

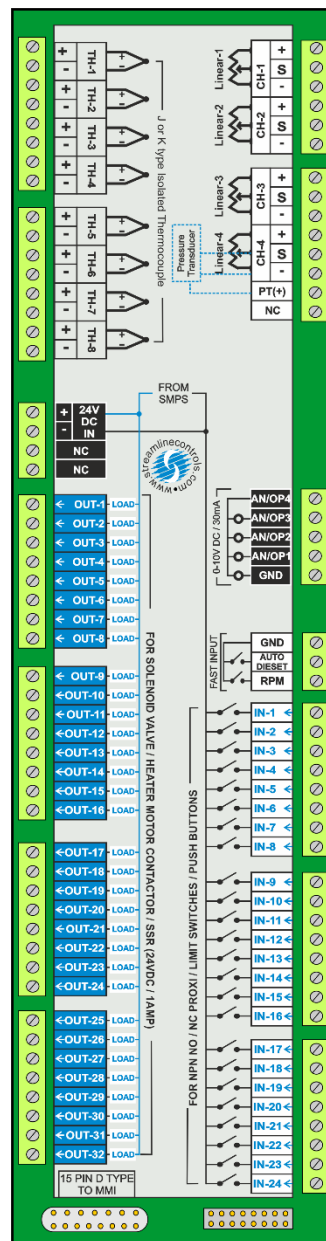
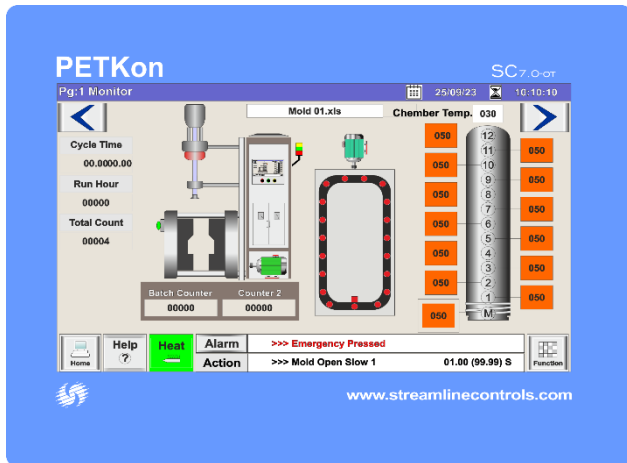


STREAMLINE CONTROLS

PETKon SC 7.0-OT

User Manual Version V1.0

By streamline controls Private Limited



STREAMLINE CONTROLS PVT.LTD.

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

PETKon 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.

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(1) Specification:

Inputs Power	Voltage	24 V DC \pm 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	0°C to 55°C
	Humidity	5 to 95% RH non-condensing

(2) Control Unit Introduction

PETKon is a complete proven & reliable control system for PET Blow Molding Machine. System consists of three units.

- (2.1) MMI unit
- (2.2) Combi card
- (2.3) SMPS
- (2.4) 15 Pin D Type Cable

(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, feather touch membrane keypad for user interface for manual/Semi auto/fully auto functions of the machine.
- ❖ Latest E²PROM Technology ensures security of programmed parameters.
User friendly programming through an extensive membrane keypad for easy operator interface (Details of Manual mode operations available is appended on separate sheet)
Five digits batch counter to count Number of Pieces & Six digit Totalizer counter.
- ❖ Six digits hour counter.
- ❖ Limit Settable of pressure, Speed, AN3 & AN 4 in Config Page.
- ❖ Adaptive temperature functions for temperature.
- ❖ Facility for counting cycle time helpful in production analysis.
- ❖ 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.
Inbuilt interlocks for Low & High temperature, 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

- 4.1 MMI (Man Machine Interface)
- 4.2 Mounting Clamp
- 4.3 CombiCard
- 4.4 Inter connecting cables.
- 4.5 SMPS.
- 4.6 IO List Print Copy
- 4.7 RC Pair (Subber)

(5) Programming of the system

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

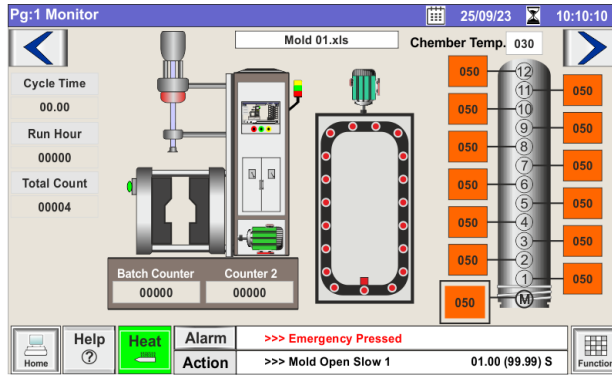
(6) Operating Panel Description

Screen Page: MONITOR

This is the monitor screen, it will come up after the startup screen. In this screen you can see the movement of the machine in graphic form, also you can see the mold memory name, the actual graphic motion of the Conveyor, motor on off indication, lubrication on off indication.

Alarm and interlock messages will appear in the alarm box line. And the action message will appear in the action box line.

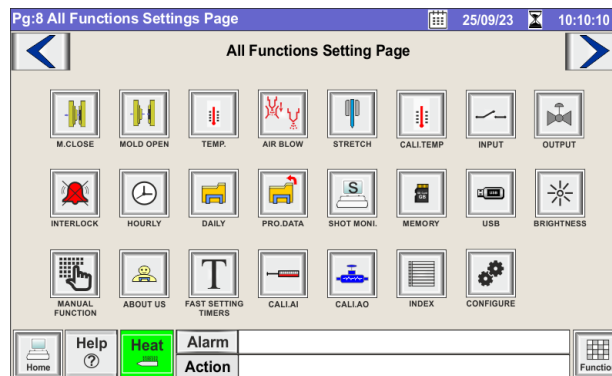
For example, the following screen shows the Emergency Press Interlock and Mold Open Slow 1 function messages.




























(6.1) Touch menu key bar

Touching the function button at the bottom right side of the screen will open this screen. Or press the up arrow key to go to this page.





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.

