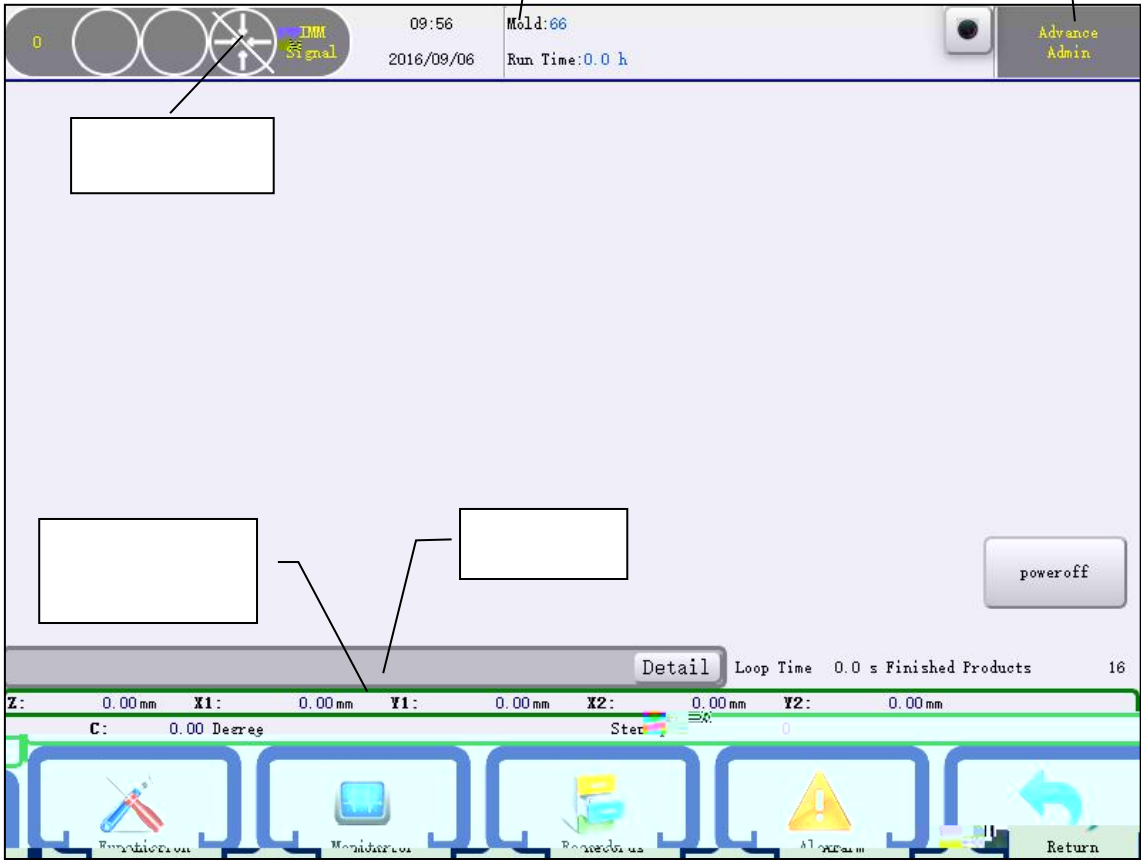

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Y1- _____

Y1+ _____

Y2- _____

Y2+

X1-

X1+

X2-

X2+

C+

C-

Z-

Z +



0

09:59

2016/09/06

Mold:66

Run Time:0.0 h

Advance
Admin

Horizontal-1

Sucker 1

 ON OFF

Sucker 3

 ON OFF

Sucker 2

 ON OFF

Sucker 4

 ON OFF

Fixture
Sucker
Reserve
Manipulator I/O

Detail
Loop Time 0.0 s
Finished Products 16

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

C: 0.00 Degree Step 0



Function

Monitor

Instruct

Alarm

Return

0  DMM Signal 09:59 2016/09/06 Mold:66 Run Time:0.0 h  Advance Admin

Horizontal-1

Injection ON OFF


Conveyor ON OFF

Fixture Sucker Reserve Manipulator I/O

Detail Loop Time 0.0 s Finished Products 16

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

0.00 Degree Step: 0





0
TMM
Signal

10:01
2016

Mold:00
Run Time:0.0 h

Advance
Admin

Home * Vertical posture 1: Delay time:0.00	
Home * X1: 0.00 Speed:80 Delay time:0.00	
Home * Y1: 0.00 Speed:80 Delay time:0.00	
Home * Z: 0.00 Speed:80 Delay time:0.00	
Home * X2: 0.00 Speed:80 Delay time:0.00	
Home * Y2: 0.00 Speed:80 Delay time:0.00	
1 * Wait Mold Opened Delay time:0.00	
2 * Mold end: Delay time:0.00	

