User Manual

HIT series Take-out Robot

■ HIT-100S/D ■ HIT-200S/D

Read this manual completely prior to installing, operating or performing maintenance on this equipment.

HYROBOTICS

Selling, Installing and Using the Product not in Manufacturing Country

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- HY Robotics Co,. Ltd. assume no responsibility for any errors or omissions in this document
- Any recommendation about manual amendment is always welcomed.
- The content include in this manual is intended to serve as reference data concerning the machine in this manual. HY Robotics Co. Ltd is not legally bound in any way whatsoever by these data.
- HY Robotics Co,. Ltd. assumes no responsibility whatsoever for damage or lost profits resulting from modification, disassembly, misuse, inadequate installation environment, or any other situation beyond our control.
- HY Robotics Co,. Ltd assumes no responsibility whatsoever for damage or lost profits resulting from the use of this equipment.
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HIT User Manual
Ver 1.0

Attention Marks

Danger, Warning, Caution, Notice

This document use following attention mark for the safety of operation

⚠DANGER	If the actions indicated in a “ DANGER”, death or serious damage of major equipment could results.
⚠WARNING	If the actions indicated in a “ WARNING”, serious injury or major equipment damage could results.
⚠CAUTION	If the actions indicated in a “ CAUTION”, some injury or damage could results.

NOTICE	A “ NOTICE “ provides supplementary information, emphasized a point or procedure, or gives a tip for easier operation.

OPERATIONAL WARNINGS

DANGER

- The robot must be installed in a safe and secure procedure by professionals who familiar with the structural engineering principles related to the installation of large industrial equipment. The information on the following pages can be used as a guide to help you install your robot. The customer must have the installation plan for the selected site verified to be adequate by a structural engineer or a similarly qualified professional. HY Robotics Co.Ltd can not accept any responsibility for damage due to improper installation

- The robot motion area is as follows, this area is the dangerous area of the robot. Be sure to operate the robot outside of the safety fence. If you enter the robot motion area during Operation, a serious accident could result.

WANRING

- Do not enter robot motion area or inside the safety guard during robot operation. Do not touch or do not allow other objects interfere with the safety fence.

- Do not remove or open safety guard during robot operation. Do not operate robot inside of the safety guard .

- Do not place any cups or bottle that containing water or liquid on the top of robot or controller. It may cause of electric shock.

- Do not place any small metal (Clip, Screw, Tool, etc) on the robot body and control box. If such a piece of metals get in to the inside of robot body or controller, an electric short may occur and cause of fire.

- Do not place any heavy obstacle or object on the robot body and controller. It may damage the robot surface as well as deform the structure of robot and it may fall directly to the person.

- Do not use an extremely flammable spray near by the robot. It may cause a fire.

- If any air leakage is detected from robot , stop immediately the robot or activate E-Stop function. Lock out and Tag out until the problem fixed.
- When an error occurs during operation, stop the robot immediately, find the cause of error and follow the step to re-start robot.

- Make sure following before turn on the power of robot
  - Confirm there in no person in the motion area of robot
  - Confirm the location of handy controller and tool is required place
  - Confirm there is no obstacle on the robot and in the area of robot motion

WANRING

- If any of the following cases should occur, stop the operation with E-Stop button immediately and turn off the power. If you continue the operation of machine under such conditions, a fire may result in the worst case.
  - When fume rises from the robot body or control box, or the outside surface of the robot emits abnormal heat.
  - When there is any abnormal noise from the robot.
  - When any water, or foreign obstacle is inside of the robot

- Stop the robot immediately when abnormal symptom happens during operation. When an error occurs during operation, the robot stops and alarm sounds and the error code displays on the handy controller. Press Stop button to stop the alarm. Check error table for a description of the error.

CAUTION

- If the following items are contained to the air, do not use it. Use only clean air.
  - Acid
  - Organic solvents
  - Chlorine gas
  - Sulfur dioxide
  - Compressor oil

- Do not drop or give any strong shock the handy controller. It may be cause of malfunction.

- Handle with care with pneumatic line. It may be cause of leaks.

- Make sure the operation environment (Motion area, Safety Guard) should be proper for operation of machine equipments.

- Operate the robot with only healthy , good and normal body and mental condition.

- Do not use handy teach palm pendant (Controller) which contact with water or oil

- Make sure the operating environment is as follows
  Operation Temperature : 0℃ ~+ 40℃ (32°F ~+ 104°F)
  Storage Temperature : -25℃ ~+ 55℃ (-13°F ~ + 131°F)
  Humidity : 35 % RH ~85 % RH (without condensation).

CAUTION

- When setting up the robot arm in the mold area by manual operation, take really care that the robot arm does not contact with the mold or tie bar. Make sure to operate from the robot outside the safety guard.

- Do not use an operation fluid other than clean compressed air (Filter required to remove humidity from pnuematic air line)

- Regulate the air pressure as specified.

- If don't operate the robot for several days or long period of the time due to plant shutoff or vacation, Turn OFF the control power.

- Proper working clothes, helmet and protective shoes required for operating and setting up the robot (Personal protective Equipment)
  - Do not operator robot without safety helmet or shoes.
  - Do not wear necktie and necklace, bracelet etc

MAINTENANCE WARNINGS

WARNING

- Before cleaning, inspecting, repairing, adjusting, or performing maintenance on the take-out, be sure to turn OFF the control power and Remove the plug from powe outlet and follow Lock out / Tag out Procedure. If you attempt to perform the cleaning without turning OFF the control power, electric shock might happen without turn off the power.

- Only a qualified person is allowed to open the maintenance cover or control panel of the take-out robot.

- Assign one qualified person who will control safety of the robot. and need to be trained by the manufacturing company or agency how to control robot and about safety

- Be sure to release pneumatic pressure before replacing a filter bowl.

- When required only by manufacturing company : Before handling ROM, turn off the control power. Use ROM Remover to pull the ROM out. Do not drop the ROM and expose it to strong shock.

POWER RELATED WARNINGS

WARNING

- Handle with care with power cable, do not pull and bend. Do not place heavy object on the cable (No folk lift passing on the power cable). Use cable tie to organize power cable for safety. (Damaged cable could be the cause of fire or electric shock.)

- Using unspecified Extension cable cause abnormal symptoms including heat and fire.

- Only qualified personal should try to install Electrical power and ground to the robot.

- Connect the earth terminal of the plug to the earth terminal of the plug socket

WARNING

- Power off when connect or disconnect any electrical connector of robot

- Lockout / Tag out before opening the control box

- Connect the earth terminal of the plug to a class D grounding terminal

Safety Signs

There are safety signs on the robot like below figures. Respect and follow the messages on these signs when operating or performing maintenance on the robot. Do not peel off these labels or signs

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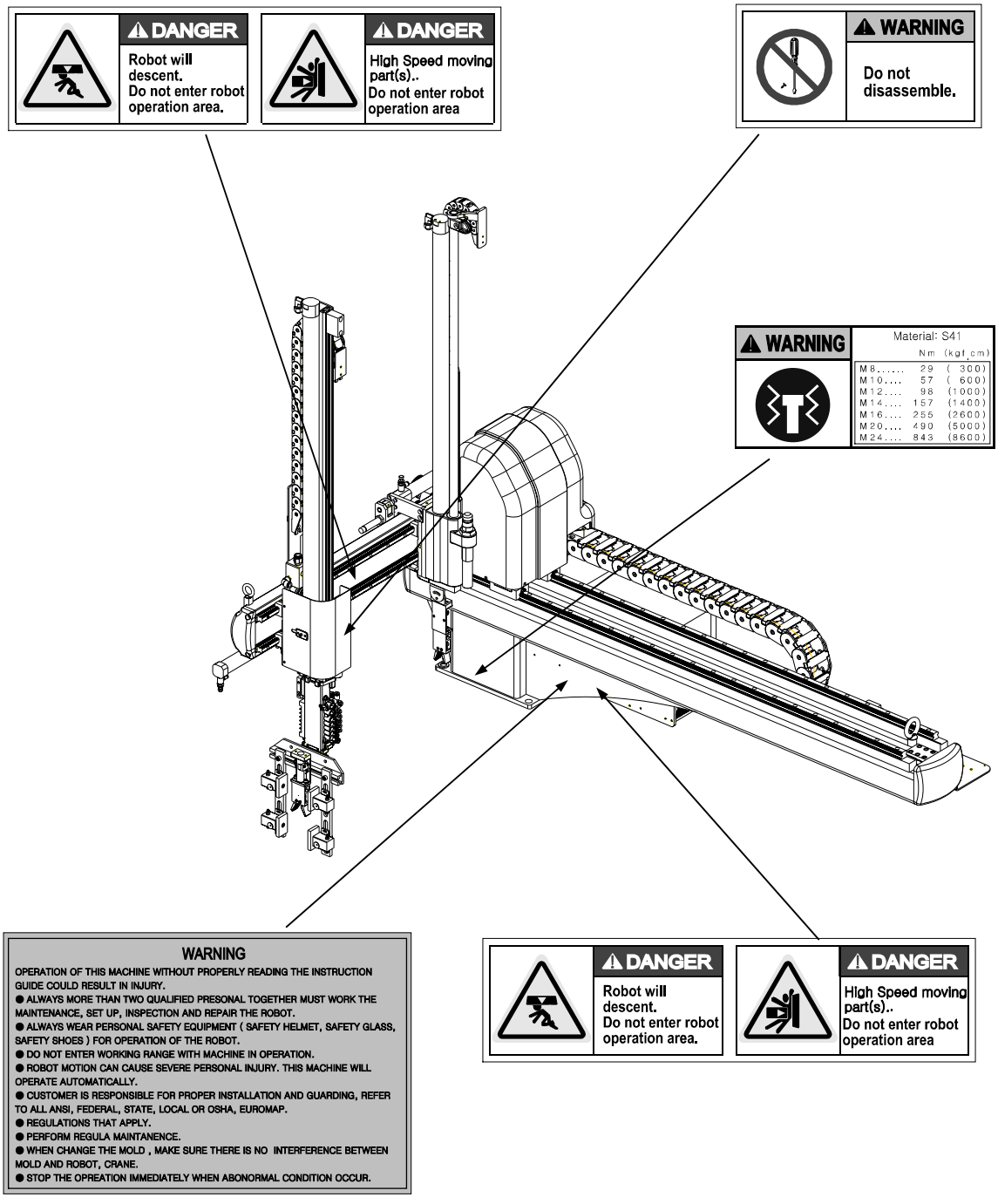

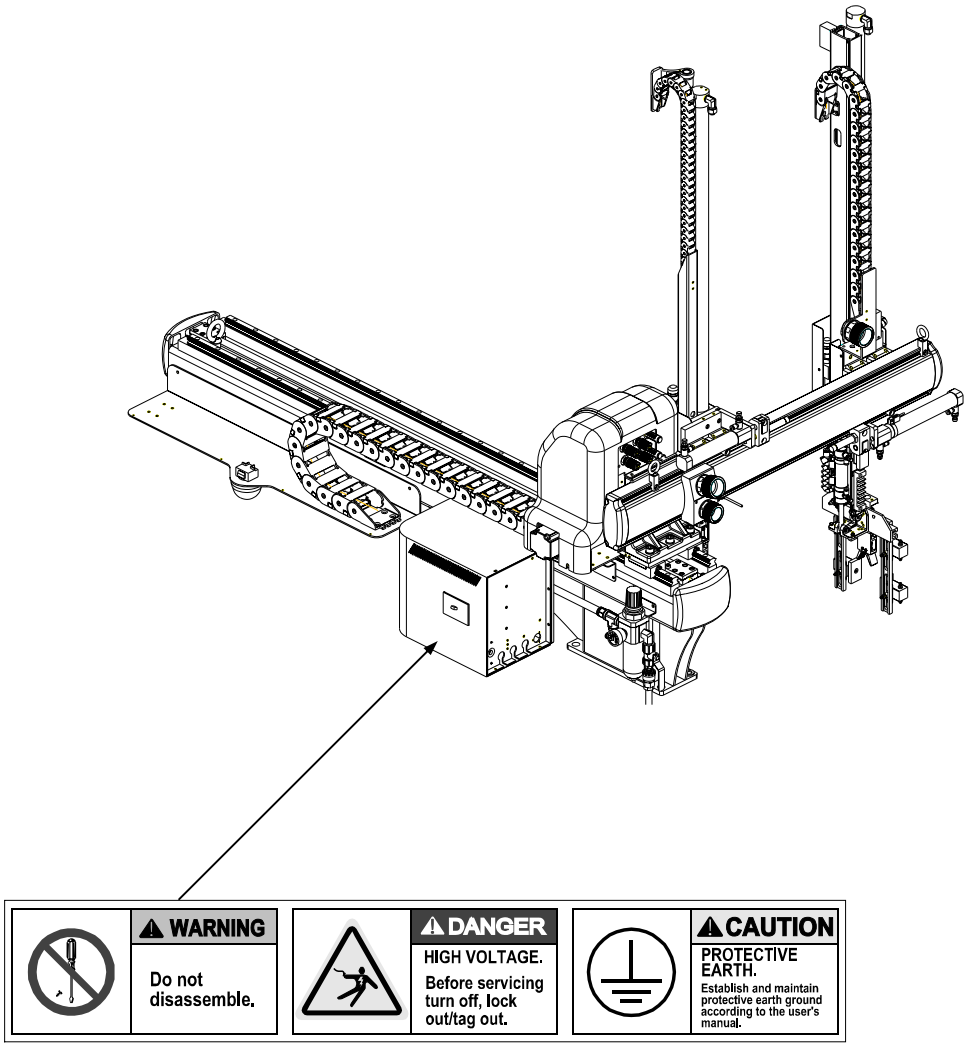
⚠ WARNING
Do not disassemble.
⚠ DANGER
HIGH VOLTAGE.
Before servicing turn off, lock out/tag out.
⚠ CAUTION
PROTECTIVE EARTH.
Establish and maintain protective earth ground according to the user's manual.

