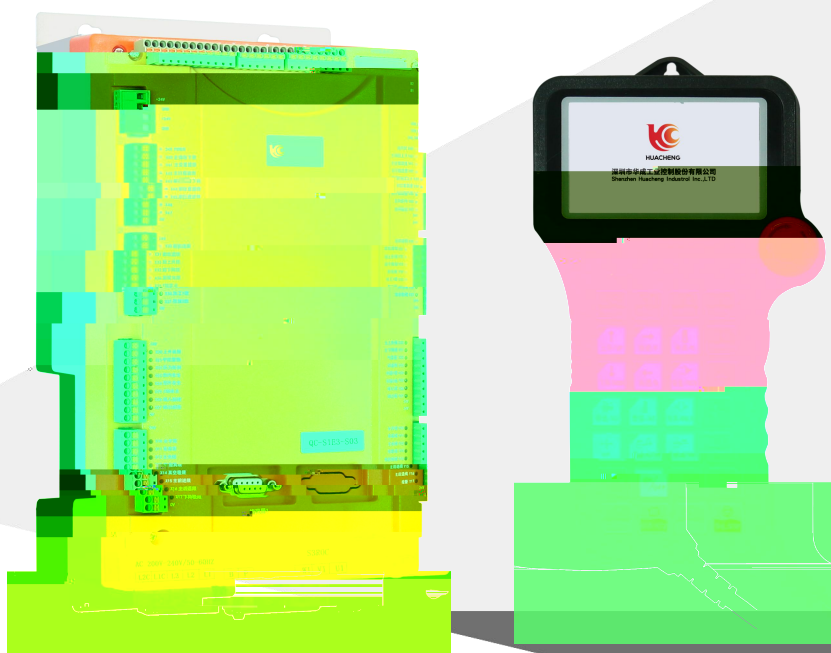
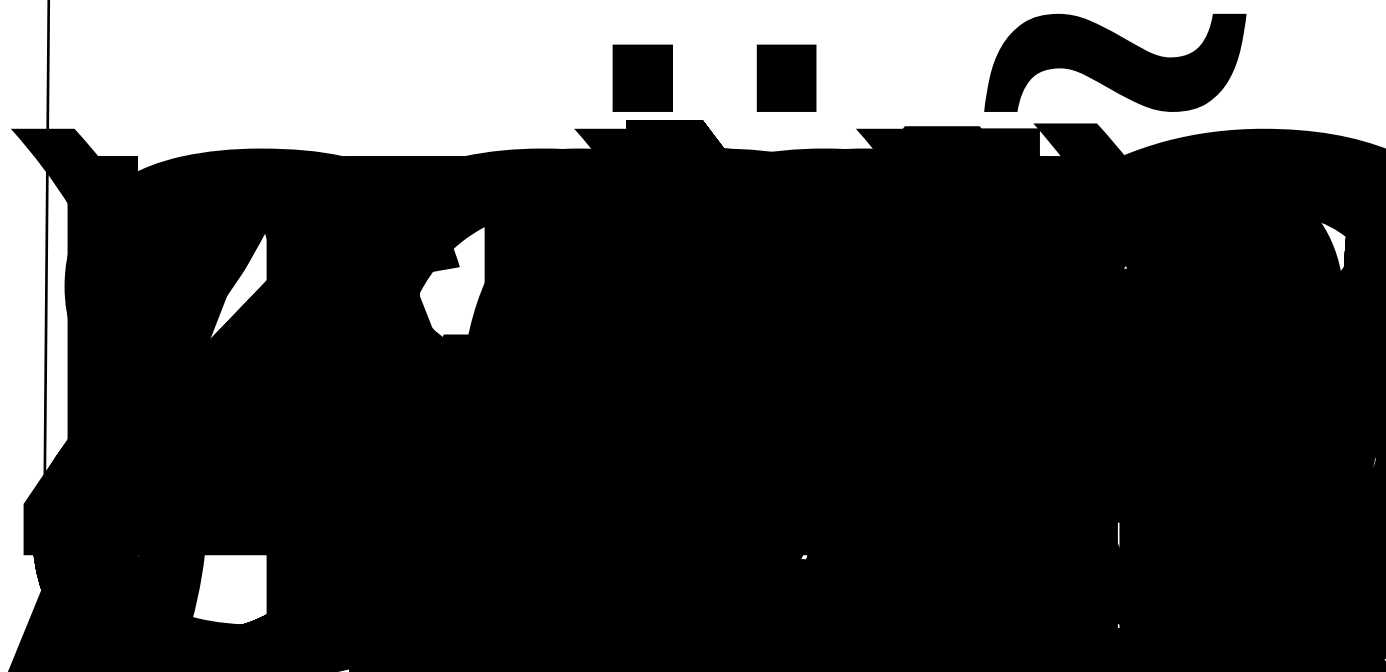
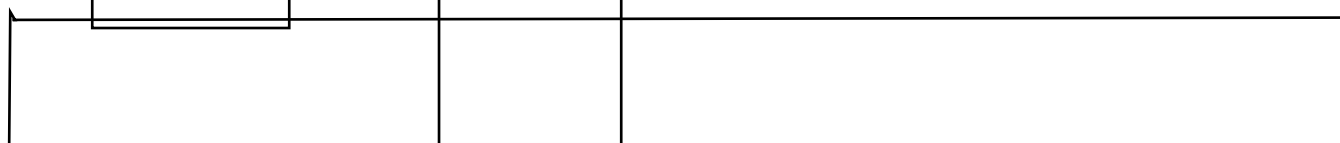




