Plastic drop machine   Setting

1. Machine set file / pin okay

1.1 We use parallel injection guns for mold injection .

S/N	Pin 1 (color 1)	Pin 2(color 2)	Pin 3(color 3)
Machine	Injection gun 1	Injection gun 2	Injection gun 3
	Injection gun 4	Injection gun 5	Injection gun 6

pin 1,pin 2, pin 3,
pin 4 groups.MP4

Video :

2.2 install pins for machine

There are 9 different pins ,   according to mold inside figure size to choose pin size .

① use pin tip to measure mold inside figure .

② loose the injection gun cap to put pin on injection gun and cover the cap and tighten.   2 parallel injection guns install same size pin .
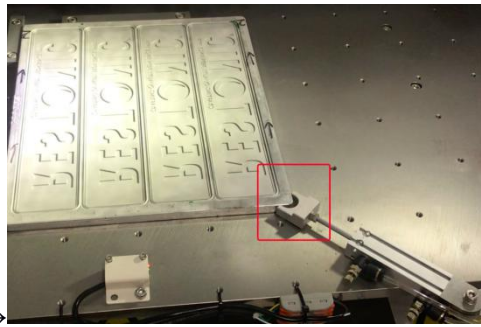
2.2 About the mold size and cross'十' distance

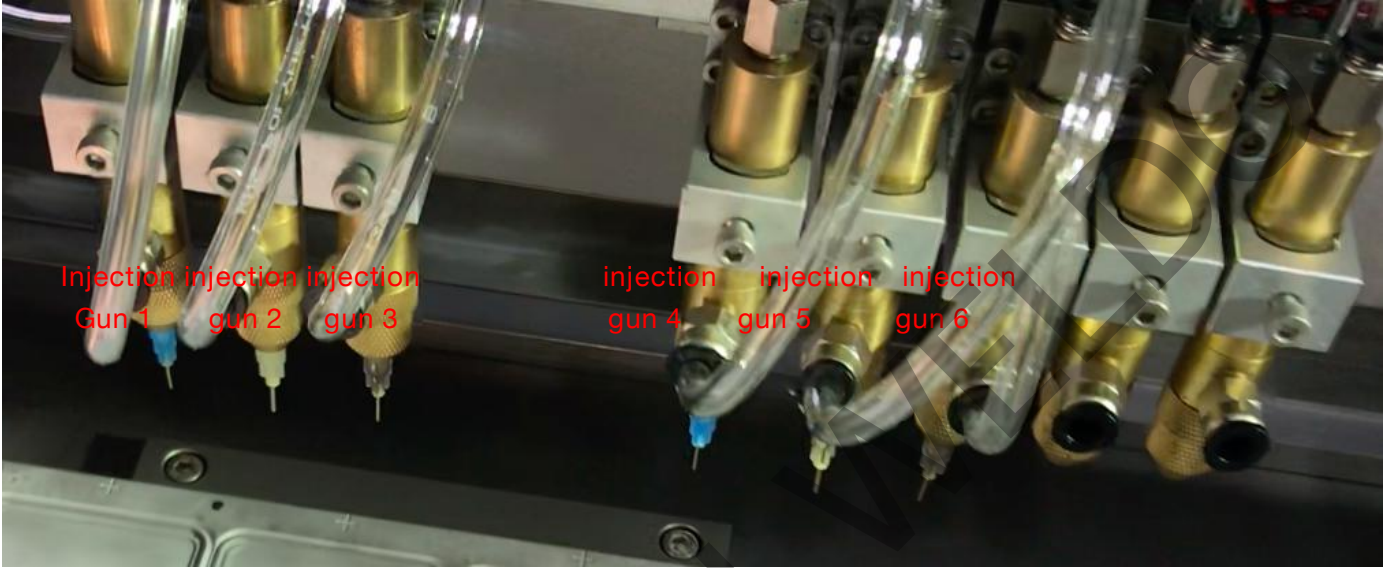① : the mold short side with 4 crosses '十 w gun side .

