→

download file 1
plate 2 to machine

download file to
machine 2.MP4

Video:

2. Machine set file / pin okay

2.1 We use parallel injection guns for mold injection .

S/N	Pin 1 (color 1)	Pin 2(color 2)	Pin 3(color 3)	Pin 4(color 4)
Machine 1	Injection gun 1	Injection gun 2	Injection gun 3	Injection gun 7
	Injection gun 4	Injection gun 5	Injection gun 6	Injection gun 9
S/N	Pin 1 (color 1) For big figure	Pin 2(color 2) For small figure	Pin 3(color 3) For stitching line	
Machine 2	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 2

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 .
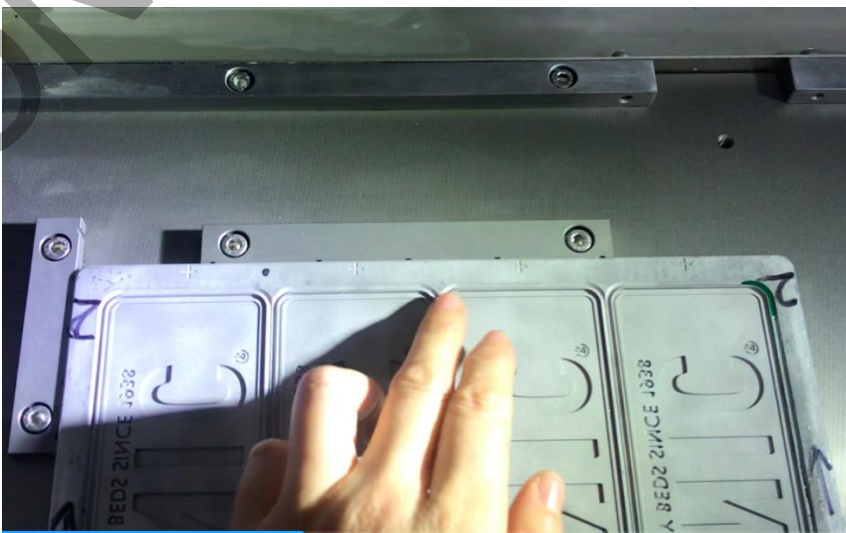
 →   →

choose pin and
install on injection

Video :

2.2 About the mold size and cross'╋' distance

① : the mold short side with 4 crosses '╋ w gun side .
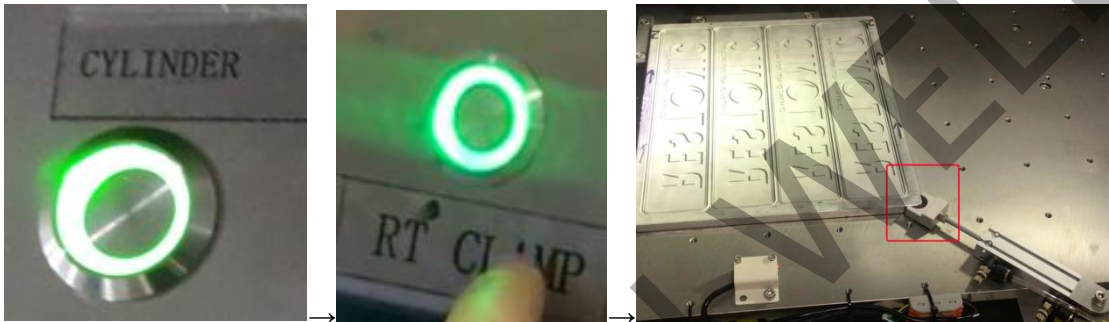
② all molds size , cross position , and cross distances are all the same , just use any one mold to set file / pin okay .
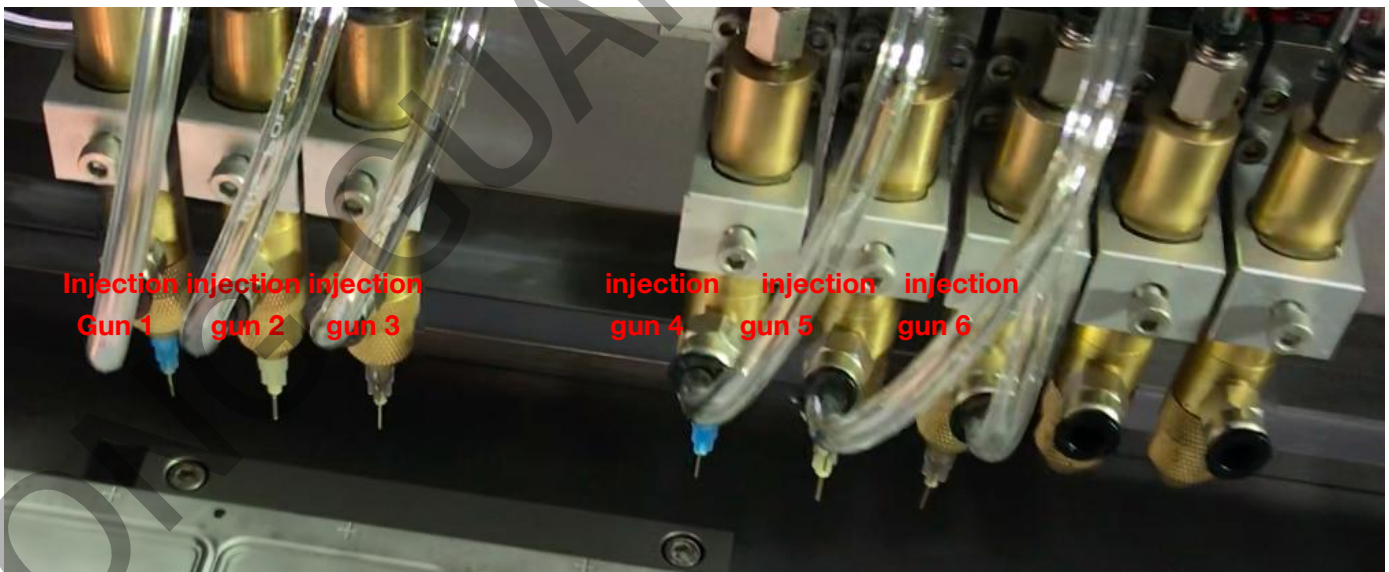
set injection gun
pin origin before