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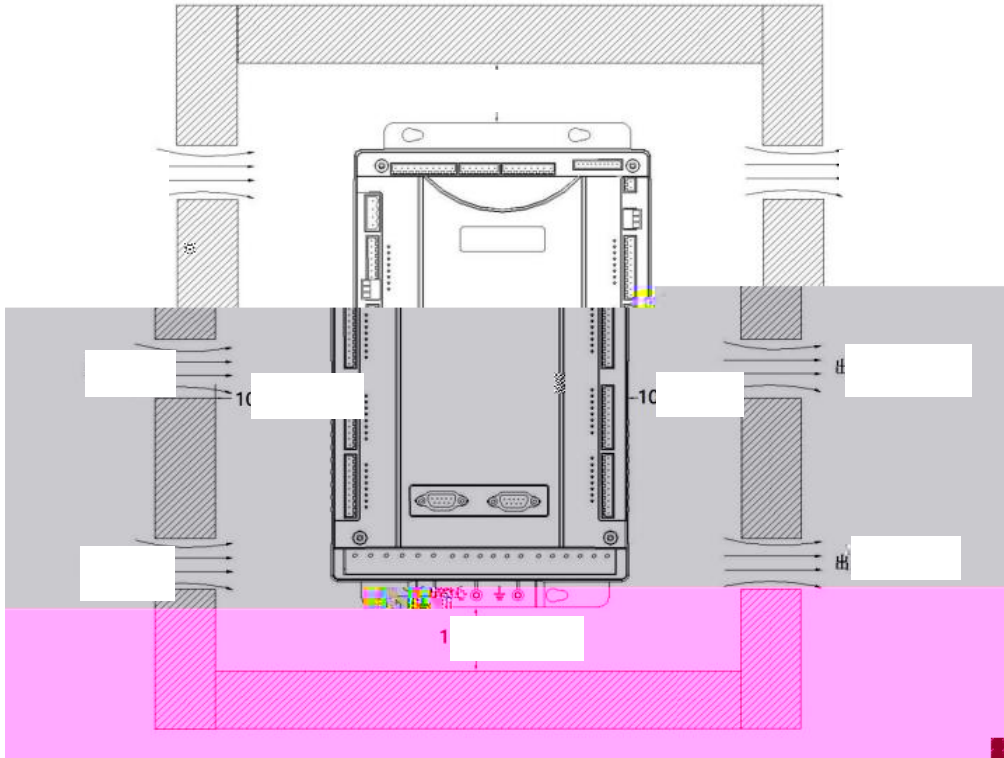


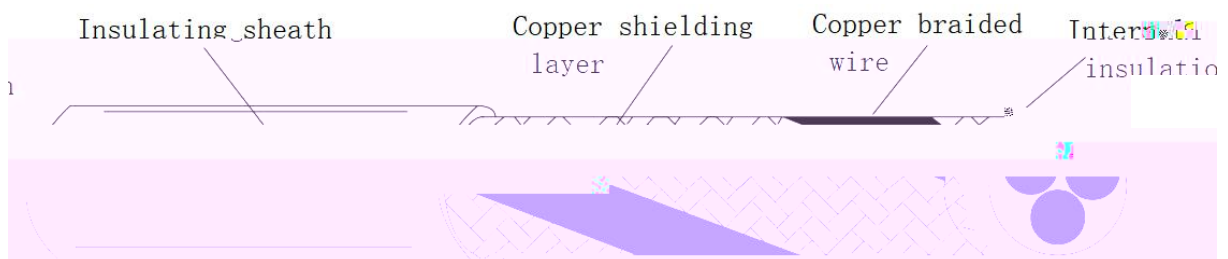