② all molds size , cross position , and cross distances are all the same , just use any one mold to set file / pin okay .
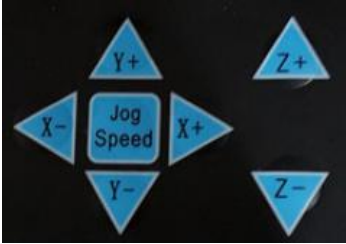
2.3 set file /pin okay at machine .
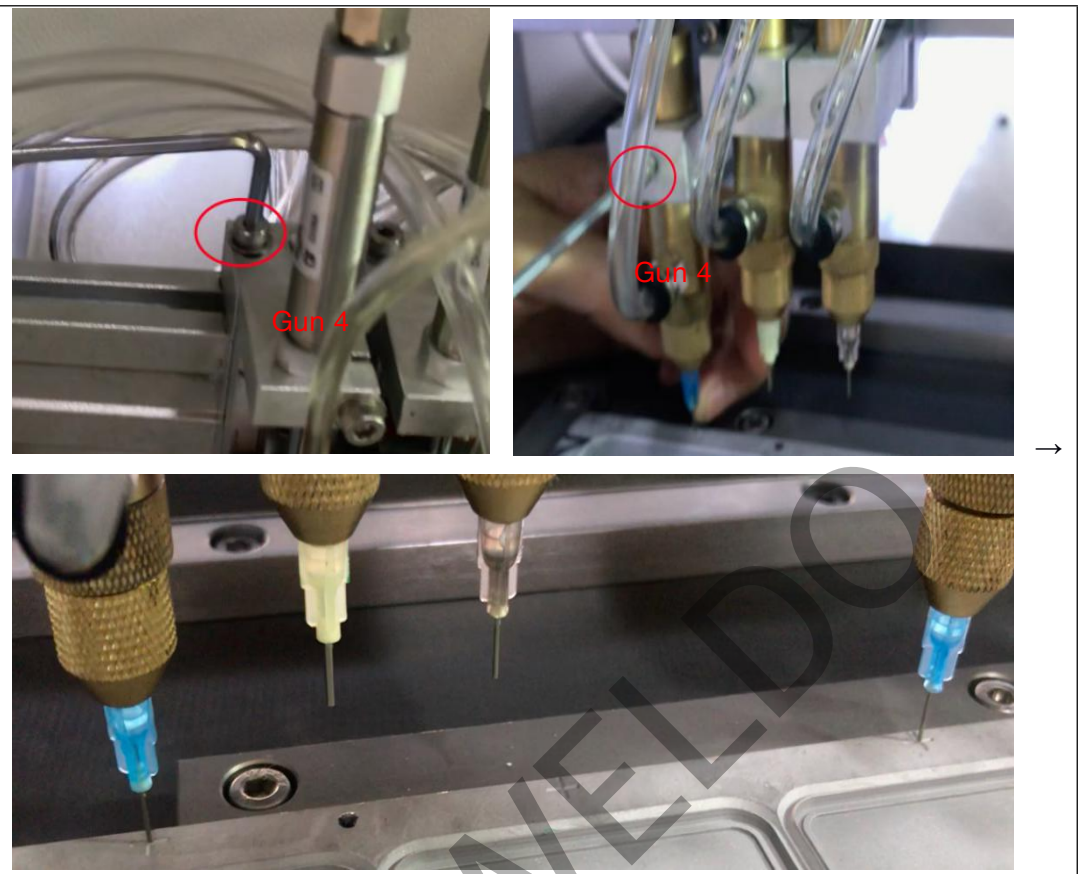
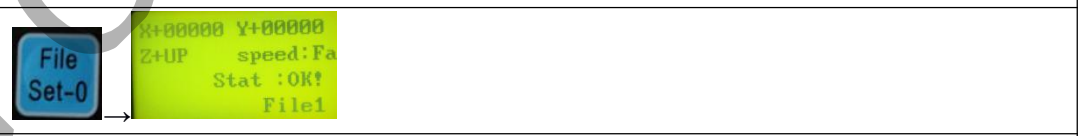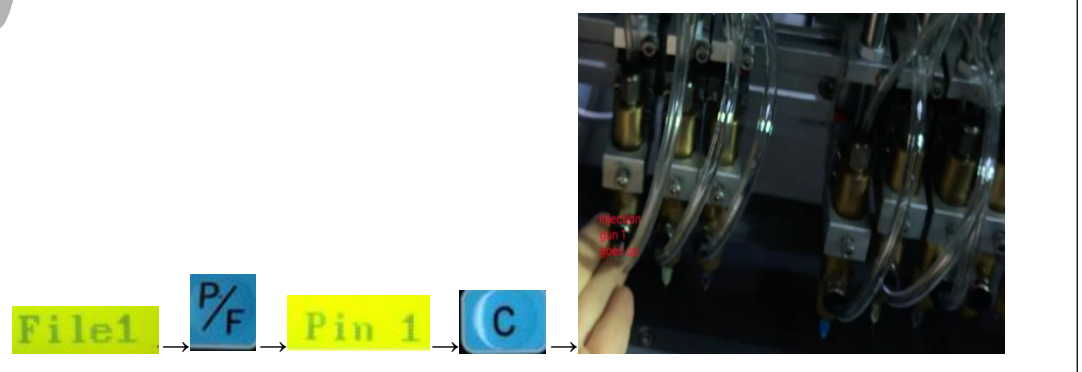① open 'Cylinder ' button on machine , put a mold on machine 2 table, press' LT Clamp' or 'RT Clamp' to fix mold on table .

