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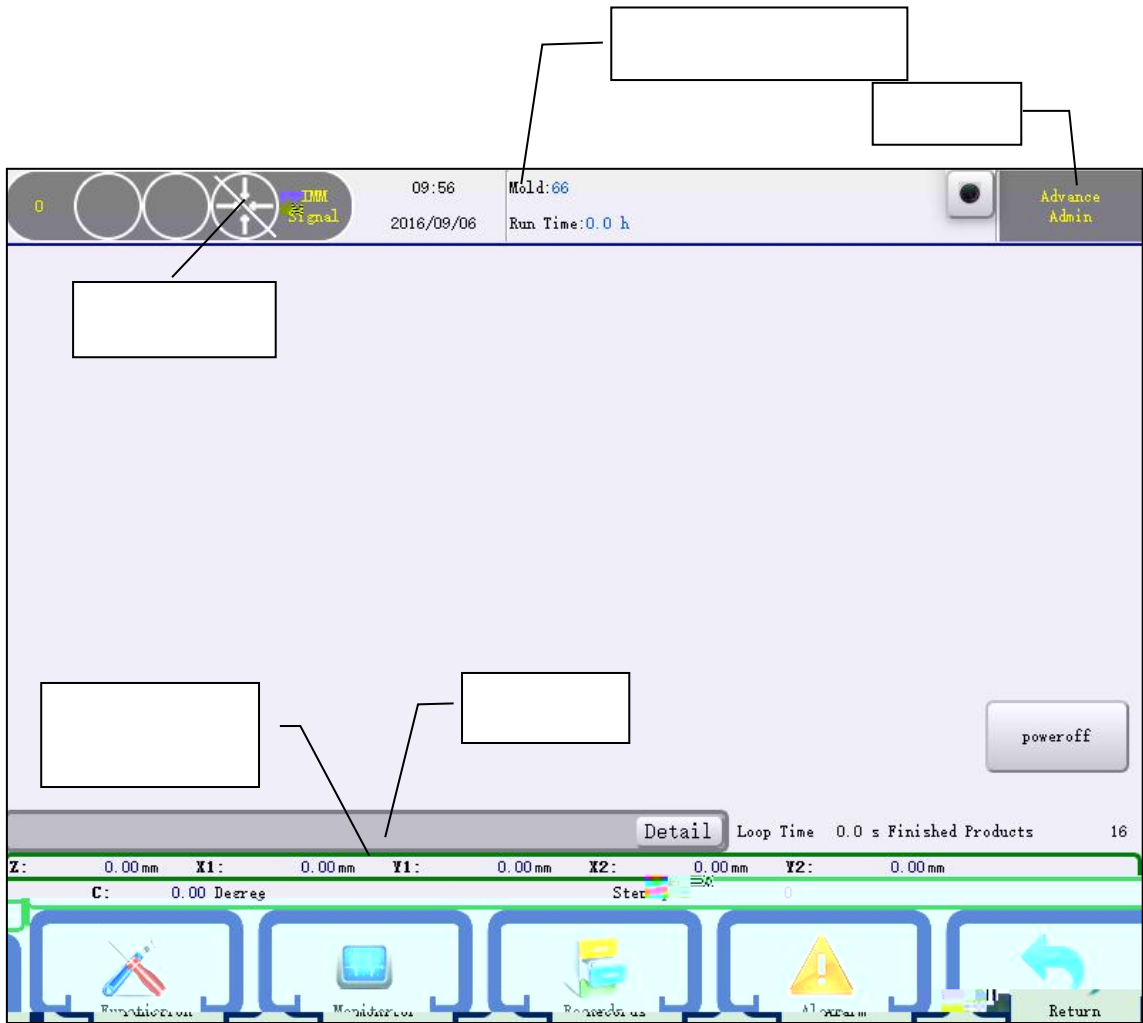
[illegible]



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Y1- \_\_\_\_\_

Y1+ \_\_\_\_\_

Y2- \_\_\_\_\_

Y2+

X1-

X1+

X2-

X2+

C+

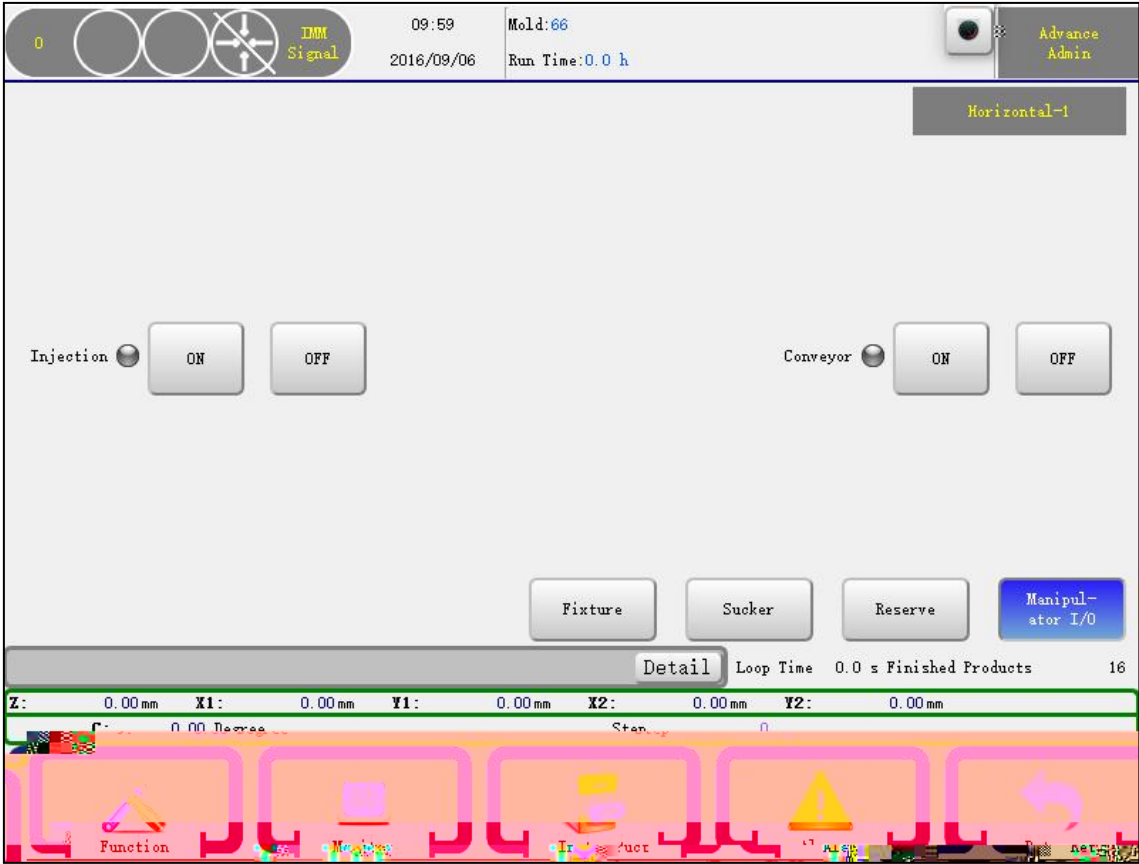
C-

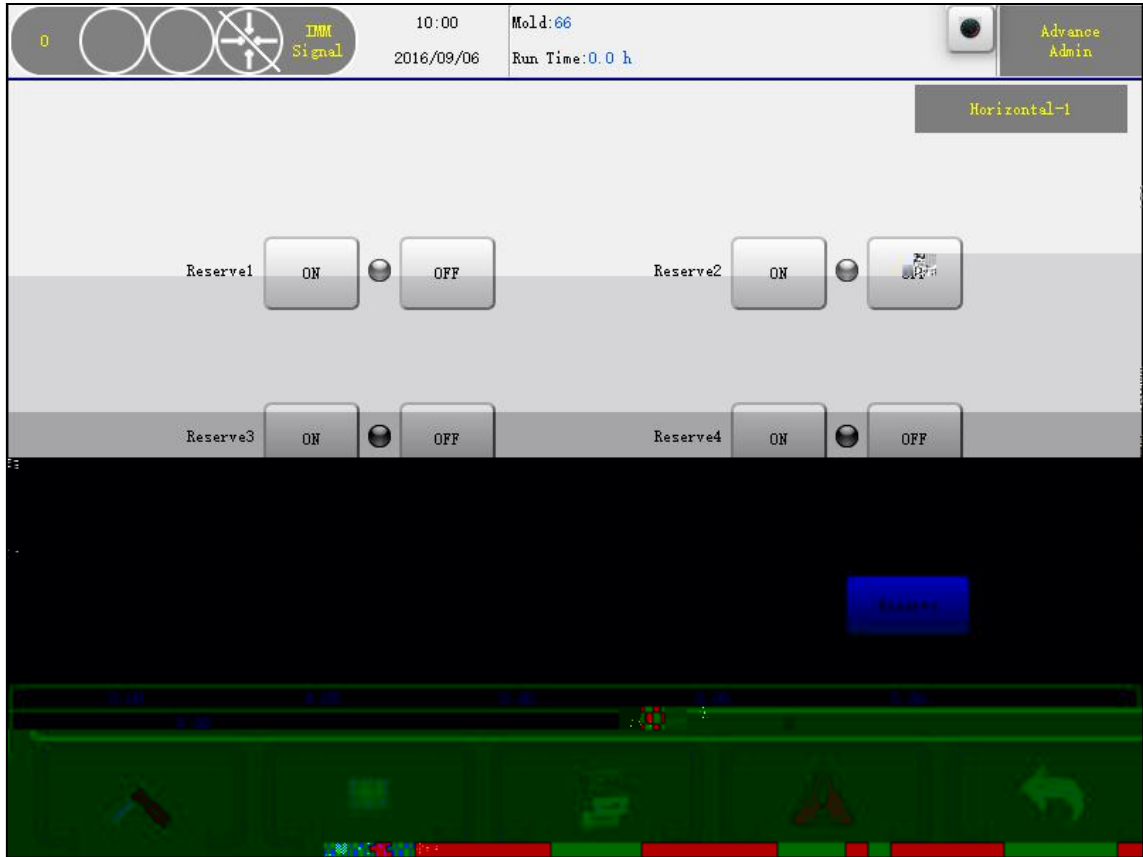
Z -

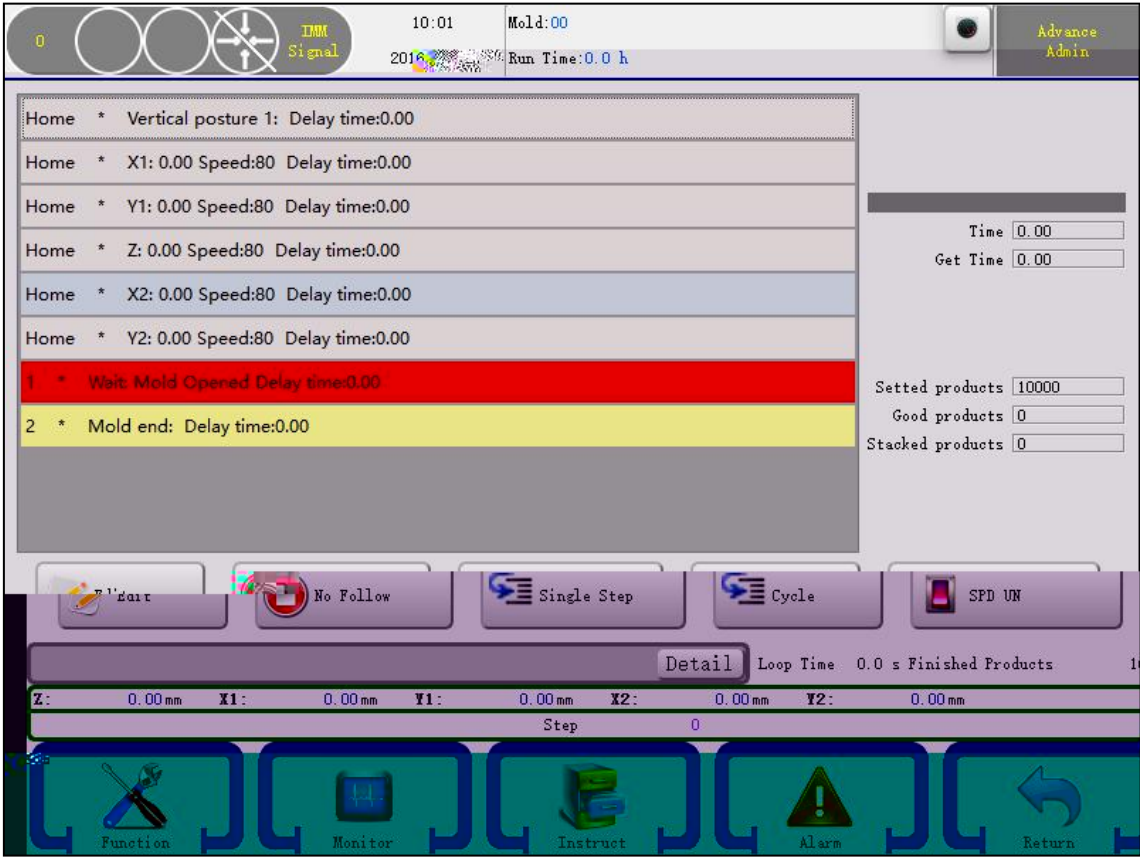
Z +













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2 \* X1: 0.00 Speed:80 Delay  
time:0.00