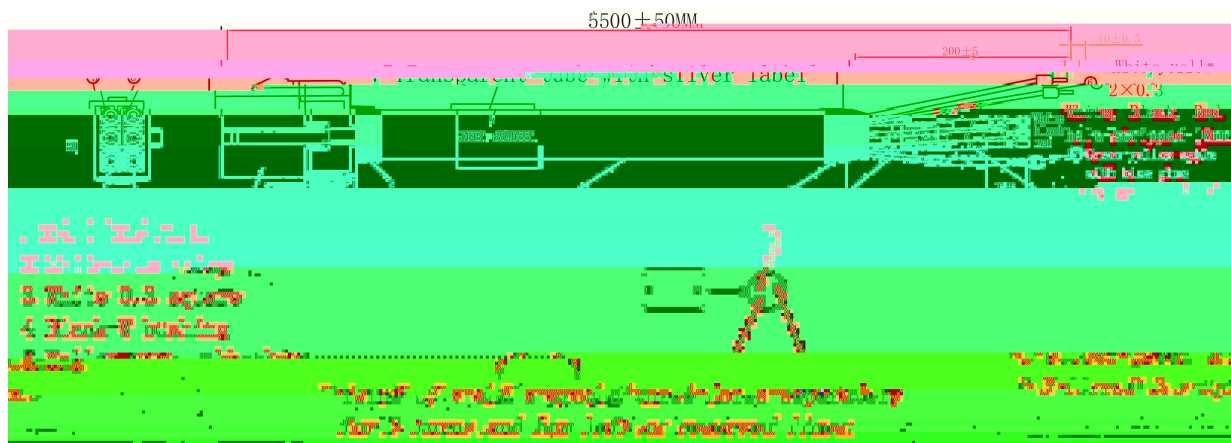
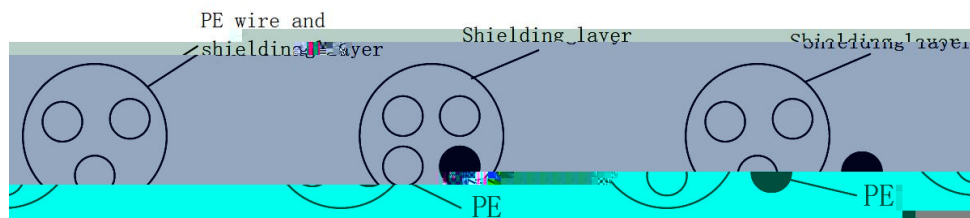
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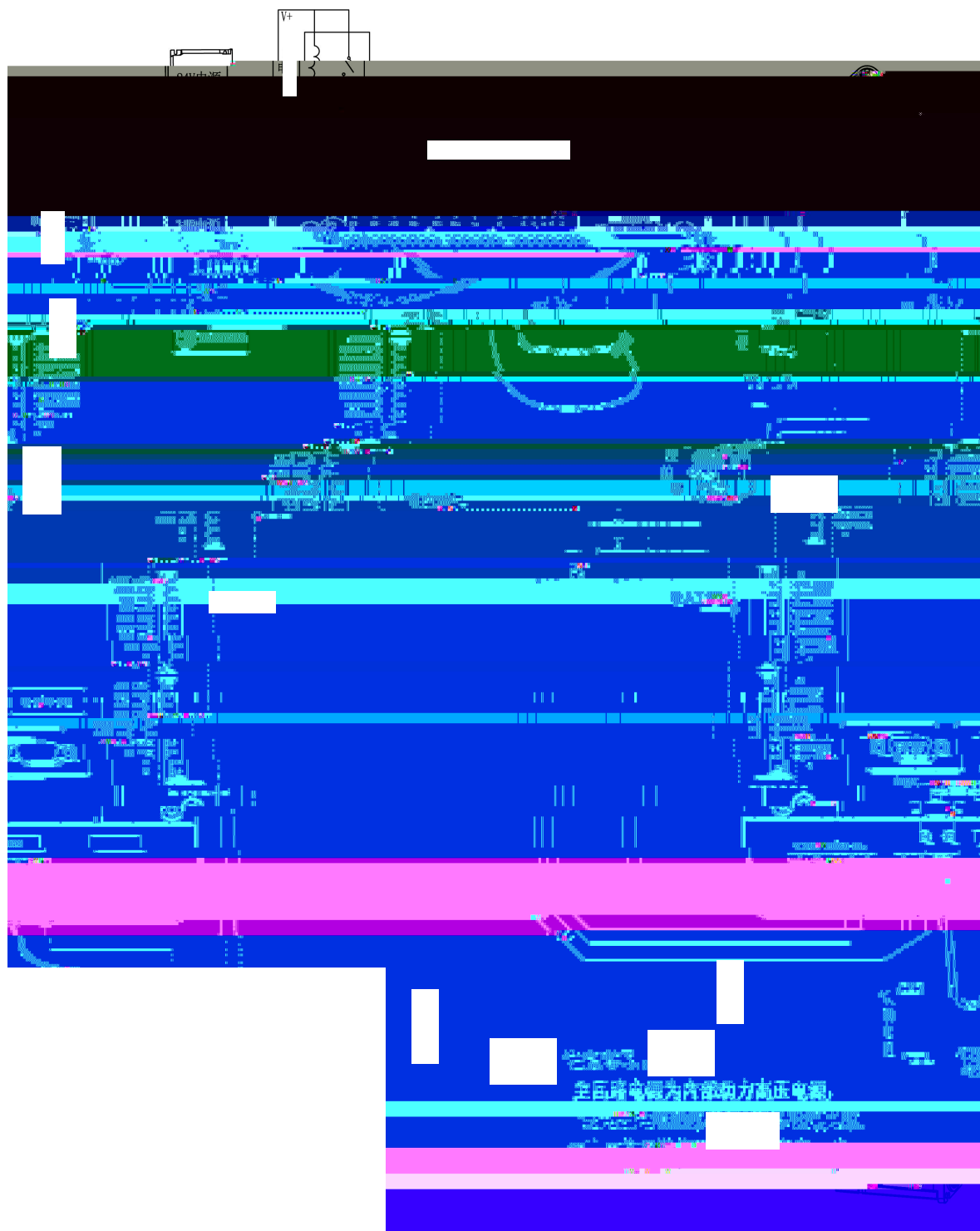


