

Color Doser Machine

Instruction Manual



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1. Link power to enter (Figure 01) Login password: "8"

【-Figure 01-】

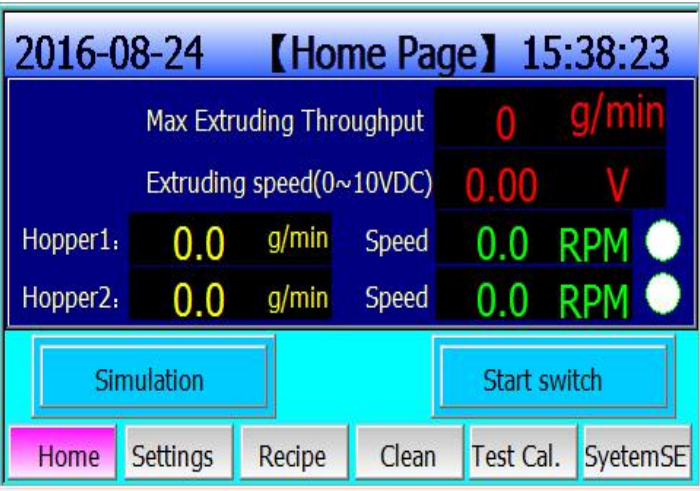


This image for boot screen!

2. Use the following:

1) Touch  go into:

【-02-】



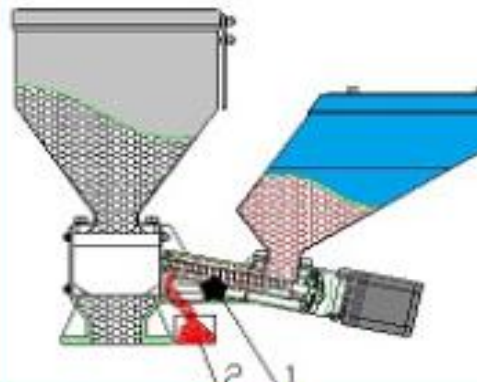
EXTRUSION

2) According to the touch screen below the [settings] button, enter the parameters set the screen, set the working mode and the corresponding parameters;

2016-08-24		【Settings】		15:43:54	
Shot weight(one cycle)	0.0	g	Speed	0.0	RPM
Time for plasticizing	0.0	s	Speed	0.0	RPM
Hopper 1 percentage	0.0	%	Metering Hopper1: compensation	0.00	
Hopper 2 percentage	0.0	%	Hopper1:	0.00	
Mixing time	0.0	s	Mixer	开	
Work Mode INJETION MOLDING					
Home	Settings	Recipe	Clean	Test Cal.	SytemSE

2016-08-24		【Settings】		15:45:13	
Max Extruding Throughput	0	g/min			
Voltage adjustment values			0.00	V	
Hopper 1 percentage	0.0	%	Speed	0.0	RPM
Hopper 2 percentage	0.0	%	Speed	0.0	RPM
Mixing time	0.0	s	Mixer	开	
Work Mode EXTRUSION					
Home	Settings	Recipe	Clean	Test Cal.	SytemSE

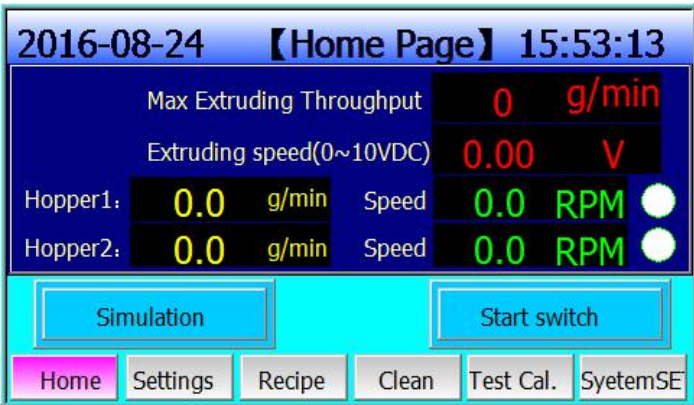
3) Press the [Test Cal.] button below the touch screen to enter the test calibration screen, according to the help step into the 50 seconds of the test process, after the completion of the weight of 50 seconds to enter the test.

