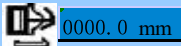### 5.2.28 Action Stroke Stage Number Selection
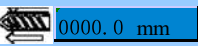
Action Stroke Stage Number Selection Screen

	Mold Name:	No. : 1	2017-3-2 14:32
MANUAL			P070

DataLockPass   111111

DataLockTime   0s   (0:OFF)

Open Number   5

Clamp Number   4

Inject Number   5

Hold Number   3

Plast Number   1

Binject Number   2

BHOLD Number   2

BPLast Number   2

0000.0 mm   PPPP.P mm   0000.0 mm   SSS Kg/cm^2

Press CLEAR + MENU ，**input supervisor password，setting necessary number of stages need for processing.**

In which: "A1"~"A5" are respective the stage numbers setting value of mould opening, mould clamping, injection, pressure holding and plasticizing.

Data setting locking function

Press key，**move cursor to** DataLockpass 456789，**input**

password，then press ENTER **key，password can be 1 to 6 digits，**

move cursor to DataLockTime0s ，setting the data locking delay timer

（0 setting mean not using locking function）. For examples of 10

seconds，press ENTER key to complete the setting，the press

MENU key to quit the screen。 If there is no operation on the data

keys for 10 seconds. The data keys will be locked.

Number Key

To release the locking of data key

To release the locking of data key，press CLEAR + MENU ，

screen comes out as shown below，inputing the keylock password ，

then press ![ENTER] key， "ON" will be changed to "OFF" it mean it

is unlocked.

If the keylock password was forgot, it is necessary to input the

supervisory password；or set `DataLockTime 0s` to"0"，the

press ![ENTER] key to unlock the function

5.2.29 Ramp Setting

Ramp Setting Screen

Ramp Setting	Mould Name:		NO. : 1			2017-3-2 14:32	
MANUAL						P072	

		SP RAMP		PR RAMP		BP RAMP	SP2 RAMP
OPEN END	S11	0.01	PR1	0.16	AUX BP1	0.31 S21	0.36
CLAMP END	S12	0.02	PR2	0.17	AUX BP2	0.32 S22	0.37
INJ	S13	0.03	PR3	0.18	AUX BP3	0.33 S23	0.38
EJECT	S14	0.04	PR4	0.19	AUX BP4	0.34 S24	0.39
PLAST	S15	0.05	PR5	0.20	AUX BP5	0.35 S25	0.40
Fast clamp	S16	0.06	PR6	0.21			
Clamp2	S17	0.07	PR7	0.22	Open Brack	5% 88bar 150.0mm	
Clamp3	S18	0.08	PR8	0.23	Ejt For Brak	4% 88bar 40.0mm	
Lp Clamp	S19	0.09	PR9	0.24			
Hp Clamp	S110	0.10	PR10	0.25			
Slow open	S111	0.11	PR11	0.26			
Open2	S112	0.12	PR12	0.27			
open3	S113	0.13	PR13	0.28			
Fast open	S114	0.14	PR14	0.29			
OPEN END	S115	0.15	PR15	0.30			

	0000.0 mm		0000.0 mm		0000.0 mm		SSSS Kg/cm^2

Press **CLEAR** + **MOLD/STAT** to call the ramp setting screen.

Press ⬆⬅➡⬇ to choose slope, and input corresponding slope, then

press **ENTER** to complete the setting.

In which: "S", "PR", "BP" are respective abbreviation of Speed, Press and Back Press.

S11: Speed slope of fast mould clamping and low pressure mould clamping;

S12: Speed slope of mould opening;

S13: Speed slope of injection and plasticizing;

S14: Speed slope of melt decompression;

S15: Speed slope of mould clamping while adjusting mould clamping force;

PR1: Pressure slope of fast mould clamping;

PR2: Pressure slope of mould opening;

PR3: Pressure slope of injection and plasticizing;

PR4: Pressure slope of melt decompression;

PR5: Pressure slope of mould clamping while adjusting mould clamping force.