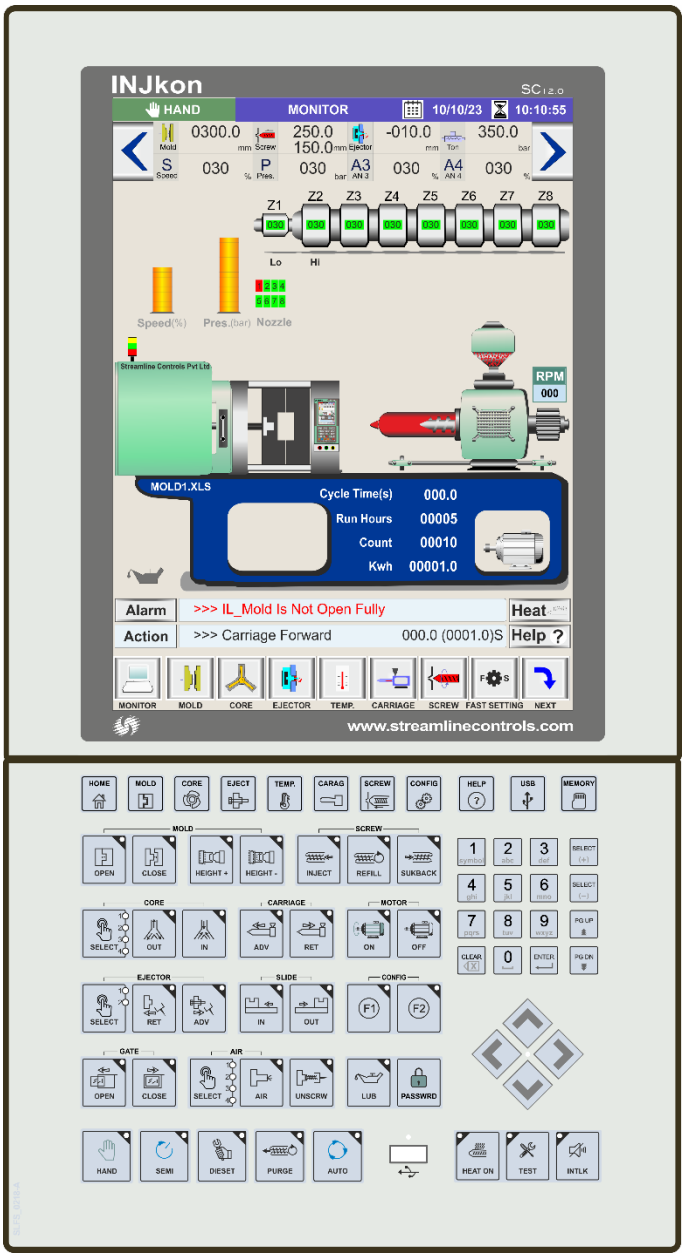
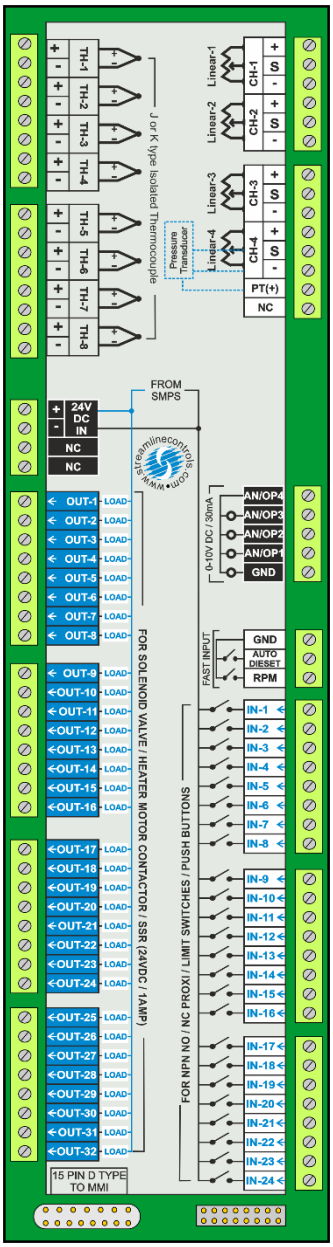
INJKon SC12

User Manual
Software Version V2.03

By streamline controls Private Limited





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 mold 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 mold 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.

સુરક્ષા માર્ગદર્શિકા

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 શરૂ 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:

(1) Specification:

Inputs Power	Voltage	24 V DC ± 1%
Temperature sensor	Thermocouple	J / K type Isolated
Digital Inputs	Proximity/ Limit Switches	NPN (NO type) ((0Volt) Negative In)
		24 Digital Inputs (10-30 Volt dc 50 mA Max.)(Expandable Up to +40)
Digital Outputs	Dc Valve, Relay, 24volt Dc Contactor	NPN Type ((0 Volt) Negative Out)
		32 Digital Outputs (For 24 V DC -1.5 Amp Max- MOSFET Driver Output)(Expandable Up to +32)
PWM Outputs	Proportional Valve	4 Channel PWM Outputs (If PWM is used for 4 channels then the total digital output will be 28)
Analog Outputs	For Servo/Ac Driver, Analog Valve	4 Chanel (0-to 10 Volt Dc Outputs 50 mA Max) (Expandable Up to +4)
Analog Inputs	For Linear, Pressure Transducer.	4 Chanel Analog Input (Expandable up to +4)
Environment	Temperature	0ºC to 55ºC
	Humidity	5 to 95% RH non-condensing

(2) Control Unit Introduction

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

(2.1) MMI Unit
(2.2) Combicard
(2.3) SMPS
(2.4) 15 Pin D Type Cabe

(2.1) MMI Unit:

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.

(2.2) CombiCard:

CombiCard 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.

(2.3) SMPS

230 Volt Ac Input and 24 Volt MW SMPS

(2.4) 15 Pin D Type

Use for MMI to combicard Communication.

(3) 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.

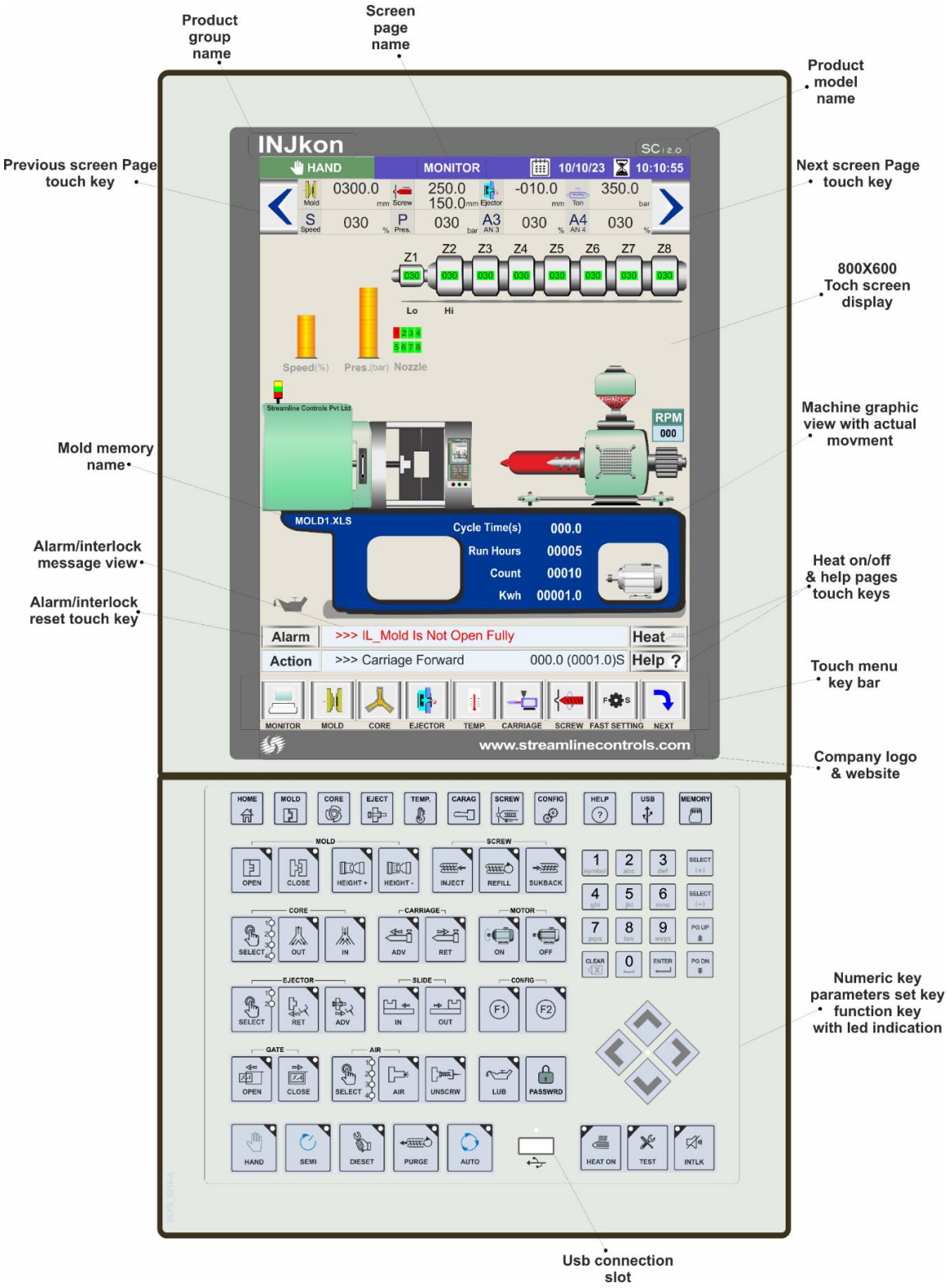
(4) Streamline controls Scope of supply

1. MMI (Man Machine Interface)
2. Mounting Clamp
3. Combi Card
4. Inter connecting cables.
5. SMPS.
6. IO List Print Copy

(5) Programming of the system

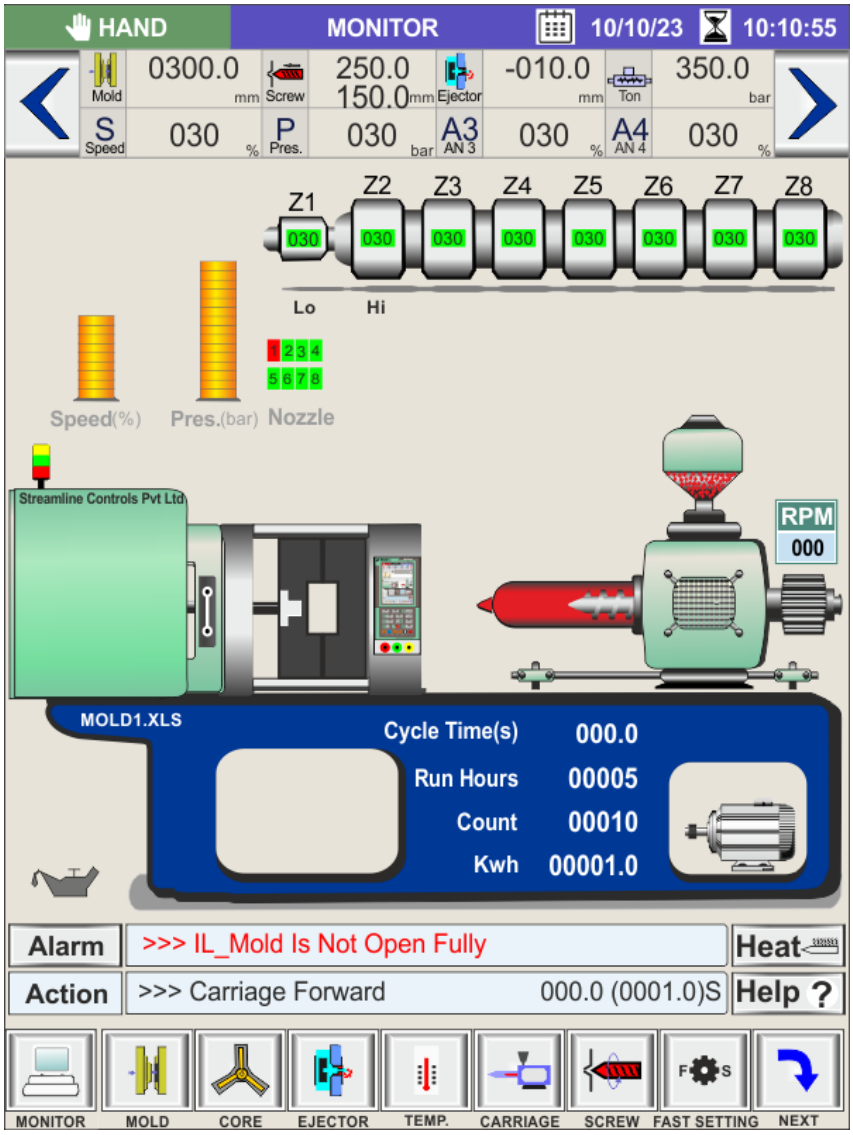
The PLC Controller will be programmed as per given Input output List / Sequence of the Injection Molding Machine.

(6) Operating Panel Description



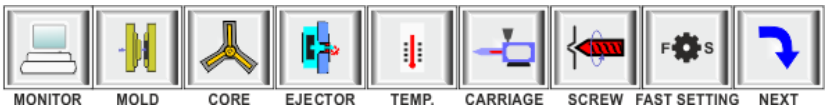
(6.1) Screen Page: MONITOR

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.



(6.2) Touch menu key bar

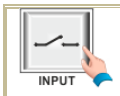
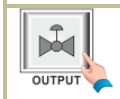
This is the touch menu bar where you can see the different touch keys, this menu key contains a parameter corresponding to the function, and the information for each key is as follows.



	Press the “MONITOR” Key at the bottom of the touch screen. The MONITOR page screen appears, containing machine overview. If you are on any page screen and press the monitor (home) key, you will directly go to the monitor screen.
	Press the “MOLD” Key at the bottom of the touch screen. The MOLD page screen appears, containing the settings for mold, mold height, hydraulic gate, shutter, and intensifier.
	Press the “CORE” Key at the bottom of the touch screen. The CORE page screen appears, containing the settings for cores.
	Press the “EJECTOR” Key at the bottom of the touch screen. The EJECTOR page screen appears, containing the settings for ejector and air.
	Press the “TEMPERATURE” Key at the bottom of the touch screen. The TEMPERATURE page screen appears, containing the settings for barrel zone temperature.
	Press the “CARRIAGE” Key at the bottom of the touch screen. The CARRIAGE page screen appears, containing the settings for carriage.
	Press the “SCREW “Key at the bottom of the touch screen. The SCREW page screen appears, containing the settings for injection, refill, suck back, intrusion, purge, second barrel.
	Press the “FAST SETTING” Key at the bottom of the touch screen. The “FAST SETTING page screen appears, containing the settings for most commonly used parameters of all function.
	Press the “NEXT” Key at the bottom of the touch screen. The NEXT page menu key appears.

Pressing the Next button will open the menu bar as shown below.

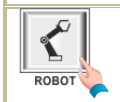
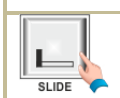
	Press the “PREVIOUS” Key at the bottom of the touch screen. The PREVIOUS page menu key appears.
	Press the “CONFIG” Key at the bottom of the touch screen. The CONFIG page screen appears, containing the settings for miscellaneous parameters of all functions.
	Press the “CALI.AI” Key at the bottom of the touch screen. The CALI.AI page screen appears, containing the settings for analog input calibration.
	Press the “CALI.AO” Key at the bottom of the touch screen. The CALI.AO page screen appears, containing the settings for analog output calibration.
	Press the “CALI.TEMP” Key at the bottom of the touch screen. The CALI.TEMP page screen appears, containing the settings for temperature calibration.

	Press the “INPUT” Key at the bottom of the touch screen. The INPUT page screen appears, you can check the status of the inputs.
	Press the “OUTPUT” Key at the bottom of the touch screen. The OUTPUT page screen appears, you can check the status of the output and also enable the outputs in test mode.

Pressing the Next button will open the menu bar as shown below.

	Press the “INTERLOCK” Key at the bottom of the touch screen. The INTERLOCK page screen appears, containing the history of interlock coming in semi, auto cycle.
	Press the “HOURLY” Key at the bottom of the touch screen. The HOURLY page screen appears, containing the history of hourly production data.
	Press the “DAILY” Key at the bottom of the touch screen. The DAILY page screen appears, containing the history of daily production data.
	Press the “SHOT MONITOR” Key at the bottom of the touch screen. The SHOT MONITOR page screen appears, containing the record of shot monitor data, like last cycle time of injection, refill, mold, total cycle time..., last position of mold open, injection start...
	Press the “MEMORY” Key at the bottom of the touch screen. The MEMORY page screen appears, On this page mold data can be save or load.
	Press the “USB” Key at the bottom of the touch screen. The USB page screen appears, On this page sequence program file, images, buttons, mold memory can be load or copy.

Pressing the Next button will open the menu bar as shown below.

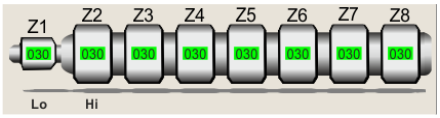
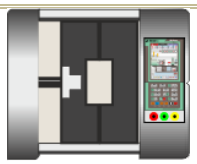
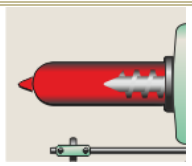
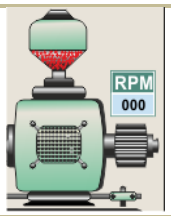
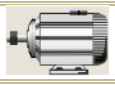
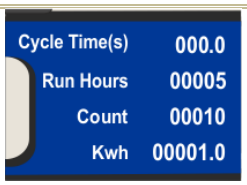
	Press the “INDEX” Key at the bottom of the touch screen. The INDEX page screen appears. A list of each page will be given in this page, by touching that page you can go directly to that page.
	Press the “ABOUT US” Key at the bottom of the touch screen. The ABOUT US page screen appears, In this page on one touch you can see OEM information, and on second touch view the sequence program and software version details.
	Press the “PRO.DATA” Key at the bottom of the touch screen. The PRO DATA page screen appears, In this page, you can see a record of what was entered before and after any function parameter
	Press the “BRIGHTNESS” Key at the bottom of the touch screen. The BRIGHTNESS page screen appears, You can increase or decrease the brightness of the lcd in this page.
	Press the “ROBOT” Key at the bottom of the touch screen. The ROBOT page screen appears, You can set robot interface parameters in this page.
	Press the “SLIDE” Key at the bottom of the touch screen. The SLIDE page screen appears, You can set slide or rotary function parameters in this page.

Pressing the Next button will open the menu bar as shown below.

	Press the “TOUCH FUN.” Key at the bottom of the touch screen. The TOUCH FUN. Page screen appears, You can perform manual functions in this page with touch keys.
	Press the “PUMP TEST” Key at the bottom of the touch screen. The PUMP TEST page screen appears, You can directly check the pressure of hydraulic pump in this page.

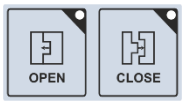
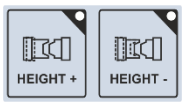
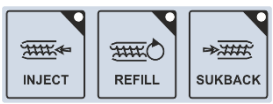
(6.3) Another additional touch key on the screen is as follows.

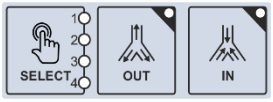
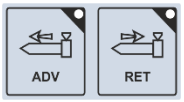
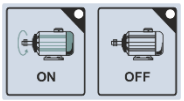
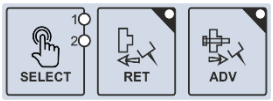
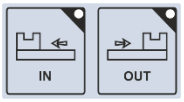
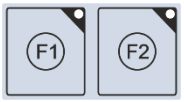
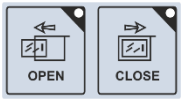
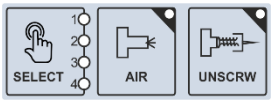
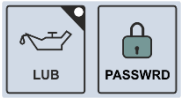
	Press the “PREV” Key at the top of the touch screen. The previews page screen appears.
	Press the “NEXT” Key at the top of the touch screen. The next page screen appears.
	Press the “Alarm” Key at the bottom of the touch screen.to reset the alarm, If there is an alarm or interlock, the button will blink in green color.
	Press the “Heat” Key at the bottom of the touch screen. to heat on/off. If hitting is on then the button color will be green
	Press the “Help” Key at the bottom of the touch screen.to open the help page screen. For example, Mold's Help will open in the Mold's page.

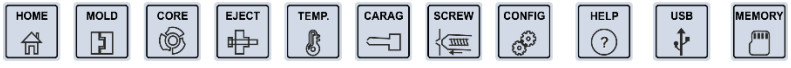
	Press the hitting barrel graphics to open the temperature page screen.
	Press the mold graphics to open The mold page screen.
	Press the screw graphics to open The screw page screen.
	Press the carriage graphics to open The carriage page screen.
	Press the motor graphics to open The motor setting page CONFIGURE3/6.
	Press the Mold memory name to open The memory page screen.
	Press the this area to open The reset function page screen CONFIGURE 1/6.
	Press the lubrication graphics to open the lubrication setting page CONFIGURE 3/6.

(6.4) Manual key

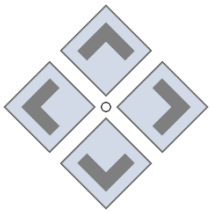
This is the manual keys the information for each key is as follows.