 → →
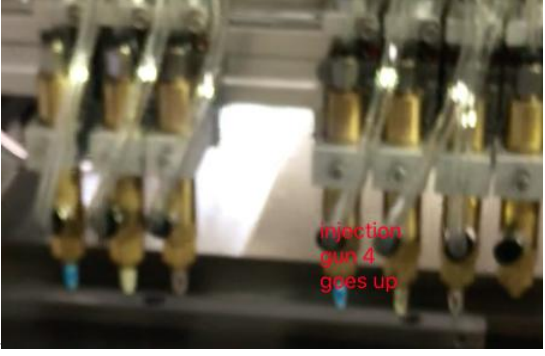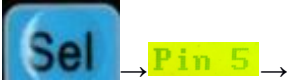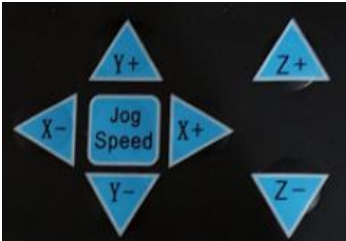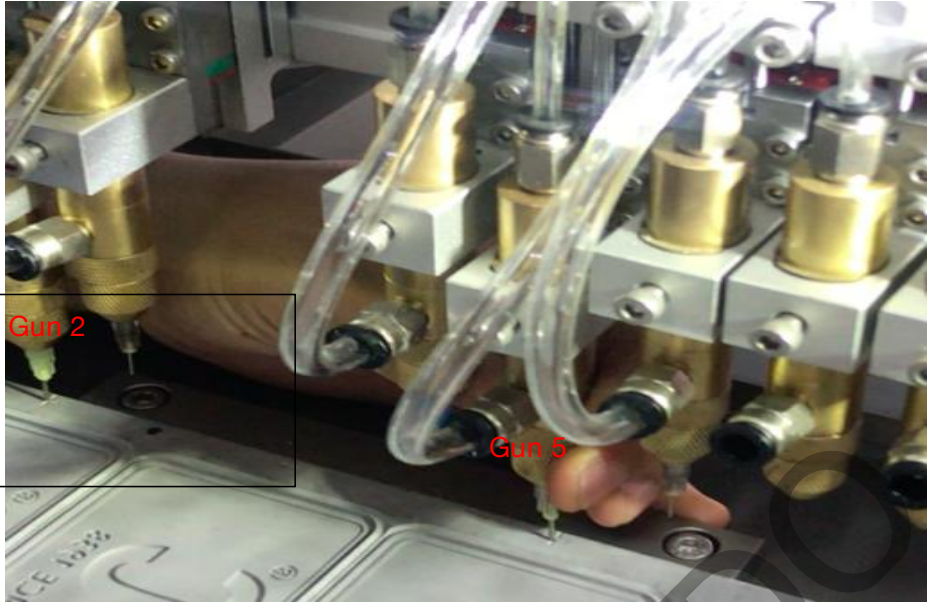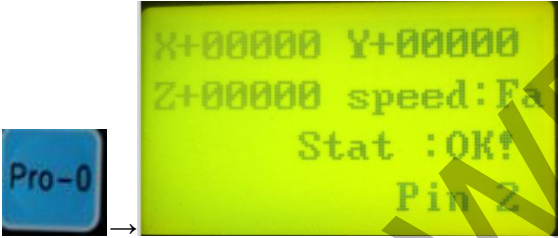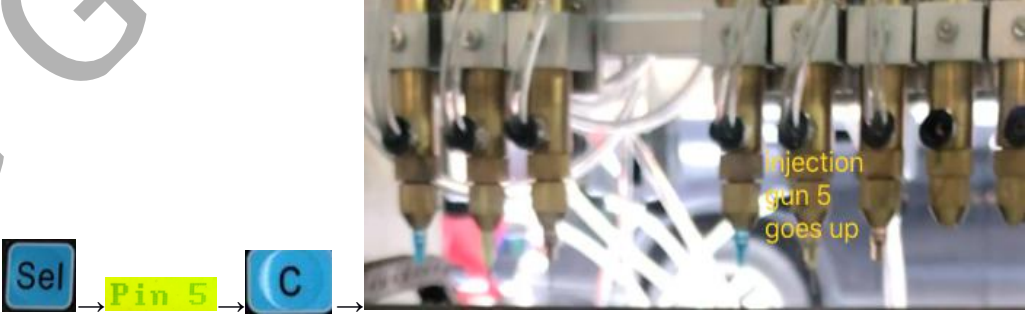
②set pin 1, 2 , 3 okay , file 1   okay   operation .