Contents

1 Introduction

1.1 Robot Assembly

This Robot is consisted of

- Robot Body
- Interlock and Control Box
- Handy Controller

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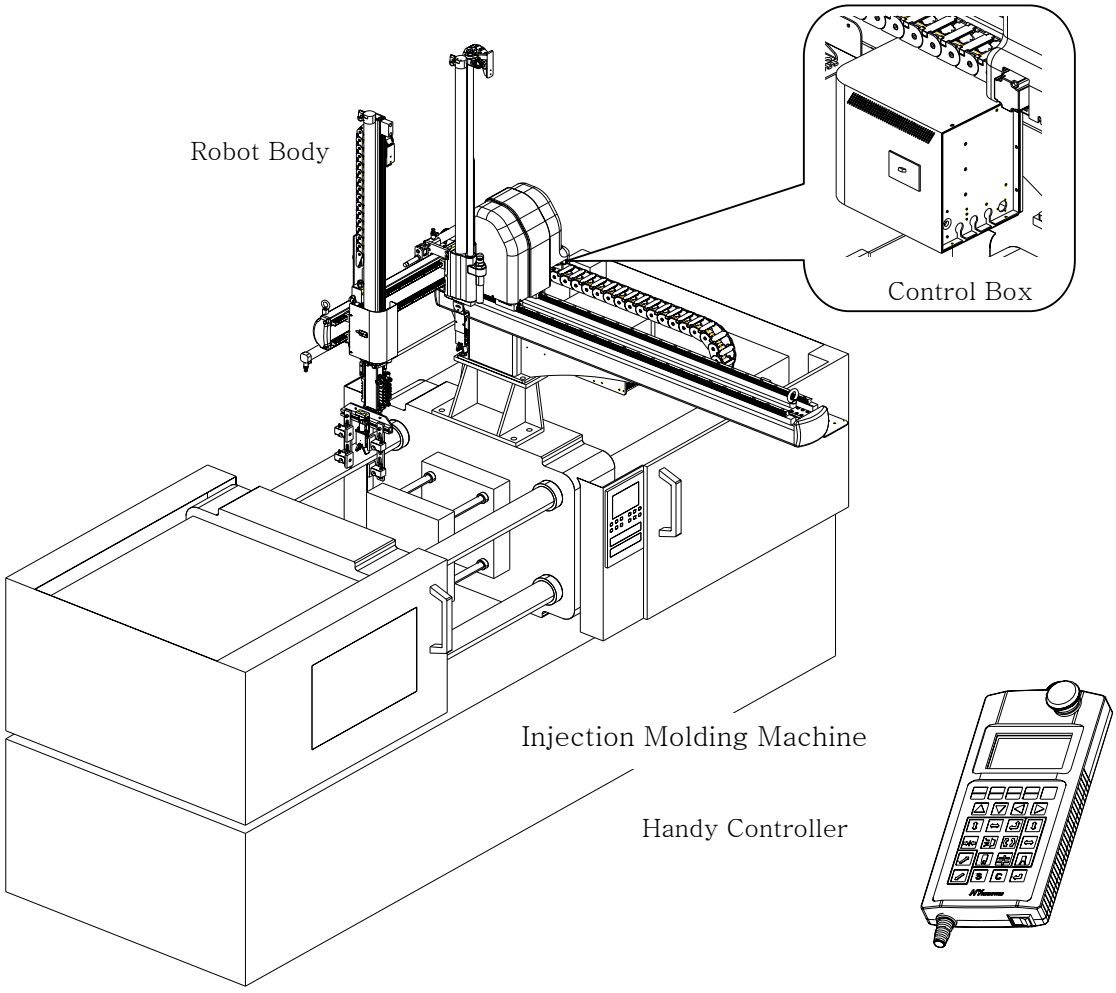
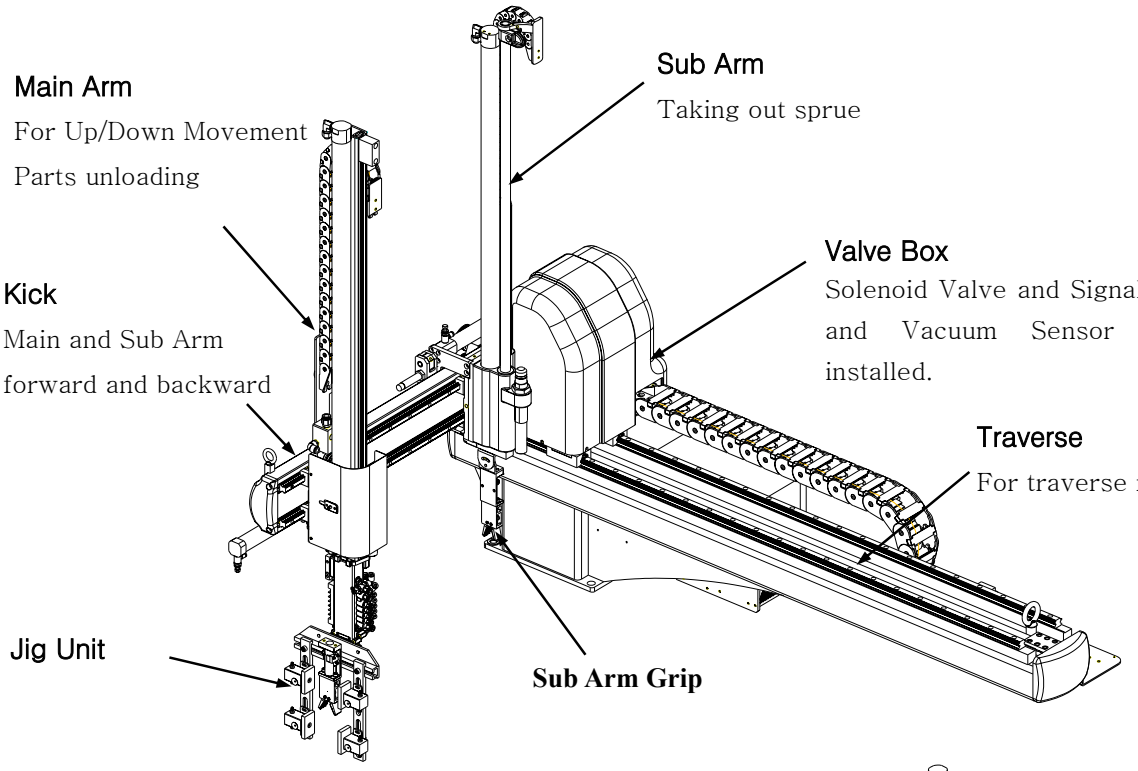
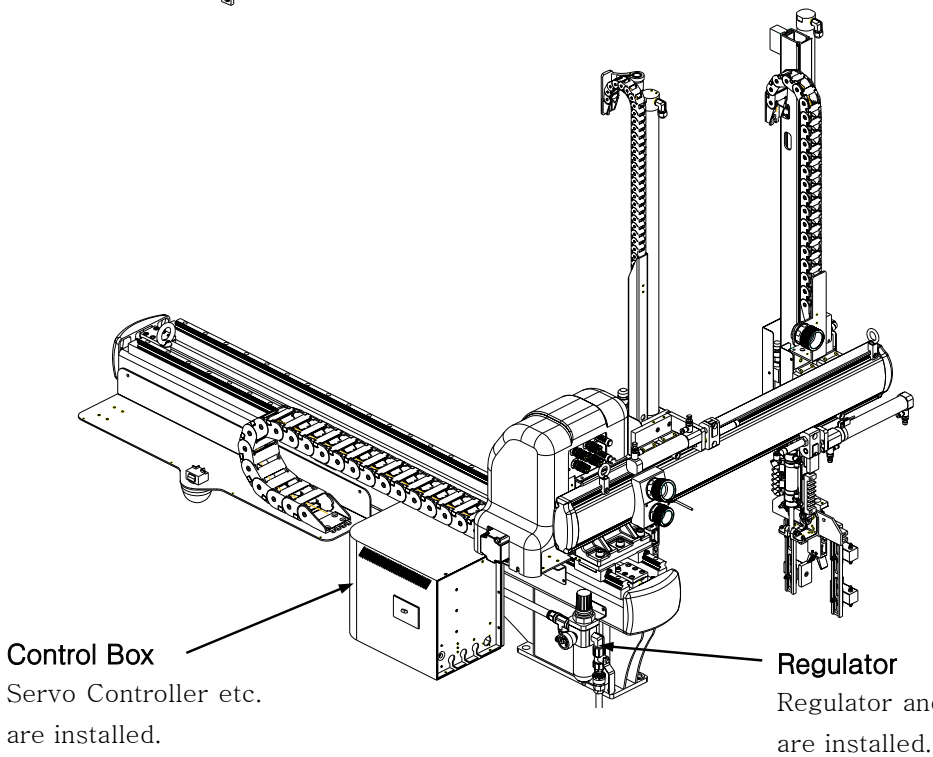
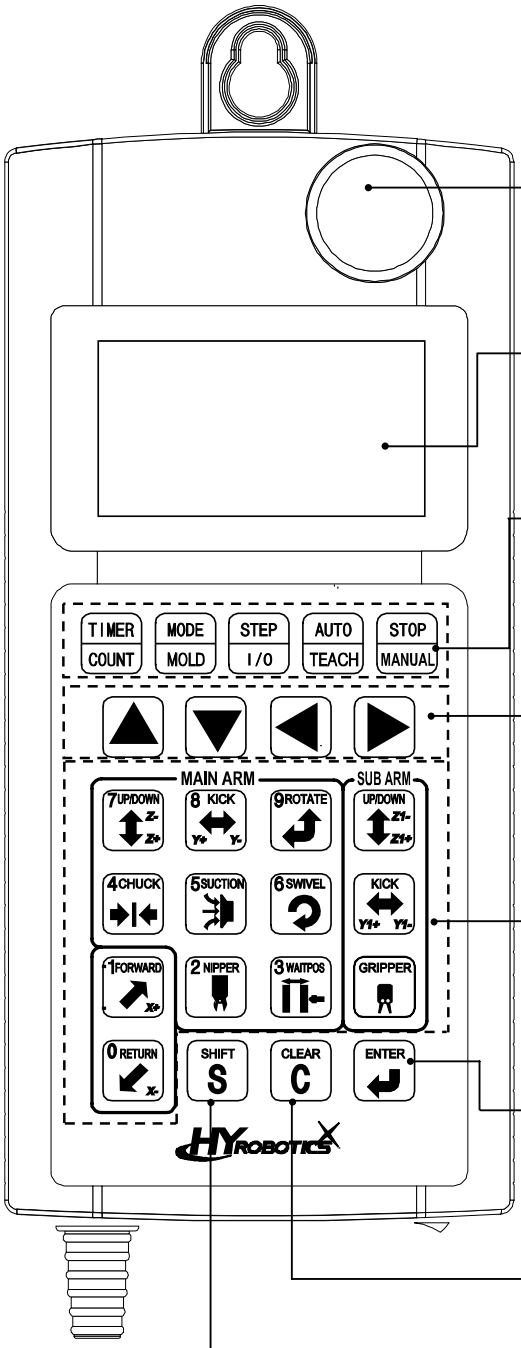


1.2 Robot Body





1.3 Handy Controller Function



- **ROBOT EMO Button**

  Press ROBOT EMO Stop will stop operation of Robot and Activate IMM EMO Stop (Emergency)

- **LED Display**

  Display current operation status, error message, initial settings

- **Function Keys**

  These keys are used to access each setting screen and to switch between Auto and Manual Mode.
  To use the function on the bottom half of a key, Hold down the S(Shift) key and then press the function key

- **Arrow Key (Up / Down, Left /Right)**

  Up / Down key move cursor to each item. Left/Right key select each mode.

- **Manual Operation Key (Also Numeric Key Pad)**

  Operate each axis or robot in manual mode
  For Timer setting, Search mold number and Input Numeric number.

- **Enter Key**

  Store the number and selected mode.

- **C (Clear) Key**

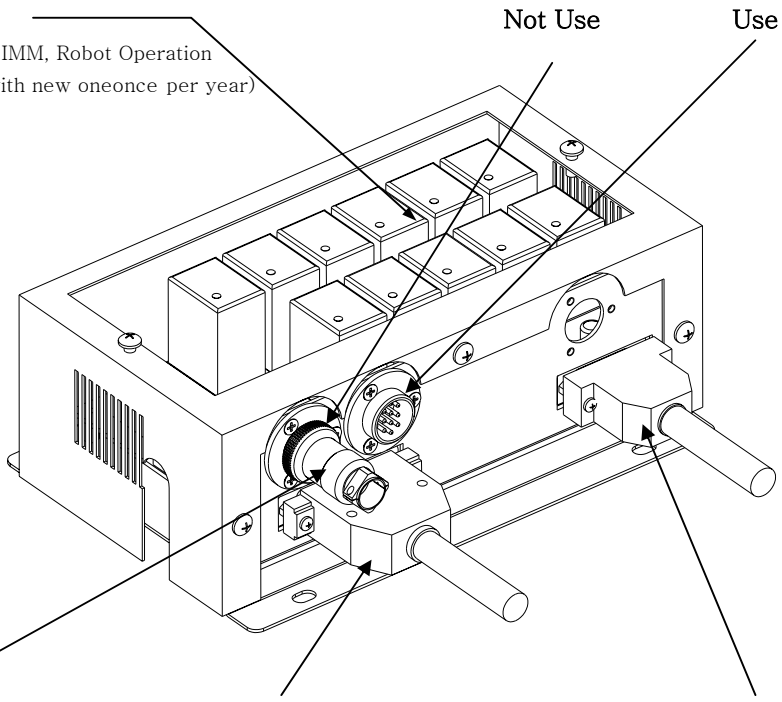
  Cancel, Clear Error

- **S(Shift) Key**

  S key will use for upper case commend

1.4 Interlock and Control Box

Interlock control box communicate and interlock the signal between the injection molding machine and the take-out robot. When robot is in use, connect the Plug to USE Socket, when robot is not in use (Operate IMM only) , move the Plug to Not Use socket.



Plug

This plug is used when robot in use or not in use (not in use : IMM operation only)

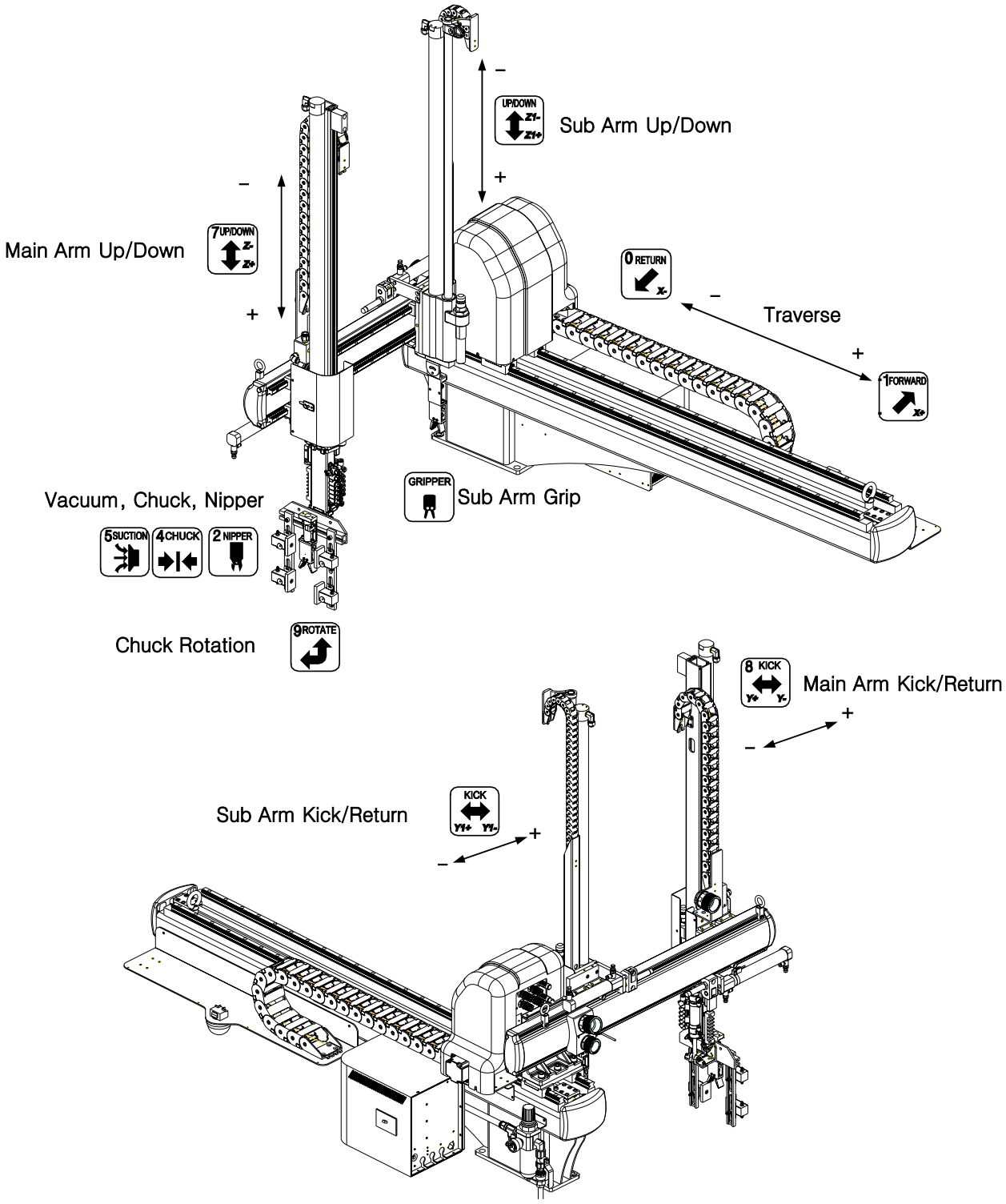
Molding Machine Interlock Cable

This cable is used to connect with the molding machine.

Robot Cable

This cable is used to connect the robot body to the interface box.

