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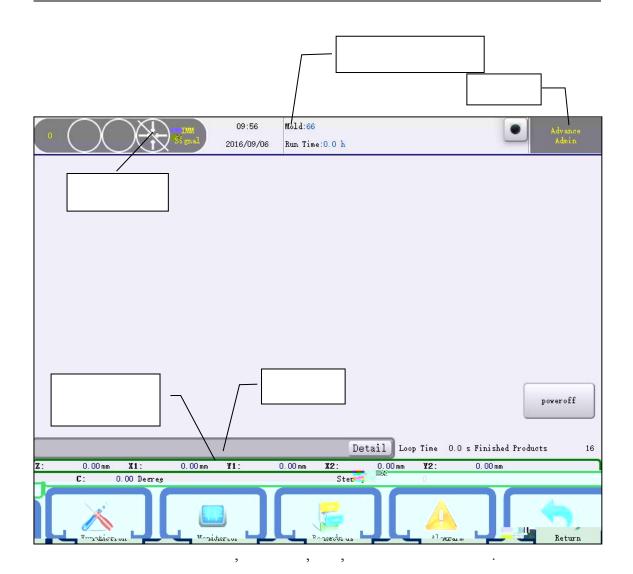
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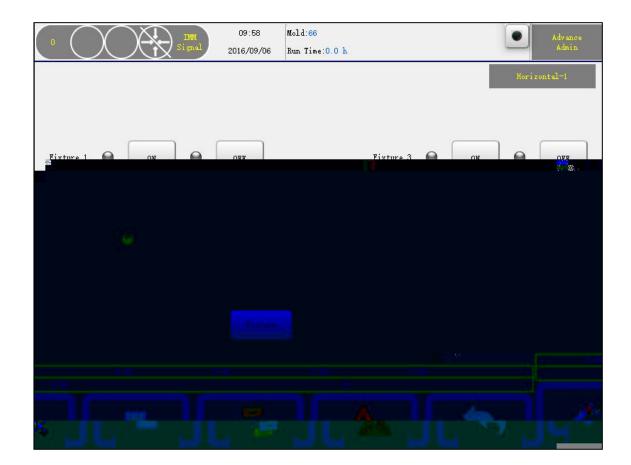
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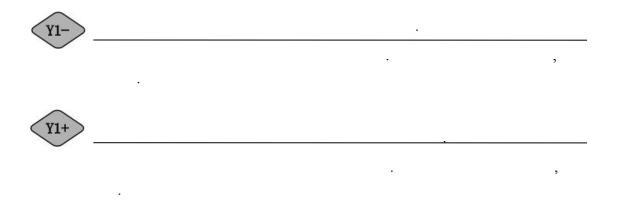
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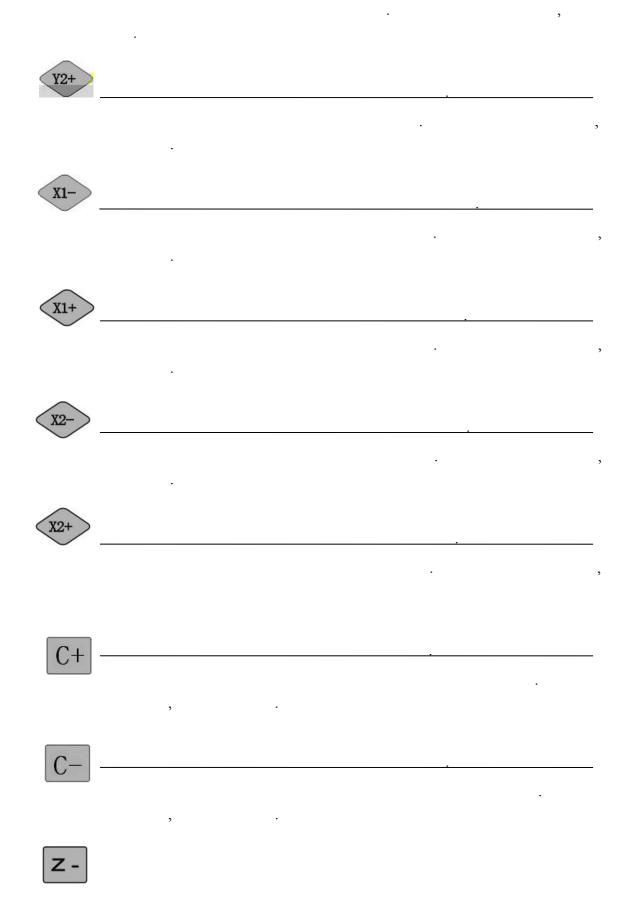
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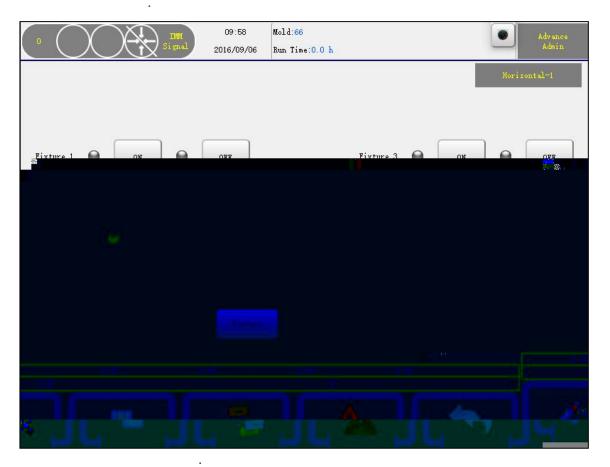