Injection injection injection   injection   injection   injection
Gun 1   gun 2   gun 3   gun 4   gun 5   gun 6

1st   2nd   3rd   4th

Step 1	Press 'P/F' to let 'pin 1' display on LCD screen	→ Pin 1
	Press' C' to let injection gun 1 down .	
	Press 'Sel' to let pin 4' display on LCD screen ,	→ Pin 4
	press 'C' to let injection gun 4 down.	
Step 2	Press 'Sel' to let pin 1 display on LCD ,	→ Pin 1
	Press 'X+,X-,Y+,Y-,Z+,Z-' to let the first injection gun 1 to aim at the center of first cross .	

	Loose injection gun 4 bracket screw and manual move injection gun tip aim at the center of ' 十 ' . the injection gun bracket can move to left ,right , and front , back . The bracket front screw adjust injection gun 4 up and down . Tighten the screw after aim at the center of cross . After adjust 'injection gun 1 and injection 4 ' .	→
	Press 'Pro-0' to set 'pin 1' okay	
Step 3:	Press 'P/F' to shift' pin 1' to 'file 1 ' displayed on LCD screen,	
	Press 'File-set 0', LCD screen dispaly 'File 1 ok' .	
	Press'P/F' to shift 'file 1' to 'pin 1'. press 'C' , injection gun 1 goes up	

	Press 'Sel' to let pin 4' display on LCD screen . press 'C' , injection gun 4 goes up.	Sel → Pin 4 → C →
Step 5	Press 'Sel' to let pin 5' display on LCD screen . press 'C' , injection gun 5 goes down.	Sel → Pin 5 →
	Press 'Sel' to let pin 2' display on LCD screen ,press 'C' to let injection gun 2 down.	Sel → Pin 2 → C →
	Press 'X+,X-,Y+,Y-,Z+,Z-' to first move injection gun 2 aim at the center of '十'.	→

	loose injection gun 5 bracket screw to make injection gun 5 tip aim at the center of '十' and tighten the screw.	
Step 6	Press'pro-0' to set pin 2 okay .	
	Press'C' rise up 'injection gun 2' .	
	Press'Sel' shift to' pin 5' , press 'C' to rise up injection gun 5.	
	Press ' Sel' to shift 'pin 5 'to' pin 6' display on LCD screen . Press' C' to let injection gun 6 down .	