2016-08-24		【Screw Test 1】		15:49:12	
					
Help: 1) loosen the plum flower nut 1; 2) put a collection bucket 2; 3) press Filling button, nutil materia discharge; 4) filling finished, press TEST button; 5) shows testing, waiting to finish; 6) Materia is weighted to obtain 50sec through; 7) Input weight data.					
Filling		TEST			
Input testing Weight:		0.0	g	page down	EXIT

4) Test calibration is completed, press [page down] button, enter [Home], press the start switch;



INJECTION MOLDING



EXTRUSION

Start switch is pressed. When injection and extruder began to move, and signal into masterbatch machine, color masterbatch machine will automatic operation.



3. Factory user level and password:

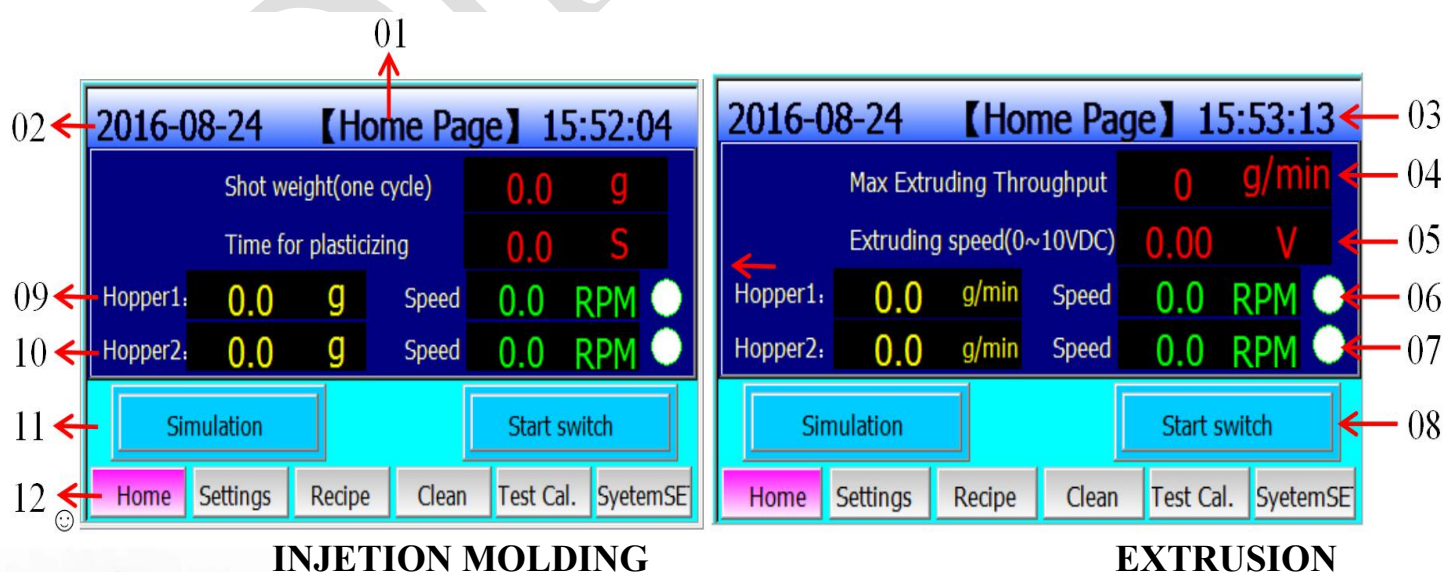
Grade	Class name	Login password	Operating range
00	Ordinary grade		Browse the machine running status and parameter settings, control the machine start and stop
01	Administrator level	2222	Most of the parameter settings
02	System level	3333	Single time simulation, working mode setting, voltage compensation value setting.

Be careful : *Password can be changed in the user management screen, but be sure to remember the modified password!*