	Mold Open key Press this key to open the mold. Mold Close key Press this key to close the mold.
	Mold Height + key Press this key to increase the mold height. Mold Height - key Press this key to decrease the mold height. This key will only work in Die set mode.
	Injection key Press this key to move the injection piston forward. Refill Key Press this key to do the refilling 1&2 function.

	Suck back key Press this key to do the suck back 1&2 function.
	Core select key Press this key to select core for manual function. Which core is currently selected can be seen from the LED. Core out Key Press this key to do the core out function. Core in key Press this key to do the core in function.
	Carriage adv key Press this key to move the carriage (injection unit) forward. Carriage ret key Press this key to move the carriage (injection unit) backward.
	Motor On key Press this key to on the hydraulic motor. Motor Off key Press this key to off the hydraulic motor.
	Ejector select key Both led off: Normal ejector selected. 1 led on: Slide ejector 1 selected. 2 led on: Slide ejector 2 selected. The slide ejector will only work when slide is activated in the CONFIGURE 1/6 page. Ejector ret key Press this key to move the ejector backward. Ejector adv key Press this key to move the ejector forward.
	Slide in key Press this key to do slide in function. Slide out key Press this key to do slide out function.
	F1 and F2 are the configure keys. The following functions are configured on this key. F1-shutter open, F2-shutter close.(This key will only work in Die set mode.) F1-slide lock, F2-slide unlock. F1-slide2 in, F2-slide2 out.
	Gate open key. Press this key to open the hydraulic gate. Gate close key. Press this key to close the hydraulic gate.
	Air select key Press this key to select air for manual function. Which air is currently selected can be seen from the LED. Air key. Press this key to do the air function. Unscrew key. Press this key to do the unscrew function.
	Lubrication key. Press this key to start manual lubrication. Password key. Press this key to enter the password. The password key will only work in the parameter setting page, And the key will not work if password is open in that page.



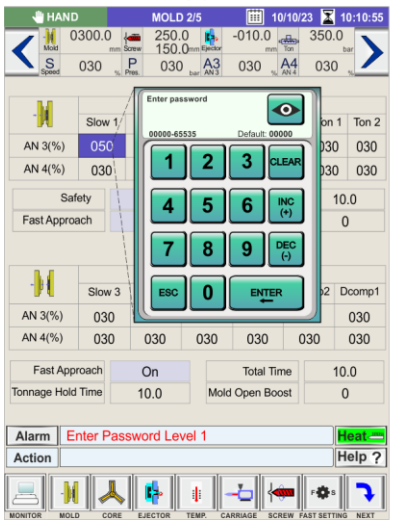
Above mentioned keys will open the parameter setting page, we have already seen the information.

	The Numeric keypad is used to enter number 0-9. You can also use this key as a direct page call. For that, go to the monitor page and press any number. For example, If you press the number 0, the version code and sequence code page will open. If 5 numbers are entered then the input page will open directly.
	This key is used to change the option parameter. Like on/off parameter to select on or off then use this key. This key is also used to view Next and Previous lists in Memory, USB, Input, Output, Prog. Data pages. select (+) key used in pump test page to on the selected pump test output.
	This key is used to clear the written numeric parameter.
	This key is used to save the parameter after entering it.
	This key is used to move the screen page forward and backward.
	Press the arrow key to navigate on page between input parameters. The right arrow key is used to latch the injection and refill functions.For that, by going to the monitor screen, then pressing the right arrow key and immediately pressing the refill key, the function of refill will be over to the set postion or input. In this way, you can also latch the injection function. Between the navigaiton arrows is the cpu ok led.which indicates that the circuit of mmi is working properly.
	Pressing the Heat On key will turn on the heater outputs. There are 3 uses of test key which are as follows. 1) Pressing the test key once will turn on the navigation cursor of the menu touch key bar. 2) To turn on the test mode first go to the output page and then hold down the test key for 3 seconds the test mode will turn on. 3) To turn on the pump test mode, first go to the pump test page and then press and hold the test key for 3 seconds to turn on the pump test mode. Press INTLK key to reset interlock.The interlock led will turn on when the machine cycle or any function is not working properly.
	Press this key to change to hand mode.in hand mode all function can be started by pressing the manulal function keys.

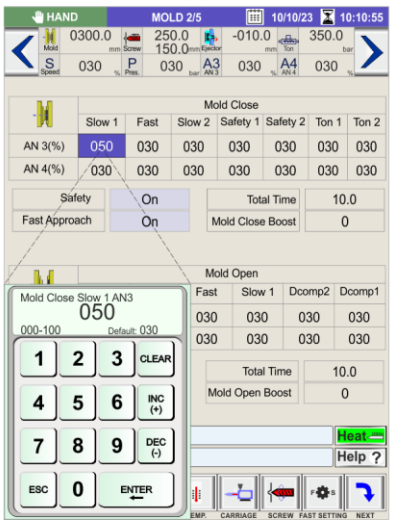
	Press this key to change to semi mode. In a semi cycle mode, full molding cycle starts by closing the front guard or pressing cycle start push button.
	Press this key to change to diset mode.in diset mode mold open close , mold height +/- can be started by pressing the this key. In this mode mold open close function work on reduced speed pressure. To turn on Auto Dieset first press the Dieset key and then press the Auto key to start the Auto Dieset function.
	This key is used to empty the material from the barrel, in which first pressing the purge key and then pressing the auto key will run the cycle of auto purge. In auto purge cycle, injection and refill cycle will run as per set purge cycle.
	Press this key to change to auto mode. In a auto cycle mode, full molding cycle starts by closing the front guard or pressing cycle start push button.

(6.5) The process of how to insert the parameter is as follows.

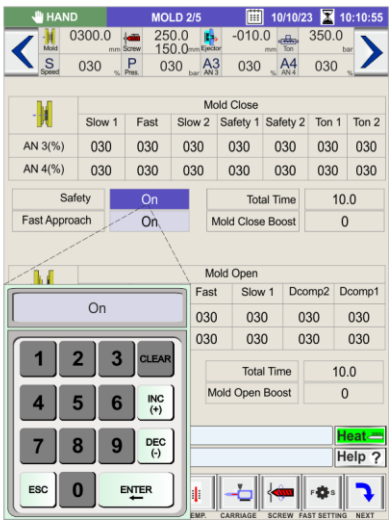
(1)



(2)

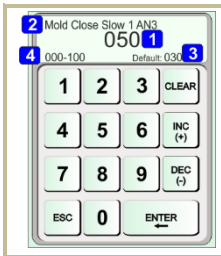


(3)



1. When you press on a parameter, the parameter box will turn blue, 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 (2), 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 (3) (Safety =on).

(6.6) Touch Key board description:

	[1] Current set value of parameter. [2] Parameter name. [3] Default value of parameter, This is a factory set value. [4] Range of parameter, The maximum parameter range is currently 100. If its value is 50 in the CONFIGURE 6/6 page {mold Open AN3 (%)}, it will show 50, And this parameter you cannot save value above 50.
	[1] Range of password parameter. [2] Default value of parameter. This is a factory set value. [3] Eye button, By touching the eye you can see the value that has been entered. For example if you are entering 22222 password it will show "*****", now when you touch eye it will show "22222".

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

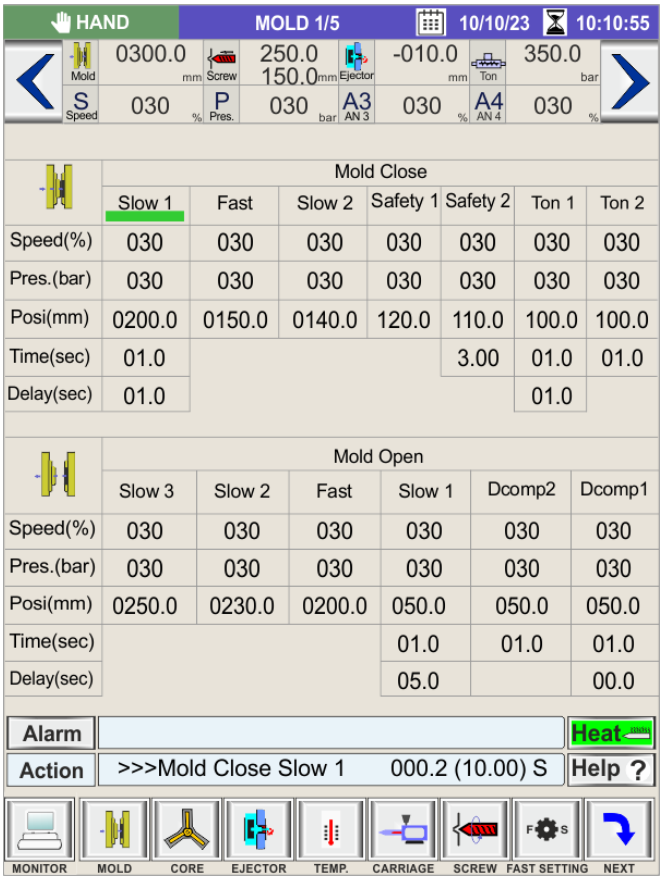
- Equipment must be operating under correct power. (Install a voltage stabilizer or CVT while need)
- Earth terminal must be connected to qualified terminal.
- All electrical elements with EARTH terminal, it is necessary for users to connect with the EARTH terminal.
- The high power cables should be 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.

(8) Setting procedures

(8.1) Screen Page: MOLD 1/5

(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.



In this page all parameter settings of mold close and mold open can be made. The mold close function can be divided in to 7 steps and mold open function can be divided in to 6 steps. For every single step speed, pressure, position can be specified. Different settings for all steps mentioned further below.
When the function is running, it will be highlighted in green color under the name of the function. As shown in the above image under the name of mold closes slow 1.
In the above image it is shown that the function of mold closes slow 1 in the line of action message. It shows the current time of the function and the total time of the mold close function on its right side.

Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Close Slow1	With select Position in type From mold fully open position to this position mold moves slow in close direction with 30% speed and 30 bar pressure.	Set Mold close slow 1 function over operating position.	Position	0000.0 – 3000.0mm	Level 1
		Set Close Slow1 function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Close Slow1 function operating Speed proportional output	Speed	000% – 100%	Level 1
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 – 3000.0mm	Level 1
		Set Close Fast function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Close Fast function operating Speed proportional output	Speed	000% – 100%	Level 1
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 – 3000.0mm	Level 1
		Set Close Slow2 function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Close Slow2 function operating Speed proportional output	Speed	000% – 100%	Level 1
Safety1 End	With select Position in type From mold Close Slow2 position to this position mold moves Slow in close direction. Here mold safety time observe position if in settable mold safety time actual position is not reach safety 2 end position than create **IL Mold Safety Time Over** and mold gets open.	Set Mold close Safety 1 function over operating position.	Position	0000.0 – 999.9mm	Level 2
		Set Close Safety 1 function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Close Safety 1 function operating Speed proportional output	Speed	000% – 100%	Level 1
Safety2 End		Set Close Safety 2 function over operating position.	Position	0000.0 – 999.9mm	Level 2
		Set Close Safety 2 function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Close Safety 2 function operating Speed proportional output	Speed	000% – 100%	Level 1
		Set Close Safety function operating time.	Time	00.0 – 9.99Sec	Level 1

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.	Bar	000.0 – 999.9bar	Level 1
		Set locking tonnage 1 function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set locking tonnage 1 function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set locking tonnage 1 function operating delay.	Delay	00.0-10.0Sec	Level 1
		Set locking tonnage 1 function operating time.	Time	00.0 – 99.9 Sec	Level 1
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.	Bar	000.0 – 999.9mm	Level 1
		Set locking tonnage 2 function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set locking tonnage 2 function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set locking tonnage 2 function operating time.	Time	00.0 – 99.9 Sec	Level 1
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	Level 1
		Set Slow Open 3 function operating pressure proportional output	Pressure	000– 255Bar	Level 1
		Set Slow Open 3 function operating Speed proportional output	Speed	000% – 255%	Level 1
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	Level 1
		Set Slow Open 2 function operating pressure proportional output	Pressure	000– 255Bar	Level 1
		Set Slow Open 2 function operating Speed proportional output	Speed	000% – 255%	Level 1
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	Level 1
		Set Fast Open function operating pressure proportional output	Pressure	000– 255Bar	Level 1

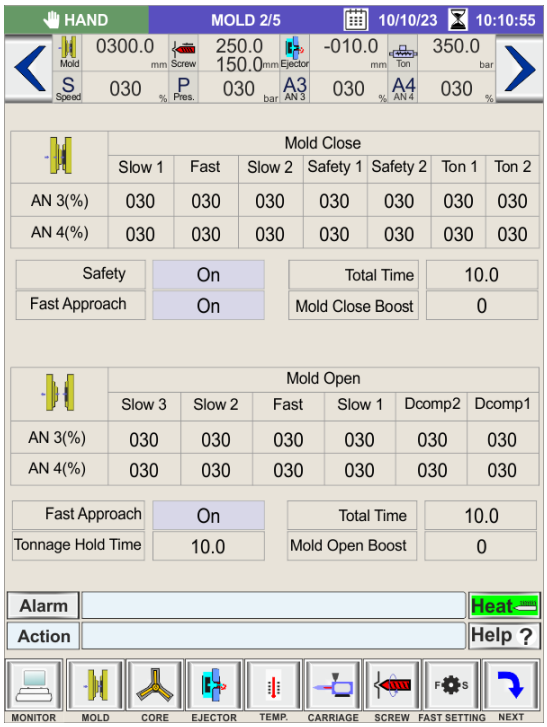
		Set Fast Open function operating Speed proportional output	Speed	000% – 255%	Level 1
Slow Open1	With select Position in type From mold fully close position to this position mold moves slow in open direction.	Set Slow Open 1 function over operating position.	Position	000.0 – 999.9mm	Level 1
		Set Slow Open 1 function operating pressure proportional output	Pressure	000– 255Bar	Level 1
		Set Slow Open 1 function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Slow Open 1 function operating Time	Time	00.0 – 99.9Sec	Level 1
		Set Slow Open 1 function operating delay	Delay	00.0- 99.9Sec	Level 1
Decompression1	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 – 999.9 mm	Level 1
		Set decompression function operating pressure proportional output	Pressure	000– 255Bar	Level 1
		Set decompression function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Decompression 1 function operating delay	Delay	00.0 – 99.9Sec	Level 1
		Set decompression function 1 operating Time	Time	00.0 – 99.9Sec	Level 1
Decompression2	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 – 999.9 mm	Level 1
		Set decompression function operating pressure proportional output	Pressure	000– 255Bar	Level 1
		Set decompression function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set decompression function 1 operating Time	Time	00.0 – 99.9Sec	Level 1

(8.2) Screen Page: MOLD 2/5

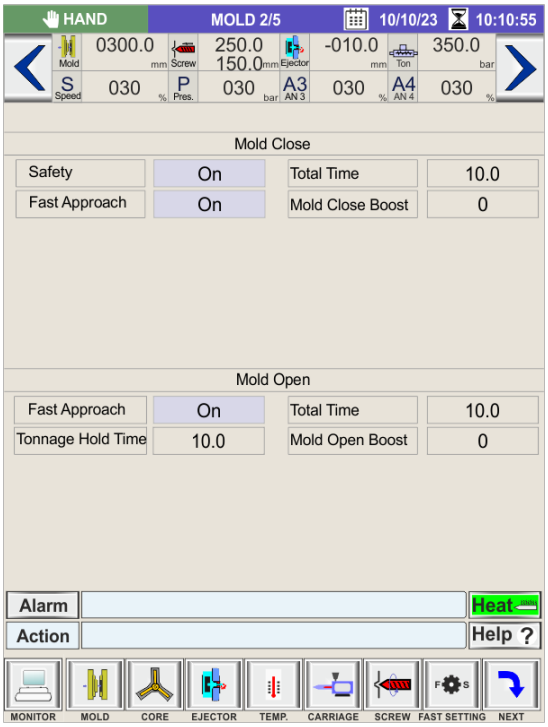
(1) Press" " key once on the top of the Touch Screen.
(2) Now Screen Page: **MOLD 2/5** is displayed on screen in first line.
(3) To change the parameter you have to press on the parameter digit.
(If you change the parameter for the first time you will want password.)
(4) Alphanumeric Touch Key Pad appears 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.

(1)



(2)



This page provides the same AN3 and AN4 settings as the mold 1/5 speed and pressure, which are used to set additional analog outputs like the speed pressure.
To disable AN3 and AN4 parameter setting go to "CONFIGURE 1/6" page, there "Disable AN Par." To turn on the parameter. So AN 3 and AN 4 parameters will not appear in this page. Which is shown in image (2).

Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Close Slow1	With select Position in type From mold fully open position to this position mold moves slow in close direction with 30% AN3 and 30% AN4 pressure.	Set Close Slow1 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Close Slow1 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Close Fast	With select Position in type From mold Close Slow1 position to this position mold moves Fast in close direction.	Set Close Fast function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Close Fast function operating AN4 proportional output	AN4	000% – 255%	Level 1
Close Slow2	With select Position in type From mold Close Fast position to this position mold moves Slow in close direction.	Set Close Slow2 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Close Slow2 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Safety 1 End		Set Close Safety1 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Close Safety1 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Safety 2 End		Set Close Safety2 function operating AN3 proportional output	AN3	000% – 255%	Level 1
Lock Ton 1		Set Locking tonnage1 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Locking tonnage1 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Lock Ton 2		Set Locking tonnage2 function operating AN3 proportional output	AN3	000% – 255%	Level 1

		Set Locking tonnage2 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Safety	See Functional Description	Select Mold close safety function enable (on) or disable (off).	Function	On/Off	Level 1
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
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
Mold Close Boost	Select various type of pump selection with close 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 Close Boost option.	Number	0-5	Level 1
Slow Open3		Set Slow Open3 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Slow Open3 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Slow Open2		Set Slow Open2 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Slow Open2 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Fast Open		Set Fast Open function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Fast Open function operating AN4	AN4	000% – 255%	Level 1

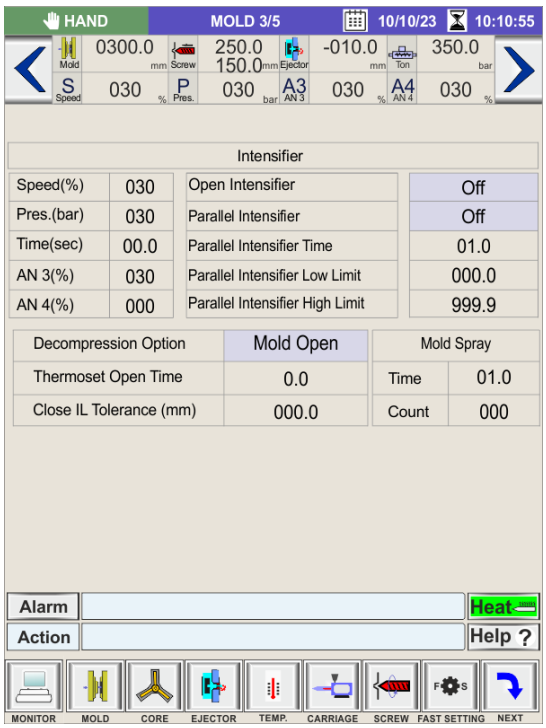
		proportional output			
Slow Open1		Set Slow Open1 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Slow Open1 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Decompression 1&2		Set decompression function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set decompression function operating AN4 proportional output	AN4	000% – 255%	Level 1
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	Level 1
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
Mold Open 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
Tonnage Hold Time	This parameter is used in semi or auto cycles, after the tonnage function is over, how long the output of the tonnage function is to be continued during the injection and refill functions.	Set Tonnage Hold Time.	Timer	00.0-10.0Sec	Level1

(8.3) Screen Page: MOLD 3/5

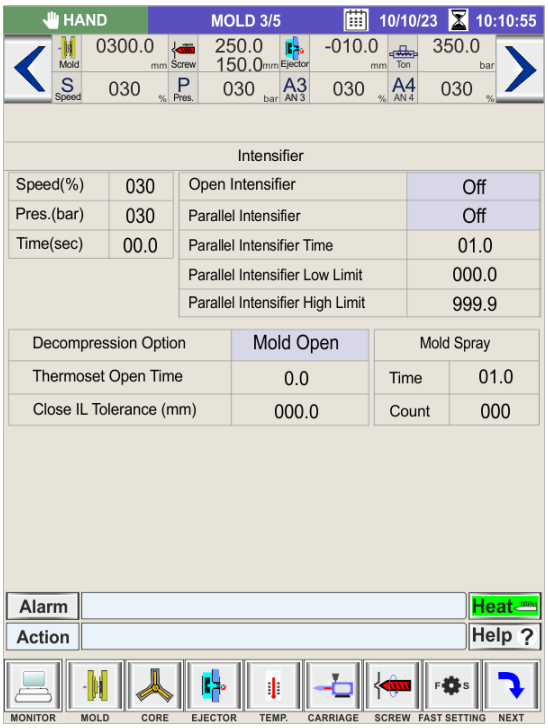
(1) Press**”** ” key once on the top of the Touch Screen.
(2) Now Screen Page: **MOLD 3/5** is displayed on screen in first line.
(3) To change the parameter you have to press on the parameter digit.
(If you change the parameter for the first time you will want password.)
(4) Alphanumeric Touch Key Pad 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.

(1)



(2)



Some additional function parameters like intensifier, mold spray, thermostat option, and close interlock tolerance can be set in this page.
To disable AN3 and AN4 parameter setting go to "CONFIGURE 1/6" page, there "Disable AN Par." To turn on the parameter. So AN 3 and AN 4 parameters will not appear in this page. Which is shown in image (2).

