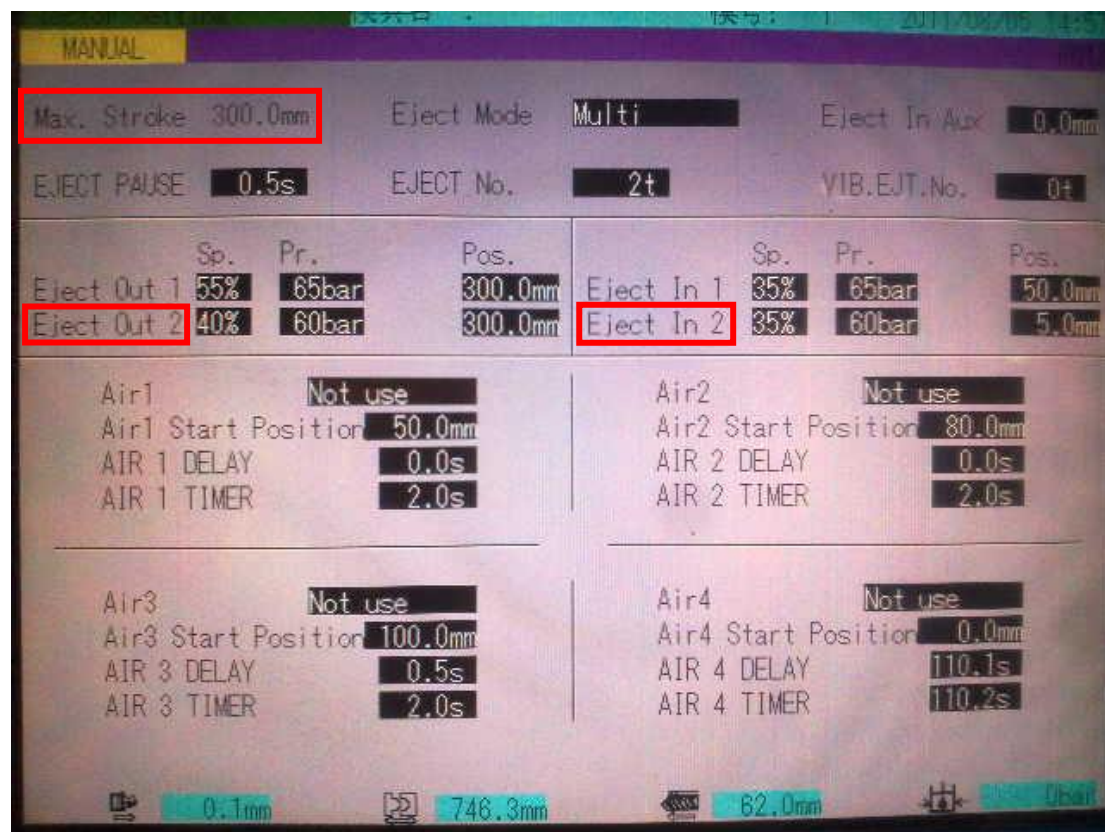


Method for setting ejector origin position of Ai – 11

(Linear transducer)


***Note:** If there is a mould in the machine, remove mould from machine before setting ejector position, otherwise, may be the mould will be damaged and position will be not correct.

1. Switch ON power of controller, then input password 654321 at level 2, make sure mould is at mould end position.



Picture 1



2. Press  key to display “EJECTOR SETTING SCREEN”, maximum stroke is shown on the screen as picture 1, different machine model has different ejector stroke.



For example, as picture 1, maximum stroke is 180mm in picture 1. Set “EJECTOR OUT 2” (ejector forward end position) to be 180mm (maximum stroke value), then set “EJECTOR IN 2” (ejector backward end position) to be

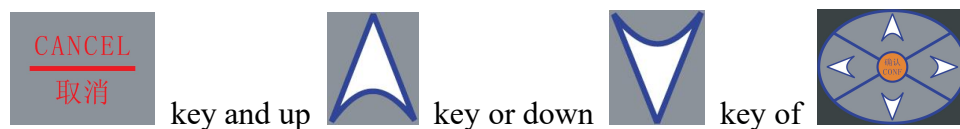
0mm. Check and adjust speed and pressure of ejector in and out.

Note: Set speed and pressure of ejector at each stage to be 20% to 40%, setting should not be too high.

