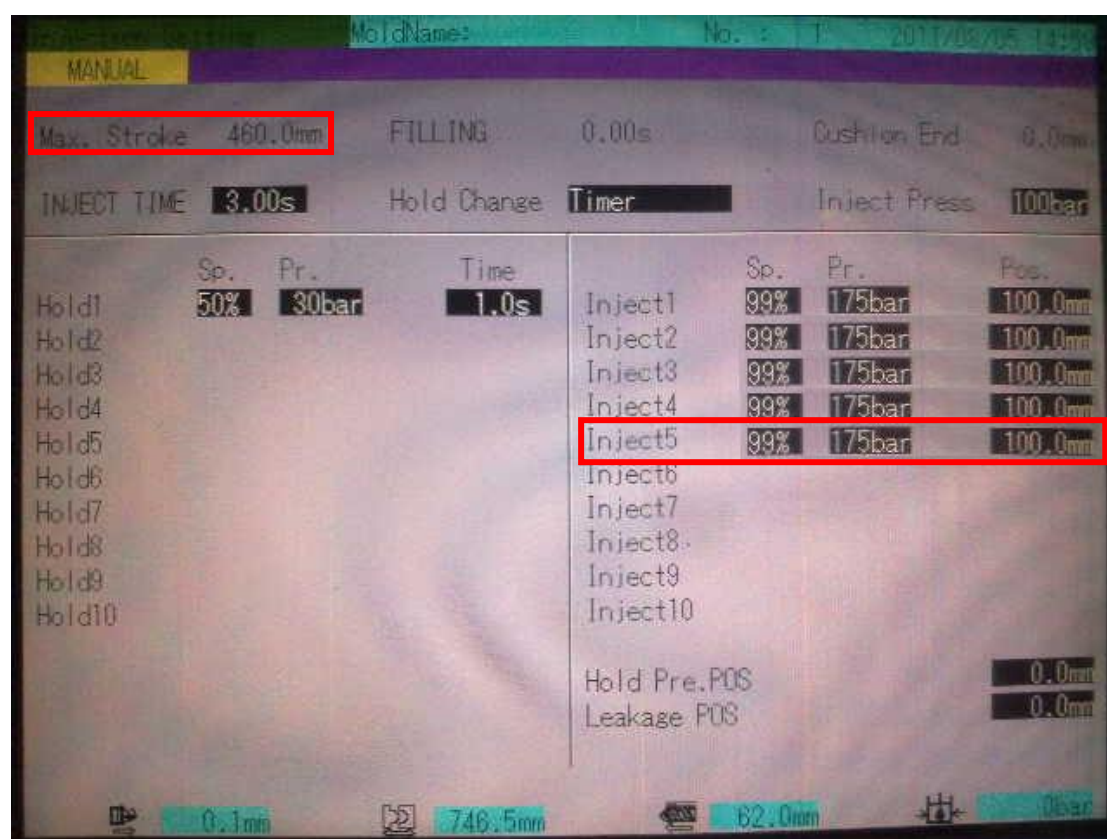


Method for setting injection origin position of Ai-11

(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.



Picture 1



2. Press  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 too high.




- 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%.

