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.

		一次は	
MANJAL			
Max. Stroke 300.0mm	Eject Mode	Multi	Elect In Aux 0.0mm
EJECT PAUSE 0.55	EJECT No.	2t	VIB.EJT.No.
So. Pr. Eject Out 1 55% 65bar Eject Out 2 40% 60bar	Pos. <u>300.0mm</u> 300.0mm	Sp. Eject In 1 35% Eject In 2 35%	Pr. Pos. 65bar 50.0mm 60bar 5.0mm
Air1 Not Air1 Start Position AIR 1 DELAY AIR 1 TIMER	use 50.0mm 0.0s 2.0s	Air2 Air2 Start AIR 2 DELAY AIR 2 TIMER	Not use Position 80.0mm 0.0s 2.0s
Air3 Not Air3 Start Position AIR 3 DELAY AIR 3 TIMER	use 100.0mm 0.5s 2.0s	Air4 Air4 Start AIR 4 DELA) AIR 4 TIMEF	Not use Position 0.0mm 110.1s 110.2s
e 100.1mm	2 746.3mm	62.0m	

Picture 1



2. Press EJECTOR 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 to high.



Picture 2



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

RANUTAL		MolaNan	1,0,250		No. : T	2011/08/08	165
Thickness	0.0m						
Clamp Force	400 tor 3 Mold 746 5mm	Biect	or 32p Screw	Nozz 0 3mm	EjectB	ScrewB	
TRIGIN MAX CYD LEN	660p 61950p 838.0mm	2240p 55800p	1038p 65000p 460.0mm	1276p 62030p 300.0mm	1p 2501p 125,1mm	1p 1201p 240.1mm	
	47634p	2263p	9648p	1338p	0p	Op	
	0.1mm	1551	10 000	4000	62 0mm	1	übar

Picture 3

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

MANUAL		MolidName:		No. : 1	2011/18/4	
Thickness	0.0mm					
Claire Force	400 tor 3 Mold 746.5mm	3c 800ton 32 Eject Screw	Nozz n 0.3mm	EJectB 0.0mm	ScrewB	
ORIGIN MAX	660p 61950p	2240p 1038p 55800p 65000p	1276p 52030p	1p 2501p	1p 1201p	
CYU LEN	47634p	2263p 9648p	1338p	125.1mm Op	Qp	
	0.100	D51 746 0	100	62 0mm	att.	Cibar.



- key to eject Start pump, press "MANUAL EJECT BACK" 5. a. backward, ejector cylinder move backward until it is at end position.
 - Check actual injection position below "CYD LEN" in red rectangle as b.

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.

MANUTAL	ins .	MoldNane:	No. : T	2011/08/06 14:57
Thickness	0.0mm			
Clamp Force	400 ton 3 Mold	3s 800ton 32s Eject Screw	Nozz EjectB	Screeß
RIGIN	660p 61950p	2240p 1038p 55800p 65000p	1276p 1p 62030p 2501p	1p 1201p
CYO LEN	838.0mm 47634p	300.0mm 460.0mm 2263p 9648p	300.0mm 125.1mm 1338p 0p	240.1mm Op
in an				
			-	
The De	In Block	P51 336 0	AND 02 0.00	Ht.

Picture 5



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.