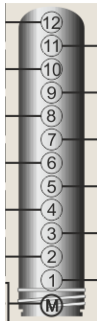
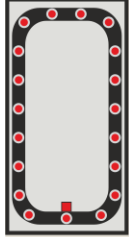



	<p>The Monitor page screen appears, containing machine overview. If you are on any page screen and press the monitor (home) key, you will directly go to the monitor screen.</p>
	<p>The Function setting page screen appears. By using this page you can go to the settings of all pages.</p>
	<p>The MOLD CLOSE page screen appears, containing the settings for mold close.</p>
	<p>The MOLD OPEN page screen appears, containing the settings for mold Open.</p>
	<p>The TEMPERATURE page screen appears, containing the settings Temperature.</p>

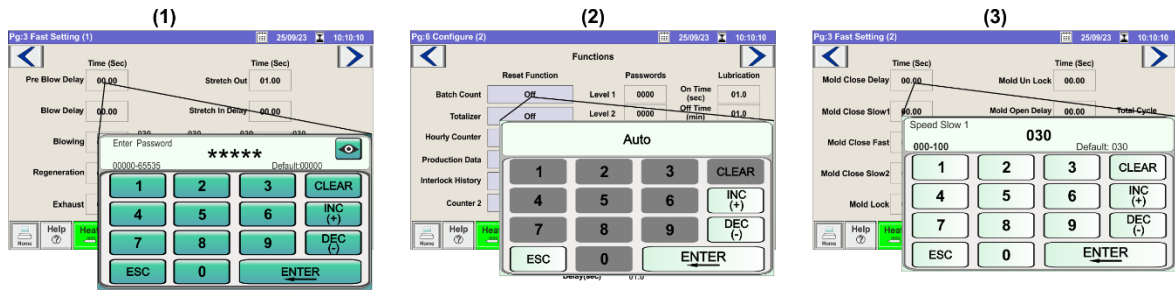
 <p>AIR BLOW</p>	<p>The AIR BLOW page screen appears, containing the settings for Air Blow.</p>
 <p>STRETCH</p>	<p>The STRETCH page screen appears, containing the settings for Stretch.</p>
 <p>CALLI.TEMP</p>	<p>The CALIBRATION TEMPERATURE page screen appears, containing the settings for Calibration of temperature.</p>
 <p>INPUT</p>	<p>The DIGITAL INPUT page screen appears, containing the Status of digital inputs.</p>
 <p>OUTPUT</p>	<p>The DIGITAL OUTPUT page screen appears, containing the Status of digital outputs. This page can be used to troubleshoot the output by force turning it on or off.</p>
 <p>INTERLOCK</p>	<p>The INTERLOCK page screen appears, containing the of Interlocks record.</p>
 <p>HOURLY</p>	<p>The HOURLY page screen appears, containing the hourly data record.</p>
 <p>DAILY</p>	<p>The DAILY page screen appears, containing the daily data record.</p>
 <p>PRO.DATA</p>	<p>The PROGRAM DATA page screen appears, containing the changed parameter list old and new.</p>
 <p>SHOT MON</p>	<p>The SHOTMONITOR page screen appears, containing the one cycle time or different function position shots and time.</p>
 <p>MEMORY</p>	<p>The MEMORY page screen appears, This page is used to set the mold memory.</p>
 <p>USB</p>	<p>The USB page screen appears, Program sequences, graphics can be inserted using this page.</p>
 <p>BRIGHTNESS</p>	<p>The BRIGHTNESS page screen appears, Screen BRIGHTNESS can be increased or decreased by using this page.</p>
 <p>MANUAL FUNCTION</p>	<p>Using this page, the MANUAL function can be performed by touch as well as by using the keypad.</p>
 <p>ABOUT US</p>	<p>VERSION code, sequence code, graphics code can be seen by using this page.</p>
 <p>FAST SETTING TIMERS</p>	<p>The FAST SETTING TIMERS page screen appears, containing the settings for all timers.</p>
 <p>CALI.AI</p>	<p>The CALIBRATION ANALOG INPUT page screen appears, containing the settings for Analog inputs.</p>
 <p>CALIAO</p>	<p>The CALIBRATION ANALOG OUTPUT page screen appears, containing the settings for Analog outputs.</p>
 <p>INDEX</p>	<p>The INDEX page screen appears, containing all pages in index screen.</p>
 <p>CONFIGURE</p>	<p>The CONFIGURE page screen appears, containing the settings for Configure.</p>

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

	<p>Press the "PREV" Key at the top of the touch screen. The previews page screen appears.</p>
	<p>Press the "NEXT" Key at the top of the touch screen. The next page screen appears.</p>
	<p>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</p>
	<p>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.</p>

	<p>Press the hitting barrel graphics to open the temperature page screen.</p>
	<p>Press the Conveyor graphics to Fast setting timers settings.</p>
	<p>Press the Counter area graphics to open The Counter reset page screen.</p>

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



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 Delay), the keypad will open as per image (3), now set the parameter with numeric key and press enter, So that parameter will be saved there.
4. Here "clear" key is used to parameter value zero in key pad display. And "ESC" key is used to close the keypad.
5. Use "INC (+)" and "DEC (-)" key if you want to change the parameter shown in image (2) (Batch Counter Reset).

(6.4) Touch Key board description

	<p>[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 (9) page {mold Open Speed (%)}, it will show 50, And this parameter you cannot save value above 50.</p>
	<p>[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".</p>

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

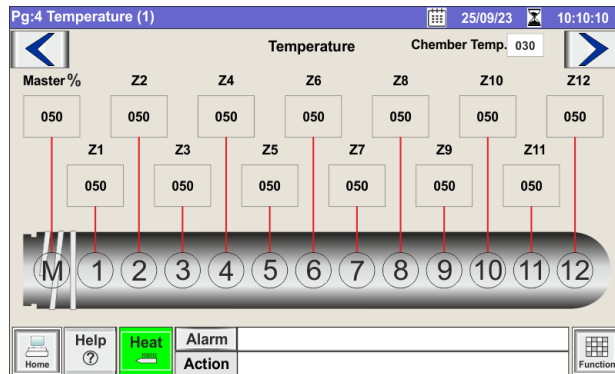
- ❖ Equipment must be operating under correct power. (Install a voltage stabilizer or CVT while need)
- ❖ Earth terminal must be connected to qualified terminal.
- ❖ All electrical elements with EARTH terminal, it is necessary for users to connect with the EARTH terminal.
- ❖ The high power cables should 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: Pg.4 Temperature (1)




- (1) Press "TEMP" key once.
- (2) Now Screen Page: **Pg.4 Temperature (1)** 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.




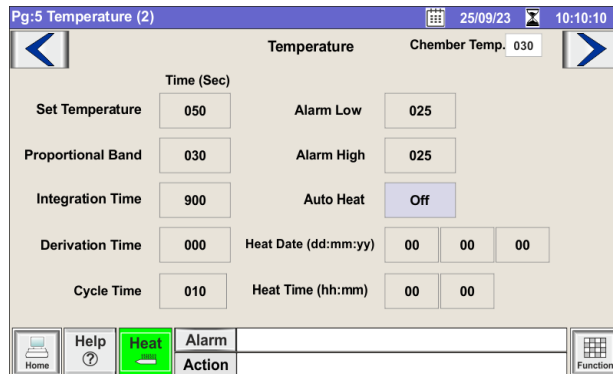
Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Master Temperature (%)	This set value is the master value of zone 1 to 12. If master is set to 50% and zone 1 temperature set value is 50%, the output of zone 1 will be on at 25%.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1
Temperature zone 1 (%)	This is the set temperature value of zone 1 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1
Temperature zone 2 (%)	This is the set temperature value of zone 2 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1
Temperature zone 3 (%)	This is the set temperature value of zone 3 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1
Temperature zone 4 (%)	This is the set temperature value of zone 4 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1
Temperature zone 5 (%)	This is the set temperature value of zone 5 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1
Temperature zone 6 (%)	This is the set temperature value of zone 6 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1
Temperature zone 7 (%)	This is the set temperature value of zone 7 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1

Temperature zone 8 (%)	This is the set temperature value of zone 8 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1
Temperature zone 9 (%)	This is the set temperature value of zone 9 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1
Temperature zone 10 (%)	This is the set temperature value of zone 10 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1
Temperature zone 11 (%)	This is the set temperature value of zone 11 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1
Temperature zone 12 (%)	This is the set temperature value of zone 12 in percentage.	The heater output will remain on as per the set value.	Set temperature in percentage	000-100 %	Level 1

(8.2) Screen Page: Pg.5 Temperature (2)



- (1) Press "  " key once.
- (2) Now Screen Page: **Pg.5 Temperature (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.




Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Chamber temperature	Actual value of chamber temperature.	Only one thermocouple is used to view the chamber temperature.	Degree centigrade	000-500	No password
Set temperature	Set value of Chamber temperature	At the set value the temperature will operate as auto PID.	Set value	000-100 %	Level 1
Prop. Band	Proportional band	Will work only in PID mode	Set value	000-100 %	Level 1

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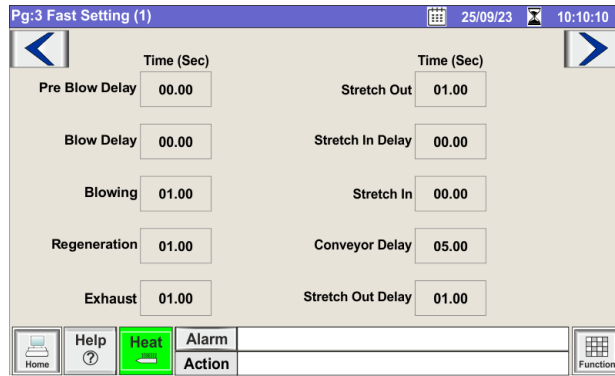
Integral time	Integral time	Will work only in PID mode	Set value	000-100 %	Level 1
Derivative time	Derivative time	Will work only in PID mode	Set value		Level 1
Cycle time	Cycle time	Will work only in PID mode	Set value		Level 1
Alarm low	Alarm low	If 200 is set temperature and 25 alarm low is set then when chamber temperature goes below 175 then alarm low will occur.	Set value		Level 1
Alarm High	Alarm High	If 200 is set temperature and 25 alarm low is set then when chamber temperature goes above 225 then alarm low will occur.	Set value		Level 1
Auto Heat	Not Used				
Heat Date	Not Used				
Heat Time	Not Used				

(8.3) Screen Page: Pg.3 Fast Setting (1)



- (1) Press "FAST SETTING TIMERS" key once.
- (2) Now Screen Page: **Pg.3 Fast Setting (1)** 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.

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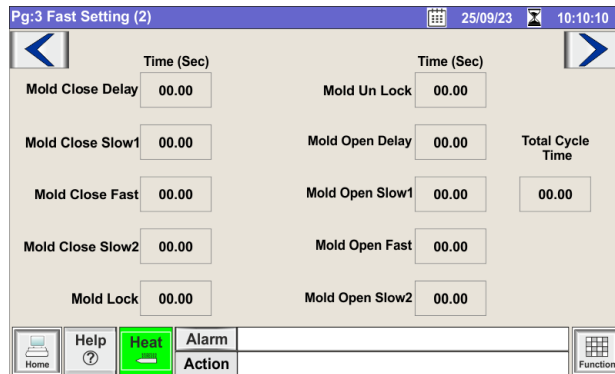


Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Pre Blow Delay	Pre Blow Delay Timer	The pre blow output will turn on after the set time in auto cycle.	Timer	00.00-99.99	Level 1
Blow Delay	Blow Delay Timer	The blow output will turn on after the set time in auto cycle.	Timer	00.00-99.99	Level 1
Blowing	Blowing Timer	Blowing output will turn on as per set. Blowing will be ON after a blowing delay in auto cycle	Timer	00.00-99.99	Level 1
Regeneration	Regeneration Timer	Regeneration output will turn on as per set.	Timer	00.00-99.99	Level 1
Exhaust	Exhaust Timer	Regeneration output will turn on as per set. In auto cycle regeneration will be on before exhaust.	Timer	00.00-99.99	Level 1
Stretch Out	Stretch Out Timer (To run this function on a timer check that its option timer is set in the configure page.)	Stretch Out output will turn on as per set.	Timer	00.00-99.99	Level 1
Stretch In Delay	Stretch In Delay Timer	Stretch In output will turn on after the set time in auto cycle.	Timer	00.00-99.99	Level 1
Stretch In	Stretch In Timer	Stretch In output will turn on as per set.	Timer	00.00-99.99	Level 1
Conveyer Delay	Conveyer Delay timer	Conveyor output will be ON after the conveyer delay timer over.	Timer	00.00-99.99	Level 1
Stretch Out Delay	Stretch Out Delay	The Stretch Out output will turn on after the set time in auto cycle. If the stretch out time is longer than the mold open time then the stretch out output will stop before the mold open.	Timer	00.00-99.99	Level 1

(8.4) Screen Page: Pg.3 Fast Setting (2)



- (1) Press " " key once.
- (2) Now Screen Page: **Pg.4 Fast Setting (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.




Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Mold Close Delay	Mold Close Delay timer	The Mold Close output will turn on after the set time in auto cycle.	Timer	00.00-99.99	Level 1
Mold Close Slow 1	Mold Close Slow 1 timer (To run this function on a timer check that its option timer is set in the configure page.)	Mold Close Slow 1 output will turn on as per set time.	Timer	00.00-99.99	Level 1
Mold Close Fast	Mold Close Fast timer (To run this function on a timer check that its option timer is set in the configure page.)	Mold Close Fast output will turn on as per set time.	Timer	00.00-99.99	Level 1
Mold Close Slow 2	Mold Close Slow 2 timer	Mold Close Slow2 output will turn on as per set time.	Timer	00.00-99.99	Level 1
Mold Lock	Mold Lock timer (To run this function on a timer check that its option timer is set in the configure page.)	Mold Close Lock output will turn on as per set time.	Timer	00.00-99.99	Level 1
Mold Un Lock	Mold Un Lock timer (To run this function on a timer check that its option timer is set in the configure page.)	Mold Close Un Lock output will turn on as per set time.	Timer	00.00-99.99	Level 1