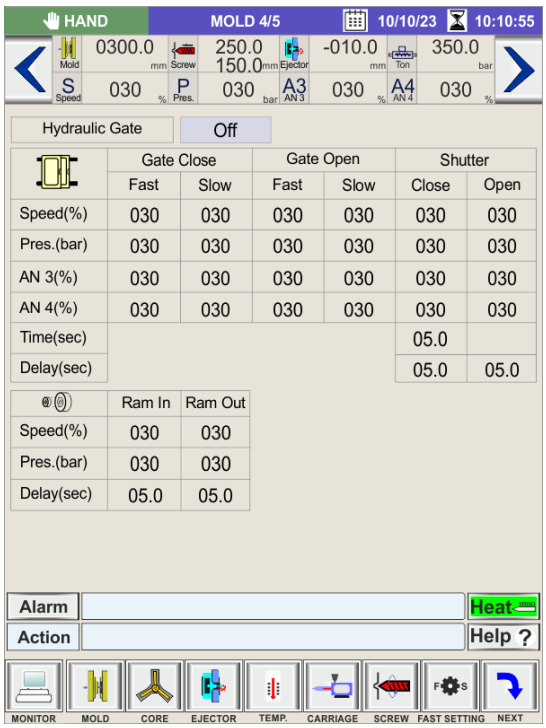
Parameter Name	Function Description	Parameter Description	Parameter description		Operating Password Level
			Parameter Type	Range	
Open Intensifier Open Intensifier	This function is use in RAM type injection molding machine to reduce tonnage pressure.	Set Open Intensifier function operating pressure proportional output	Pressure	000–255Bar	Level 1
		Set Open Intensifier function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Open Intensifier function operating Time	Time	00.0 – 99.9 Sec	Level 1
		Set Open Intensifier function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Open Intensifier function operating AN4 proportional output	AN4	000% – 255%	Level 1
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
Parallel Intensifier	This function operate parallel to mold open function	Parallel Intensifier function on/off.	Function	On/Off	Level 1
Parallel Intensifier Time		Set Parallel Intensifier function operating time.	Time	00.0 – 99.9 sec	Level 2
Parallel Intensifier Low Limits		Set Parallel Intensifier function operating low limit.	Position	000.0 – 999.9	Level 2
Parallel Intensifier High Limits		Set Parallel Intensifier function operating high limit.	Position	000.0 – 999.9	Level 2
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 If select After Refill than decompression start on completion of Refill function	Select Decompression function operating sequence.	Function	Mold Open/After Injection/After Refill	Level1
Thermo set open time		Set Thermo set option function operating time.	Time	0.0 – 9.9	Level 1
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
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
		Set Mold Spray function Count.	Count	000 – 999	Level1

(8.4) Screen Page: MOLD 4/5

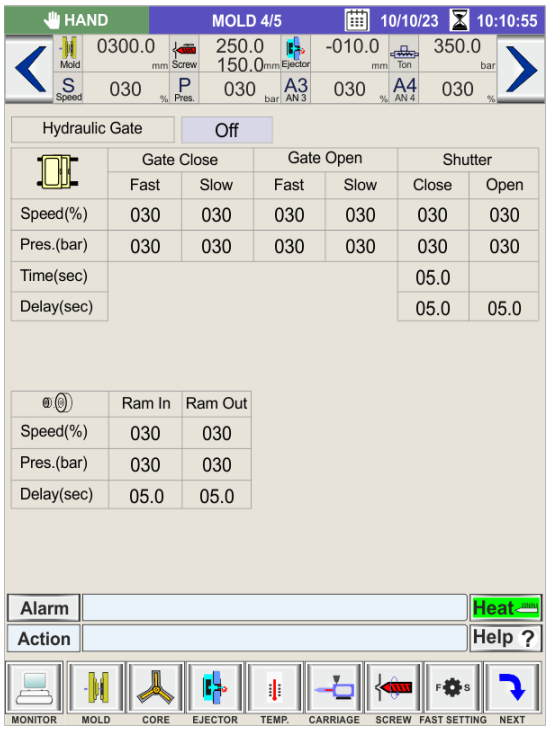
(1) Press"  " key once on the top of the Touch Screen.
(2) Now Screen Page: **MOLD 4/5** is displayed on screen in first line.
(3) To change the parameter you have to press on the parameter digit.
(If you change the parameter for the first time you will want password.)
(4) Alphanumeric Touch Key Pad 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.

(1)



(2)



Some function parameters like hydraulic gate, shutter, and ram setting can be set in this page.

To disable AN3 and AN4 parameter setting go to "CONFIGURE 1/6" page, there "Disable AN Par." To turn on the parameter. So AN 3 and AN 4 parameters will not appear in this page. Which is shown in image (2).

Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Hydraulic Gate	If this parameter is On, the analog output and digital output of the hydraulic gate will be Off.	Hydraulic Gate on/off function	Function	On/Off	Level 1
Gate Close Fast		Set Front Safety Gate Fast Close function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Front Safety Gate Fast Close function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Front Safety Gate Fast Close function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Front Safety Gate Fast Close function operating AN4 proportional output	AN4	000% – 100%	Level 1
Gate Close Slow		Set Front Safety Gate Slow Close function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Front Safety Gate Fast Close function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Front Safety Gate Slow Close function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Front Safety Gate Slow Close function operating AN4 proportional output	AN4	000% – 255%	Level 1
Gate Open Fast		Set Front Safety Gate Fast Open function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Front Safety Gate Fast Open function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Front Safety Gate Fast Open function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Front Safety Gate Fast Open function operating AN4 proportional output	AN4	000% – 255%	Level 1
Gate Open Slow		Set Front Safety Gate Slow Open function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Front Safety Gate Slow Open function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Front Safety Gate Slow Open function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Front Safety Gate Slow Open function operating AN4 proportional output	AN4	000% – 255%	Level 1
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
		Set Shutter Close function operating Speed proportional output	Speed	000% – 255%	Level 1

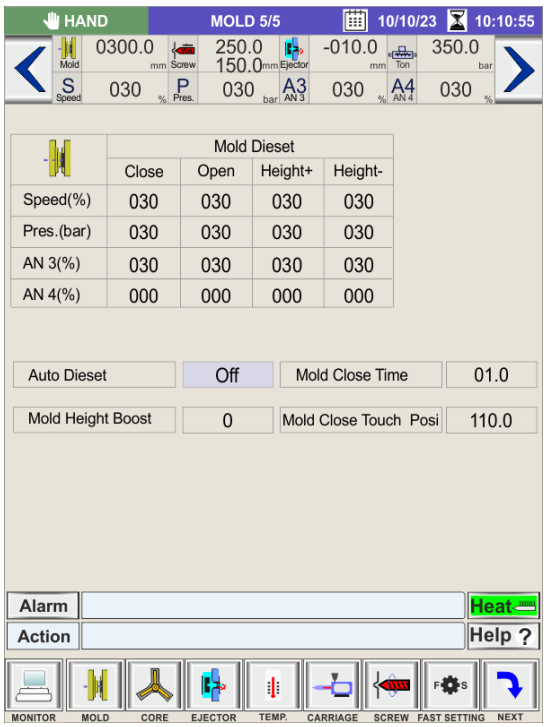
		Set Shutter Close function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Shutter Close function operating AN4 proportional output	AN4	000% – 255%	Level 1
		Set Shutter Close Total Time	Time	00.0-99.9 Sec	Level 1
		Set Shutter Close operating delay time.	Delay	00.0 – 99.9 Sec	Level 1
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
		Set Shutter Open function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Shutter Open function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Shutter Open function operating AN4 proportional output	AN4	000% – 255%	Level 1
		Set Shutter Open operating delay time.	Delay	00.0 – 99.9 Sec	Level 1
Ram In	Before mold close ram in function start. Over on input.	Set Ram in function operating Pressure proportional output.	Pressure	000 – 255Bar	Level 1
		Set Ram in function operating Speed proportional output.	Speed	000 – 255Bar	Level 1
		Set Ram In operating delay time.	Delay	00.0 – 99.9 Sec	Level 1
Ram Out	With decompression ram out function start. Over on input.	Set Ram Out function operating Pressure proportional output.	Pressure	000 – 255Bar	Level 1
		Set Ram in function operating Speed proportional output.	Speed	000 – 255Bar	Level 1
		Set Ram Out operating delay time.	Delay	00.0 – 99.9 Sec	Level 1

(8.5) Screen Page: MOLD 5/5

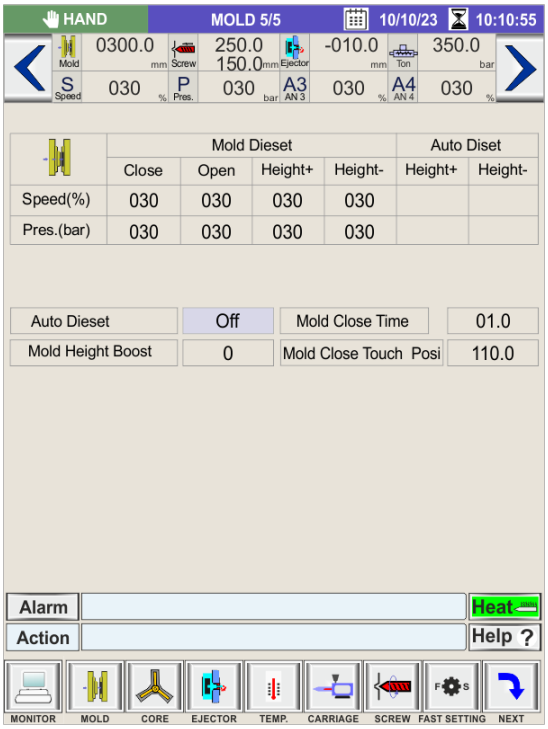
(1) Press"  " key once on the top of the Touch Screen.
(2) Now Screen Page: **MOLD 5/5** is displayed on screen in first line.
(3) To change the parameter you have to press on the parameter digit.
(If you change the parameter for the first time you will want password.)
(4) Alphanumeric Touch Key Pad 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

(1)



(2)



Die set function parameters can be set in this page.

To disable AN3 and AN4 parameter setting go to "CONFIGURE 1/6" page, there "Disable AN Par." To turn on the parameter. So AN 3 and AN 4 parameters will not appear in this page. Which is shown in image (2).

Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
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
		Set Mold Close function operating Speed proportional output	Speed	000% – 100%	Level 1
		Set Mold Close function operating AN3 proportional output	AN3	000% – 100%	Level 1
		Set Mold Close function operating AN4 proportional output	AN4	000% – 100%	Level 1
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
		Set Mold Open function operating Speed proportional output	Speed	000% – 100%	Level 1
		Set Mold Open function operating AN3 proportional output	AN3	000% – 100%	Level 1
		Set Mold Open function operating AN4 proportional output	AN4	000% – 100%	Level 1
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
		Set Mold Height Maximum function operating Speed proportional output	Speed	000% – 100%	Level 1
		Set Mold Height Maximum function operating AN3 proportional output	AN3	000% – 100%	Level 1
		Set Mold Height Maximum function operating AN4 proportional output	AN4	000% – 100%	Level 1
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
		Set Mold Height Minimum function operating Speed proportional output	Speed	000% – 100%	Level 1

		Set Mold Height Minimum function operating AN3 proportional output	AN3	000% – 100%	Level 1
		Set Mold Height Minimum function operating AN4 proportional output	AN4	000% – 100%	Level 1
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
Mold close Time	Mold close time for die set mode only. This time operate parallel to mold close function and if mold is not fully close during this time over than mold gets open and adjust mold height maximum.	Set mold close time for auto die set mode only.	Time	00.0-99.9Sec	Level 1
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
Mold Close Touch Position	This parameter is a duplicate of Mold Safety 2 position. It is used in shutter operation.	Set Close Safety 2 function over operating position.	Position	000.0-999.9	Level 2

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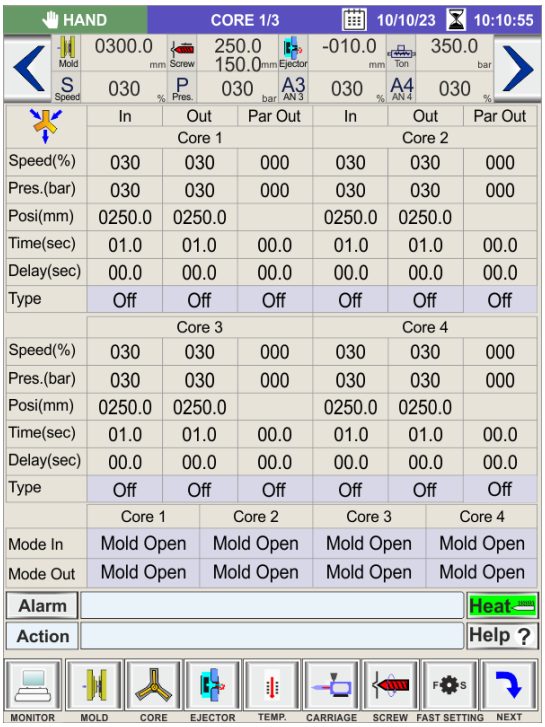
(8.6) Screen Page: CORE 1/3

(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.



Parameter name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
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	Level 1
		Set Core In 1 function operating Speed proportional output	Speed	000% – 255%	Level 1
		On completion of set delay time Core In 1 function take place.	Delay	00.0-99.9Sec	Level 1
		Set Core In 1 function operating time.	Timer	00.0-99.9Sec	Level 1
		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
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	Level 1
		Set Core Out 1 function operating Speed proportional output	Speed	000% – 255%	Level 1
		On completion of set delay time Core Out 1 function take place.	Delay	00.0-99.9Sec	Level 1
		Set Core Out 1 function operating time.	Timer	00.0-99.9Sec	Level 1
		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
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	Level 1
		Set Core Partial Out 1 function operating Speed proportional output	Speed	000% – 255%	Level 1
		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	Level 1
		Set Core Partial Out 1 function operating time.	Timer	00.0-99.9Sec	Level 1
		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	Type	On/Ls/Timer	Level 1

		Core Partial Out 1 function is over on completion of set time with **Timer** selection			
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	Level 1
		Set Core In 2 function operating Speed proportional output	Speed	000% – 255%	Level 1
		On completion of set delay time Core In 2 function take place.	Delay	00.0-99.9Sec	Level 1
		Set Core In 2 function operating time.	Timer	00.0-99.9Sec	Level 1
		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
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	Level 1
		Set Core Out 2 function operating Speed proportional output	Speed	000% – 255%	Level 1
		On completion of set delay time Core Out 2 function take place.	Delay	00.0-99.9Sec	Level 1
		Set Core Out 2 function operating time.	Timer	00.0-99.9Sec	Level 1
		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
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	Level 1
		Set Core Partial Out 2 function operating Speed proportional output	Speed	000% – 255%	Level 1
		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	Level 1
		Set Core Partial Out 2 function operating time.	Timer	00.0-99.9Sec	Level 1

		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 completion of set time with **Timer** selection	Type	Off/Ls/Timer	Level 1
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	Level 1
		Set Core In 3 function operating Speed proportional output	Speed	000% – 255%	Level 1
		On completion of set delay time Core In 3 function take place.	Delay	00.0-99.9Sec	Level 1
		Set Core In 3 function operating time.	Timer	00.0-99.9Sec	Level 1
		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
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	Level 1
		Set Core Out 3 function operating Speed proportional output	Speed	000% – 255%	Level 1
		On completion of set delay time Core Out 3 function take place.	Delay	00.0-99.9Sec	Level 1
		Set Core Out 3 function operating time.	Timer	00.0-99.9Sec	Level 1
		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
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	Level 1
		Set Core Partial Out 3 function operating Speed proportional output	Speed	000% – 255%	Level 1
		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	Level 1
		Set Core Partial Out 3 function operating time.	Timer	00.0-99.9Sec	Level 1

		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
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	Level 1
		Set Core In 4 function operating Speed proportional output	Speed	000% – 255%	Level 1
		On completion of set delay time Core In 4 function take place.	Delay	00.0-99.9Sec	Level 1
		Set Core In 4 function operating time.	Timer	00.0-99.9Sec	Level 1
		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
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	Level 1
		Set Core Out 4 function operating Speed proportional output	Speed	000% – 255%	Level 1
		On completion of set delay time Core Out 4 function take place.	Delay	00.0-99.9Sec	Level 1
		Set Core Out 4 function operating time.	Timer	00.0-99.9Sec	Level 1
		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
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	Level 1
		Set Core Partial Out 4 function operating Speed proportional output	Speed	000% – 255%	Level 1
		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	Level 1
		Set Core Partial Out 4 function operating time.	Timer	00.0-99.9Sec	Level 1

		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
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 then 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
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 then again start MOLD OPEN function take place. **Mold Lock :** During mold lock function first start core out than Mold Lock function take place	MODE Out	Mold Open Mold Close In Between Mold Lock	Level 1
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
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

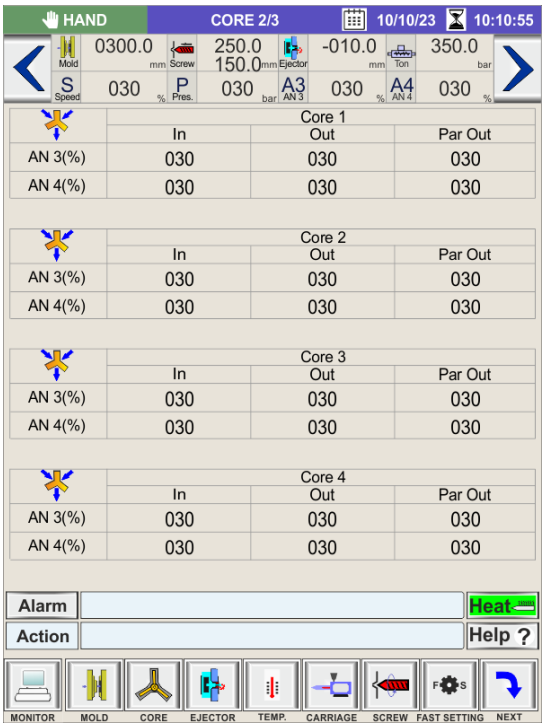
CORE 3 MODE In	Select core 3 in-operating sequence. On select sequence core in function start. When select **IN Between** sequence core in operation start on **CORE IN POSI**.	Same as CORE 1 MODE In description	MODE In	Mold Open Mold Close In Between Mold Lock	Level 1
CORE 3 MODE Out	Select core 3 out-operating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

(8.7) 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



To disable AN3 and AN4 parameter setting go to "CONFIGURE 1/6" page, there "Disable AN Par." To turn on the parameter. So AN 3 and AN 4 parameters will not appear in this page. Which is shown in image.