4. Detailed picture:

01】: Home

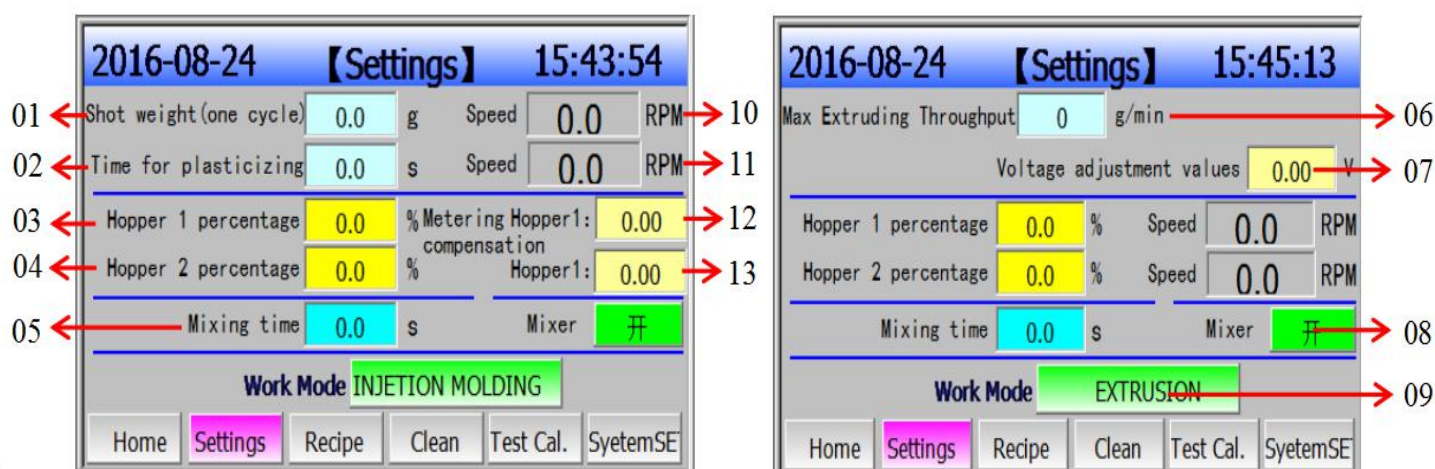
After the machine is in power, the touch screen displays the initial picture. After about 20 seconds to automatically enter the operation of the screen / or touch [Enter button] into the operation screen.



——Display-operation picture——

NO	Project	Describe
01	Picture label	Displays the label for the current picture.
02	Date display area	Display the current date.
03	Time display area	Display current time.
04	Per die weight / maximum extrusion parameters display	Under different working modes, the corresponding parameters are automatically displayed.
05	Sol time / extruder feedback voltage value display	Under different working modes, the corresponding parameters are automatically displayed.
06/07	Metering motor working status display	White = stop state; green flash = running state.
08	Start switch	Automatically run the boot switch, turn green when the state.
09/10	The demand for the 1 and 2 of the display group	Injection molding mode: the 1, 2 of the demand for each model. Extrusion mode: display component 1, 2 minute volume of feed.
11	Single analog button	Injection mode: click, to simulate a sol signal input; Extrusion mode: click, run for a minute;
12	6 function buttons	Click to enter the relevant picture.