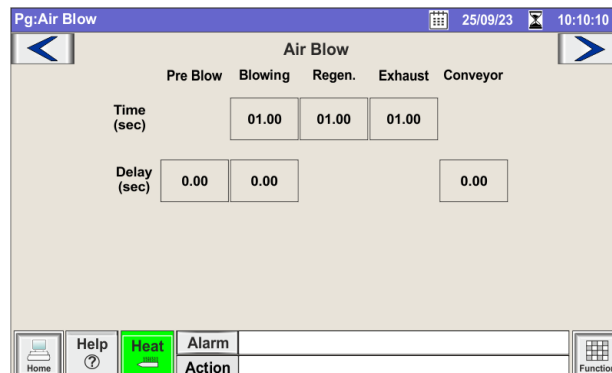
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Mold Open Delay	Mold Open Delay (To run this function on a timer check that its option timer is set in the configure page.)timer	The Mold Open output will turn on after the set time in auto cycle.	Timer	00.00-99.99	Level 1
Mold Open Slow 1	Mold Open Slow1 Timer (To run this function on a timer check that its option timer is set in the configure page.)	Mold Open Slow1 output will turn on as per set time.	Timer	00.00-99.99	Level 1
Mold Open Fast	Mold Open Fast timer (To run this function on a timer check that its option timer is set in the configure page.)	Mold Open Fast output will turn on as per set time.	Timer	00.00-99.99	Level 1
Mold Open Slow2	Mold Open Slow2 timer (To run this function on a timer check that its option timer is set in the configure page.)	Mold Open Slow2 output will turn on as per set time.	Timer	00.00-99.99	Level 1
Total Cycle Time	Total cycle timer	If the machine cycle exceeds the set time, the interlock message "IL Total cycle timer over" will appear and the machine will switch from auto to manual mode automatically.	Timer	00.00-99.99	Level 1

(8.5) Screen Page: Pg: Air Blow




- (1) Press "AIR BLOW" key once.
- (2) Now Screen Page: **Pg: Air Blow** 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.

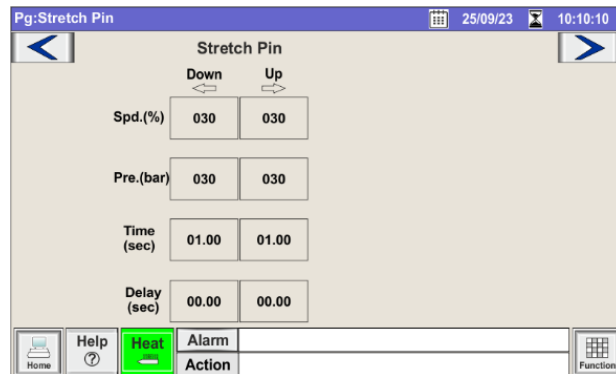


The parameter description of this page is as per the previous page.

(8.6) Screen Page: Pg: Stretch Pin




- (1) Press "  " key once.
- (2) Now Screen Page: **Pg: Stretch Pin** 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.

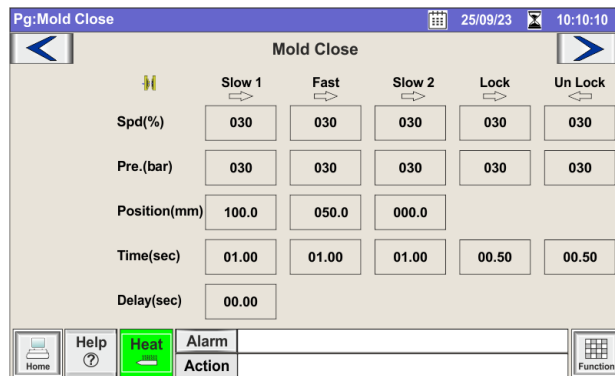


The parameter description of this page is as per the previous page.
It will function according to the setting of speed and pressure

(8.7) Screen Page: Pg: Mold Close



- (1) Press "M.CLOSE" key once.
- (2) Now Screen Page: **Pg: Mold Close** is displayed on screen in first line.
- (3) T 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.



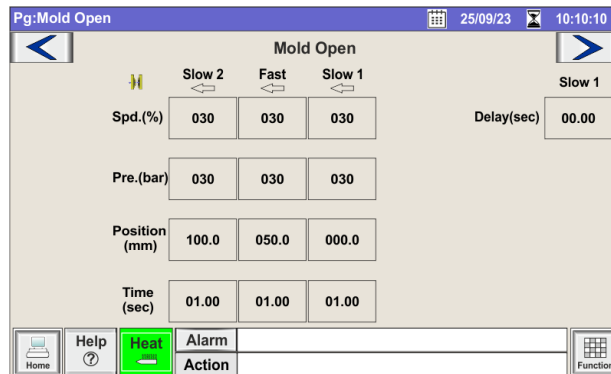
In this page all parameter settings of mold close can be made. The mold Close function can be divided in to 3 steps for every single step speed, pressure, position can be specified. Different settings for all steps mentioned further below. When the function is running, it will be highlighted in green color arrow under the name of the function. As shown in the above image under the name of mold closes slow 1.

Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Close Slow 1	With select Position in type From mold Fast Open position to this position mold moves Slow in open direction.	Set Close Slow 1 function over operating position.	Position	0000.0 – 999.9mm	Level 1
		Set Close Slow 1 function operating pressure proportional output	Pressure	000– 255Bar	Level 1
		Set Close Slow 1 function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Close Slow 1 function operating Time	Time	00.0 – 99.9Sec	Level 1
Close Fast	With select Position in type From mold Slow Open1 position to this position mold moves Fast in open direction.	Set Close Fast function over operating position.	Position	0000.0 – 999.9mm	Level 1
		Set Close Fast function operating pressure proportional output	Pressure	000– 255Bar	Level 1

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		Set Close Fast function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Close Fast function operating Time	Time	00.0 – 99.9Sec	Level 1
Close Slow 2	With select Position in type From mold fully close position to this position mold moves slow in open direction.	Set Close Slow 2 function over operating position.	Position	000.0 – 999.9mm	Level 1
		Set Close Slow 2 function operating pressure proportional output	Pressure	000– 255Bar	Level 1
		Set Close Slow 2 function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Close Slow 2 function operating Time	Time	00.0 – 99.9Sec	Level 1
		Set Close Slow 2 function operating delay	Delay	00.0- 99.9Sec	Level 1

(8.8) Screen Page: Pg. Mold Open




In this page all parameter settings of Left/Right mold close can be made. The Left/Right mold Close function can be divided in to 3 steps for every single step speed, pressure, position can be specified. Different settings for all steps mentioned further below.

Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Slow Open2	With select Position in type From mold Fast Open position to this	Set Slow Open 2 function over operating position.	Position	0000.0 – 999.9mm	Level 1

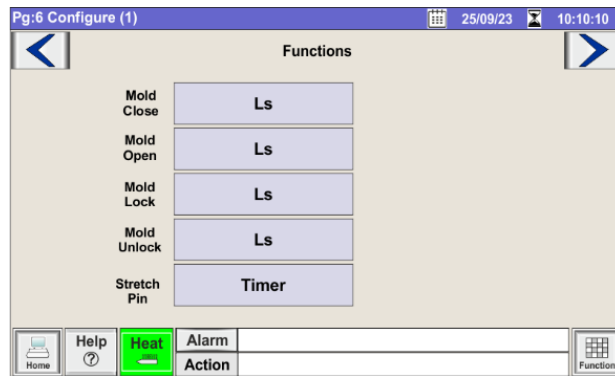
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	position mold moves Slow in open direction.	Set Slow Open 2 function operating pressure proportional output	Pressure	000–255Bar	Level 1
		Set Slow Open 2 function operating Speed proportional output	Speed	000% – 255%	Level 1
		Set Slow Open 2 function operating Time	Time	00.0 – 99.9Sec	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 – 999.9mm	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
		Set Fast Open 1 function operating Time	Time	00.0 – 99.9Sec	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
Total Tim	If mold open time is exceed from total time then system come in hand mode & display >>>IL_LT Mold Open Timer Over , >>>IL_RT Mold Open Timer Over.	Set Total time for mold open function.	Timer	00.0 – 99.9Sec	Level 2

(8.9) Screen Page: Pg. Configure (1)




- (1) Press "CONFIGURE" key once on the top of the Touch Screen.
- (2) Now Screen Page: **Configure (1)** 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.