Press'Sel' to let 'pin 3'display on LCD screen . press 'C' to let injection gun 3 down .	Sel → Pin 3 → C →	injection gun 3 down
Press 'X+,X-. Y+,Y-, Z+,Z- ' to let injection gun 3 aim at the center of the 1st mold cross	Y+ Z+ X- Jog Speed X+ Y- Z- →	gun 3
please loose injection gun **6** bracket screw to make injection gun tip aim at the center of ' ＋ ' and tighten the screw.	gun 3 Gun 6	
Press'pro-0' to set pin 3 okay .	Pro-0 →	X+00000 Y+00000 Z+00000 speed:Fa Stat :OK! Pin 3
Press 'C' , injection gun 3 goes up , press 'Sel' shift to pin 6 , press 'C' , injection gun 6 goes up.	C → Pin 3 →	injection gun 3 up
	Sel → Pin 6 →	injection gun 6 up
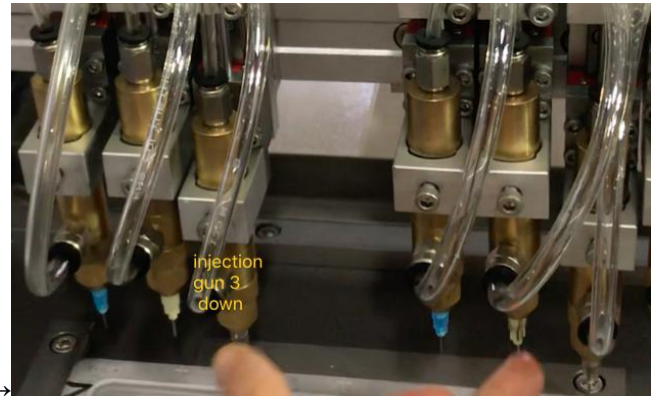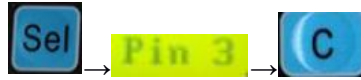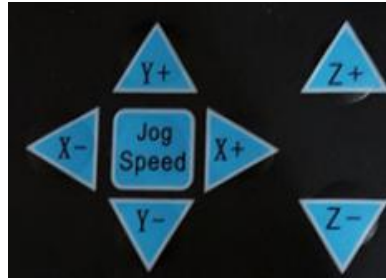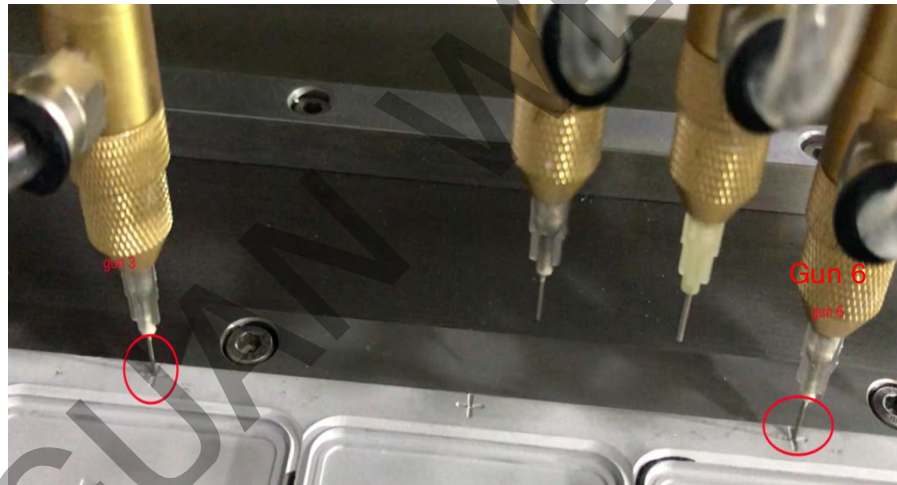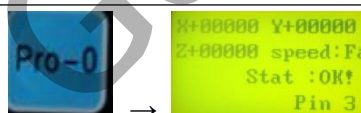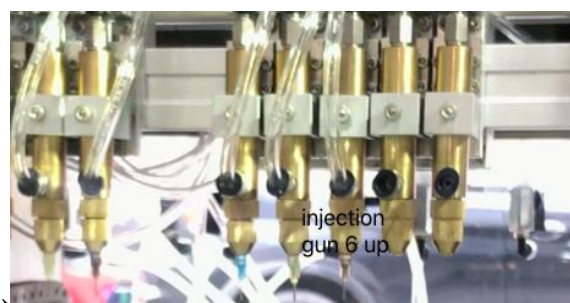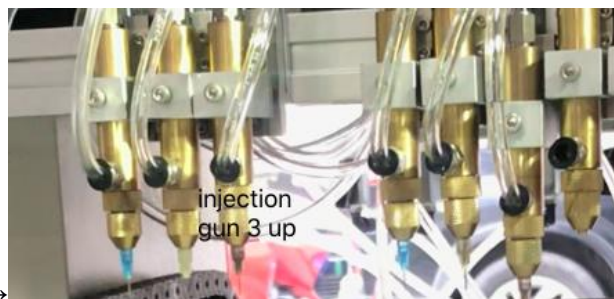
2. Production .

3.1 Adding material .

| Sryinge 1stock white PVC	Supply PVC to injection gun 1	Used to inject big letters
syringe 2 stock white PVC	Supply PVC to injection gun 2	Used to inject small letters
syringe 3stock white PVC	Supply PVC to injection gun 3	Used to inject big letters
sryinge 4stock white PVC	Supply PVC to injection gun 4	Used to inject small letters
syringe 5stock Green / black PVC	Supply PVC to injection gun 5 and injection gun 6	Restonic label base has two base . when make black base , please add black pvc in syringe 5. If make green base , please add green pvc in syringe .

3.2 Release MACHINE   Injection guns air

①Press machine 1 and 3 valve buttons   to open material .

②before working , please release each machine air out from injection gun .

Release MACHINE Injection guns air	First , please press X,Y to move the injection guns on top of waste narrow sink .	
	Press 'P/F' shift to Pin 1 . Press' V ' 15-20 times to let PVC out from injection gun 1 to release air out .	
	Press 'Sel' shift to Pin 2 . Press 'V' 15-20 times to let PVC out from injection gun 2 to release air out .	
	Press 'Sel' shift to Pin 3 . Press V 15-20 times to let PVC out from injection gun to release air out .	
	Press 'P/F' shift to Pin 4 . Press V 15-20 times to let PVC out from injection gun to release air out .	
	Press 'P/F' shift to Pin 5 . Press V 15-20 times to let PVC out from injection gun to release air out .	
	Press 'P/F' shift to Pin 6. Press V 15-20 times to let PVC out from injection gun to release air out .	