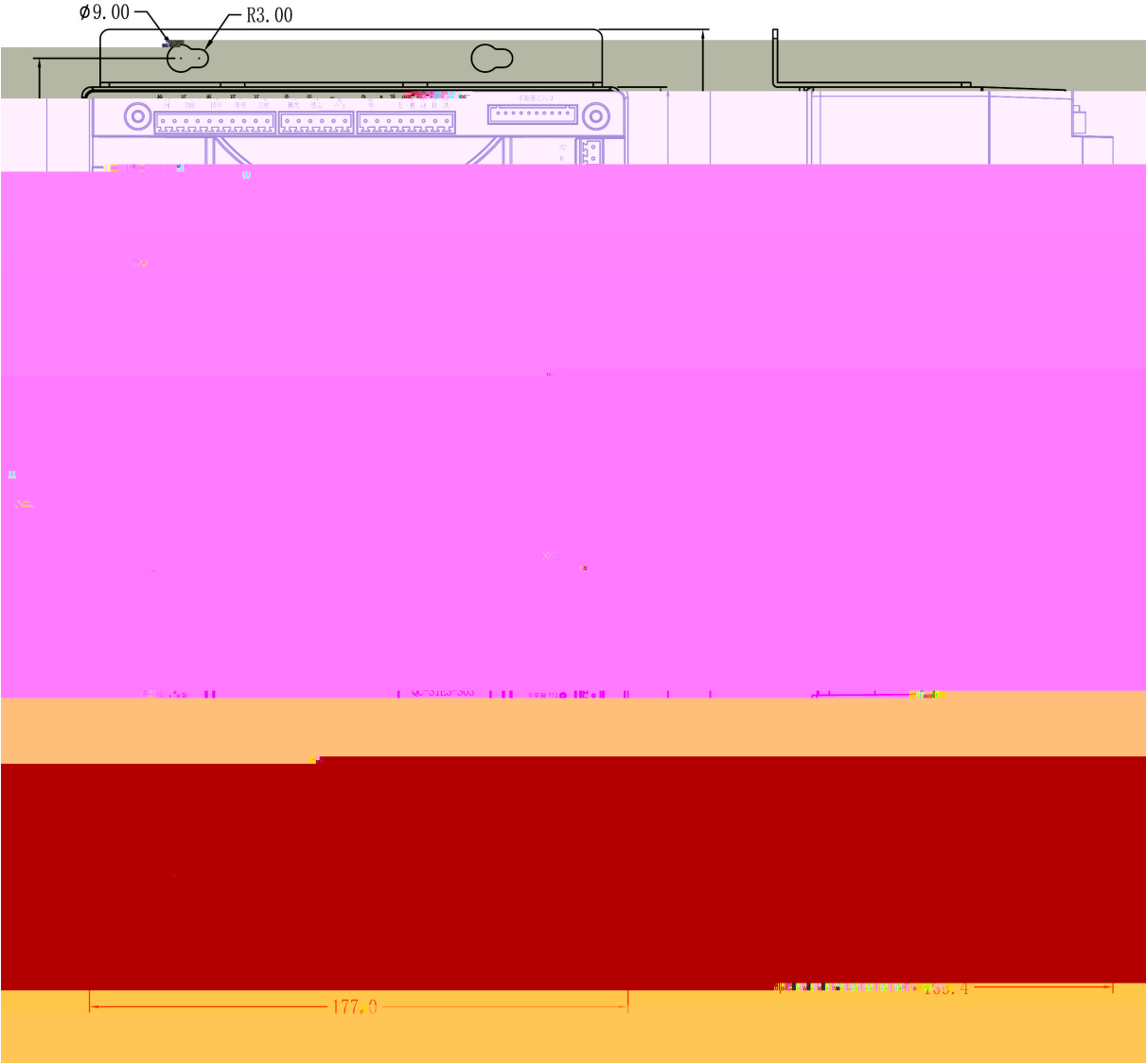
HUACHENG

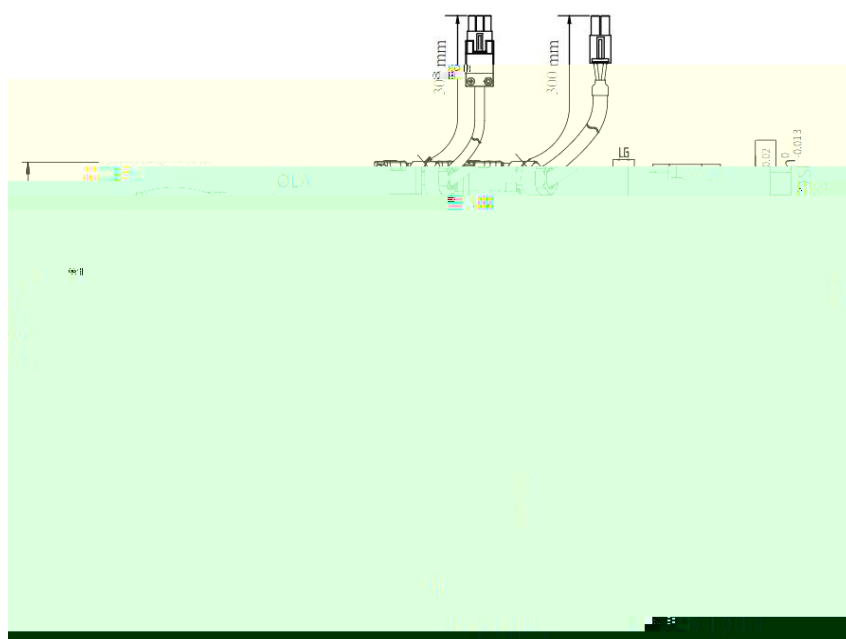


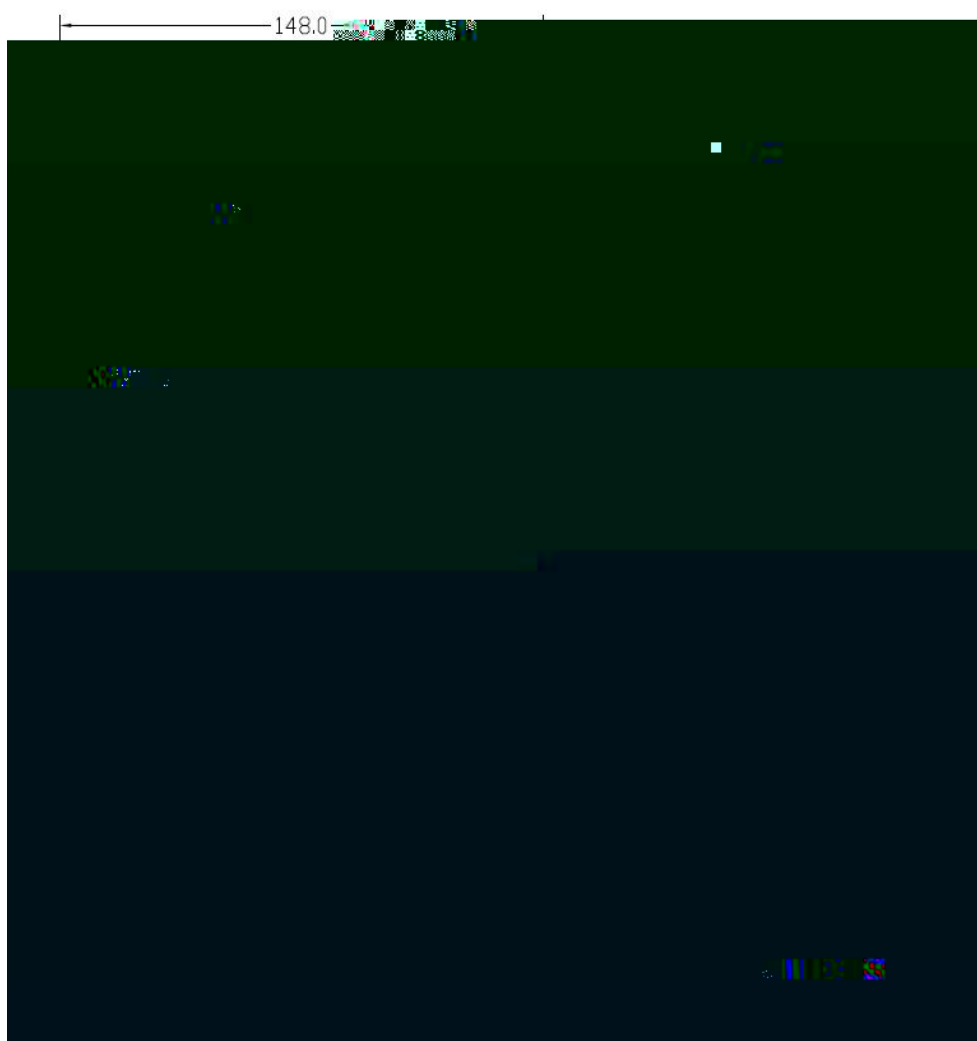






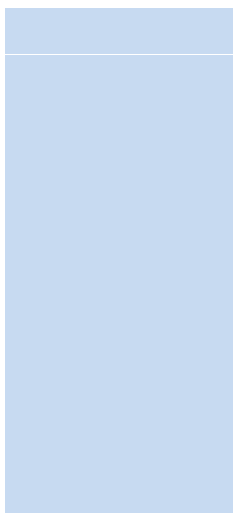


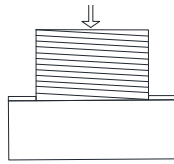
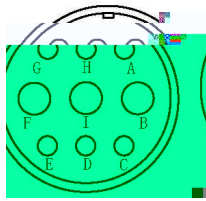


