

9	CONFIGURE 5/6	Gate Closed		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Gate Closed function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Gate Closed function	Decl	0-9.99 sec	Level 2	NO
10	CONFIGURE 5/6	Injection		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Injection function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Injection function	Decl	0-9.99 sec	Level 2	NO
10	CONFIGURE 5/6	Suck back		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Suck back function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Suck back Function	Decl	0-9.99 sec	Level 2	NO

11	CONFIGURE 5/6	Carriage Forward		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Carriage Forward function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Carriage Forward function	Decl	0-9.99 sec	Level 2	NO
12	CONFIGURE 5/6	Unscrew		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Unscrew function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Unscrew function	Decl	0-9.99 sec	Level 2	NO
13	CONFIGURE 5/6	Shutter Closed		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Shutter Closed function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in	Decl	0-9.99 sec	Level 2	NO

				Shutter Closed function				
14	CONFIGURE 5/6	Mold Open		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Mold Open function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Mold Open function	Decl	0-9.99 sec	Level 2	NO
15	CONFIGURE 5/6	Tonnage		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Tonnage function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Tonnage function	Decl	0-9.99 sec	Level 2	NO
16	CONFIGURE 5/6	Ejector Backward		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Ejector Backward function	Acel	0 -9.99 sec	Level 2	NO

				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	NO
17	CONFIGURE 5/6	Core OUT		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core OUT function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 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	NO
18	CONFIGURE 5/6	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
				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	CONFIGURE 5/6	Core 3 OUT		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
				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
20	CONFIGURE 5/6	Core 4 Out		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
				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	CONFIGURE 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

				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Mold Hight - function	Decl	0-9.99 sec	Level 2	NO
22	CONFIGURE 5/6	Gate Open		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Mold Height - function	Acel	0 -9.99 sec	Level 2	NO
				0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 3 OUT function				
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Gate Open function	Decl	0-9.99 sec	Level 2	NO
22	CONFIGURE 5/6	Refilling		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Refilling function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output	Decl	0-9.99 sec	Level 2	NO

				maximum in Refilling function				
23	CONFIGURE 5/6	Intensifier		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Intensifier Function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Intensifier function	Decl	0-9.99 sec	Level 2	NO
24	CONFIGURE 5/6	Carriage Backward		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Carriage Backward function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Carriage Backward function	Decl	0-9.99 sec	Level 2	NO
25	CONFIGURE 5/6	Open Instant		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Open Instant function	Acel	0 -9.99 sec	Level 2	NO

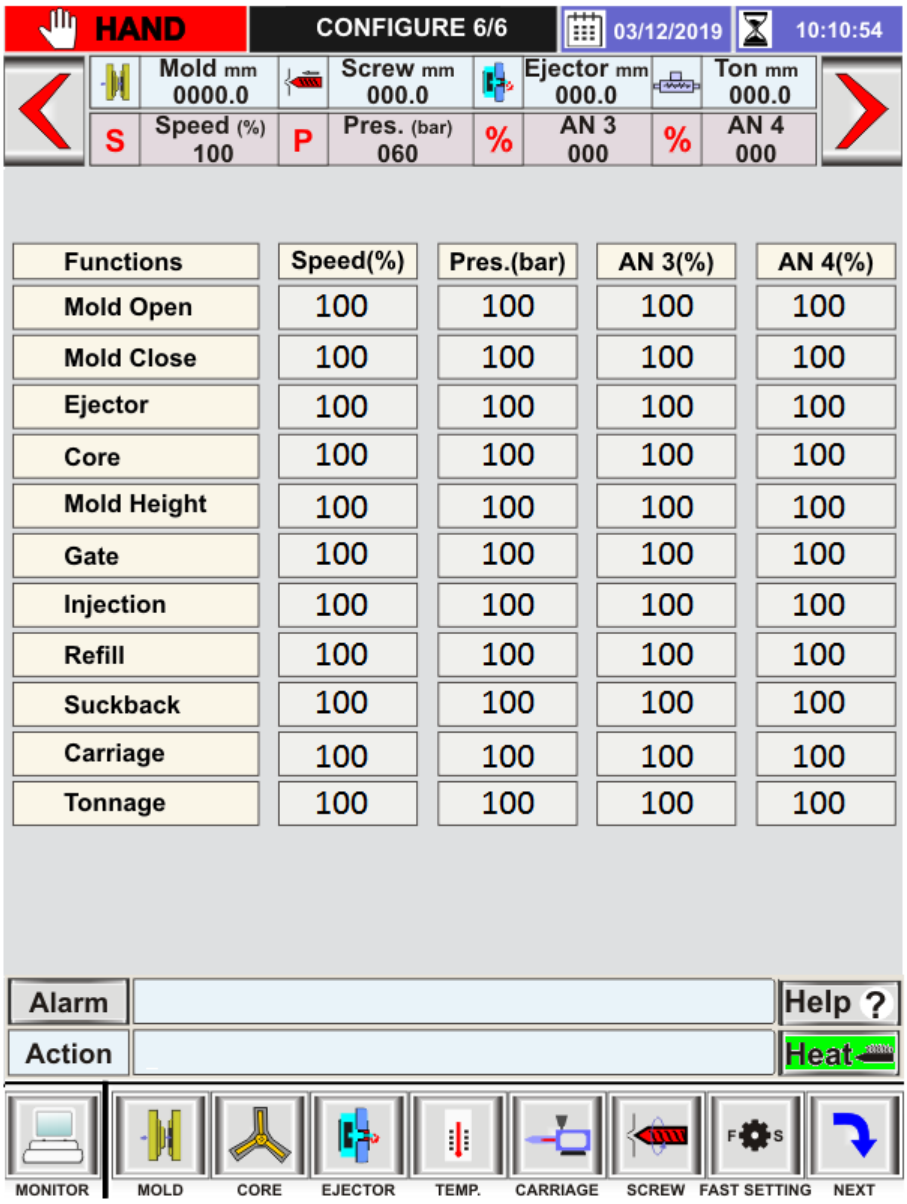
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Open Instant function	Decl	0-9.99 sec	Level 2	NO
26	CONFIGURE 5/6	Shutter Open		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Shutter Open function	Acel	0 -9.99 sec	Level 2	NO
				Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Shutter Open function	Decl	0-9.99 sec	Level 2	NO

Screen Page: CONFIGURE 6/6

CONFIGURE

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



Sr No	Page Name	Message Of Parameter On Screen	Function Description	Parameter Description	Parameter Description		Operating Password Level	Part Of Memory
					Parameter Type	Range		
1	CONFIGURE 6/6	Mold Open		This value define the maximum permitted pressure setting in all mold Open function	Pressure	000-255 Bar	Level 3	NO
				This value define the maximum permitted Speed setting in all mold Open function	Speed	000%-100%	Level 3	NO
				This value define the maximum permitted AN 3 setting in all mold Open function	AN 3	000%-100%	Level 3	NO
				This value define the maximum permitted AN 4 setting in all mold Open function	AN4	000%-100%	Level 3	NO
2	CONFIGURE 6/6	Mold closed		This value define the maximum permitted pressure setting in all Mold closed function	Pressure	000-255 Bar	Level 3	NO
				This value define the maximum permitted Speed setting in all Mold closed function	Speed	000%-100%	Level 3	NO
				This value define the maximum permitted AN3	AN 3	000%-100%	Level 3	NO

				setting in all Mold closed function				
				This value define the maximum permitted AN4 setting in all Mold closed function	AN4	000%-100%	Level 3	NO
3	CONFIGURE 6/6	Ejector		This value define the maximum permitted pressure setting in all Ejector function	Pressure	000-255 Bar	Level 3	NO
				This value define the maximum permitted Speed setting in all Ejector function	Speed	000%-100%	Level 3	NO
				This value define the maximum permitted AN 3 setting in all Ejector function	AN 3	000%-100%	Level 3	NO
				This value define the maximum permitted AN4 setting in all Ejector function	AN4	000%-100%	Level 3	NO
4	CONFIGURE 6/6	Core		This value define the maximum permitted pressure setting in all Core function	Pressure	000-255 Bar	Level 3	NO
				This value define the maximum permitted Speed setting in all Core function	Speed	000%-100%	Level 3	NO

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

				in all Gate function				
				This value define the maximum permitted AN3 setting in all Gate function	AN 3	000%-100%	Level 3	NO
				This value define the maximum permitted AN4 setting in all Gate function	AN4	000%-100%	Level 3	NO
7	CONFIGURE 6/6	Injection		This value define the maximum permitted pressure setting in all Injection function	Pressure	000-255 Bar	Level 3	NO
				This value define the maximum permitted Speed setting in all Injection function	Speed	000%-100%	Level 3	NO
				This value define the maximum permitted AN3 setting in all Injection function	AN 3	000%-100%	Level 3	NO
				This value define the maximum permitted AN4 setting in all Injection function	AN4	000%-100%	Level 3	NO
8	CONFIGURE 6/6	Refilling		This value define the maximum permitted pressure setting in all Refilling function	Pressure	000-255 Bar	Level 3	NO
				This value define the maximum permitted	Speed	000%-100%	Level 3	NO