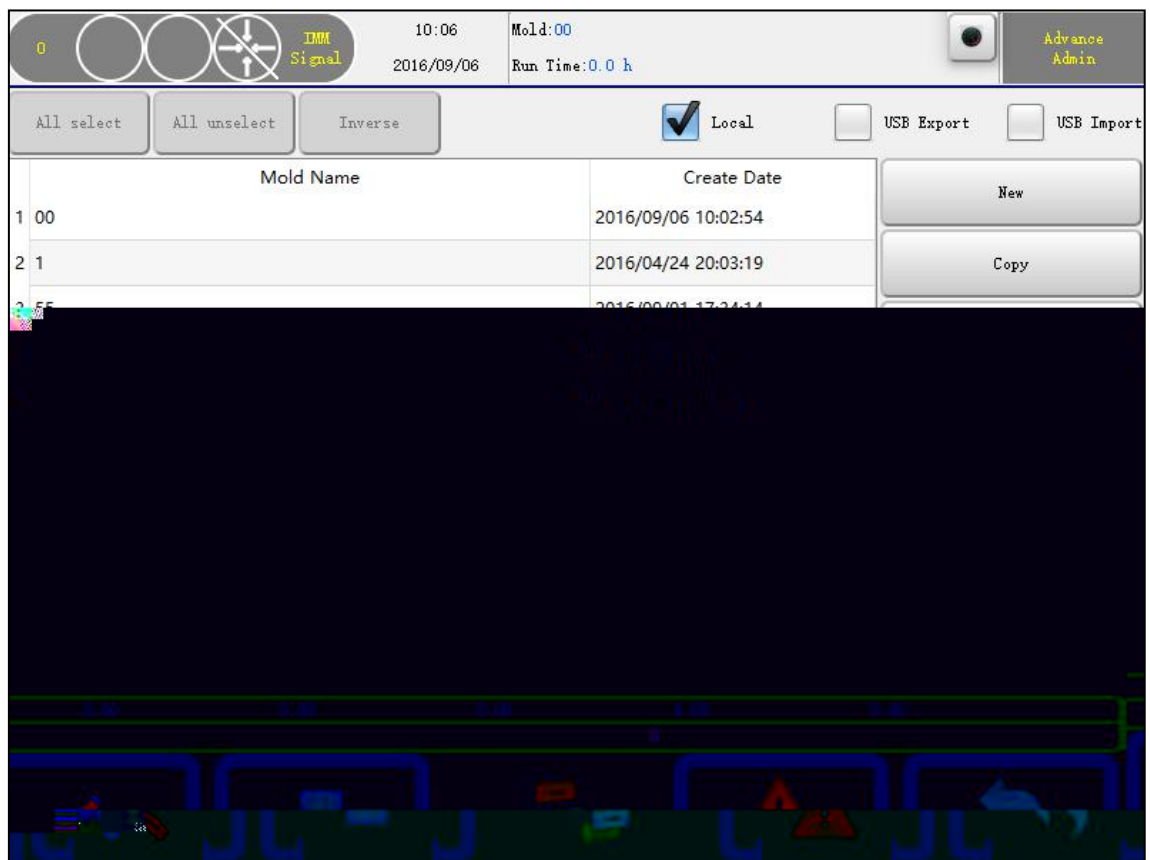
Delay Time: 0.00 s

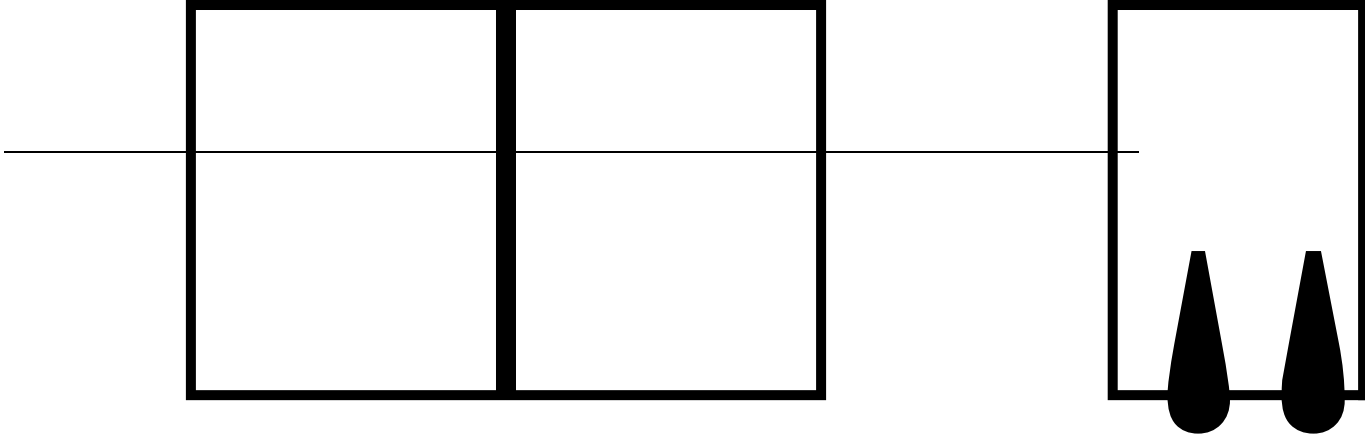
Speed: 80 %

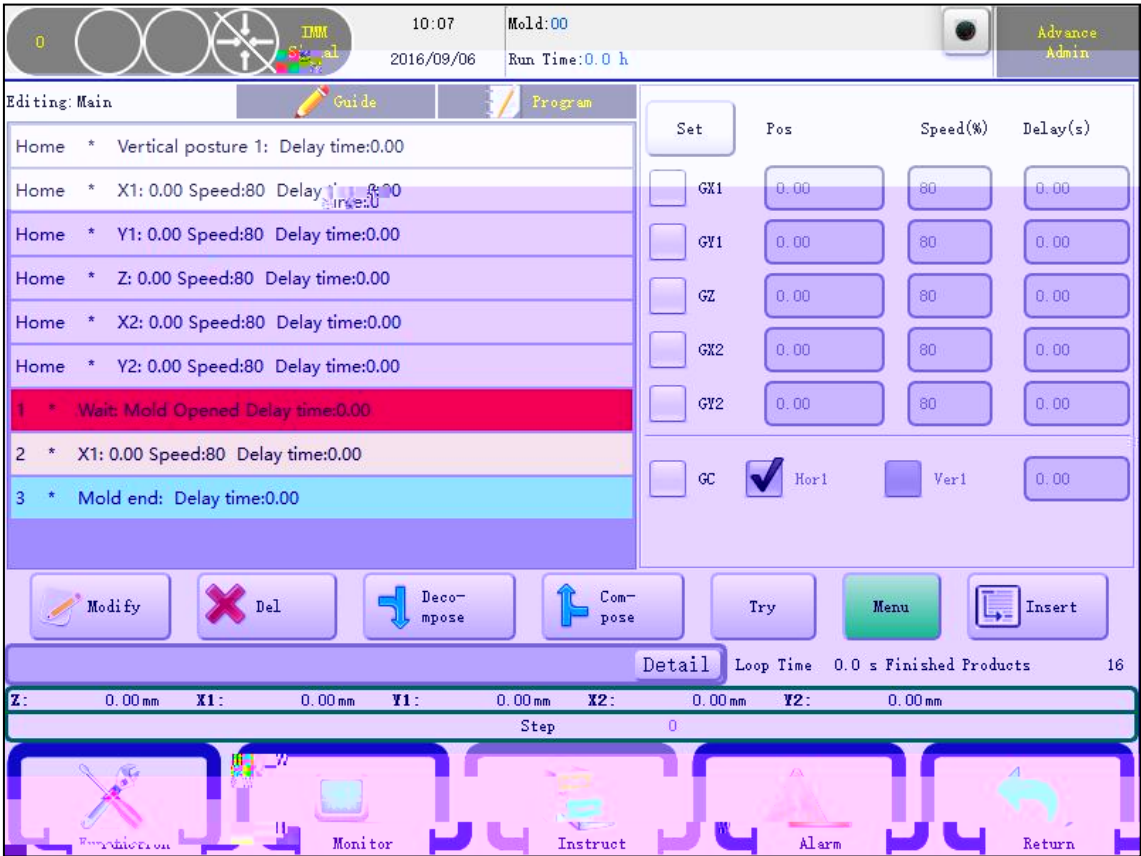
Pos(+/-5): 0.0 mm

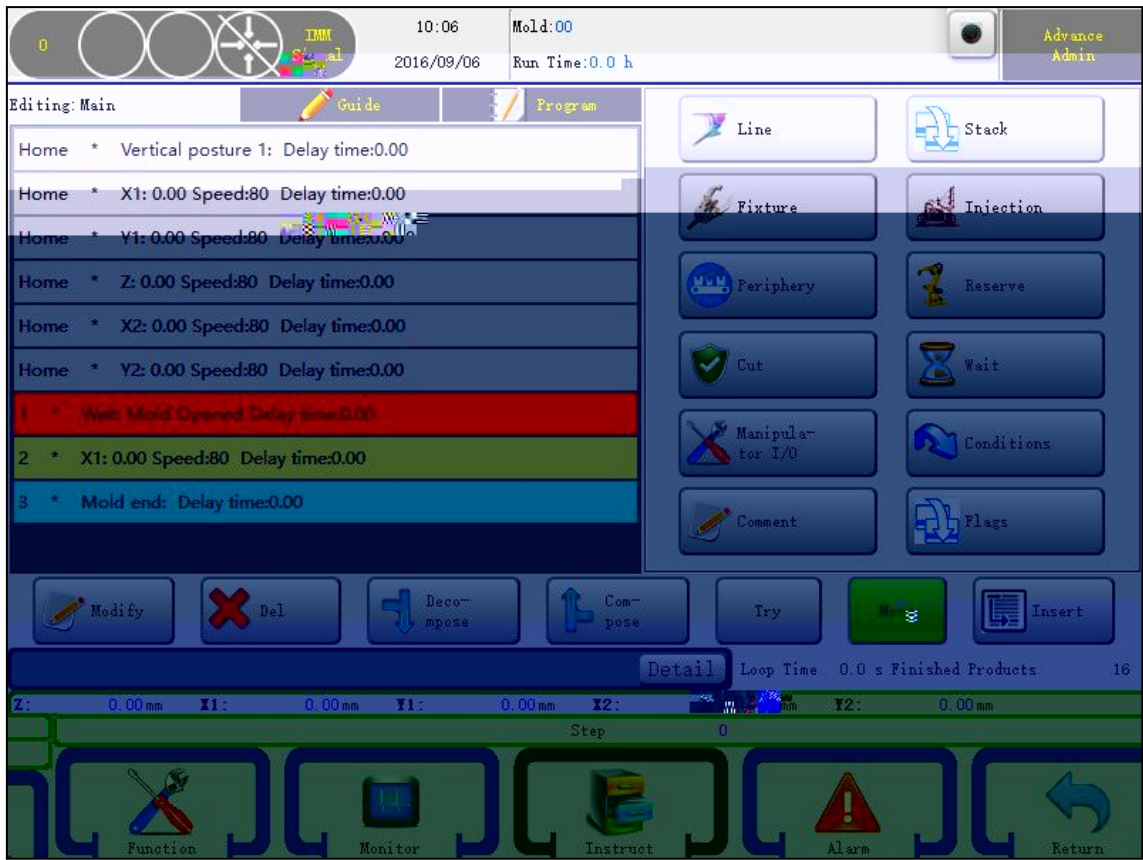
OK

Cancel









0

IMM  
Signal

10:09  
2016/09/06

Mold:00  
Run Time:0.0 h

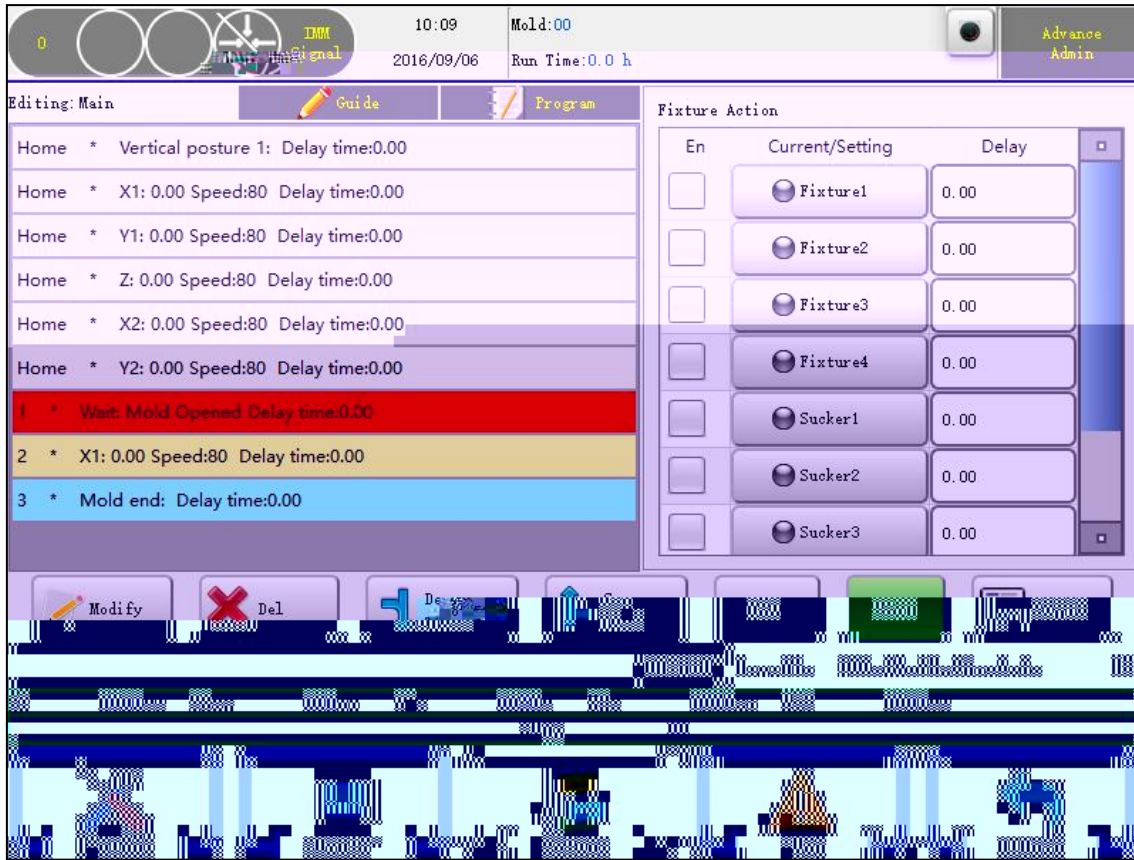
Advance  
Admin

Editing: Main

Guide

Program

		Seq	S:Pos	Num	Step
Home * Vertical posture 1: Delay time:0.00	<input type="checkbox"/> Group-1	X->Z->Y	X: P	2	10.00