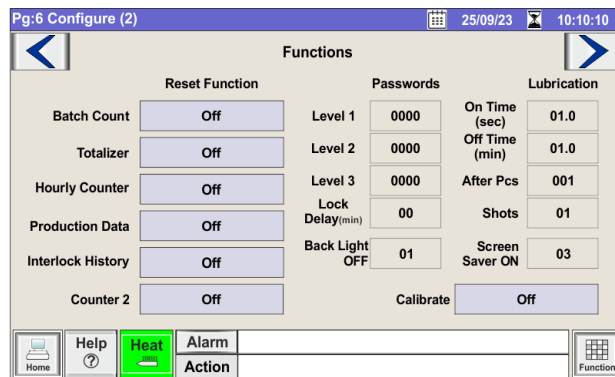


Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Mold Close Side	Select mold close operating type. In case use of Analog input (Linear Transducer or Encoder) select POSI (position) mode operating type. In case use of Digital Input (Limit Switches or Proximity Switches) select LS mode operating type.	Select mold Close side operating type	Function	Position/ Ls /Timer	Level 2
Mold Open Side	Select 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 open side operating type	Function	Position/ Ls /Timer	Level 2
Mold Lock Side	Select Mold Lock operating type. In case use of Digital Input (Limit Switches or Proximity Switches) select LS mode operating type.	Select Mold Lock function operating type.	Function	Ls/Timer	Level 2
Mold Unlock Side	Select Mold Lock operating type. In case use of Digital Input (Limit Switches or Proximity Switches) select LS mode operating type.	Select Mold Un Lock function operating type.	Function	Ls/Timer	Level 2
Stretch Pin	Select Stretch Pin operating type. In case use of Digital Input (Limit Switches or Proximity Switches) select LS mode operating type.	Select Stretch Pin function operating type.	Function	Ls/Timer	Level 2

(8.10) Screen Page: Pg. 6 Configure (2)



- (1) Press “” Touch Key once in Touch screen.
- (2) Now, **Screen Page: Pg: 6 Configure (2)** 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.




Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
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 interlock History	Function	On/Off	Level 3
Counter 2	If set to on, counter 2 is reset to zero.	Make on to reset Counter 2.	Function	On/Off	Level 3
Level 1	Set password level 1 to protect software decided configures parameters at level 1.	Set password level 1	Number	00000-65535	Level 3
Level 2	Set password level 2 to protect software decided configures parameters at level 2.	Set password level 2	Number	00000-65535	Level 3

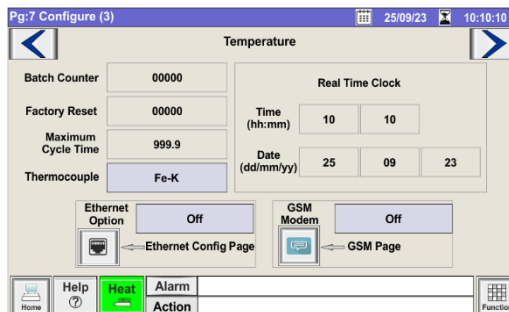
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Level 3	Set password level 3 to protect software decided configures parameters at all level.	Set password level 3	Number	00000-65535	Level 3
Lock Delay (min)	Set password lock delay. If there is no any data entry within this set time open any password level is lock automatically.	Set password lock delay	Timer	00-99	Level 3
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
LCD Delay Back light Off Screen Saver On	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)	Set time	Timer	00-30 mint	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

(8.11) Screen Page: Pg.7 Configure (3)



- (1) Press " " key once on the top of the Touch Screen.
- (2) Now Screen Page: **Pg.7 Configure (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.



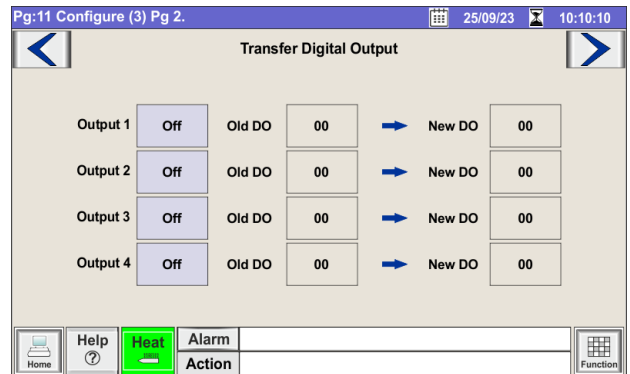
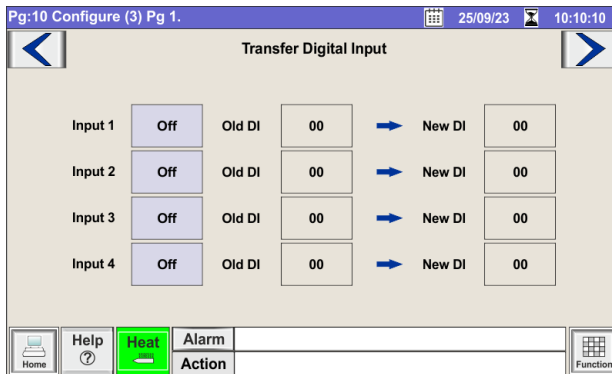
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Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
Batch Counter	Batch Counter preset value. The batch counter resets on reaching this Count. On over Speed batch counter system comes into HAND mode. On setting value 00000 disables the counter.	Set batch count	Number	00000-99999	Level 1
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 1
Maximum 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
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
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

(8.12) Screen Page: Pg.10 Configure (3) Pg. 1.



- (1) Press " " key once on the top of the Touch Screen.
- (2) Now Screen Page: **Pg.22 Configure (3) Pg. 1** 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.

