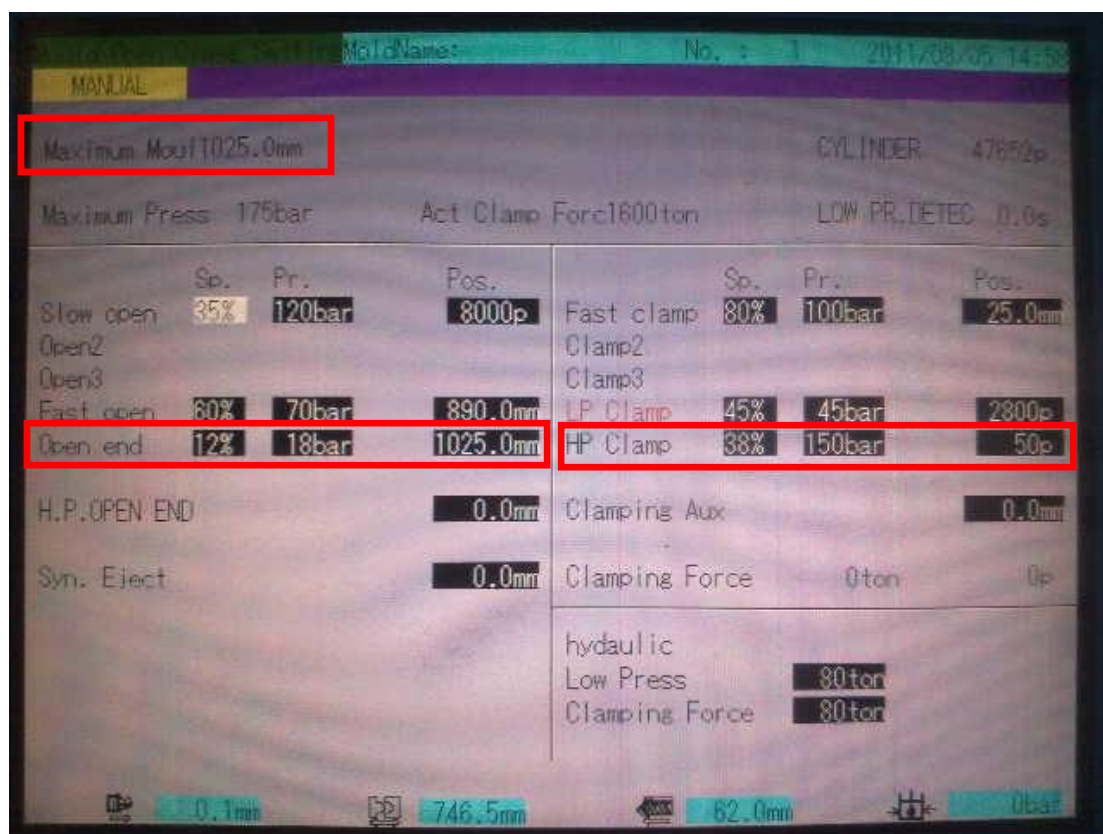


Method for setting clamping origin position of Ai-11

(Linear transducer)

*Note: For the accurate of setting clamping origin, to make sure that the mould on the moving platen and stationary can't be touched after the toggle is straightened if a mould is installed in the machine.

1. Switch ON power of controller, and input level 2 password --- 654321. Ejector back position is at end position.



Picture 1









2. Press **OP. / CL. MD** key, to check maximum open position at “OPEN & CLAMP SCREEN” as picture 1, opening stroke is different for different machine model. For example, maximum mould stroke (maximum opening stroke) is 670 mm as picture 1, set OPEN 5 position (open end position) to be 670 mm and CLAMP 5 (clamp end position – minimum value) to be 0p (minimum value for all of