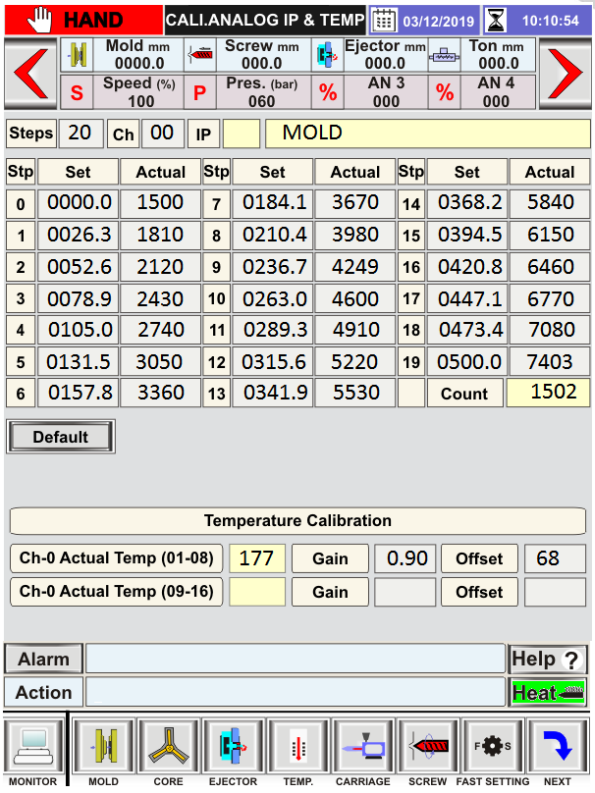
				Speed setting in all Refilling function				
				This value define the maximum permitted AN3 setting in all Refilling function	AN 3	000%-100%	Level 3	NO
				This value define the maximum permitted AN4 setting in all Refilling function	AN4	000%-100%	Level 3	NO
9	CONFIGURE 6/6	Suck back		This value define the maximum permitted pressure setting in all Suck back function	Pressure	000-255 Bar	Level 3	NO
				This value define the maximum permitted Speed setting in all Suck back function	Speed	000%-100%	Level 3	NO
				This value define the maximum permitted AN3 setting in all Suck back function	AN 3	000%-100%	Level 3	NO
				This value define the maximum permitted AN4 setting in all Suck back function	AN4	000%-100%	Level 3	NO
10	CONFIGURE 6/6			This value define the maximum permitted pressure setting in all Carriage function	Pressure	000-255 Bar	Level 3	NO

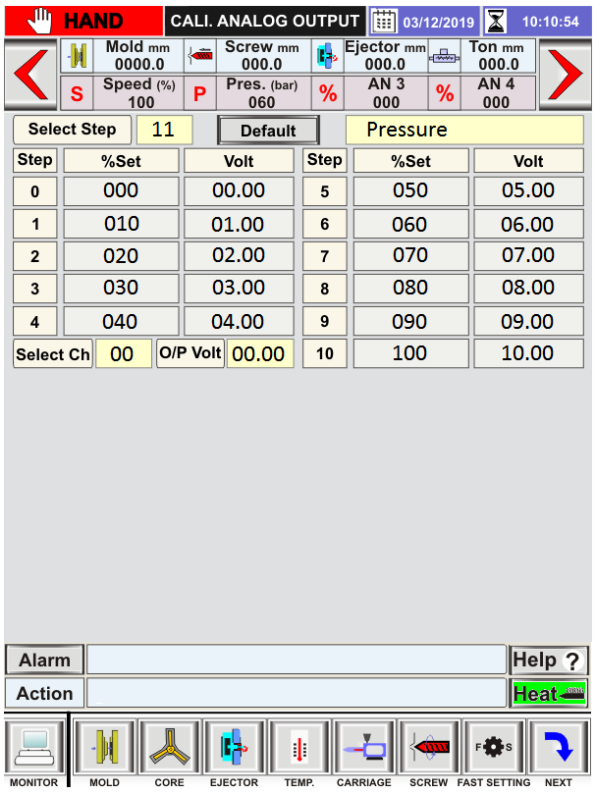
		Carriage		This value define the maximum permitted Speed setting in all Carriage function	Speed	000%-100%	Level 3	NO
				This value define the maximum permitted AN3 setting in all Carriage function	AN 3	000%-100%	Level 3	NO
				This value define the maximum permitted AN4 setting in all Carriage function	AN4	000%-100%	Level 3	NO
11	CONFIGURE 6/6	Tonnage		This value define the maximum permitted pressure setting in all Tonnage function	Pressure	000-255 Bar	Level 3	NO
				This value define the maximum permitted Speed setting in all Tonnage function	Speed	000%-100%	Level 3	NO
				This value define the maximum permitted AN3 setting in all Tonnage function	AN 3	000%-100%	Level 3	NO
				This value define the maximum permitted AN4 setting in all Tonnage function	AN4	000%-100%	Level 3	NO

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 “CALI.AI”
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.
7. 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.





Page Screen: CALI.AO

The procedure for calibration of analog input is as follows.

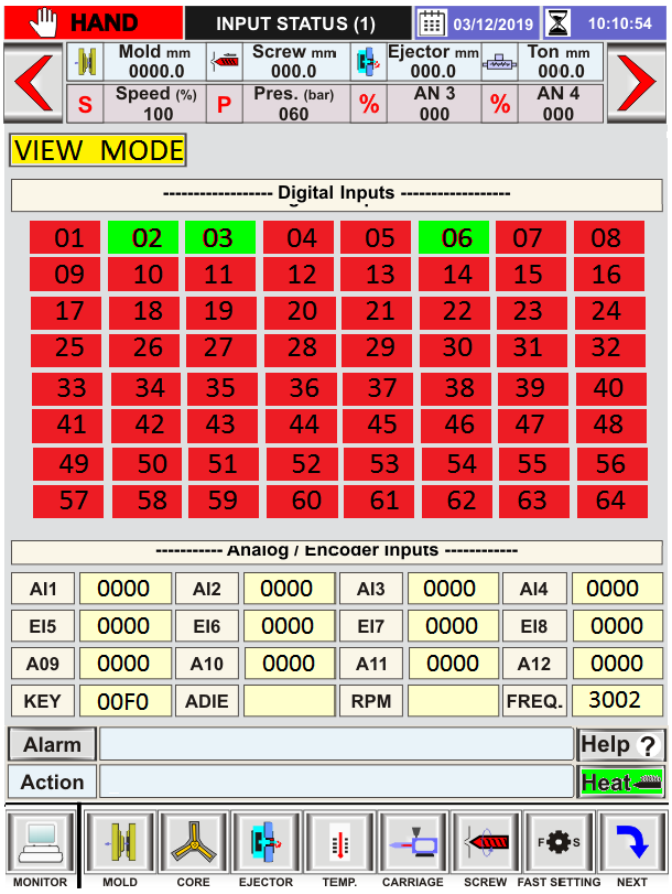
1. Go to the calibration analog output screen page by pressing “CALI.AO” on Menu Key Bar.
2. If you are in another Menu Bar , otherwise pressing “next “ or “Previews” key, And go to the “CALI.AO”
3. So screen appears CALI.ANALOG OUTPUT. There will be no changes in this screen, for that.
4. Go to the 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.
7. 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.

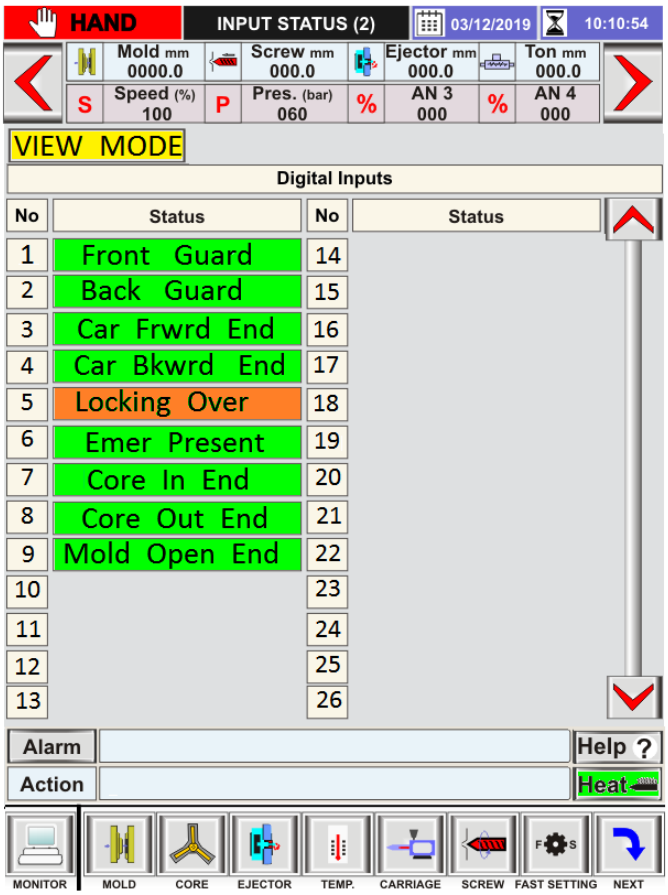
Page Screen: CALI.TEMP.

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

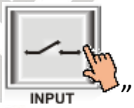
1. Go to the calibration temp by pressing “ CALI.TEMP ” on Menu Key Bar.
2. If you are in another Menu Bar , otherwise pressing “next “ or “Previews” key, And go to the “Output”
3. Insert mili volt generator in zone 1 or link in zone 1(+ and -)of “ Temperature section “ and set 0 mV in it and verify 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 “
5. 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.