Time
 Get Time

Setted products
 Good products
 Stacked products

Start

No Follow

Single Step

Cycle

SPD UN

Detail

Loop Time 0.0 s Finished Products 1

Z: 0.00mm

X1: 0.00mm

Y1: 0.00mm

X2: 0.00mm

Y2: 0.00mm

Step 0

Function

Monitor

Instruct

Alarm

Return

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



Delay Time: s

Speed: %

Pos(+/-5): mm

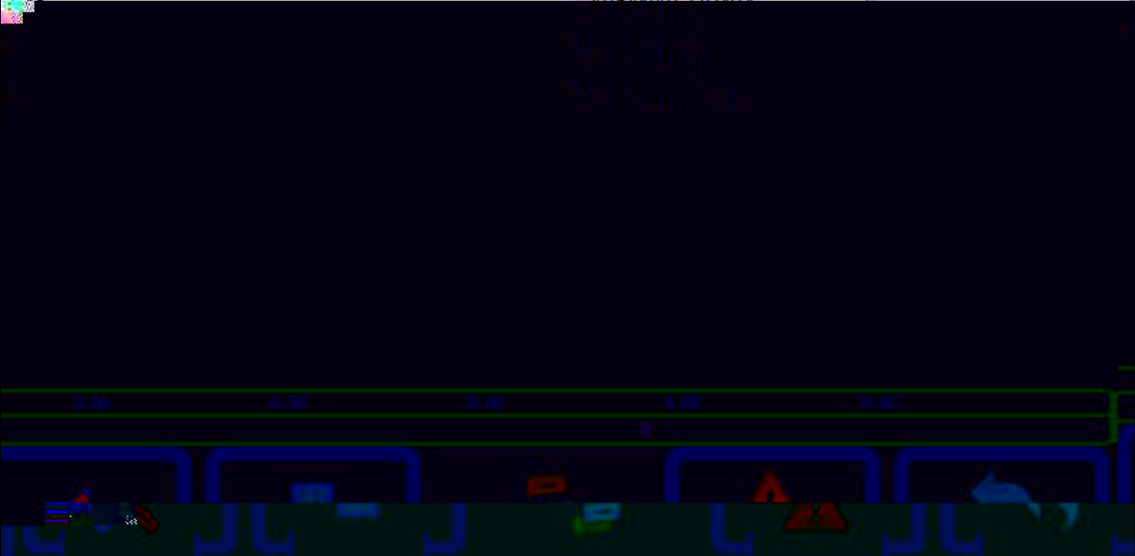
OK

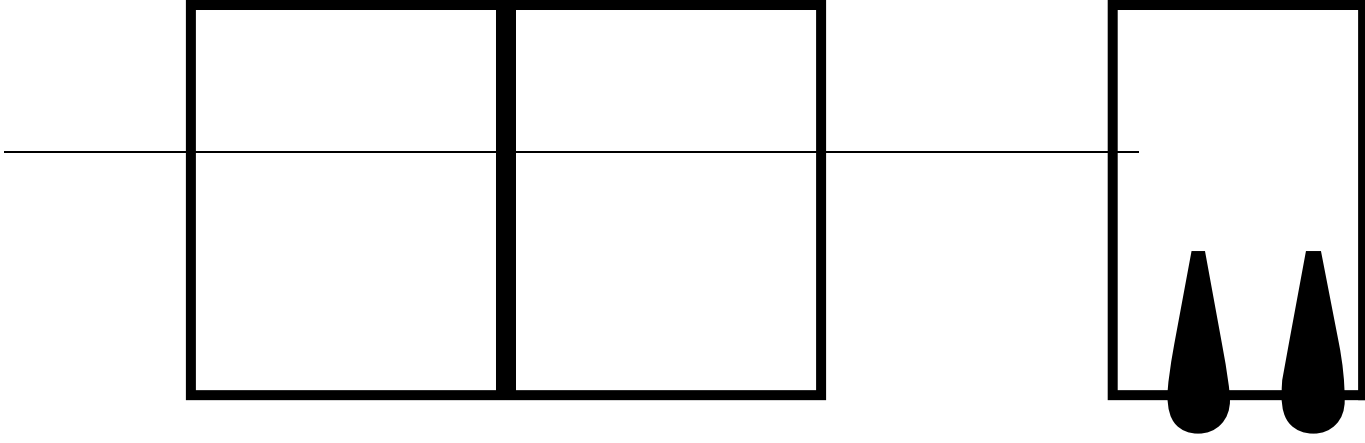
Cancel

0  IMM Signal 10:06 2016/09/06 Mold:00 Run Time:0.0 h  Advance Admin

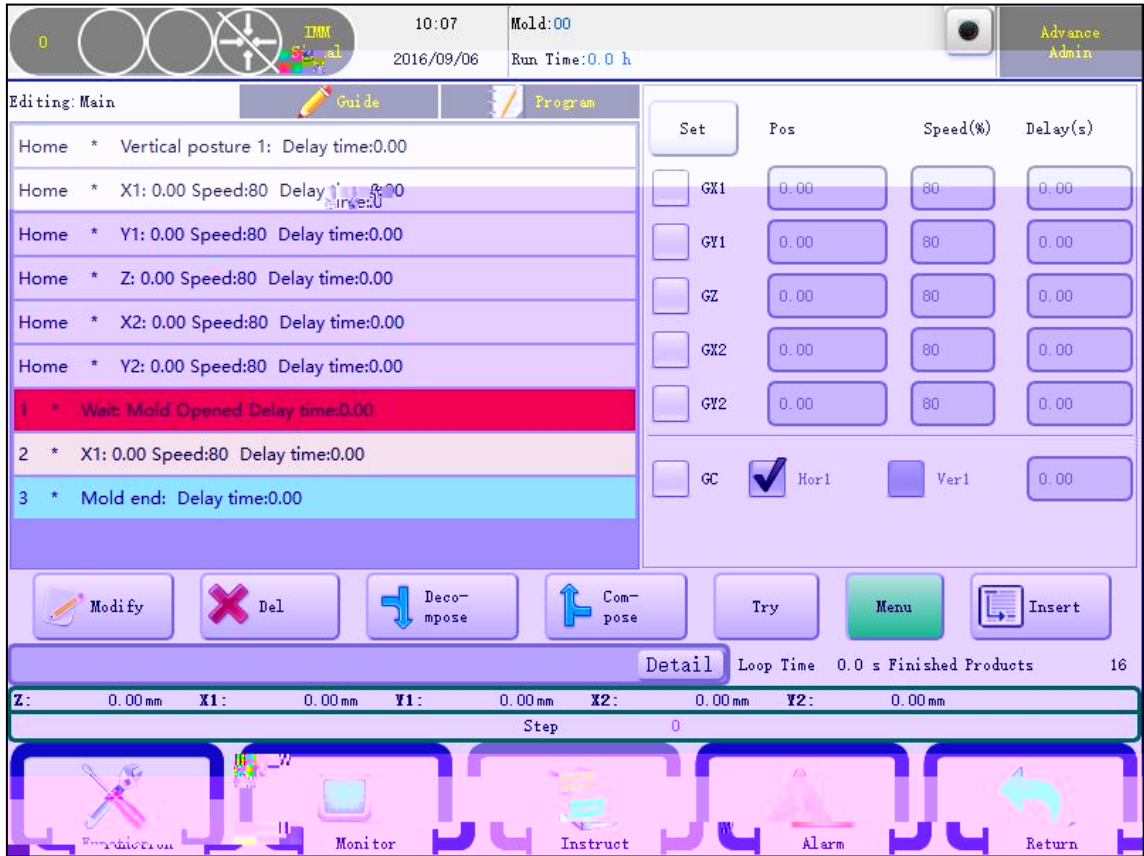
All select All unselect Inverse Local USB Export USB Import

	Mold Name	Create Date	
1	00	2016/09/06 10:02:54	New
2	1	2016/04/24 20:03:19	Copy
3	55	2016/09/06 17:24:14	





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0 10:06 Mold:00
2016/09/06 Run Time:0.0 h Advance Admin

Editing: Main Guide Program

Home * Vertical posture 1: Delay time:0.00
 Home * X1: 0.00 Speed:80 Delay time:0.00
 Home * Y1: 0.00 Speed:80 Delay time:0.00
 Home * Z: 0.00 Speed:80 Delay time:0.00
 Home * X2: 0.00 Speed:80 Delay time:0.00
 Home * Y2: 0.00 Speed:80 Delay time:0.00
 1 * **Wait Mold Opened** Delay time:0.00
 2 * X1: 0.00 Speed:80 Delay time:0.00
 3 * **Mold end:** Delay time:0.00

Line Stack
 Fixture Injection
 Periphery Reserve
 Cut Wait
 Manipulator I/O Conditions
 Comment Flags

Modify Del Decompose Compose Try Insert

Detail Loop Time 0.0 s Finished Products 16

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

Step 0

Function Monitor Instruct Alarm Return

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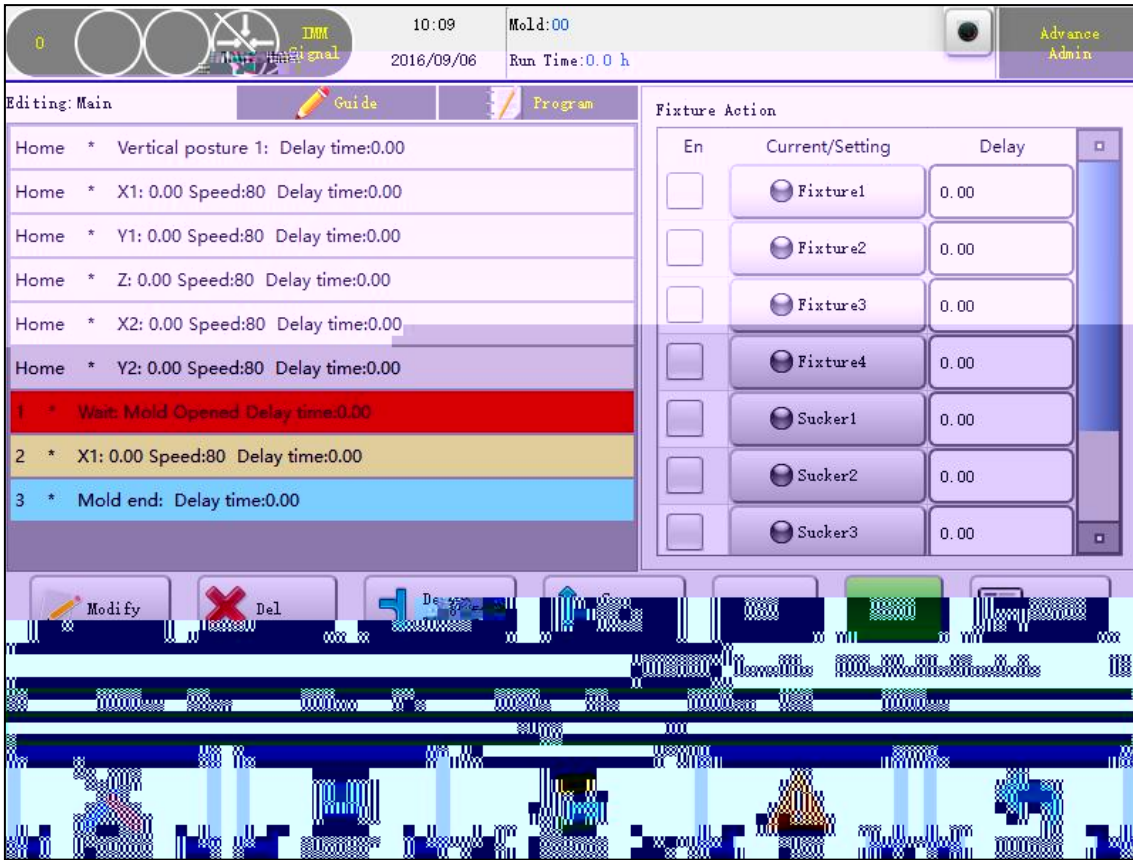
0
10:09
2016/09/06

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 Y: RP Z: P	2 2 2 10.00 10.00 10.00
Home *	X1: 0.00 Speed:80 Delay time:0.00	<input type="checkbox"/>	Group-2	X->Z->Y	X: P Y: RP Z: P	3 3 3 10.00 10.00 10.00
Home *	Y1: 0.00 Speed:80 Delay time:0.00	<input type="checkbox"/>	Group-3	X->Z->Y	X: P Y: RP Z: P	4 4 4 5.00 5.00 5.00
Home *	Z: 0.00 Speed:80 Delay time:0.00	<input type="checkbox"/>			X: P Y: RP Z: P	5 5 5 5.00 5.00 5.00



0 IMM Signal 10:10 2016/09/06 Mold:00 Run Time:0.0 h Advance Admin

Editing: Main Guide Program

Home * Vertical posture 1: Delay time:0.00

Home * X1: 0.00 Speed:80 Delay time:0.00

Home * Y1: 0.00 Speed:80 Delay time:0.00

Home * Z: 0.00 Speed:80 Delay time:0.00

Home * X2: 0.00 Speed:80 Delay time:0.00

Home * Y2: 0.00 Speed:80 Delay time:0.00

Injection

En	Current/Setting	Delay
<input type="checkbox"/>	Close Mold Permit	0.50
<input type="checkbox"/>	Ejection Permit	0.50
<input type="checkbox"/>	Ejection BW Permit	0.50