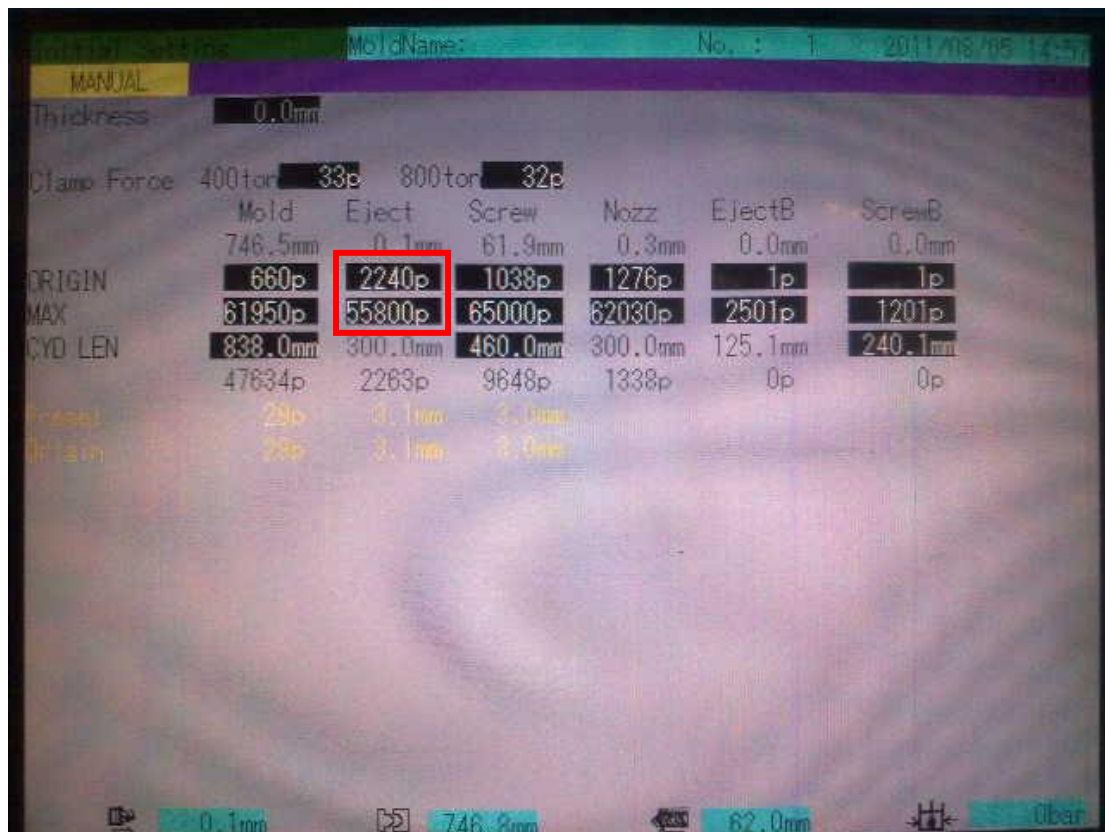


Picture 2

3. Press  key first, and press  key together, to display "INITIAL SETTING SCREEN" as picture 2, if screen is others, press

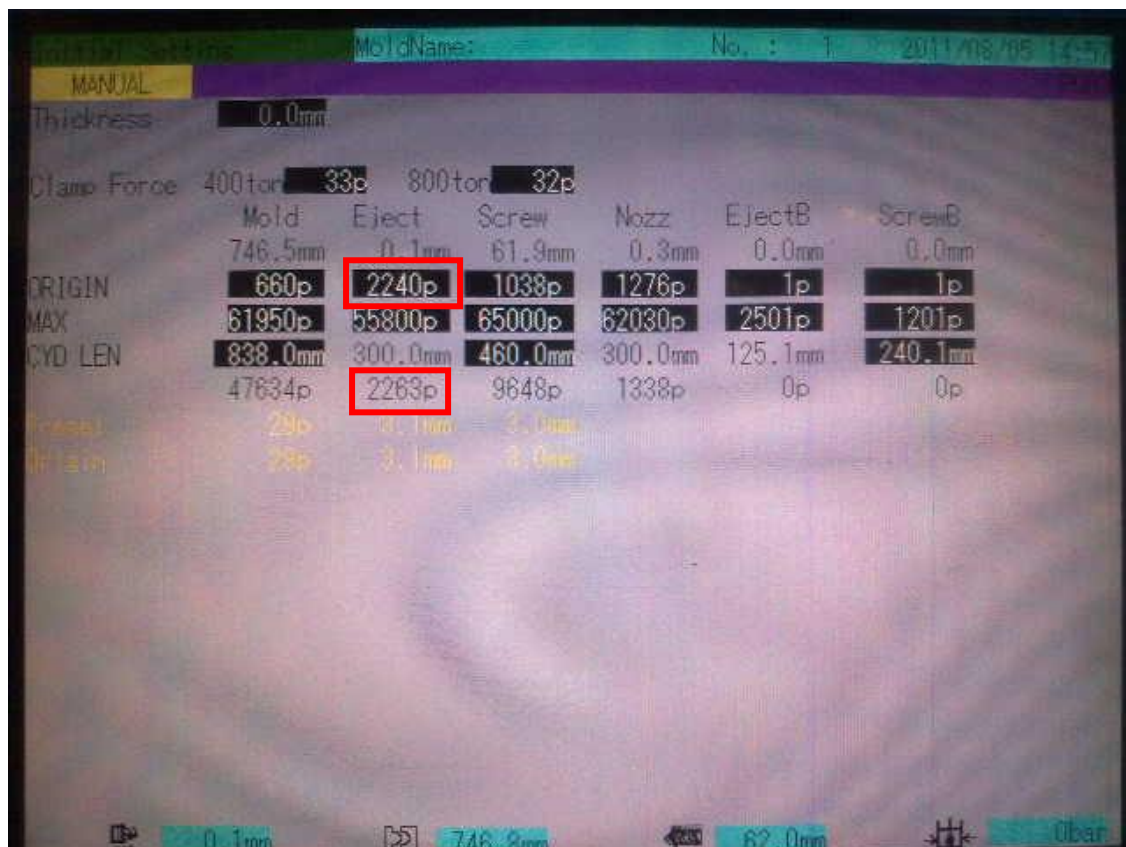


together until "INITIAL SETTING SCREEN" shown as picture 2.