Video :

2.3 set file /pin okay at machine 2 .

① open 'Cylinder ' button on machine , put a mold on machine 2 table, press' LT Clamp' or 'RT Clamp' to fix mold on table .

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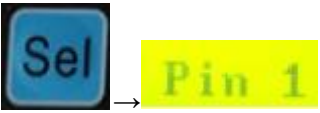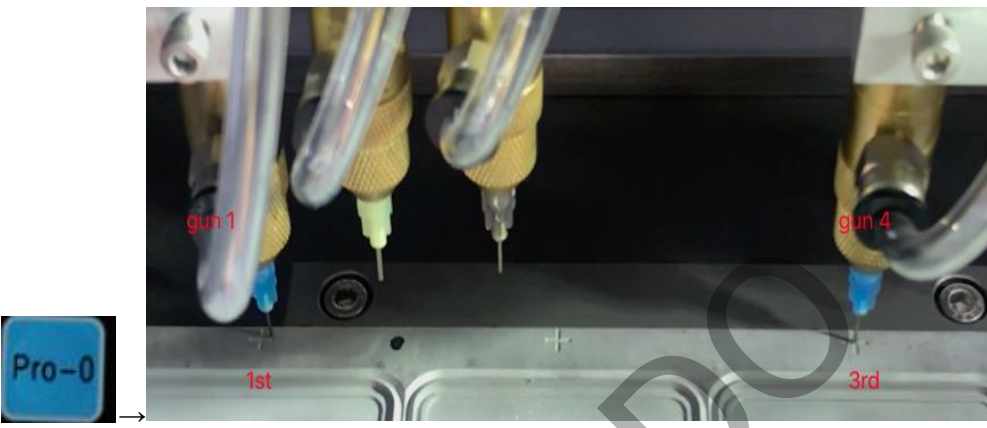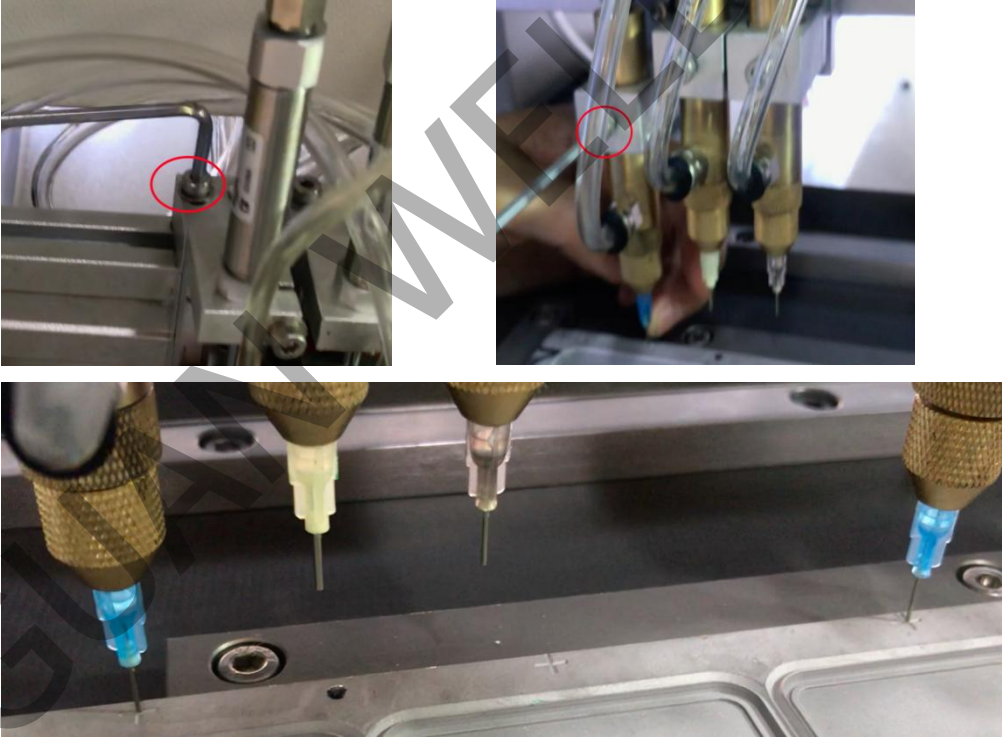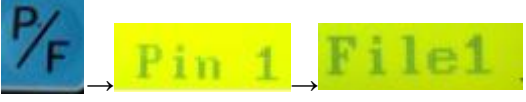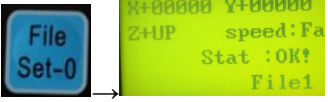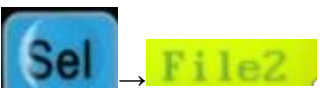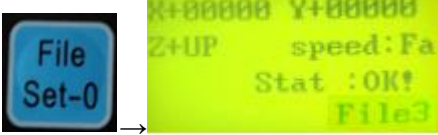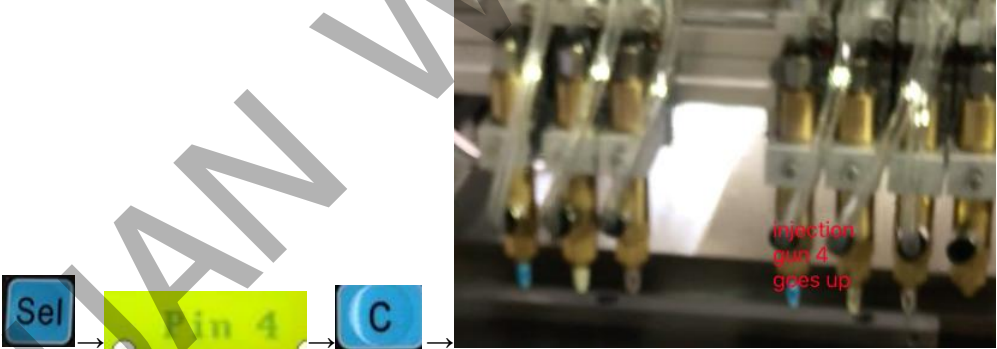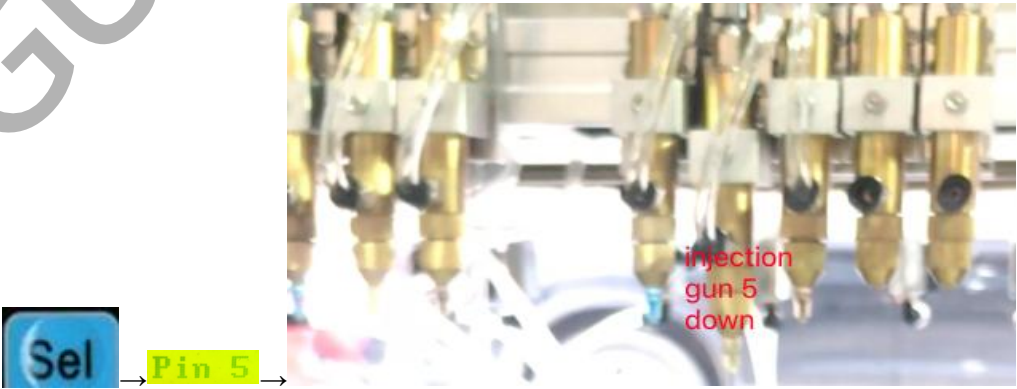
②set pin 1, 2 , 3 okay , file 1 , file 2, file 3 okay   operation .