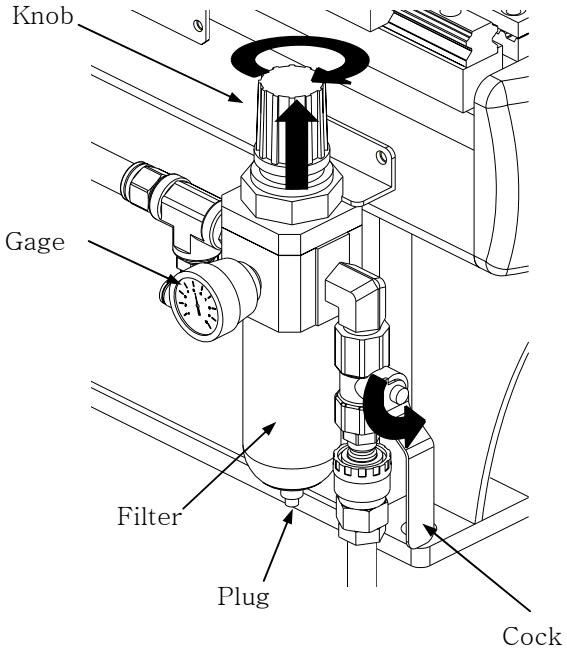
1.5 Each Axis


Sub Arm Up/Down
UP/DOWN
Z1-
Z1+
–
+
Main Arm Up/Down
7 UP/DOWN
Z-
Z+
0 RETURN
X-
Traverse
1 FORWARD
X+
Vacuum, Chuck, Nipper
5 SUCTION
4 CHUCK
2 NIPPER
GRIPPER
Sub Arm Grip
Chuck Rotation
9 ROTATE
8 KICK
Y+
Y-
Main Arm Kick/Return
Sub Arm Kick/Return
KICK
Y1+
Y1-

2 Before Operation

2.1 Before Operation

2.1.1 Air regulator



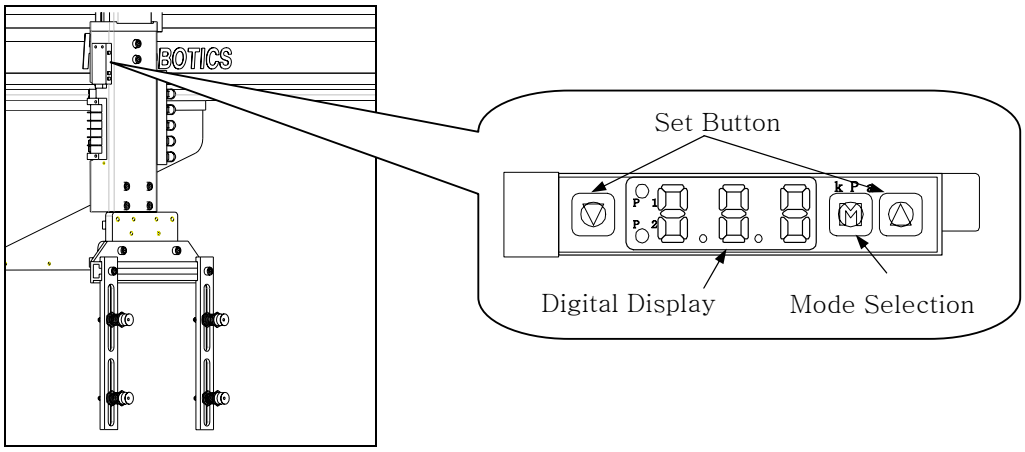
1. Make sure the robot arm is retracted
Beware that the robot may move suddenly as the system is pressurized.

2. Turn Cock to counterclockwise

3. Pull Up the adjusting knob and adjust the pressure to [5.9×10^5 Pa(Gauge) or 6 kg/cm^2] and Push down to set
(Factory set is standard, you might not required to adjust this)

* Remove water from air regulator regularly if required.

2.1.2 Vacuum Verification Sensor Adjustment

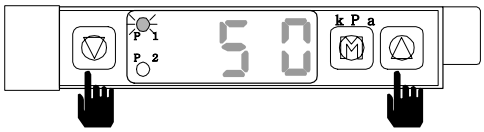


[Main Arm Up/Down]

Vacuum Sensitivity Adjustment (Normally not required)

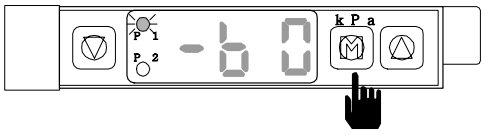
- **STEP 1**

Press (M) and (△) at the same time
P1 will blink.



- **STEP 2**

Press (▽) or (△) , set pressure -60(kpa) .

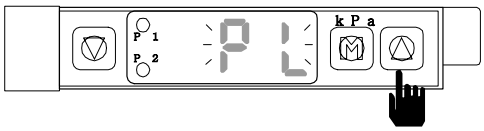


- **STEP 3**

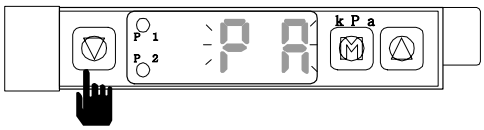
Press (M) more than 1 second.
Set up finished, and LED will display current Vacuum pressure.

Lock and Unlock for Vacuum Sensor value

Locking Vacuum Sensor Value will prevent setup value from changing by mistake



Press (△) more than 3 seconds. "PL" will blink twice and Sensor will lock.



Press (▽) more than 3 seconds "PA" will blink twice and sensor will unlock.

2.2 Before Starting (Preventative Maintenance Schedule)

Before you start daily operation of the robot, perform preventive maintenance.

- Daily

- Check air Pressure is 5~6.5 kg/cm^2 or 5 ~ 7 × 10^5 Pa(Gauge)]
- Check the Power for Robot (110 Volts or 220 Volts)
- Inspecting filter regulator unit : Check the bowl for water and contamination and for correct pressure.
- Check Hoses and Cables : Check for kinks, cuts and tears. Replace as needed.
- Inspecting Shock absorbers and cushions. : Make sure the are operating smoothly
- Checking Gripper return spring : Check that the gripper return spring is operating properly
- Checking residue buildup: Inspect the shafts and gripper for buildup of plastic residue. Clean as necessary.
- Checking Interlock functions. : Make sure the interlock functions are working properly. (Relay might required to be replaced once / year)
- Checking part verification: Check that the parts verification is working properly.
- Check Suction cups

- Weekly or as often as needed.

- Check EOAT mounting screw including gripper : Check EOAT screw for tightness . Tighten as required.
- Inspecting fittings and mounting hardware : Check all fittings, screws, and component mounting hardware for tightness. Tighten as needed.
- Check the safety latch cylinder for Down. : Make sure the safety latch cylinder is working properly
- Testing the Emergency Stop Button. : Verify that the emergency stop works properly.

- Monthly

- Inspecting the filter regulator : Check that the filter regulator is set at the correct pressure. Check the filter and clean or replace it as needed.
- Checking the solenoid valves : Check that the solenoid Valves are working properly. Replace as needed.
- Checking all electrical cables : Inspect all electrical cables for cuts, burns and replace as required
- Checking the exhaust filter.
- Inspecting electrical terminal : Check all electrical terminals for tightness, adjust as

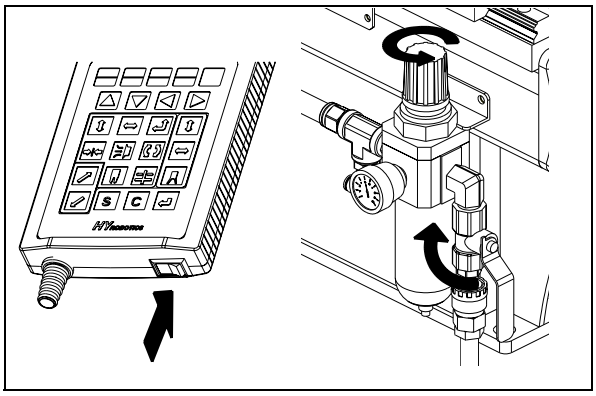
required.

- Inspect each axis cylinder, **make sure operation and the air cylinder cushion** is working properly
- Inspect body for any damage during mold set up or other operation.

2.3Adjust Kick/Return Cylinder

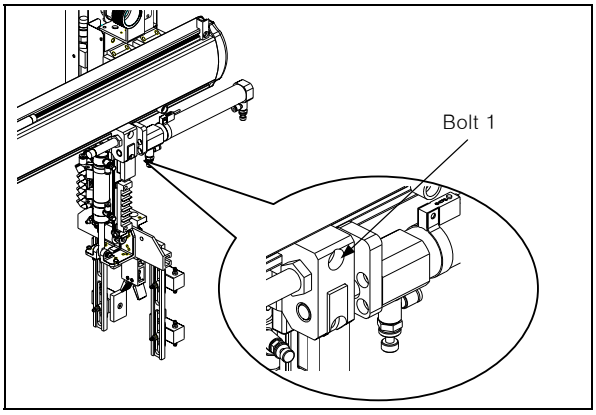
Adjust the location of Kick Cylinder with Kick shock absorber block and bolts

NOTICE This information is designed for main arm. Follow same step for sub arm as described below.



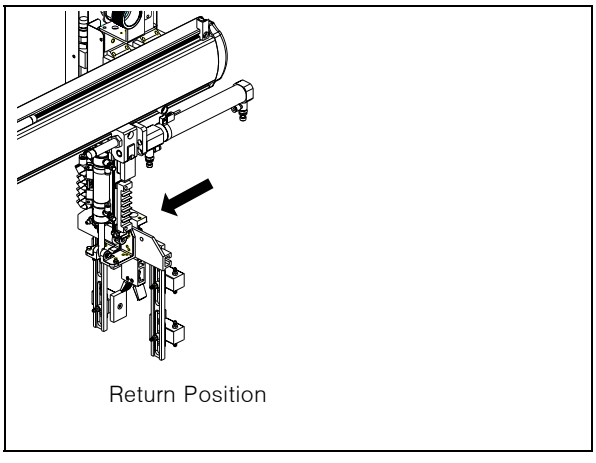
- **STEP 1**

Turn off Power and depressurized system with air regulator or disconnect air.



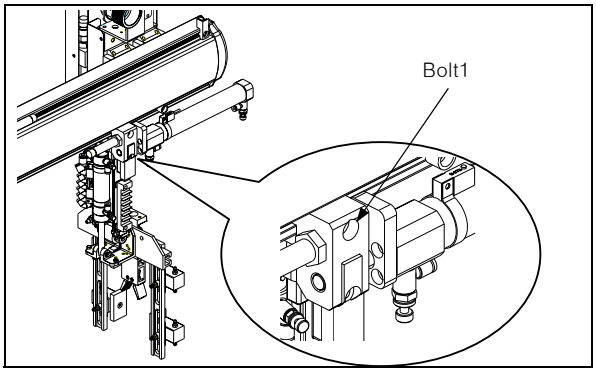
- **STEP 2**

Loosen the Bolt 1



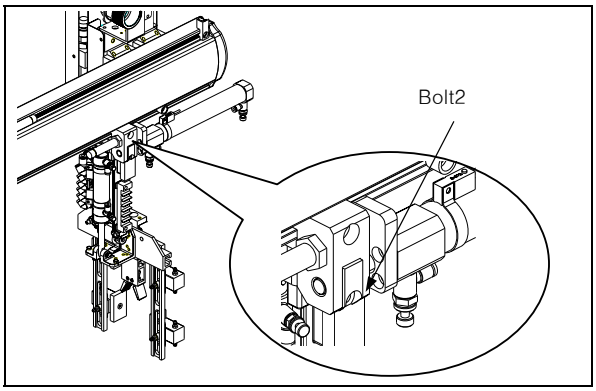
- **STEP 3**

Adjust main arm location and find return position for application.



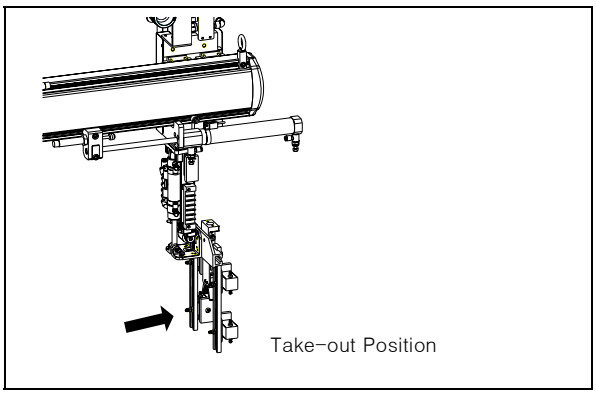
● STEP 4

Push Block to the kick cylinder guide (Till the end of Shock Absorber Stroke) . Tighten the bolt1 .



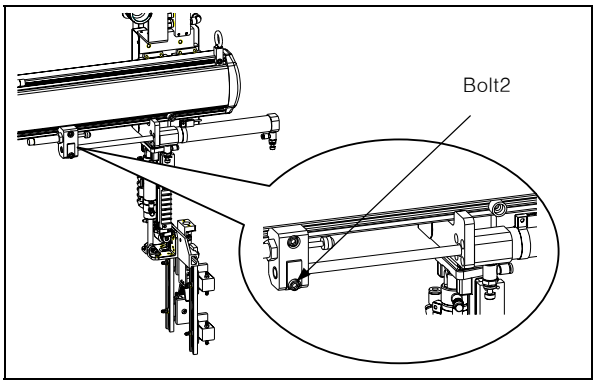
● STEP 5

Loosen the bolt2.



● STEP 6

Adjust main arm location and find return position for application.



● STEP 7

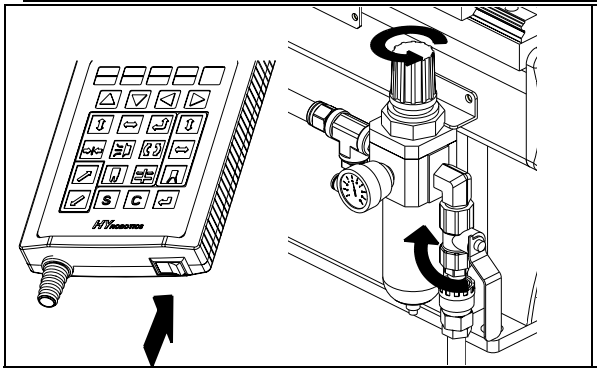
Tighten bolt2

(Please tight bolts after supplying the air)

2.4 Down Stroke Adjustment

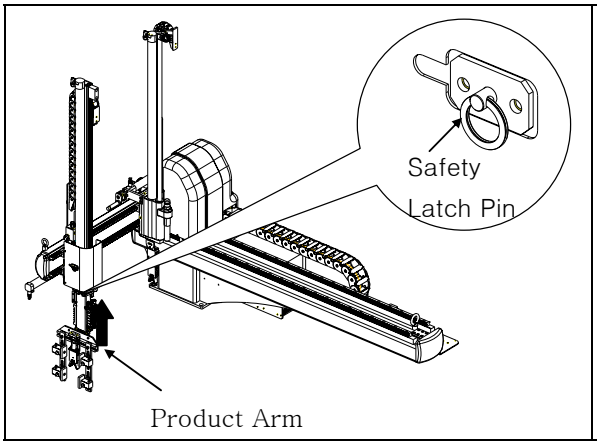
Adjust the stroke for Down Position with Stopper

NOTICE This information is designed for main arm. Follow same step for sub arm as described below.



- **STEP 1**

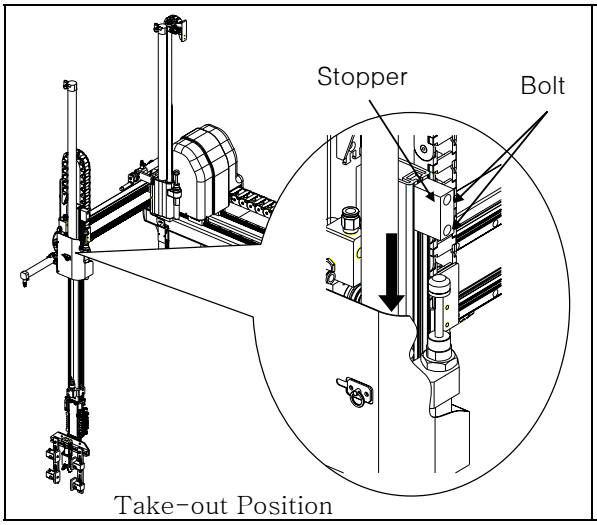
Turn off Power and depressurized system with air regulator or disconnect air.



- **STEP 2**

Slowly lift Arm up and Pull Safety Latch Pin.