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|                        | 09:59<br>2016/09/06 | Mold:66<br>Run Time:0.0 h |                     |                     | idvance<br>Admin |
|------------------------|---------------------|---------------------------|---------------------|---------------------|------------------|
|                        |                     |                           |                     | Horizonta           | 1-1              |
| Injection 🕑 ON OFF     | ]                   |                           | Conveyor 🌘          | NO RO               | OFF              |
|                        |                     | Fixture                   | Sucker              | Reserve             | nipul-<br>or I/0 |
|                        |                     | Det                       | ail Loop Time 0.0 : | s Finished Products | 16               |
| Z: 0.00 mm X1: 0.00 mm | ¥1:                 | 0.00 mm X2:               | 0.00 mm <b>¥2</b> : | 0.00 mm             |                  |
| Function               |                     | Stan                      |                     |                     | ARTIST           |

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|     |          | JMM<br>Signal | 10:00<br>2016/09/06 | Mold:66<br>Run Time:0.0 h |          |    |     | Advance<br>Admin |
|-----|----------|---------------|---------------------|---------------------------|----------|----|-----|------------------|
|     |          |               |                     |                           |          |    |     | Horizontal-1     |
|     |          |               |                     |                           | ŕ        |    |     | i i              |
|     | Reservel | KO            | OFF OFF             |                           | Reserve2 | KO |     |                  |
|     |          |               |                     |                           | (        |    |     |                  |
| 1   | Reserve3 | ON            | OFF                 |                           | Reserve4 | ON | OFF |                  |
| · • |          |               |                     |                           |          |    |     |                  |
|     |          |               |                     |                           |          |    |     |                  |
|     |          |               |                     |                           |          |    |     |                  |
|     |          |               |                     |                           |          |    |     |                  |
| X   |          |               |                     |                           |          |    |     |                  |
|     |          |               | CAN BE FOR          |                           |          |    |     |                  |

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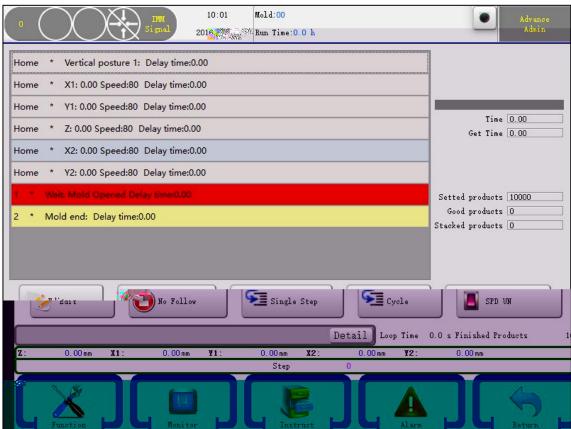
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|                          | 0 Speed:80 Delay |    |        |
|--------------------------|------------------|----|--------|
| time:0.00<br>Delay Time: | 0.00             | s  | OK     |
| Speed:                   | 80               |    | Cancel |
| Pos(+/-5):               | 0.0              | mm |        |

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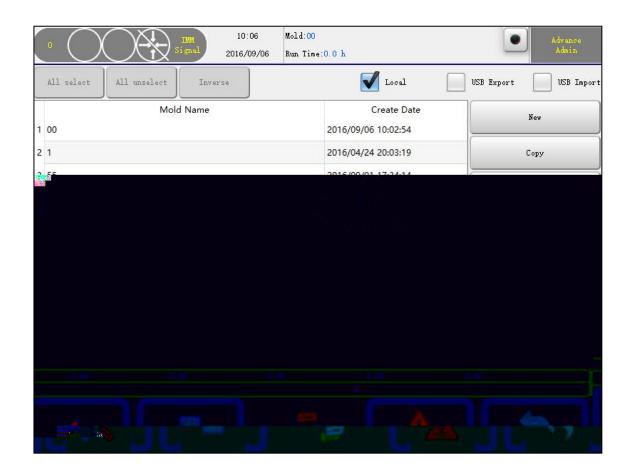
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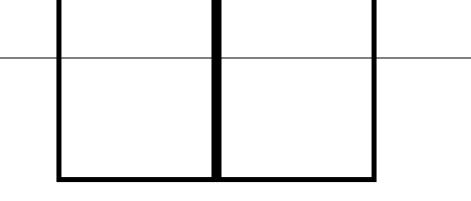
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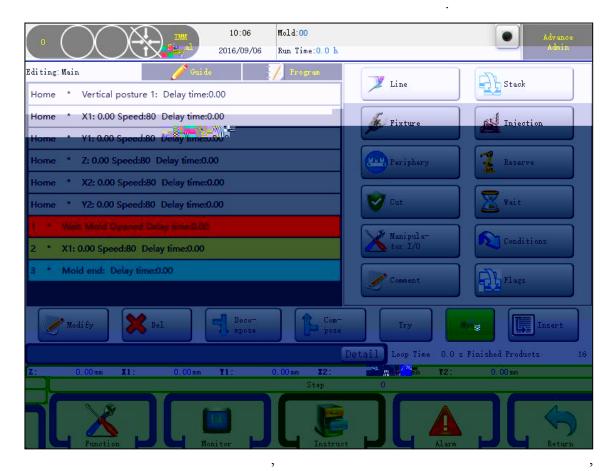