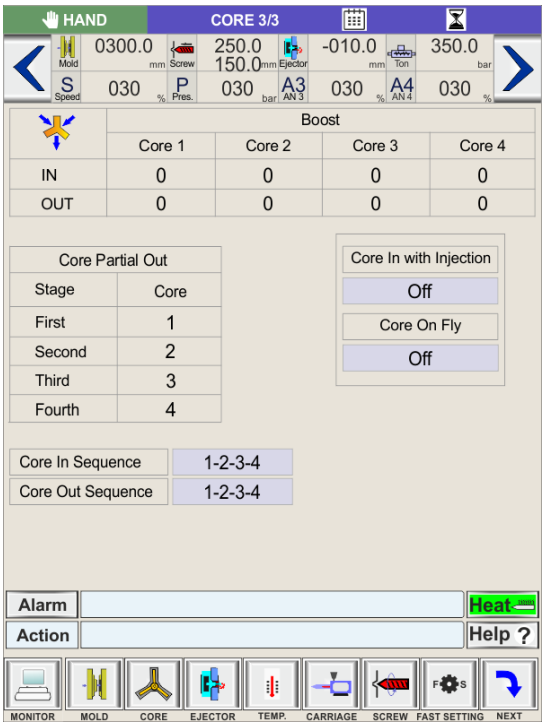
Parameter name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Core In		Set Core In 1 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Core In 1 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Core Out		Set Core Out 1 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Core Out 1 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Partial Out		Set Core Partial Out 1 function operating AN3 proportional output	AN3	000% – 255%	Level 1

		Set Core Partial Out 1 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Cor2 In		Set Core In 2 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Core In 2 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Cor2 Out		Set Core Out 2 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Core Out 2 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Par2 Out		Set Core Partial Out 2 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Core Partial Out 2 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Cor3 In		Set Core In 3 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Core In 3 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Cor3 Out		Set Core Out 3 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Core Out 3 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Par3 Out		Set Core Partial Out 3 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Core Partial Out 3 function operating AN4 proportional output	AN4	000% – 255%	Level 1

(8.8) Screen Page: CORE 3/3

(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



Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
BOOST 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	Select Core In 1 boost option	Number	0-5	Level 1

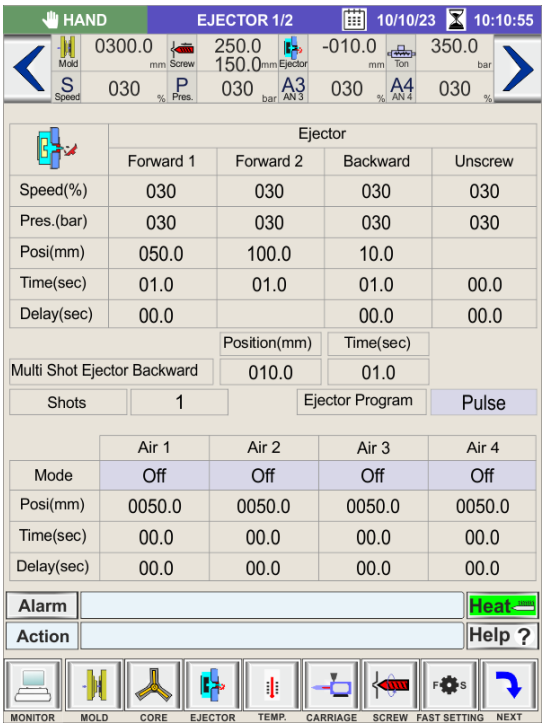
	proportional output. With boost selection 5 pump selection very with set Speed proportional output.	Select Core Out 1 boost option	Number	0-5	Level 1
BOOST COR2	Select various type of pump selection with Core In2 and Core Out2 function as per output selection provide in sequence table. With boost selection 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
		Select Core Out 2 boost option	Number	0-5	Level 1
BOOST 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 proportional output. With boost selection 5 pump selection very with set Speed proportional output.	Select Core In 3 boost option	Number	0-5	Level 1
		Select Core Out 3 boost option	Number	0-5	Level 1
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
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
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

Core On Fly	Core moves parallel to the mold movement, Core movement starts once the mold passes through the in-between position.	Select on to enable this function or off to disable this function	Function	On/Off	Level 1
Core Partial Out Stages	There are stages of core partial out. As per the settings in the image, first core 1 will be partial out, then 2, 3, 4 will be done.	Select Stages	Function	1,2,3,4	Level 1
Core In Sequence	By selecting core 1-2-3-4, the sequence of core in will run as core 1 in, core 2 in, core 3 in, core 4 in. Accordingly, selecting 4-3-2-1 will run in reverse.	Select core sequence type	Function	1-2-3-4 4-3-2-1	Level 1
Core Out Sequence	By selecting core 1-2-3-4, the sequence of core out will run as core 1 out, core 2 out, core 3 out, core 4 out. Accordingly, selecting 4-3-2-1 will run in reverse.	Select core sequence type	Function	1-2-3-4 4-3-2-1	Level 1

(8.9) Screen Page: EJECTOR 1/2

(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



Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
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
		Set Ejector Forward 1 function operating pressure proportional output	Pressure	000–255Bar	User
		Set Ejector Forward 1 function operating Speed proportional output	Speed	000% – 255%	User
		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
		Set Ejector Forward 1function operating time.	Timer	00.0-99.9Sec	User
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
		Set Ejector Forward 2 function operating pressure proportional output	Pressure	000–255Bar	User
		Set Ejector Forward 2 function operating Speed proportional output	Speed	000% – 255%	User
		Set Ejector Forward 2 function operating time.	Timer	00.0-99.9Sec	User
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
		Set Ejector Backward function operating pressure proportional output	Pressure	000–255Bar	User
		Set Ejector Backward function operating Speed proportional output	Speed	000% – 255%	User
		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
		Set Ejector Backward function operating time.	Timer	00.0-99.9Sec	User
Unscrew	This function is use to unscrewing molded product from die	Set Unscrew function operating pressure proportional output	Pressure	000–255Bar	User
		Set Unscrew function operating Speed proportional output	Speed	000% – 255%	User
		On completion of set delay time Unscrew function take place. Its start on completion of decompression function	Delay	00.0-99.9Sec	User
		Set Ejector Backward function operating time.	Timer	00.0-99.9Sec	User
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
	Set Position for more than one shot	set position for multi-shot in Eject-backward	Position	000.0-999.9	User

	to do ejector backward function.				
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
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
Air 1	Set Air 1 function to operate it	**With open-** air on with mold open movement. **Open Position-** air on with set mold open position. **After Open-**air on with after mold open movement. **After Injection-** air on with after injection function.	Mode	With Open, Open Position, After Open, After Injection,	Level 1
	Set Air 1 delay time to operate it		Delay	00.0-99.9Sec	Level 1
	Set Air 1 time to do the function.		Time	00.0-99.9Sec	Level 1
	Set Air 1 position to do the function with mold open position		Position	9999.0	Level 1
Air 2	Set Air 2 function to operate it		Mode	With Open Open Position After Open After Injection	Level 1
	Set Air 2 delay time to operate it		Delay	00.0-99.9Sec	Level 1
	Set Air 2 time to do the function.		Time	00.0-99.9Sec	Level 1
	Set Air 2 position to do the function with mold open position		Position	9999.0	Level 1

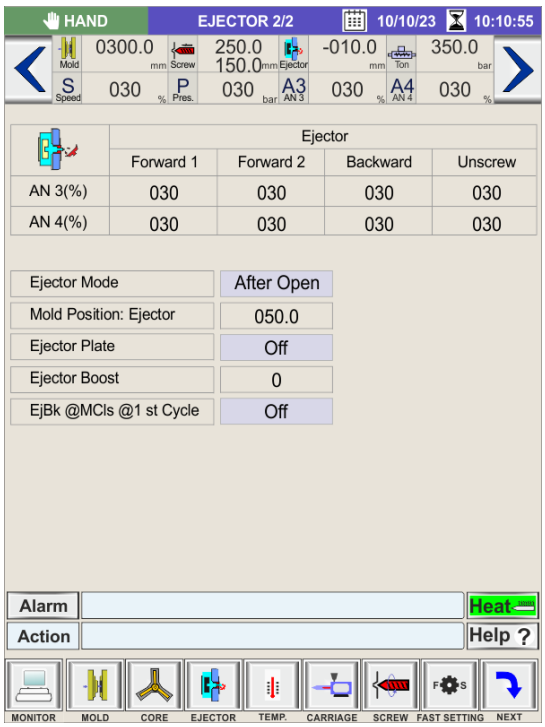
Air 3	Set Air 3 function to operate it		Mode	With Open Open Position After Open After Injection	Level 1
	Set Air 3 delay time to operate it		Delay	00.0-99.9Sec	Level 1
	Set Air 3 time to do the function.		Time	00.0-99.9Sec	Level 1
	Set Air 3 position to do the function with mold open position		Position	9999.0	Level 1
Air 4	Set Air 4 function to operate it		Mode	With Open Open Position After Open After Injection	Level 1
	Set Air 4 delay time to operate it		Delay	00.0-99.9Sec	Level 1
	Set Air 4 time to do the function.		Time	00.0-99.9Sec	Level 1
	Set Air 4 position to do the function with mold open position		Position	9999.0	Level 1

(8.10) Screen Page: EJECTOR 2/2

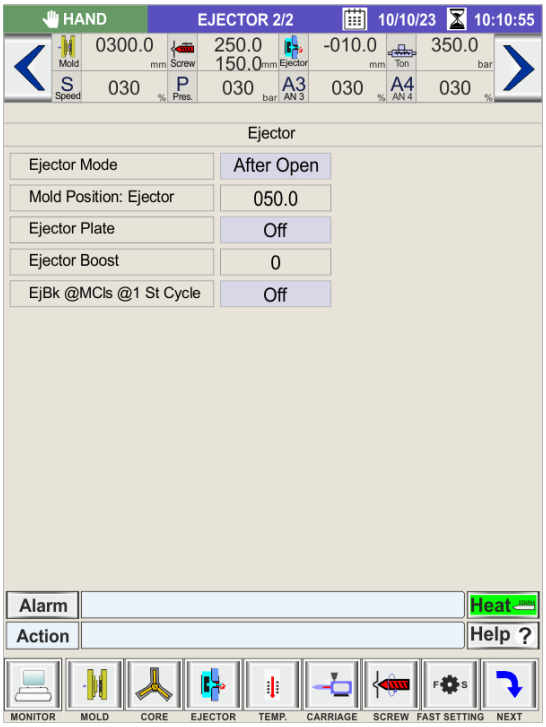
(1) Press**”**  ” key once on the top of the Touch Screen.
(2) Now Screen Page: **EJECTOR 2/2** is displayed on screen in first line.
(3) To change the parameter you have to press on the parameter digit.
(If you change the parameter for the first time you will want password.)
(4) Alphanumeric Touch Key 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

(1)



(2)



To disable AN3 and AN4 parameter setting go to "CONFIGURE 1/6" page, there "Disable AN Par." To turn on the parameter. So AN 3 and AN 4 parameters will not appear in this page. Which is shown in image (2).

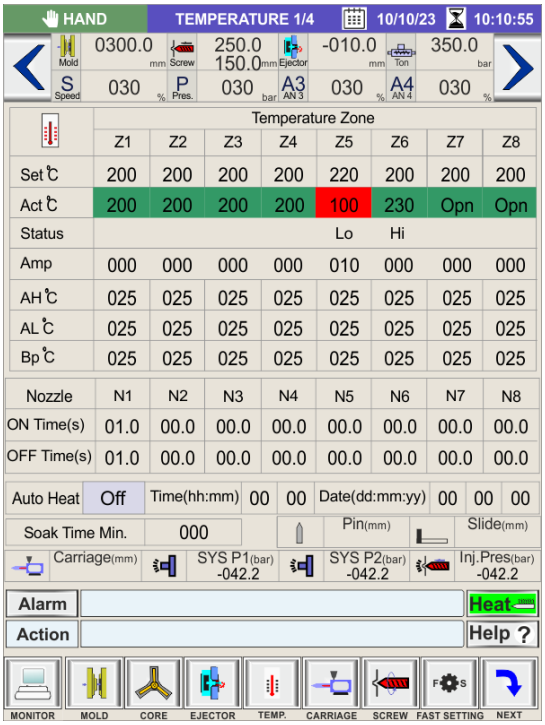
Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Ejector Forward1		Set Ejector Forward 1 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Ejector Forward 1 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Ejector Forward2		Set Ejector Forward 2 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Ejector Forward 2 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Ejector Backward		Set Ejector Backward function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Ejector Backward function operating AN4 proportional output	AN4	000% – 255%	Level 1
Unscrew		Set Unscrew function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Unscrew function operating AN4 proportional output	AN4	000% – 255%	Level 1
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 set position in POSI.	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** selection. Ejector function starts at select position With **Open Position** selection.	Function	With Open Open Position After Open	Level 1
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
Ejector Plat		Enable or Disable Ejector Plate function operation.	Function	On/Off	Level 1
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	Select ejector boost option	Number	0-5	Level 1

	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.				
Ejector Bk @MCls @1 St Cycle		During cycle if ejector backward o/p need during mold close at first cycle then this function to ON	Function	On/Off	Level 1

(8.11) Screen Page: Temperature (1/4)

(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.
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.

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



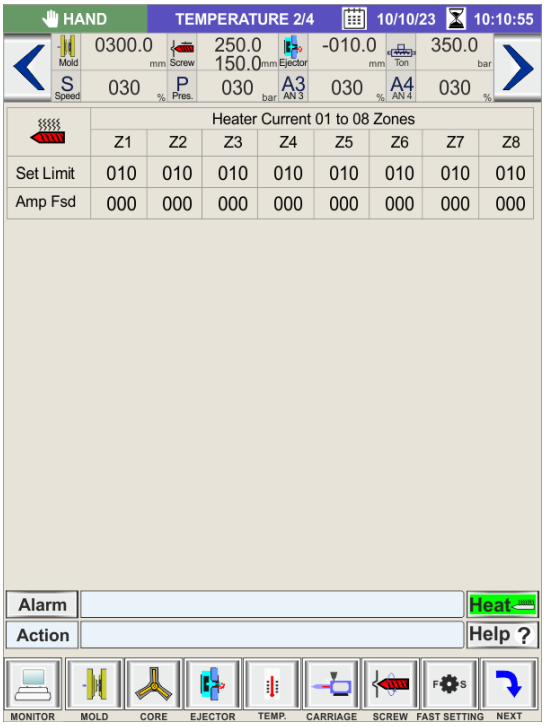
Zone No.	Parameter Name	Description	Range	Default Value	Operating Password Level
Z1 to Z8	Set °C	Set temperature	0-999 °C	200 °C	Level 1
	Act °C	Actual temperature			
	Status	Display Alarm Low & Alarm High online status	Lo, Hi		
	Amp	Actual ampere will show here			
	AL °C	Alarm low	0-999 °C	025 °C	Level 1
	AH °C	Alarm High	0-999 °C	025 °C	Level 1
	Bp °C	Blower Point	0-200 °C	000 °C	Level 1
N1 to N8	ON Time(s)	The nozzle 1 heater will stay on for as long as the time is running.	0-9.99 Sec	0.00 Sec	Level 1
	Off Time(s)	The nozzle 1 heater will stay off for as long as the time is running	0-9.99 Sec	0.00 Sec	Level 1

Parameter Name	Description	Parameter Description		Operating Password Level
		Parameter Type	Range	
Auto Heat	If set to on, auto heat function is enable.	Function	ON / OFF	Level 1
Time(hh:mm)	Set auto heat on time.	Time Hour	00-23	Level 1
		Time Minute	00-59	Level 1
Date(dd:mm:yy)	Set auto heat on date.	Date	01-31	Level 1
		Month	01-12	Level 1
		Year	01-99	Level 1
Sock Time Min.		Time Minute	0-255	Level 1

(8.12) Screen Page: Temperature (2/4)

(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.
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.

Temperature 2/4 page and list of parameter is as per given below.

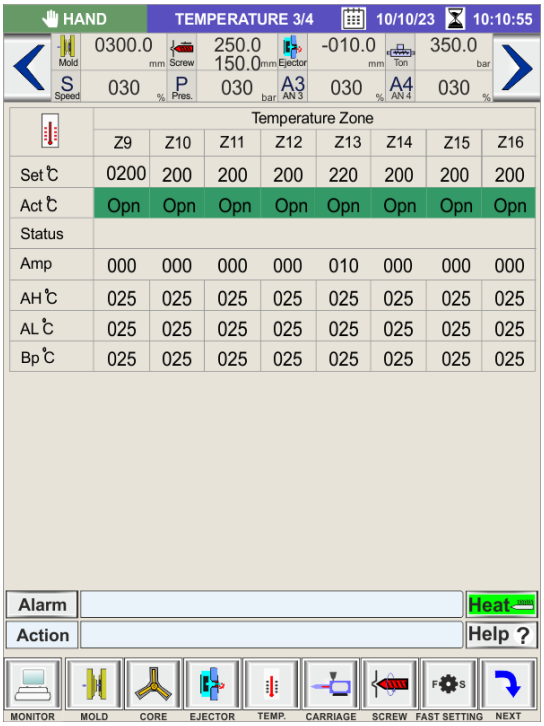


Zone No.	Parameter Name	Description	Range	Default Value	Operating Password Level
Z1 to Z8	Set Limit	Heater Current Limit For example if the set value is 10, if the heater current shows below 10 then the "Heater Current Low..." alarm will occur.	000-100	010	Level 1
	Amp Fsd	Ampere full scale reading	000-010	000	Level 1

(8.13) Screen Page: TEMPERATURE (3/4)

(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.
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.

Temperature 2/4 page and list of parameter is as per given below.



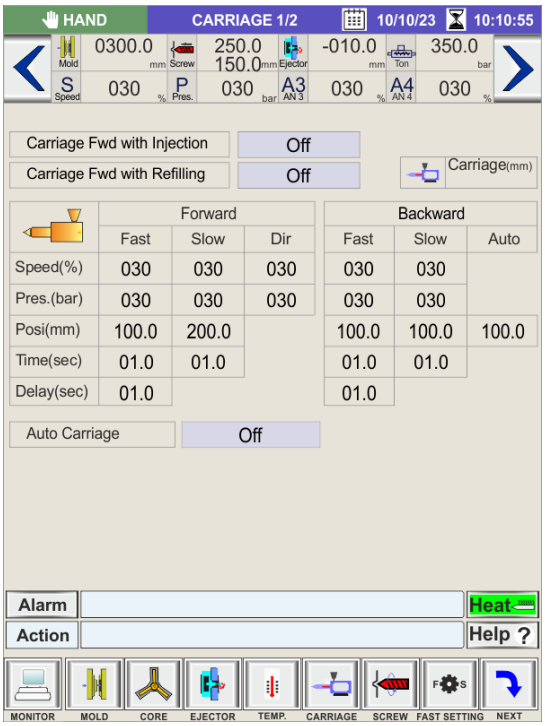
If this page is enabled in the sequence program, it will come, otherwise it will not come.
9-16 Heater zone settings will be done from this page.

(8.14) Screen Page: CARRIAGE 1/2

(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



Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
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 3
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 3
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	Level 1
		Set Carriage forward fast function operating pressure proportional output	Pressure	000-255Bar	Level 1
		Set Carriage forward fast function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set delay time before carriage forward fast function take place	Delay	00.0-99.9Sec	Level 1
		Set carriage forward fast function operating time.	Timer	00.0-99.9Sec	Level 1
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	Level 1
		Set Carriage forward slow function operating pressure proportional output	Pressure	000-255Bar	Level 1
		Set Carriage forward slow function operating Speed proportional output	Speed	000% – 255%	Level 1

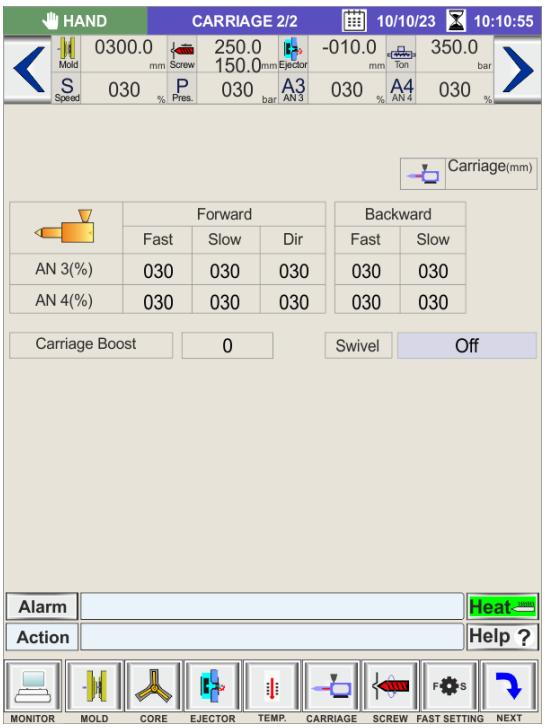
		Set carriage forward slow function operating time.	Timer	00.0-99.9Sec	Level 1
Carriage Forward Direction	The proportional output is enable if carriage forward with injection or refill option is enable Select carriage forward direction proportional output operating action during refill time in semi auto & fully auto.	Set carriage forward direction proportional pressure output during injection or refill time in semi auto & fully auto.	Pressure	000-255Bar	Level 1
		Set carriage forward direction proportional flow output during injection or refill time in semi auto & fully auto.	Speed	000% – 255%	Level 1
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	Level 1
		Set Carriage backward fast function operating pressure proportional output	Pressure	000-255Bar	Level 1
		Set Carriage backward fast function operating Speed proportional output	Speed	000% – 100%	Level 1
		Set delay time before carriage backward fast function take place	Delay	00.0-99.9Sec	Level 1
		Set carriage backward fast function operating time.	Timer	00.0-99.9Sec	Level 1
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	Level 1
		Set Carriage backward slow function operating pressure proportional output	Pressure	000-255Bar	Level 1
		Set Carriage backward slow function operating Speed proportional output	Speed	000% – 100%	Level 1
		Set carriage backward slow function operating time.	Timer	00.0-99.9Sec	Level 1

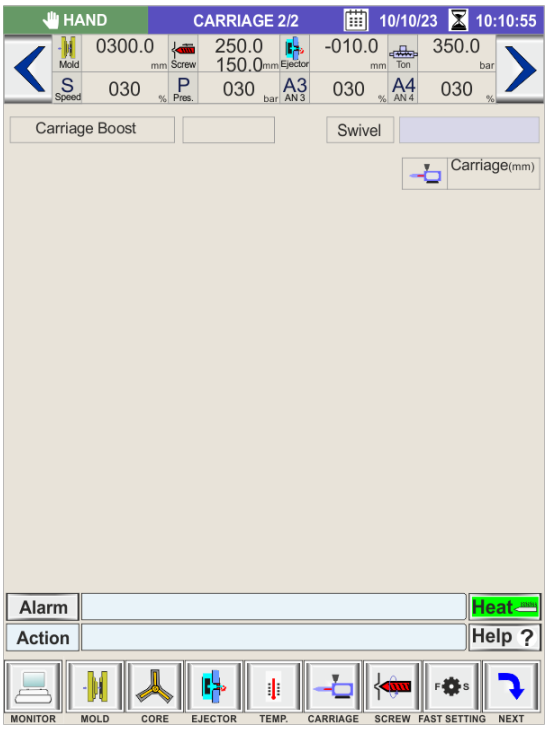
Carriage Backward Auto	Carriage backward stops position for auto mode. With enable auto carriage function carriage backward stop on this set position in every cycle.	Set carriage backward auto position. Always set it less than carriage backward end position.	Position	000.0-999.9	Level 1
Auto Carriage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

(8.15) Screen Page: CARRIAGE 2/2

(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.





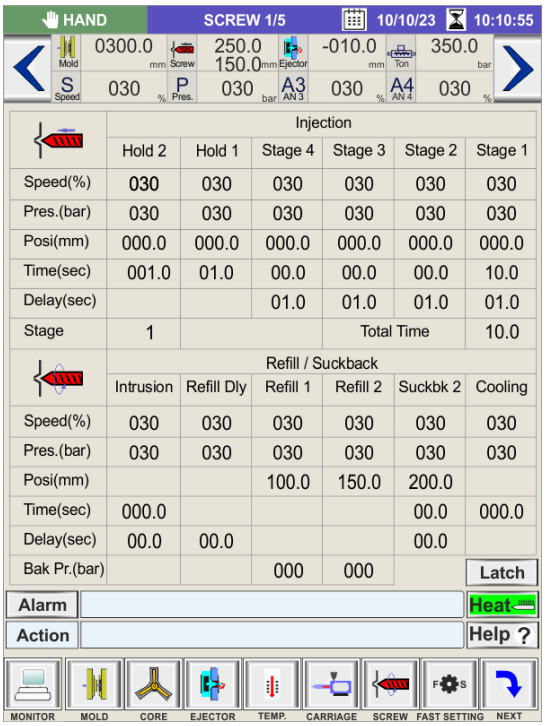
To disable AN3 and AN4 parameter setting go to "CONFIGURE 1/6" page, there "Disable AN Par." To turn on the parameter. So AN 3 and AN 4 parameters will not appear in this page. Which is shown in image (2).

Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Carriage Forward Fast		Set Carriage forward fast function operating AN3 proportional output	AN3	000% – 100%	User Level
		Set Carriage forward fast function operating AN4 proportional output	AN4	000% – 100%	User Level
Carriage Forward Slow		Set Carriage forward Slow function operating AN3 proportional output	AN3	000% – 100%	User Level
		Set Carriage forward Slow function operating AN4 proportional output	AN4	000% – 100%	User Level
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
		Set carriage forward direction proportional AN4 output during injection or refill time in semi auto & fully auto.	AN4	000% – 100%	User Level
Carriage Backward Fast		Set Carriage backward fast function operating AN3 proportional output	AN3	000% – 100%	User Level
		Set Carriage backward fast function operating AN4 proportional output	AN4	000% – 100%	User Level
Carriage Backward Slow		Set Carriage backward slow function operating AN3 proportional output	AN3	000% – 100%	User Level
		Set Carriage backward slow function operating AN4 proportional output	AN4	000% – 100%	User Level
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
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

(8.16) Screen Page: SCREW 1/5

(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.



Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Stages	Select injection-operating stage.	Select operating stage	Number of stage	0 – 4	Level 1
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
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	Level 1
		Set Injection Stage-1 function operating pressure proportional output	Pressure	000Bar – 255Bar	Level 1
		Set Injection Stage-1 function operating Speed proportional output	Speed	000% – 255%	Level 1
		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	Level 1
		Set Injection Stage-1 operating time	Timer	000.0 – 999.9Sec	Level 1
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	Level 1
		Set Injection Stage-2 function operating pressure proportional output	Pressure	000Bar – 255Bar	Level 1
		Set Injection Stage-2 function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Injection Stage-2 operating time	Timer	000.0 – 999.9Sec	Level 1
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	Level 1
		Set Injection Stage-3 function operating pressure proportional output	Pressure	000Bar – 255Bar	Level 1

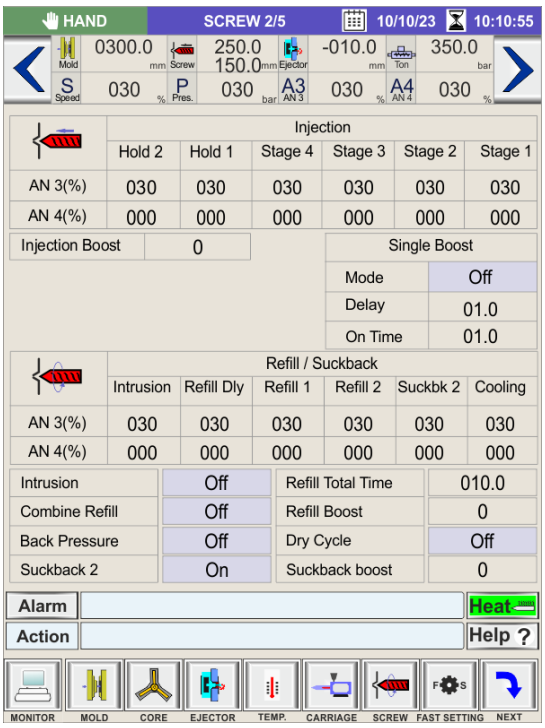
		Set Injection Stage-3 function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Injection Stage-3 operating time	Timer	000.0 – 999.9Sec	Level 1
Stage 4	Injection Stage 4 Injection stage 4 Function work till to reach the stage 4 set position or over the set time	Set Injection Stage-4 function over operating position.	Position	000.0 – 999.9mm	Level 1
		Set Injection Stage-4 function operating pressure proportional output	Pressure	000Bar – 255Bar	Level 1
		Set Injection Stage-4 function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Injection Stage-4 operating time	Timer	000.0 – 999.9Sec	Level 1
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	Level 1
		Set Injection Hold On-1 function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Injection Hold On-1 operating time	Timer	000.0 – 999.9Sec	Level 1
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	Level 1
		Set Injection Hold On-2 function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Injection Hold On-2 operating time	Timer	000.0 – 999.9Sec	Level 1
Intrusion		Set Intrusion function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Intrusion function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Intrusion operating delay time	Delay	00.0 – 99.9Sec	Level 1
		Set Intrusion operating time	Time	000.0 – 999.9Sec	Level 1
Refill Delay		Set Refill delay function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Refill delay function operating Speed proportional output	Speed	000% – 255%	Level 1

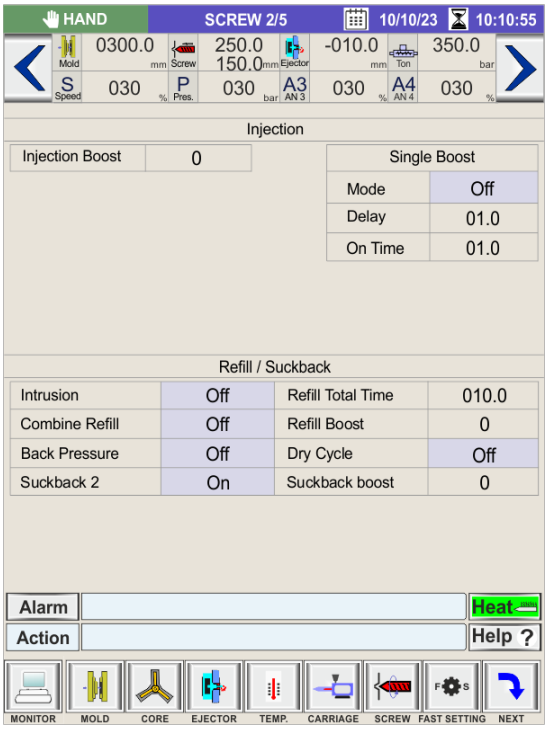
		Set Refill delay operating time	Time	00.0 – 99.9Sec	Level 1
Refill 1		Set Refill-1 function over operating position.	Position	000.0 – 999.9mm	Level 1
		Set Refill-1 function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Refill-1 function operating Speed proportional output	Speed	000% – 255%	Level 1
Refill 2		Set Refill-2 function over operating position.	Position	000.0 – 999.9mm	Level 1
		Set Refill-2 function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Refill-2 function operating Speed proportional output	Speed	000% – 255%	Level 1
Suck back 2		Set Suck back-2 function over operating position.	Position	000.0 – 999.9mm	Level 1
		Set Suck back-2 function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Suck back-2 function operating Speed proportional output	Speed	000% – 255%	Level 1
		On completion of set delay time Suck back-2 function take place. Its start on completion of Refill function	Delay	00.0-99.9Sec	Level 1
		Set Suck back-2 operating time	Time	00.0 – 99.9Sec	Level 1
Cooling		Set Cooling function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Cooling function operating Speed	Speed	000% – 255%	Level 1
		proportional output Set Cooling operating time.	Time	000.0 – 999.9Sec	Level 1
Latch Key	Letch key is used to letch the key of injection and refill function. Pressing and releasing the injection key once immediately after pressing the latch key will continue the injection function up to its limit. Similarly in refill too.				

(8.17) Screen Page: SCREW 2/5

(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.





To disable AN3 and AN4 parameter setting go to "CONFIGURE 1/6" page, there "Disable AN Par." To turn on the parameter. So AN 3 and AN 4 parameters will not appear in this page. Which is shown in image (2).

Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
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
		Set Injection Stage-1 function operating AN4 proportional output	AN4	000% – 100%	User Level
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
		Set Injection Stage-2 function operating AN4 proportional output	AN4	000% – 100%	User Level

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
		Set Injection Stage-3 function operating AN4 proportional output	AN4	000% – 100%	User Level
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
		Set Injection Stage-4 function operating AN4 proportional output	AN4	000% – 100%	User Level
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
		Set Injection Hold On-1 function operating AN4 proportional output	AN4	000% – 100%	User Level
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
		Set Injection Hold On-2 function operating AN4 proportional output	AN4	000% – 100%	User Level
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
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
		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
		Set boost on time	On Time	00.0-99.9	User Level
Intrusion		Set Intrusion function operating AN3 proportional output	AN3	000% – 100%	User
		Set Intrusion function operating AN4 proportional output	AN4	000% – 100%	User
Ref Delay		Set Refill delay function operating AN3 proportional output	AN3	000% – 100%	User
		Set Refill delay function operating AN4 proportional output	AN4	000% – 100%	User

Refill 1		Set Refill-1 function operating AN3 proportional output	AN3	000% – 100%	User
		Set Refill-1 function operating AN4 proportional output	AN4	000% – 100%	User
Refill 2		Set Refill-2 function operating AN3 proportional output	AN3	000% – 100%	User
		Set Refill-2 function operating AN4 proportional output	AN4	000% – 100%	User
Suck back 2		Set Suck back-2 function operating AN3 proportional output	AN3	000% – 100%	User
		Set Suck back-2 function operating AN4 proportional output	AN4	000% – 100%	User
Cooling		Set Cooling function operating AN3 proportional output	AN3	000% – 100%	User
		Set Cooling function operating AN4 proportional output	AN4	000% – 100%	User
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
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 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.	Make on to operate combine refill function	Function	On/Off	Level 1
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
Suck back 2		Set Suck back-2 function operating AN3 proportional output	AN3	000% – 100%	User
		Set Suck back-2 function operating AN4 proportional output	AN4	000% – 100%	User

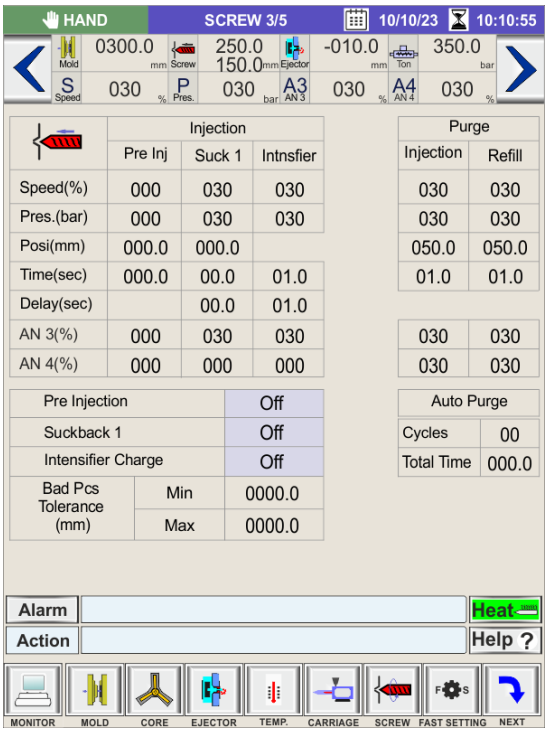
Refill Total Time	Total time for refill function. If refill time is exceed from total time at that time system come in hand mode & display IL..REFILL TIMER OVER.	Set total time for refill function	Timer	000.0-999.9	Level 2
Refill Boost	Select various type of pump selection with Refill function as per output selection provide in sequence table. With boost selection 0 to 3 provide fix output selection. 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
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
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
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

(8.18) Screen Page: SCREW 3/5

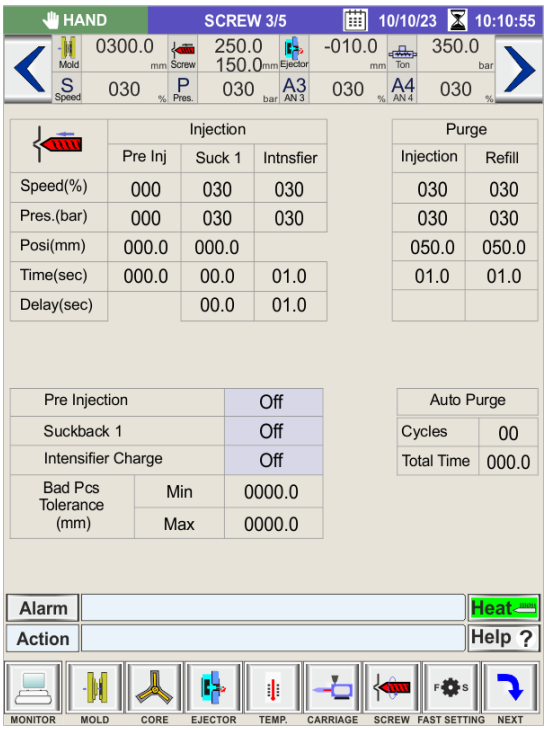
(1) Press" " key once on the top of the Touch Screen.
(2) Now Screen Page: **SCREW 3/5** is displayed on screen in first line.
(3) To change the parameter you have to press on the parameter digit.
(If you change the parameter for the first time you will want password.)
(4) Alphanumeric Touch Key Pad 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.

(1)



(2)



Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
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	Level 1
		Set Pre Injection function operating pressure proportional output	Pressure	000Bar – 255Bar	Level 1
		Set Pre Injection function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Pre Injection operating time	Timer	000.0 – 999.9Sec	Level 1
		Set Pre Injection function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Pre Injection function operating AN4 proportional output	AN4	000% – 255%	Level 1
Suck back 1		Set Suck back-1 function over operating position.	Position	000.0 – 999.9mm	Level 1
		Set Suck back-1 function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Suck back-1 function operating Speed proportional output	Speed	000% – 255%	Level 1
		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	Level 1
		Set Suck back-1 operating time	Time	00.0 – 99.9Sec	Level 1
		Set Suck back-1 function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Suck back-1 function operating AN4 proportional output	AN4	000% – 255%	Level 1
Intensifier		Set Intensifier function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Intensifier function operating Speed proportional output	Speed	000% – 255%	Level 1
		On completion of set delay time Intensifier function take place. Its start on completion of Injection function	Delay	00.0-99.9Sec	Level 1
		Set Intensifier operating time	Time	00.0 – 99.9Sec	Level 1
		Set Intensifier function operating AN3 proportional output	AN3	000% – 100%	Level 1
		Set Intensifier function operating AN4 proportional output	AN4	000% – 100%	Level 1

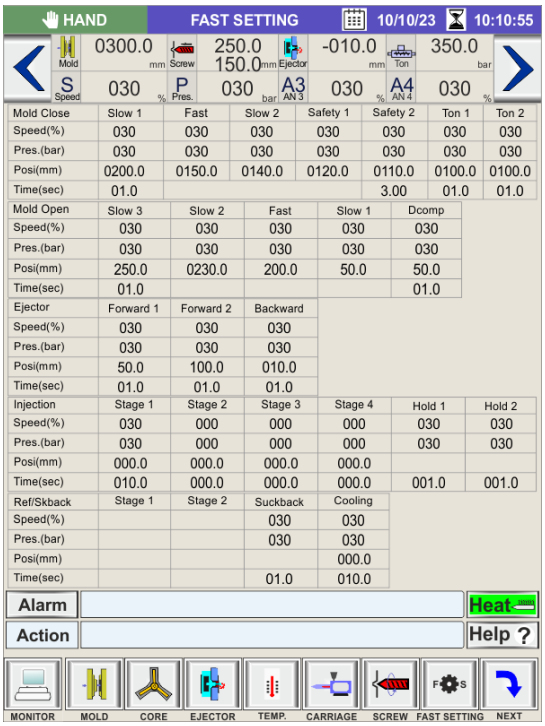
Injection		Set Purge Injection function over operating position.	Position	000.0 – 999.9mm	Level 1
		Set Purge Injection function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Purge Injection function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Purge Injection function operating AN3 proportional output	AN3	000% – 255%	Level 1
		Set Purge Injection function operating AN4 proportional output	AN4	000% – 100%	Level 1
		Set Purge Injection time	Time	000.0 – 99.9Sec	Level 1
Refill		Set Purge Refill function over operating position.	Position	000.0 – 999.9mm	Level 1
		Set Purge Refill function operating pressure proportional output	Pressure	000 – 255Bar	Level 1
		Set Purge Refill function operating Speed proportional output	Speed	000% – 100%	Level 1
		Set Purge Refill function operating AN3 proportional output	AN3	000% – 100%	Level 1
		Set Purge Refill function operating AN4 proportional output	AN4	000% – 100%	Level 1
		Set Purge Refill time	Time	000.0 – 99.9Sec	Level 1
Pre-Injection	Select pre injection function.	Make on to operate Pre injection function	Function	On/Off	Level 1
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
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
Cycles	This function is use to clean up injection barrel while you change material.	Set auto purge mode operating cycle.	Number	00-99	Level 1
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 1
Bad Pcs Tolerance (mm)					Level 3

(8.19) 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.



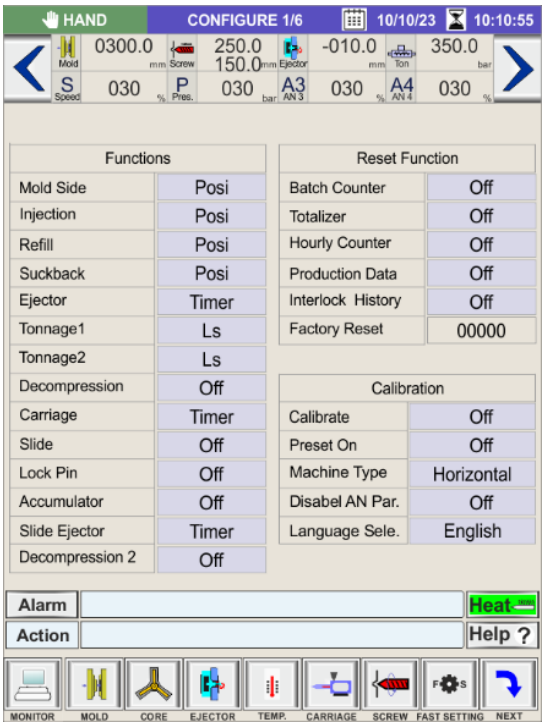
Message Of Parameter On Screen	Function Description	Parameter Description
Mold close parameters	Go to MOLD 1/5 page	Go to MOLD 1/5 page
Mold open parameters	Go to MOLD 1/5 page	Go to MOLD 1/5 page
Ejector parameters	Go to EJECTOR 1/2 page	Go to EJECTOR 1/2 page
Injection parameters	Go to SCREW 1/5 page	Go to SCREW 1/5 page
Ref/Suck back parameters	Go to SCREW 1/5 page	Go to SCREW 1/5 page

(8.20) Screen Page: CONFIGURE 1/6

(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.



Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
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

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
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
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
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
Tonnage 1	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 feedback	Select tonnage 1 function operating type.	Function	Position/Ls/Timer	Level 2

	select TIMR mode operating type.				
Tonnage 2	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
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
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
Slide	Used for slide table- vertical clamping injection machine	Select Slide function operating type	Function	Off/Position/Ls/Timer	Level 2
Lock Pin	Used for Rotary table-vertical clamping injection molding machine	Select Lock Pin function operating type	Function	Off/Position/Ls/Timer	Level 2

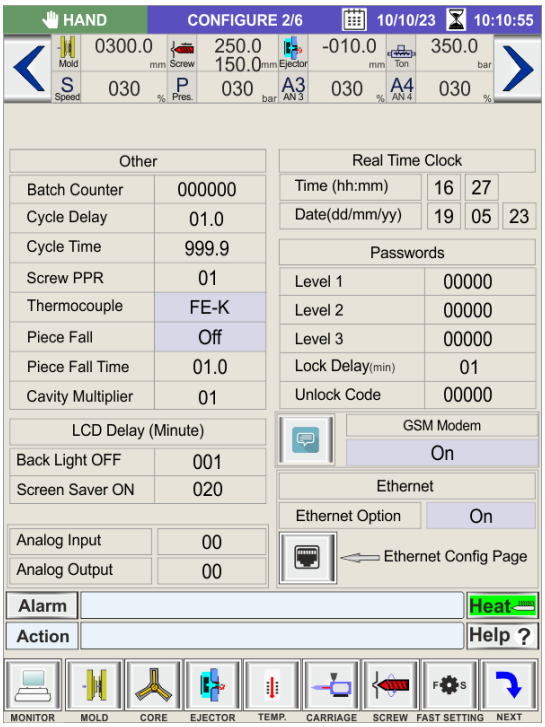
Accumulator	The accumulator is designed to boost the injection forward motion to aid in the filling process of thin walled parts	Select Accumulator function operating type	Function		
Slide Ejector	Used for slide table- Rotary table vertical clamping injection machine				
Decompression 2	This will come when the parameter version is updated.				
Batch Counter	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
Totalizer	If set to on, totalize counter is reset to zero.	Make on to reset Totalizer counter.	Function	On/Off	Level 3
Hourly Counter	If set to on, hour counter is reset to zero.	Make on to reset Hour counter.	Function	On/Off	Level 3
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
Interlock History	If set to on, Interlock history is reset.	Make on to reset production data.	Function	On/Off	Level 3
Factory Reset	A factory reset will default all recipes and constant parameters Call to the customer care number for factory reset.	Enter value to do factory reset	Function	Fix value	Level 3
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
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
Machine Type	The graphics of the machine can be changed using this parameter. You can see it on the monitor page. It has two graphics selection for horizontal molding machine and for vertical molding machine.	Select to change it	Operating	HORIZONTAL /VERTICAL	Level 2

Disable AN Par.	Using this parameter, the AN3 and AN4 parameters of all functions can be turned off.	Select to change it	Operating	On/Off	Level 2
Language Sele.	This is the language selection parameter. English, Hindi, Gujarati language selection is given in it.	Select to change it	Operating	English/Hindi/ Gujarati	Level 2

(8.21) Screen Page: CONFIGURE 2/6

(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.