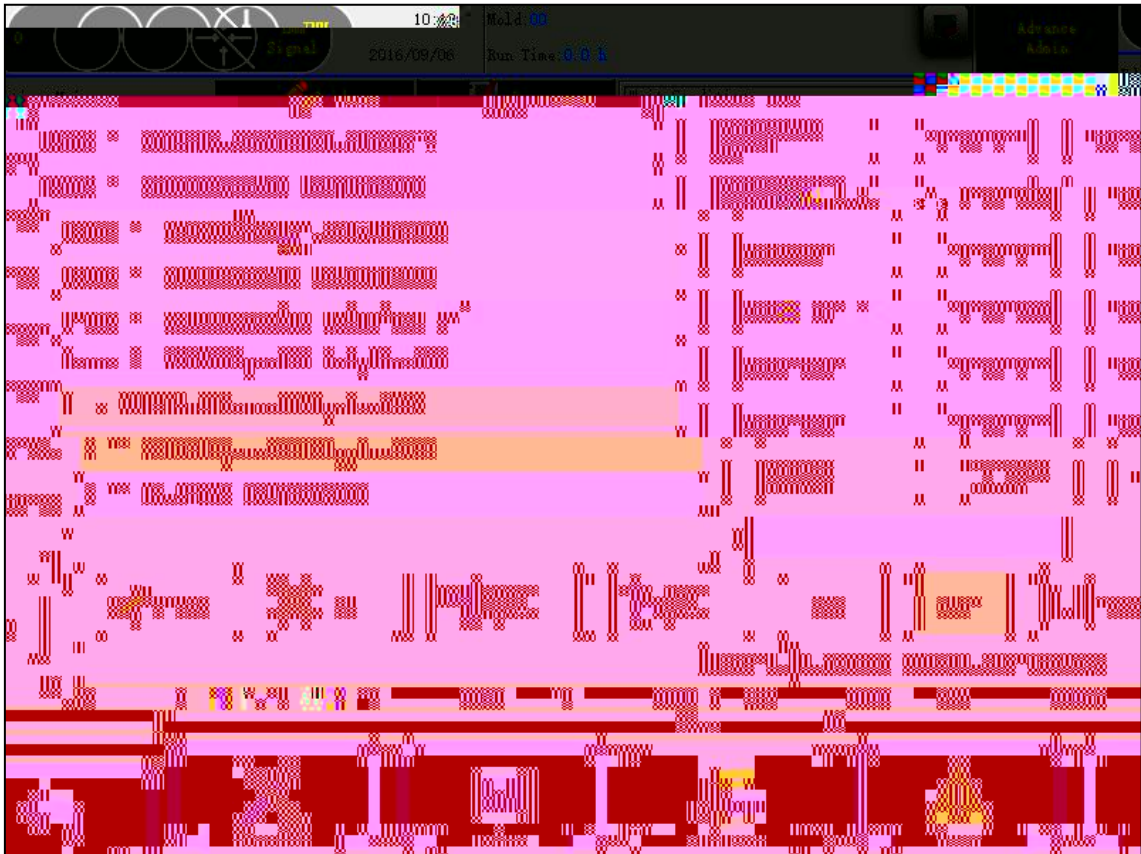
Wait Mold Closed Delay time:0.00

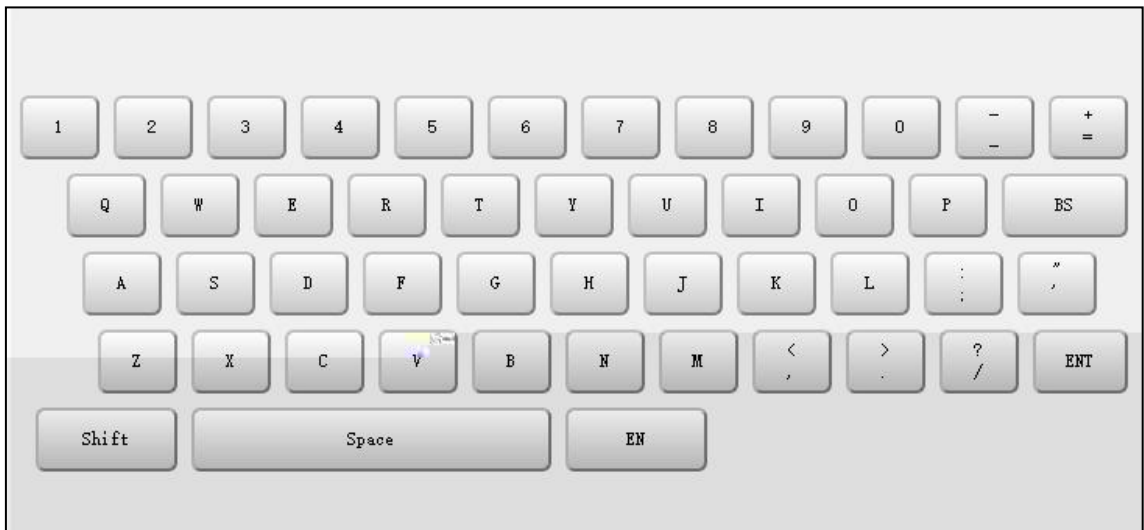
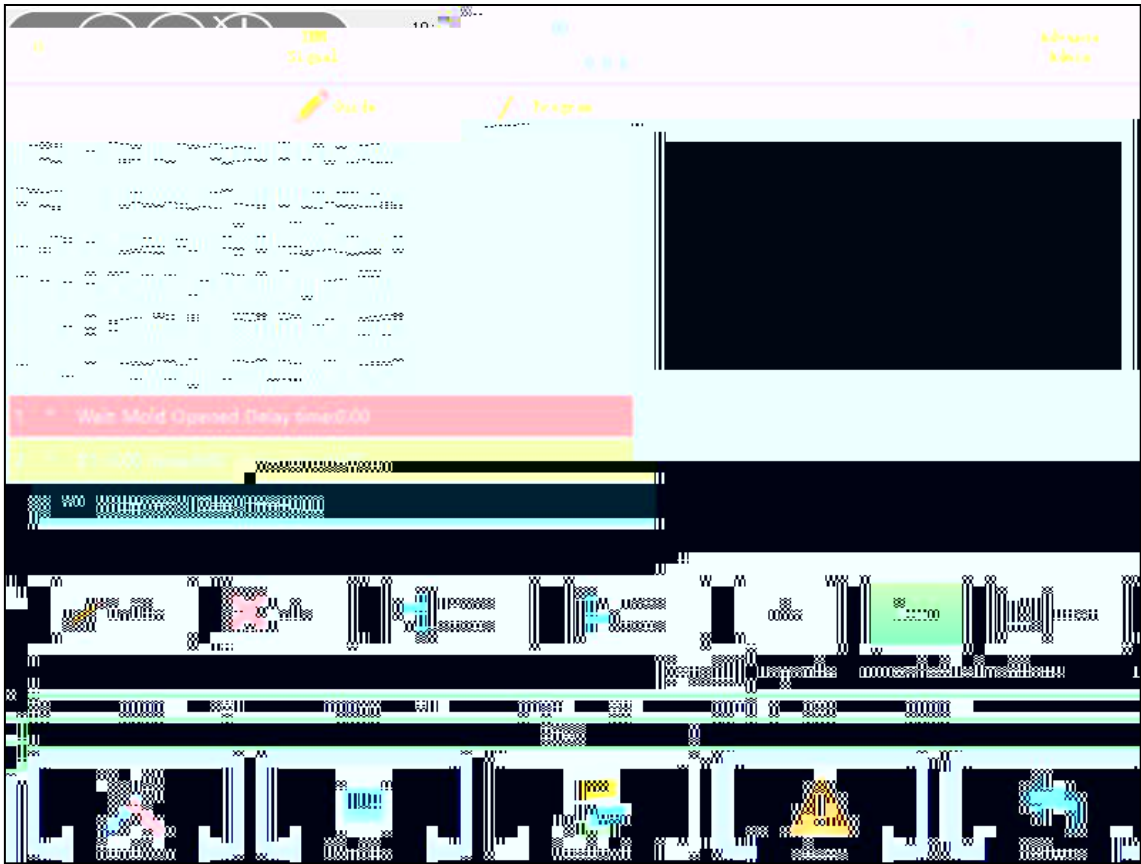
Mold Open Delay time:0.00