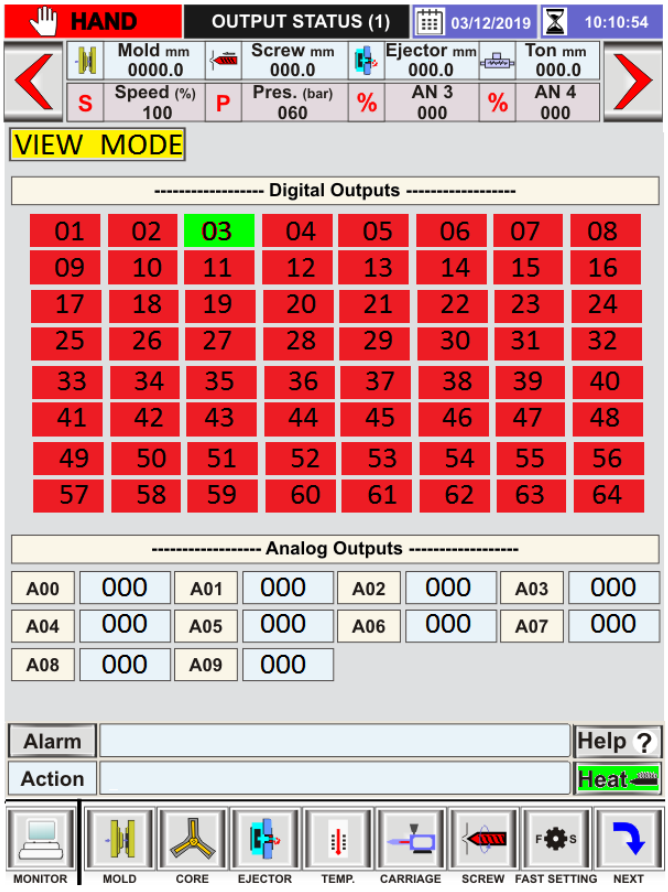


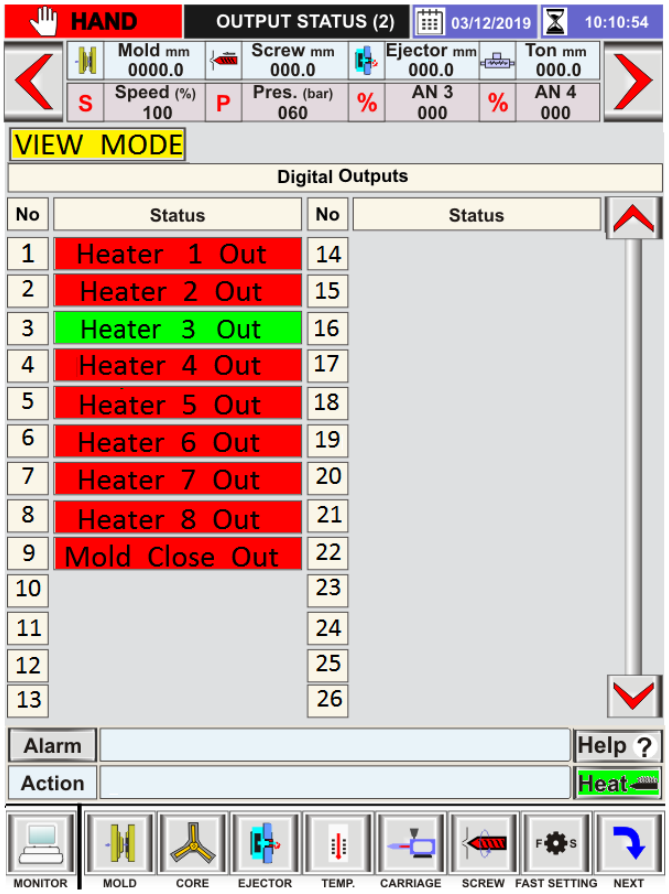
The following is how to show the digital inputs.

1. Go to the input Status by pressing “ 

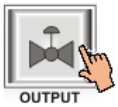
” on Menu Key Bar.
2. If you are in another Menu Bar , otherwise pressing “next “ or “Previews” key, And go to the “Output”
3. So screen appears INPUT STATUS (1) , this screen will simply show only digital input numbers only.
4. If you see a screen with inputs name please press next page “  “key on top 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.





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

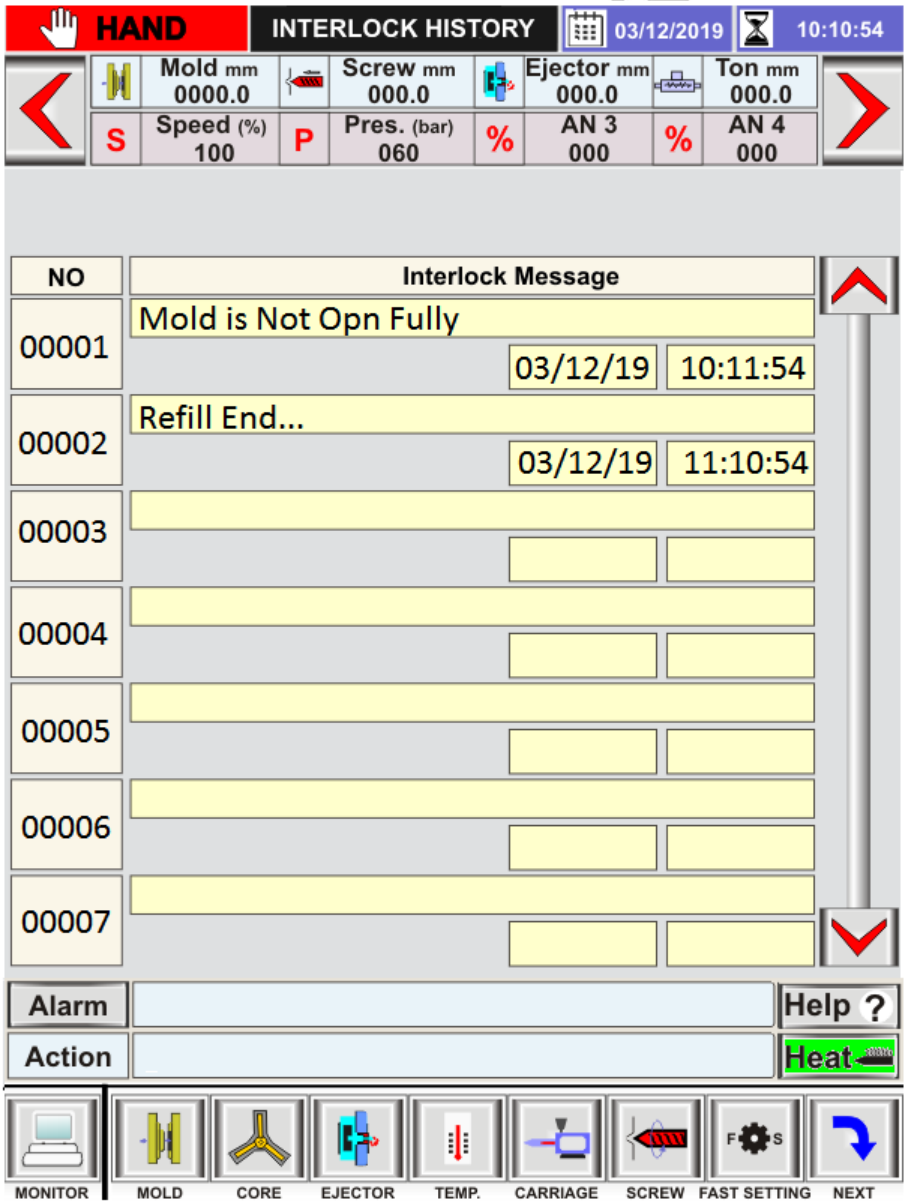
1. Go to the Output Status by pressing “ 

” 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".
6. 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" " key once on the bottom of the Touch Screen.
2. Now Screen 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



Following are the different interlock messages.

Sr.No.	Operation	Interlocks Messages On Screen	Description Of Messages	Type Of Mode		
				Hand	Semi Auto	Fully Auto
1	Mold Open	IL..MOLD OPEN END.	Mold fully open end	Y	Y	Y
		IL..MOLD IS NOT OPEN FULLY	Mold is not fully open		Y	Y
		IL.Mold OPN/CLS Limit ON	If both mold open and mold close input is present	Y	Y	y
		IL_Mold Open Timer Over..	Mold Open Total Time Over	y	y	y
		IL_Clamppres switch on	Clamp switch input present	Y	Y	Y
2	Mold Close	IL..MOLD IS NOT FULLY CLOSED	Mold fully Close end		Y	Y
		IL..MOLD SAFETY TIME OVER	Mold Safety time over	Y	Y	Y
		IL..MOLD CLOSE TIMER OVER	Mold open close limits on	Y	Y	Y
		IL..LOCKING OVER	Mold is fully close	Y	Y	Y
		IL..MOLD CLOSE TIMER OVER	Mold close total time over	Y	Y	Y
		IL_ Safety Gate Interrupted		Y	Y	y
		IL_MClsSafety Sensor Break		y	y	y
3	Unit Forward	IL..UNIT FORWARD END REACHED	Carriage Forward End	Y	Y	y
		IL_ Nozzle Guard Absent..	Nozzle guard input present		y	y
4	Unit Backward	IL..UNIT BACKWARD END REACHED	Carriage Backward End	Y	Y	y
		Il. Carriage Swivel not at home	Carriage swivel input is defined	Y	Y	y
		IL.Carriage Swivel Option On	Option is done ON	Y	Y	Y
5	Injection	IL..TEMPERATURE IS LOW	Temperature is low	Y	y	Y
		IL..TEMPERATURE IS HIGH	Temperature is High	y	y	Y
		IL Injection End	Injection End	y	y	Y
6	Refill	IL..REFILL END.	Refill End	y	y	Y
		IL..TEMPERATURE IS LOW	Temperature is low	y	y	Y
		IL..TEMPERATURE IS HIGH	Temperature is High	y	y	Y
		IL. refill timer over	Set refilling time	Y	Y	Y
7	Suck Back	IL..TEMPERATURE IS LOW	Temperature is low	y	y	Y
		IL..TEMPERATURE IS HIGH	Temperature is High	y	y	Y
		IL..SUKBAK END.	Suck back End	y	y	Y
8	Ejector Forward	IL..EJECTOR FORWARD END.	Ejector Forward end	y	y	Y
9	Ejector Backward	IL..EJECTOR BAKWARD END.	Ejector Backward end	y	y	Y
		IL..EJECTOR IS NOT BAKWARD.	Ejector not back	y	y	Y
		IL..EJECTOR PLATE BACK IS NOT PRESSED.	Ejector plate is not back	y	y	Y
10	Core in	IL_ mold not in core in position	Mold close position not present for core IN	y	y	Y
11	Core 1 In	IL..CORE 1 IN END.	Core 1 in End	y	y	Y
	Core out	IL mold not in core out position	Mold OPN position not present for core out	y	y	Y
12	Core 1 Out	IL..CORE 1 OUT END.	Core 1 out End	y	y	Y
		IL..CORE 1 PARTIAL OUT END.	Core 1 not out	y	y	Y
13	Core 2 In	IL..CORE 2 IN END.	Core 2 in End	y	y	Y
14	Core 2 Out	IL..CORE 2 OUT END.	Core 2 out End	y	y	Y
		IL..CORE 2 PARTIAL OUT END.	Core 2 not out	y	y	Y