Picture 3

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



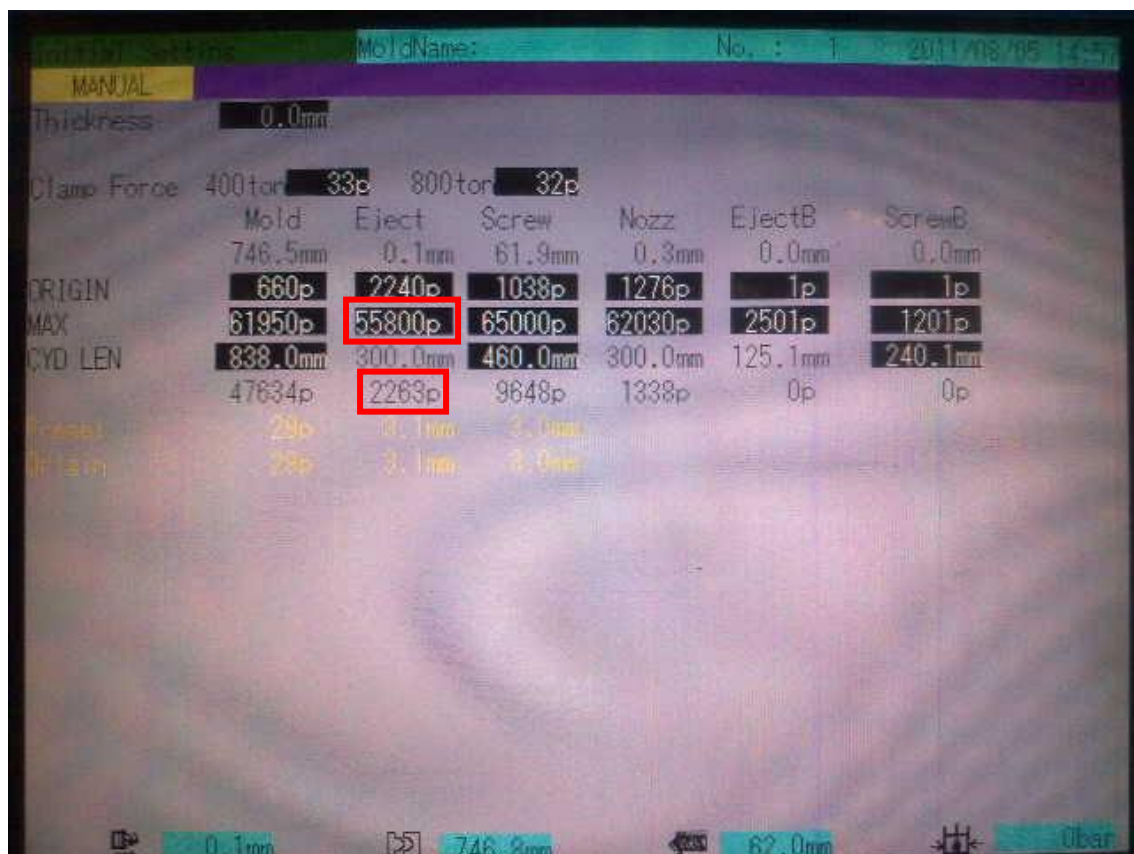
Picture 4



5. a. Start pump, press “MANUAL EJECT BACK” key to eject backward, ejector cylinder move backward until it is at end position.
- b. Check actual injection position below “CYD LEN” in red rectangle as picture 4, if it is jumping between 283 and 280, choose greater value (283) to add 1, new value is 284 (=283+1), then change setting of “ORIGIN” from 0 to 284.



- c. Press “MANUAL EJECTOR BACK” key to eject backward, “EJECT BACKWARD END” message will be shown on the screen and ejector backward pressure will be 0 bar.



Picture 5



6. a. Start pump, press “MANUAL EJECT FORWARD” key to

eject forward, ejector cylinder move forward until it is at end position and eject forward pressure increase.

- b. Check actual ejector forward position below “CYD LEN” in red rectangle as picture 5, if it is jumping between 4000p and 4002p, choose smaller value to minus 1, new value is 3999 (=4000-1), the change setting of “MAX” from 65535 to 3999.



- c. Press “MANUAL EJECT FORWARD” key, to eject forward, “EJECT FORWARD END” message will be shown on the screen, and eject forward pressure will be 0 bar.