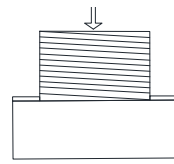
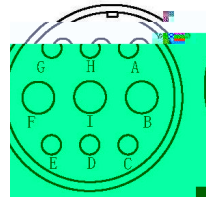


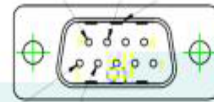


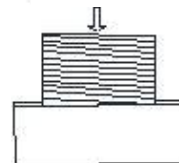
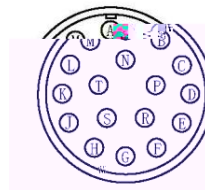




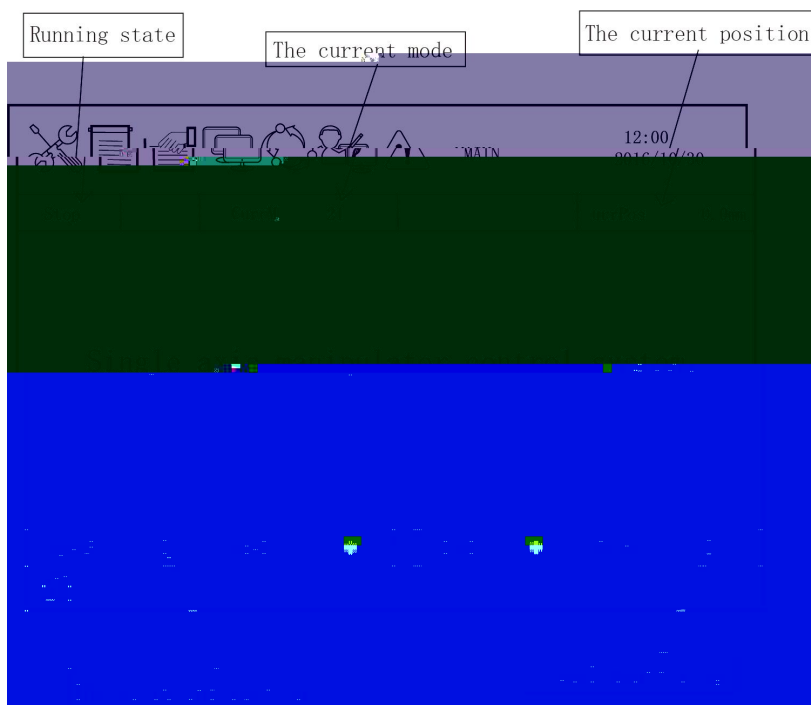
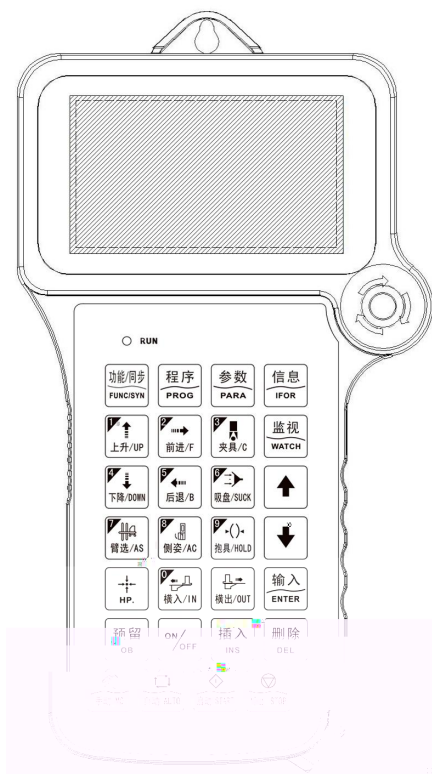














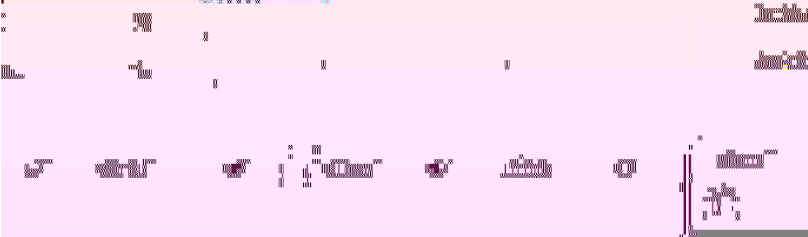




MAN

12:00
2016/10/30

Manu		CurrM	21		urrPos	0.0mm
TravMode	Manual		CurrAction:			
ManuPos	600.0 mm		No Act			
ManuSpd	10%					



输入
ENTER

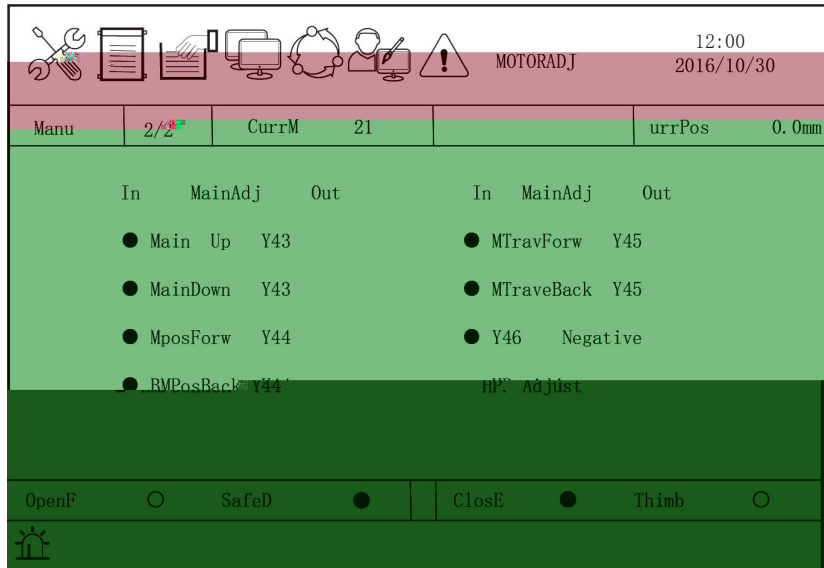




      				MANIPARAM		12:00 2016/10/30	
Manu		CurrM	21		urrPos	0.0mm	
ManuSpd	80 %	DotRange	0.1mm				
ManuPos	100.0mm						
DoVSpd	30.0 %						
TackPos	10.0mm						
OpenF	☐	SafeD	☒	ClosE	☒	Thimb	☐
							