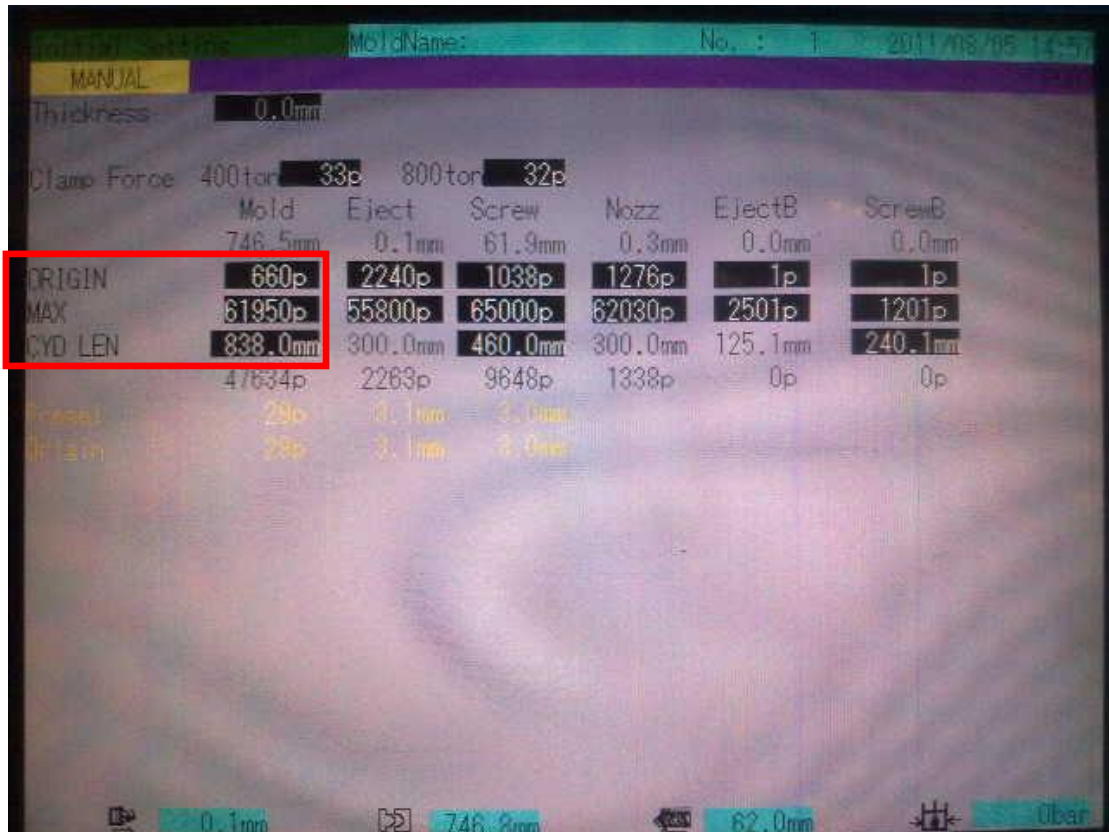
machine model is 0p). Then check and adjust speed and pressure of opening and clamping.

Note: Set speed and pressure of opening and clamping to 30% and 50%, setting should not be high.



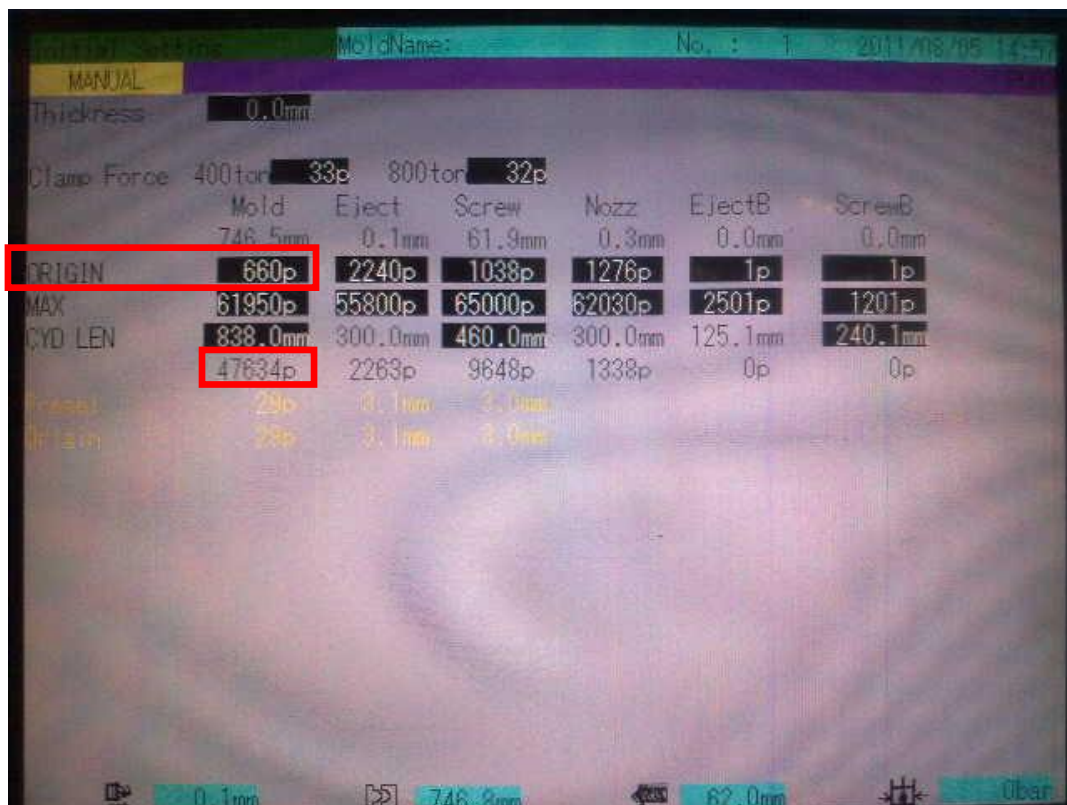
Picture 2

3. Press  key first, and press  key together, to show
- “INITIAL SETTING SCREEN” as picture 2, if screen is others, press 
- key and  key or  key of  together until screen
- “INITIAL SETTING SCREEN” shown as picture 2.