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

Step1	Press 'P/F' to let 'pin 1' display on LCD screen	
	Press' C' to let injection gun 1 down .	
	Press 'Sel' to let pin 4' display on LCD screen，	
	press 'C' to let injection gun 4 down.	

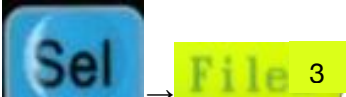|		
Step2	Press 'Sel' to let pin 1 display on LCD ,	→ Pin 1
	Press' Pro-0' , machine automatically moves injection gun 1 down to mold 1st ' 十 ', injection gun 4 down to mold 3rd ' 十'. the injection gun 1 and injection gun 4 tip not aim at the center of '十' →	
	Loose injection gun bracket screw and manual 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 up and down . Tighten the screw after aim at the center of cross . After adjust 'injection gun 1 and injection 4 '. pin 1 is okay . Video : set pin 1 okay at machine 2.MP4	→
Step3:	Press 'P/F' to shift' pin 1' to 'file 1 ' displayed on LCD screen,	→ Pin 1 → File1
	Press 'File-set 0', LCD screen dispaly 'File 1 ok' .	→ X+00000 Y+00000 Z+UP speed:Fa Stat :OK! File1
	Press 'Sel' shift 'File 1' to' File 2' display on LCD screen .	→ File2

DONG GUAN WELD

	Press 'File-set 0', LCD screen dispaly 'File 2 ok'.	File Set-0 → X+00000 Y+00000 Z+UP speed:Fa Stat :OK! File2
	Press 'Sel' shift 'File 2' to' File 3' display on LCD screen	Sel → File 3
	Press 'File-set 0', LCD screen dispaly 'File 3 ok'. 3 files zero set okay .	File Set-0 → X+00000 Y+00000 Z+UP speed:Fa Stat :OK! File3
	Press'P/F' to shift 'file 3' to 'pin 1'. press ' C' , injection gun 1 goes up	File 3 → P/F → Pin 1 → C →
	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 →