			Y: RP	2	10.00
			Z: P	2	10.00
Home * X1: 0.00 Speed:80 Delay time:0.00	<input type="checkbox"/> Group-2	X->Z->Y	X: P	3	10.00
			Y: RP	3	10.00
			Z: P	3	10.00
Home * Y1: 0.00 Speed:80 Delay time:0.00	<input type="checkbox"/> Group-3	X->Z->Y	X: P	4	5.00
			Y: RP	4	5.00
			Z: P	4	5.00
Home * Z: 0.00 Speed:80 Delay time:0.00	<input type="checkbox"/> Group-4	X->Z->Y	X: P	5	

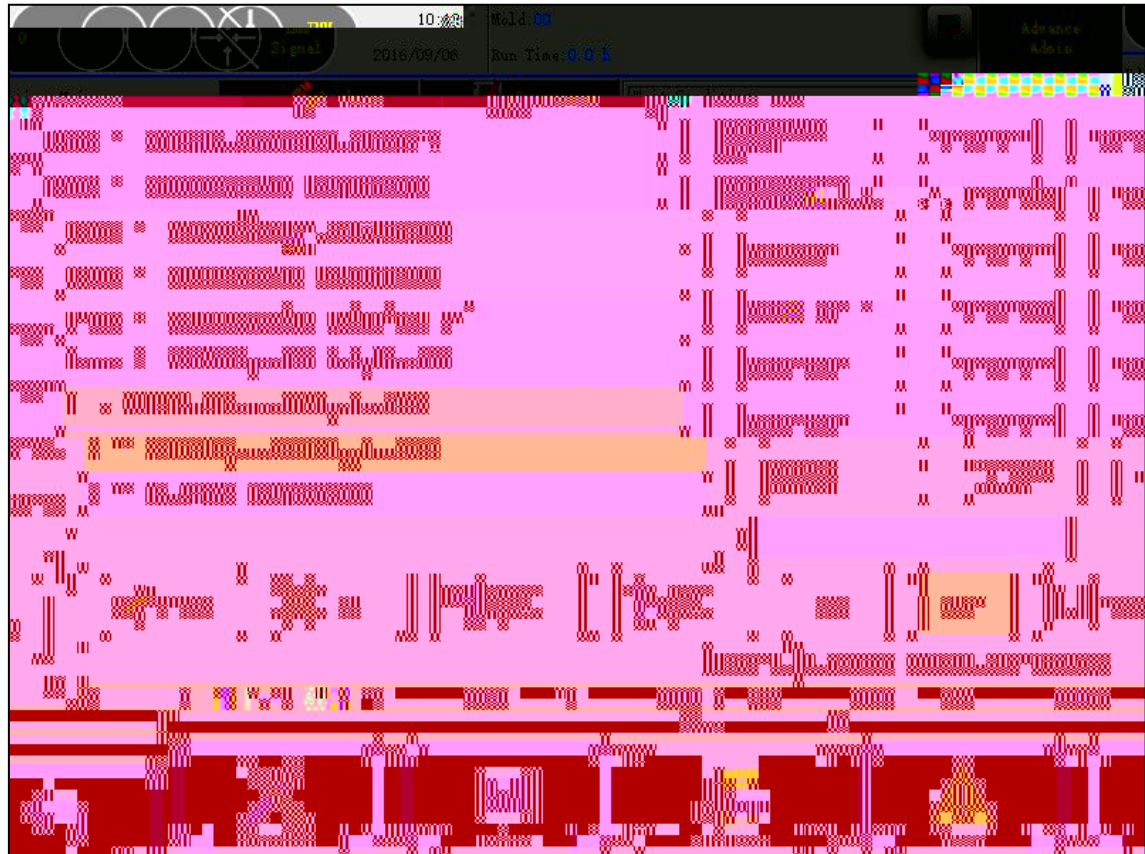


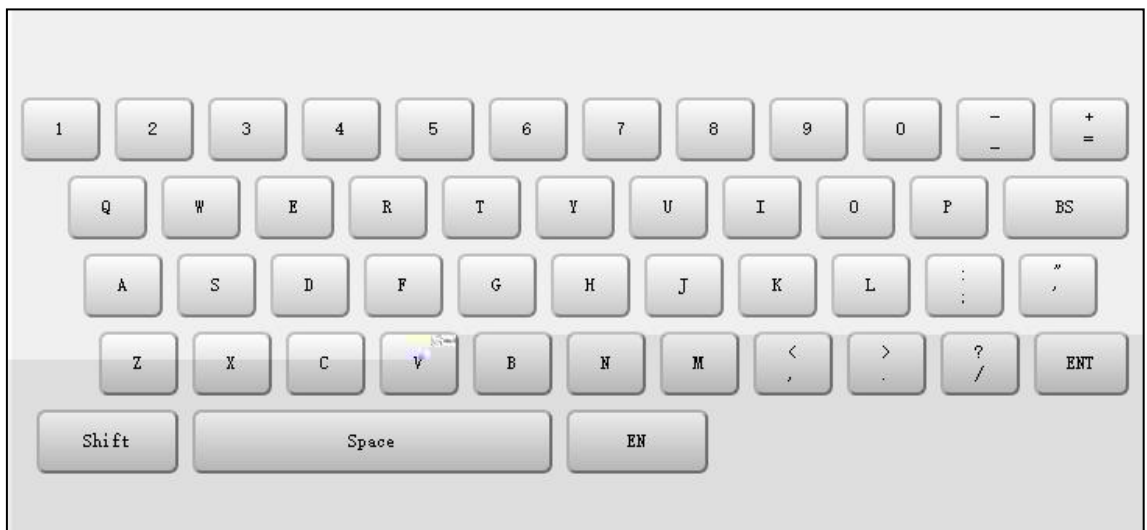
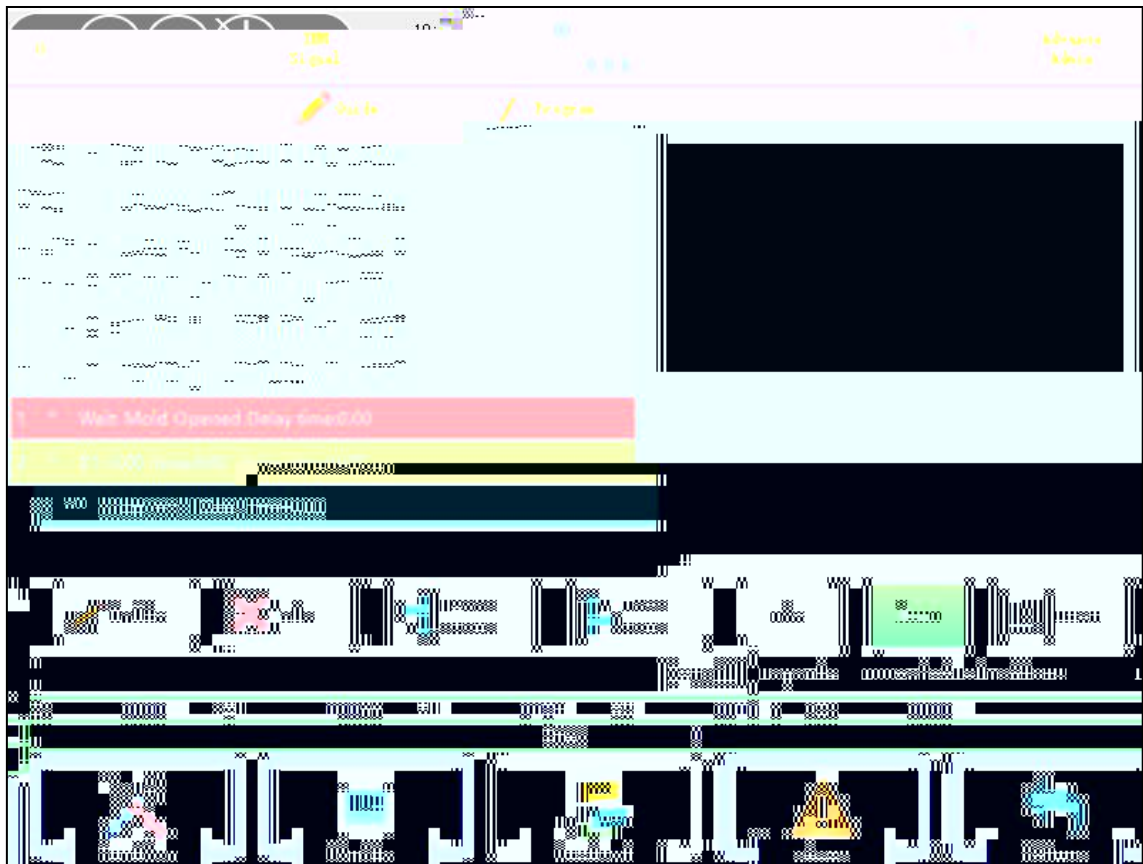