Release Arm will allow it Down by gravity

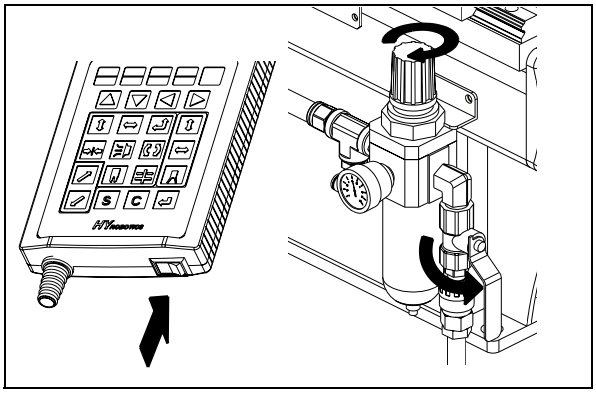


- **STEP 3**

Loosen the bolt and find proper location of EOAT for parts with pushing Shock absorber with Stopper. And Tighten the bolt

Precision positioning for finding suction cups position is required in EOAT location adjustment.

2.5 Speed Control for Down, Kick, Rotation



● **STEP 1**

Normally it is not necessary to adjust speeds because they are factory set.

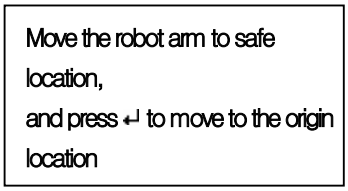
Power On and pressurized system with air regulator or connect air..

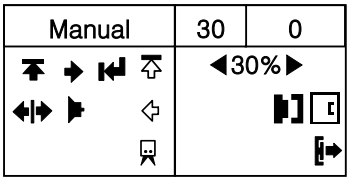
● **STEP 2**

HY Logo will displays and move to Servo Origin screen

⚠DANGER

Before operate Servo Origin, make sure the robot arm is in safe location. If robot arm is not if safe location, move robot arm manually to safe location with manual button.

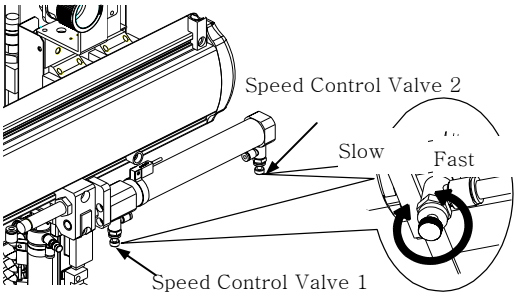




● **STEP 3**

Press ENTER will move each axis arm to servo origin point. And then screen will display manual operation screen.

Speed Control for Kick



● STEP 4

To adjust the Kick Cylinder speed, use speed control Valve 1.

To adjust the Kick Return Cylinder speed, use speed control Valve 2.

Turn the speed controller clockwise to reduce the speed and counterclockwise to increase the speed.

● STEP 5

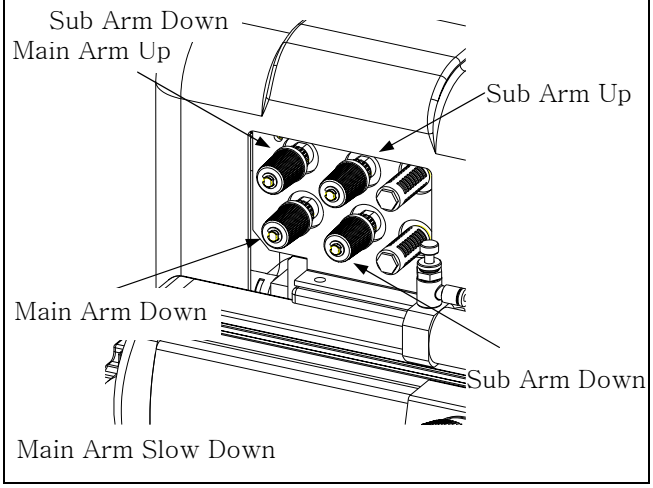
Press 

will activate kick and kick return.

Make sure the operation speed is proper. If not perform step 4

*Follow same step to adjust speed sub arm kick speed control.

Speed Control for Down/Up



● STEP 6

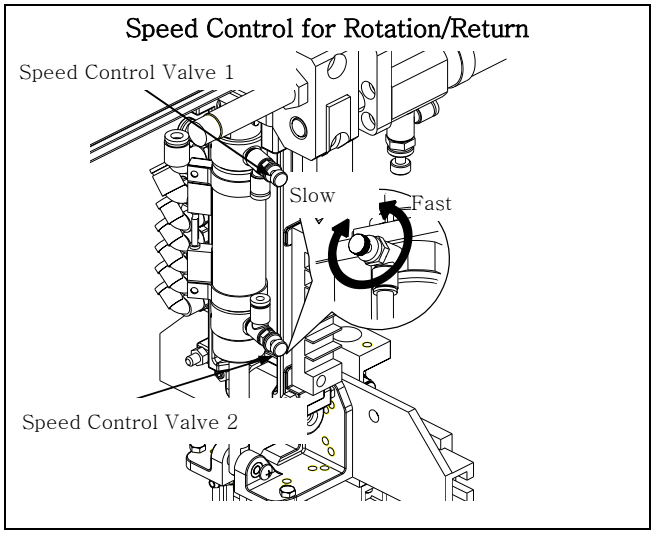
Turn the speed controller clockwise to reduce the speed and counterclockwise to increase the speed.

● STEP 7

Press 

for main arm descent(down), press 

for sub arm, check the speed.



● STEP 8

To adjust the Rotation Cylinder speed, use speed control Valve 1.

To adjust the Rotation Return Cylinder speed, use speed control Valve 2.

Turn the speed controller clockwise to reduce the speed and counterclockwise to increase the speed..

● STEP 9

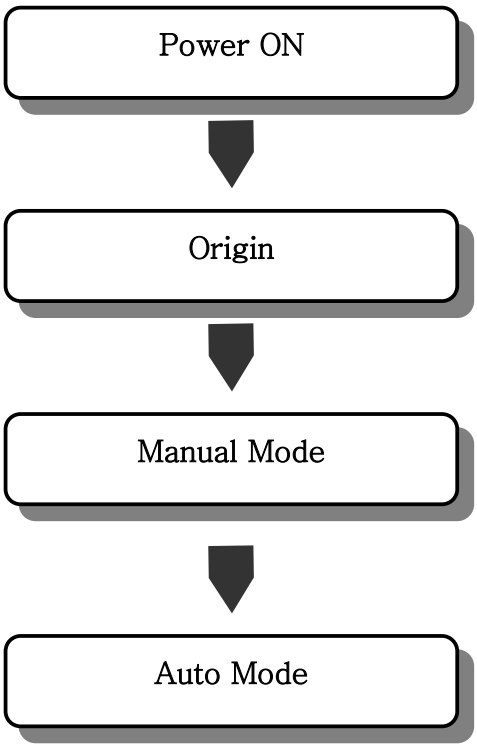
Press 

will activate Rotation and Rotation return. Make sure the operation speed is proper. If not, perform step 4 to adjust speed.

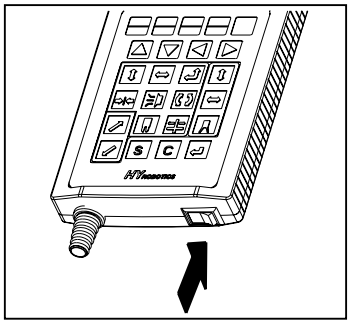
3. START UP / STOP

3.1 STEP FOR START-UP

Follow step for Auto Operation



3.2 Start Up



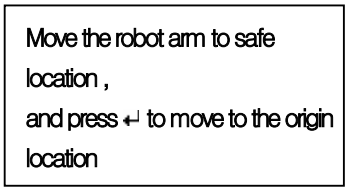
● **STEP 1**

Turn On Power.

● **STEP 2**

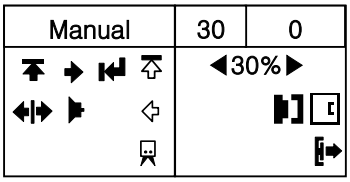
It will display System Version. And move to origin screen.

⚠DANGER Before operate Servo Origin, make sure the robot arm is in safe location. If robot arm is not if safe location, move robot arm manually to safe location with manual button.



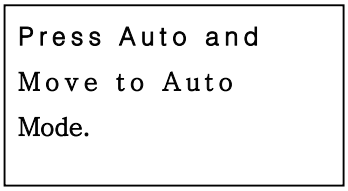
● **STEP 3**

Press [ENTER] will move each axis arm to servo origin point. And then screen will display manual operation screen.



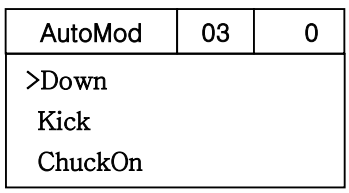
● **STEP 4**

Press [AUTO TEACH] and move to Auto Message Screen.



● **STEP 5**

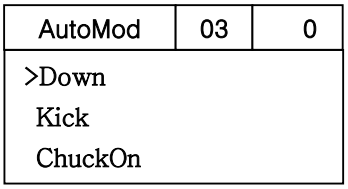
Press [AUTO TEACH] and move to Auto Mode.



● **STEP 6**

Robot arm will move initial position and start Auto Operation

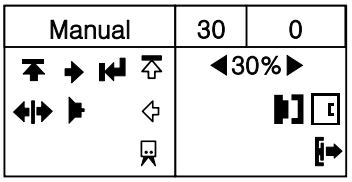
3.3 Stop Operation



- **STEP 1**

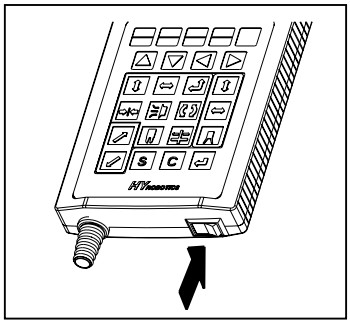
Press STOP for Auto Mode

It will stop the operation after finish to run last step. And moves to manual mode.



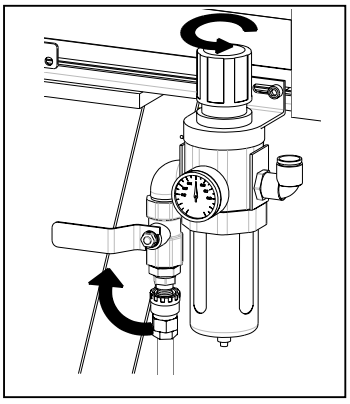
It will not stop in the middle of step . If robot runs any step, it will finish the step and stop before next step. (Due to Pneumatic Operation Pressure)

⚠WARNING Turn Off Handy Controller, Power off Molding Machine.



- **STEP 2**

Turn Off Power

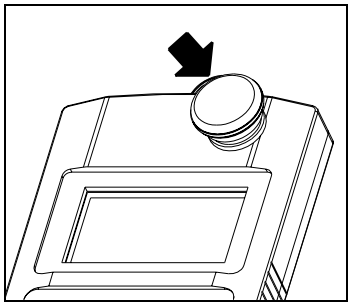


- **STEP 3**

Disconnect Air Pressure.

3.4 Emergency Stop (EMO Stop)

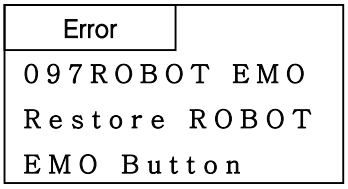
Press ROBOT EMO button in any dangerous situation (Protect People, Robot, Mold Etc)



- **STEP 1**

Pressing ROBOT EMO button.

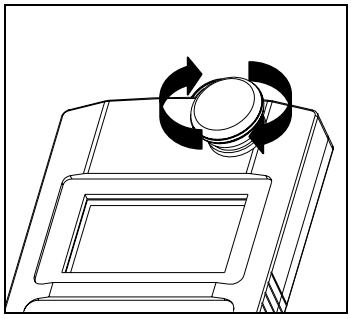
Robot will move to waiting position and stop Operation.



Alarm and buzzer will be on and Error message will appear in the handy controller.

3.5 Restoring Emergency Stop

> **⚠ WARNING** Eliminate Emergency Environment before restoring ROBOT EMO button.



- **STEP 1**

Eliminate Emergency Stop Situation.

Rotate ROBOT EMO button to Clock Wise

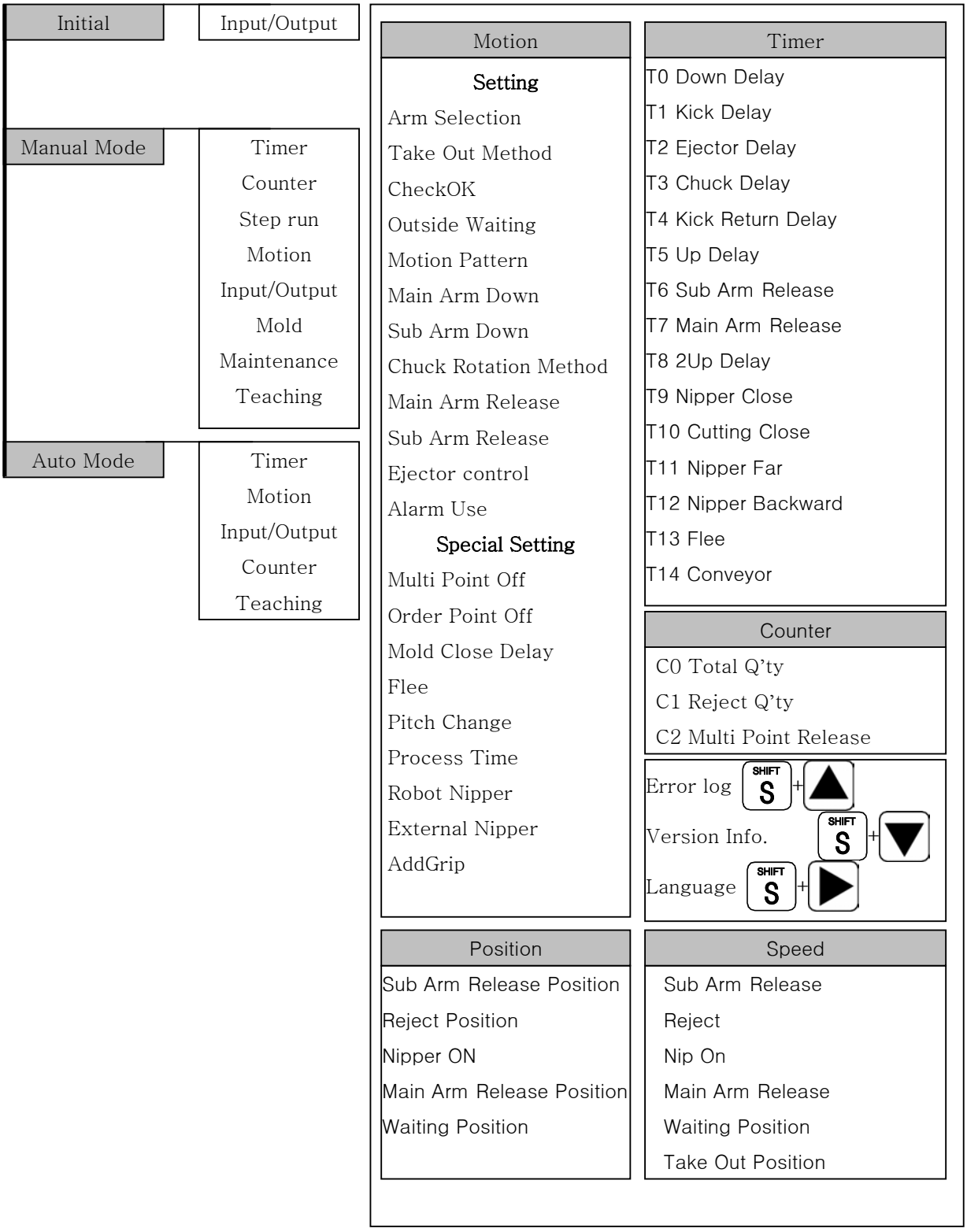
- **STEP 2**

Press 

and stop Alarm and Buzzer, moves to Manual Mode.

4 OPERATION

4.1 Screen Structure



4.2 Initial Screen

Power on displays Logo and Robot Name/type , Robot Initiation and Move Origin Point

NOTICE	Selecting Outside Waiting Option will initiate Robot move to the selected location (Outside of Mold)

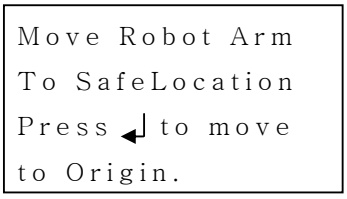
4.3 Searching Robot Origin Point

(1) Description

Robot will operate with following step automatically to search origin point. 1. Ascent, 2. Kick Return, 3. Rotation Return, 4. Swivel Return and 5. Traverse Axis search origin point (This Step is developed to have more safety movement when restart robot)

Selecting Outside Waiting Option will initiate Robot move to the selected location (Outside of Mold) . Handy controller screen displays manual operation after finish origin point searching

NOTICE Before operate Servo Origin, make sure the robot arm is in safe location. If robot arm is not if safe location, move robot arm manually to safe location with manual button.