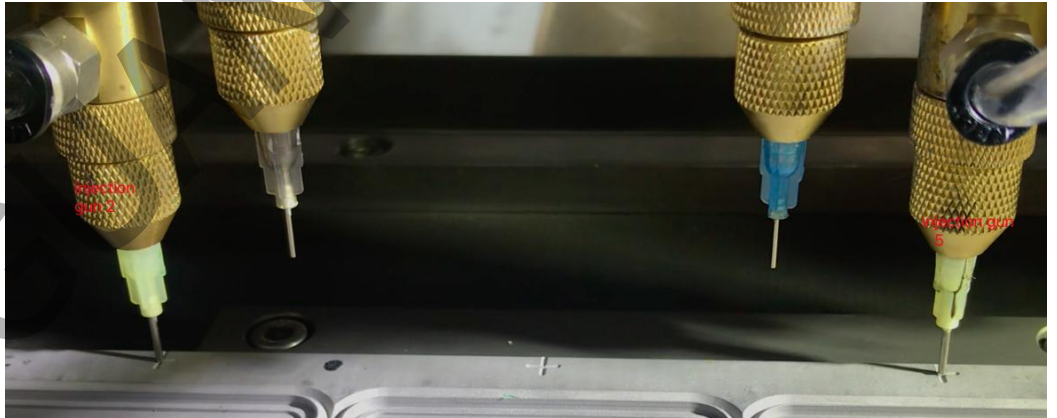|		
	Press' Pro-0', machine automatically moves injection gun 2 down to mold 1st ' 十 ', injection gun 5 down to mold 3rd '十'.	
	Injection gun 2 and 5 tip not aim at the center of ' 十 '. loose injection gun bracket screw to make injection gun 2, 5 tip aim at the center of ' 十 ' and tighten the screw. Video : set pin 2 okay and adjust injection	
Step6	Press'C' rise up 'injection gun 2'.	
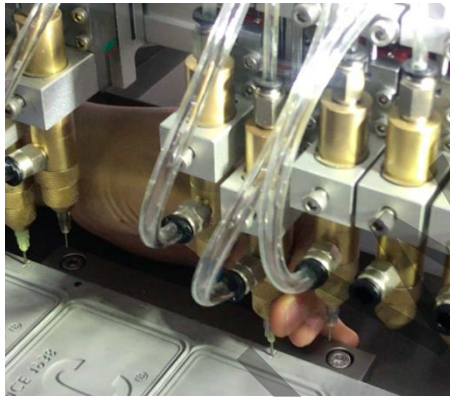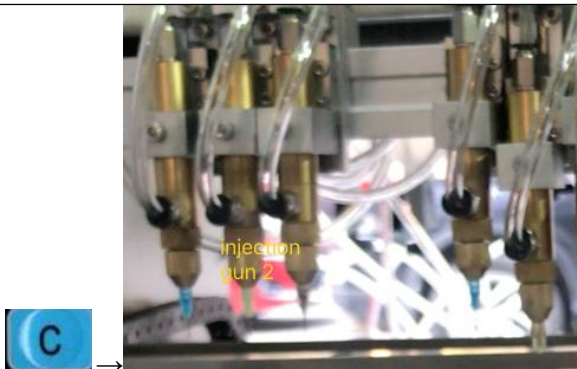
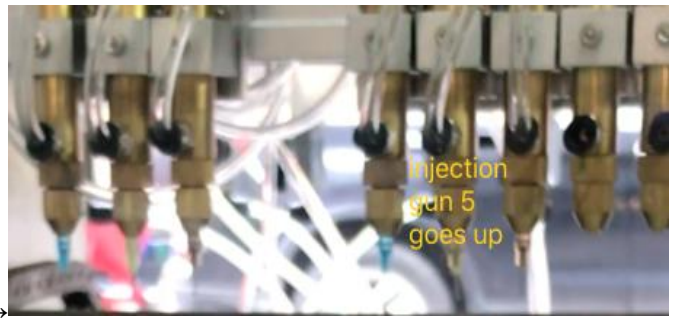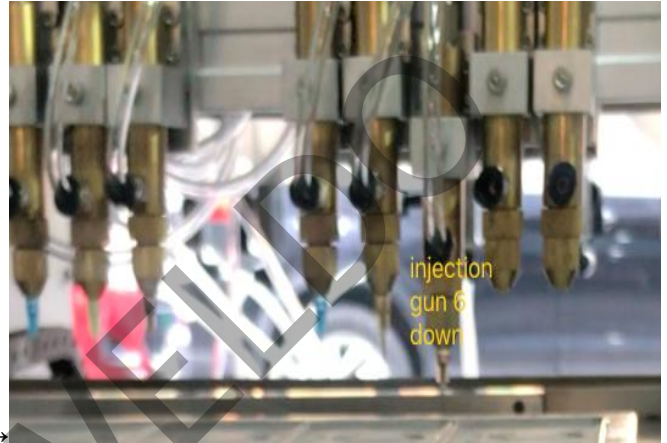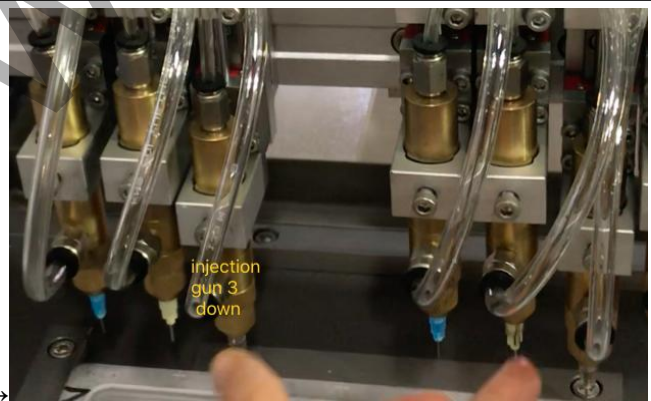|		
	Press'Sel' shift to' pin 5'	Sel → Pin 5 → C →
	Press ' Sel' to shift 'pin 5 'to' pin 6' display on LCD screen . Press' C' to let injection gun 3down .	Sel → Pin 6 → C →