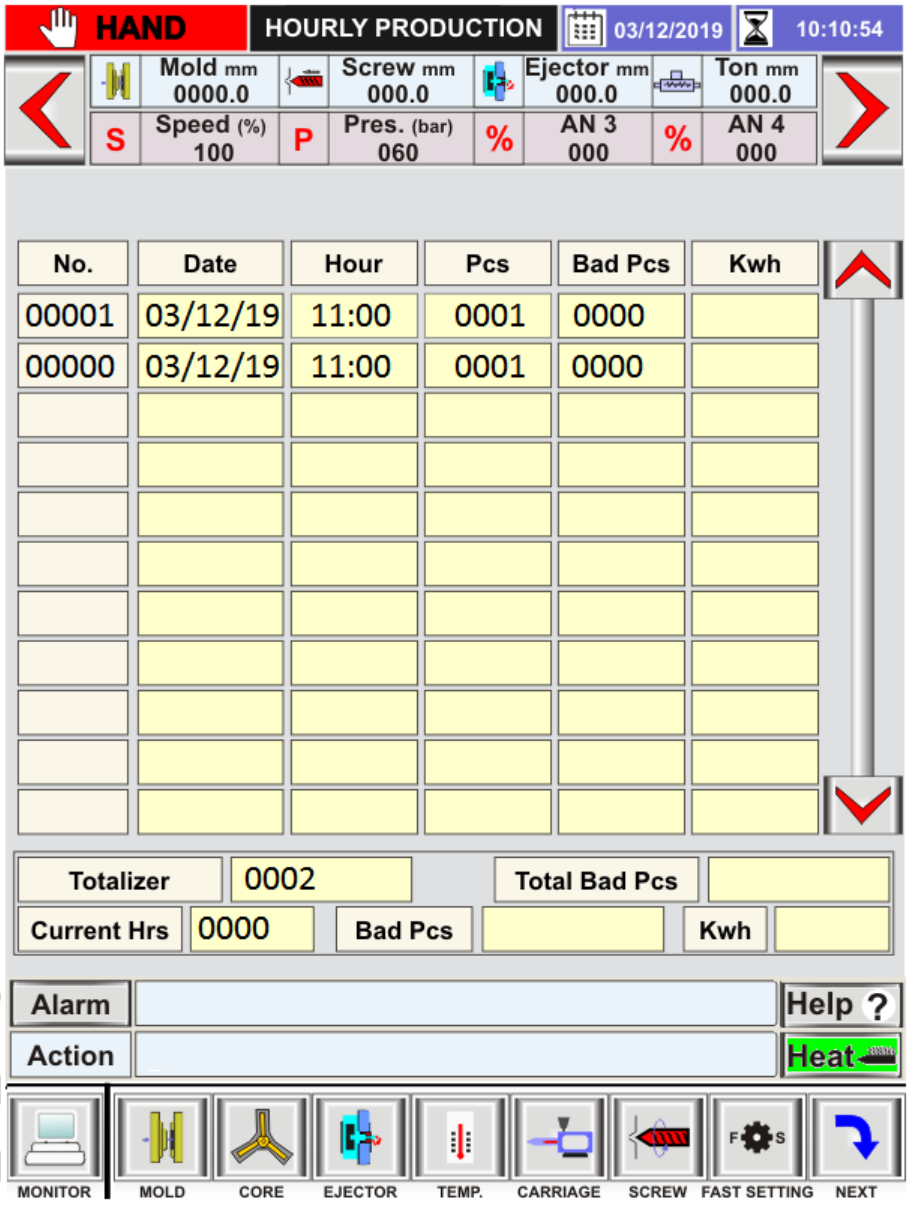
15	Core 3 In	IL..CORE 3 IN END.	Core 3 in End	y	y	Y
16	Core 3 Out	IL..CORE 3 OUT END.	Core 3 out End	y	y	Y
		IL..CORE 3 PARTIAL OUT END.	Core 3 not out	y	y	Y
17	Core 4 In	IL..CORE 4 IN END.	Core 4 in End	y	y	Y
18	Core 4 Out	IL..CORE 4 OUT END.	Core 4 out End	y	y	Y
		IL..CORE 4 PARTIAL OUT END.	Core 4 not out	y	y	Y
19	Mold Height Min.	IL..MOLD HEIGHT MINIMUM END.	Mold Height minimum End	y	y	Y
		IL Mold Height Min.	Mold Height minimum	y	y	Y
20	Mold Height Max.	IL..MOLD HEIGHT MAXIMUM END.	Mold Height maximum End	y	y	Y
		IL Mold Height Max.	Mold Height maximum	y	y	y
21	Temperature	IL..TEMPERATURE IS LOW.	Temperature is low	y	y	y
		IL. Thermocouple is open X	If any thermocouple is open	y	y	y
		IL..TEMPERATURE IS HIGH.	Temperature is High	y	y	Y
		IL..OIL TEMPERATURE IS HIGH.	Oil temperature is high	y	y	y
		IL. Heat is OFF	If heat key is On during injection	Y	Y	y
22	Robot	IL_ Robot Time out	If robot function is ON			y
		IL _Robot Not at Home Position	Robot Not home Position		y	y
23	Purge	IL _Auto Purge Cycles Zero	If purge mode is ON		y	Y
		IL_ Auto Purge Max Tim Over	If Purge mode is ON and time is zero		y	y
24	password	IL_18001.Contact Supplier	Password 1 from machine Manuf.	Y		
		IL_18002.Contact Supplier;	Password 2 from machine manuf.	Y		
		IL_18003.Contact Supplier	Password 3 from machine Manuf.	y		
25	Auto Die set	IL_ Auto Die set Fails:Lvl1	During Auto die set if input not comes proper	y	y	y
		IL_AutoDie set Fails:Lvl2		y	y	y
26	Gate	IL_ Gate Open End..	Gate Open End		y	y
		IL _Gate Close End..	Gate Close End		y	y
27	Shutter	IL_ Shutter Gap I/P On.	Shutter gap input is present	y	y	y
		IL _Shutter Close/Open Limit On	If both Shutter opn and close input is present			
		IL_ Shutter Not Closed..	Shutter Not Close		y	y
		IL_ Shutter Not Open..	Shutter Not Open		y	y
		IL _Pres Safety IP Operated			y	y
		IL_ Mold clamp Prot IP Present			y	y
		IL_ Mold clamp Prot1 IP Fail			y	y
		IL _Mold clamp Prot2 IP Fail			y	y
29	Slide	IL_ Slide Not In Position	Slide in End		y	y
30	Alarm	AL_LubricatinPresLow.		y	y	y
		AL_Filling End...		y	y	
		AL_Vari.in Analog I/p			y	y
		AL_HeaterCurrent Card Absent		y	y	y
		AL_Heater Current Low		y	y	y
		AL_Heater/SSR Fail		y	y	y
				y	y	y
				y	y	y
				y	y	y

				y	y	y
		Al. Hopper Is Empty...	Hopper input is present	y	y	y
		Al. Lubrication Oil Level Lo	Lubrication level input present	y	y	y
31	Common	IL..FRONT GUARD OPEN.	Front door open	y	y	y
		IL..BACK GUARD OPEN.	Rear door open	y	y	y
		IL..TOTAL CYCLE TIME OVER.	Cycle time over	y	y	y
		IL..EMERGENCY / MOTOR NOT AT DELTA.	Emergency press	y	y	y
		IL..HYDRAULIC MOTOR NOT AT DELTA.	Hydraulic motor not on Delta	y	y	y
		IL _Single Phase Prevent On	Single phase input present	y	y	y
		IL_ Oil Filter Clogged..	Oil filter input present	y	y	y
		IL _Lubrication .Motor Feedback Fail		y	y	y
		IL _Batch Count Over..	Set Batch reached	y	y	y
		IL _Lock Cylinder Over Stork		y	y	y
		IL_ 'Piece Fall Error!	Piece fall input not comes		y	y
				y	y	y