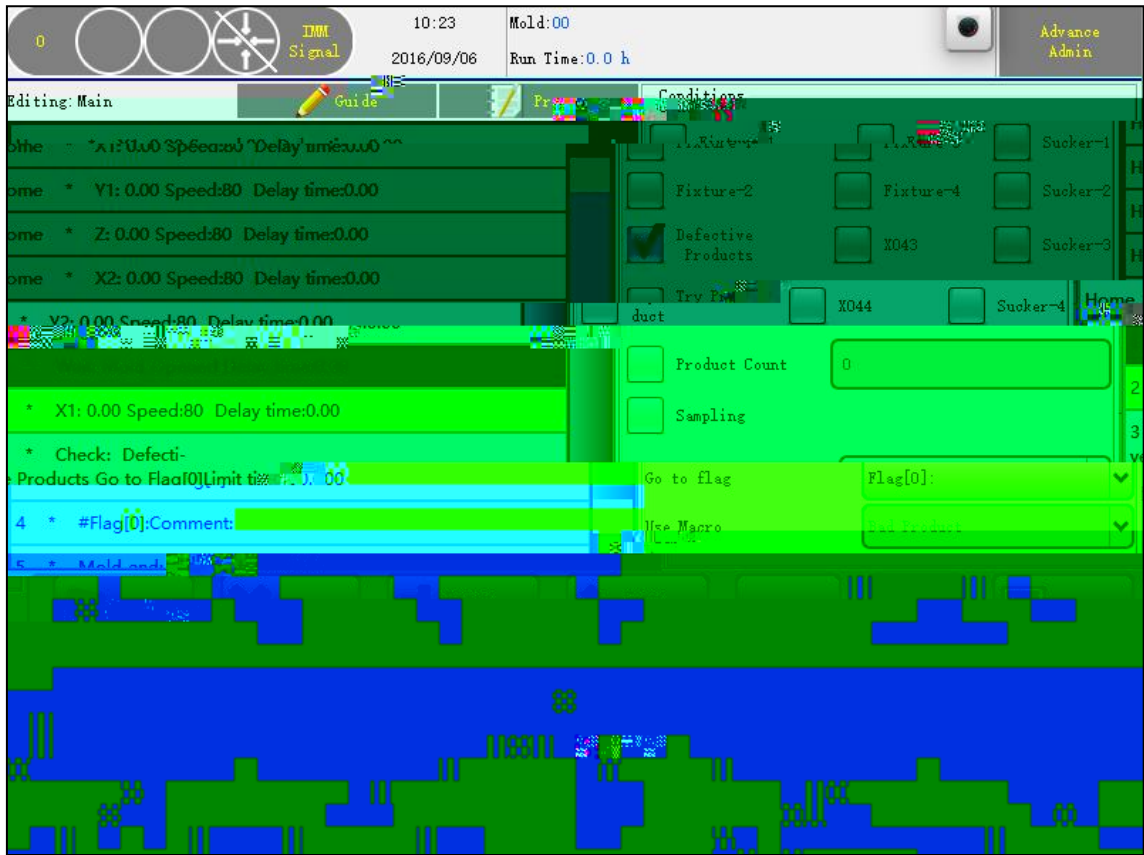












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Set

Position  mm

speed  %

Delay Time  s

☐ Early End

☐ Early Speed-Down  %

End Position  mm

OK Cancel

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IMM  
Signal


10:28  
2016/09/06


Mold:00  
Run Time:0.0h





Advance  
Admin


Signal Settings


Product Settings


Machine Configure

Security Point Settings

Stack Settings

System Settings

Struct Settings


Maintains


Detail


Loop Time 0.0 s Finished Products 16


Z: 0.00 mm X1: 0.00 mm Y1: 0.00 mm X2: 0.00 mm Y2: 0.00 mm


Step 0

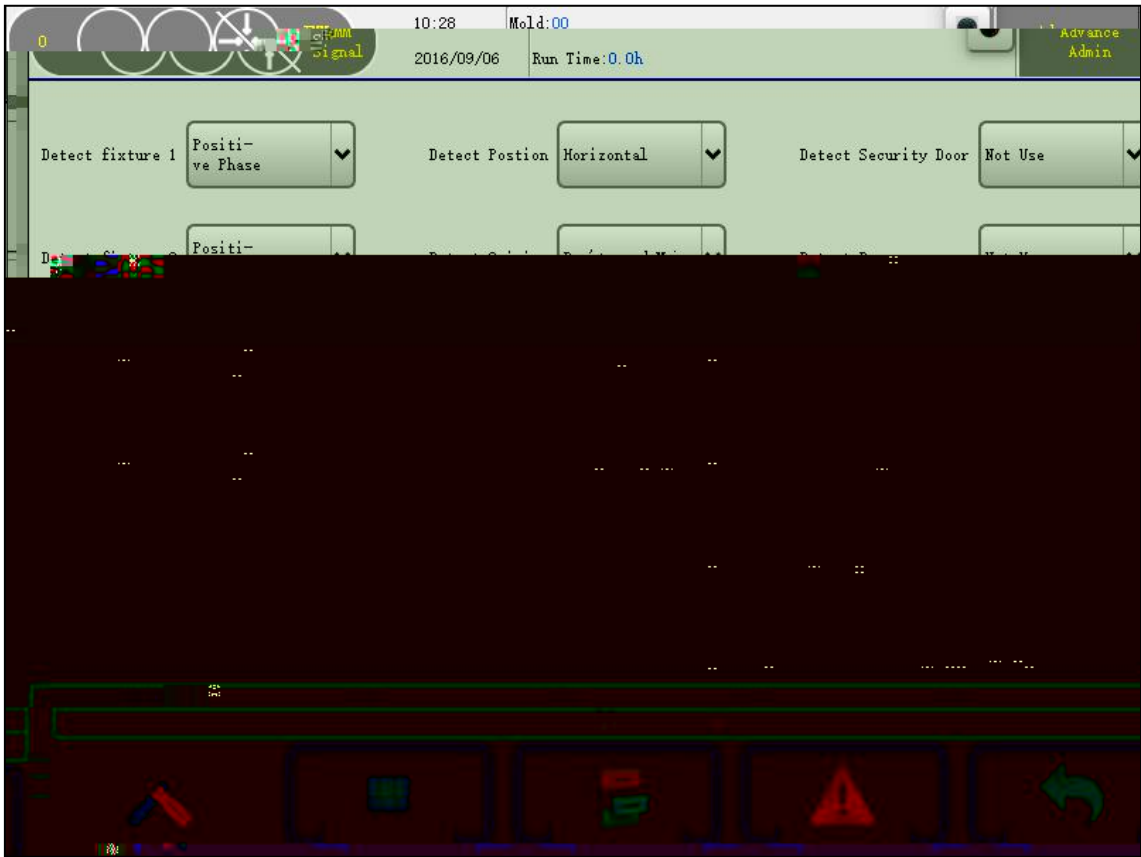
Function

Monitor

Record

Alarm

Return



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IMM  
Signal

10:29  
2016/09/06

Mold:00  
Run Time:0.0h

Advance  
Admin

Product

10000

Wait Mold Opened  
Limit Time

65.9

s

TryProduct

0

Alarm Times

30

s

Sampling Interval

0

Recycle Time

0.0

s

Fixture

☒ Positive Phase

☐ Reverse Phase

Get Fail

Alarm When Up

▼

Count Ways

All

▼

☐ Product Save

Product Clear

Detail

Loop Time

0.0 s

Finished Products

16

Z:

0.00 mm

X1:

0.00 mm

Y1:

0.00 mm

X2:

0.00 mm

Y2:

0.00 mm

Step

0

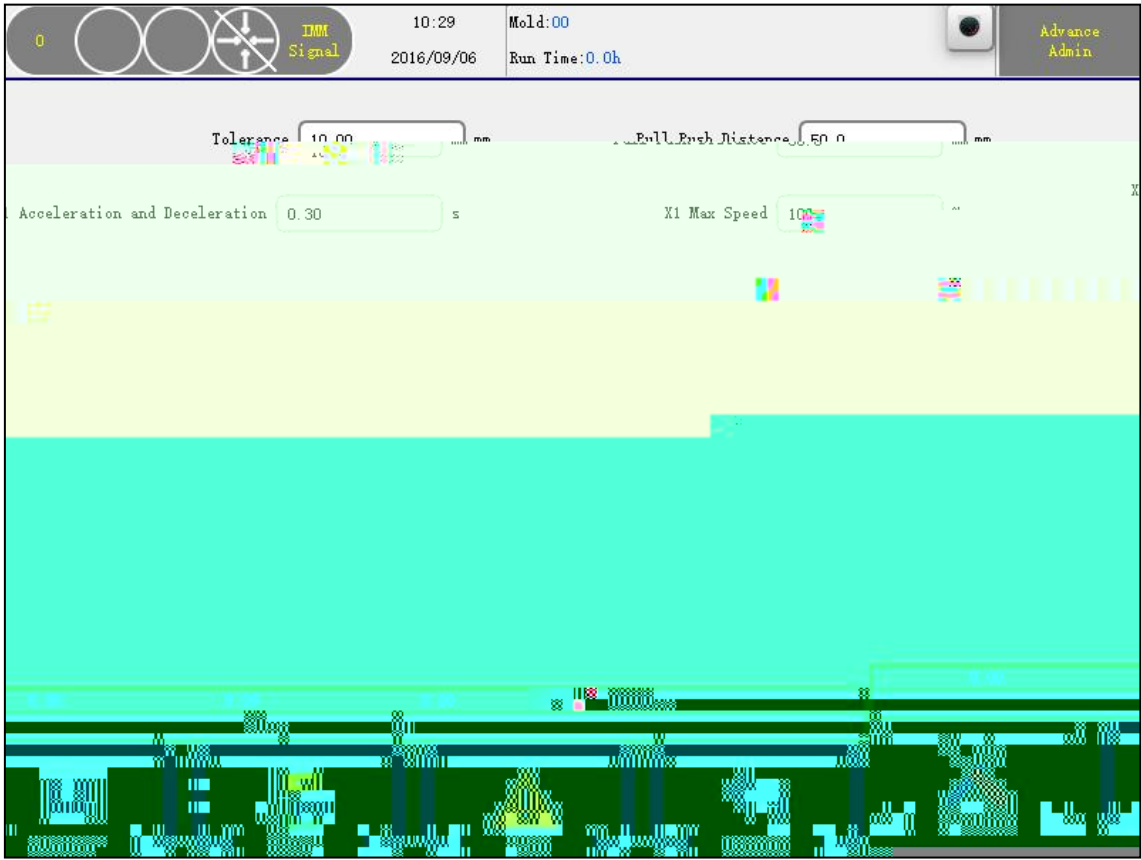
Function

Monitor

Record

Alarm

Return



0

10:31  
2016/09/06

Mold:00  
Run Time:0.0h

Advance  
Admin

X1 Axis

Y1 Axis

Z Axis

X2 Axis

Y2 Axis

C Axis

Figure

Security Point

Maximum displacement400.0mm

Min pos inside mold0.0mm

Max pos inside mold400.0mm

Save

Test Feedback

Test0

Feedback0

Z Signal0

+Test

-Test

Clear

Detail

Loop Time0.0 s Finished Products16

Z:0.00mm

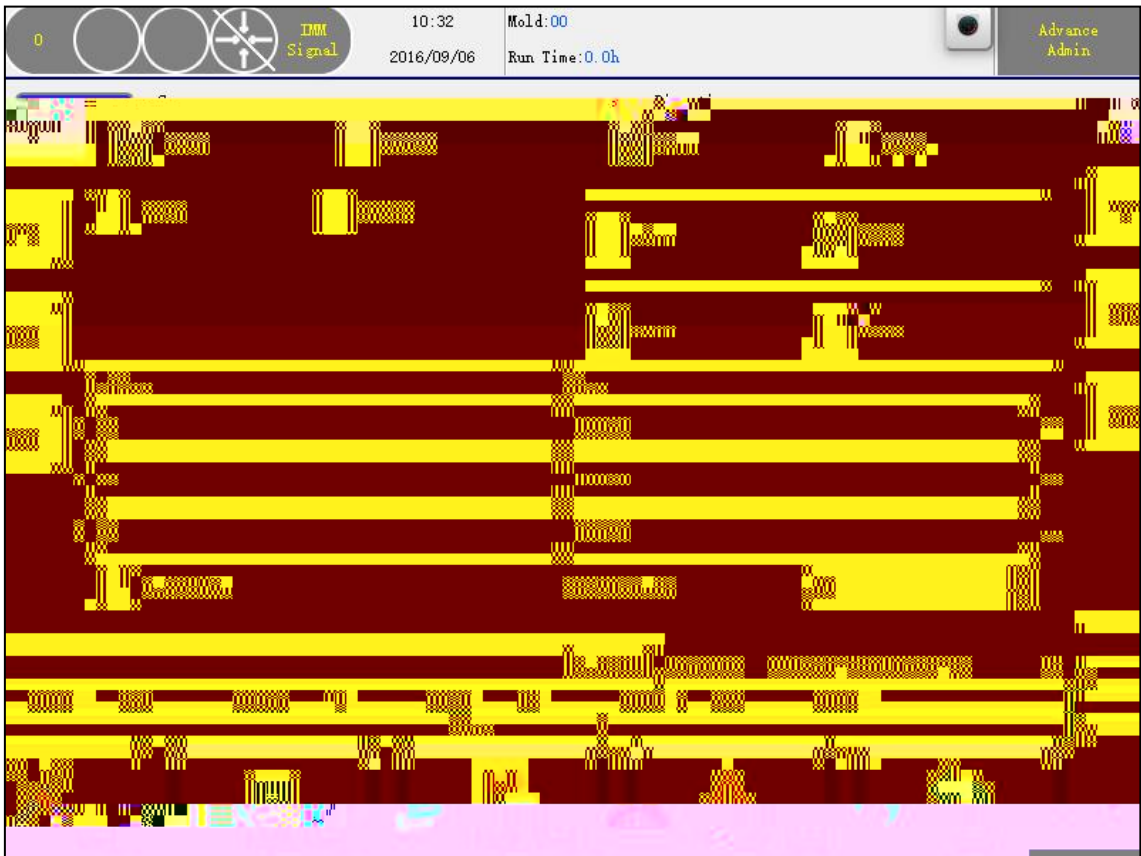
X1:0.00mm

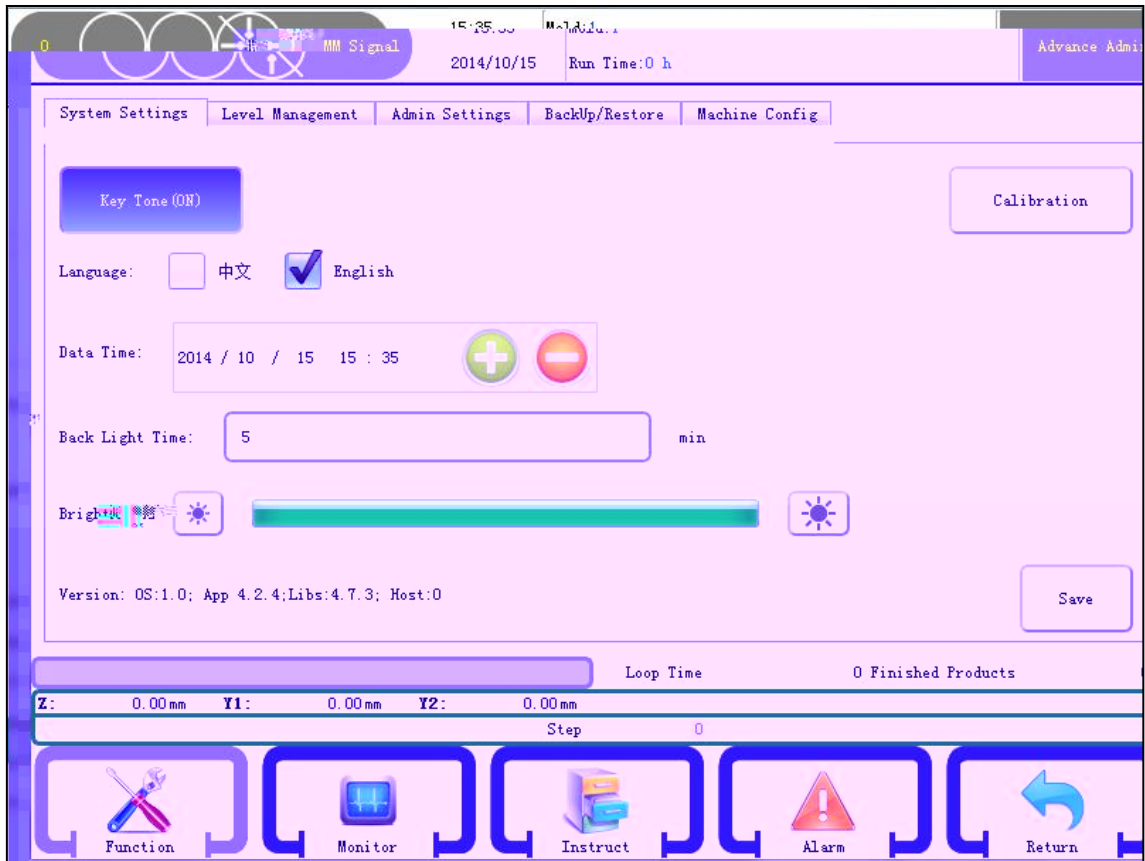
Y1:0.00mm

X2:0.00mm

Y2:0.00mm

Step0











0

10MM  
Signal

10:36  
2016/09/06

Mold:00  
Run Time:0.0h

Advance  
Admin

X1 AxisY1 AxisZ AxisX2 AxisY2 AxisC AxisStruct DefineTime

Security Point

Mechanical length500.0mm

Maximum displacement400.0mm

Min pos inside mold0.0mm

Max pos inside mold400.0mm

Distance/Rotation20.00mm

Save

Test Feedback

Test0

Feedback0

Z Signal0

+Test-TestClear

Detail

Loop Time 0.0 s Finished Products 1

Z: 0.00mmX1: 0.00mmY1: 0.00mmX2: 0.00mmY2: 0.00mm

Step 0

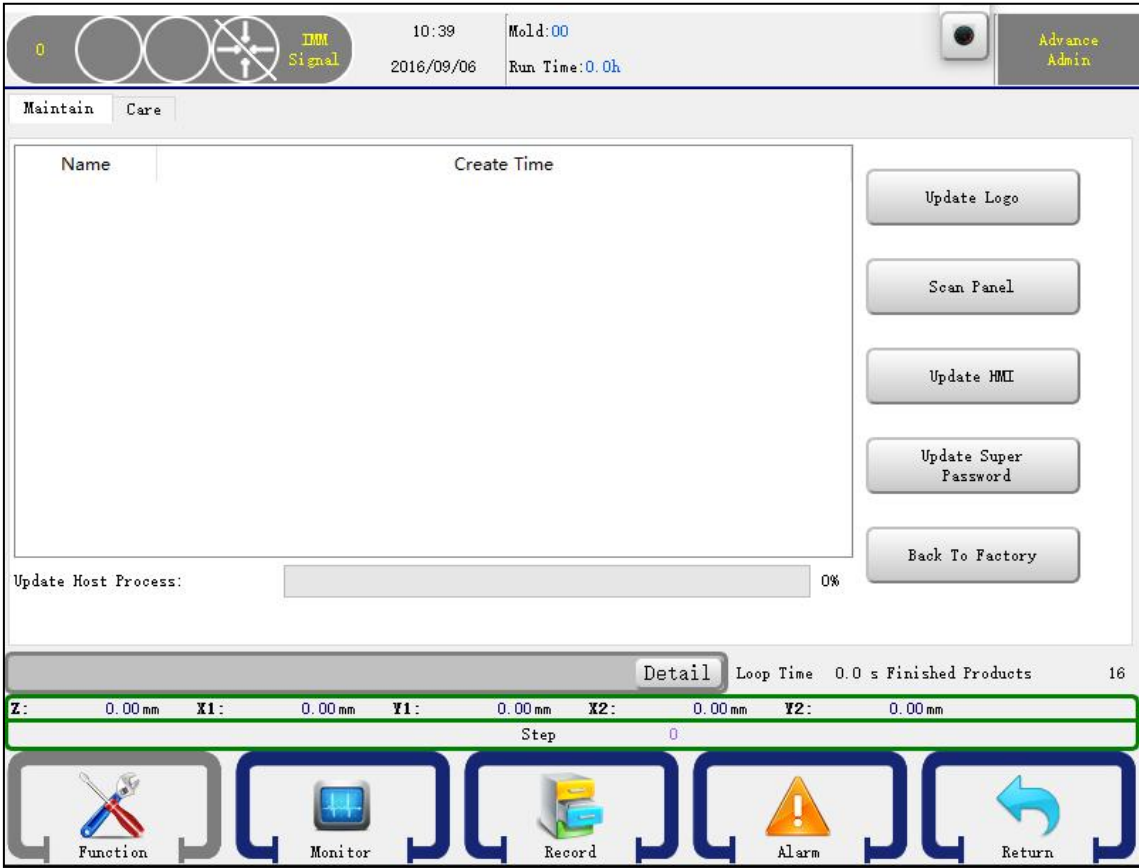
Function

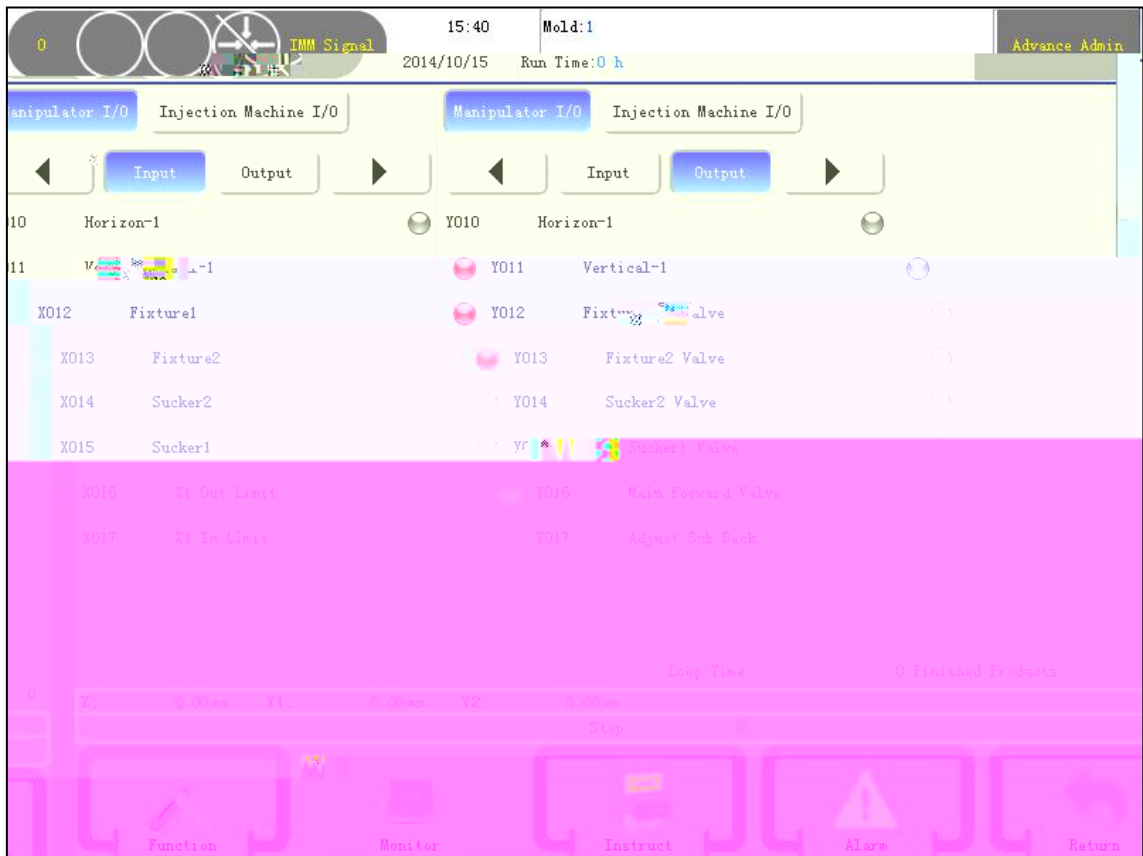
Monitor

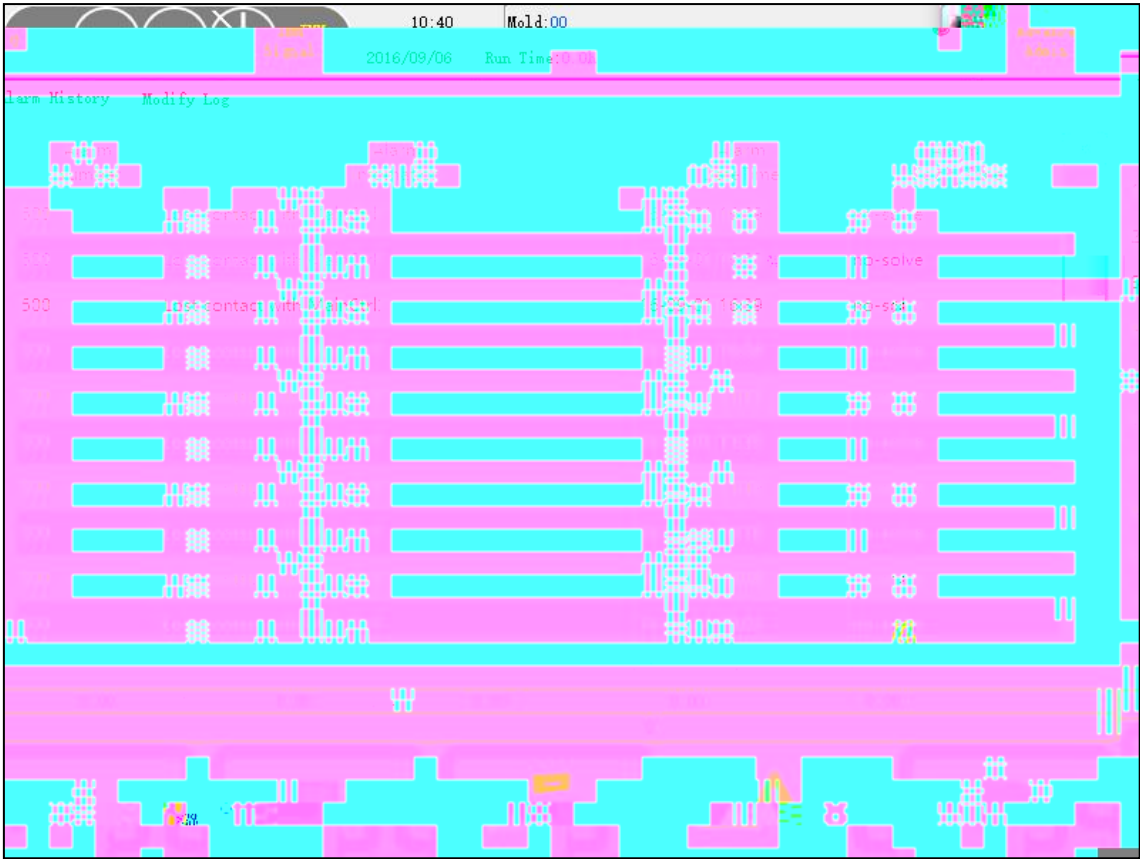
Record

Alarm

Return







Alarm ID: 500

Alarm Text:

Alarm Reason:

Alarm Solution:

Close

0

IHM  
Signal

10:45  
2016/09/06

Mold:00  
Run Time:0.0h

Machine  
Operator

Alarm History

Modify Log

Log

1	16-09-06 10:45:35	kCS_User_Changed[1]	from	NoneLevel to Machine
2	16-09-06 10:42:56	kCS_STRUCT_Config_Save[528]	Save	
3	16-09-06 10:42:53	kCS_STRUCT_Axis_Define_C[508]	from	Pneumatic to None
4	16-09-06 10:02:01	kCS_Mold_Changed[2]	from	66 to 00
5	16-09-06 10:01:46	kCS_STRUCT_Config_Save[528]	Save	
6	16-09-06 10:01:44	kCS_STRUCT_Axis_Define_C[508]	from	Servo to Pneumatic
7	16-09-06 09:59:00	kCS_STRUCT_Other_Define_Tune_bit[525]	from	Use to No Use
8	16-09-01 17:41:43	kCS_PANEL_Language[903]	from	中文 to English
9	16-09-01 17:40:57	kCS_PANEL_Language[903]	from	English to 中文
10	16-09-01 17:40:48	kCS_Mold_Changed[2]	from	66 to 00

Detail

Loop Time 0.0 s

Finished Products

Z:

0.00 mm

X1:

0.00 mm

Y1:

0.00 mm

X2:

0.00 mm

Y2:

0.00 mm

Step


Function

Monitor

Record

Alarm




Return

22	-	
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2	00	- 100
0	00	- 100
1	00	- 100
2	00	- 100
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1000	<div>1. ,</div> <div>2. 1 , 1 - - ( )</div>	<div>1.</div> <div>2. , -</div>
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1002	<div>1. 1 , 1 - ,</div> <div>2. , , ( - )</div>	<div>1.</div> <div>2.</div>

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<div>102</div> <div>-</div>		<div>1.</div> <div>-</div> <div>2.</div> <div>,</div> <div>-</div> <div>-</div>
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<p>11 1 1</p> <p>,</p>	<p>1.</p> <p>,</p> <p>–</p> <p>,</p> <p>1</p> <p>2.</p> <p>,</p> <p>–</p> <p>,</p> <p>1 /</p> <p>3.</p> <p>,</p> <p>–</p> <p>,</p> <p>1 /</p>	
<p>11 2 1</p> <p>,</p>	<p>,</p> <p>,</p>	

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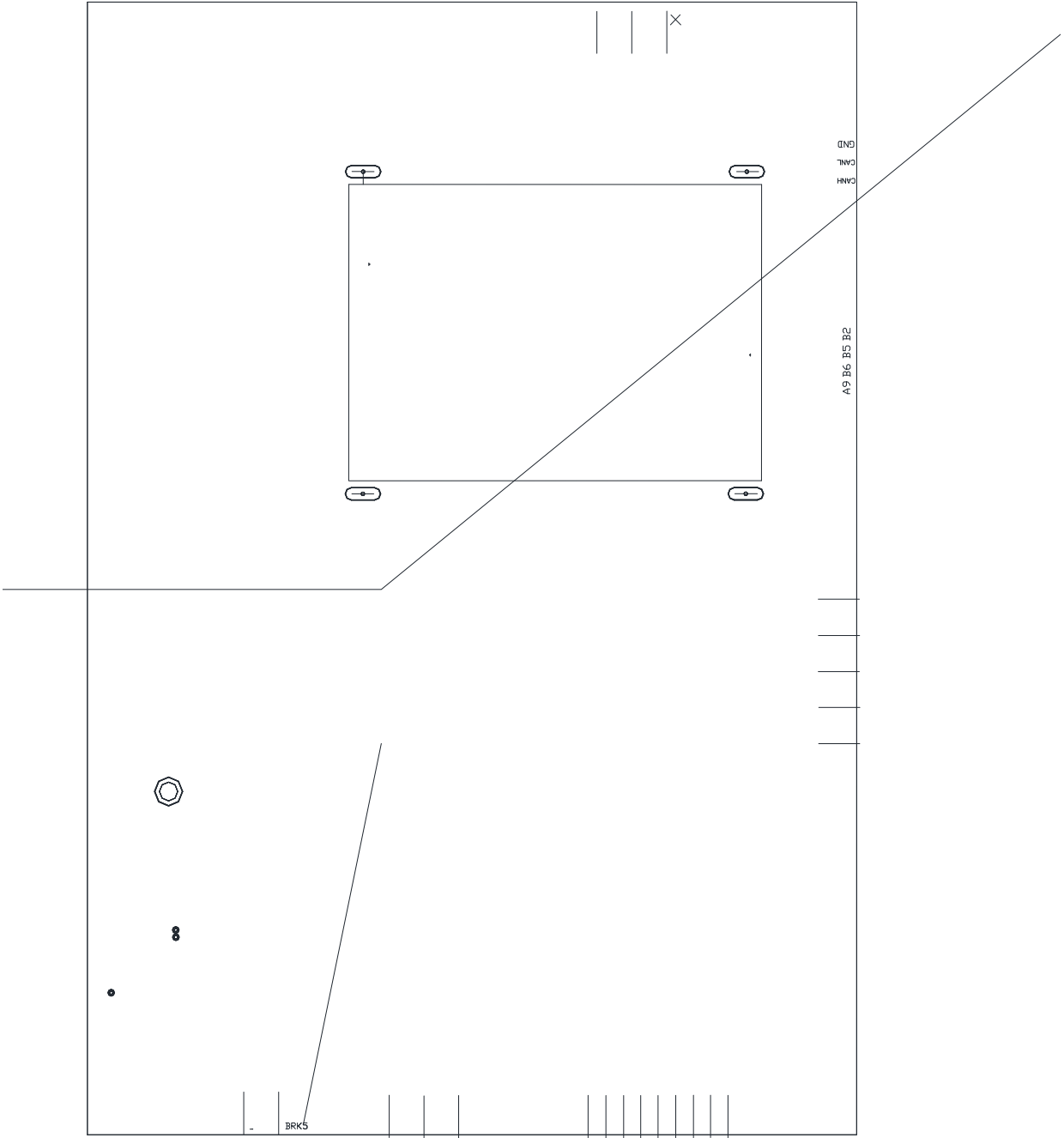
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11 0 ,	, ,	
11 1 – ,	– , 1	1.  2. 0 0 0
11 2	, ,	–
11 3	,	
1200 1 , 1	1.  2.	
1201 1 , 1	,	

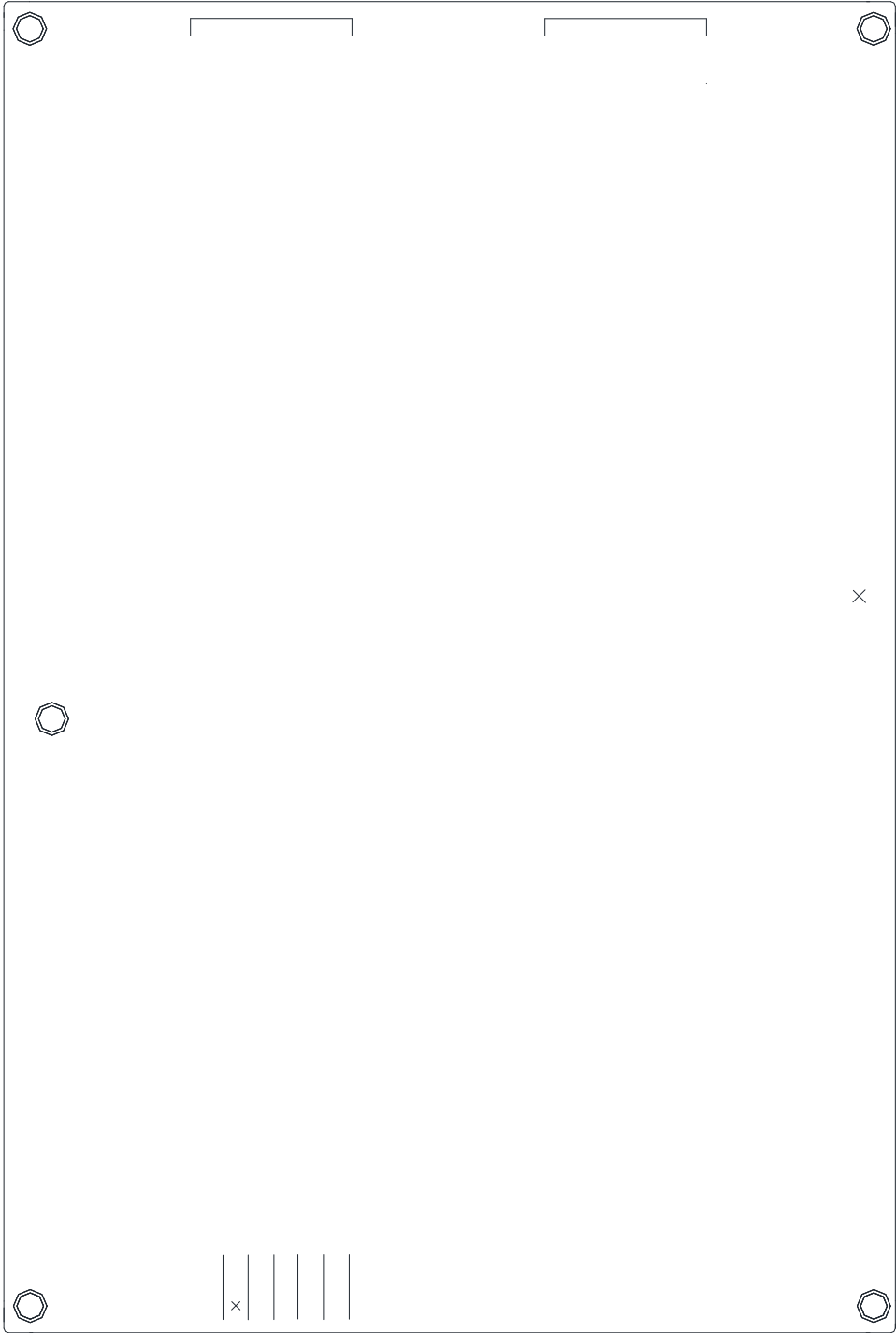
1202	2	
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1203	2	
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120	3	
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1212	3	
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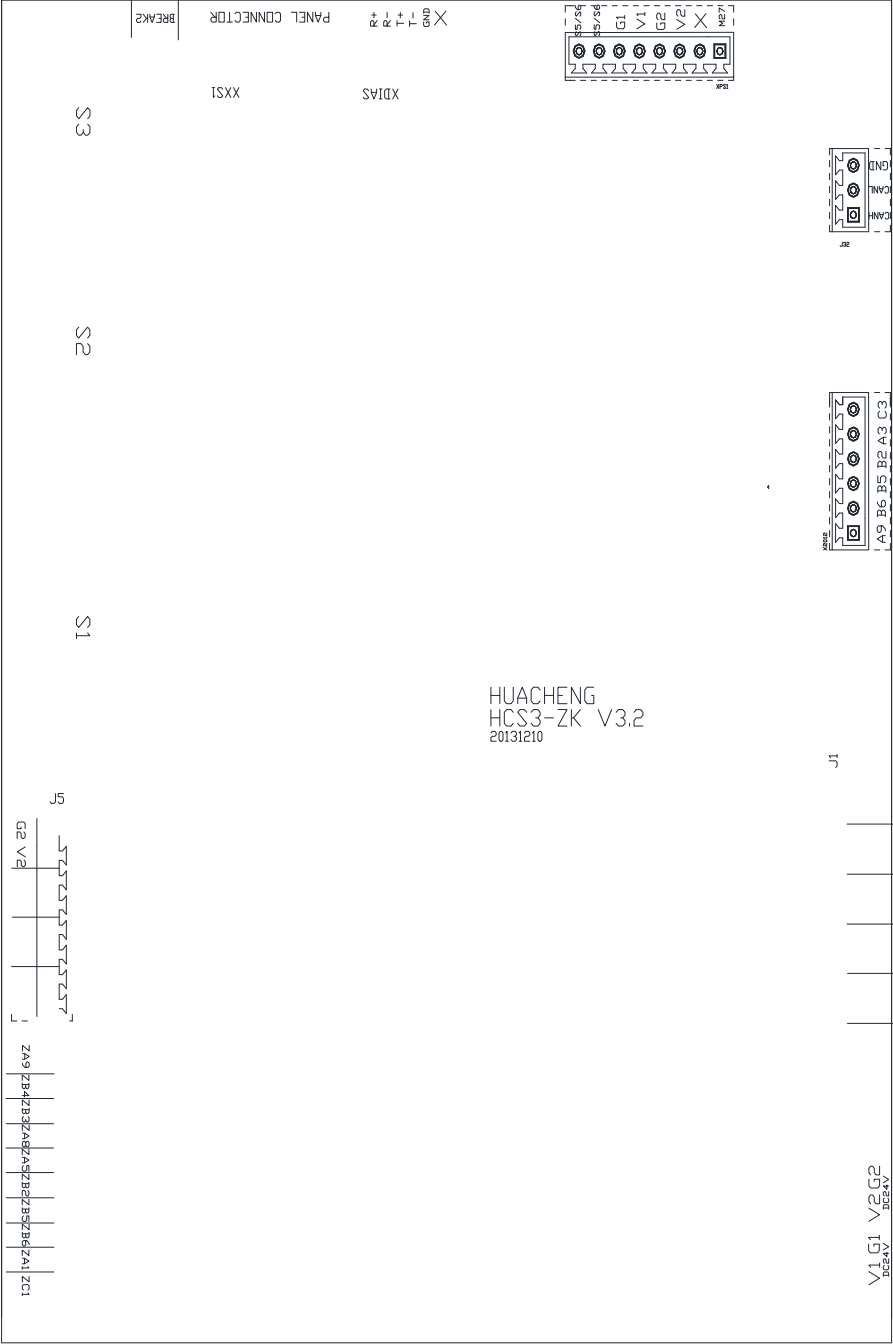