02】: Parameter setting screen

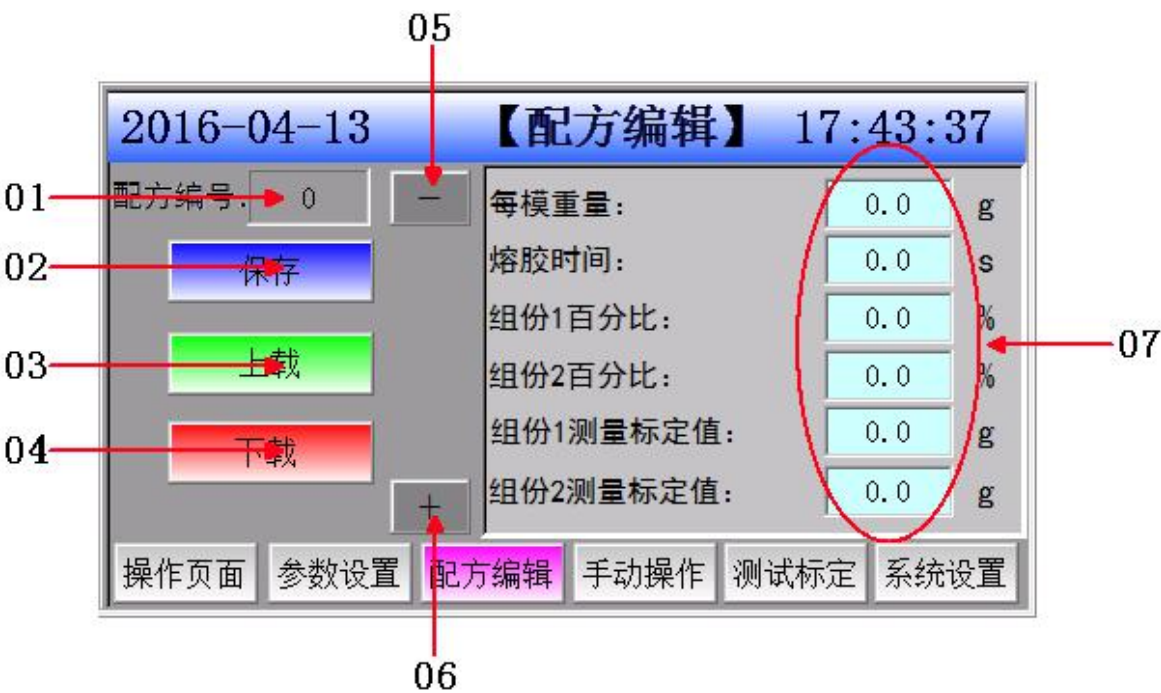


——Parameter setting screen——

NO	Project	Describe
01	Injection molding machine, the total weight of each set	Input injection molding machine weight per die (product weight + nozzle weight)
02	Injection molding machine sol time	And the injection molding machine operation on the computer display of the sol time can be set, if there is a small amplitude fluctuations, take the average value of three times.
03	Percentage of group 1	The input component 1 (Color Masterbatch percentage). For example: 25kg production process of raw materials, 1kg Color Masterbatch, then the proportion of: $1 / (1+25) = 0.0384 = 3.84\%$ Ratio of 3.84 can be entered.
04	Percentage of group 2	Percentage of input group of 2 (recycled material or additive).
05	Stirring time	Injection Molding Machine Mode: When there is a sol signal, the agitator starts, and when the sol signal ends, the agitator continues to run. Extruder mode: The agitator runs continuously and synchronously (stirring time does not work).
06	Maximum extrusion capacity of extruder	The extrusion quantity of the input extruder in the frequency converter analog voltage value in the 10VDC state.
07	Voltage compensation value	When the value of the voltage is different from the actual measured value, the input value is a compensation value. In order to maintain consistency.
08	Stirring motor switch	[off] to turn off the blender, [open] indicates that the agitator is enabled.
09	Working mode	Click to select [injection molding machine mode] or [extruder mode].
10/11	Display working speed	Display operating speed
12/13	Measurement compensation	Users can modify the running speed of the motor parameters according to the actual situation, such as screw actual output (melt time screw fanout is 9g, and actual demand for 10G, this time the need for modifying the parameter of motor speed, the correction value $= 1 + (10-9) / 10 = 1.1$