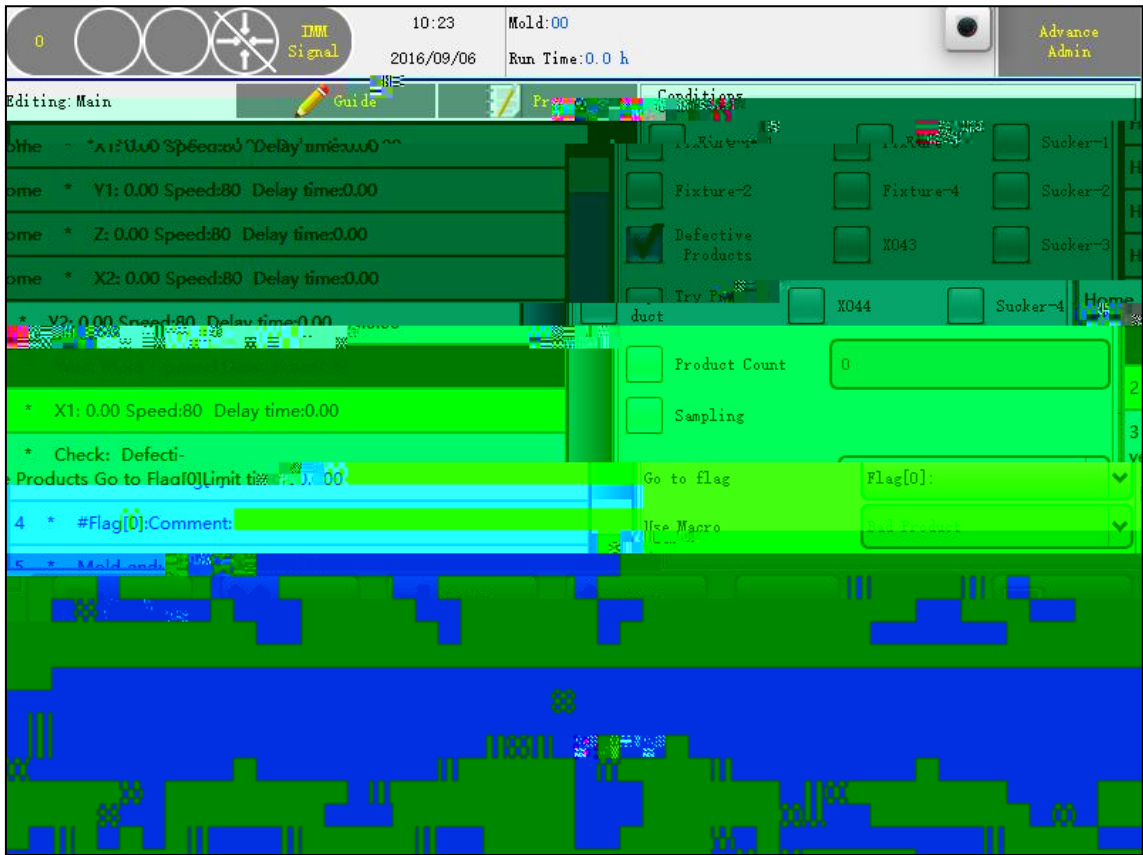
Function Monitor Instruct Alarm Return











Set

Position mm

speed %

Delay Time s

Early End

Early Speed-Down %

End Position mm

OK Cancel



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DMM
Signal

10:28

2016/09/06

Mold:00

Run Time:0.0h

Advance
Admin

✔
Signal Settings

⊞
Stack Settings

🔧
Product Settings

⚙️
System Settings

🔧
Machine Configure

⚙️
Struct Settings

✔
Security Point 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									

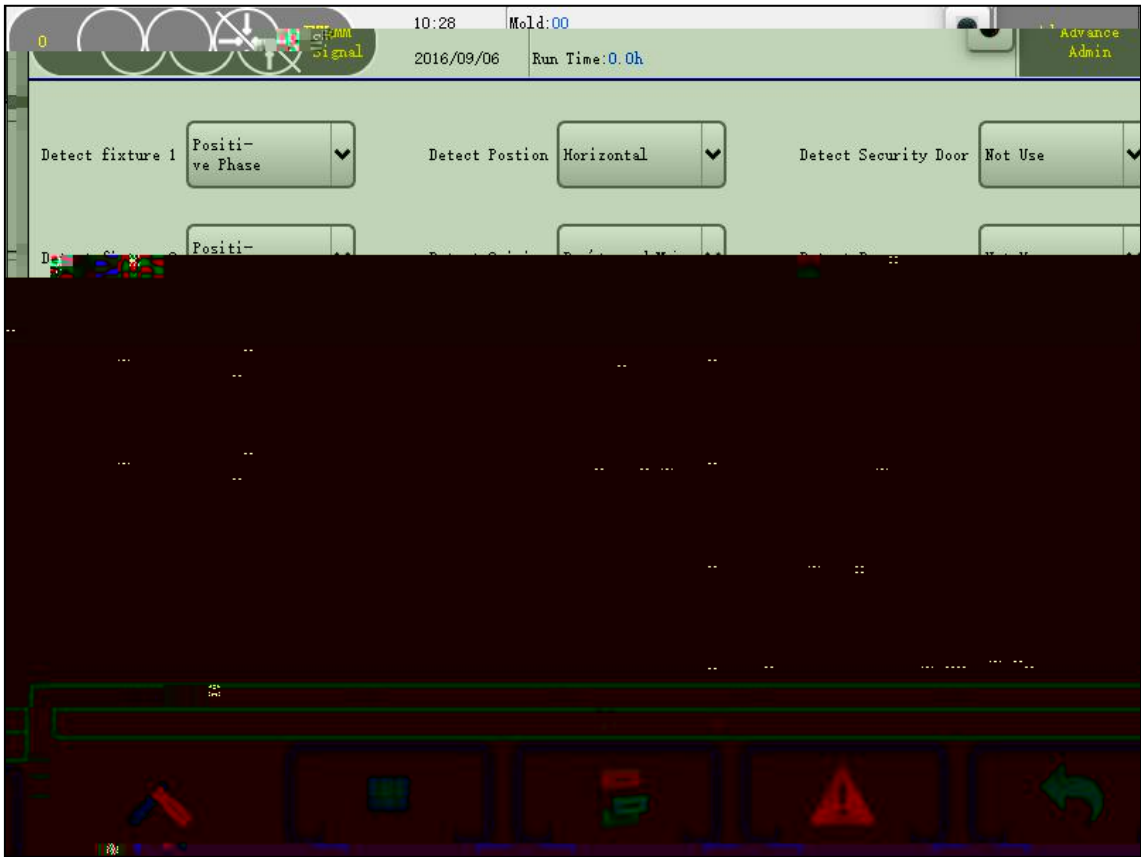
Function

Monitor

Record

Alarm

Return



0

10:29

2016/09/06

Mold:00

Run Time:0.0h

Advance
Admin

Product	<input type="text" value="10000"/>	Wait Mold Opened Limit Time	<input type="text" value="65.9"/> s
TryProduct	<input type="text" value="0"/>	Alarm Times	<input type="text" value="30"/> s
Sampling Interval	<input type="text" value="0"/>	Recycle Time	<input type="text" value="0.0"/> s
Get Fail	<input type="text" value="Alarm When Up"/> ▼	Fixture	<input checked="" type="checkbox"/> Positive Phase <input type="checkbox"/> Reversed Phase
		Count Ways	<input type="text" value="All"/> ▼
		<input type="checkbox"/> Product Save	<input type="button" value="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									

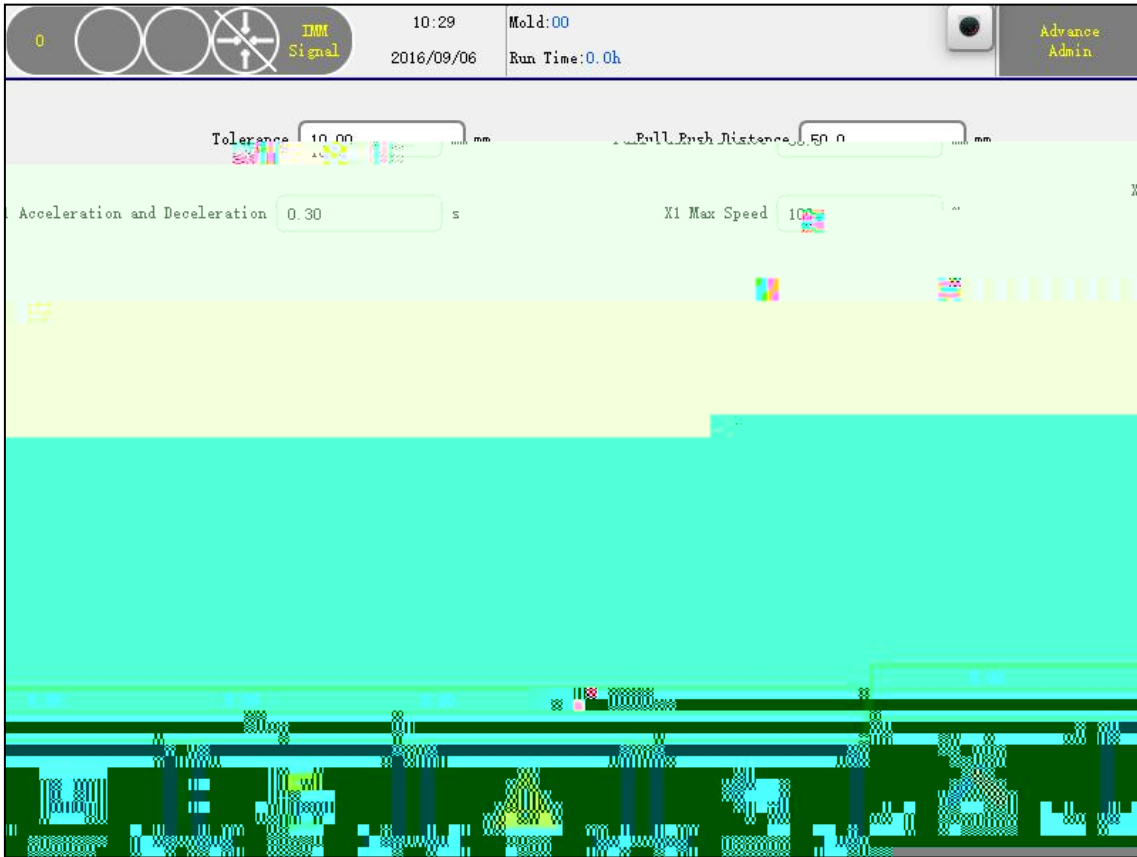
Function

Monitor

Record


Alarm

Return



> >

> >

0  DMM Signal 10:31 Mold:00
2016/09/06 Run Time:0.0h Advance Admin

X1 Axis Y1 Axis Z Axis X2 Axis Y2 Axis C Axis Figure

Security Point

Maximum displacement mm

Min pos inside mold mm

Max pos inside mold mm

Save

Test Feedback

Test

Feedback


Z Signal

+Test -Test Clear

Detail Loop Time 0.0 s Finished Products 16

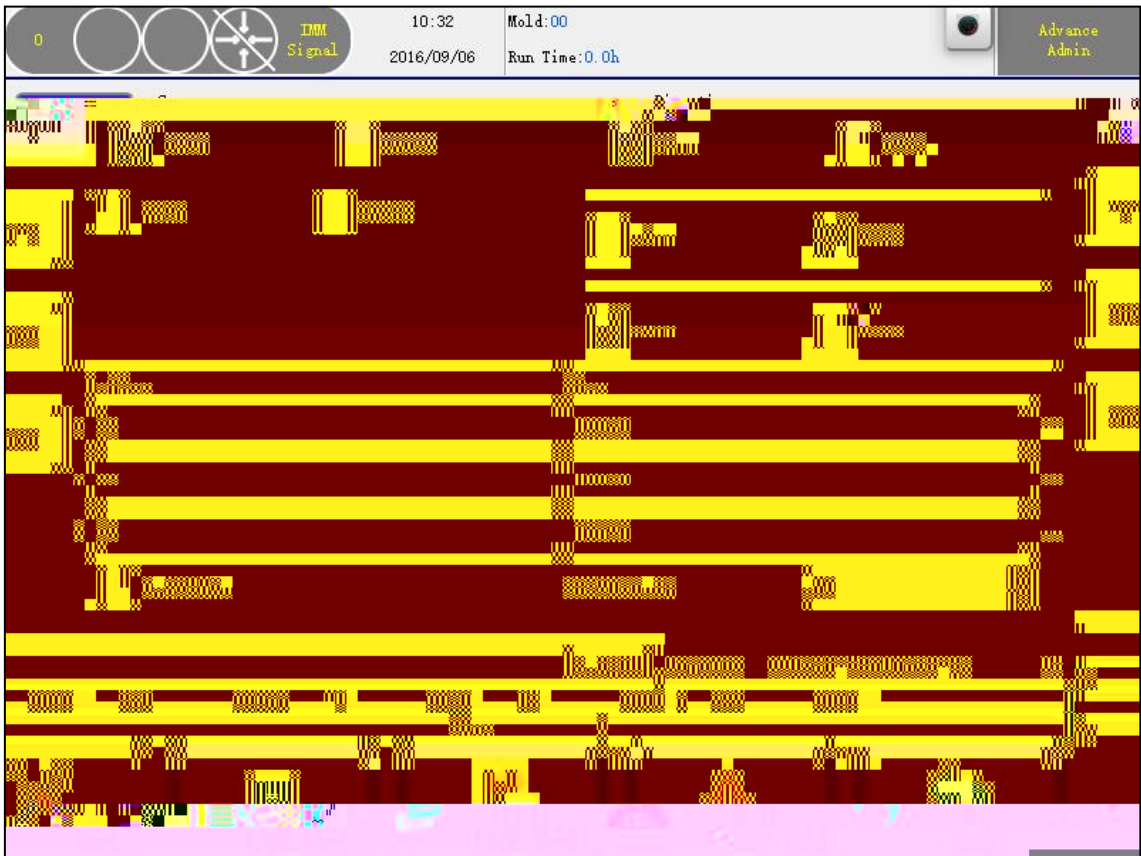
Z: 0.00mm X1: 0.00mm Y1: 0.00mm X2: 0.00mm Y2: 0.00mm