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1403 2	<p>，</p> <p>·</p> <p>，</p>	<p>1.</p> <p>2.</p>

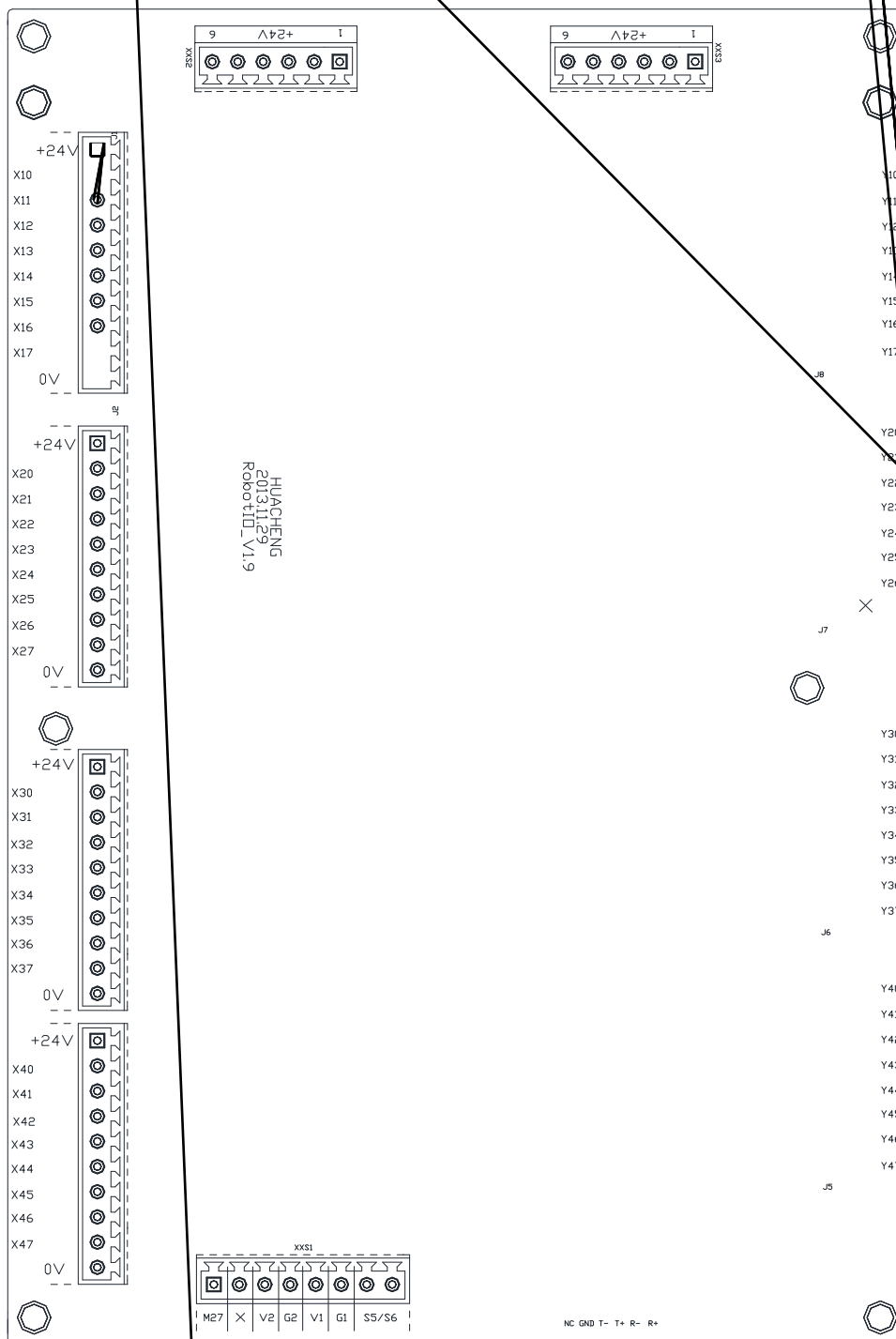




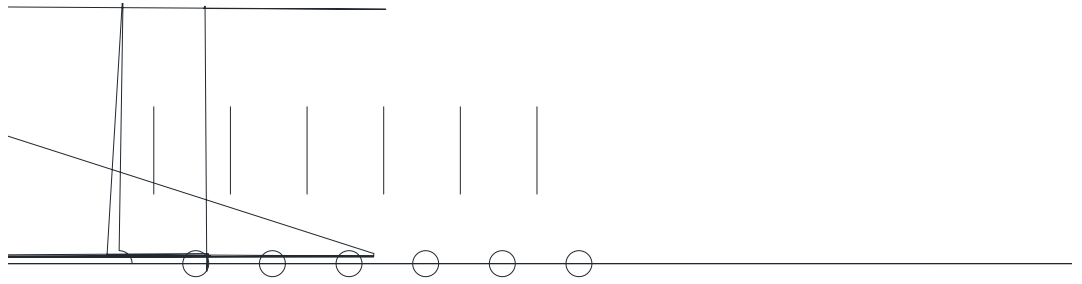


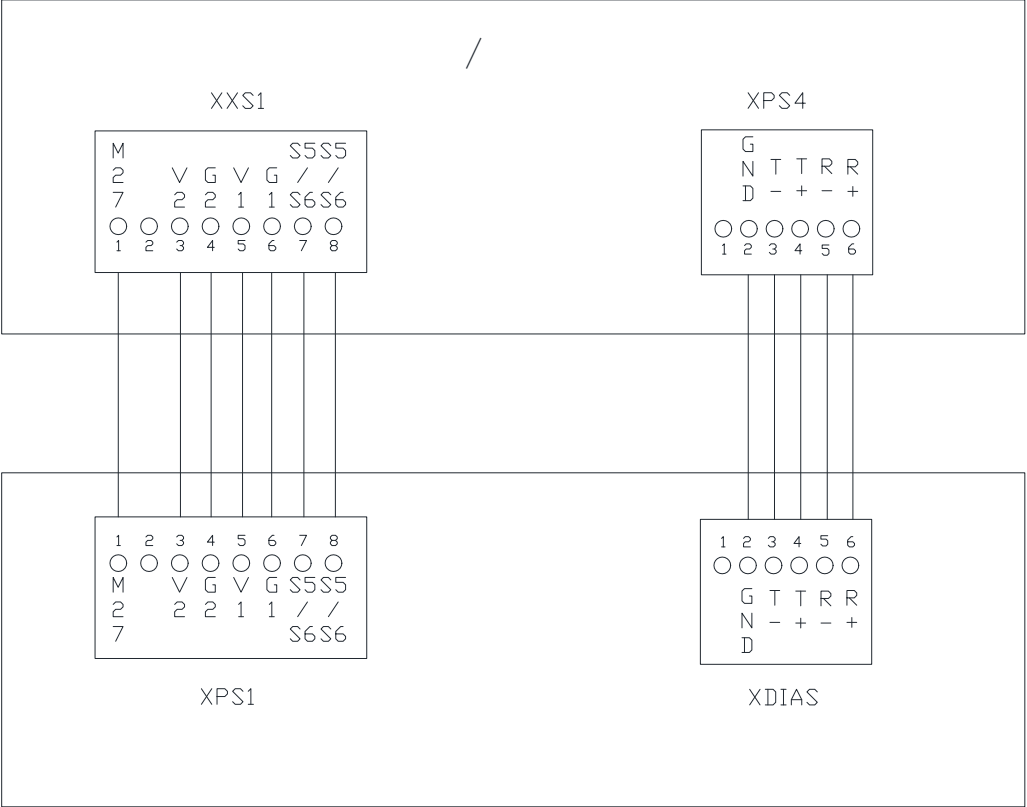
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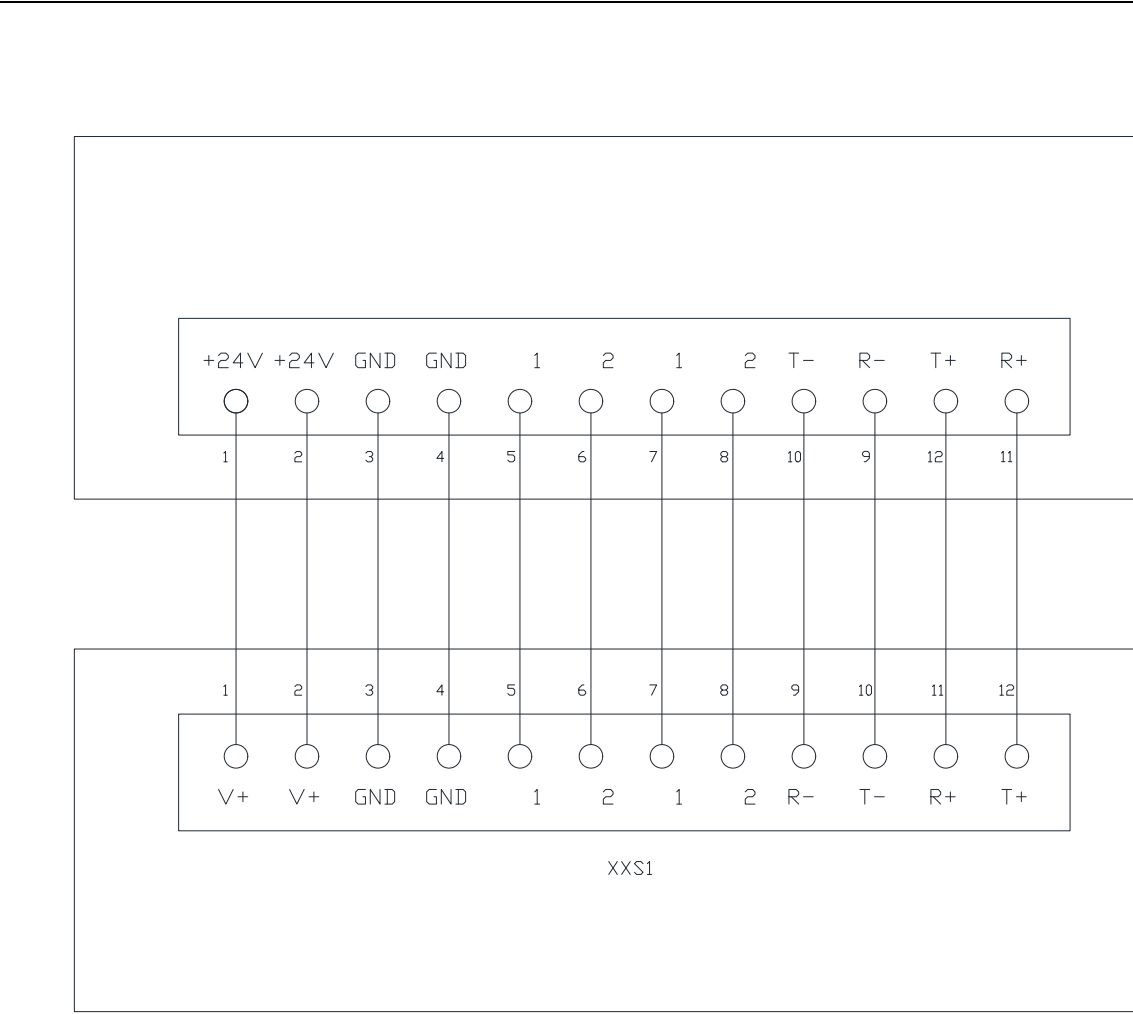