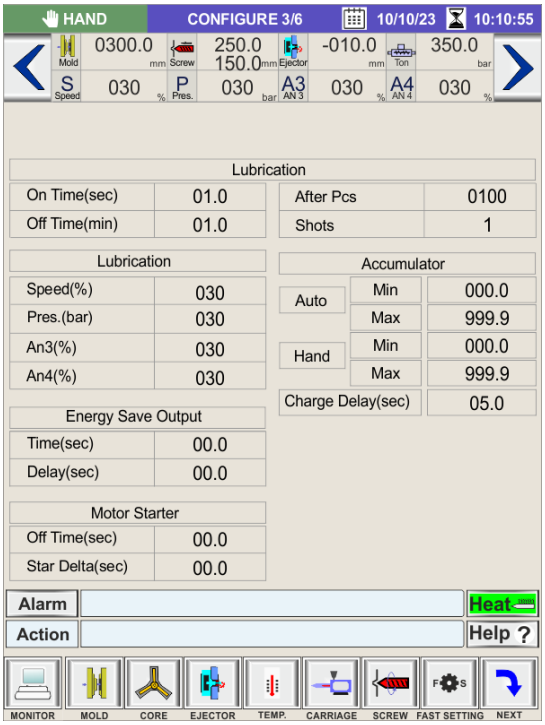
Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Batch Counter	Batch Counter preset value. The batch counter resets on reaching this Count. On over Speed batch counter system comes into HAND mode. On setting value 00000 disables the counter.	Set batch count	Number	00000-99999	Level 1
Cycle Delay	Set delay between two continues cycles in fully auto mode.	Set delay time between two cycles.	Timer	00.0-99.9	User
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
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
Thermocouple	Selection provide for Fe-K (J-Type) or Cr-Al (K-Type) type thermocouple to measure barrel temperature.	Select thermocouple type	Function	Fe-K / Cr-Al	Level 2
Piece fall		For piece fall confirmation needed during cycle	Function	ON/OFF	Level 2
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 cycle. This time start with mold open function	Timer	0-99.9Sec	Level 2
Cavity Multiplier	To set according to the cavity of the mold. For example, if the cavity is 2, then a machine shot will count 2.				
LCD Delay (Minute)	If screen saver parameter is set to 3 minutes and backlight off parameter is set to 1 minute then after 3 minutes the screen saver will come on and after 1 minute the backlight will turn off. (When PLC is in ideal condition)	Back Light OFF	Timer	00-30mnt	Level 3
		Screen Saver ON	Timer	00-30mnt	Level 3
Analog Input	This is an analog Input hardware IC selection parameter.	Set number	Number	0-1	Level 3

Analog Output	This is an analog output hardware IC selection parameter.	Set number	Number	0-1	Level 3
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
		Set minute time	Time Minute	00-59	Level 2
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
		Set Month	Month		Level 2
		Set year	Year		Level 2
Level 1	Set password level 1 to protect software decided configures parameters at level 1.	Set password level 1	Number	0000-65535	Level 3
Level 2	Set password level 2 to protect software decided configures parameters at level 2.	Set password level 2	Number	0000-65535	Level 3
Level 3	Set password level 3 to protect software decided configures parameters at all level.	Set password level 2	Number	0000-65535	Level 3
Lock Delay (min)	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
Unlock Code	To unlock the PLC system after it is locked, enter the password in this space.	Enter Password	Number	0000-65535	Level 3
GSM Modem	Used for GSM connection.	To On for Use	Number	On/Off	Level 3
Ethernet Option	Used for Ethernet connection.	To On for Use	umber	On/Off	Level 3

(8.22) Screen Page: CONFIGURE 3/6

(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.

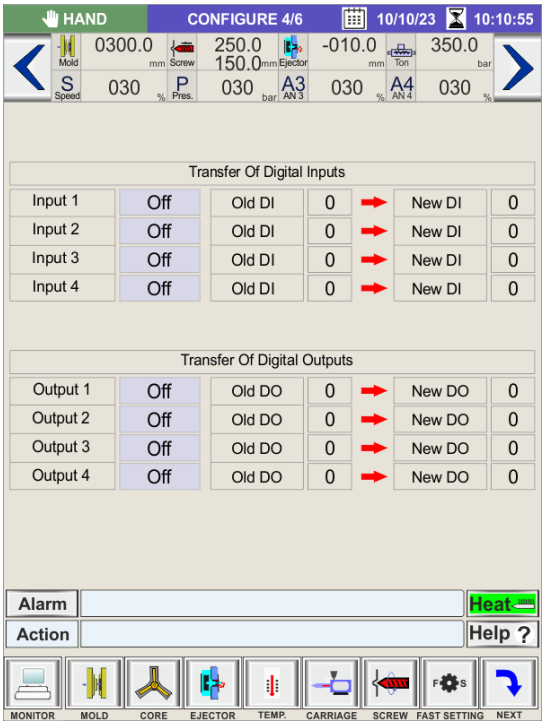


Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Lubrication After Pcs	With enter count here time base lubrication function is disable and auto cycle base lubrication is start.	Set auto cycle then after lubrication function make on.	Number	000-999	Level 1
Lubrication On Time	Set lubrication on time.	Set lubrication on time.	Number	00.0-99.9	Level 1
Lubrication Off Time	Set lubrication off time.	Set lubrication off time.	Number	00.0-99.9	Level 1
Lubrication Shots	Set lubrication shots		Number	0-9	Level 1
Lubrication	This function is use to provide oil to machine.	Set Lubrication function operating pressure proportional output	Pressure	000 – 255Bar	Level 2
		Set Lubrication function operating Speed proportional output	Speed	000% – 100%	Level 2
		Set Lubrication function operating AN3 proportional output	AN3	000% – 100%	Level 2
		Set Lubrication function operating AN4 proportional output	AN4	000% – 100%	Level 2
Energy Save Time(Sec)	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 then goes off.	Set on time for energy save output	Timer	00.0-99.9Sec	Level 2
Energy Save Delay(Sec)		Set on delay for energy save output	Delay	00.0-99.9Sec	Level 2
Motor Starter 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
Motor Starter Star Delta (sec)		Set on time for star motor on	Timer	00.0-99.9Sec	Level 2
Accumulator: Auto Min		Select Accumulator charging function minimum limit for AUTO mode only.	Position	000.0-999.9	Level 3
Accumulator: Auto Max		Select Accumulator charging function maximum limit for AUTO mode only.	Position	000.0-999.9	Level 3
Accumulator: Hand Min		Select Accumulator charging function minimum limit for HAND mode only.	Position	000.0-999.9	Level 3
Accumulator: Hand Max		Select Accumulator charging function maximum limit for HAND mode only.	Position	000.0-999.9	Level 3
Accumulator: Charge Delay		Set accumulator charge delay	Delay	00.0-99.9	Level 3

(8.19) Screen Page: CONFIGURE 4/6

(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.



Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
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
Old DI	Enter old faulty digital input number.	Select faulty digital input number	Number	00-64	Level 2
New DI	Enter new spare digital input number.	Select spare digital input number where faulty input shift	Number	00-64	Level 2
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
Old DI	Enter old faulty digital input number.	Select faulty digital input number	Number	00-64	Level 2
New DI	Enter new spare digital input number.	Select spare digital input number where faulty input shift	Number	00-64	Level 2
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
Old DI	Enter old faulty digital input number.	Select faulty digital input number	Number	00-64	Level 2
New DI	Enter new spare digital input number.	Select spare digital input number where faulty input shift	Number	00-64	Level 2
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
Old DI	Enter old faulty digital input number.	Select faulty digital input number	Number	00-64	Level 2
New DI	Enter new spare digital input number.	Select spare digital input number where faulty input shift	Number	00-64	Level 2
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
Old DO	Enter old faulty digital output number.	Select faulty digital output number	Number	00-64	Level 2
New DO	Enter new spare digital output number.	Select spare digital output number where faulty output shift	Number	00-64	Level 2
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
Old DO	Enter old faulty digital output number.	Select faulty digital output number	Number	00-64	Level 2
New DO	Enter new spare digital output number.	Select spare digital output number where faulty output shift	Number	00-64	Level 2
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

Old DO	Enter old faulty digital output number.	Select faulty digital output number	Number	00-64	Level 2
New DO	Enter new spare digital output number.	Select spare digital output number where faulty output shift	Number	00-64	Level 2
Op4:Trans	If set to on, OP4 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
Old DO	Enter old faulty digital output number.	Select faulty digital output number	Number	00-64	Level 2
New DO	Enter new spare digital output number.	Select spare digital output number where faulty output shift	Number	00-64	Level 2

(8.24) Screen Page: CONFIGURE 5/6

(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.

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

Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
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
		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
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
		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
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
		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
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
		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
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
		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
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
		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

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
		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
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
		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
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
		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
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
		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
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
		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
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
		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

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
		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
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
		Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Shutter Closed function	Decl	0-9.99 sec	Level 2
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
		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
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
		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
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
		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
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
		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

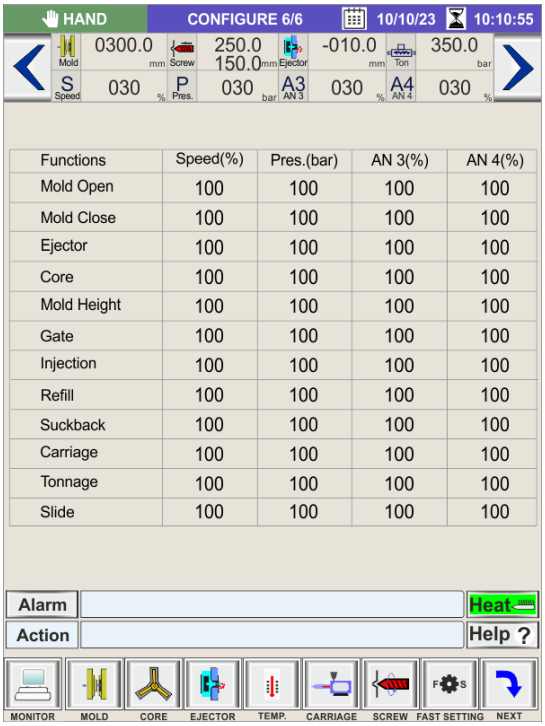
Core 2 OUT		Set Acel Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 2 OUT function	Acel	0 -9.99 sec	Level 2
		Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog output maximum in Core 2 OUT function	Decl	0-9.99 sec	Level 2
Core 3 OUT		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
		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
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
		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
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
		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
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 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
		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
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
		Set Decl Value in 0 to 9.99 sec. to parameter set 0 to Set value then analog	Decl	0-9.99 sec	Level 2

		output maximum in Refilling function			
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
		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
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
		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
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
		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
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
		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

(8.25) Screen Page: CONFIGURE 6/6

(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.



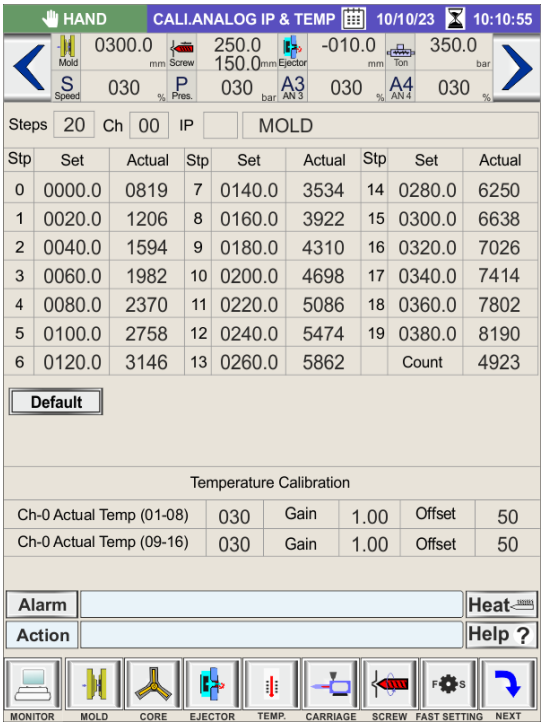
Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Mold Open	setting in all Mold open function	This value define the maximum permitted pressure setting in all mold Open function	Pressure	000-255 Bar	Level 3
		This value define the maximum permitted Speed setting in all mold Open function	Speed	000%-100%	Level 3
		This value define the maximum permitted AN 3 setting in all mold Open function	AN 3	000%-100%	Level 3

		This value define the maximum permitted AN 4 setting in all mold Open function	AN4	000%-100%	Level 3
Mold closed	setting in all Mold close function	This value define the maximum permitted pressure setting in all Mold closed function	Pressure	000-255 Bar	Level 3
		This value define the maximum permitted Speed setting in all Mold closed function	Speed	000%-100%	Level 3
		This value define the maximum permitted AN3	AN 3	000%-100%	Level 3
		This value define the maximum permitted AN4 setting in all Mold closed function	AN4	000%-100%	Level 3
Ejector		This value define the maximum permitted pressure setting in all Ejector function	Pressure	000-255 Bar	Level 3
		This value define the maximum permitted Speed setting in all Ejector function	Speed	000%-100%	Level 3
		This value define the maximum permitted AN 3 setting in all Ejector function	AN 3	000%-100%	Level 3
		This value define the maximum permitted AN4 setting in all Ejector function	AN4	000%-100%	Level 3
Core		This value define the maximum permitted pressure setting in all Core function	Pressure	000-255 Bar	Level 3
		This value define the maximum permitted Speed setting in all Core function	Speed	000%-100%	Level 3
		This value define the maximum permitted AN3 setting in all Core function	AN 3	000%-100%	Level 3
		This value define the maximum permitted AN4 setting in all Core function	AN4	000%-100%	Level 3
Mold Height		This value define the maximum permitted pressure setting in all Mold Height function	Pressure	000-255 Bar	Level 3
		This value define the maximum permitted pressure setting in all Mold Height function	Speed	000%-100%	Level 3

		This value define the maximum permitted AN3 setting in all Mold Height function	AN 3	000%-100%	Level 3
		This value define the maximum permitted AN4 setting in all Mold Height function	AN4	000%-100%	Level 3
Gate		This value define the maximum permitted pressure setting in all Gate function	Pressure	000-255 Bar	Level 3
		This value define the maximum permitted Speed setting in all Gate function	Speed	000%-100%	Level 3
		This value define the maximum permitted AN3 setting in all Gate function	AN 3	000%-100%	Level 3
		This value define the maximum permitted AN4 setting in all Gate function	AN4	000%-100%	Level 3
Injection		This value define the maximum permitted pressure setting in all Injection function	Pressure	000-255 Bar	Level 3
		This value define the maximum permitted Speed setting in all Injection function	Speed	000%-100%	Level 3
		This value define the maximum permitted AN3 setting in all Injection function	AN 3	000%-100%	Level 3
		This value define the maximum permitted AN4 setting in all Injection function	AN4	000%-100%	Level 3
Refilling		This value define the maximum permitted pressure setting in all Refilling function	Pressure	000-255 Bar	Level 3
		This value define the maximum permitted Speed setting in all Refilling function	Speed	000%-100%	Level 3
		This value define the maximum permitted AN3 setting in all Refilling function	AN 3	000%-100%	Level 3
		This value define the maximum permitted AN4 setting in all Refilling function	AN4	000%-100%	Level 3

Suck back		This value define the maximum permitted pressure setting in all Suck back function	Pressure	000-255 Bar	Level 3
		This value define the maximum permitted Speed setting in all Suck back function	Speed	000%-100%	Level 3
		This value define the maximum permitted AN3 setting in all Suck back function	AN 3	000%-100%	Level 3
		This value define the maximum permitted AN4 setting in all Suck back function	AN4	000%-100%	Level 3
		This value define the maximum permitted pressure setting in all Carriage function	Pressure	000-255 Bar	Level 3
Carriage		This value define the maximum permitted Speed setting in all Carriage function	Speed	000%-100%	Level 3
		This value define the maximum permitted AN3 setting in all Carriage function	AN 3	000%-100%	Level 3
		This value define the maximum permitted AN4 setting in all Carriage function	AN4	000%-100%	Level 3
Tonnage		This value define the maximum permitted pressure setting in all Tonnage function	Pressure	000-255 Bar	Level 3
		This value define the maximum permitted Speed setting in all Tonnage function	Speed	000%-100%	Level 3
		This value define the maximum permitted AN3 setting in all Tonnage function	AN 3	000%-100%	Level 3
		This value define the maximum permitted AN4 setting in all Tonnage function	AN4	000%-100%	Level 3

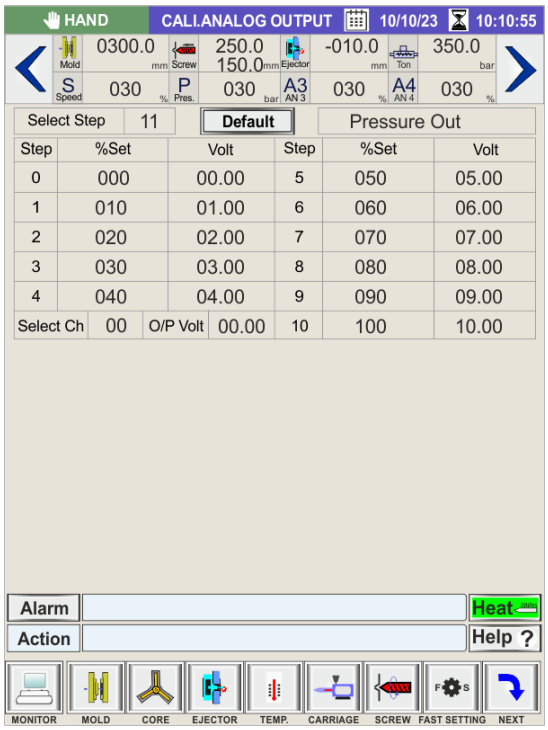
(8.26) Page Screen: CALI.AI



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 mold movement.
17	Similarly, the calibration of the screw, ejector can be done by channel number.

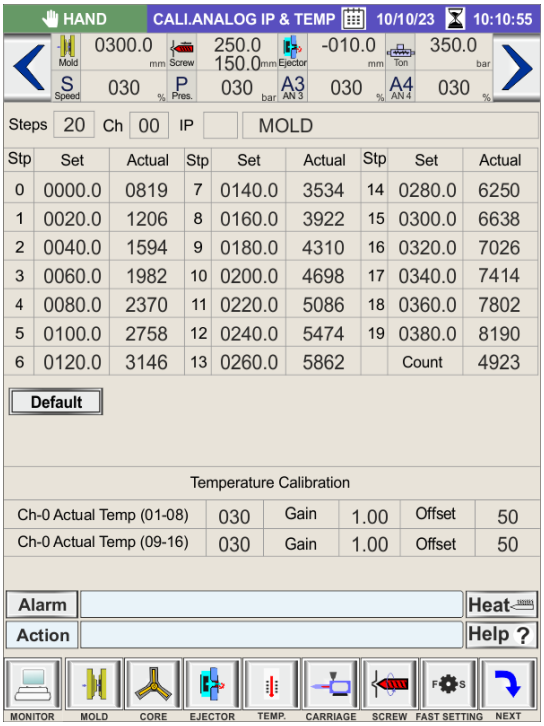
(8.27) Page Screen: CALI.AO



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

(8.28) Page Screen: CALI.TEMP.

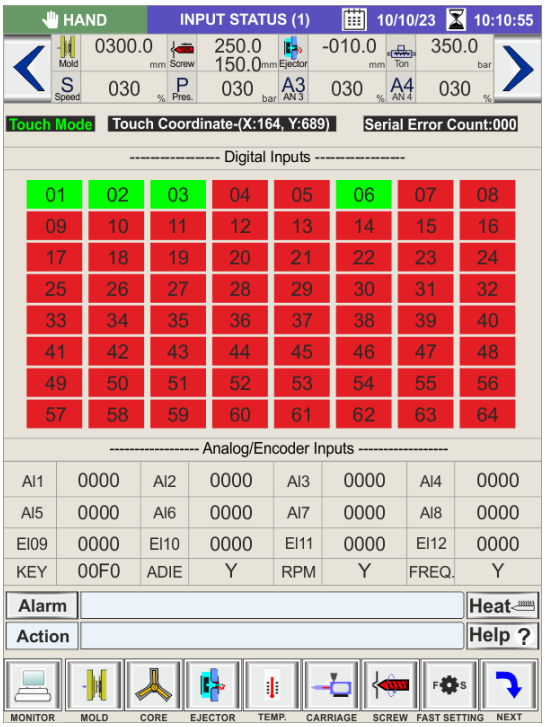


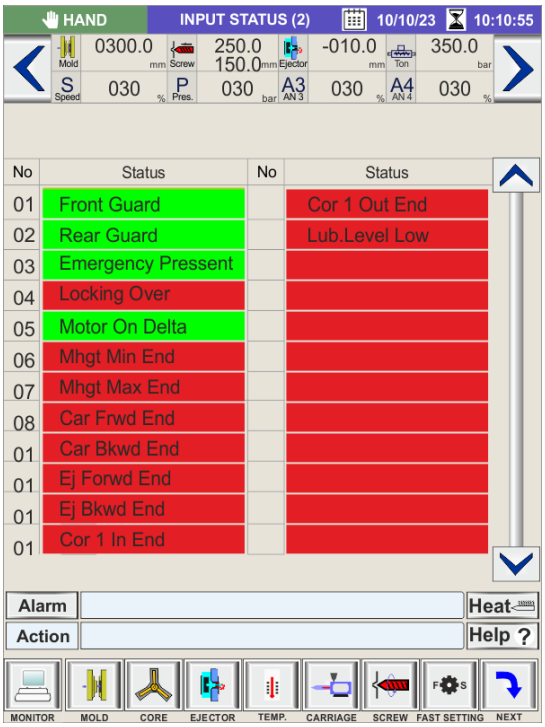
The procedure for calibration of temperature calibration is as follows.