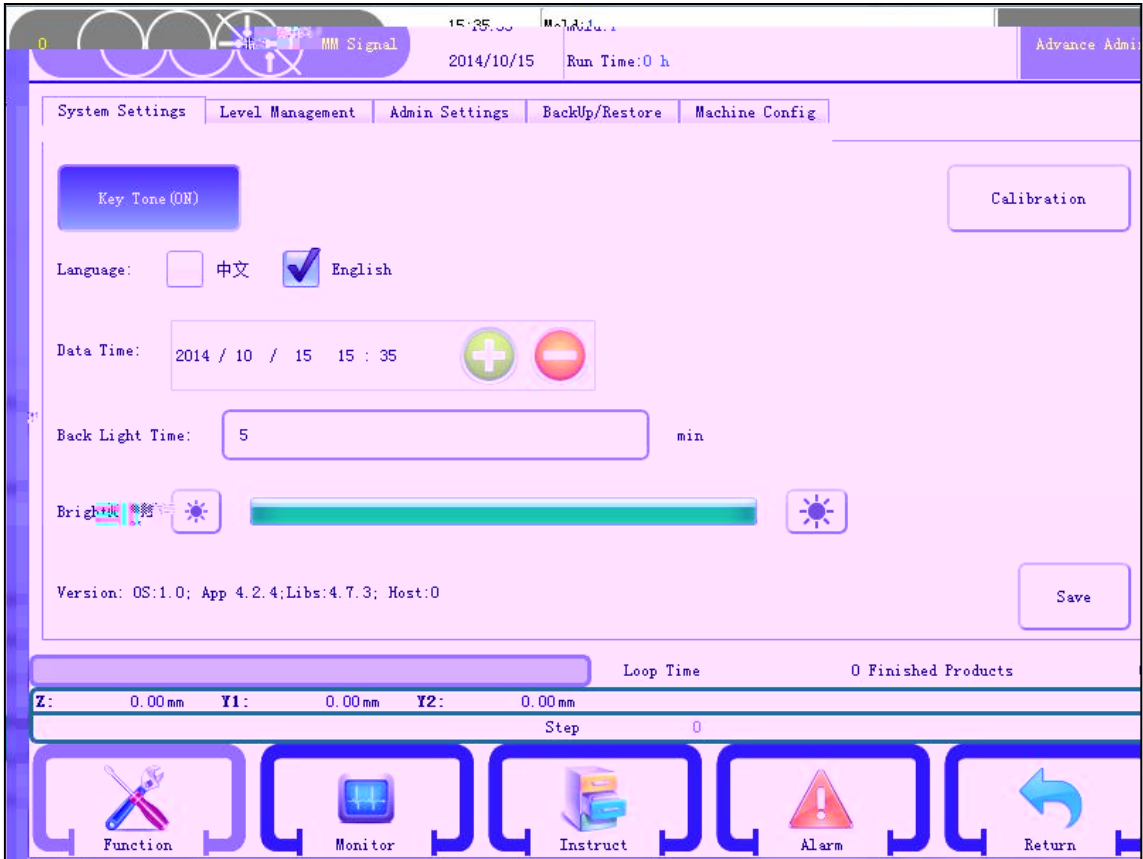
Step 0

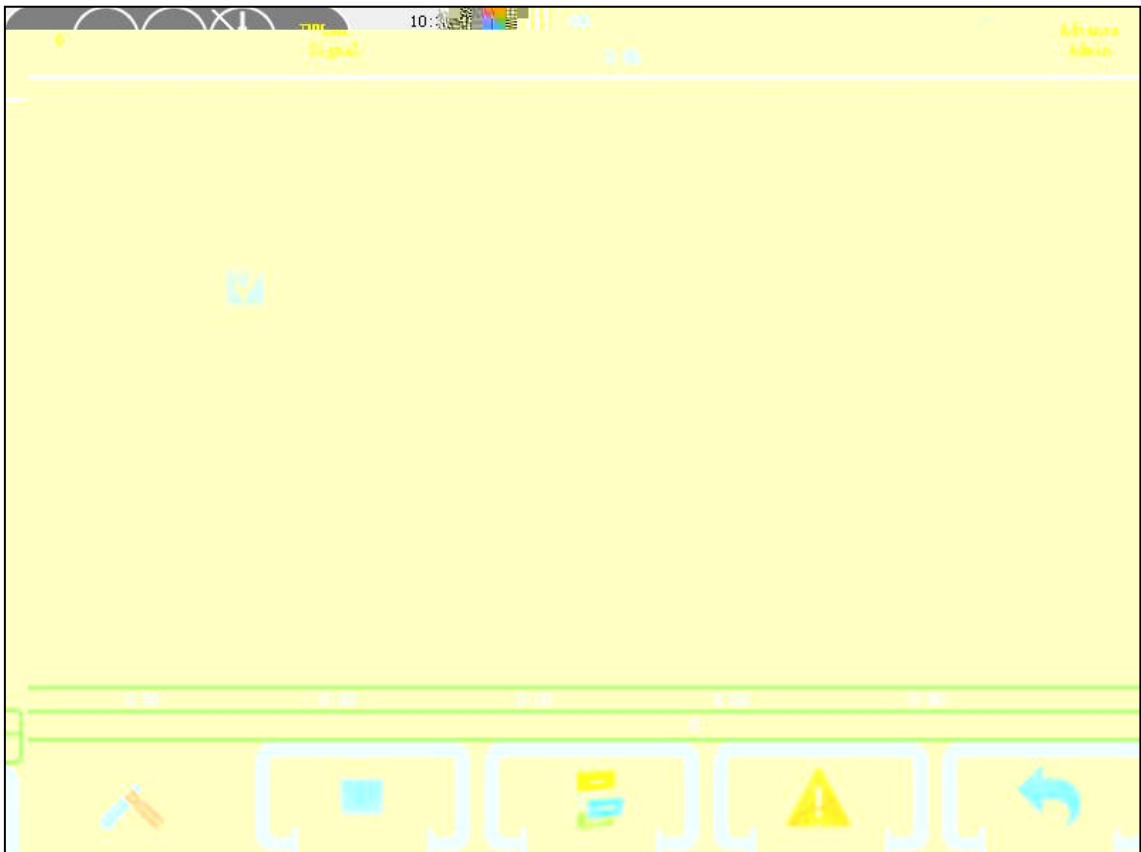


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0  IMM Signal 10:35 2016/09/06 Mold:00 Run Time:0.0h Advance Admin

System Settings Level Management Admin Settings BackUp/Restore

Backup

Backup Machine Configures

Backup System Configures

Backup All

Restore

Restore Machine Configures

Restore System Configures

Restore All




Unmount

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     **IMM**
Signal

10:36 Mold:00
2016/09/06 Run Time:0.0h

Advance Admin

X1 Axis Y1 Axis Z Axis X2 Axis Y2 Axis C Axis Struct Define Time

Security Point

Mechanical length mm

Maximum displacement mm

Min pos inside mold mm

Max pos inside mold mm

Distance/Rotation mm

Save

Test Feedback

Test

Feedback

Z Signal

+Test -Test Clear

Detail Loop Time 0.0 s Finished Products 1

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

Step 0

Function Monitor Record Alarm Return

0

IMM
Signal

10:39

2016/09/06

Mold:00

Run Time:0.0h

Advance
Admin

Maintain
Care

Name	Create Time

Update Logo

Scan Panel

Update HMI

Update Super Password

Back To Factory

Update Host Process:

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 15:40 Mold:1
 2014/10/15 Run Time:0 h Advance Admin