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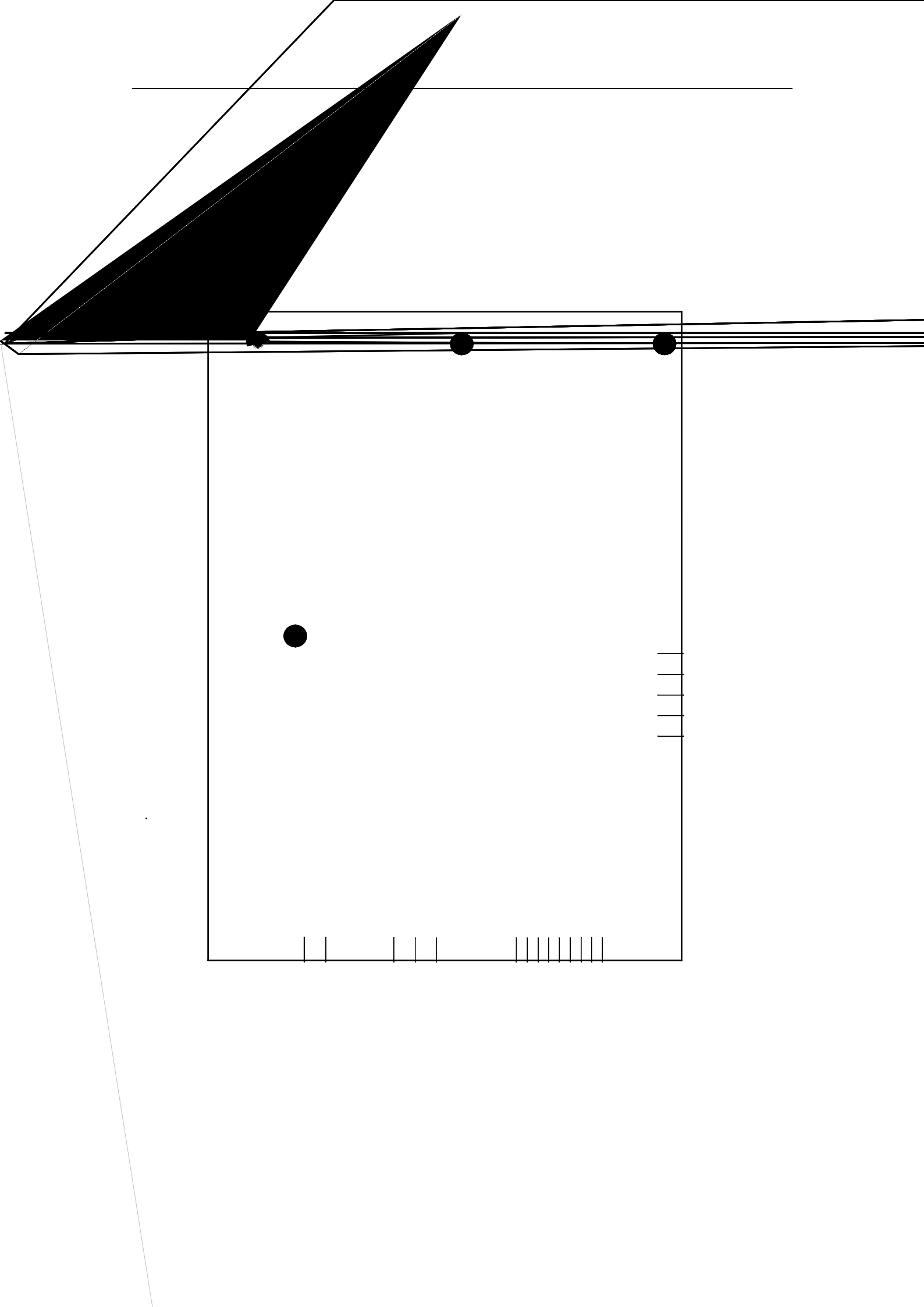
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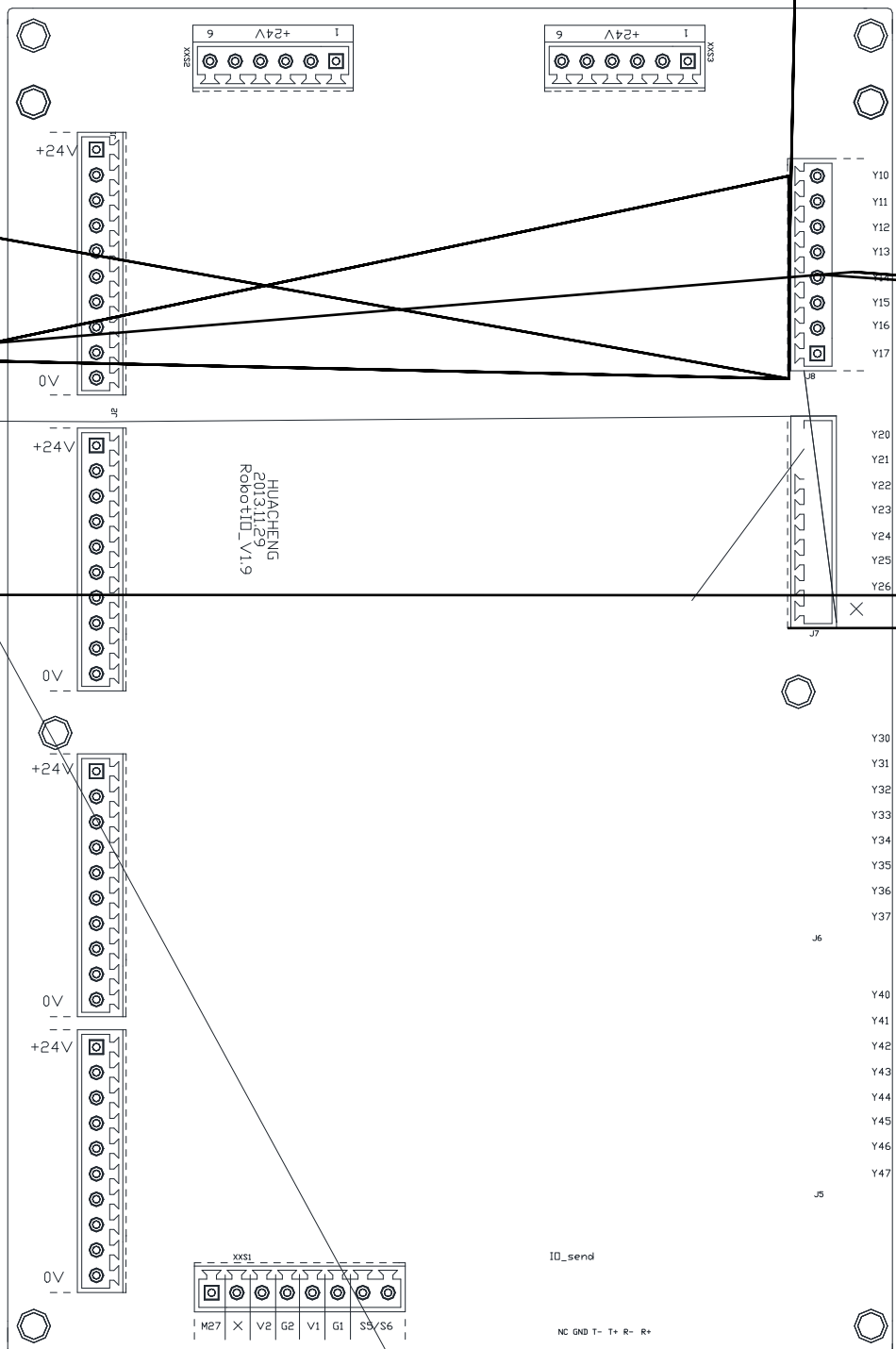
			4/		
1	+		3	1	1
2	-		4	2	
3	+			1	2
4	-			2	
	+		21	+	
	-		22	-	
	+		4	+	
	-		4	-	
	+		23	+	
10	-		24	-	
13			13		
2	+24	+24		+	+
2	0		41	-	-
			3	-	
1			3	+	
23		-	2	-	-

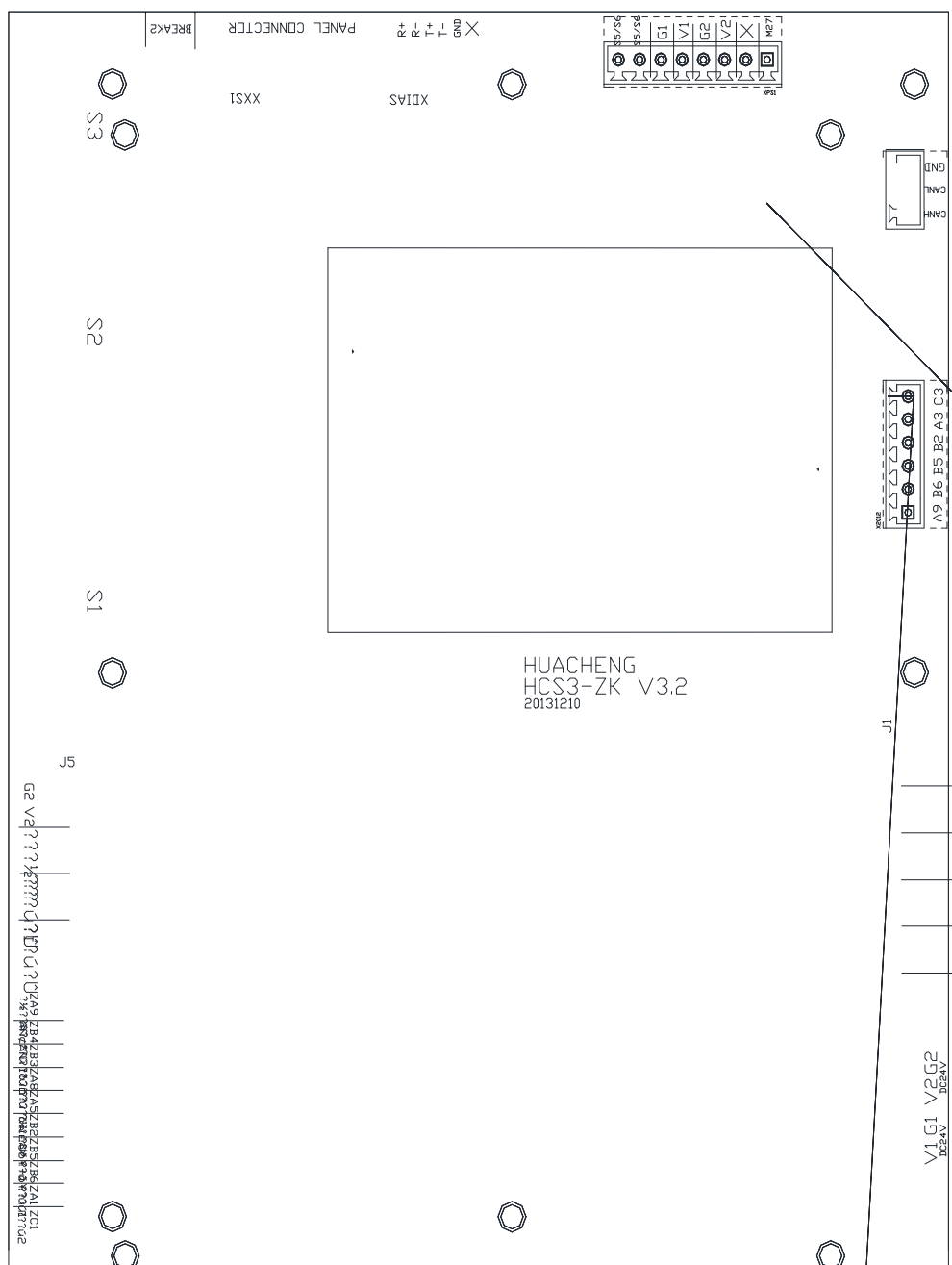
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	+		1		
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	+		1		
	-		1		
	+		1		
10	-		20		
13			14		
2	+24	+24	1		24 +
2	0		13		24 -
1					
23		-	4		-







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