(2) Button Function

NO	Button	Description
1		Operate Robot arm moves Traverse X+
2		Operate Robot arm moves Traverse X-
3		Search Origin Point and Initiate Robot Position
4		Display input / output signal screen

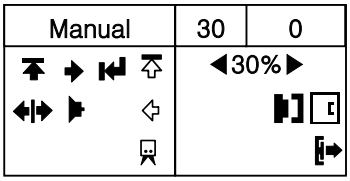
4.4 Manual Operation

(1) Description

In the manual operation mode , robot can be operated with manual operation button

Selecting Outside Waiting Option will initiate Robot to move to the selected location

> **⚠DANGER** CLEARING ROBOT MOTION AREA : It is the responsible of the operator to verify that the robot motion area is clear before any robot operation.



ICON Description on Handy Controller					
NO	Icon	Description	No	Icon	Description
1		Main Arm Down	12		Vacuum Off
2		Main Arm Up	13		Chuck
3		Main Arm Up Complete	14		Chuck Off
4		Main Kick	15		Sub Arm Down
5		Main Kick Complete	16		Sub Arm Up
6		Main Kick Return	17		Sub Arm Up Complete
7		Chuck Rotation	18		Sub Arm Kick
8		Rotation Complete	19		Sub Arm Kick Return
9		Chuck Rotation Return	20		Sub Arm Grip
10		Rotation Return Complete	21		Sub Arm Grip Off
11		Vacuum On			
Injection Molding Machine Interlock Signal					
Input			Input		
NO	NO	NO	NO	NO	NO
1		Full Auto	6		Mold Open/Close Complete Signal
2		Auto Injection	7		Ejector Signal
3		Mold Open Complete			
4		Safety Door			
5		Ejector Forward Complete			

(2) Button Function

⚠DANGER Do not enter robot motion area. If anyone enter the robot motion area during Auto operation or Manual Operation, serious accident could results.

NOTICE Robot arm will not descent if mold is not open. (or Safety Door Closed:Option)

NO	Button	Description
1	TIMER / COUNT	Press Timer button, LCD displays timer mode for delay time settings.
2	SHIFT S + TIMER / COUNT	Press Timer button with Shift button. (Counter) LCD displays Counter screen, Counter screens display Total Q'ty, Detection Fail, Mult Point Release.
3	MODE / MOLD	Press Mode button, LCD displays Mode screen (Motion Mode).
4	SHIFT S + MODE / MOLD	Press Mode Button with Shift button, (Mold) LCD displays Mold Maintenance screen. (Search Mold Number, Open and Create, Delete Mold File)
5	STEP / I/O	Press Step Button LCD displays Step Motion Mode screen (Robot can operate Step by Step Operation.)
6	SHIFT S + STEP / I/O	Press Step Button with Shift Button, (I/O) LCD display Input / Output Signal.
7	AUTO / TEACH	Press Auto Button. LCD displays Auto Mode screen.
8	SHIFT S + AUTO / TEACH	Press Auto Button with Shift LCD display Number input screen to set speed and position with numeric number input.
9	SHIFT S + ▲	Press Up Arrow with Shift Button. LCD displays Error History Screen
10	SHIFT S + ▼	Press Up Arrow with Shift Button. LCD displays Version Info.
11	SHIFT S + ▶	Press Right Arrow with Shift Button. LCD displays the commend in the screen with selected Language.
12	7 UP/DOWN Z- Z+	Press Descent Button Move Main Arm Down, Press again, Move Main Arm up
13	8 KICK Y+ Y-	Press Kick Button Move Main Arm Kick, Press again, Move Main arm Kick Return
14	9 ROTATE	Press Rotate. Rotate Chuck, Press again, Chuck rotate return.
15	4 CHUCK	Press Chuck Chuck , Press again, Chuck Off

NO	Button	Description
16		Press Suction Suction, Press again, Suction Off
17		Press Descent Button for Sub Arm Move Sub Arm Down, Press again, Move Sub Arm up
18		Press Kick Button Move Sub Arm Kick, Press again, Move Sub Arm Kick Return
19		Press Gripper Grip and Grip Off
20		Press WAITPOS LCD displays waiting position setting screen (Option).
21		Press 1 Forward Robot arm will move traverse (X+)

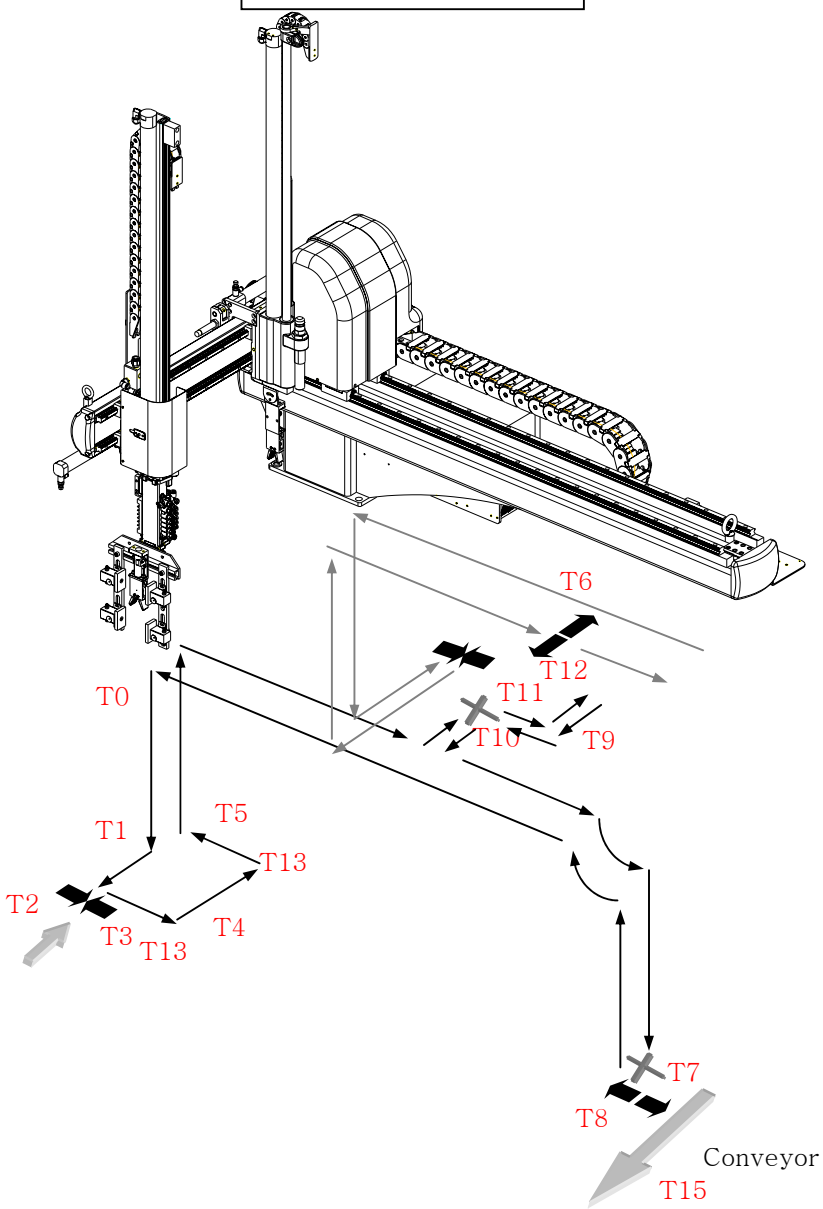
4.1.1 Timer Set Up

(1) Description

Timer setup will control the Robot motion smoothly with Injection Molding Machine Operation.

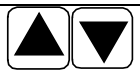
> **⚠DANGER** Timers will not be saved separately with Mold Files. For examples setting T0 as a 0.2 Seconds will make all other mold file use T0 as 0.2 Seconds

Timer	30	0
T0 Down	0.0	0.0
T1 Kick	0.3 <	0.0
T2 Eject	0.1	0.0



NO	Default (sec)	Display	Description
T0	0	Down	After Mold Open Complete, delay time for move arm down
T1	0.3	Kick	After starting Down, Delay time for Kick Movement
T2	0.1	Eject	After starting Kick, Delay time for Ejector Operation
T3	0	Chuck	Chuck Delay
T4	0.2	KicRt	Kick Return Delay
T5	0.5	Up	Ascent(Up) Delay
T6	0.1	SOpen	Sub Arm Release
T7	0.2	MOpen	Main Arm Release
T8	0.5	2Up	2nd Ascent(Up) Delay
T9	0.5	NiCls	Nipper Close
T10	0.5	CutDl	Cutting Delay – Robot Nipper, External Nipper
T11	0.5	NiFar	Nipper Far – Robot Nipper, External Nipper
T12	0.5	NiBwd	Nipper Backward
T13	0.3	Flee	Flee
T14	3	Conve	After 2nd Up, Delay time for Conveyor Operation

(2) Button Function

NO	Button	Description
1		'<' key moves up and down to select each Timer.
2	Numeric Key	Displays Delay Time.
3		Press the Enter Button to save the change
4		Cancel the Input
5		Stop Auto Operation and Back to Manual Mode
6		Pressing Auto Button will back to Auto Operation Mode

(3) Programming Timer Settings

Timer settings can be viewed and changed using the handy controller under two conditions.

1. When the robot is in Timer Mode. 2. During Auto Mode (While Robot is running)

> **NOTICE**
>
> Timer can be changed during Auto Mode, but cannot be changed during Cycle and Step Operation.
> Press the Timer button to move Timer Mode while in Auto Mode

Setting T1 (Kick Delay) to 0.5 Seconds

Timer	30	0
T0 Down	0.0 <	0.0
T1 Kick	0.3	0.0
T2 Eject	0.1	0.0

- **STEP 1**

Press [TIMER / COUNT] move to Timer Mode in Manual Mode

Timer	30	0
T0 Down	0.0	0.0
T1 Kick	0.3 <	0.0
T2 Eject	0.1	0.0

- **STEP 2**

Press [▼] , Move < to the T1 (Kick)

Timer	30	0
T0 Down	0.0	0.0
T1 Kick	0.3 <	0.5
T2 Eject	0.1	0.0

- **STEP 3**

Press [5 SUCTION], input 0.5 sec. (Press 0 and 5)

Timer	30	0
T0 Down	0.0	0.0
T1 Kick	0.5 <	0.5
T2 Eject	0.1	0.0

- **STEP 4**

Press the [ENTER] to save the change

Manual	30	0
	◀30%▶	

- **STEP 5**

Press [STOP / MANUAL], Move to Manual Mode.

4.1.2 Counter

(1) Description

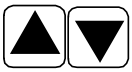
Counter can be viewed and changed using handy controller.

Counter Mode displays Total Production Quantity , Detection Failure Quantity, Multi Point Release.

Counter	30	0
>C0 TotQty	10000	
C1 DetFai	3	
C2 MulRel	2/4	

NO	Name	Description
C0	TotQty	Total Operation (Production) Q'ty : Robot Operation Cycle after Reset
C1	DetFai	Detection Failure Q'ty
C2	MulRel	Current Multi Release(Off) number and Total Multi Release(Off) number

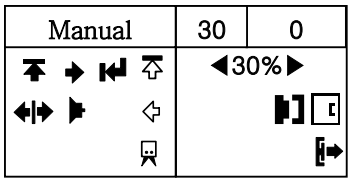
(2) Button Function

NO	Button	Description
1		Pressing arrow key scroll the > key through the list.
2		Press Clear Key will Reset the item on > key. Press more than 2 seconds..
3		Press Stop button to change Manual Operation mode..
4		Press Auto button to back to Auto Operation Mode

(3) Counter Reset Method

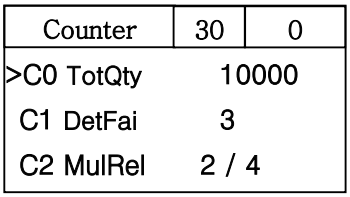
NOTICE Counter can be changed during Auto Mode, but can not be changed during Cycle and Step Operation.

Resetting C0 to 0



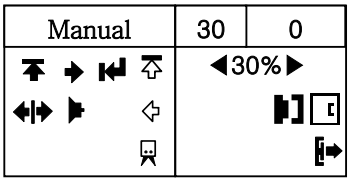
● **STEP 1**

Press, TIMER COUNT with SHIFT S key , it displays Counter Screen.



● **STEP 2**

Press CLEAR C for 2 seconds, Total will be 0 (Reset).



● **STEP 3**

Press STOP MANUAL displays manual mode

4.1.3 Motion Mode

(1) Description

SHIFT S + MODE MOLD	Press Mode Button with Shift button, (Mold) LCD displays Mold Maintenance screen. (Search Mold Number, Open and Create, Delete Mold File)

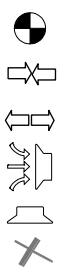
And Press Enter will creat new mold or you can select saved mold (motion pattern with arrow key)

Robot motion pattern can be decided by selecting of Each Motion Mode.

ArmSet	M&S ◀
Method	Vacuum
ChuckOk	Use
OutWait	NoUse

NOTICE

The below icons uses for robot motion in this book

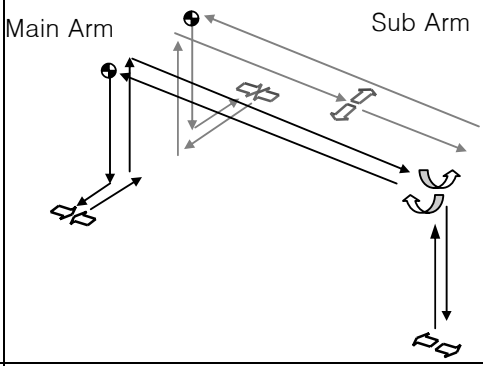
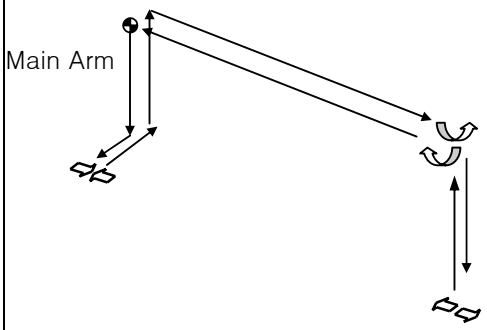
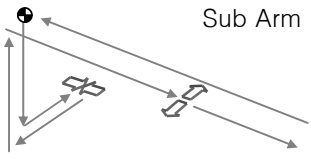


Origin
Chuck
Chuck Off
Vacuum
Vacuum
Cutting

① Robot Arm Setting (Press Right arrow button will change and Press Enter to save) And Press down arrow button to go to next line)

Setting for Take-Out Motion Arm. Default setting is “M&S”.

ArmSet	M&S ◀
Method	Vacuum
ChuckOk	Use
OutWait	NoUse

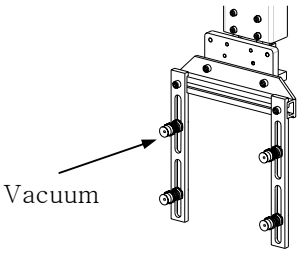
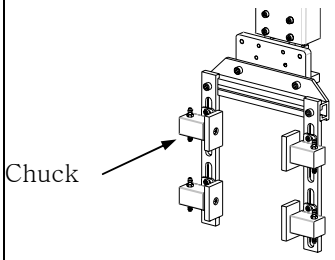
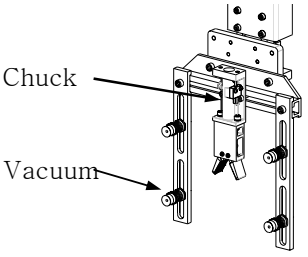
Name	Description	Motion
M&S (=Default)	Select Main and Sub for Both Arm opeartion	
M-Arm	Select Main for Main Arm Operation (Taking Out Parts)	
S-Arm	Select Sub for Sub Arm Operation (Sprue or Gate Picking)	

② Method

Settings take out method, Vacuum, Chucking.