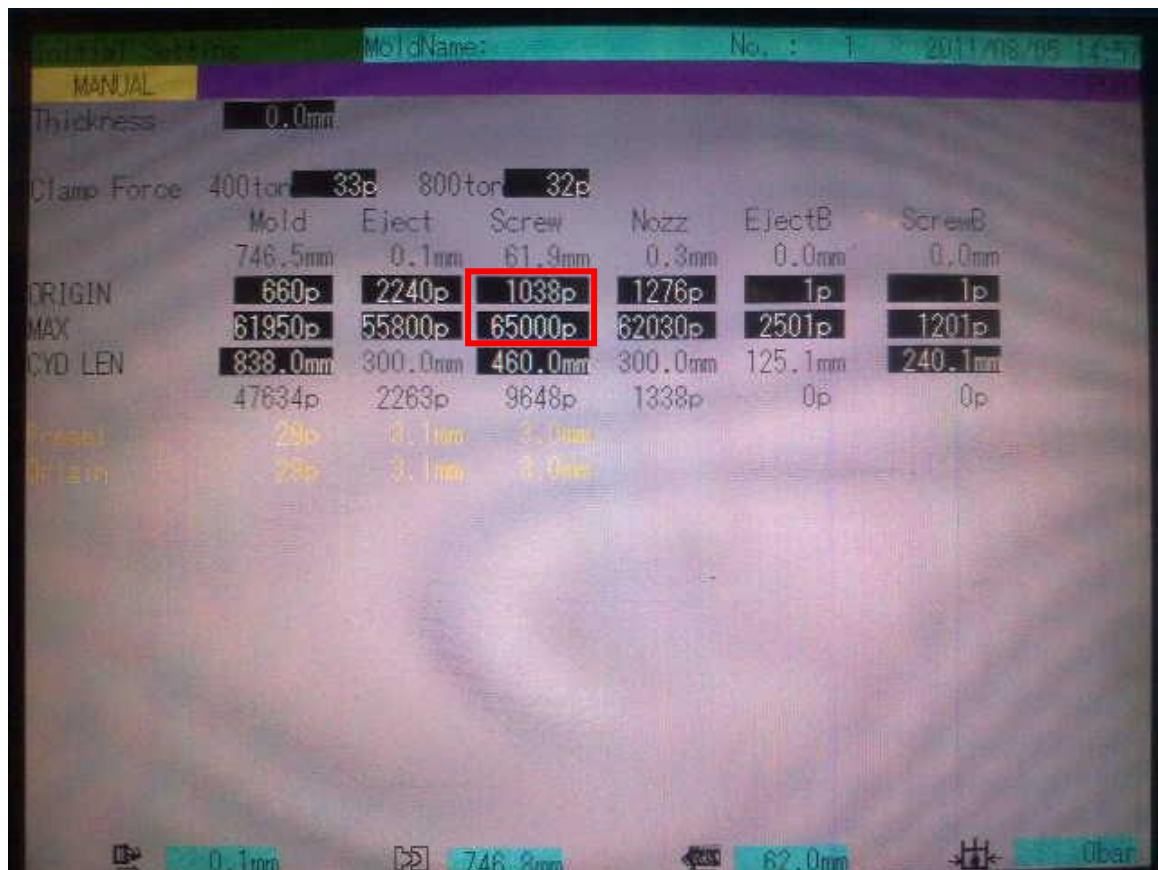


Picture 2

4. Press  key, then press  key, to display “INITIAL SETTING

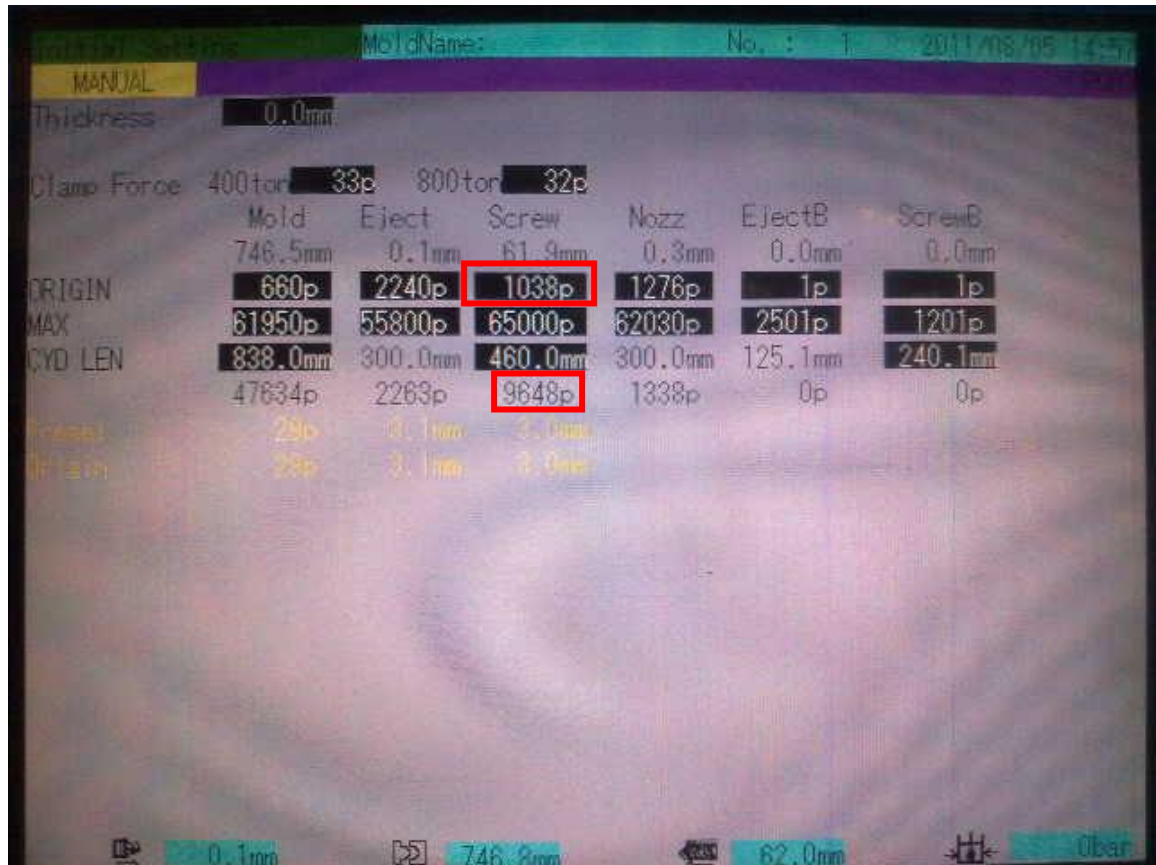
SCREEN” as picture 2, if screen is other, press  key continuously and