Manipulator I/O Injection Machine I/O Manipulator I/O Injection Machine I/O

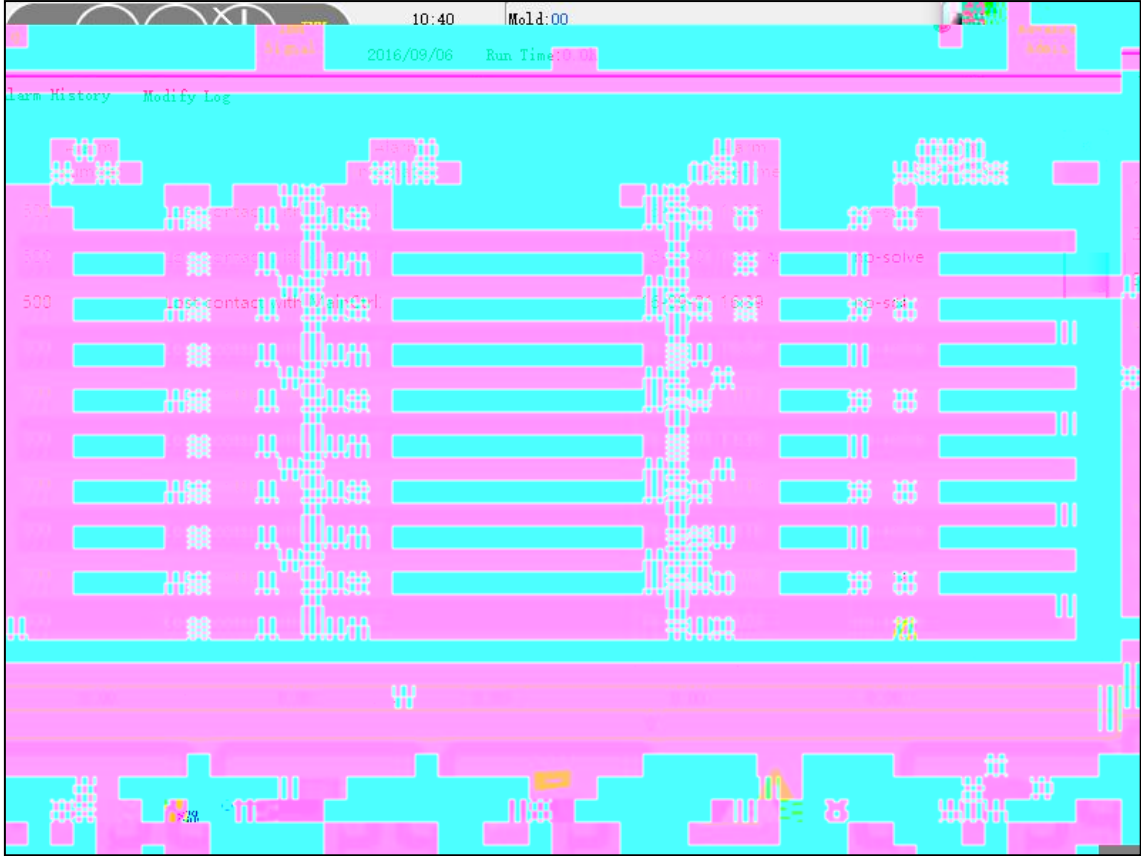
Input Output Input Output

10	Horizon-1	Y010	Horizon-1
11	Valve L-1	Y011	Vertical-1
X012	Fixture1	Y012	Fixture1 Valve
X013	Fixture2	Y013	Fixture2 Valve
X014	Sucker2	Y014	Sucker2 Valve
X015	Sucker1	Yr	Sucker1 Valve
X016	XI Out Limit	Y016	Main Forward Valve
X017	XI In Limit	Y017	Adjust Sub Back

Loop Time 0 Finished Products

Stop

Function Monitor Instruct Alarm Return



Alarm ID:	500
Alarm Text:	[Redacted]
Alarm Reason:	[Redacted]
Alarm Solution:	[Redacted]

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	55	to	66

Detail
Loop Time 0.0 s
Finished Products

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

Step

Factory

Monitor

Forward

Alarm

Return

22	-	
23		
24	-	
2	00	- 100
2	00	- 100
2	00	- 100
0	00	- 100
1	00	- 100
2	00	- 100
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113		2. ,
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133		-
134		- " "
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13		- " "
13		-
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		2. ,
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1 2	2	2.
1 0 2	2	,
1 1 2	2	.
1 2 2	2	1.
1 3 2	2	,
1 4 2	2	2.
1 2	2	,
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1 2		
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1 1 2	2	- " 2 - "
1 2 2	2	- " 2 - "

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3 3		
3 4		
3		

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<p>01 /</p> 		<p>1.</p> <p>2.</p> <p>3.</p> <p>4.</p>
<p>02</p> 		<p>1. -</p> <p>2.</p> <p>, -</p> <p>0</p>
<p>03</p> 		<p>1.</p> <p>2.</p> <p>, -</p>
<p>04</p> 		
<p>0</p> 		<p>,</p>
<p>0</p> 		<p>1.</p> <p>2. -</p>









<p>00</p> <p>,</p> <p>-</p>	<p>,</p> <p>()</p>	<p>1. -</p> <p>2. -</p>
<p>02</p> <p>,</p> <p>-</p>	<p>,</p> <p>()</p>	<p>1. -</p> <p>2. -</p>
<p>04 -</p> <p>,</p>	<p>(),</p>	<p>1. -</p>
<p>0</p>  <p>,</p>	<p>,</p>	<p>2.</p>
<p>0 2</p>	<p>(2), 2</p>	<p>2</p> <p>.</p>
<p>00</p> <p>043</p>		<p>1.</p>
<p>01</p> <p>044</p>		<p>2.</p>
<p>02</p> <p>1</p>		
<p>03</p> <p>2</p>		
<p>04</p> <p>3</p>		

<div style="text-align: center;"> $\begin{array}{c} 0 \\ \nearrow 4 \\ 0 \end{array}$ </div>		
<div style="text-align: center;"> $\begin{array}{cc} 0 & 1 \end{array}$ </div>		
<div style="text-align: center;"> $\begin{array}{c} 0 \\ 2 \end{array}$ </div>		
<div style="text-align: center;"> 0 </div>		
<div style="text-align: center;"> 0 </div>		
<div style="text-align: center;"> 10 </div>		
<div style="text-align: center;"> 11 </div>		
<div style="text-align: center;"> 1000 </div>	<ol style="list-style-type: none"> 1. $\quad \quad \quad ,$ 2. $\quad 1 \quad , \quad 1$ $\quad \quad \quad - \quad \quad -$ $\quad \quad \quad (\quad \quad \quad)$ 	<ol style="list-style-type: none"> 1. 2. $\quad \quad \quad -$
<div style="text-align: center;"> 1001 </div>	<ol style="list-style-type: none"> 1. $\quad 1 \quad , \quad 1$ $\quad -$ $\quad \quad \quad ,$ $\quad (\quad \quad \quad)$ 	<ol style="list-style-type: none"> 1. 2.
<div style="text-align: center;"> 1002 </div>	<ol style="list-style-type: none"> 1. $\quad 1 \quad , \quad 1$ $\quad -$ $\quad \quad \quad ,$ 2. $\quad \quad \quad ,$ $\quad \quad \quad ,$ $\quad (\quad \quad \quad - \quad \quad \quad)$ 	<ol style="list-style-type: none"> 1. 2.

1003 -		
1004		
100 	<p>1. - , 1</p> <p>2.</p> <p>3.</p> <p>4. 1 (), 1 .</p>	<p>1.</p> <p>2.</p> <p>3.</p>
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100 -	1 , 1 -	1. -
100	1 , 1 - ,	1. 1 2.
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1011 1	1 , - ,	-
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1021 ,	,	1.
1022 ,	,	2. ,
1023 ,	,	1.
1024 ,		2. ,

<p>102 ,</p> 	<p>1. ,</p> <p>, - ,</p> <p>2</p> <p>2. ,</p> <p>- , -</p> <p>, 2</p> <p>3. ,</p> <p>2</p>	<p>1. 2</p> <p>2.</p>
<p>102 -</p>		<p>1.</p> <p>-</p> <p>2.</p> <p>, -</p> <p>-</p>
<p>103</p>	<p>,</p>	
<p>103</p> <p>-</p>		
<p>1040</p>		<p>, ,</p>
<p>10 4</p> 	<p>-</p>	
<p>10</p> 	<p>,</p>	
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112	,	
112 ,	,	1. 2.
112 ,	- ,	1. 2.
1140 , -	,	1. 2. 3. , - -
1141 , -	, -	1. 2. 3. , - -
1142 ,	,	1. 2. 3. , - -

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<p>11 0</p> <p>,</p> <p>1</p>	<p>1.</p> <p>,</p> <p>-</p> <p>1</p> <p>2.</p> <p>,</p> <p>-</p> <p>,</p> <p>1</p> <p>/</p> <p>3.</p> <p>,</p> <p>-</p> <p>1</p> <p>/</p>	
<p>11 1</p> <p>,</p> <p>1</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>/</p> <p>3.</p> <p>,</p> <p>-</p> <p>,</p> <p>1</p> <p>/</p>	
<p>11 2</p> <p>,</p> <p>1</p>	<p>,</p> <p>,</p>	<p>1</p>