      				MOTORADJ		12:00 2016/10/30	
Manu	1/2	CurrM	21		urrPos	0.0mm	
In	MainAdj	Out		In	MainAdj	Out	
● Main Up	Y40			● MTravForw	Y42		
● MainDown	Y40			● MTraveBack	Y42		
● MposForw	Y41			● Y46	Negative		
● BMPosBack	Y41			HP. Adjust			
OpenF	☐	SafeD	☒	ClosE	☒	Thimb	☐
							



功能/同步
FUNC/SYN

输入
ENTER

       FUNC 12:00 2016/10/30			
Stop		CurrM 21	urrPos 0.0mm
Language	English	ChkVFix	PP
SetVold	30000	ChkVaccu	Use
OpenDly	0.5 s	ChkHold	Use
Thimbdly	0.0 s	ClearPro	ON
ChkMPEx	PP	KeyTone	OFF
OpenF ☐	SafeD ☒	ClosE ☒	Thimb ☐

功能/同步
FUNCTION

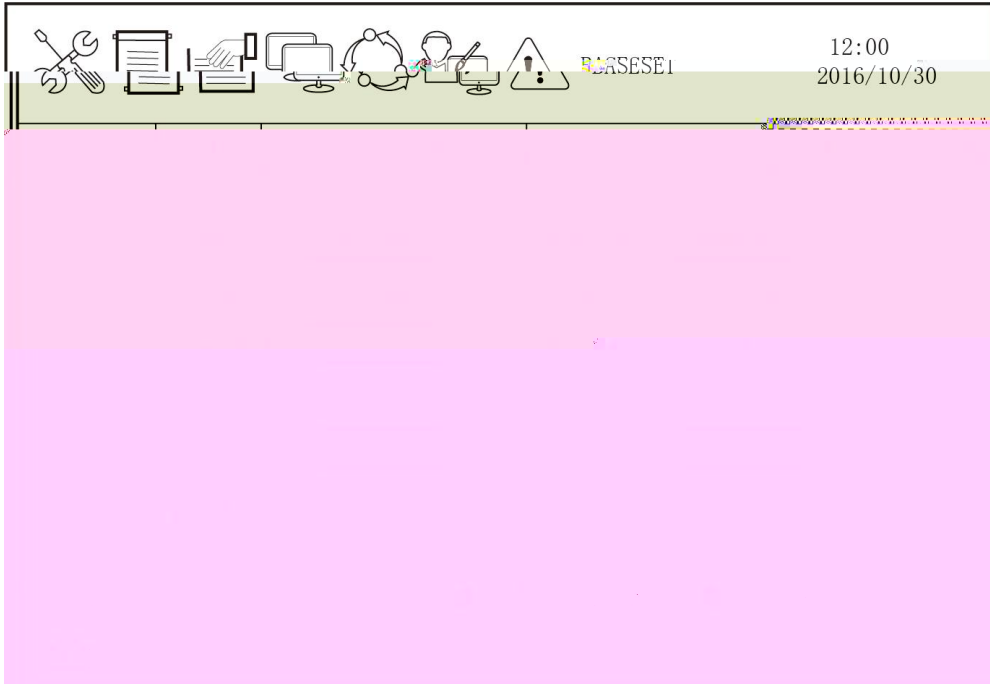
      		PASSWORD	
		12:00 2016/10/30	
OpenF	☐	SafeD	☒
ClosE	☒	Thimb	☐
			

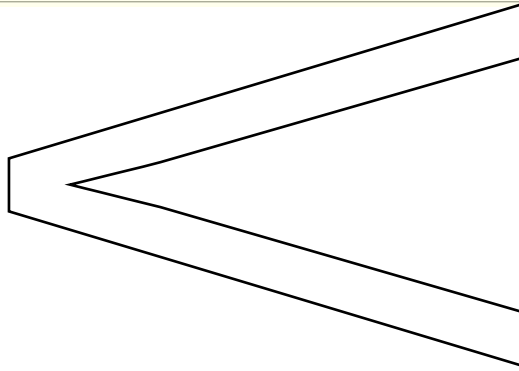
输入
ENTER

输入
ENTER

      		BASESET	
		12:00 2016/10/30	
Step	2/4	CurrM	21
		urrPos	0.0mm
CycleTime	600.0 s	StdyPros	Inside
InThim	Use	StopSafe	NoLockM
SafeDoor	Use	SubPutDe	0.5s
MidVold	Use	StartVoss	10.0 mm/s
StdbyGes	Verti	EmbInMld	Use
OpenF	☐	SafeD	☒
ClosE	☒	Thimb	☐
			

       BASESET				12:00 2016/10/30	
Steady	2/4	CurrM 21		urrPos	0.0mm
PointCnt	1	Reserv2	1		
Space	10.0mm	ChckPress	No Use		
ConvCnt	9	ChckDfPrd	No Use		
Reserv1	1	ChckCtRshld	No Use		
ClScrTim	10s	ClpAbDect	TravOut		
OpenF	☐	SafeD	☒	ClosE	☒
				Thimb	☐
					





BASESET

				BASESET		12:00 2016/10/30	
Stop	4/4	CurrM	21		urrPos	0.0mm	
OpenDAIar Conti ReservlTime 0.0 s ConveyOn 0.0 s StkClear ON testMould 0 StkDrt PSTV							
OpenF	☐	SafeD	☒	ClosE	☒	Thimb	☐
 n M — —							