Page Screen: Hourly Production

1. Press" 

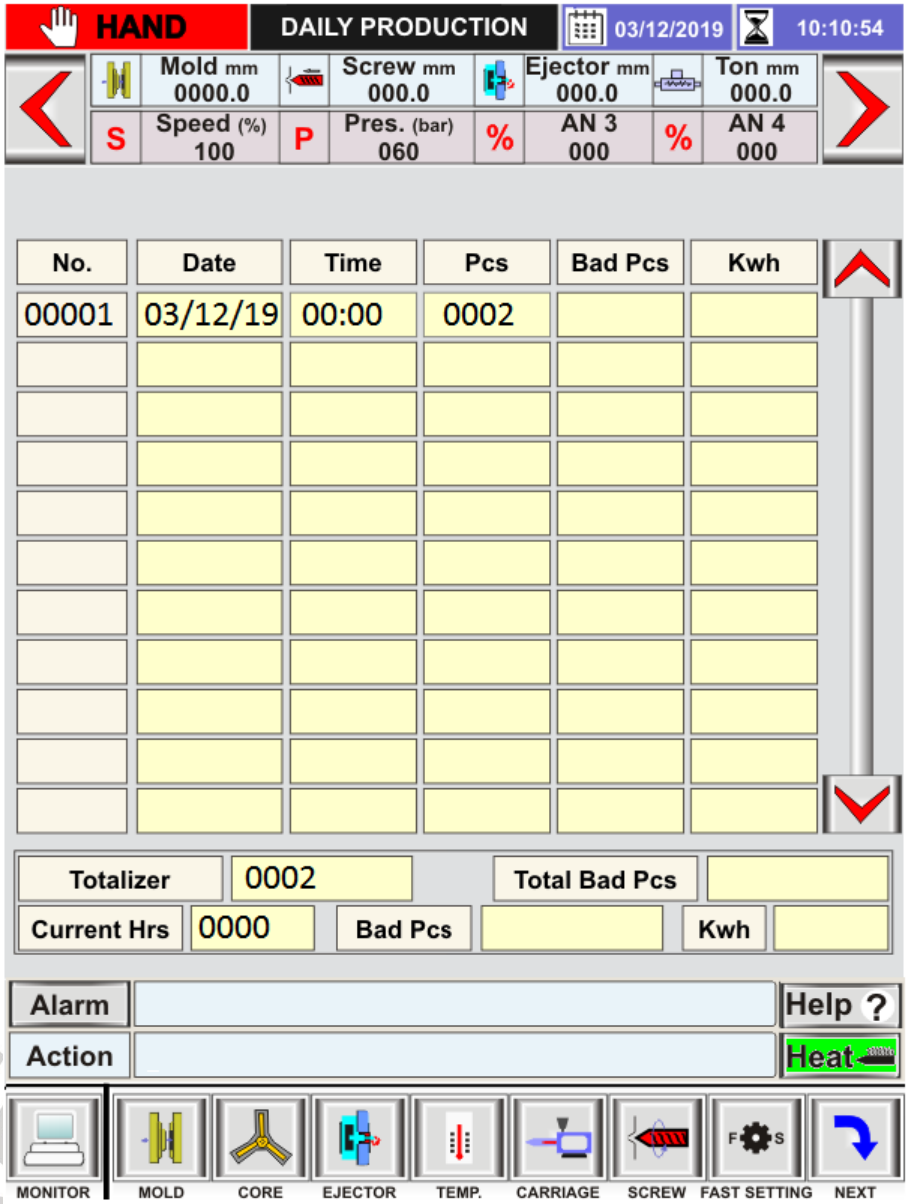
" key once on the bottom of the Touch Screen.
2. Now Screen Page: **HOURLY PRODUCTION** is displayed on screen in first line.
3. In this page hourly production shows of 24 hours, current hours shots show differently in this page.



Page Screen: Daily Production

4. Press" 

" key once on the bottom of the Touch Screen.
5. Now Screen 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.

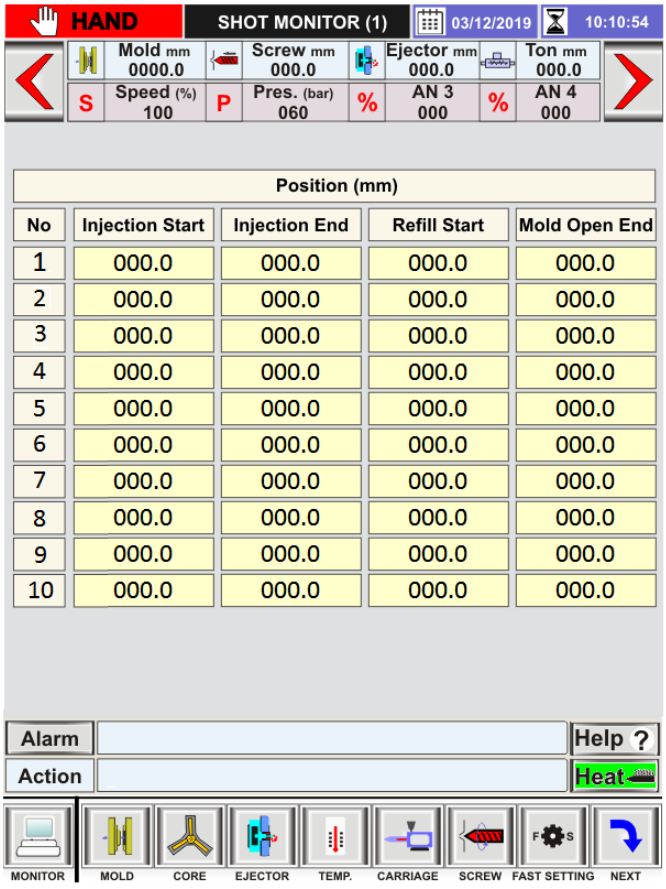


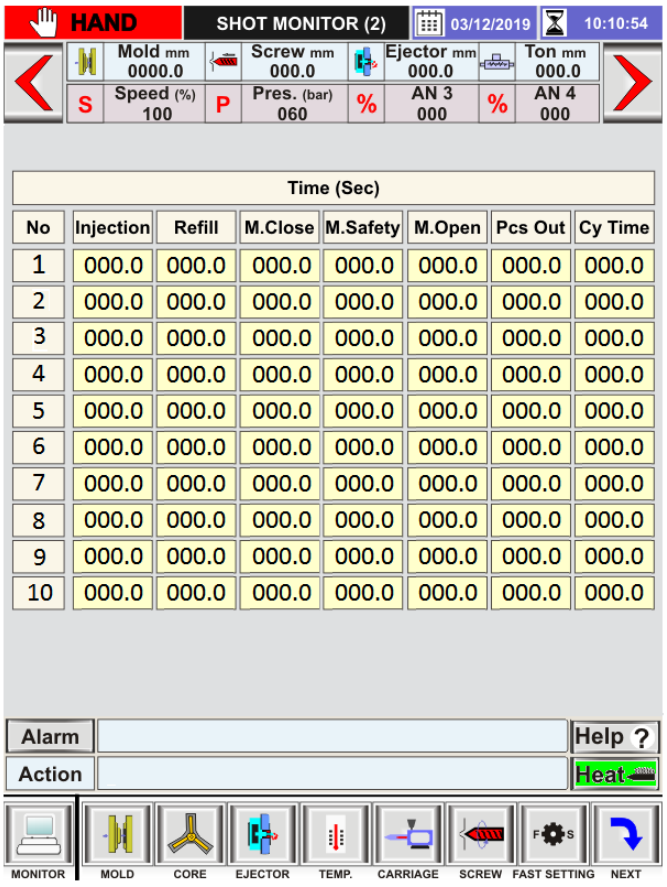
Page Screen: Shot Monitor

1. Press" 

" key once on the bottom of the Touch Screen.
2. Now Screen 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. Now Screen 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.

.



