Method for setting injection origin position of Ai-11

(Linear transducer)

- *Note: Barrel must be heated up to be temperature setting before setting injection origin position, otherwise, it will cause injection screw broken.
- 1. Switch ON power of controller, input password (654321) of Level 2 on the password screen. Heat up barrel and make sure actual barrel temperature of barrel is temperature setting.

MANUAL	le i dName≎	No. :		45 LEX
Max. Stroke 460.0mm	FILLING	0.00s	Cushilion End	
INJECT TIME 3.00s	Hold Change	Timer	Inject Press	100536
Sp. Pr. Hold1 Hold2 Hold3 Hold4 Hold5 Hold6 Hold9 Hold10	Time 1.05	Sp. Inject1 99 Inject2 99 Inject3 99 Inject3 99 Inject4 99 Inject5 99 Inject5 99 Inject5 Inject8 Inject9 Inject10	6 175bar 6 175bar 8 175bar 8 175bar	Pes. 100.0m 100.0m 100.0m
0.1m	2 746.5mm	Hold Pre.POS Leakage POS		0.0m

Picture 1



2. Press **INJECTION** key, to display "INJECTION SETTING SCREEN", maximum stroke is shown on the screen as picture 1, different machine model has different maximum stroke.

For Example, as picture 1, maximum stroke is 320mm as picture 1, and set "INJECT

5" (injection end position) to be 0mm, then check and adjust speed and pressure of injection at each stage.

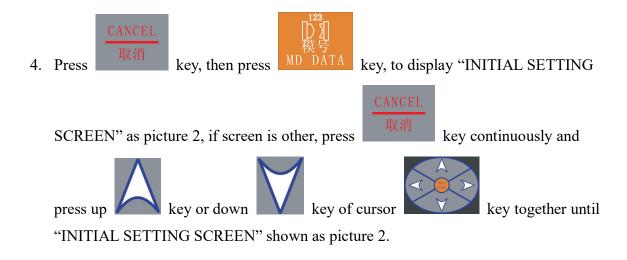
Note: Set speed and pressure of injection at each stage to be 30% to 50%, setting should not be to high.



3. Press **PLAST/DEC** key to display "PLAST / DECOMP SETTING SCREEN", set all of plasticization position to be 0mm and all of decompression position to be maximum stroke (320mm) (different machine model has different decompression stroke), then check and adjust speed and pressure of plasticization and decompression at each stage.

Note: speed and pressure of injection at each stage is not set to be great, it is suggested to be 30% to 50%.

MANUAL	Mol dName:			No. : 1 2011/08/05 12:57				
Thickress	0.0m							
Clamo Force	Mold 746.5mm	Eject 0.1mm	Screw 61.9mm	Nozz 0,3mm	EjectB 0.0mm	G. Omm		
ORIGIN MAX CYD LEN	660p 61950p 838.0mm 47634p	2240p 55800p 300.0mm 2263p	65000p 460.0mm		125.1mm 0p	1p 1201p 240.1m 0p		
	236 286	it tum I ime						
40	O. Jon	[55] 7	10-0-0	-	62 (Jum	Ht		



MANUAL Thickness	0.0mm	MolaNane			No. : 1	2011/08/40	
Clano Force CRIGIN MAX CYO LEN	400 tor 3 Mold 746 .5mm 660p 61950p 838 .0mm 47634p	Eject 0.1mm 2240p 55800p 300.0mm	Screw 61.9mm 1038p 65000p 460.0mm	Nozz 0,3mm 1276p 62030p 300.0mm 1338p	Eject8 0.0mm 1e 2501e 125.1mm 0p	Screw6 0.0mm 1p 1201p 240.1mm 0p	No. of Contraction
							A States
	O. Trop	22 7	46.8mm	-	62.0mm	生	Uban.

Picture 3

5. On the "INITIAL SETTING SCREEN", set "ORIGIN" to be 0p and "MAX" to be 65535p in red rectangle as picture 3.

MANUAL	0.0mm	MoliciNane:	No. : T. 2001 ANS HE LAST			
Clane Force PRIGIN MAX	Mold 746.5mm 660p 61950p	3p 800 ton 32p Eject Screw 0.1mm 61.9mm 2240p 1038p 55800p 65000p 450.0mm 450.0mm	1276p 1p 62030p 2501p	Screuß G.Omm Ip 1201p 240 1 m		
CYD LEN	838.0mm 47634p 200	300.0mm 2263p 9648p 3.1mm 3.1mm 9648p	300.0mm 125.1mm 1338p 0p	0p		
B	0.1mm	22 746,8mm	#2 62.0m	tik Obat		

Picture 4



6. a. Start pump, press "MANUAL INJECT INJECT " key to inject,

injection cylinder move forward until it is at end position and injection pressure increase.

b. Check actual injection position below "CYD LEN" in red rectangle as picture
4, if it is jumping between 150 and 153, choose greater value (153) to add 1, new value is 154 (=153+1), then change setting of "ORIGIN" from 0 to 154.

MANUAL	0.0mm	MOI dName:		No. : 1 2011/08/05 14:57			
Clane Force	400 tor 3 Mold 746.5mm	35 800tor Eject S 0.1mm	Screw	Nozz 0.3mm	EjectB 0.0mm	ScrewB Q.Qmm	
ORIGIN MAX CYD LEN	660p 61950p 838.0mm	2240p 55800p	1038p 65000p	1276p 62030p 300.0mm	1p 2501p 125.1mm 0p	1p 1201p 240.1m 0p	
	47634p ///b	2263p	3048p	1338p	UP	qu	and the second
							1
and the second							14 miles
B. 19	O. Trop	22 74	S. Smp	煙	62.0mm	生	Uban

Picture 5



7. a. Press "MANUAL MELT DEC MELT DEC" key to melt decompression,

injection cylinder move backward until it is at end position.

b. Check actual injection position below "CYD LEN" in red rectangle as picture 5, if it is jumping between 4000 and 4003, choose smaller value to minus 2, new value is 3998 (=4000-2), then change setting of "MAX" from 65535 to 3998.