	Press'Sel' to let 'pin 3'display on LCD screen .	Sel → Pin 3 → C →
	Press' Pro-0' , machine automatically moves injection gun 3 down to mold 1st '十', injection gun 6 down to mold 3rd '十'.	Pro-0 →
	Please check injection gun tip aim at the center of '十' or not , if not ,please loose injection gun bracket screw to make injection gun tip aim at the center of '十' and tighten the screw. Video :	↓

	set pin 3 okay at machine 2.MP4	
Press 'C' , injection gun 3 goes up , press 'Sel' shift to pin 6 , press 'C' , injection gun 6 goes up. Video : set pin 3 okay at machine 2.MP4	C → Pin 3 → Sel → Pin 6 →	injection gun 3 up injection gun 6 up
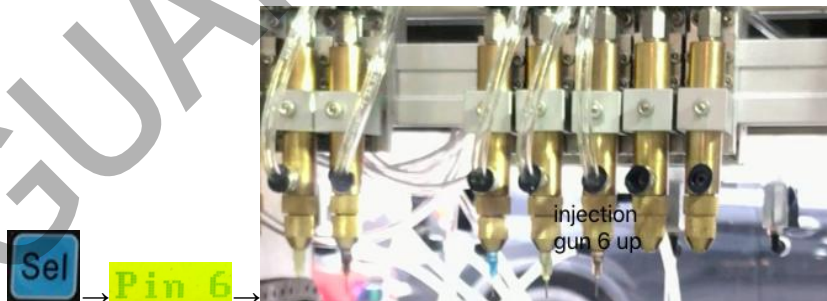
2.4 set file / pin okay at machine 1