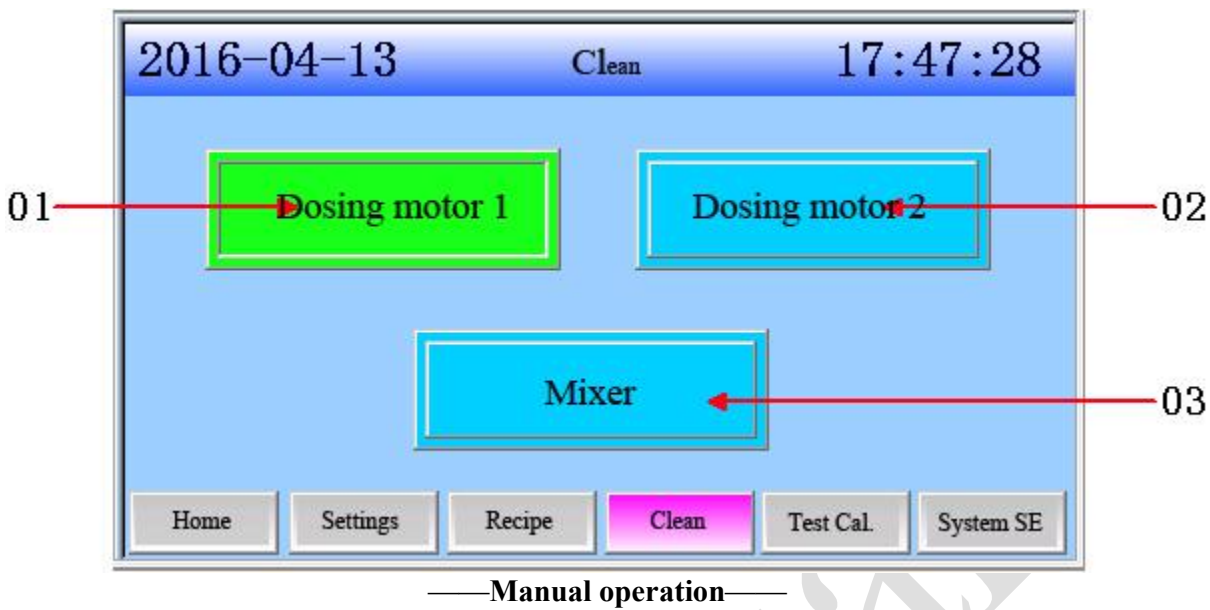
03]:【Recipe】



——Recipe——

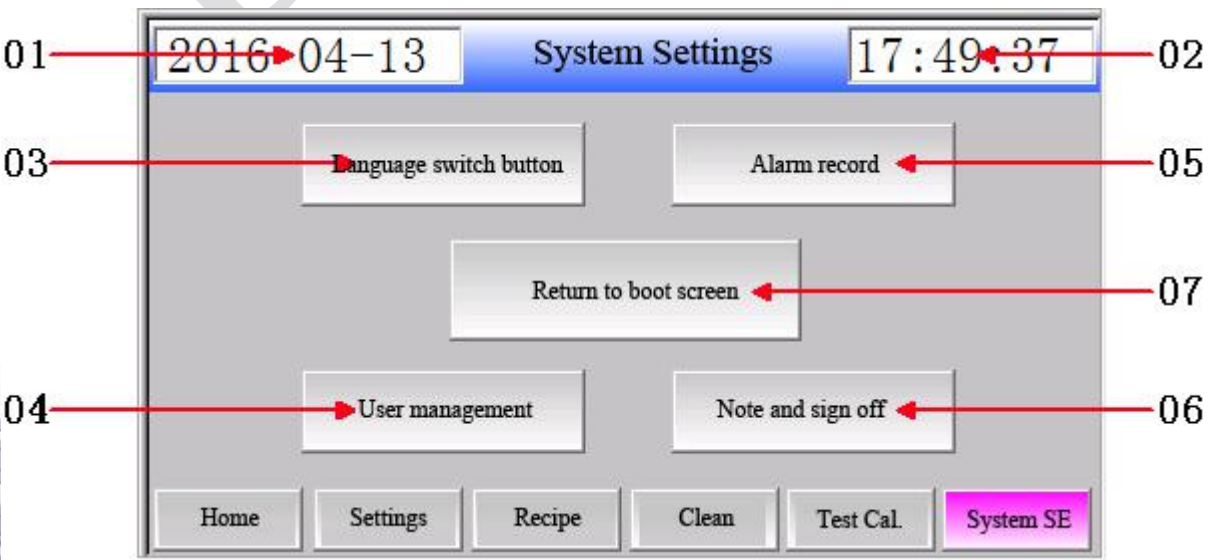
NO	Project	Describe
01	Number:	Shows the current recipe number
02	SAVE	When uploading a recipe or change the content of the recipe element, it is required to press the Save button to confirm the save.
03	UPLOAD	The parameters that are being used are transferred to the current recipe number element.
04	DOWNLAOD	The elements of the current formula are transferred to the parameters used.
05	View a recipe button	View on a recipe (a total of 100 recipes)
06	View the next recipe button	Look at the next recipe (a total of 100 recipes)
07	Formula element	Can be manually edited or through the upload button, the parameters are being used to import.

04】:【Manual operation】



NO	Project	Describe
01	Dosing motor 1	In the [start] off state, manually start the metering motor 1
02	Dosing motor 2	In the [start] off state, manually start the metering motor 2
03	Mixer	In the [start] off state, manually start the blender