press up  key or down  key of cursor  key together until “INITIAL SETTING SCREEN” shown as picture 2.




Picture 3

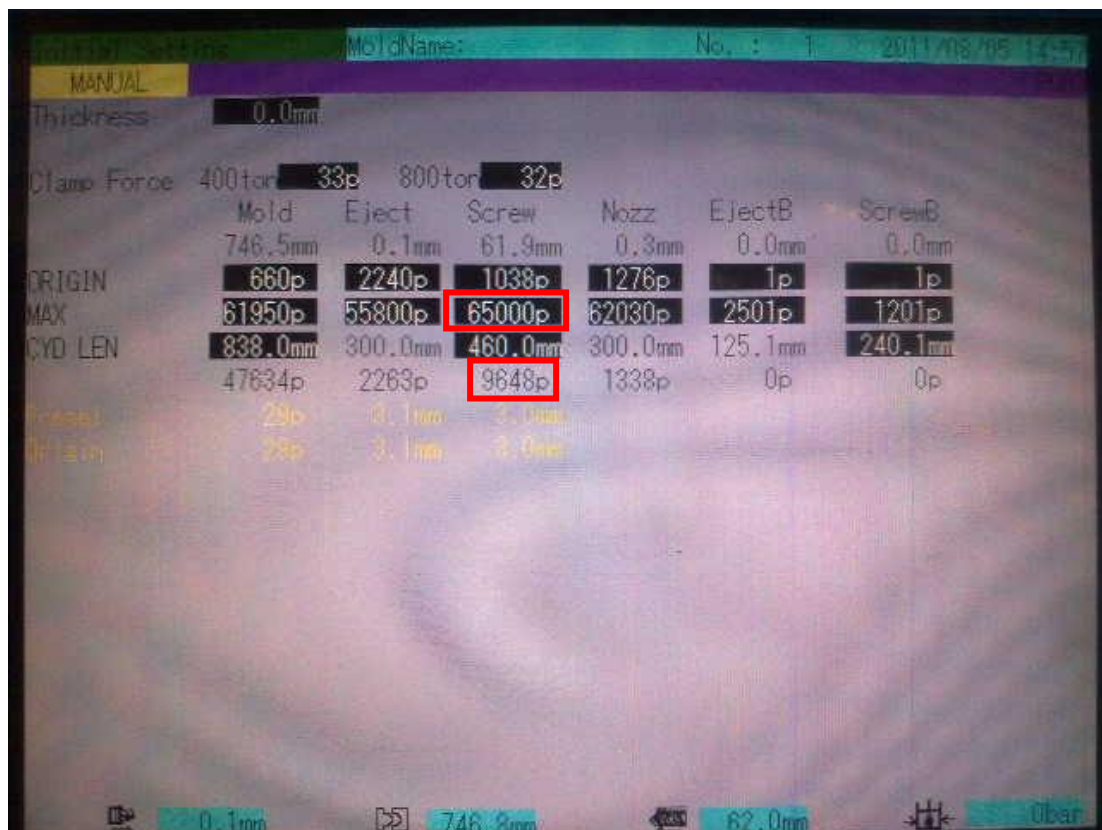
5. On the “INITIAL SETTING SCREEN”, set “ORIGIN” to be 0p and “MAX” to be 65535p in red rectangle as picture 3.



Picture 4



6. a. Start pump, press “MANUAL 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.



Picture 5



7. a. Press “MANUAL 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.