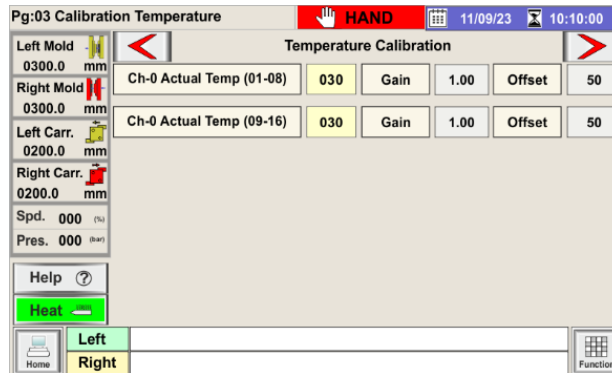


Parameter Name	Function Description	Parameter Description	Parameter Description		Operating Password Level
			Parameter Type	Range	
In1:Trans	If set to on, IN1 is active. Now old digital input (faulty) is transfer to new digital input (spare) place.	Make on to transfer digital input	Function	On/Off	Level 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

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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

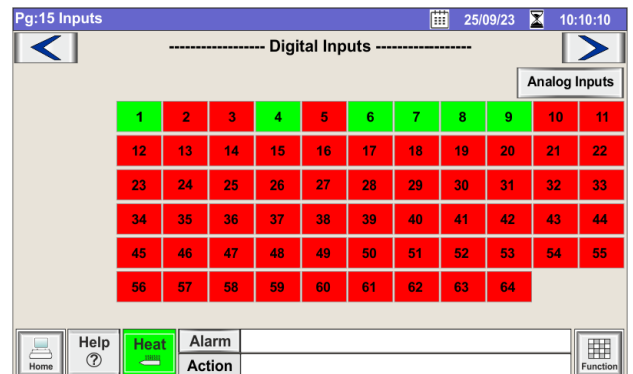
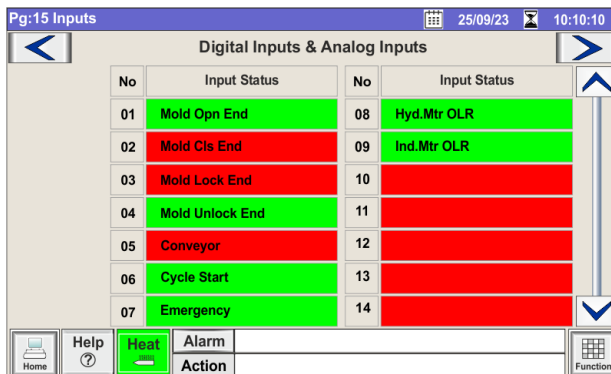
(8.13) Screen Page: Pg.03 Calibration Temperature



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.

(8.14) Screen Page: Pg. 15 Inputs

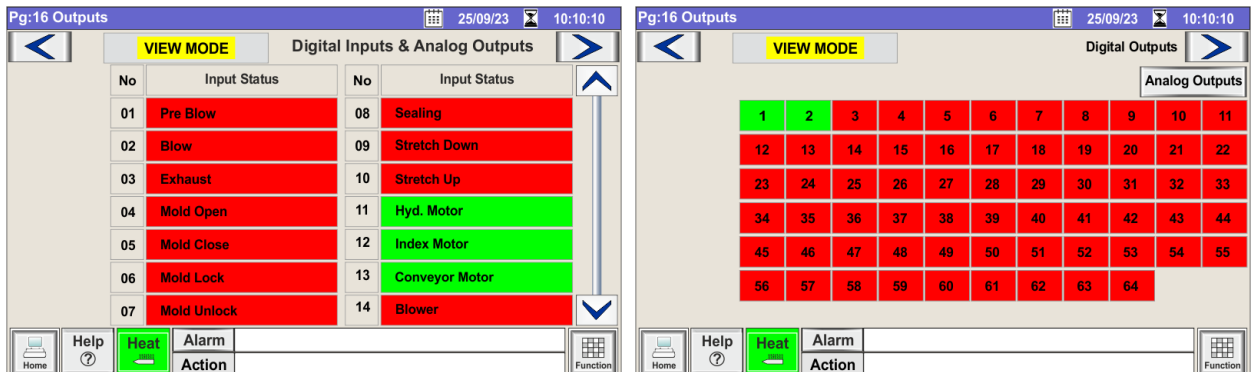


The following is how to show the digital inputs.

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.

(8.15) Screen Page: Pg.16 Output Status screen

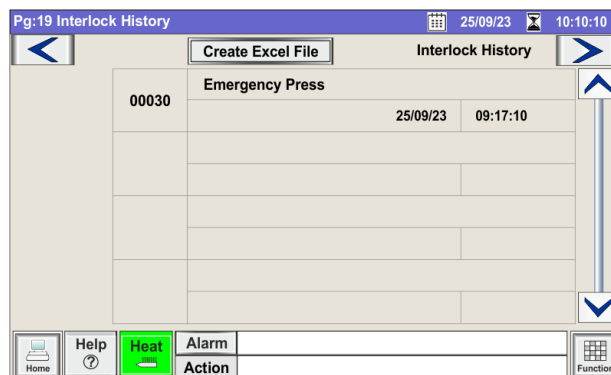
This is the Output Status screen, in which you can see which output is on or off, and also output on or off one by one in test mode.



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

- 1 Go to the Output Status by pressing “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.

(8.16) Screen Page: Pg.19 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


Pg:21 Shot Monitor 25/09/23 10:10:10

Create Excel File Shot Monitor 2

Time(Sec)						
No	Mold Close	Mold Open	Mold Lock	Mold Unlock	Stretch Out	Cy Time
0006	01.04	01.14	00.54	00.84	00.99	06.99
0005	01.04	01.14	00.54	00.84	00.99	06.99
0004	01.04	01.14	00.54	00.84	00.99	06.99
0003	01.04	01.14	00.54	00.84	00.99	06.99
0002	01.04	01.14	00.54	00.84	00.99	06.99
0001	01.04	01.14	00.54	00.84	00.99	06.99

Home Help Heat Alarm Action Function

(8.20) Screen Page: Pg.12 Memory

 Press "MEMORY" key once on the bottom of the Touch Screen. Now Screen Page: **Pg.12 Memory** is displayed on screen in first line. This is a mold memory setting screen page.

Pg:12 Memory 25/09/23 10:10:10

Memory

Save File New File

SD Status Connected Current File Mold 1.xls

Index	Sequence File Name
001	New File (0).xls
002	Mold 1.xls
003	

Home Help Heat Alarm Action Function

(1)

(2)


(3)

(4)

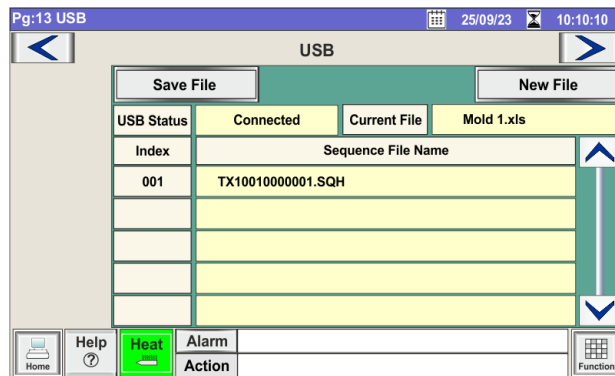
(5)

1	Go to mold memory setting page by pressing “MEMORY” on Function setting page.
2	If you are in another Menu Bar , otherwise pressing “next “ or “Previews” key, And go to the “Pg: Memory”
3	So screen appears Pg.:23 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 create new file? (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.
9	Save any mold memory before changing it through “Save File” key.