05】:【SYSTEM SET.】



—SYSTEM SET.—

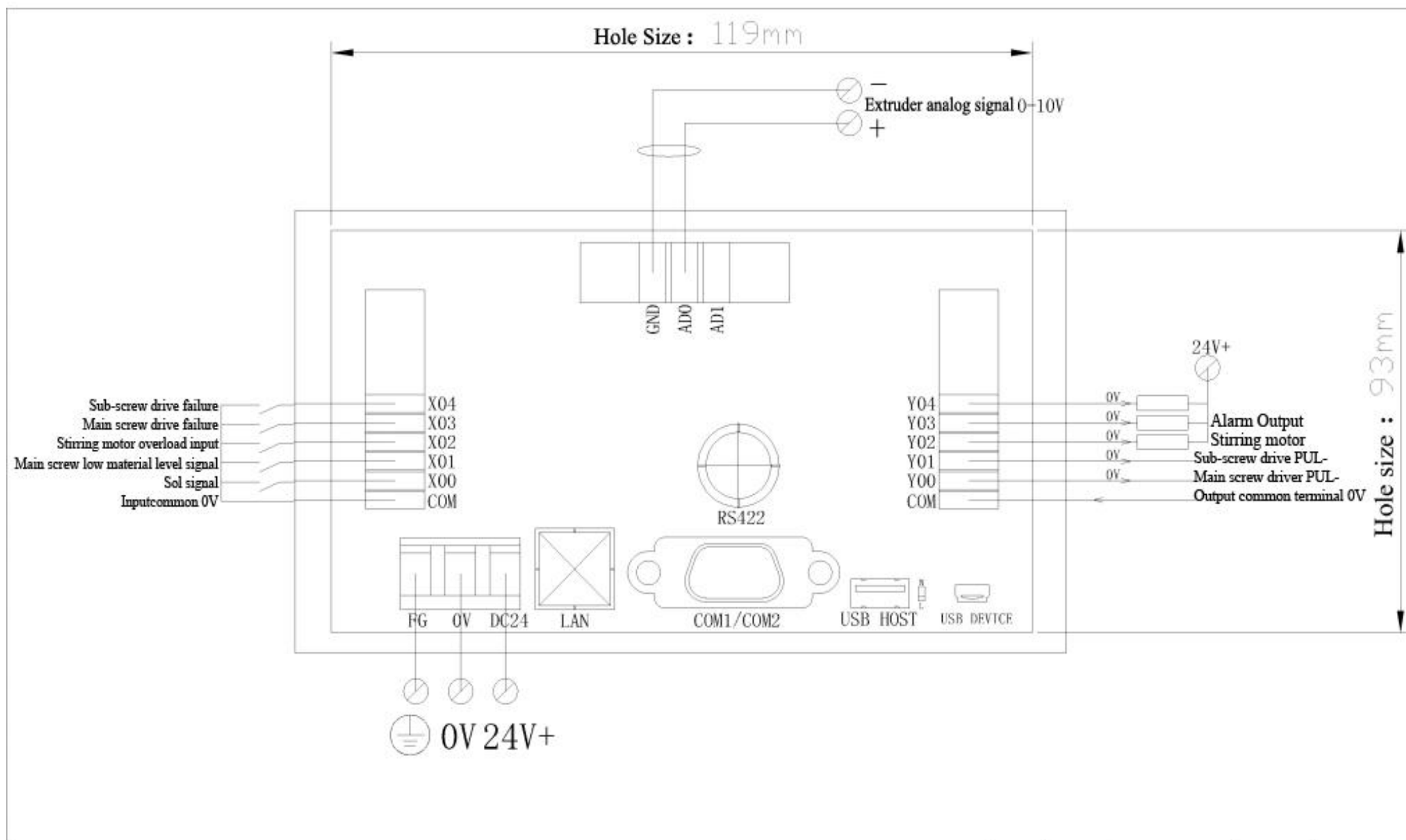
NO	Project	Describe
01	Date setting	Adjust system date.
02	Time setting	Adjust system time.
03	Language switch button	Click to toggle the display screen
04	User management	View, modify the administrator and system level password
05	Alarm record	View, early warning information.
06	Note and sign off	When you leave the operation, you can manually log off the login operation. Ensure that changes to the parameters require password confirmation.
07	Return to boot screen	Returns the initial boot first screen.