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|                    |  | 10:07<br>2016/09/06 | Mold:00<br>Run Time:0.0 h |          |       |                | Adva:<br>Adm |
|--------------------|--|---------------------|---------------------------|----------|-------|----------------|--------------|
| Editing: Main      | J G.   | i de l              | // Program                | Set      | Pos   | Speed(%)       | .Delay(      |
|                    | al posture 1: Delay tin                          |                     |                           |          |       |                |              |
| Home * X1:0        | 00 Speed:80 Delay                                | e:U                 |                           | GX1      | 0.00  | 80             | 0.00         |
| Home * Y1: 0.      | 00 Speed:80 Delay tim                            | ie:0.00             |                           | GY1      | 0.00  | 80             | 0.00         |
|                    | 0 Speed:80 Delay time                            |                     |                           | GZ       | 0.00  | 80             | 0.00         |
|                    | 00 Speed:80 Delay tin                            |                     |                           | GX2      | 0.00  |                | 0.00         |
|                    | 00 Speed:80 Delay tim                            |                     |                           |          | 0.00  |                |              |
|                    | d Opened Delay time:0.<br>peed:80 Delay time:0.0 |                     |                           | GY2      | 0.00  |                | 0.00         |
| 3 * Mold end       | Delay time:0.00                                  |                     |                           |          |       |                |              |
| Modi fy            | Del  | Deco-<br>mpose      | Com-<br>pose              |          |       | fenu           | Insert       |
| 6                  |  | n <b>¥1</b> :       | 0.00mm <b>X2</b> :        | Detail L | -     | Finished Produ | cts          |
| <b>7</b> . 0.00mm  | X1 0.00 m  |                     |                           | 0        |       | 0.001          |              |
| <b>Z</b> : 0.00 mm | X1: 0.00 m                                       |                     | Step                      |          |       |                |              |
| Z: 0.00 mm         |  | nitor               | Step                      | J        | Alarm | J              | Return       |

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| • (                              |                             | IMM<br>Signal   | 10:09<br>2016/09/06 | Mold: <mark>00</mark><br>Run Time: | 0.0 h |                        |            |              |             | Advance<br>Admin        |
|----------------------------------|-----------------------------|-----------------|---------------------|------------------------------------|-------|------------------------|------------|--------------|-------------|-------------------------|
| Editing: Ma                      | in                          | 🧪 Gui de        |                     | 🕖 Progra                           | m     | Seq                    | S:Po       |              | Num         | Step                    |
| Home *                           | Vertical posture 1          | I: Delay time:0 | .00                 |                                    |       | Group=1 X=>Z=>         |            | P<br>RP<br>P | 2<br>2<br>2 | 10.00<br>10.00<br>10.00 |
| Home *                           | X1: 0.00 Speed:80           | Delay time:0.   | .00                 |                                    |       | Group-2 X->Z->         |            | P<br>RP      | 3           | 10.00<br>10.00          |
| Home *                           | Y1: 0.00 Speed:80           | ) Delay time:0. | 00                  |                                    |       |                        | Z:<br>X:   | P<br>P       | 3 4         | 10.00<br>5.00           |
| Home *                           | Z: 0.00 Speed:80            | Delay time:0.0  | 0                   |                                    |       | Group=3 X=>Z=>         | Y Y:<br>Z: | RP<br>P      | 4<br>4      | 5.00<br>5.00            |
|                                  | V3. 0 00 C J.90             | 0.0-10          | 00                  |                                    |       |                        | Х:<br>т т. | P            | 5.00        |                         |
| <sup>ine</sup> u" <sub>nan</sub> |                             |                 | 872000              |                                    | Ш     |                        |            |              | *           |                         |
| W                                | : my <mark>14 8 8</mark> 11 |                 | 1 <b>00''</b> 80    |                                    |       |                        |            |              |             |                         |
| ມື້<br>8                         |                             |                 | MOTINE              |                                    |       | u                      |            |              |             |                         |
|                                  |                             | ເມັກກອີກຮຸດແຜ   |                     |                                    |       |                        |            |              |             |                         |
| ***                              |                             |                 |                     |                                    |       |                        |            |              |             |                         |
|                                  | α                           |                 | */////              | Î                                  |       | <sup>IIIII</sup> 00 00 |            | <u> </u>     |             | 11 <sup>10</sup> 10s mm |
| 8                                |                             | le Heel         |                     |                                    |       |                        | 8          |              | illes:      |                         |
| " nll "                          |                             |                 |                     |                                    |       |                        |            |              | Nuelluss    | ในให้ได้หลัง            |
|                                  |                             |                 | illiku 🔜            |                                    |       | ***                    |            |              | iii         | llino                   |
|                                  |                             |                 |                     |                                    |       |                        |            |              | nill        |                         |
|                                  |                             |                 |                     |                                    | W     |                        |            |              |             |                         |
| Ш                                |                             |                 |                     |                                    |       |                        |            |              |             |                         |