①install pins for injection guns

②Operation steps

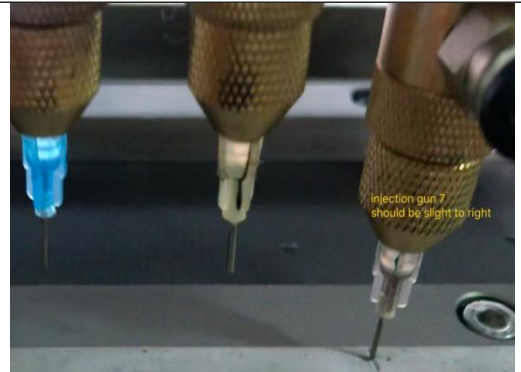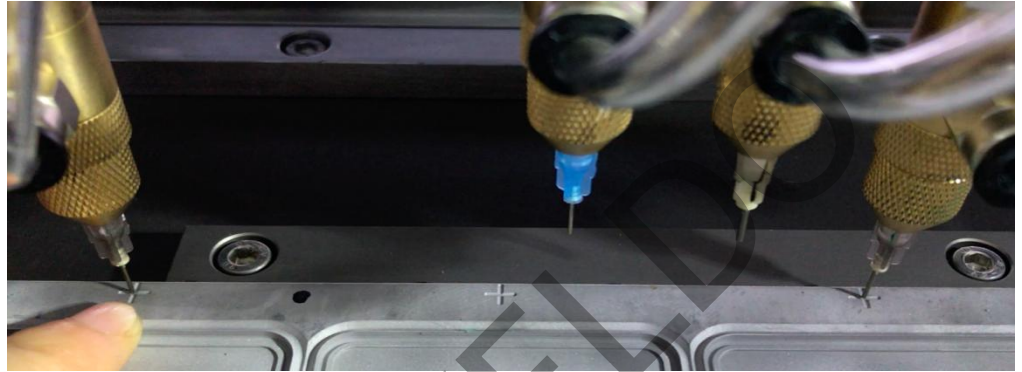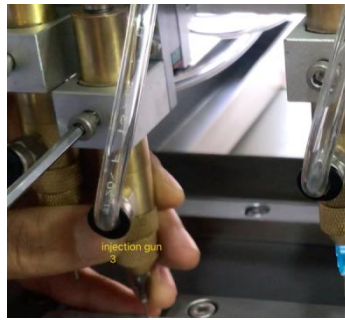|		
Step1	Press 'P/F' to let 'pin 1' display on LCD screen	→ Pin 1
	Press' C' to let injection gun 1 down .	
	Press 'Sel' to let pin 4' display on LCD screen ,	→ Pin 4
	press 'C' to let injection gun 4 down.	
Step2	Press 'Sel' to let pin 1 display on LCD ,	→ Pin 1
	Press' Pro-0' , machine automatically moves injection gun 1 down to mold 1st '十', injection gun 4 down to mold 3rd '十'. the injection gun 1 and injection gun 4 tip aim at the center of '十'. no need to adjust injection gun 1 and injection 4 .	→
Step3:	Press 'P/F' to shift' pin 1' to 'file 1 ' displayed on LCD screen,	→ Pin 1 → File1

Press 'File-set 0', LCD screen dispaly 'File 1 ok'.	File Set-0 →	X+00000 Y+00000 Z+UP speed:Fa Stat :OK! File1
Press 'Sel' shift 'File 1' to' File 2' display on LCD screen .	Sel →	File2
Press 'File-set 0', LCD screen dispaly 'File 2 ok'.	File Set-0 →	X+00000 Y+00000 Z+UP speed:Fa Stat :OK! File2
Press 'Sel' shift 'File 2' to' File 3' display on LCD screen	Sel →	File3
Press 'File-set 0', LCD screen dispaly 'File 3 ok'. 3 files zero set okay .	File Set-0 →	X+00000 Y+00000 Z+UP speed:Fa Stat :OK! File3
Press'P/F' to shift 'file 3' to 'pin 1'. press ' C' , injection gun 1 goes up	File3 → P/F → Pin 1 → C → gun 1 up	
Press 'Sel' to let pin 4' display on LCD screen . press 'C', injection gun 4 goes up.	Sel → Pin 4 → C → gun 4 up	
Step 5	Press 'Sel' to let pin 5' display on LCD screen . press 'C', injection gun 5 goes down.	Sel → Pin 5 → gun 5 down