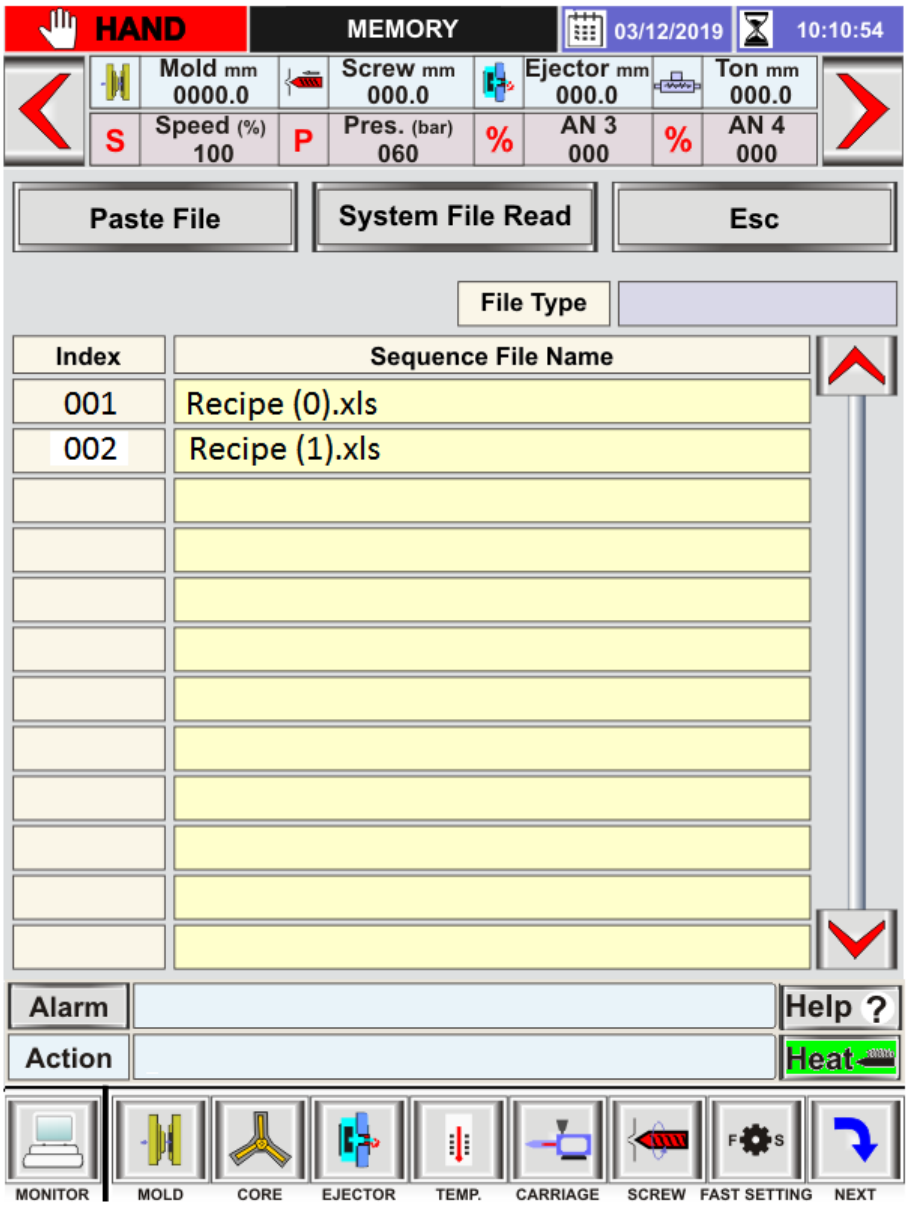


Page Screen: Memory

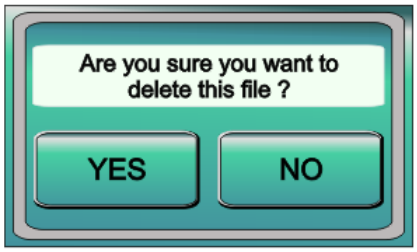
Press” 

” key once on the bottom of the Touch Screen.
Now Screen Page: **MEMORY** is displayed on screen in first line.

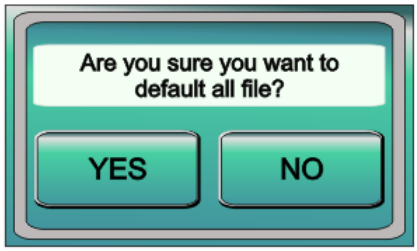
This is a mold memory setting screen page.



(1)

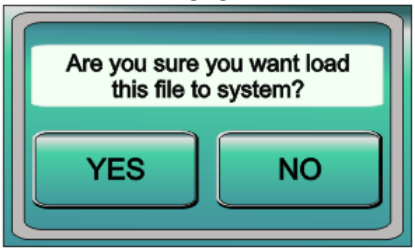


(2)

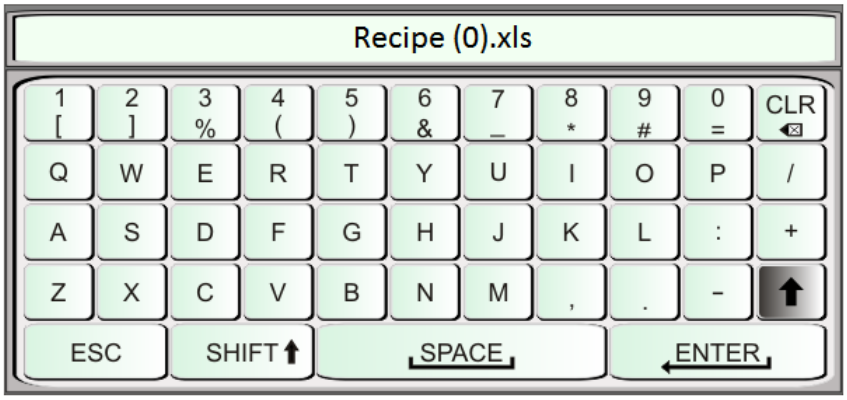


(3)

(4)

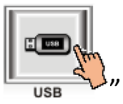


(5)

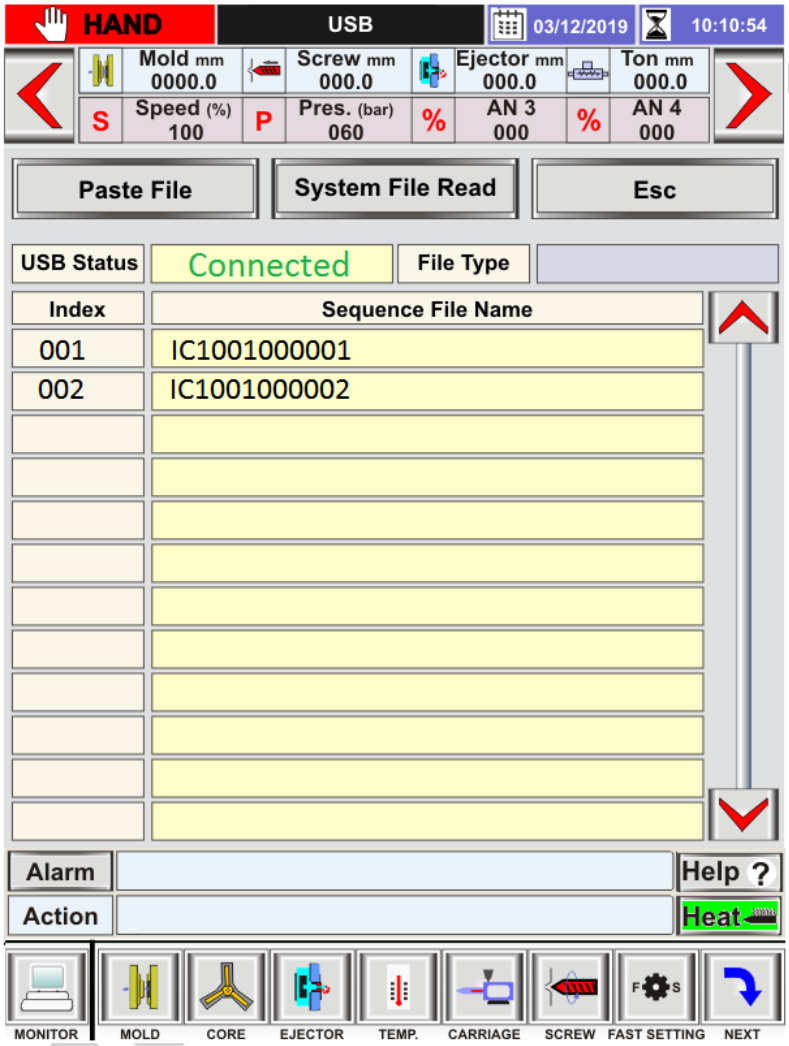


1. Go to mold memory setting page by pressing “MEMORY” on Menu Key Bar.
2. If you are in another Menu Bar , otherwise pressing “next “ or “Previews” key, And go to the “MEMORY”
3. So screen appears MEMORY is displayed on screen in first line.
4. Now press the “System File Read” key to save the mold that 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

Press" 

" key once on the bottom of the Touch Screen.
Now Screen Page: **USB** is displayed on screen in first line.



Page Screen: INDEX

Press" 

" key once on the bottom of the Touch Screen.
Now Screen 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.