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| 0 10:09 Mold:00<br>2016/09/06 Run Time:0.0  | h                  | Advance<br>Admin |  |  |  |  |
|---|--------------------|------------------|--|--|--|--|
| Editing: Main 🧪 Guide 🗾 Program   | Fixture Action     |                  |  |  |  |  |
| Home * Vertical posture 1: Delay time:0.00  | En Current/Setting | Delay 🔹          |  |  |  |  |
| Home * X1: 0.00 Speed:80 Delay time:0.00  | Fixturel           | 0.00             |  |  |  |  |
| Home * Y1: 0.00 Speed:80 Delay time:0.00  | Fixture2           | 0.00             |  |  |  |  |
| Home * Z: 0.00 Speed:80 Delay time:0.00<br>Home * X2: 0.00 Speed:80 Delay time:0.00 | Fixture3           | 0.00             |  |  |  |  |
| Home * Y2: 0.00 Speed:80 Delay time:0.00  | Fixture4           | 0.00             |  |  |  |  |
| 1 * Wait: Mold Opened Delay time:0.00   | Sucker1            | 0.00             |  |  |  |  |
| 2 * X1: 0.00 Speed:80 Delay time:0.00   | Sucker2            | 0.00             |  |  |  |  |
| 3 * Mold end: Delay time:0.00   |                    |                  |  |  |  |  |
| Î   | Sucker3            | 0.00             |  |  |  |  |
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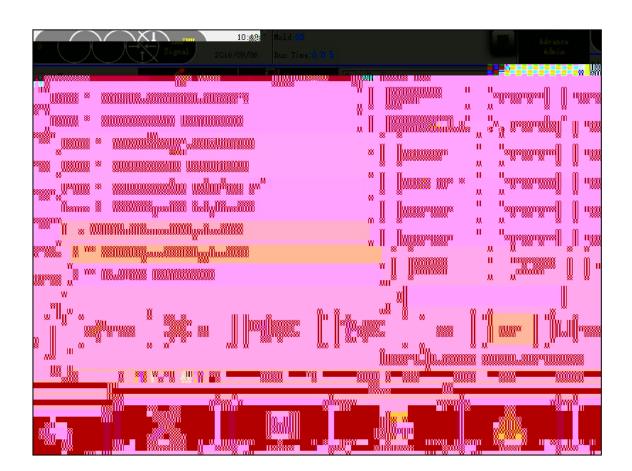
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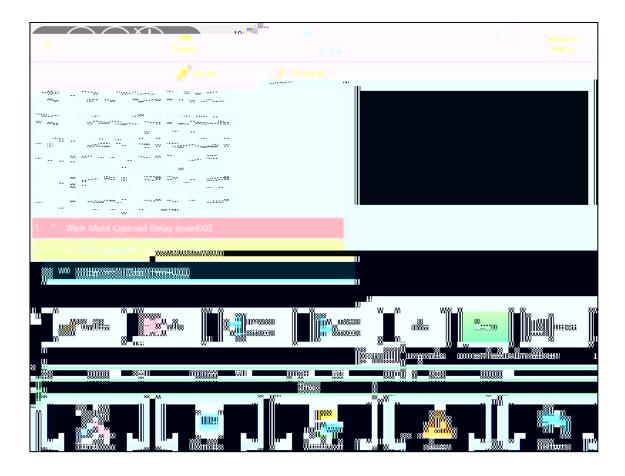
|       | 10:11 | Mold:00 | Advance |
|-------|-------|---------|---------|
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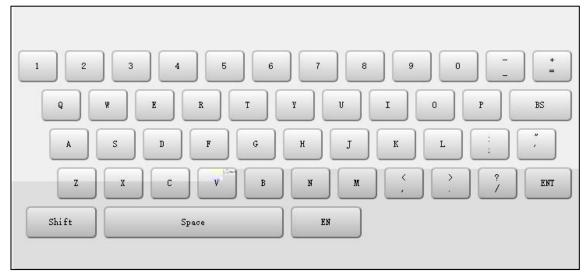
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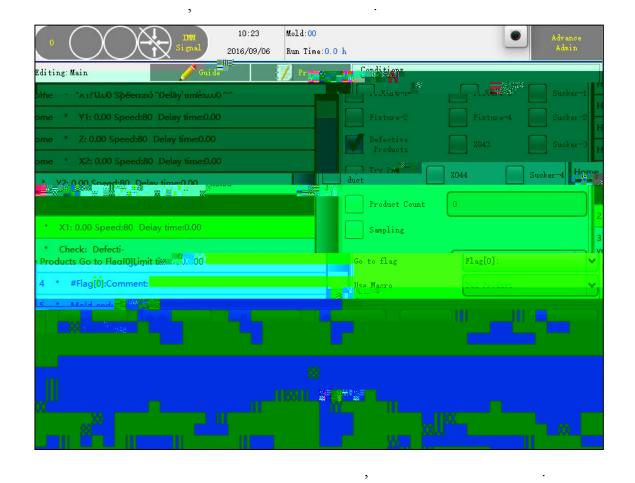
| 0 10:12                                | Mold:00 |  | Advance |
|--|---------|--|---------|
|  | 1 riv-  |  |         |
| 70% - 0102552 - 0 GM + 101062 /F2888   |         |  | 11 W.   |
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| and a second second second             |         |  |         |
| entre grant de l'hoursee               |         |  |         |
|  |         |  |         |
| 1 * Wait Mold Operand Delay Inner0.00  |         |  |         |
| الاشتىن بانى الشنى كارا كار ا          |         |  |         |
| A State and Delay should be            |         |  |         |
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| 2 | Set              |           |     |
|---|------------------|-----------|-----|
|   | Position         | 0.00      | m   |
|   | speed            | 80        | ) % |
|   | Delay Time       | 0.00      | s   |
|   | Early End        |           |     |
|   | Early Speed-Down | 0         | \$  |
|   | End Position     | 0         | m   |
|   |                  | OK Cancel |     |