	Press 'Sel' to let pin 2' display on LCD screen ,press 'C' to let injection gun 2 down.	Sel → Pin 2 → C → gun 2 down
	Press' Pro-0' , machine automatically moves injection gun 2 down to mold 1st ' ＋ ', injection gun 5 down to mold 3rd '＋'.	Pro-0 → gun 2 gun 5
Step6	Press'C' rise up 'injection gun 2' .	C → gun 2 up
	Press'Sel' shift to' pin 5'	Sel → Pin 5 → C → gun 5 up
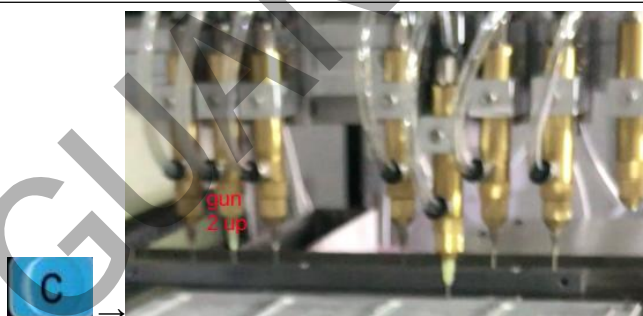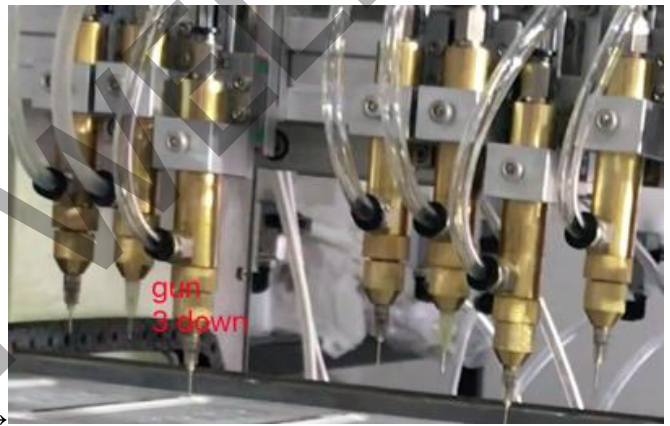
	Press ' Sel' to shift 'pin 5 'to' pin 6' display on LCD screen . Press' C' to let injection gun 3down .	
	Sel → Pin 6 → C →	
	Press'Sel' to let 'pin 3'display on LCD screen .	
	Sel → Pin 3 → C →	
	Press' Pro-0' , machine automatically moves injection gun 3 down to mold 1st ' ＋ 'center, injection gun 6 down to mold 3rd '＋'center .	Pro-0 →
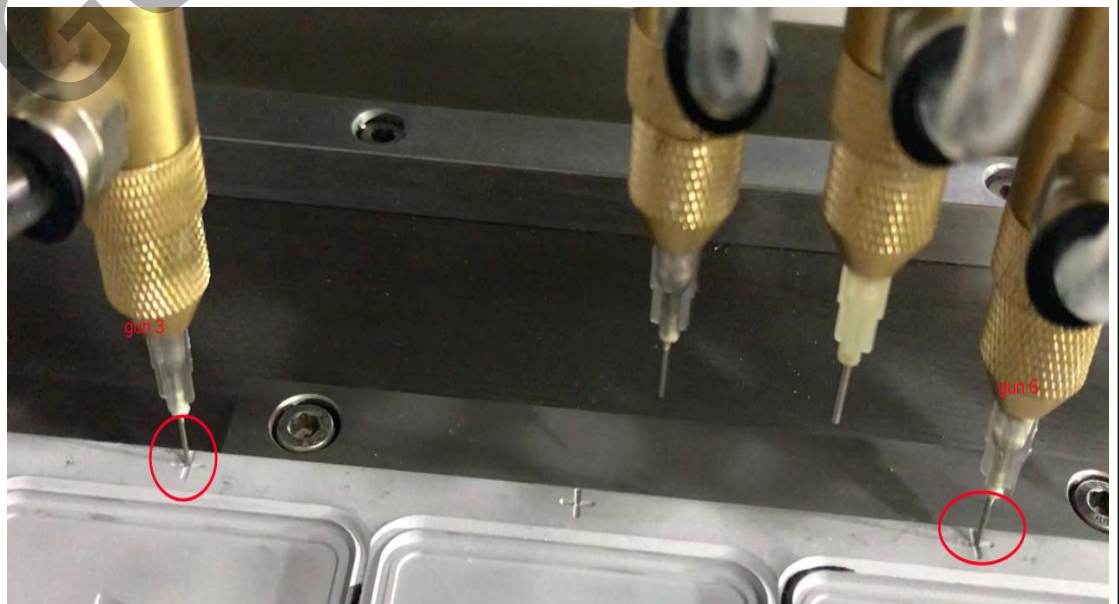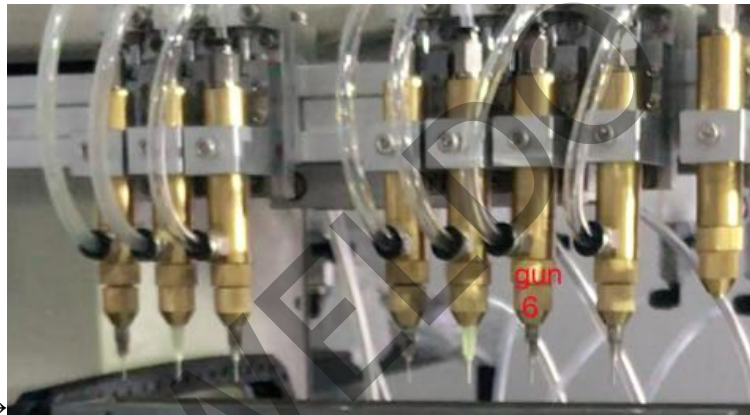
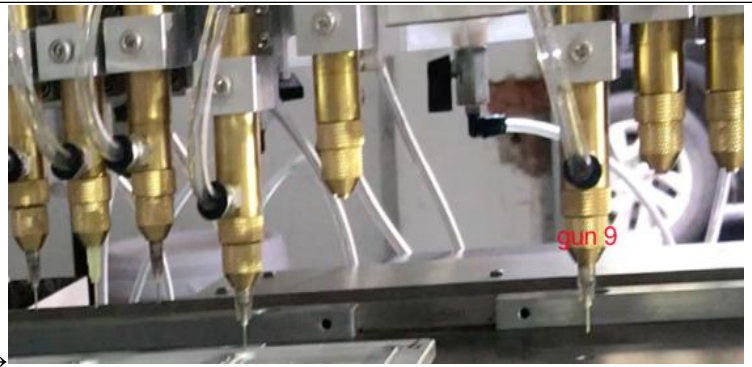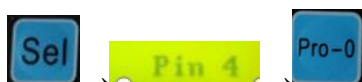|		
	Press 'C' , injection gun 3 goes up , press 'Sel' shift to pin 6 , press 'C' , injection gun 6 goes up. Video :	
Step7	Press'Sel' shift 'pin 6 ' to 'pin 7',press 'C' to press injection 7 down .	
	Press'Sel' shift 'pin 7 ' to 'pin 9',press 'C' to press injection 9 down .	
	Press ' Sel' shift pin 9 to pin 4. press Pro-0' , machine automatically moves injection gun 7 down to mold 1st ' 十 'center, injection gun 9 down to mold 3rd '十'center .	