(8.21) Screen Page: Pg.13 USB



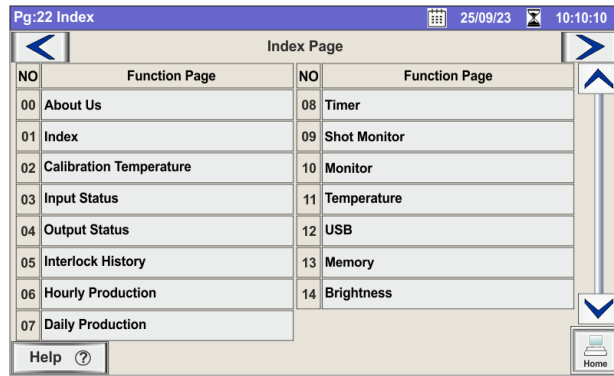
Press” **USB** ” key once on the bottom of the Touch Screen.
 Now Screen Page: **USB** is displayed on screen in first line.
 You can load programming sequences, Images, Recipe file, Page Buttons from USB



(8.22) Screen Page: Pg.22 Index



Press” **INDEX** ” 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.



(8.23) Screen Page: About Us

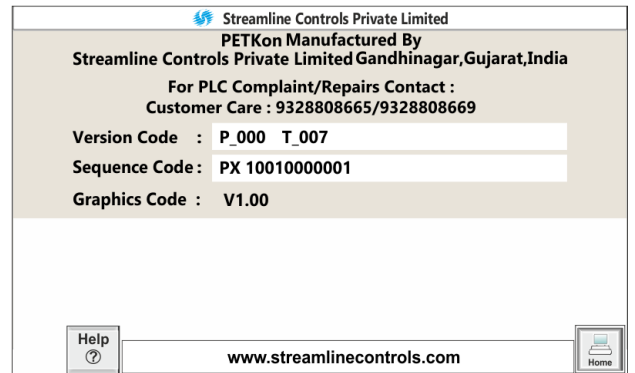
This is the Startup screen, when you first turn on the power of plc this screen first appears, as per image (1). You can also see this screen by pressing “about us” touch key. In this screen you can see OEM information, the streamline company logo will appear in the default setting.

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)

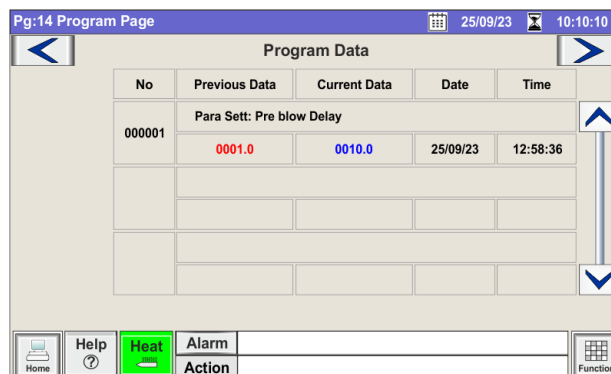


(2)



(8.24) Screen Page: Pg.14 Program Data

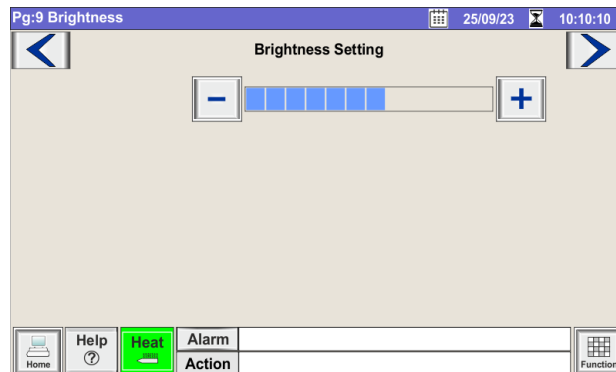
This is the Program data changes list screen, In this page you can see the list of parameter changes. For example, let's take a parameter like 000 in the Temperature zone 1, now we save 001, so the first parameter is 0000 and the current parameter is 0001 So it will be shown in this list.



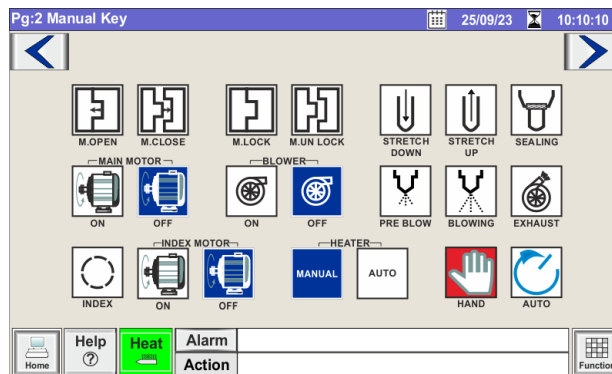
(8.25) Screen Page: Pg.9 Brightness

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



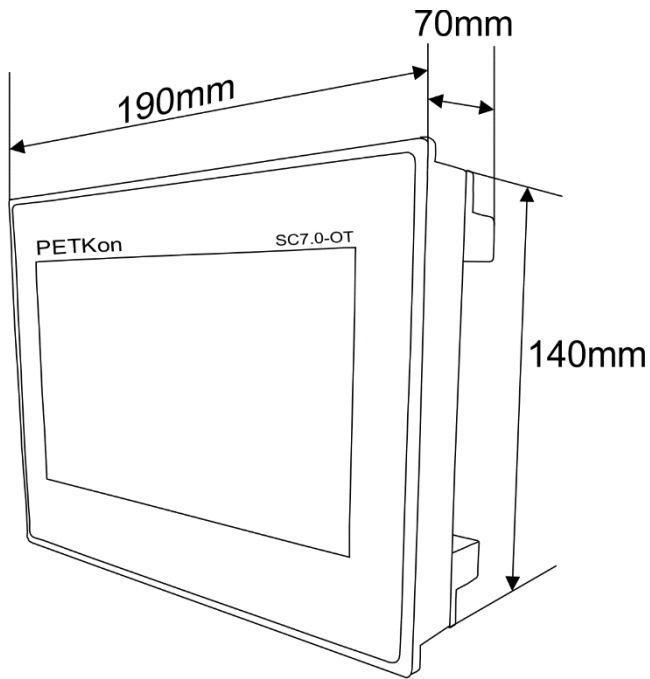
(8.26) Screen Page: Pg.2 Manual Function Page



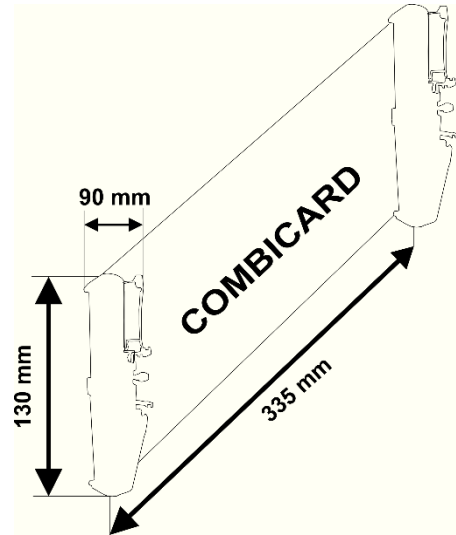
Just like the manual function key, the touch key is used to perform the manual function.