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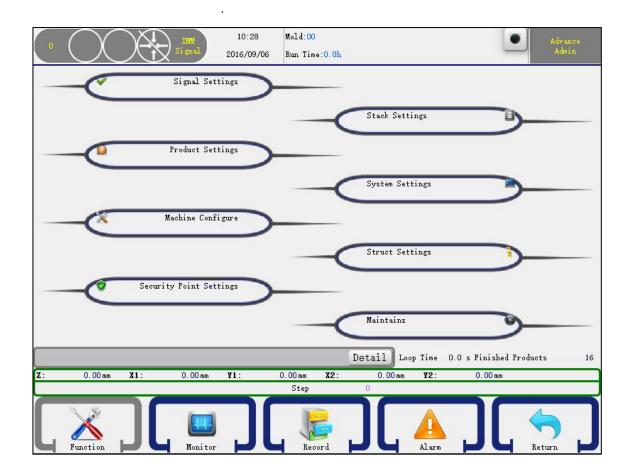
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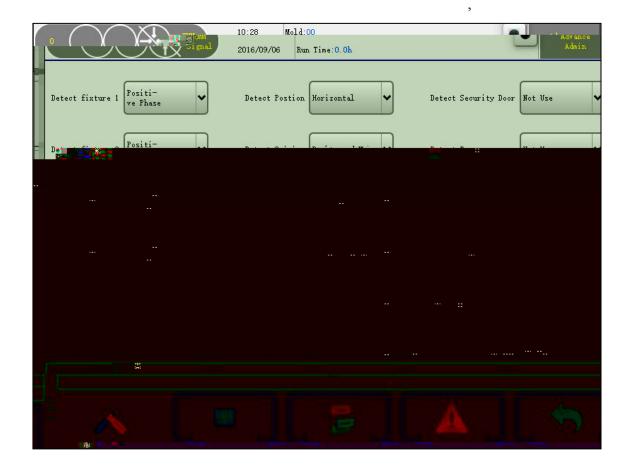
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|                    |               | 10:29<br>2016/09/06 | Mold:00<br>Run Time:0.0h       | Advance<br>Admin                          |
|--------------------|---------------|---------------------|--------------------------------|---|
| Product            | 10000         |                     | Wait Mold Opened<br>Limit Time | 65.9 s                                    |
| TryProduct         | 0             |                     | Alarm Times                    | 30 s                                      |
| Sampling Interval  | 0             |                     | Recycle Time                   | 0.0 s                                     |
|                    |               |                     | Fixture                        | Ve Phase Rever-<br>sed Phase              |
| Get Fail           | Alarm When Up |                     | Count Ways                     | A11 🗸                                     |
|                    |               |                     | Product Save                   | e Product Clear                           |
|                    |               |                     | De                             | tail Loop Time 0.0 s Finished Products 16 |
| <b>Z</b> : 0.00 mm | X1: 0.00 mm   | ¥1:                 | 0.00 mm X2:                    | 0.00 mm ¥2: 0.00 mm                       |
| Function           |               | ][                  | Step<br>Record                 |   |