3.3 air pressure meter adjustment for machine 1,2,3
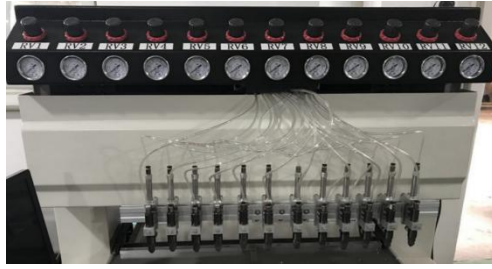
| MACHINE Air meter	RV 1 to control injection gun 1 material flow volume. Meter working number within 0.4. if the pvc is too much , please reduce the air pressure , if too small , please increase the air pressure
	RV 2 to control injection gun 2 material flow volume. Meter working number within 0.4. if the pvc is too much , please reduce the air pressure , if too small , please increase the air pressure
	RV 3 to control injection gun 3 material flow volume. Meter working number within 0.4. if the pvc is too much , please reduce the air pressure , if too small , please increase the air pressure
	RV 4 to control injection gun 4 material flow volume. Meter working number within 0.4. if the pvc is too much , please reduce the air pressure , if too small , please increase the air pressure
	RV 5 to control injection gun 5, gun 6 material flow volume. Meter working number within 0.4. if the pvc is too much , please reduce the air pressure , if too small , please increase the air pressure

3.4 software pin setting .
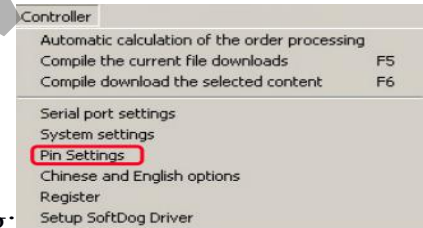
①Open Weldo software， click Controller , choose pin setting:

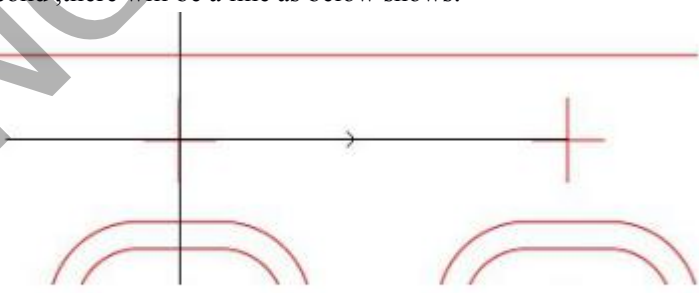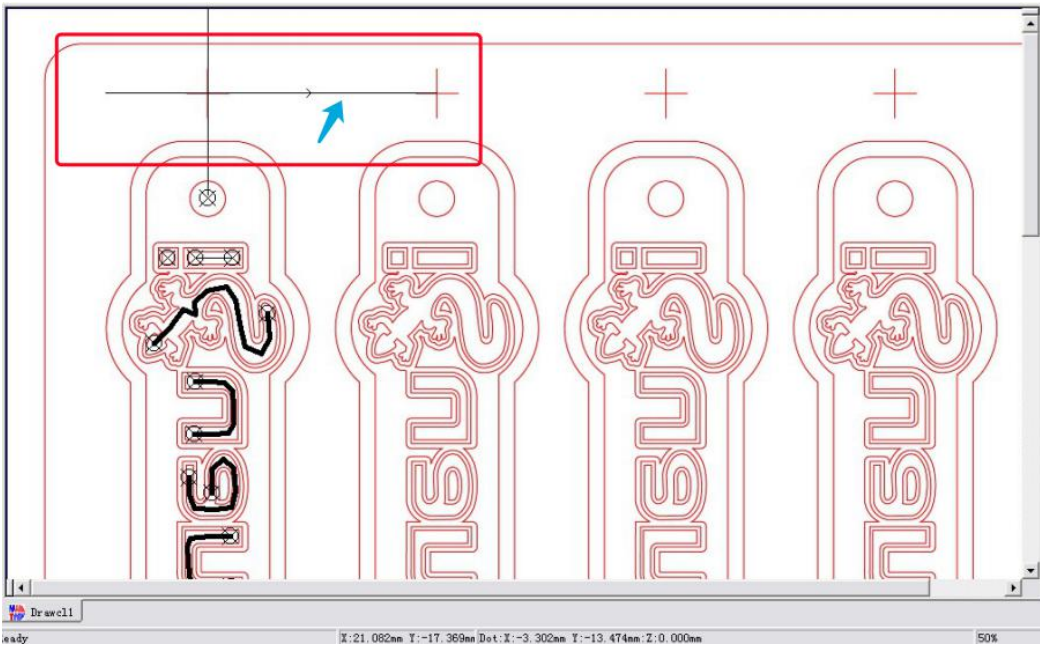② please tick the valve and cylinder for pin 1 , pin 2, pin 3 .as below image.
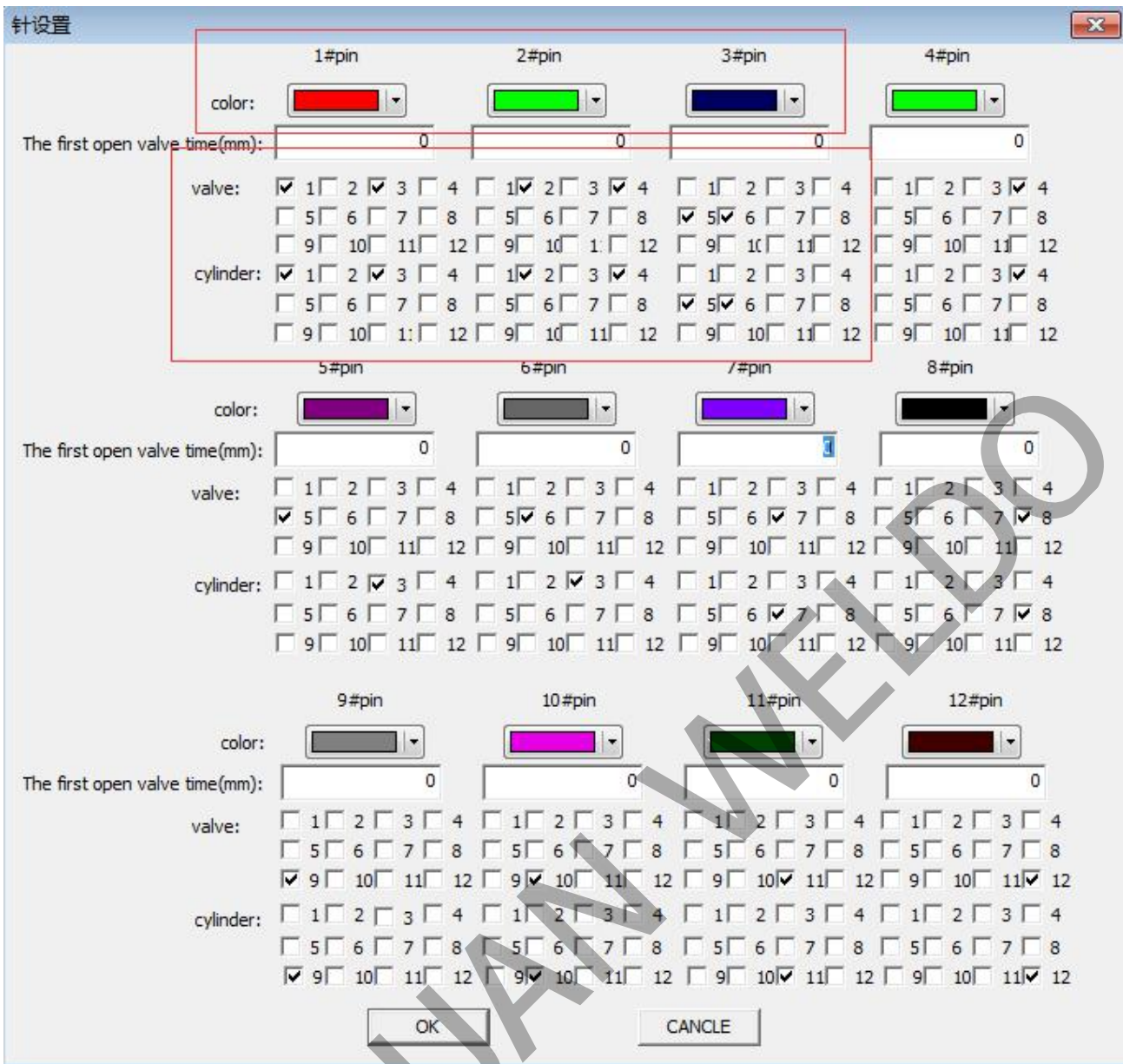
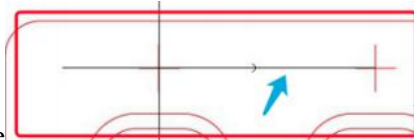③ measure the distance from the 1st cross to the 2nd cross .

Measure X direction distance. Measure the distance between two near cross.