<p>11 3 1 , 1</p>	<p>1 , 1</p>	<p>1. 1 2. 1</p>
<p>11 4 1 , 1</p>	<p>1 , 1</p>	<p>1. 1 2. 1</p>
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<p>11 0 2 ,</p>	<p>1. , - , 2 2. , - , 2 / 3. - , 2 /</p>	
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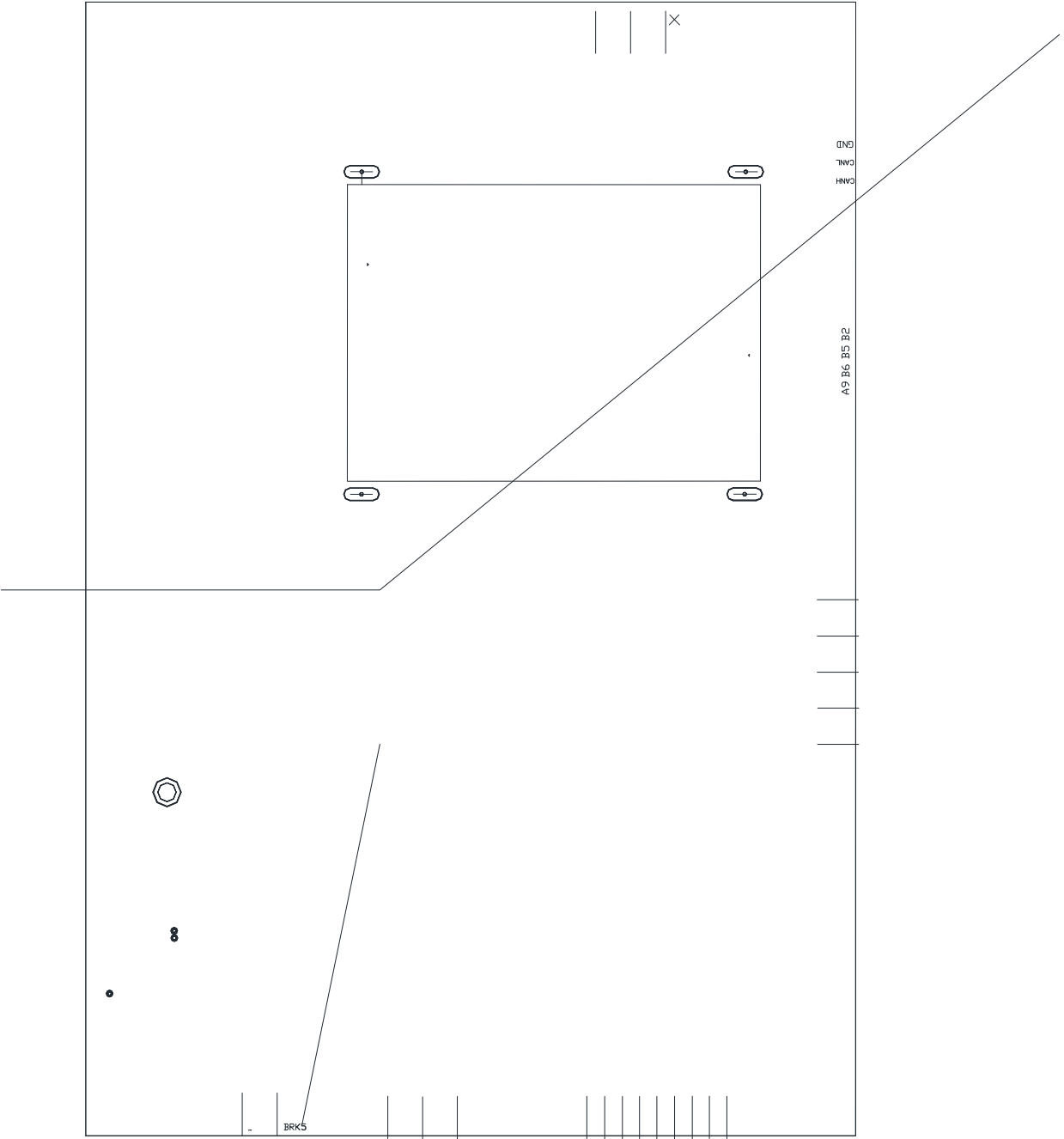
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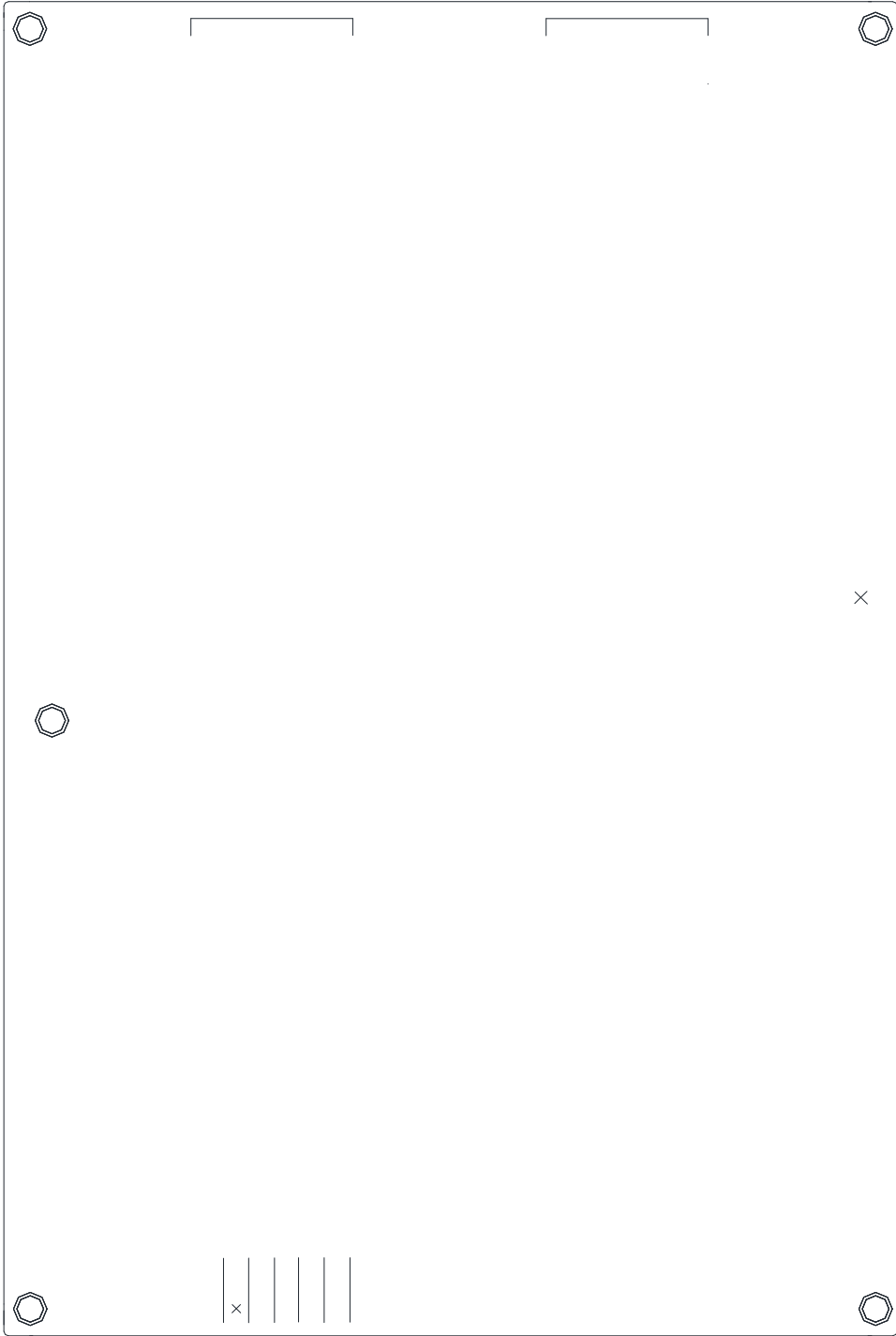
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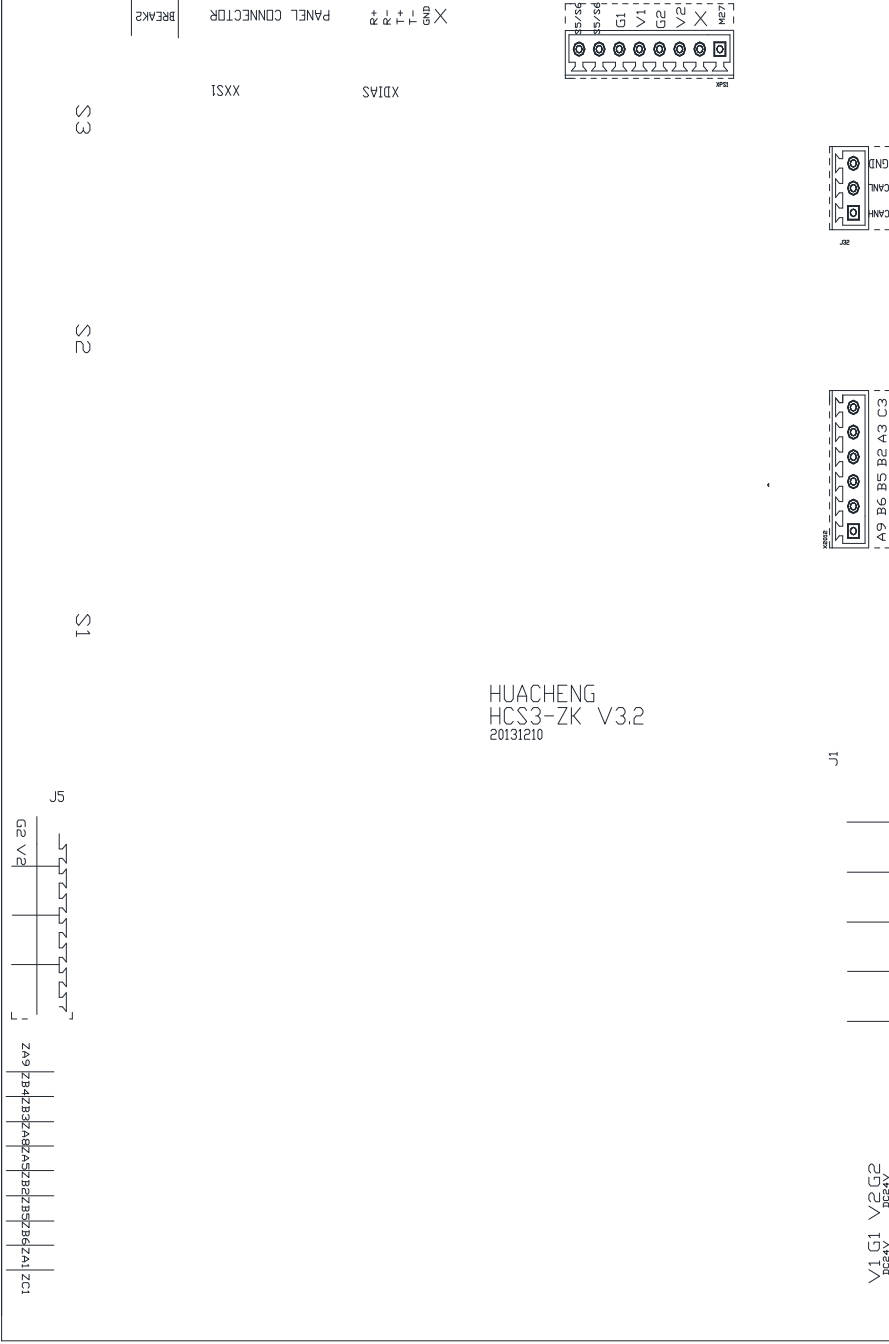
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HUACHENG
HCS3-ZK V3.2