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|                      | 10:31<br>Signel 2016/09, |         |                        | Advance<br>Admin       |
|----------------------|--------------------------|---------|------------------------|------------------------|
| X1 Axis ¥1 Axis      | Z Axis                   | 2 Axis  | Y2 Axis C Axis F       | igure                  |
| Security Point       |                          |         | Test Feedback          |                        |
| Maximum displacement | 400.0                    | mm      | Test 0<br>Feedback     |                        |
| Min pos inside mold  | 0.0                      | m       | Z Signal               |                        |
| Max pos inside mold  | 400.0                    | mm      | +Test -Test            | Clear                  |
| Save                 |                          |         | Detail Loop Time 0.0 : | s Finished Products 16 |
| Z: 0.00              | 0.00 mm ¥1:              | 0.00 mm | X2: 0.00mm Y2:         | 0.00 mm                |
| ALL                  |                          | Step    | 0                      |                        |
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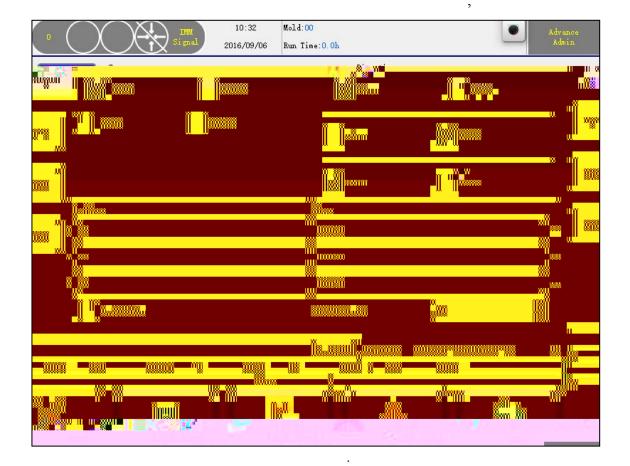
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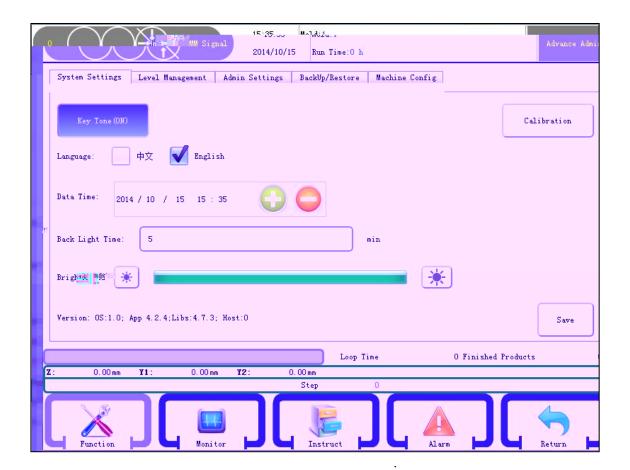
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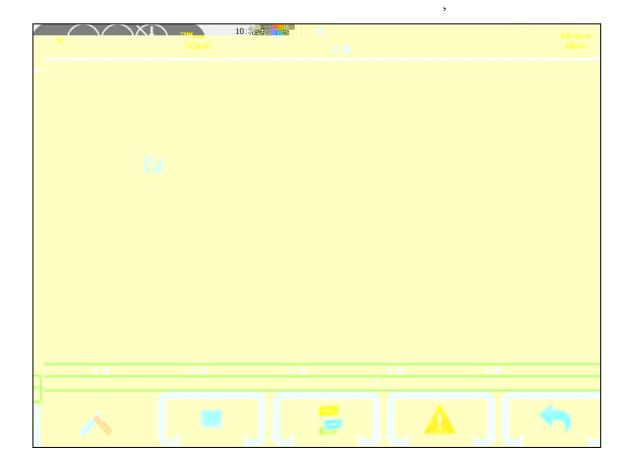
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|              | X          |           | IMM<br>Signal | 10:35<br>2016/09/06 | Mold:00<br>Run Tim | e:0.0h  |         | 2          |                  | Advance<br>Admin |
|--------------|------------|-----------|---------------|---------------------|--------------------|---------|---------|------------|------------------|------------------|
| System Se    | ttings     | Level Man | agement       | Admin Settings      | BackUp             | /Resto  |         |            |                  |                  |
| Backup       |            |           |               |                     |                    | Restore |         |            |                  |                  |
|              |            | Backup Ma | chine Confi   | ân.ez               |                    |         | Rest    | tore Machi | ne Configures    |                  |
|              |            | Backup Sy | stem Confi    | gures               |                    |         | Res     | tore Syste | em Configures    |                  |
|              |            | Ba        | ckup All      |                     |                    |         |         | Resto      | re All           |                  |
| umount       | t          |           |               |                     |                    |         |         |            |                  |                  |
|              |            |           |               |                     |                    |         |         |            | ).O s Finished F | roducts 16       |
| <b>Z</b> : 0 | 0.00 mm    | X1:       | 0.00 mm       | ¥1:                 | 0.00mm<br>Step     | X2:     | 0.00 mm | ¥2:        | 0.00 mm          |                  |
| Func         | K<br>etion | JL        | Monito        |                     | Rec                | ord I   | II.     | Alarm      |                  | Return           |

|                 | )))          | Si gnal | 10:36<br>2016/09/ | 100 C 100 | ::0. 0h     |                  |               |             | Advance<br>Admin |
|-----------------|--------------|---------|-------------------|---|-------------|------------------|---------------|-------------|------------------|
| X1 Axis         | ¥1 Axis      | Z Axis  | X2 Axis           | Y2 Axis   | C Axis      | Struct<br>Define | Time          |             |                  |
| Security I      | Point        |         |                   |   | Test Feedba | ck               |               |             |                  |
| - Shani         | cal length   | 500.0   |                   |   | Test o      | Ľ                |               |             |                  |
| Maximum         | displacement | 400.0   |                   | mm  | Feedback    | 0                |               |             |                  |
| Min pos         | inside mold  | 0.0     |                   | mm  | Z Signal    |                  |               |             |                  |
| Mar 355         | inside mold  | 400.0   |                   | mm  | +]          | lest             | -Test         |             | Clear            |
| Distanc         | e/Rotation   | 20.00   |                   | mm  |             |                  |               |             |                  |
| Sar             | ve           |         |                   |   |             |                  |               |             |                  |
|                 |              |         |                   |   | De          | tail Loop Ti     | ime 0.0 s.F:  | inished Pro | ducts 1          |
| <sup>6</sup> Z: | 0.00 mm X1   | : 0.00  | mm ¥1:            | 0.00 mm   |             |                  | <b>12</b> : 0 | . 00 mm     |                  |
|                 | Motion       | Kor Mor | itor              |   | ecord       |                  | Larm          |             | Return           |

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|                    |     | IMM<br>Signal | 10:39<br>2016/09/06 | Mold:00<br>Run Time:0.0h  | al l         |           |                         | Advance<br>Admin |
|--------------------|-----|---------------|---------------------|---------------------------|--------------|-----------|-------------------------|------------------|
| Maintain Car       | 2   |               |                     |                           |              |           |                         |                  |
| Name               |     |               | Crea                | te Time                   |              |           | Update Log              | •                |
|                    |     |               |                     |                           |              |           | Scan Panel              |                  |
|                    |     |               |                     |                           |              |           | Update HMI              |                  |
|                    |     |               |                     |                           |              |           | Update Supe<br>Password | r                |
| Update Host Proce  | 55: |               |                     |                           |              | 0%        | Back To Facto           | ory              |
|                    |     |               |                     |                           | Detail Loo   | pTime O.( | ) s Finished Produc     | ts 16            |
| <b>Z</b> : 0.00 mm | X1: | 0.00 mm       | ¥1:                 | 0.00mm <b>X2:</b><br>Step | 0.00 mm<br>0 | ¥2:       | 0.00 mm                 |                  |
| Function           | כ   | Monitor       | כ                   | Record                    | כ            | Alarm     |                         | b<br>eturn       |

