

# INJECTION MOLDING DATA SHEET

DATE 2011/10/23 12:22

-----< INJECTION / PACK SETTING >-----

INJ.STEP	4 STEP		INJ >PACK	POS TRANS		MAX INJ.PRES	1700 BAR
	(MM/S)	(MM)		2.70 MM		MAX INJ.TIME	0.20 SEC
1	170.0	14.00				MAX PACK VEL	180.0 MM/S
2	180.0	3.00	PACK STEP	2 STEP		DWELL BEFORE INJ	0.0 SEC
3	60.0	2.80		(BAR)	(SEC)		
4	30.0	-----	1	140	0.10	ACCEL RAMP B	40 MSEC
5	-----	-----	2	100	0.10	HR MODE	ON
6	-----	-----	3	-----	-----		
7	-----	-----	4	-----	-----		
8	-----	-----	5	-----	-----		
9	-----	-----	6	-----	-----		
10	-----		BEF. EXT	0	0.0		

-----< EXTRUDER / SPRUE BREAK SETTING >-----

EXTR ON	EXT STEP	4 STEP	SHOT SIZE	17.15 MM	SPRUE BREAK	BEFORE EXT.	
	(BAR)	(RPM)	(MM)	DECOMP DIST	1.50 MM	SPRUE BREAK DELAY	1.0 SEC
1	60	300	13.00	DECOMP VEL	5.0 MM/S	RETRACT DISTANCE	13 MM
2	50	300	14.00	COOL TIME	2.52 SEC	FWD BEFORE CLAMP OPEN	ON
3	40	300	14.50				
4	30	300	-----				
5	----	---	-----				
6	----	---	-----				

-----< TEMPERATURE SETTING >-----

BARREL CONTROL	ON	MODE	MANNED OPERATION									
(βC)	MOLD1	MOLD2	MOLD3	MOLD4	NZL 1	NZL 2	BRL 1	BRL 2	BRL 3	BRL 4	BRL 5	F-THR
HIGH (+)	-----	-----	-----	-----	20.0	-----	20.0	20.0	20.0	20.0	20.0	20.0
SETTING	-----	-----	-----	-----	320.0	-----	350.0	350.0	330.0	320.0	295.0	80.0



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-----< PROCESS MONITOR >-----

	INJ-TIME	RCV-TIME	V-P POS	M-CUSHION	EXT-START	PEAK-PRS	CYCL ALM
	OFF (SEC)	OFF (SEC)	OFF (MM)	OFF (MM)	OFF (MM)	OFF (BAR)	60 SEC
UPPER	0.20	0.90	0.00	2.50	3.00	900	
LOWER	0.00	0.00	0.00	0.00	0.00	0	

-----< PRODUCT MANAGEMENT >-----

PRODUCT MANAGEMENT	OFF	CONT. NG ALARM	OFF	1 SHOT	
CYCLES REQUESTED		0 SHOT	START UP NG	OFF	1 SHOT
SIGNAL BEF COMPLET.		0 SHOT			
CONTAINER MANAGMNT	OFF	1 SHOT			
INJ PRESSURE ALARM	OFF	1700 BAR			

-----< PRESSURE JUDGMENT >-----

	NO.1	NO.2	NO.3	NO.4	NO.5
INJCT PRES. JUDGMENT	OFF	OFF	OFF	OFF	OFF
UPPER LIMIT (BAR)	0	0	0	0	0
LOWER LIMIT (BAR)	0	0	0	0	0

-----< TORQUE JUDGMENT >-----

	NO.1	NO.2	NO.3	NO.4	NO.5	NO.6
TORQUE JUDGMENT	OFF	OFF	OFF	OFF	OFF	OFF
UPPER LIMIT (%)	0.0	0.0	0.0	0.0	0.0	0.0
LOWER LIMIT (%)	0.0	0.0	0.0	0.0	0.0	0.0

-----< CLAMP / EJECTOR SETTING >-----

	(MM)	(MM/S)	(MM)	(MM/S)		
OPEN LIMIT	129.55	555	BREAKAWAY	555		
CLOSE SW	124.00	555	OPEN 1ST	20.00	555	OPEN TIME 0.0 SEC
CLS SLOW	70.00	555	OPEN 2ST	100.00	555	MOLD PROTECT 20 %
CLOSE SP	40.50					PROTECT TIME 4.00 SEC
TAKE-OUT-ROBOT MODE	OFF	DELAY	0.00 SEC		START POS	0.00 MM