①click [icon] =>put the curse suppose on the first cross => move curse to the second cross =>

move curse to the second ,there will be a line as below shows:

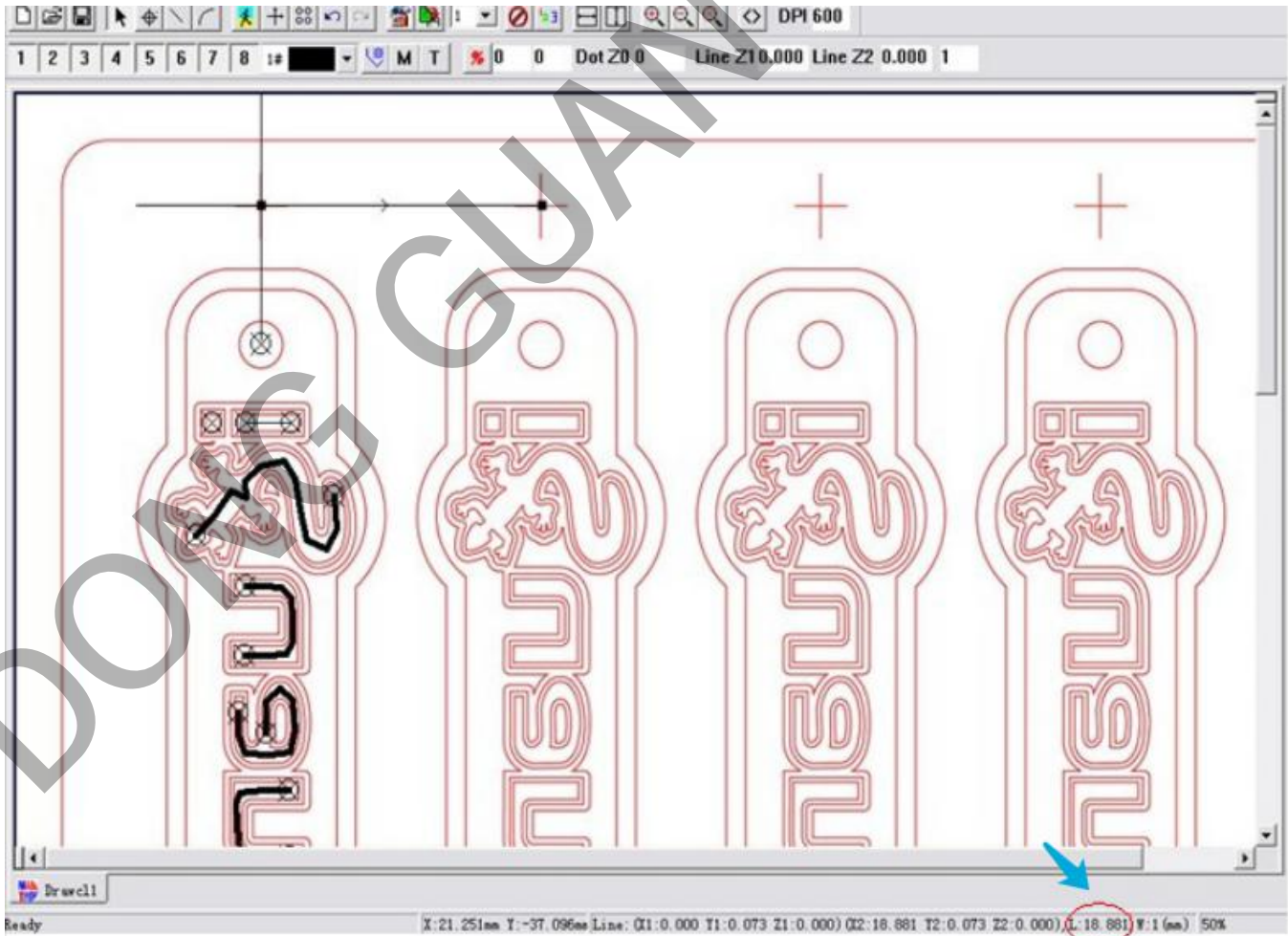②Click [cursor icon] to change the curse to arrow.

③ click the line   by left mouse
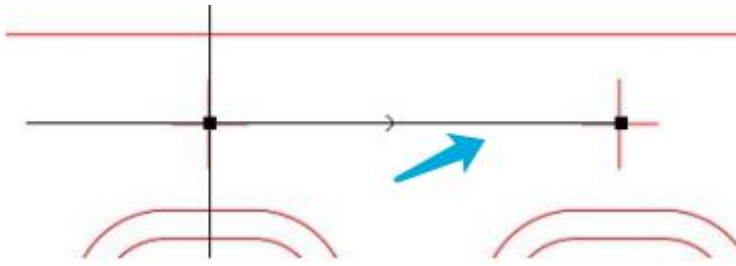
④ Read the distance from the statue column

⑤double click blank , the File Property Setting will pup out , fill in 2 in Copies of X-axis direction that mean the pin

will move 2 times to the right

Copies of X-axis direction: 2

. fill the distance 18.881 to X-axis

X-axis offset(mm): 18.881

offset.

.that mean the distance between two near

copies in X direction is18.881mm. Press'

OK

⑥Select the line

, press "Delete" to delete the line.