Default setting is “Vacuum”.

ArmSet	M&S	
Method	Vacuum	◀
ChuckOk	Use	
OutWait	NoUse	

Name	Description	Motion
Vacuum (=Default)	Take out Parts with Vacuum Operation.	
Chuck	Take out Parts with Chuck Operation.	
Vac+ Chu	Take out Parts with Vacuum and Chuck Operation.	

③ Chuck Confirm

When use Suction and Vacuum function at the same time for takes out method, need to select use or no-use for Chuck confirmation sensor. Factory set is “Use”

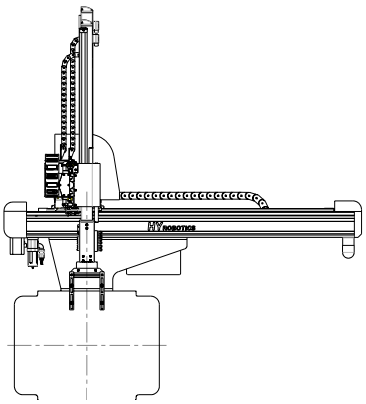
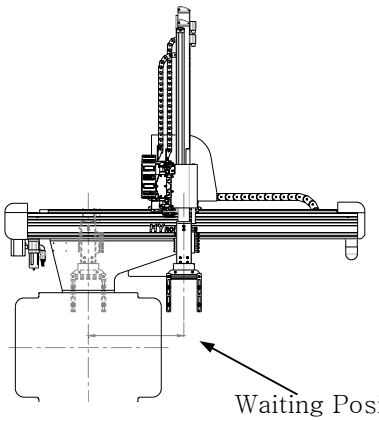
ArmSet	M&S	
Method	Vacuum	
ChuckOk	Use	◀
OutWait	NoUse	

④ Outside Waiting

When many other auxiliary products are attached on the top of the mold, robot might not able to wait on the top of the mold until the mold is completely open. Robot has function to wait outside of IMM, and robot will move to IMM after mold is completely open. (This is for minimizing crash with Robot EOAT and Attachments of Mold (Like Hose, Cylinder, Core etc).

Need to set waiting position outside of the range of Descent (Down) Area. Default setting is “NoUse”.

ArmSet	M&S	
Method	Vacuum	
ChuckOk	Use	
OutWait	NoUse	◀

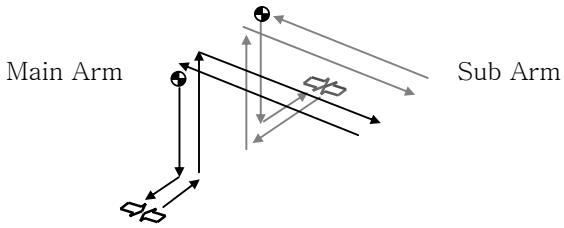
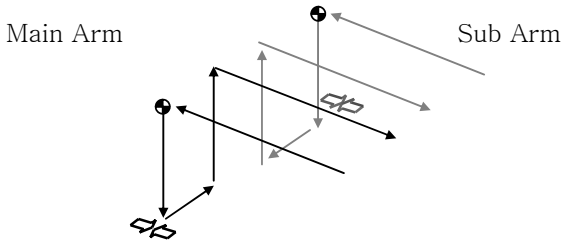
Name	Description	Motion
NoUse (=Default)	Robot waits on the top of the mold until mold is completely open.	
0 mm	Robot waits outside of mold until mold is open. (Outside Waiting Distance is mm) Need to set waiting position outside of the range of Descent (Down) Area	

⑤ Motion Pattern

There are two types of motion, L and U type. L type is 1.Down, 2 Kick, 3 Vacuum or Chuck, and Out and U type is 1.Down, 2.Vacuum or Chuck 3. Kick and Out. Main and Sub arm set together.

Default setting is “LType”.

Motion	Ltype	◀
MArmDn	Nozzle	
SArmDn	Clamp	
ChuckRot	BeforeT	

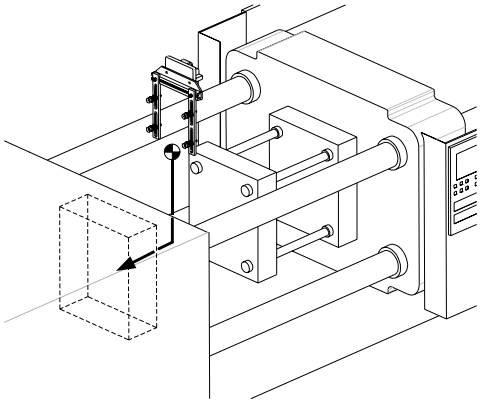
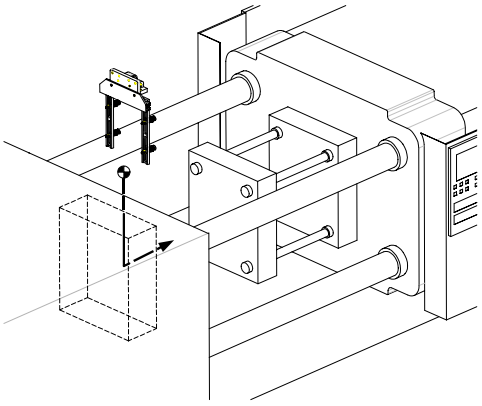
Name	Description	Motion
LType (=Default)	Main and Sub Arm operate 1. Descent, 2 Kick, 3 Chuck or Vacuum 4 Kick Return, 5. Ascent.	
UType	Main and Sub Arm operate 1. Descent, 2 Chuck or Vacuum 3 Kick Return, 4. Ascent.	

⑥Main Arm Down

Main Arm Descent position can be set up at either nozzle side or clamp side.

Default setting is “Nozzle”.

Motion	Ltype	
MArmDn	Nozzle	◀
SArmDn	Clamp	
ChuckRot	BeforeT	

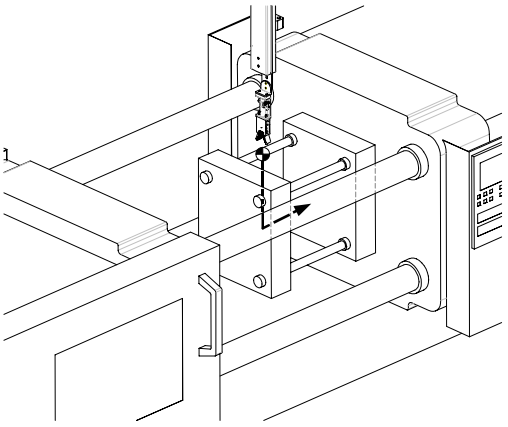
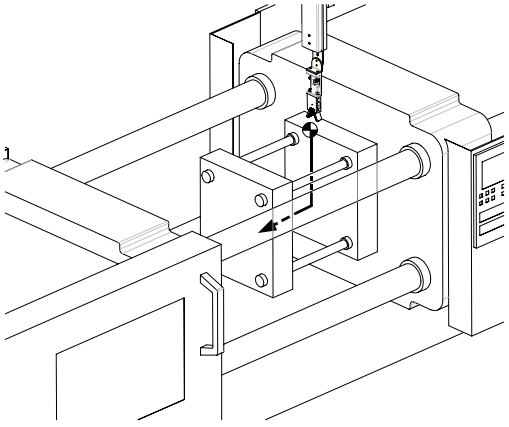
Name	Description	Motion
Nozzle (=Default)	Main arm descent(down) at nozzle side	
Clamp	Main arm descent(down) at clamp side	

⑦Sub Arm Down

Sub Arm Descent position can be set up at either nozzle side or clamp side.

Default setting is “Clamp”

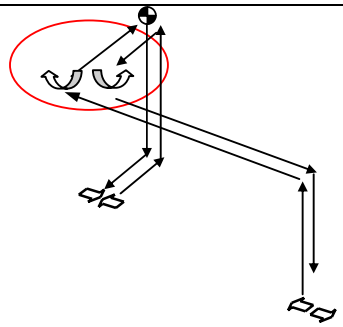
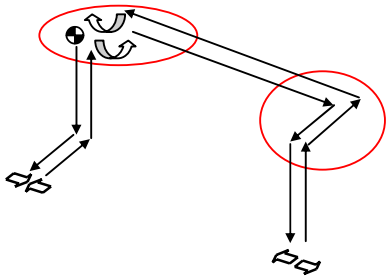
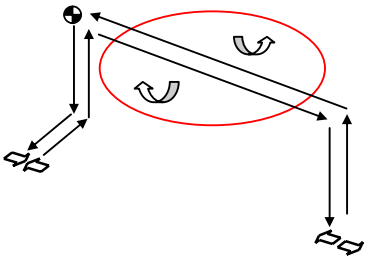
Motion	Ltype	
MArmDn	Nozzle	
SArmDn	Clamp	◀
ChuckRot	BeforeT	

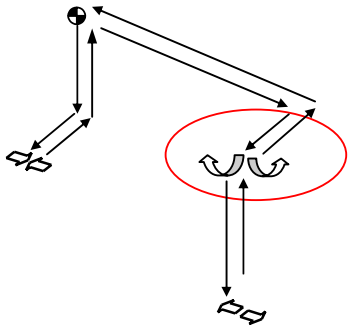
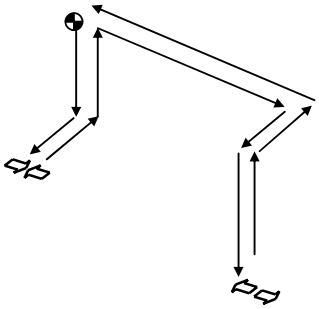
Name	Description	Motion
Clamp (=Default)	Sub arm descent(down) at clamp side	
Nozzle	Sub arm descent(down) at nozzle side	

⑧EOATRot

EOATRot means EOAT rotation time setting
Default setting is “BeforeT”. (Before Traverse)

Motion	Ltype
MArmDn	Nozzle
SArmDn	Clamp
EOATRot	BeforeT ◀

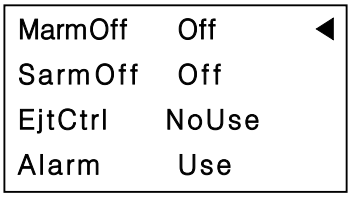
Name	Description	Motion
BeforeT (=Default)	Before T : Before Traverse Movement. Chuck (EOAT) unit rotates before traverse movement to prevent EOAT unit from crash with Safety Door. (After Kick)	
NoKick	No Kick : No Kick , Before Traverse Movement. Chuck (EOAT) unit rotates before Kick motion and traverse movement to prevent EOAT unit from crash with Safety Door. (After Kick) and Core of the Mold (Some Mold has core)	
WhileT	Operate Traverse, Kick, Chuck(EOAT) Rotation simultaneously. (High Speed).	

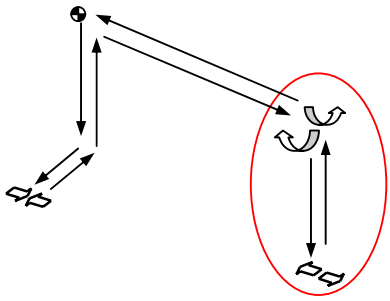
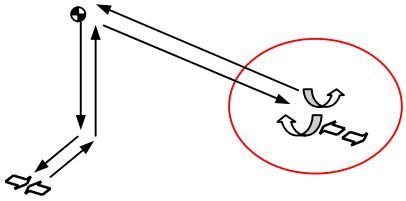
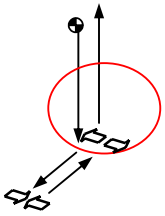
AfterT	After T : After Traverse, After Traverse and Kick, EOAT Chuck Rotate.	
NoRot	No Chuck(EOAT) Rotation	

⑨Main Arm Release(Off)

MArmOff : Main Arm Release(Off), Set Main Arm Off(Parts Release) Timing

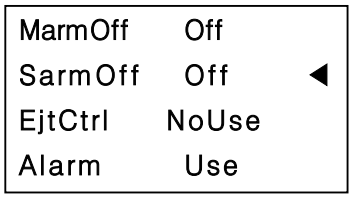
Default setting is “Off”.

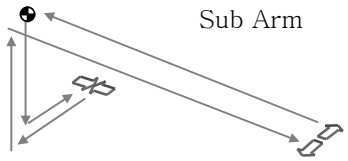
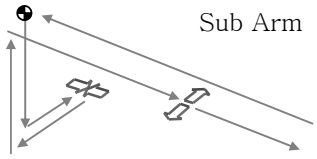
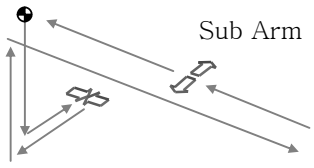
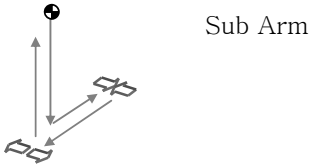


Name	Description	Motion
Off (=Default)	Traverse and Descent (Down) and Main Arm Release (Off) the Products. (Default)	Main Arm 
NoDown	Traverse and Release Products without Descent(Down)	Main Arm 
InMold	Products Arm Release(Off) the products in Mold (Drop In the IMM)	Main Arm 

⑩Sub Arm Release(Off)

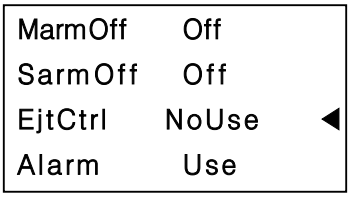
SArmOff : Sub Arm Release(Off), Set Sub Arm Off(Parts Release) Timing Default setting is "Off".

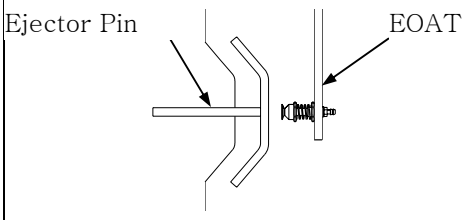
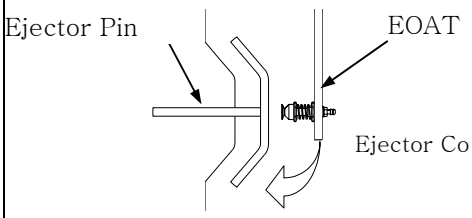


Name	Description	Motion
Off (=Default)	Traverse and Release(Off) the Runner (Sub Arm)	
TrvOff	Sub Arm Release (Off) while traversing.	
ReOff	Sub Arm Release (Off) while traversing return .	
InMold	Sub Arm Release (Off) in Mold.	

⑪Ejector Control

When Automate Thin Plate Molded Products or Products can be drop with Ejector Kick Operation easily, Robot can control IMM Ejector. Default setting is “NoUse”.

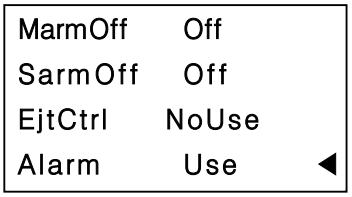


Name	Description	Motion
NoUse (=Default)	Ejector is controlled by IMM (Default)	
Use	Ejector Kick operation can be controlled by Robot. Ejector Kick operation number can be changed. Default Number is 1 time,	

⑫Alarm (Buzzer)Use

Set Alarm (Buzzer) function in Use or Not in Use

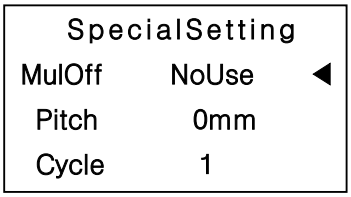
Default setting is “Use”.