1	If you are in another Menu Bar , otherwise pressing “next “ or “Previews” key, And go to the “Output”
2	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“
3	Set 10 mV thru mili volt generator Verify “ CH 0 ACT Temp “
4	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 / Down arrow key and Set Value by Select(+) / Cancel (-) Keys].
5	Once Gain Value set by INC (+) / INC (-) key press Enter for saving the “Gain “Value.
6	Press MONITOR touch key to exit CALI.TEMP mode.

(8.29) INPUT STATUS (1), (2)

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



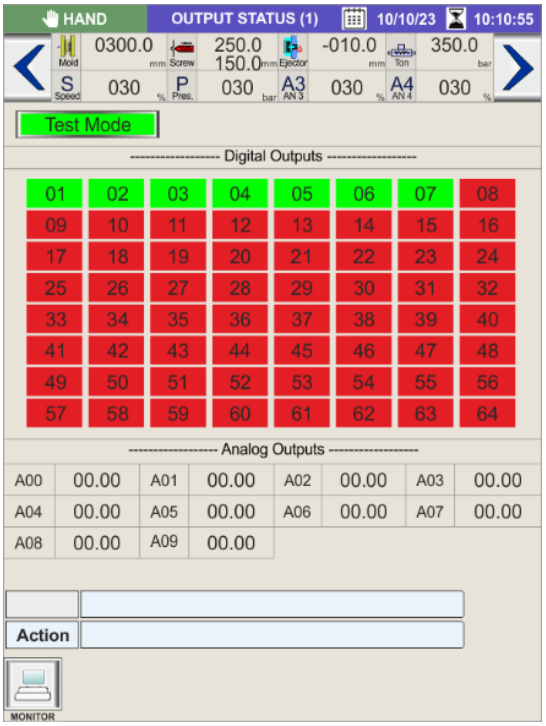


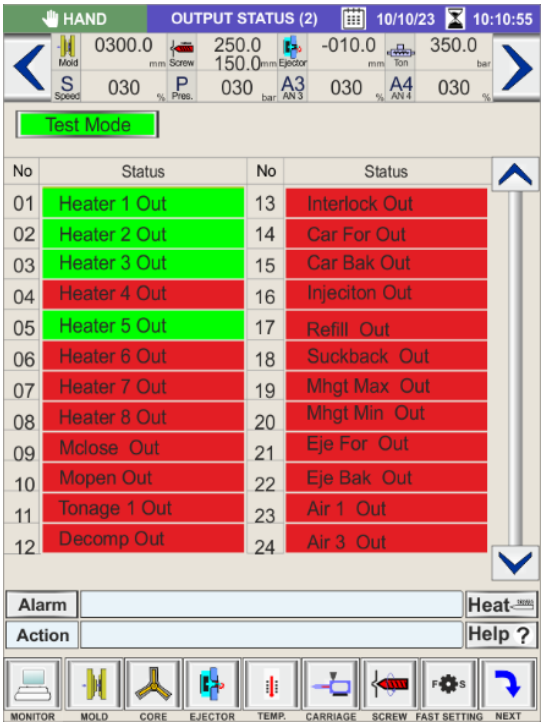
The following is how to show the digital inputs.

1	Go to the input Status by pressing “INPUT” 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 “Next button “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 INPUT Page.

(8.30) Screen Page: OUTPUT STATUS (1), (2)

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.

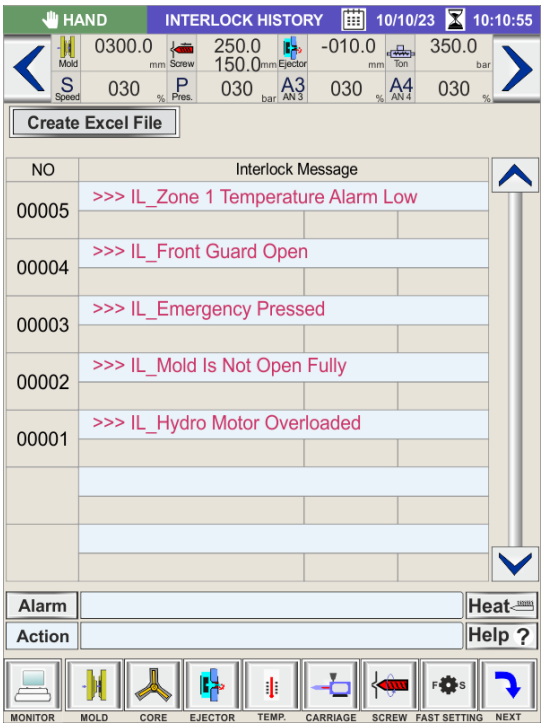




The following is how to turn on or off the digital and analog outputs

1	Go to the Output Status by pressing “OUTPUT” 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 “Next “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.

(8.31) Page Screen: INTERLOCK HISTORY



1	Press" INTERLOCK" 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.
4	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.

Operation	Interlocks Messages On Screen	Description Of Messages	Type Of Mode		
			Hand	Semi Auto	Fully Auto
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
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
Unit Forward	IL..UNIT FORWARD END REACHED	Carriage Forward End	Y	Y	Y
	IL_ Nozzle Guard Absent..	Nozzle guard input present		Y	Y
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
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
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
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
Ejector Forward	IL..EJECTOR FORWARD END.	Ejector Forward end	y	y	Y
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
Core in	IL_ mold not in core in position	Mold close position not present for core IN	y	y	Y
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
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
Core 2 In	IL..CORE 2 IN END.	Core 2 in End	y	y	Y
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
Core 3 In	IL..CORE 3 IN END.	Core 3 in End	y	y	Y

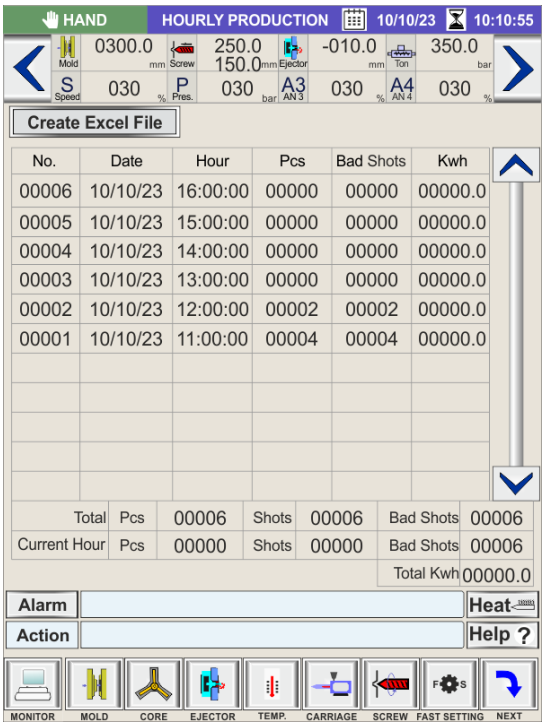
Core 3 Out	IL..CORE 3 OUT END.	Core 3 out End	y	y	Y
	IL..CORE 3 PARTIAL OUT END.	Core 3 not out	y	y	Y
Core 4 In	IL..CORE 4 IN END.	Core 4 in End	y	y	Y
Core 4 Out	IL..CORE 4 OUT END.	Core 4 out End	y	y	Y
	IL..CORE 4 PARTIAL OUT END.	Core 4 not out	y	y	Y
Mold Height Min.	IL..MOLD HEIGHT MINIMUM END.	Mold Height minimum End	y	y	Y
	IL Mold Height Min.	Mold Height minimum	y	y	Y
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
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
Robot	IL_ Robot Time out	If robot function is ON			y
	IL _Robot Not at Home Position	Robot Not home Position		y	y
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
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		
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
Gate	IL_ Gate Open End..	Gate Open End		y	y
	IL _Gate Close End..	Gate Close End		y	y
	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			
Shutter	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
Slide	IL_ Slide Not In Position	Slide in End		y	y
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

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

(8.32) 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 hour's shots show differently in this page.

Hourly Production page and list of parameter is given below

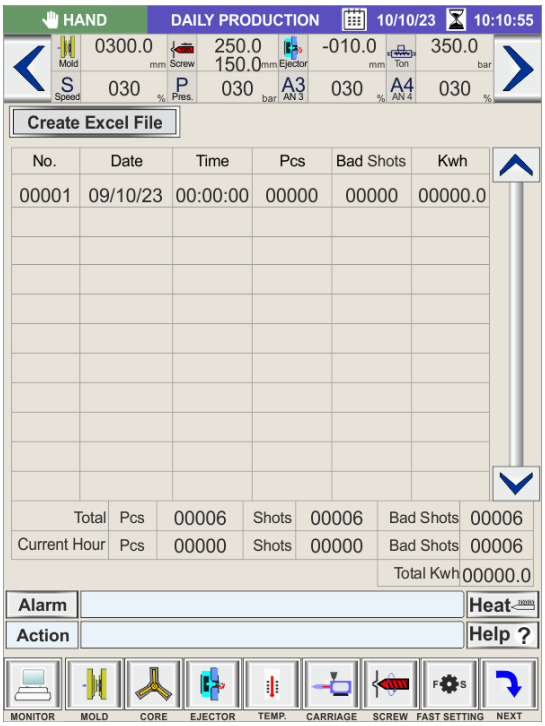


(8.33) Page Screen: DAILY PRODUCTION

1. Press" 

" key once on the bottom of the Touch Screen.
2. Now Screen Page: **DAILY PRODUCTION** is displayed on screen in first line.
3. In this page whole day production shows of 30 days. Current day's production shows separately.

Hourly Production page and list of parameter is given below

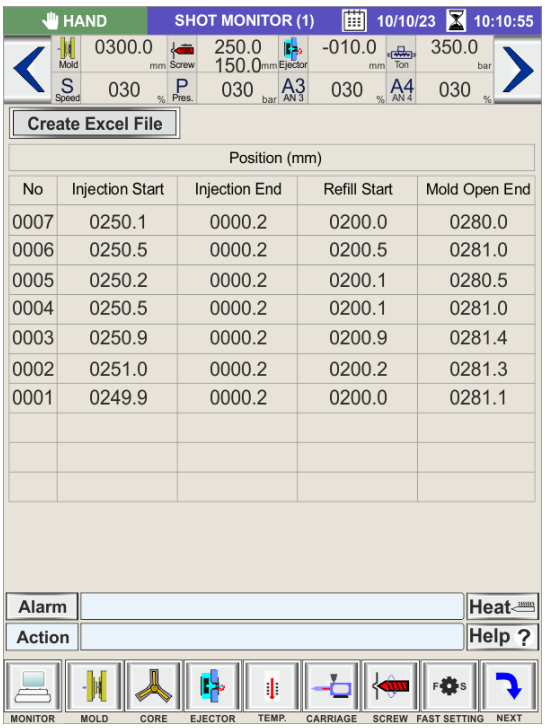


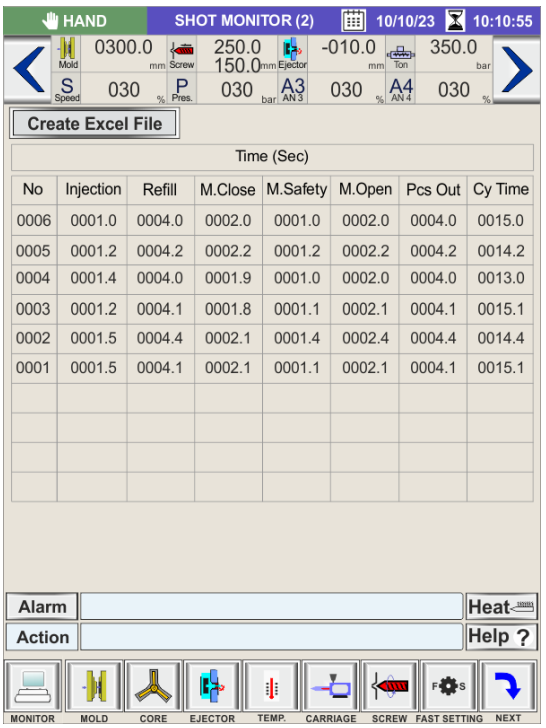
(8.34) Page Screen: SHOT MONITOR (1), (2)

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, Pc Out) Total Cycle time show in Page.

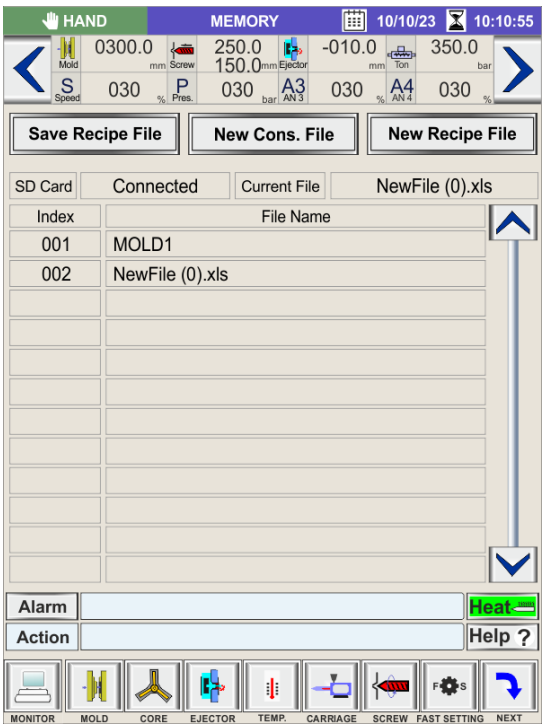
.

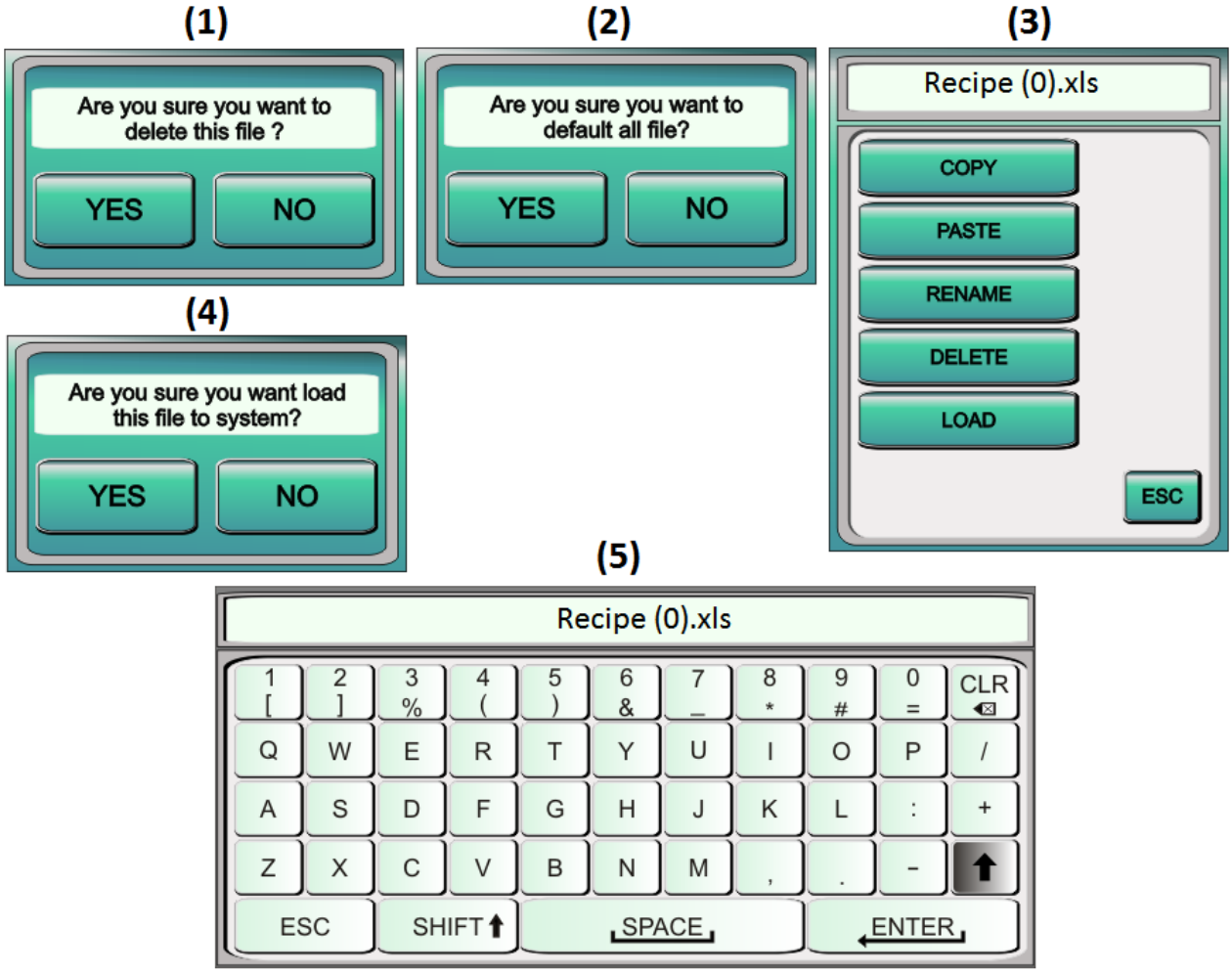




(8.35) Page Screen: MEMORY

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.



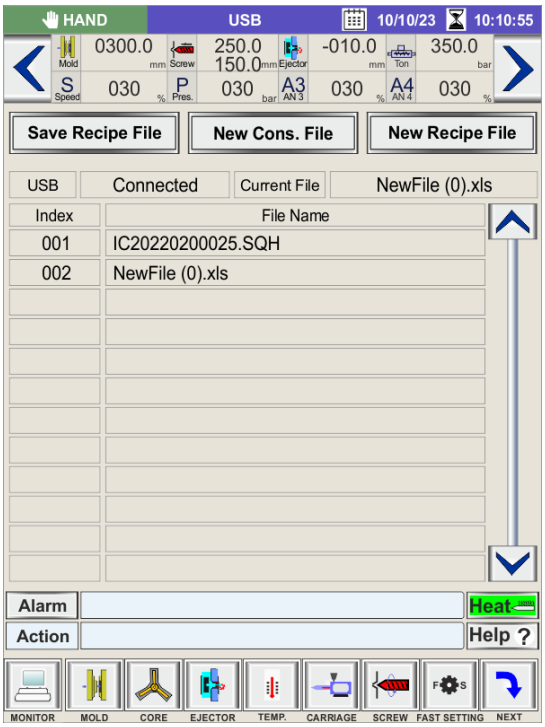


1	Go to mold memory setting page by pressing “MEMORY” on Menu Key Bar.
2	If you are in another Menu Bar , otherwise pressing “next “ or “Previews” key, And go to the “MEMORY”
3	So screen appears MEMORY is displayed on screen in first line.
4	Now press the “New File” key to save the mold that is currently 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 keyboard like this (image 5) will appear on the screen, now type the name of the mold, then presses enter.
7	Now the name of the mold memory will appear on the screen. All the molds can be saved as follows.
8	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.
10	

(8.36) Page Screen: USB

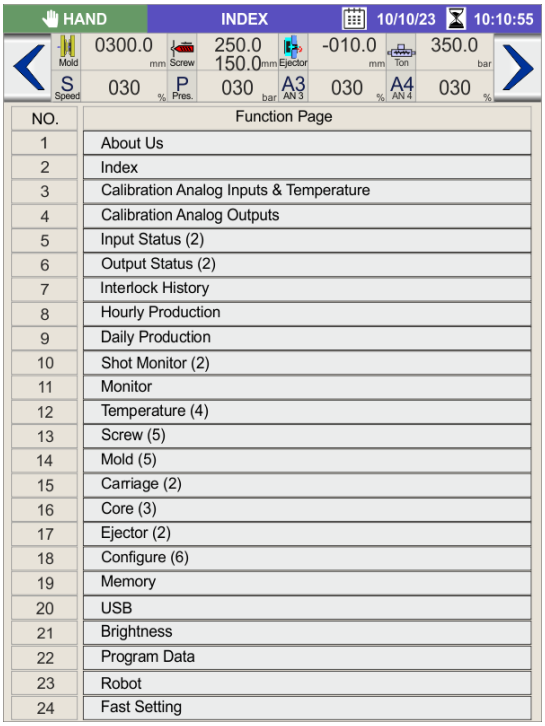
Press” 

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



(8.37) 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.