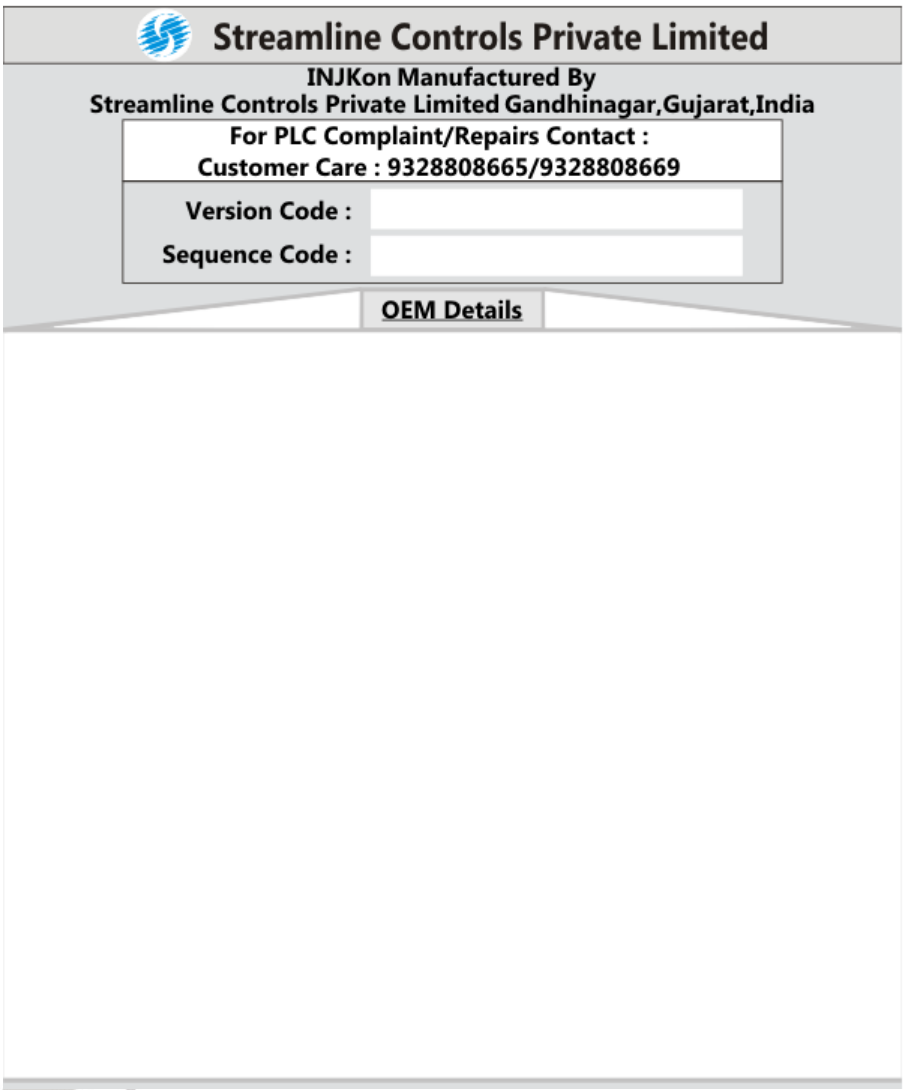
INDEX

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

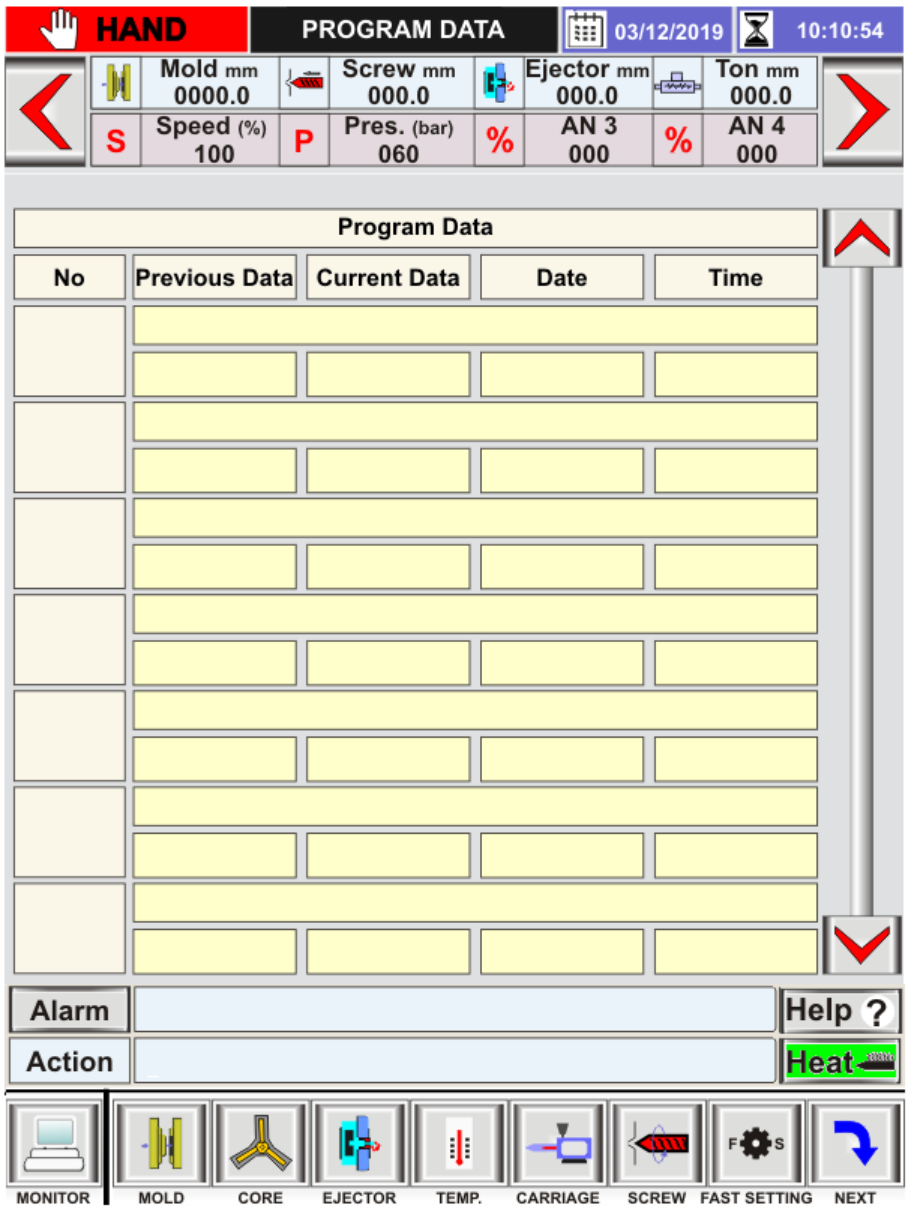
- **Start up screen page**
  This is the Start up screen, when you first turn on the power of plc this screen first appears.
  You can also see this screen by pressing “about us” touch key.
  In this screen you can see company information, customer care mobile number, Version Code, Machine Sequence Code and OEM information.



Page Screen: PROG. DATA

This is the Program data changes list screen,

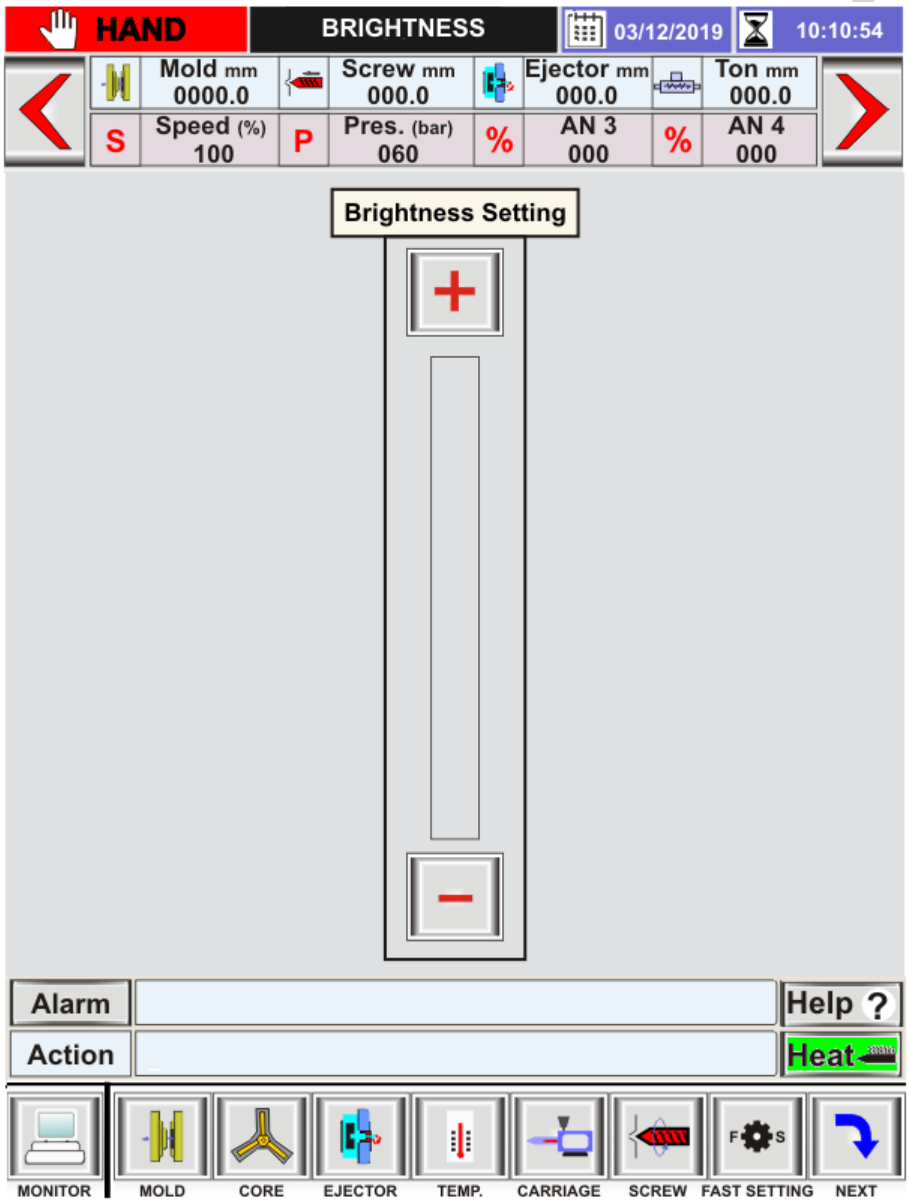
In this page you can see the list of parameter changes. For example, let's take a parameter like 100 in the temperature zone 1, now we save 200, so the first parameter is 100 and the current parameter is 200. So it will be shown in this list.



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:

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.