Picture 3

- On "INITIAL SETTING SCREEN", set "ORIGIN" to be 0p and "MAX" to be 65535p, and also set "CYD LEN" (CYLINDER LENGTH) to be maximum mould stroke (maximum opening stroke) 670mm in red rectangle as picture 3.



Picture 4



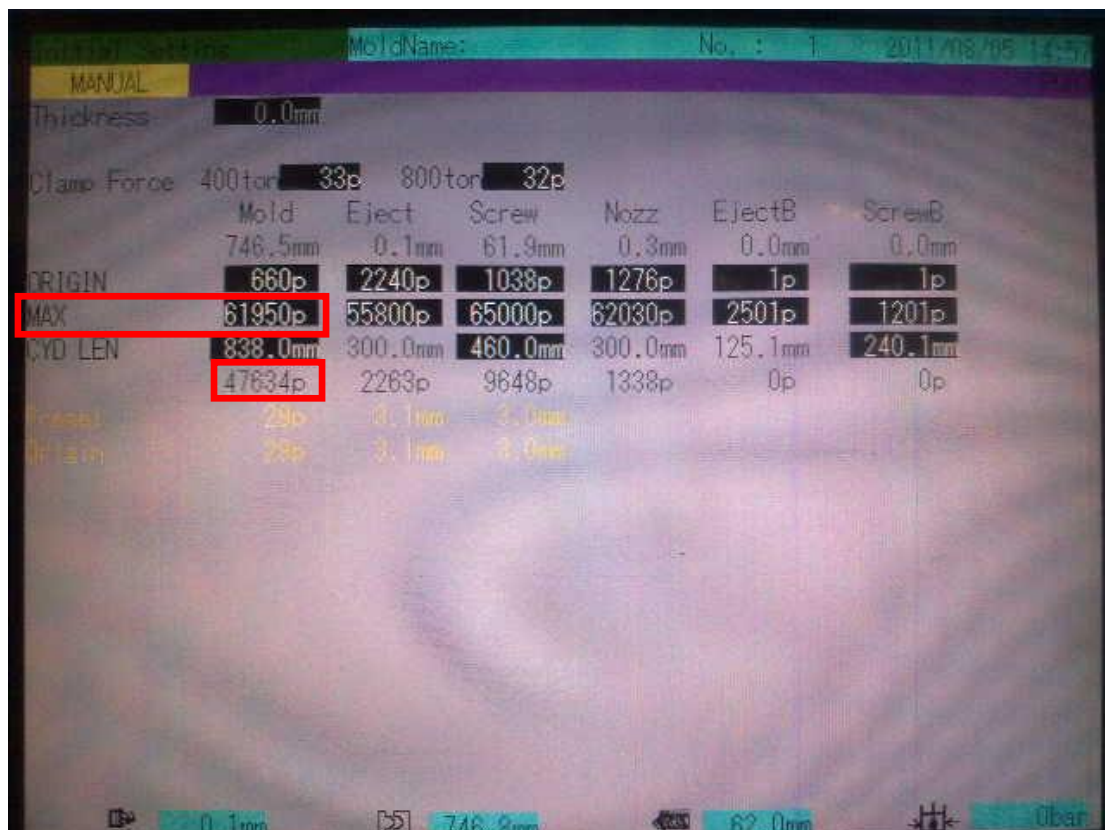
5. a. Start pump, press “MANUAL CLAMP” key to close mould, moving platen move forward until toggle straightened fully and pressure increase, then check signal proximity switch near cross head, light of proximity switch is ON, input signal is IN 29.
- b. Check actual clamping position below ”CYD LEN” in red rectangle as picture 4, if it is jumping between 225 and 227, choose mean value 226, change setting of “ORIGIN” from 0 to 226.



- c. Press “MANUAL CLAMP” key, change setting of “CLAMP 5” (clamp end position) from 0 to 230, it must be greater than 226, otherwise, clamping will not be at end position.




- d. Press “MANUAL CLAMP” key, to close mould, “CLAMP END” message will be shown on the screen, and clamping pressure will be 0 bar.




Picture 5

6. a. Press  and  together, to display “INITIAL

SETTING SCREEN”. Press “MANUAL OPEN”  key to open mould, the moving platen move backward until platen not moving.

- b. Check actual opening position located below “CYD LEN” as picture 5, if it is jumping between 3785 and 3787, choose mean value 3786, then change setting of “MAX” from 65535 to 3786.

- c. Press “MANUAL OPEN”  key, to open mould, “OPEN END” message will be shown on the screen, and opening pressure will be 0 bar.