| | Press 'Sel' shift pin 4 to pin 7, press'C' , injection gun 7 goes up .

 Press 'Sel' shift pin 7 to pin 9 , press 'C' pin 9' goes up .
 Video： | Sel → Pin 7 → C → gun 7 up

 Sel → Pin 9 → C → gun 9 up |
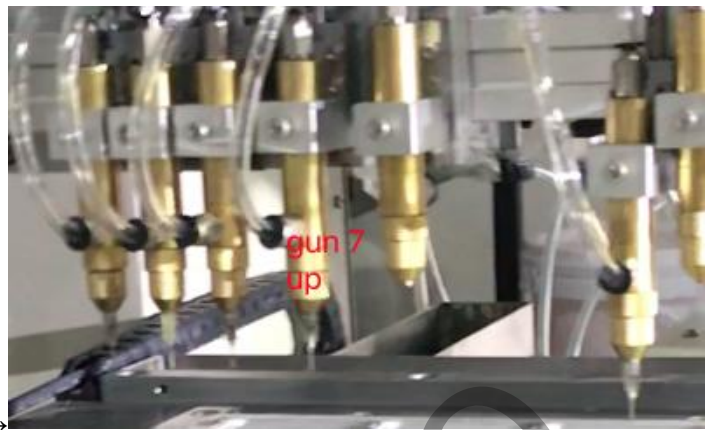
3. Production .

3.1 Adding material .

Machine 2

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