(9) Dimension Drawing

MMI Cutout Dimension

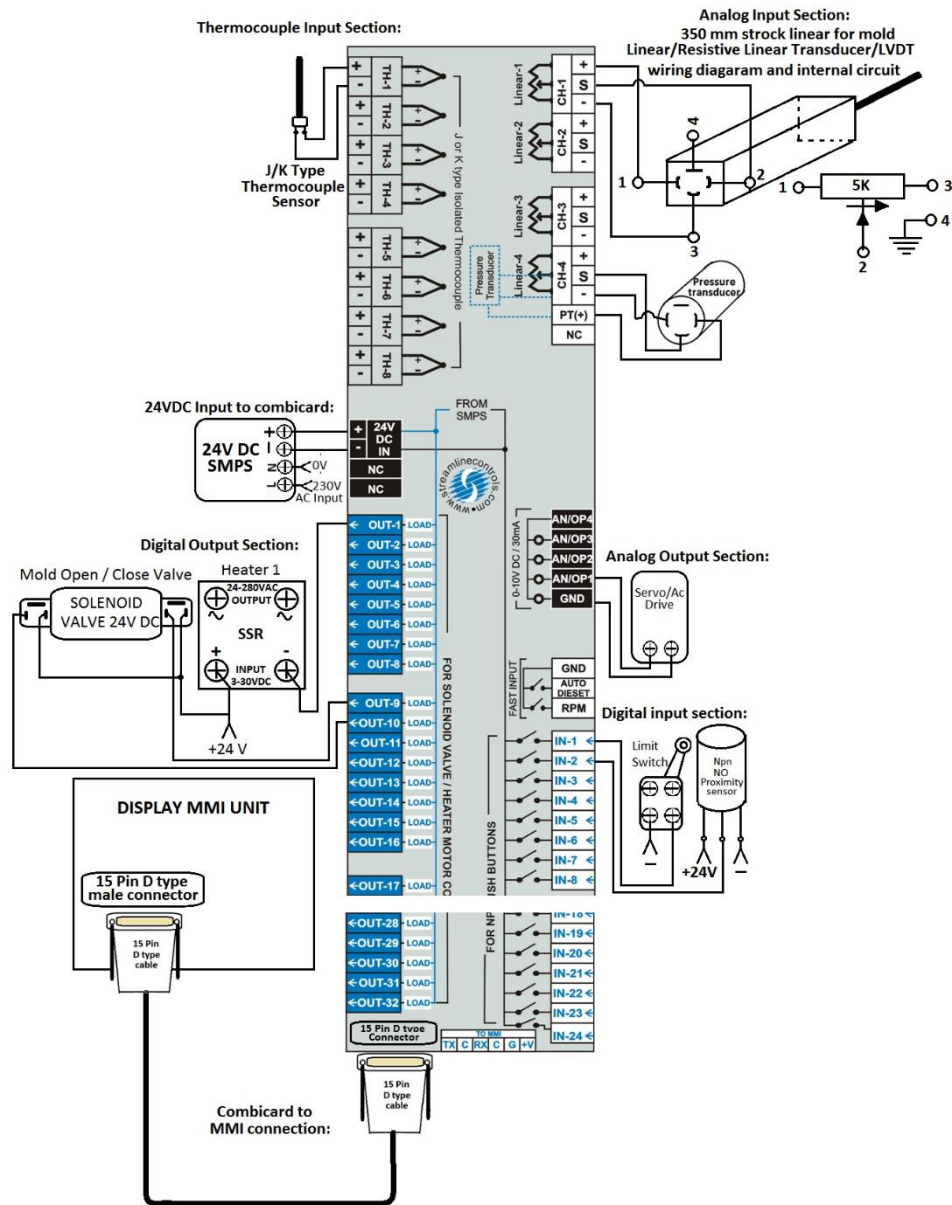


Combicard Dimension



(10) Wiring Diagram

Wiring Diagram: 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.)



(11) Input Output List:

INPUT & OUTPUT LIST					
Sequence Code :PX10010000001					
Product Code : PETkon Rainbow					
OUTPUT LIST			INPUT LIST		
Sr No	Solenoid No	Name	Sr No	Input No	Name
S1	S1	Pre Blow	I1	LS1	Mold Open End
S2	S2	Blowing	I2	LS2	Mold Close End
S3	S3	Exhaust	I3	LS3	Mold Lock End
S4	S4	Mold Open	I4	LS4	Mold Unlock End
S5	S5	Mold Close	I5	LS5	Conveyor
S6	S6	Mold Lock	I6	LS6	Cycle Start
S7	S7	Mold Unlock	I7	LS7	Emergency
S8	S8	Sealing	I8	LS8	Hydraulic Motor OLR
S9	S9	Stretch Down	I9	LS9	Index Motor OLR
S10	S10	Stretch Up	I10	LS10	Not Used
S11	S11	Hydraulic Motor	I11	LS11	Not Used
S12	S12	Index Motor	I12	LS12	Not Used
S13	S13	Conveyor	I13	LS13	Not Used
S14	S14	Blower	I14	LS14	Not Used
S15	S15	Regeneration	I15	LS15	Not Used
S16	S16	Interlock	I16	LS16	Not Used
S17	S17	H1 R	I17	LS17	Not Used
S18	S18	H2 Y	I18	LS18	Not Used
S19	S19	H3 B	I19	LS19	Not Used
S20	S20	H4 R	I20	LS20	Not Used
S21	S21	H5 Y	I21	LS21	Not Used
S22	S22	H6 B	I22	LS22	B Phase Zero Cross
S23	S23	H7 R	I23	LS23	Y Phase Zero Cross
S24	S24	H8 Y	I24	LS24	R Phase Zero Cross
S25	S25	H9 B			
S26	S26	H10 R			
S27	S27	H11 Y			
S28	S28	H12 B			
S29	S29	Not Used			
S30	S30	Not Used			
S31	S31	Not Used			
S32	S32	Not Used			

Notes:
You can use either pwm output or digital output. (You cannot use both outputs at the same time.)

Analogue Output List		
Sr No	Analogue Output No	Analogue Output Name
1	AN1	Not Used
2	AN2	Not Used
3	AN3	Not Used
4	AN4	Not Used

Analogue Input List		
Sr No	Analogue Input No	Analogue Input Name
1	AIN1	Not Used
2	AIN2	Not Used
3	AIN3	Not Used
3	AIN4	Not Used

OUR PRODUCT RANGE

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

AUTOMATION... PRODUCTIVITY THROUGH TECHNOLOGY