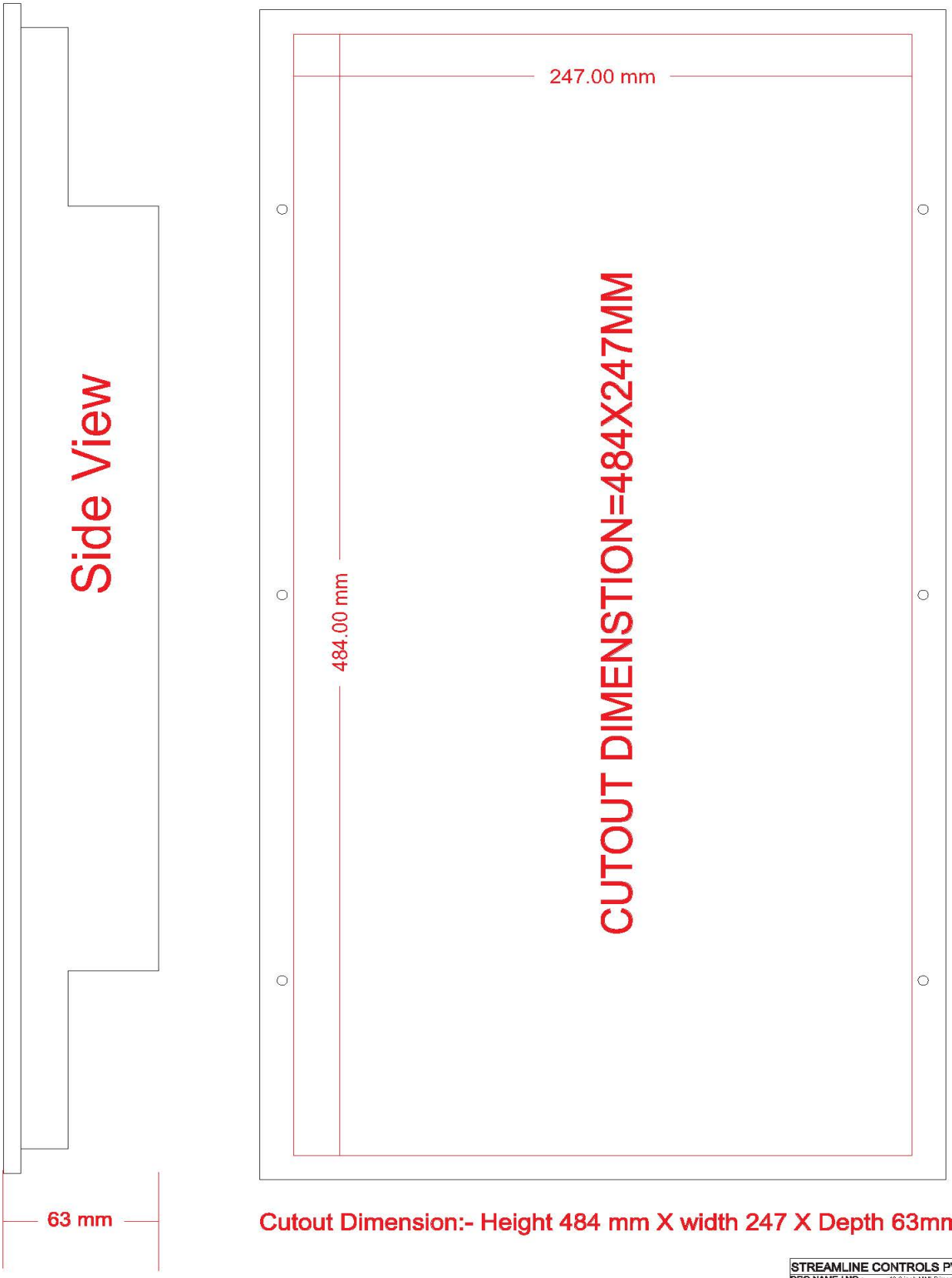
(6) DIE SET:

On Pressing **DIESET** Key the Only work DIESET Mode.

(7) PURGE:

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

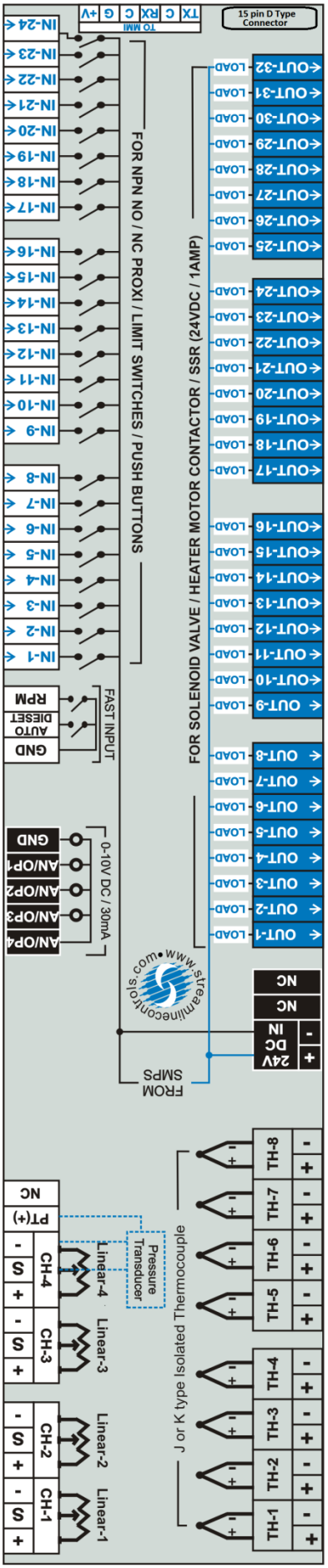
(M) DIMENSION DRAWING : mmi Dimension drawing



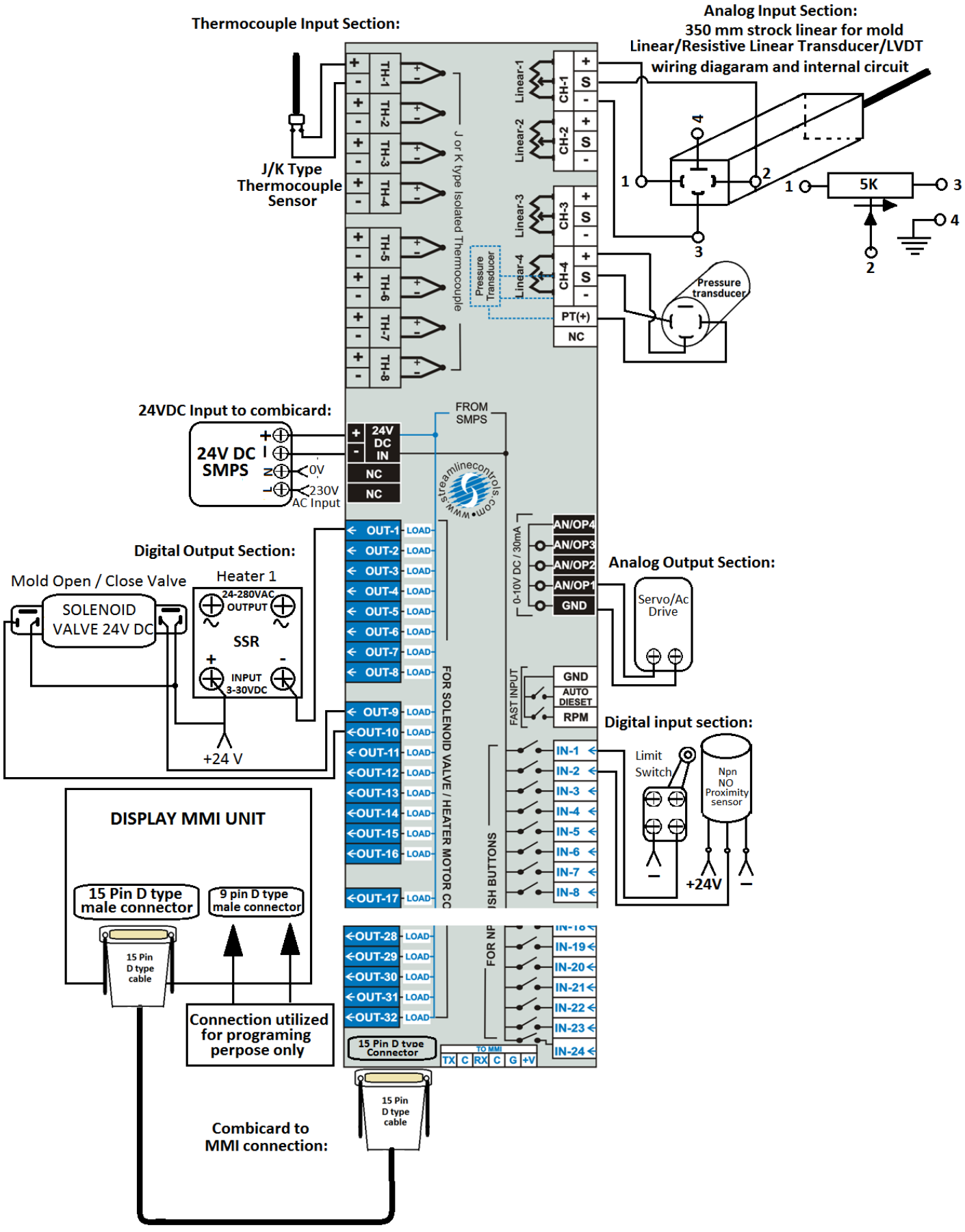
Cutout Dimension:- Height 484 mm X width 247 X Depth 63mm

STREAMLINE CONTROLS PVT LTD.	
DRG NAME / NO :	10.2 Inch MMI Dimension Drawing
REV DATE :	24-JAN-2019
DRG BY:	KULDEEPAK MEWADA
VERIFIED & APPROVED BY:	UTKANTH BHANDARI

(N) WIRING DIAGRAM: Front sticker of combicard



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