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| lerm Kistory Modify Log   | 10:40 Mold:00<br>2016/09/06 Run Time <mark>:0.00</mark> |   | ada i s |
|---|---|---|---------|
|   |   |   |         |
| 500 Antipation and a second and a | 997   | np-solve                                |         |
|   |   |   |         |
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| ia en la companya da anti-<br>anti-   |   |   |         |
|   |   | s stiller                               |         |

| Alarm ID:       | 500   |
|-----------------|-------|
| Alarm Text:     |       |
| Alarm Reason:   |       |
| Alarm Solution: |       |
|                 | Close |

| 0  |                   | DMM         10:45         Mold:00         Machine           Signal         2016/09/06         Run Time:0.0h         Machine         Operator |
|----|-------------------|--|
| Al | arm History Modif | y 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 CSave  |
| 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_Changedfr at from [ bo to bo  |
|    |                   |  |
| Z  | : 0.00 mm         | Detail Loop Time 0.0 s Finished Products<br>X1: 0.00mm V1: 0.00mm X2: 0.00mm V2: 0.00mm  |
| Ť  | . 0.00 mm         | Step   |
|    |                   | Monitor  |

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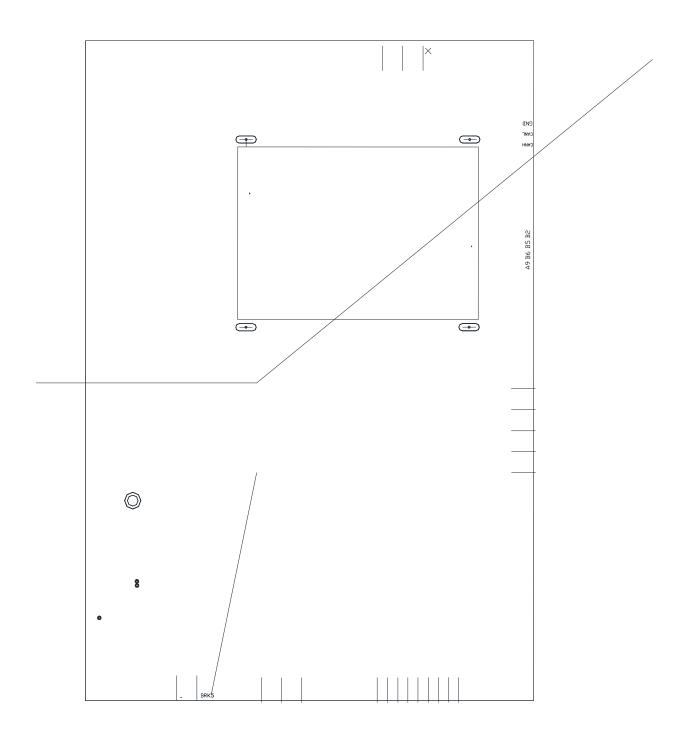
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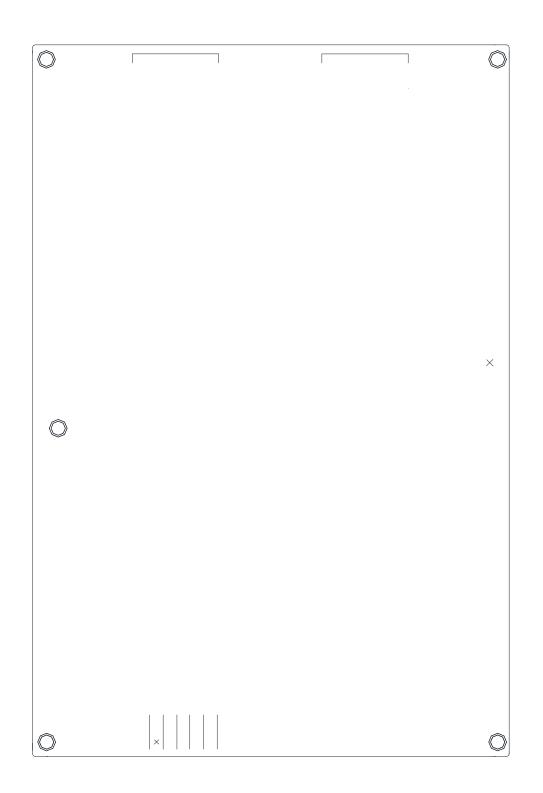
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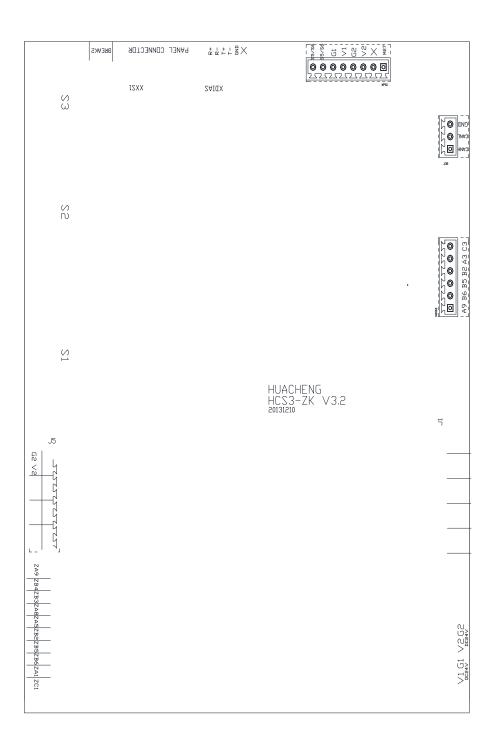
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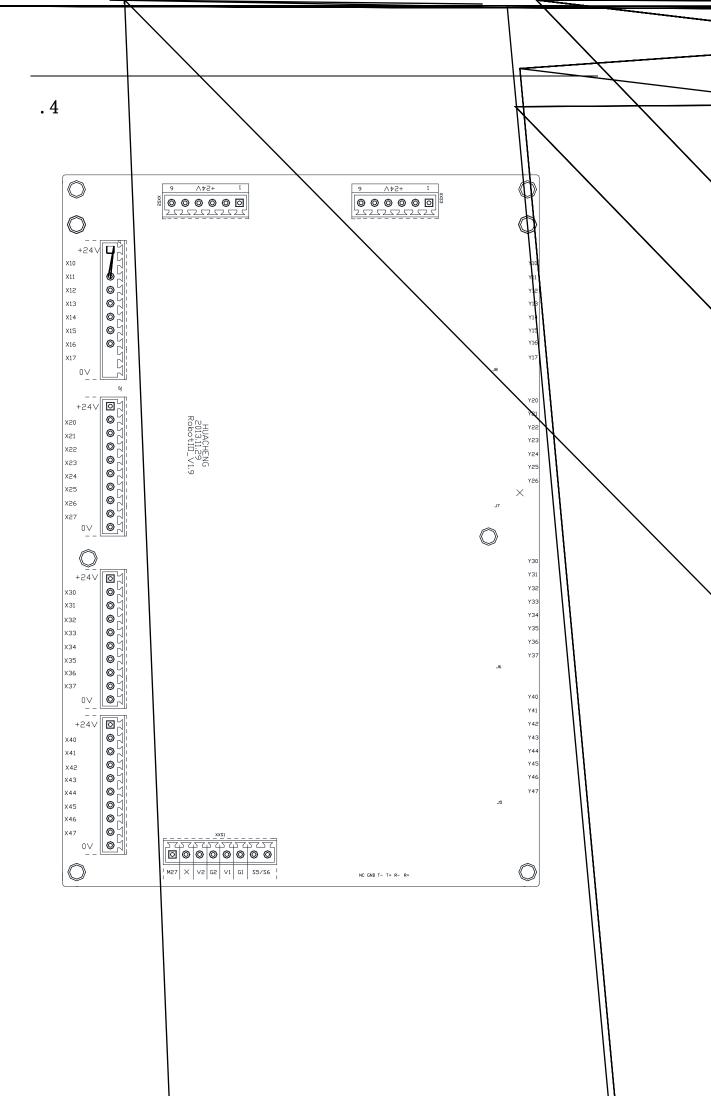
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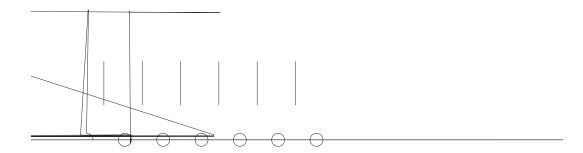
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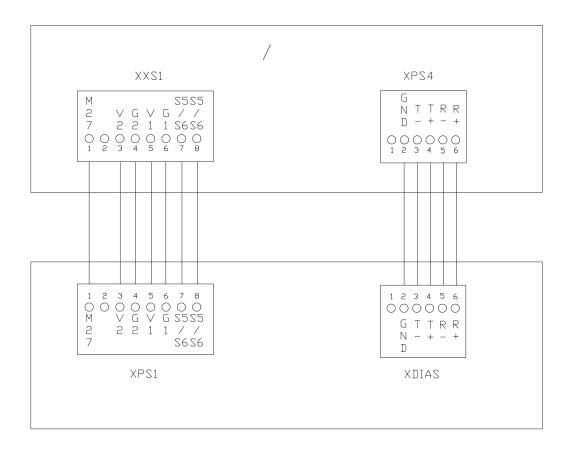


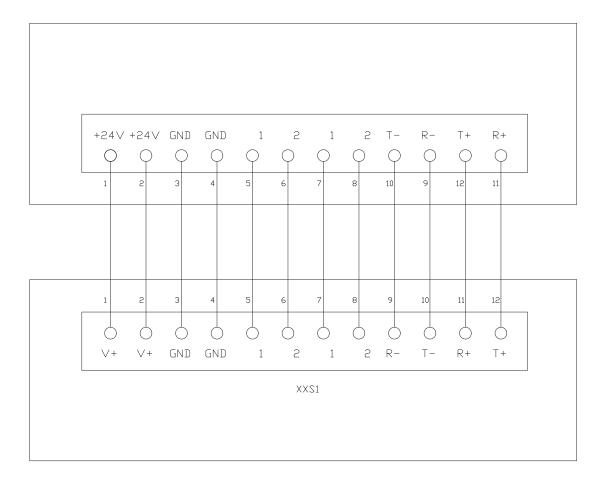












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