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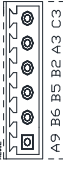
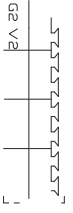
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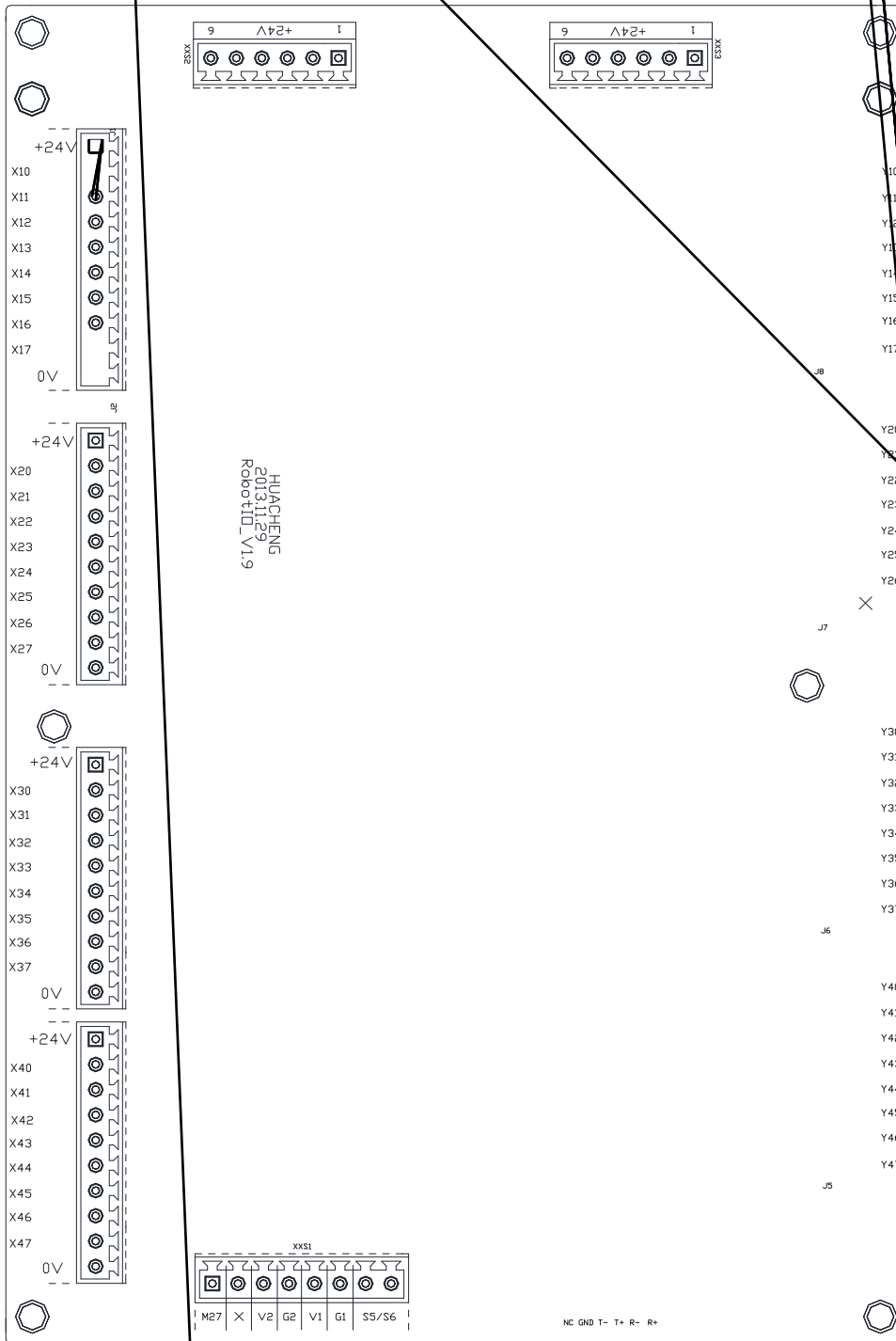
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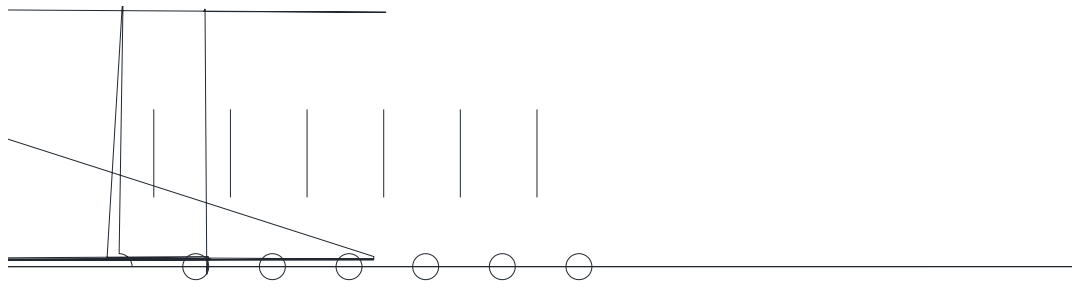
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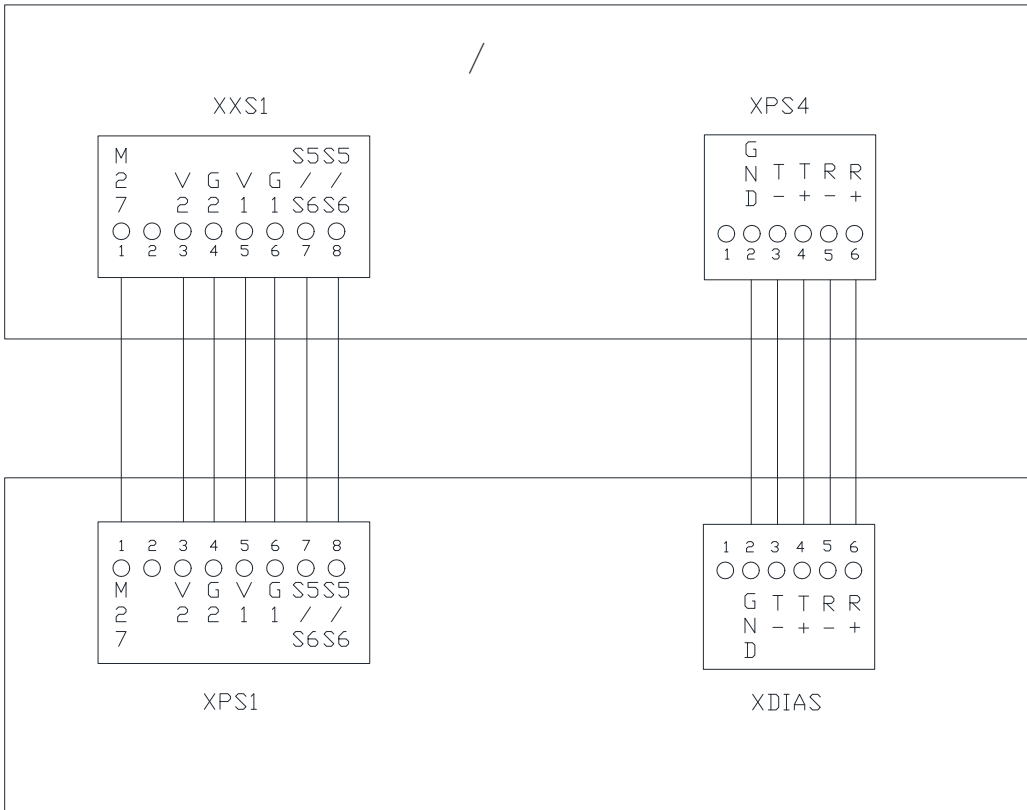
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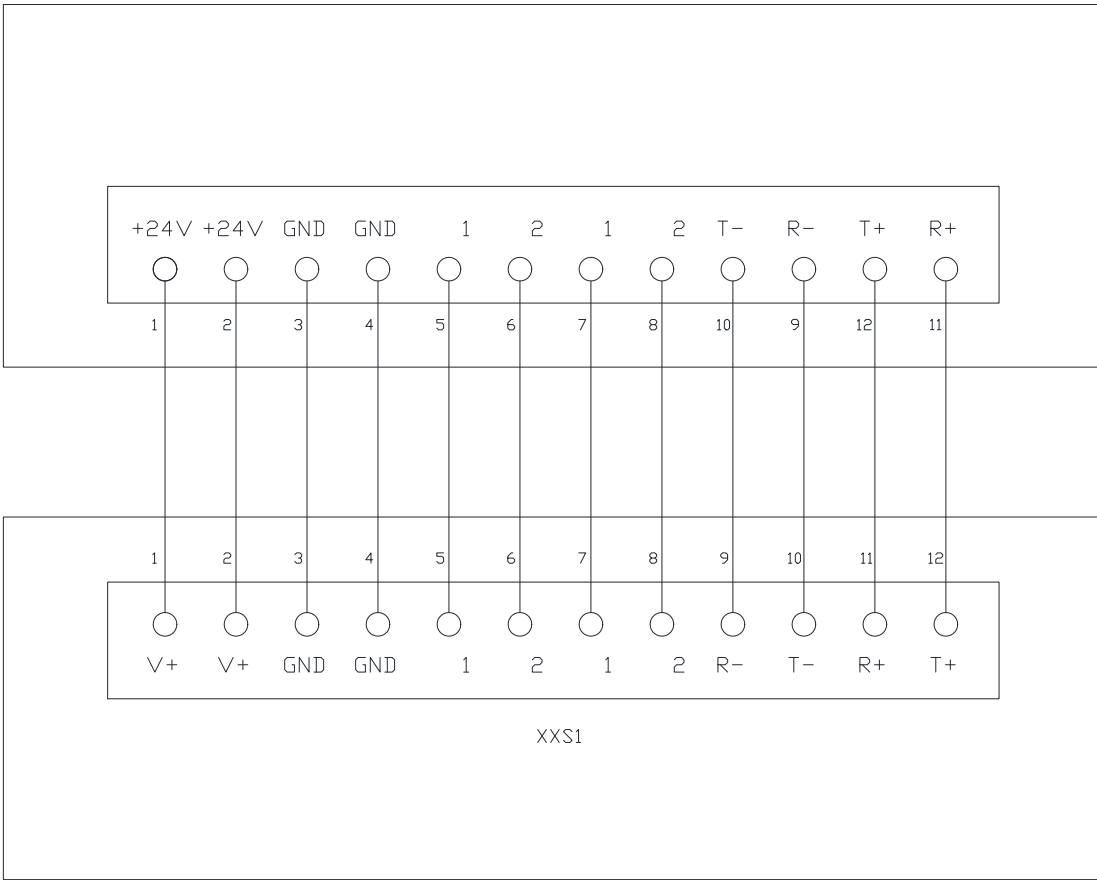
BREAK2

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