	POS.	VEL.
TAKE-OUT POS	0.00	0.0
HAND OVER POS	0.00	0.0
PARK POS	0.00	0.0

-----< SPECIAL OPTION >-----

	ROBOT	SPECIAL-EJECT	PUNCHER	AIR EJE (FIX)	AIR EJE (MOV)	
START	60.00 MM	120.00 MM	1.0 SEC	0.1 SEC	40.00 MM	
END			15.00 MM	40.00 MM	0.3 SEC	
SHUT OFF DELAY		0.0 SEC	AUTO PURGE		30 COUNT	
SHOT SIZE		16.00 MM	COOL TIME		2.50 SEC	
DECOMP DISTANCE		1.50 MM	PACK RATIO		100 %	
EXTRD.1ST	PRES.	53 BAR	SPEED 300 RPM	TRANS	14.00 MM	
2ST	PRES.	43 BAR	SPEED 300 RPM			
	CONNECT	SET (BC)	TOROLANCE (BC)	SHUT DOWN	SET (SDW) (BC)	
MOLD1	ON	80.0	20.0	OFF	20.0	
MOLD2	ON	79.0	20.0	OFF	20.0	
MOLD3	ON	78.0	20.0	OFF	20.0	
MOLD4	OFF	0.0	0.0	OFF	0.0	
SPRUE-EJECT	START POS	110.00 MM	DELAY	0.09 SEC	LAST	0.18 SEC

-----< DIE HEIGHT ADJUST >-----

CLAMP FORCE	320 KN	MAINTENANCE MODE	OFF	231.10 MM
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-----< CLAMP OPTION 2 >-----

PRE INJECT. 2 ON	INJECT. DELAY	0.00 SEC	
	POS. (MM)	VEL. (MM/S)	DWEL (SEC)
CLOSE SP	40.50	350	0.15
LOCK UP POS 1	20.00	555	0.12
LOCK UP WAIT	0.00	0	0.00
LOCK UP POS 2	0.00	0	0.00
OPEN WAIT	0.00		

-----< EXTERNAL I/O >-----

MANIPULATORS	NOT USE
ALARM BUZZER	NOT USE
SHUT OFF NOZZLE	USE
EJECTOR RETRACT	NOT USE
PARTS REMOVAL DETECTOR	NOT USE

-----< SEQUENCE SELECTION >-----

CLAMP AND EJECT AT NO MATERIAL ALARM	NOT PERMISSION
HEATER AT PRODUCT. COMPLETE (UNMAN)	NOT TURN OFF
CLAMP OPEN AT MOLD PROTECT ALARM	CLAMP NOT OPEN
CLAMP OPEN AT CONTINUOUS NG SHOT ALARM	CLAMP OPEN
EJECT AT CONTINUOUS NG SHOT ALARM	EJECT
INDEPENDENT MODE	USE
CLAMP CLOSE (SHUT DOWN SEQ.)	CLAMP CLOSE
INJ. UNIT RETRACT (SHUT DOWN SEQ.)	RETRACT
AUTO PURGE (SHUT DOWN SEQ.)	NOT PURGE
NOZZLE BACK BEFORE AUTOPURGE	BACK
HOUR DISPLAY MODE (PROCESS MONITOR)	POWER ON
TEMPERATURE CONTROLLER UNIT HARD ALARM	AVAILABLE
ALARM DISPLAY OF LUBRICATION MESSAGE	NOT ALARM

DIE HEIGHT BUTTON

NOT USE

-----< SERVO DIAGNOS >-----

SCREW 5 % CLAMP 1 %

EXTRUDER 5 % EJECTOR 1 %

-----< MACHINE SPECIFICATION >-----

MACHINE TYPE FRS 50i MACHINE NUM. 51xx SCREW DIAMETER 28 MM

INJCT SPEC. STANDARD CLAMP SPEC. STANDARD

EXTRD SPEC. STANDARD EJECT SPEC. STANDARD

TEMP. (BRL) STANDARD TEMP. (NZL) STD.1PC

-----< END >-----