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	Temperature (4)
13	Screw (5)
14	Mold (5)
15	Carriage (2)
16	Core (3)
17	Ejector (2)
18	Configure (6)
19	Memory
20	USB
21	Brightness
22	Program Data
23	Robot
24	Fast Setting

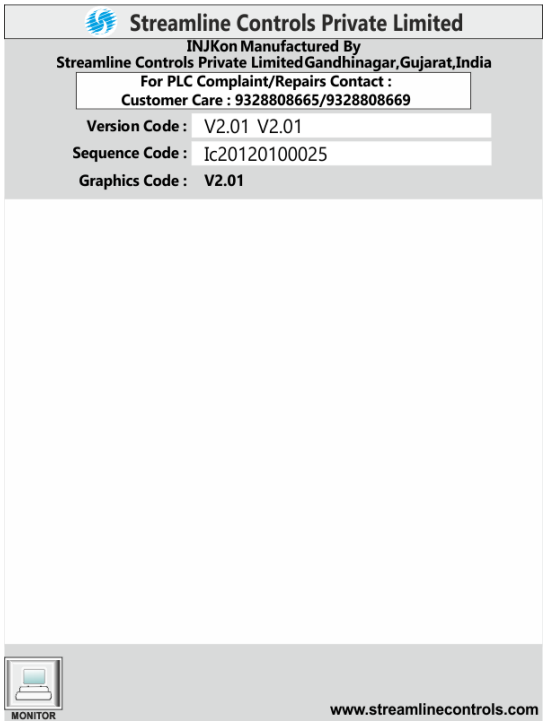
(8.38) Page Screen: ABOUT US

This is the Startup screen, when you first turn on the power of plc this screen first appears, as per image (1).
You can also see this screen by pressing “about us” touch key.
In this screen you can see OEM information, the streamline company logo will appear in the default setting.

By pressing the about us touch button, the screen will open as shown in image (2) on touching the screen that opens. This screen will show software version information and company information.
This screen can also be viewed by directly pressing the "0" key while on the monitor screen.

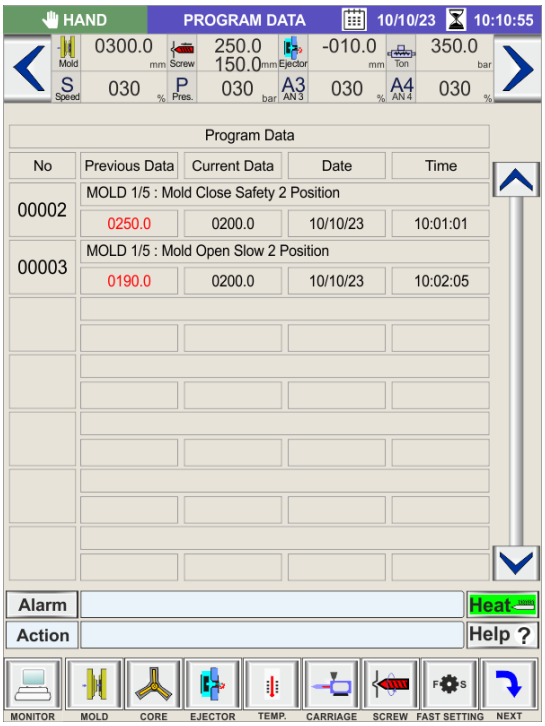
(1)

(2)



(8.39) Page Screen: PROG. DATA

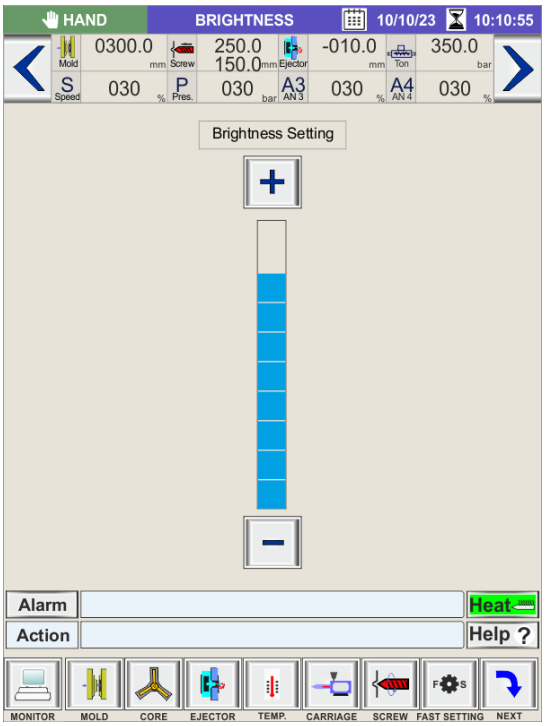
This is the Program data changes list screen,
In this page you can see the list of parameter changes. For example, let's take a parameter like 0250.0 in the Mold Close Safety2 Position, now we save 0200.0, so the first parameter is 0250.0 and the current parameter is 0200.0 So it will be shown in this list.



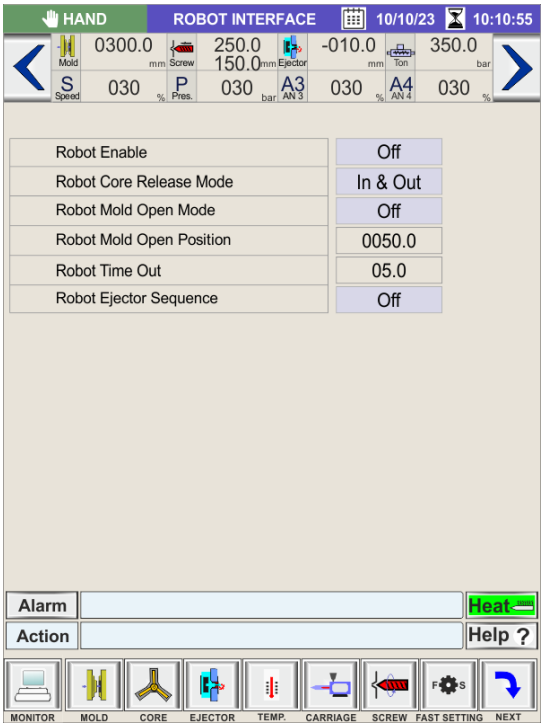
(8.40) Page Screen: BRIGHTNESS

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

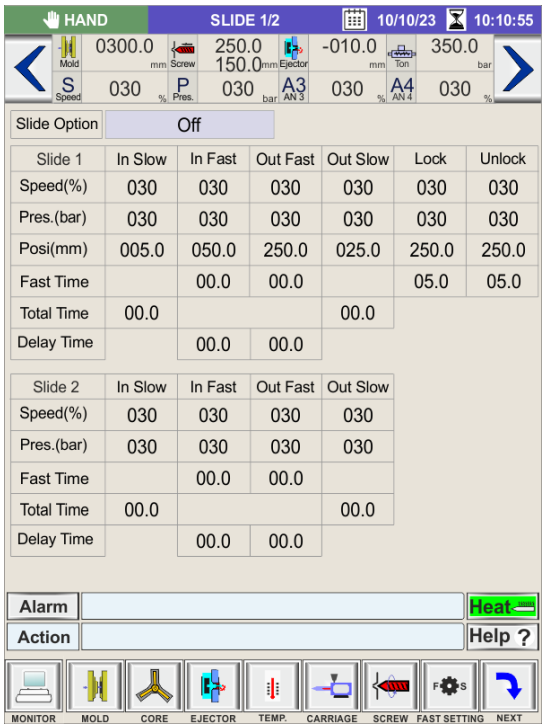
Increasing the lcd's brightness by pressing the "+" touch key. Or from the Select+ key on the keypad
Decreasing the lcd's brightness by pressing the "-" touch key. Or from the Select+ key on the keypad

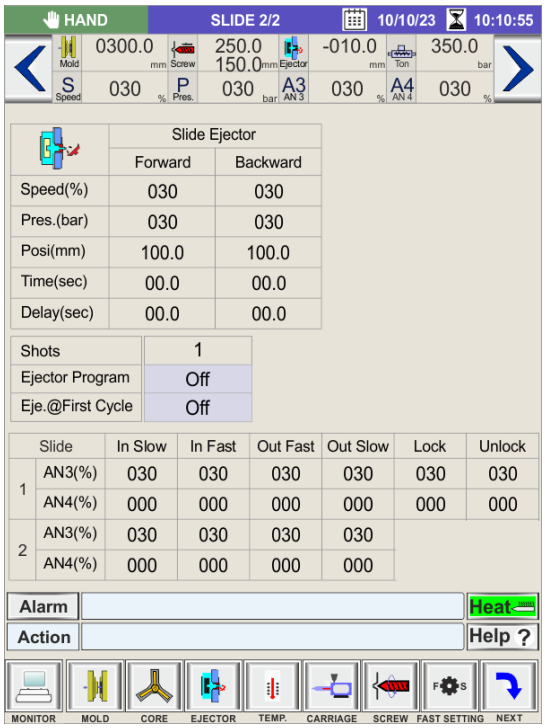


Page Screen: ROBOT

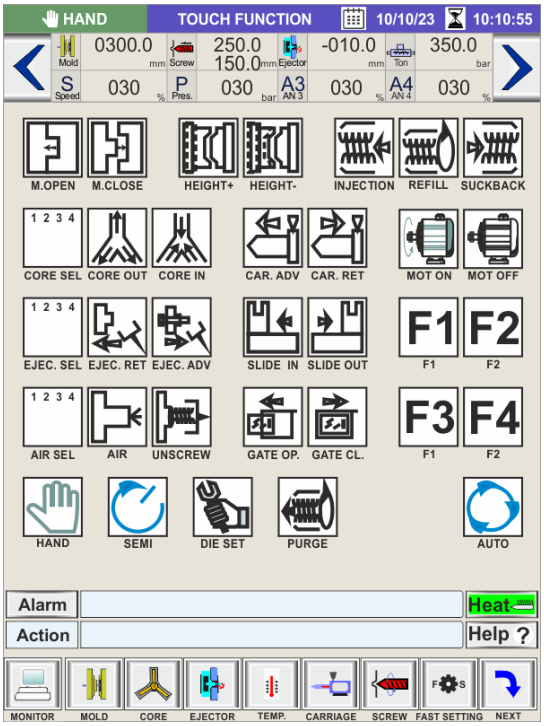


(8.41) Page Screen: SLIDE

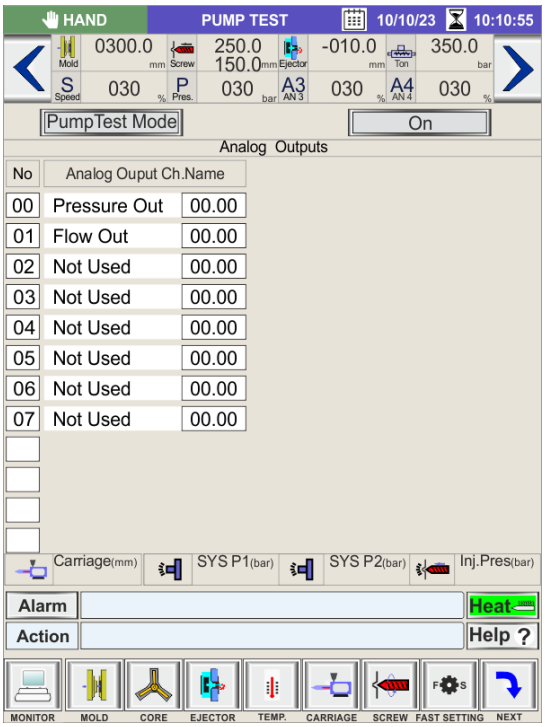




(8.42) Page Screen: TOUCH FUN.

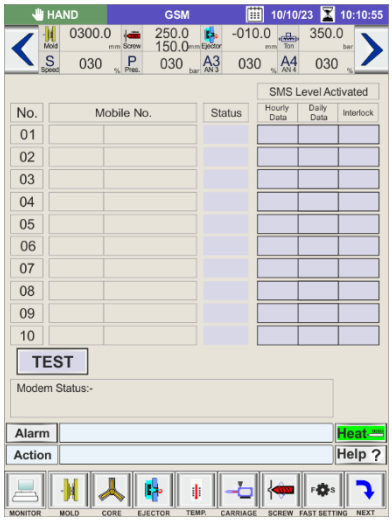


(8.43) Page Screen: PUMP TEST

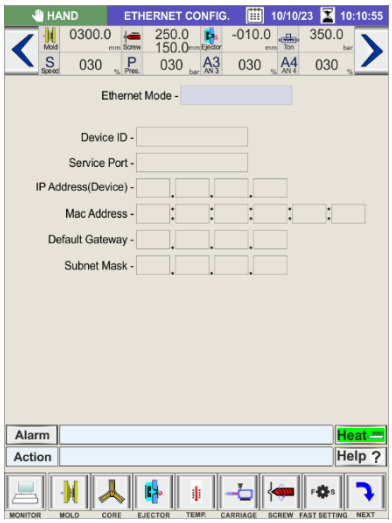


1- Go to the pump test mode page.
2- Touch Pump Test Mode key. Or Press Touch the pump test mode key or press and hold the test key for 3 seconds to activate the pump test mode. The color of the button will be green, so the mode is activated.
3- Now select the analog output channel by touching the channel name. Or move the cursor to it with arrow key and enter.
4- Now enter the analog value. For example enter 10.00 and touch and hold the "On" button, or press and hold the Select + key. So the output of that channel will appear in the analog output section of the combicard.
5- So in this way the pump output can be checked on the pressure gauge by selecting different channels.

Page Screen: GSM



Page Screen: ETHRNET CONFIG.



(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.

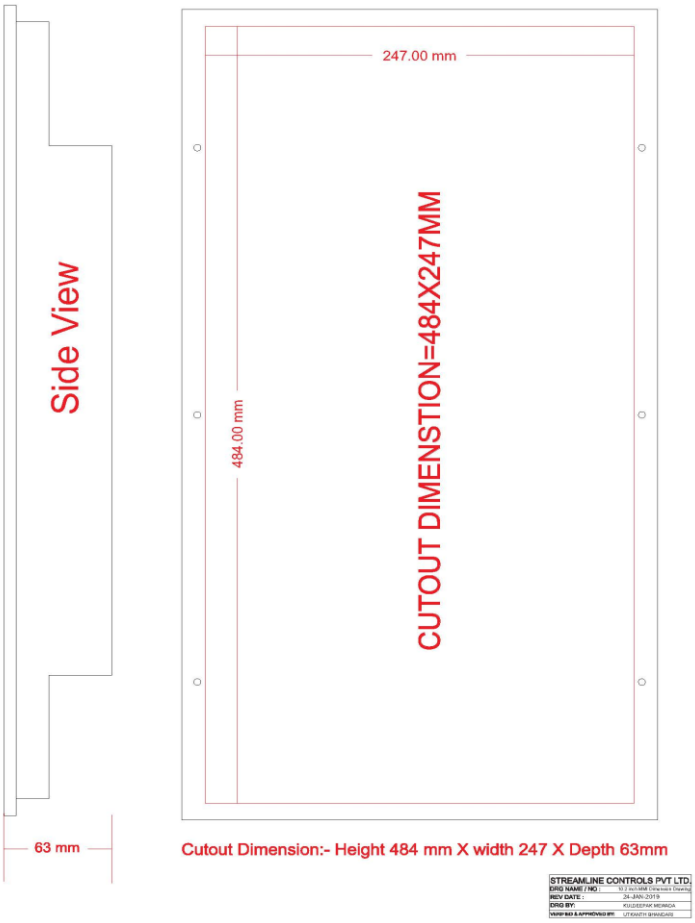
(6) DIE SET:

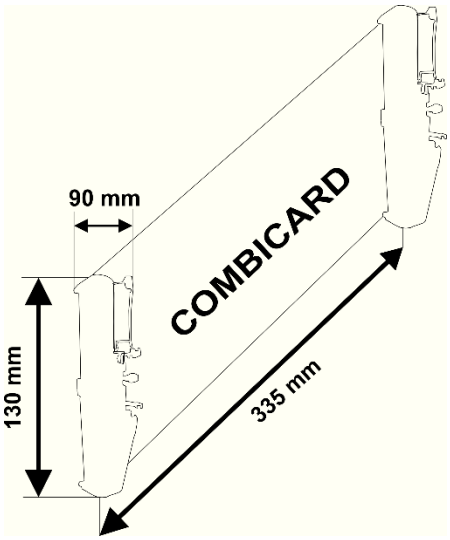
On Pressing **DIESET** Key the only work DIESET Mode.

(7) PURGE:

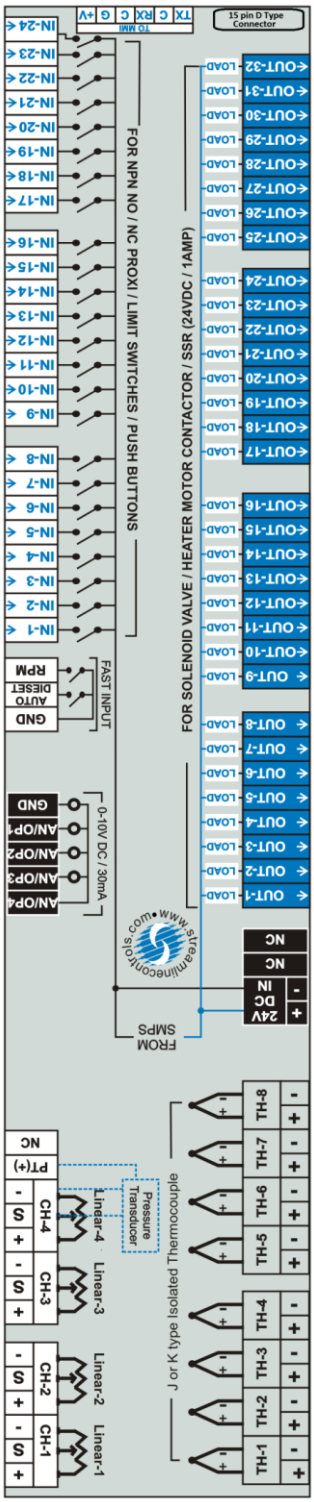
On Pressing **PURGE** Key the Work SEMI & AUTO cycle.

(9) Dimension drawing : MMI and Combicard Cut out Dimension drawing

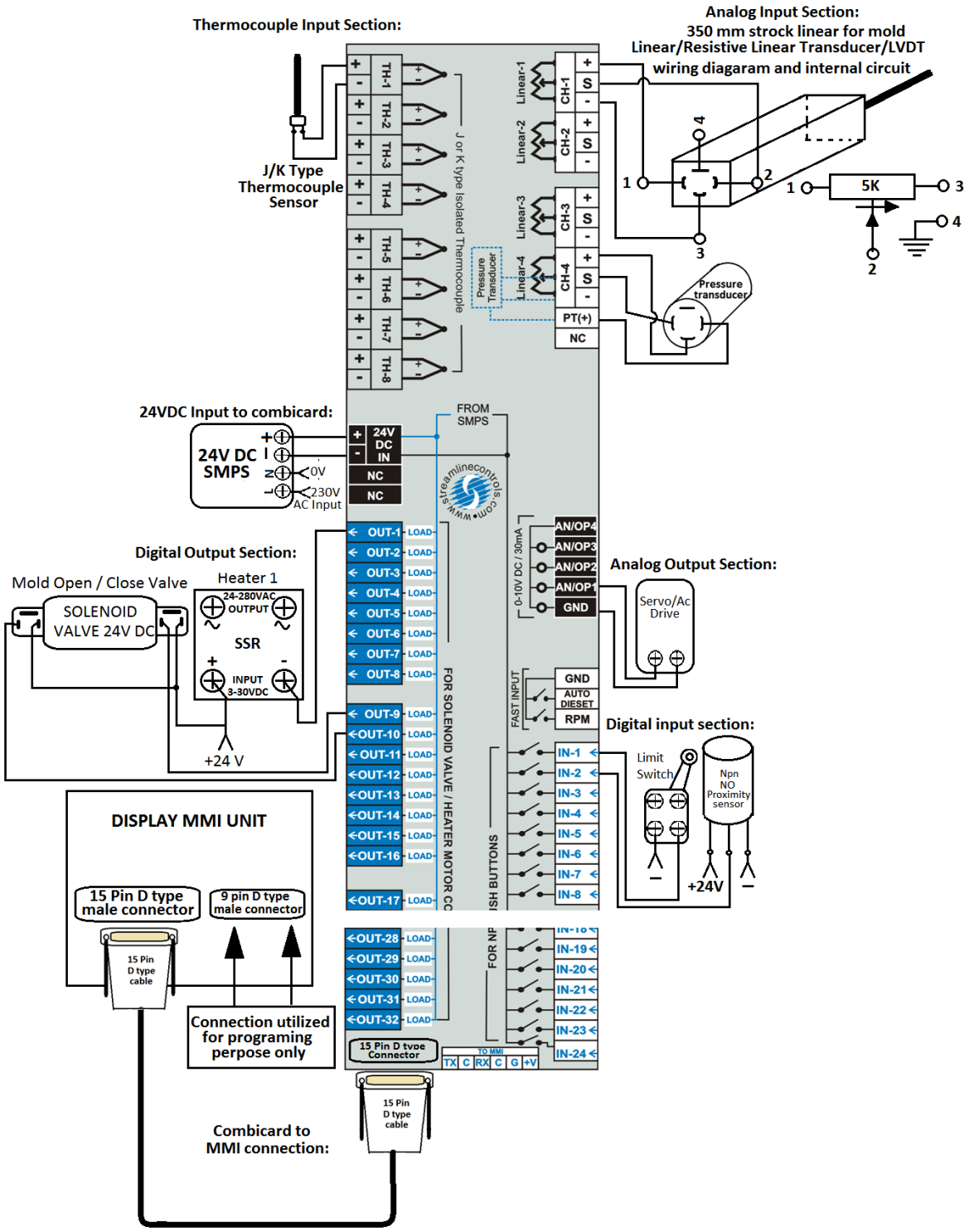




(10) Wiring diagram: Front sticker of combicard



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.)



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- AC Servo Motor Drive
- DC Stepper Drive
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- 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
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