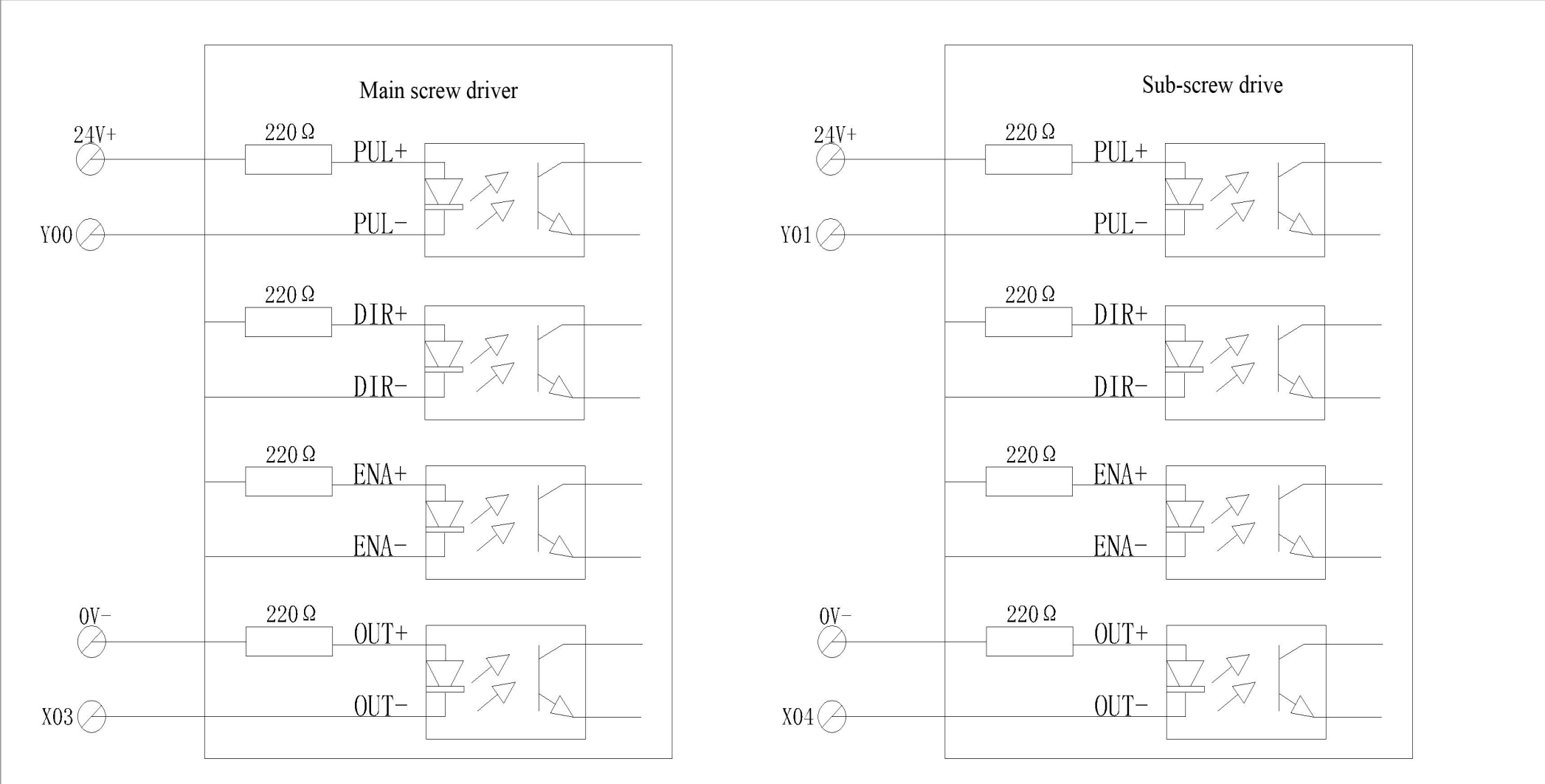
06】: System alarm contents and methods

NO	Fault content	Trouble shooting
01	Calculated 01 motor speed exceeded 200RPM.	1 check the parameter setting is reasonable; 2 to replace the larger model of the screw.
02	Calculated 02 motor speed exceeded 200RPM.	1 check the parameter setting is reasonable; 2 to replace the larger model of the screw.
03	Meter 01 low level alarm!	1 loading materials; 2 false action, to re adjust the sensitivity of the material level switch.
04	Motor overload!	Check the agitator.
05	Meter 01 stepper motor driver alarm!	Check the stepper drive, the red light / green light is flashing, flashing lights, and manufacturers contact.
06	Meter 02 stepper motor driver alarm!	Check the stepper drive, the red light / green light is flashing, flashing lights, and manufacturers contact.



5. Wiring diagram





Drive interface	Interface function	Terminal wiring method
GND	DC power ground	Switching power supply 0V
VDC	DC power supply positive	Switching power supply 0V
A+ A-	Motor A phase	White---A+; Red---A-
B+ B-	Motor B phase	Black---B+; Yellow-green---B-