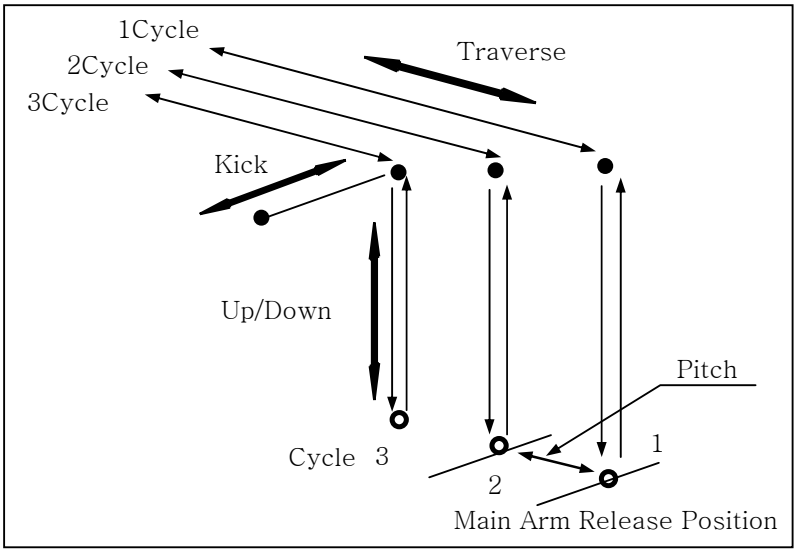


Name	Description
Use (=Default)	When Error occurs, Alarm will make a Buzzer (Siren Noise)
NoUse	When Error occurs, Alarm will not make a Buzzer (No Siren Noise)

⑬Multi Point Off

Each cycle can release (Off) part in a different location (Position) with specified distance with Multi Point Off Function. Default setting is “NoUse”. If “USE” , Default number of point is “ 1 “.





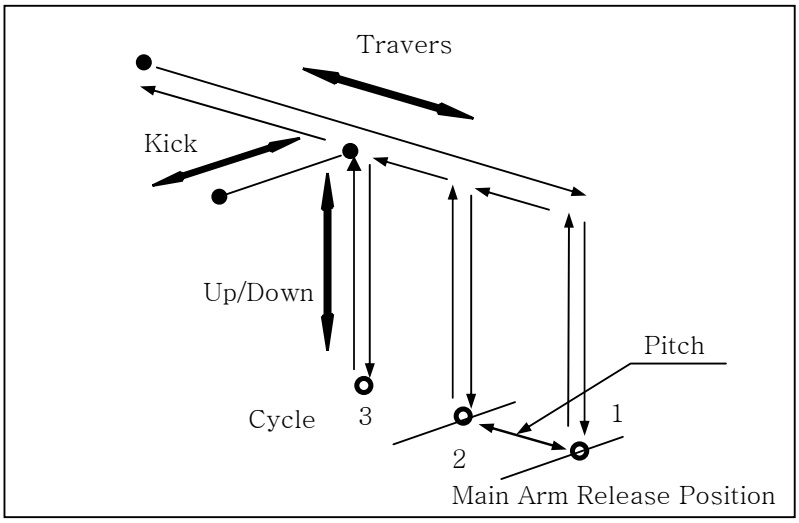
NOTICE (Pitch X Number of Cycle) should be in the distance of (Products Release(Off) position – Descent available location)

⑭Order Point Off (Option : Additional Vacuum circuit required)

When there are more than 2 cavity products in the mold, each cavity part can be released different position with Order Point Off Option.

Default setting is “NoUse”. If “USE” , Number of Cavity is “ 2 “

OrdOff	NoUse	◀
Pitch	0mm	
Cycle	1	



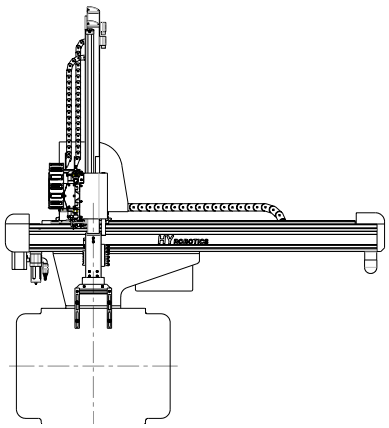
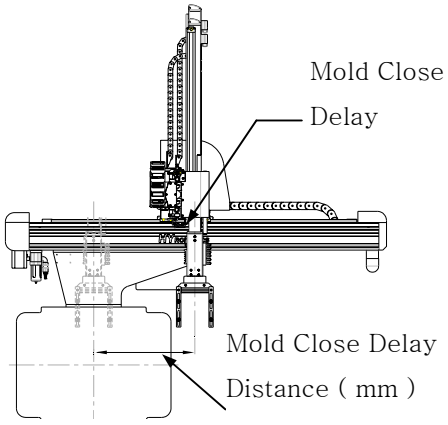
NOTICE Order Point Off (Pitch x Number) should be lower than Multi Point Off’s pitch

NOTICE This is optional feature, Please contact factory

⑮ Mold Close Delay

Robot can delay the mold close, after taking out the parts from the mold, ascent, until traverse movement to set position . Default setting is “NoUse”. Position can be set in the range of Robot descent range.

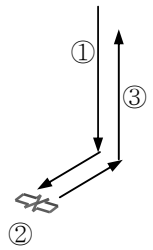
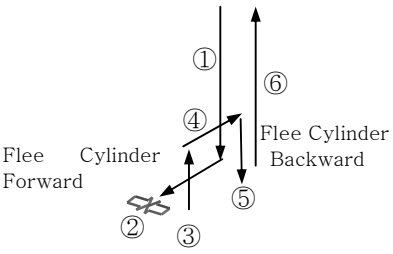
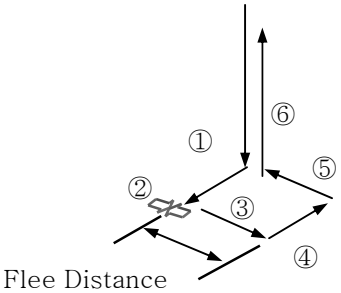
MdClos	NoUse ◀
Flee	NoUse
Pitch	NoUse
Swivel	NoUse

Name	Description	Motion
NoUse (=Default)	No mold close Delay function. Mold will close after robot arm ascent.	
Use	Mold will not close until the robot move to traverse position (mm)	

⑯Flee (Optional feature) : Some other robot company says this feature as Undercut
After Chuck or Suction the parts in mold, robot can move traverse axis (-X+) or up in mold so that parts can escape from core and Ejector attachments to take out from the mold.
Default setting is “NoUse”.

NOTICE This is optional feature, Contact factory to add this feature.

MdClos	NoUse
Flee	NoUse ◀
Pitch	NoUse
Swivel	NoUse

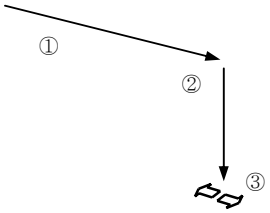
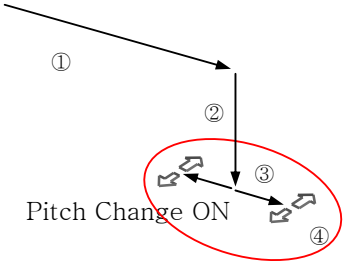
Name	Description	Motion
NoUse (=Default)	Not in Use	
Cylin (Option)	After Chuck or Suction the parts, operate cylinder and move to up or down position and take out parts from mold * Need special Cylinder attachment	
0 mm (Traverse)	After Chuck or Suction the parts, Robot can move to traverse axis with set distance.(mm)	

⑰Pitch Change(Option)

When robot release (off) parts with different pitch of the part's pitch of the mold, additional EOAT can be added with cylinder to change the pitch distance of the release (off) Default setting is "NoUse".

NOTICE This is optional feature, Contact factory to add this feature.

MdClos	NoUse
Flee	NoUse
Pitch	NoUse ◀
Swivel	NoUse

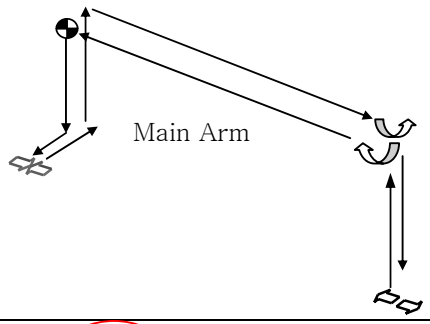
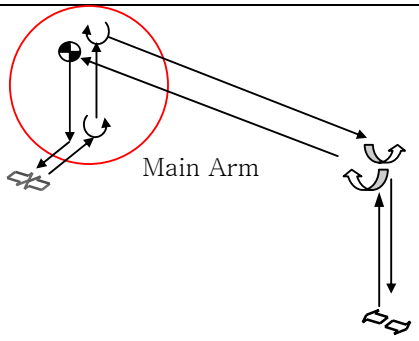
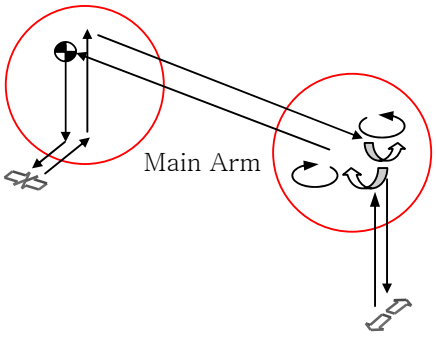
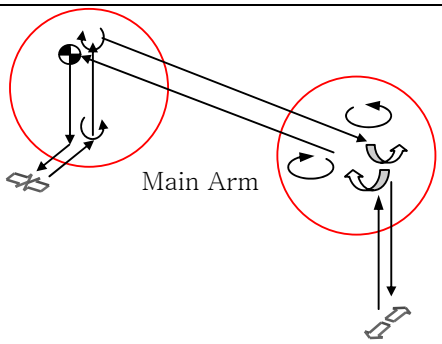
Name	Description	Motion
NoUse (=Default)	No Use	
Use	Installed EOAT cylinder can change pitch distance of the parts (Optional Feature)	

⑱Vertical Swivel (Option)

Set the Swivel operation timing. (Robot EOAT can Rotate with Vertical Axis)

Default setting is “NoUse”.

MdClos	NoUse
Flee	NoUse
Pitch	NoUse
Swivel	Swivel ◀

Name	Description	Motion
NoUse (=Default)	Not in Use	
Swivel	Robot EOAT swivel in mold and Ascent (Up) and Swivel Return. (This feature can be added when the parts is too parallel too long so that Part can not move up because of tie bar distance. Like Car Bumper)	
RoAfT	Robot EOAT swivel after traverse	
InTrv	Robot EOAT swivel in Mold and swivel return after traverse. .	

⑲Process Time (Production Time)

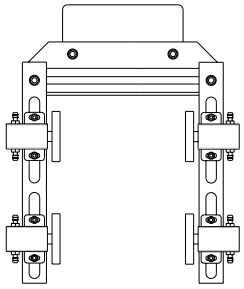
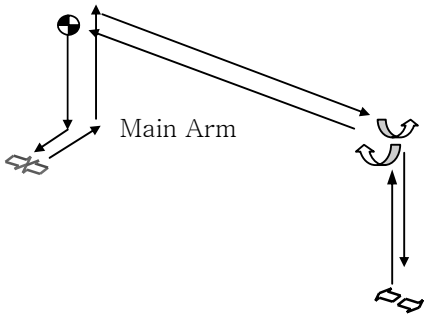
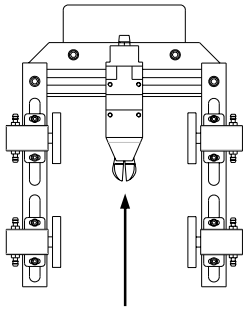
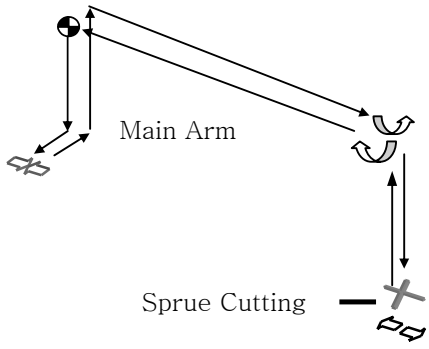
This time is for 1 total cycle of the production. If exceed error this time, it occur Process Time Error. Set time as “0” second will not occur any error. Default setting is 0 sec.

Ptime	0 sec	◀
RoNipp	NoUse	
ExNipp	NoUse	
AddGrip	NoUse	

⑳Robot Nipper (Option : Nipper, Valve required)

Robot cut sprue or runner with attached nipper on EOAT

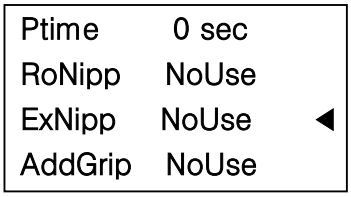
Ptime	0 sec	
RoNipp	NoUse	◀
ExNipp	NoUse	
AddGrip	NoUse	

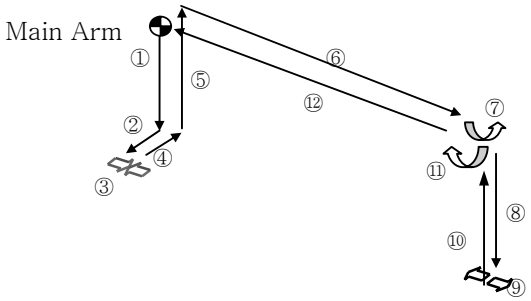
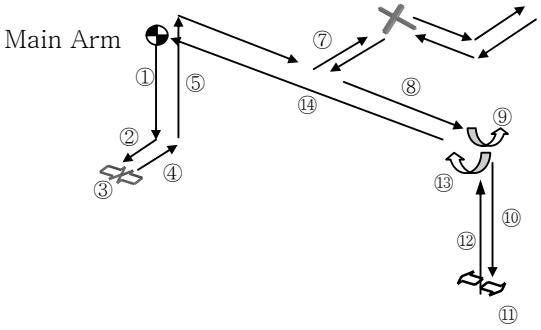
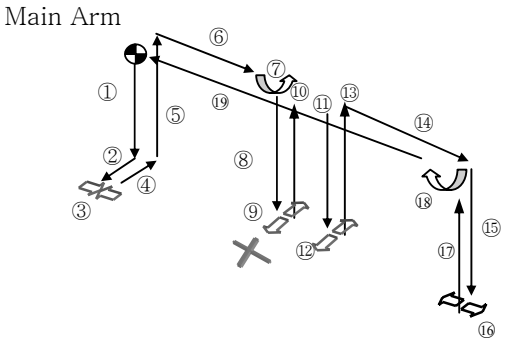
Name	Description	Jig	Motion
NoUse (=Default)	Not in Use		
Use	Robot operate cutting sprue or runner with attached nipper		

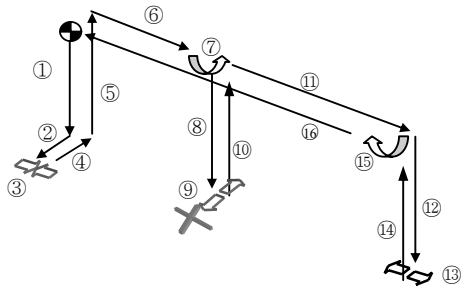
㉑External Nipper (Need Nipper Cutting Attachement Required)

Robot can send signal of cutting sprue or nipper operating to Nipper Cutting machine

Default setting is “NoUse”.

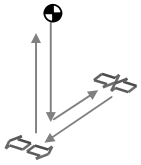
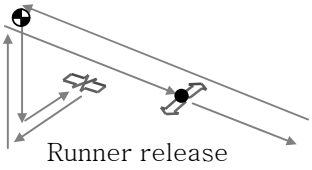
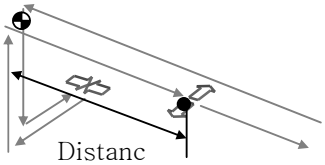


Name	Description	Motion
NoUse (=Default)	Not In Use	
InCut	Nipper attached in Traverse Axis cut sprue and runner. (Need Nipper Cutting Attachments)	
ExCut1	Nipper cutting equipment built in out side of mold to cut sprue and runner. (Need Nipper Cutting Machine)	

Name	Description	Motion
ExCut2	Nipper cutting equipment built in out side of mold to cut sprue and runner. (Need Nipper Cutting Machine)	

㉒Additional Gripper

In two color molding application, required to use additional gripper for gripping another sprue or runner. (Can't not use additional gripper when runner release is standard and return release.)

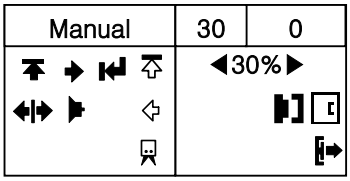
Name	Description	Motion
No Use (=Default)	No use Additional Gripper	
In Mold	Additional gripper release in mold	
RunRele	Additional gripper release in runner release position	
Position	Release in set position * Set over runner release position and traverse limit.	