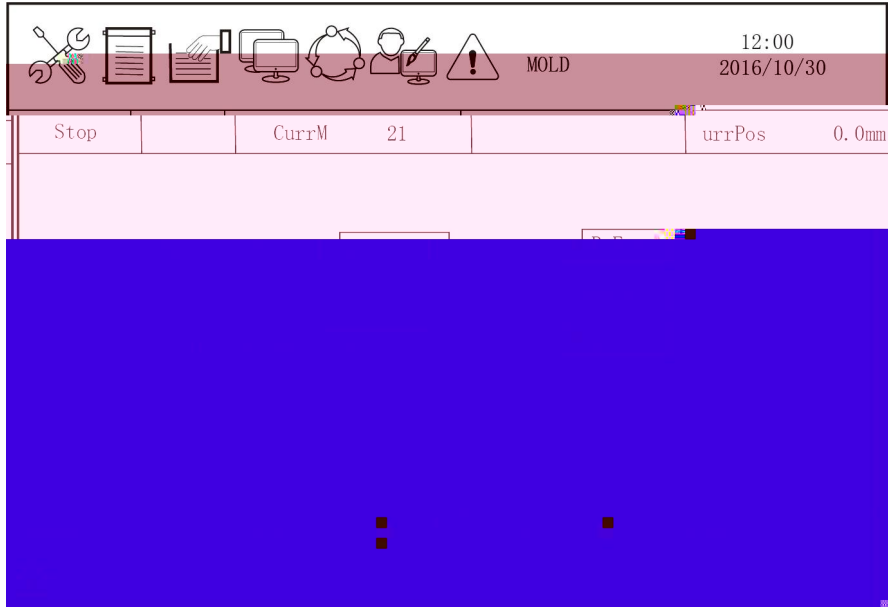


功能/同步
FUNC/SYN

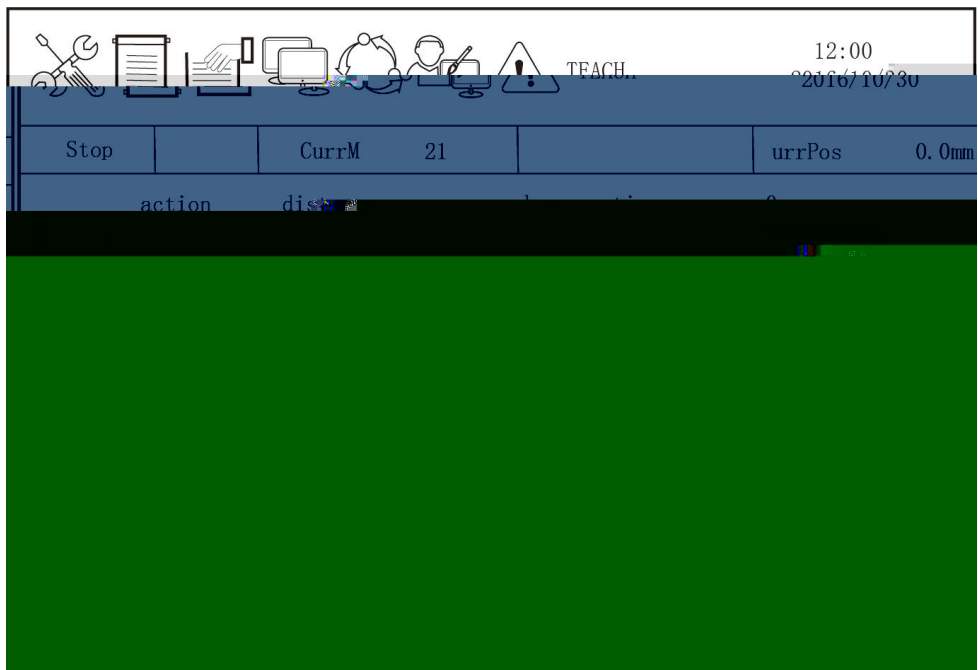
输入
ENTER

       ADMINSET				12:00 2016/10/30			
Step	1/2	CurrM	21		urrPos	0.0mm	
MaxPos	0.0 mm	FBPulseIn	1				
PrdrsrIn	500	FBPulseOut	1				
FeedBack	No Use	AlarmTime	10.00s				
DownGset	vert	actDefTime	0.300s				
ovrSpeed	20%	MaxSpeed	100 %				
		WholeSpeed	100%				
OpenF	☐	SafeD	☒	ClosE	☒	Thimb	☐

       ADMINSET 12:00 2016/10/30					
Stop	2/2	CurrM	21		urrPos 0.0mm
WaitSig Teach FixReverse No Use TravOutPre 0.0 TravInPre 0.0					
OpenF	☐	SafeD	☒	ClosE	☒
		Thimb	☐		
					



       MOLD				12:00 2016/10/30			
Stop		CurrM	21		urrPos	0.0mm	
Read (00-99) 21 ☐ ReFresh..							
Update							
Write (20-99) 21 Pop							
OpenF	☐	SafeD	☒	ClosE	☒	Thimb	☐
							



信息
IFOR

 INFO 12:00 2016/10/30																	
Stop		CurrM	21		urrPos 0.0mm												
<table><tr><td>NO.</td><td>Num</td><td>AlaemInfo</td></tr><tr><td>1</td><td>5004</td><td>Abnormal parameter setting</td></tr><tr><td>2</td><td>5004</td><td>Abnormal parameter setting</td></tr><tr><td>3</td><td>5004</td><td>Abnormal parameter setting</td></tr></table>						NO.	Num	AlaemInfo	1	5004	Abnormal parameter setting	2	5004	Abnormal parameter setting	3	5004	Abnormal parameter setting
NO.	Num	AlaemInfo															
1	5004	Abnormal parameter setting															
2	5004	Abnormal parameter setting															
3	5004	Abnormal parameter setting															

信息
IFOR

 INFO 12:00 2016/10/30																													
Stop		CurrM	21		urrPos 0.0mm																								
<table><thead><tr><th>NO.</th><th>MoldNum</th><th>CycleTime</th><th>s</th></tr></thead><tbody><tr><td>1</td><td>21</td><td>2.51</td><td></td></tr><tr><td>2</td><td>21</td><td>2.51</td><td></td></tr><tr><td>3</td><td>21</td><td>2.51</td><td></td></tr><tr><td>4</td><td>21</td><td>2.51</td><td></td></tr><tr><td>5</td><td>21</td><td>2.51</td><td></td></tr></tbody></table>						NO.	MoldNum	CycleTime	s	1	21	2.51		2	21	2.51		3	21	2.51		4	21	2.51		5	21	2.51	
NO.	MoldNum	CycleTime	s																										
1	21	2.51																											
2	21	2.51																											
3	21	2.51																											
4	21	2.51																											
5	21	2.51																											
OpenF	☐	SafeD	☒	ClosE	☒																								
 Thimb ☐																													





12:00
2016/10/30

Stop

1/2

CurrM

21

urrPos

0.0mm

● X10 Unfor ● X11 Verti ● X12 MainFin ● X13 Hold ● X14 ViceForw ● X15 ViceBack ● X16 ViceUp ● X17 MainDown	● V20 Preserve ● X21 Injection ● X22 CheckPress ● X23 InSafe ● V24 OutSafe ● X26 TravInLim ● X27 TravOutLim
---	---







12:00
2016/10/30

Stop

2/2

CurrM

21

urrPos

0.0mm

● X30 ViceForw ● X31 ViceBack ● X32 SubUp ● X33 ViceDown ● X34 SafeDoor ● X35 MainUp ● X36 Proecssl ● X37 Reserv2	● SafeDoor ● OpenFini ● CloFini ● DefProd ● V25 AdoLim ● V26 WithMoId ● Thimble ● EmergStop
--	--





☐ SafeD

☒ ClosE

☐ Thimb

☐ Oper





MONITOR
12:00
2016/10/30

Stop	1/2	CurrM	21		urrPos	0.0mm
● Y10 Hori ● Y11 Verti ● Y12 MainFix ● Y13 Hold ● Y14 Vacuum ● Y15 MainForw ● Y20 MainUp ● Y21 MainDown ● Y22 LowPress ● Y23 SlowDown ● Y24 Reserv1 ● Y25 Reserv2						
● Y16 MainBack ● Y17 Alarm ● Y26 TravIn ● Y27 TravOut						
OpenF	☐	Safed	☒	ClosE	☒	Thimb ☐





MONITOR
12:00
2016/10/30

2/2	CurrM	21	Y25	urrPos	0.0mm	Open	Stop
Y30 SubForw		Y47 EmergStop					
Y31 SubBack		CloseSafe					
Y32 SubUp		OpenSafe					
Y33 SubDown		Recycling					
Y34 SubFix		ThimSafe					
Y35 Process1		YReserv1					
Y36 Scissor		YReserv3					
Y37 Coneryor		YReserv2					
☐	Safed	☒	ClosE	☒	Thimb	☐	OpenF







12:00
2016/10/30

MONITOR

Stop		CurrM	21		urrPos	0.0mm
	MotorSpd	0		Voltage	0.0	
	Pos	0			0.0	

Open



SafeD



Close



thimb





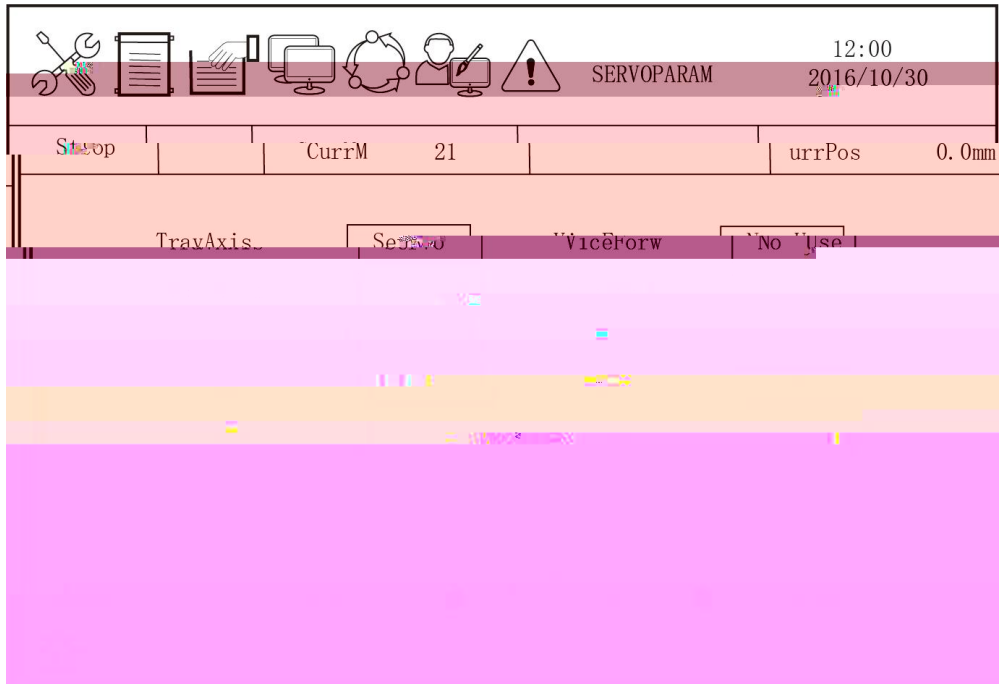
功能/同步
FUNC/SYN

输入
ENTER

       LIMIT				12:00 2016/10/30		
Stop		CurrM	21		urrPos	0.0mm
MainUpDn		5.0s	Trav		5.0s	
MainForwBk		5.0s	Posture		5.0s	
ViceUpDown		5.0s	Process1		5.0s	
ViceForwBk		5.0s	Reversed2		5.0s	

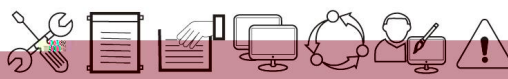
功能/同步
FUNC/SYN

输入
ENTER



功能/同步
FUNC/SYN

输入
ENTER

				SERVOPARAM		12:00 2016/10/30	
Stop		CurrM	21		urrPos	0.0mm	
SpdLoopGain 180 SpdLoopInt 50 PosLoopGain 4 RotInertiaRa 200 ServoDir 1							
OpenF	☐	SafeD	☒	ClosE	☒	Thimb	☐
							

功能/同步
FUNC/SYN

输入
ENTER





SERVOPARAM

12:00
2016/10/30

	CurrM	21		urrPos	0.0mm	Stop
--	-------	----	--	--------	-------	------

ParamSetting

0

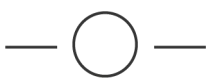
SeValue

0

Base Function Selet 0:CWW default: 1000



u R Y;) Ÿ P • 'B!% 6



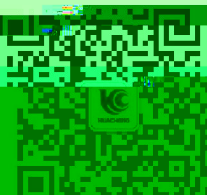
[illegible]



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