(2) Button Function

NO	Button	Description
1		Pressing Up and Down arrow key will scroll '▶' icon and select line
2		Press Right and Left arrow key will change Mode / Setting and Blink '▶' icon
3	Numeric Key	For Input Numeric Number
4		Pressing Enter key will stop Blinking of the '▶' icon and save input data.
5		Cancel the Input.
6		Press Stop Button to change to Manual Mode.
7		Press Stop Button to change to Manual Mode.

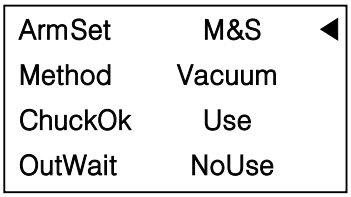
(3) Mode Confirmation

Example) Change from the suction to Chuck for TakeOut Method



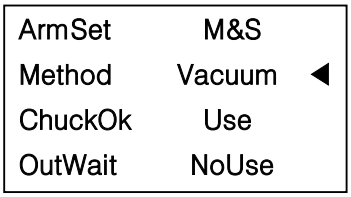
● STEP 1

In manual Molde, Press MODE/MOLD , move to mode screen



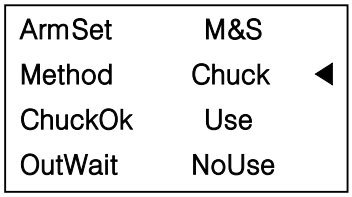
● STEP 2

Press ▼ , moves "▶" to Method Item.



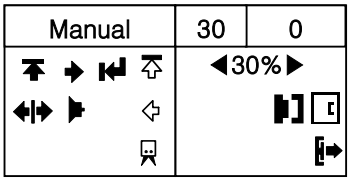
● STEP 3

Press ▶ , changes the mode from Vacuum to Chuck



● STEP 4

Press ENTER , saves selected mode.



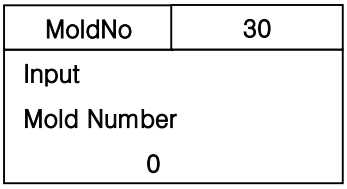
● STEP 4

Press, STOP/MANUAL, finish setting the mode and move to manual mode.

4.1.4 Creating Mold File

(1) Description

Search Mold Number : Press Shift and Mode at the same time.



(2) Button Function in Mold Number Screen

NO	Button	Description
1	Numeric Key	Input Mold Number
2	STOP	Change to Manual Mode
3	Clear C	Cancel the Input Number
4	Enter	Change to Mold Maintenance Screen with selected Number

(3) Mold Manager

Select , Create and Delete Mold File.

MoldMgr	30
> 0 NEW MOLD	
01 RUN_L	
02 RUN_U	

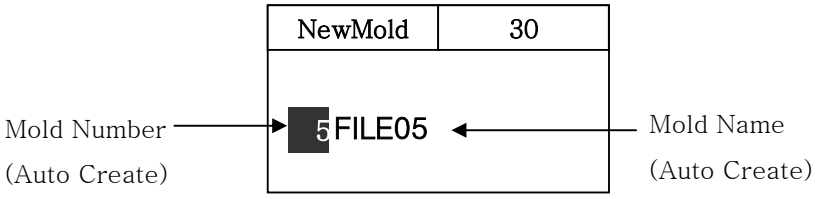
(4) Each Button Function in Mold Manager Screen

NO	Button	Description
1		Open Mold File. Select 0 file can create any motion pattern and mode which can be created by user and move to New Mold Screen and save with Mold Number and name. 1~6 : Basic Motion Pattern which is in system. 7~99: User can create motion pattern.
2		Move to Manual Operation Mode.
3		Move to Delete Screen for file with '>'

NOTICE	Mold Number can use only 2 Number, Mold Name can use 8 Character with Number

(5) New Mold

Save the motion pattern in the mode with new mold number and name.

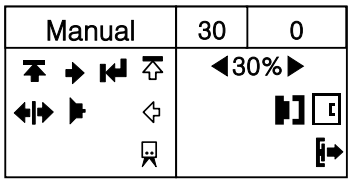


(6) Button Function in New Mold

NO	Button	Description
1	Numeric Key	Pressing the numeric key while blinking Mold Number will Input Number
2	Enter	Pressing Enter to save Mold Number and Name
3	▶	Press ▶ to scroll the cursor on the mold number.
4	▲ ▼	Selecting Mold Name Character.
5	STOP	Change to Manual Mode

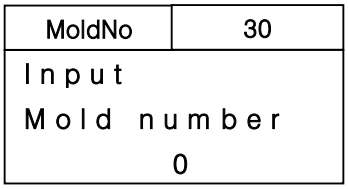
(7) Creating Mold File

Creating Mold file with new motion pattern.



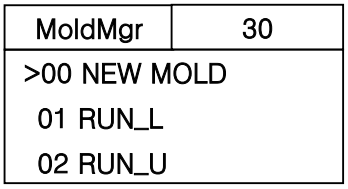
● **STEP 1**

Press [SHIFT S] + [MODE MOLD] and move to mold search Screen



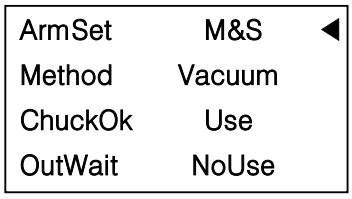
● **STEP 2**

Press [ENTER] to change mold maintenance mode..



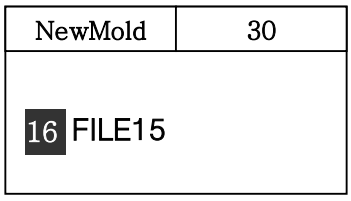
● **STEP3**

Move cursor ">" to 00 and press [ENTER].



● **STEP 4**

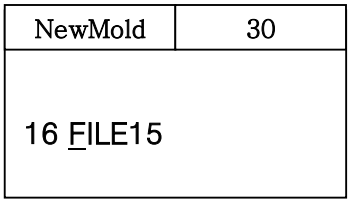
Press [▲] or [▼] move "▶" icon to the mode to select. , Press [▶] to change mode and press [ENTER] to set



● **STEP 5**

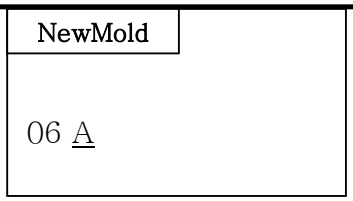
[Set Mold Number to 16]

Press [CLEAR C], clear the mold number, press [1 FORWARD] and press [6 SWIVEL] to input 16 , Press [ENTER] to save. It will stop the blinking of the mold number.



● **STEP 6**

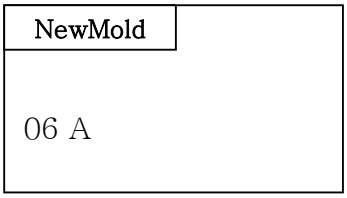
Press [▶] button will move cursor to first character of Mold Name.



● **STEP 7**

Press ▲▼, select Character

It will displays A~Z, 0~9, _, -,

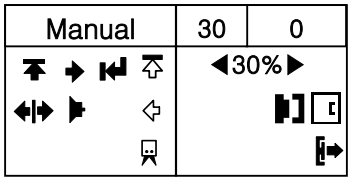


● **STEP 8**

Press Enter to save data

NOTICE

Press ◀ will move cursor to left side and, Change the text with pressing ▲▼ button.



● **STEP 9**

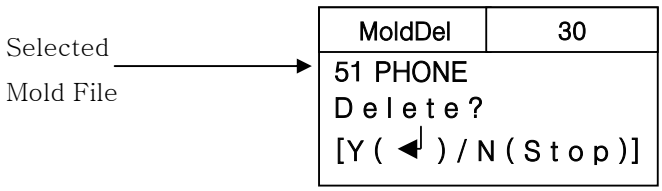
Press STOP will create mold name, save and move to manual mode.

4.1.5 Delete Mold File

(1) Delete Mold File

Delete Mold File that created before.

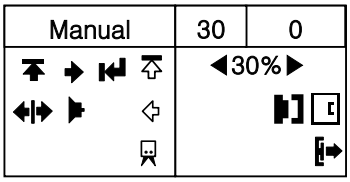
NOTICE Currently open mold file can not be deleted.



(2) Button function in Mold Delete Mode

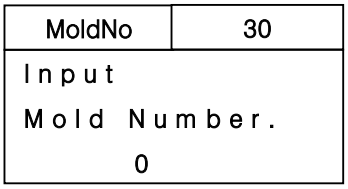
NO	Button	Description
1	ENTER	Delete Mold Selected file and move to manual mode.
2	STOP MANUAL	Cancel operation and Move to manual mode

(3) Delete Mold File



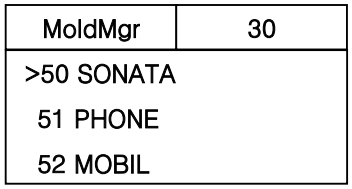
● **STEP 1**

Press SHIFT S + MODE MOLD move to mold search screen.



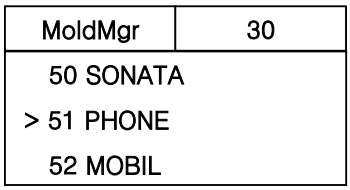
● **STEP 2**

Press ENTER and move to mold maintenance screen



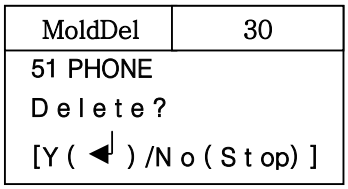
● **STEP 3**

Select mold file to delete with pressing ▲ or ▼



● **STEP 4**

Press CLEAR C displays "<Mold Number><Name> Delete?.



● **STEP 5**

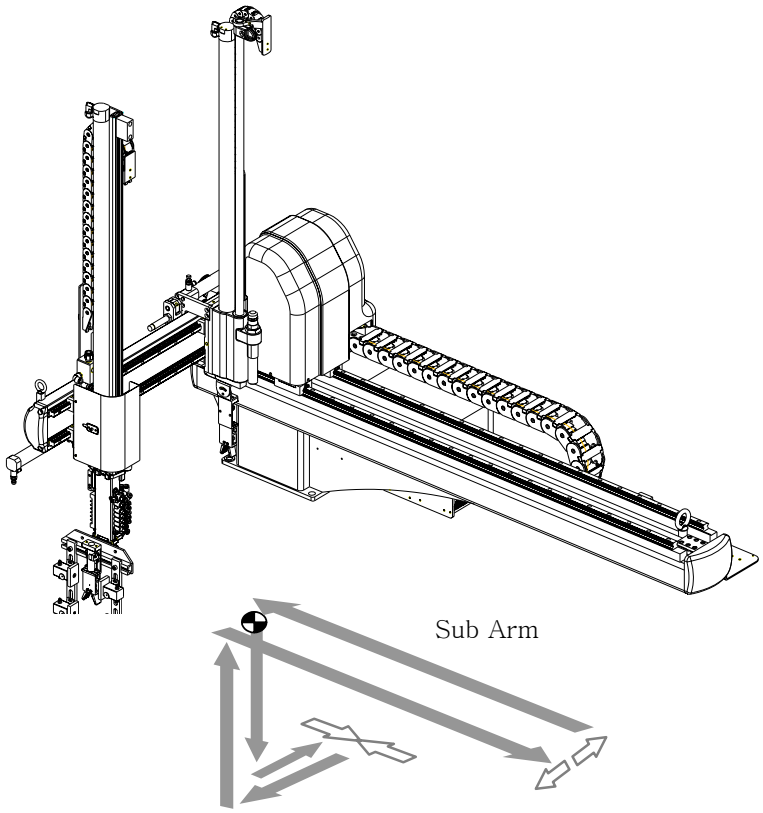
Press ENTER will delete selected file and moves to manual mode

4.1.6 Setting Basic Motion Pattern

(1) Description of Basic Motion Pattern

The Motion pattern for simple and popular operation are already memorized in the system Can change some mode from the similar operation that want to create, and setting.

01 SUB_L	Sub Arm L Type
Motion	

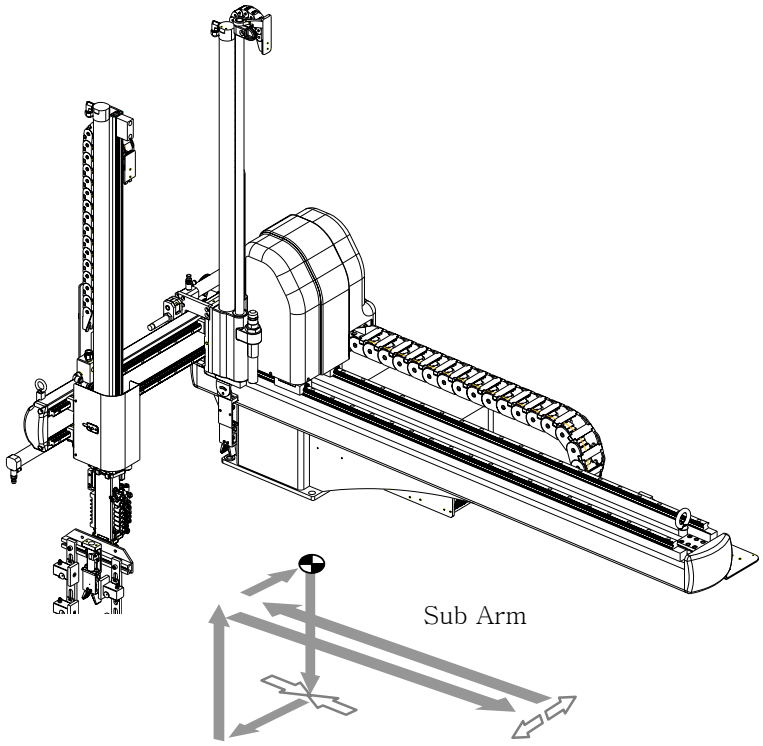


Screen

SArmDn	Nozzle ◀
SArmOff	Off
EjtCtrl	Use

02 SUB_U	Sub Arm U Type

Motion

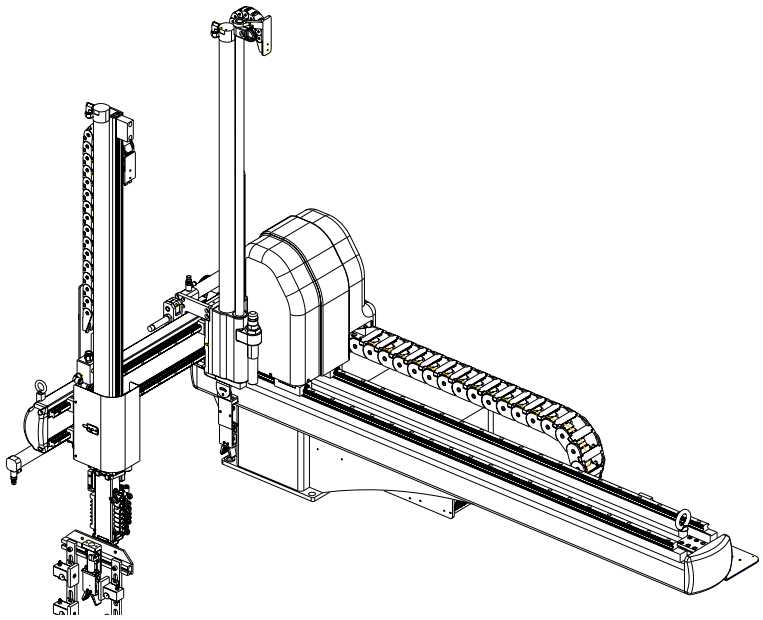


Screen

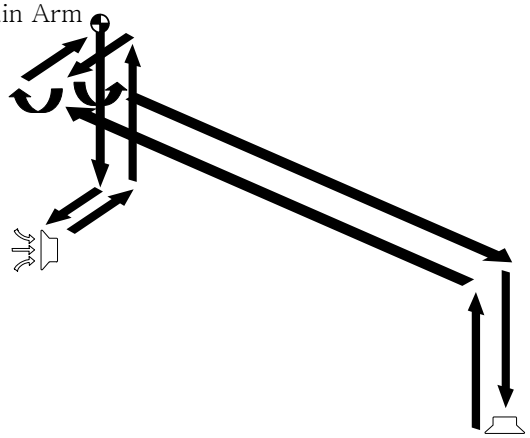
SArmDn	Nozzle ◀
SArmOff	Off
EjtCtrl	Use

03 MAIN_L	Main Arm L Type

Motion



Main Arm

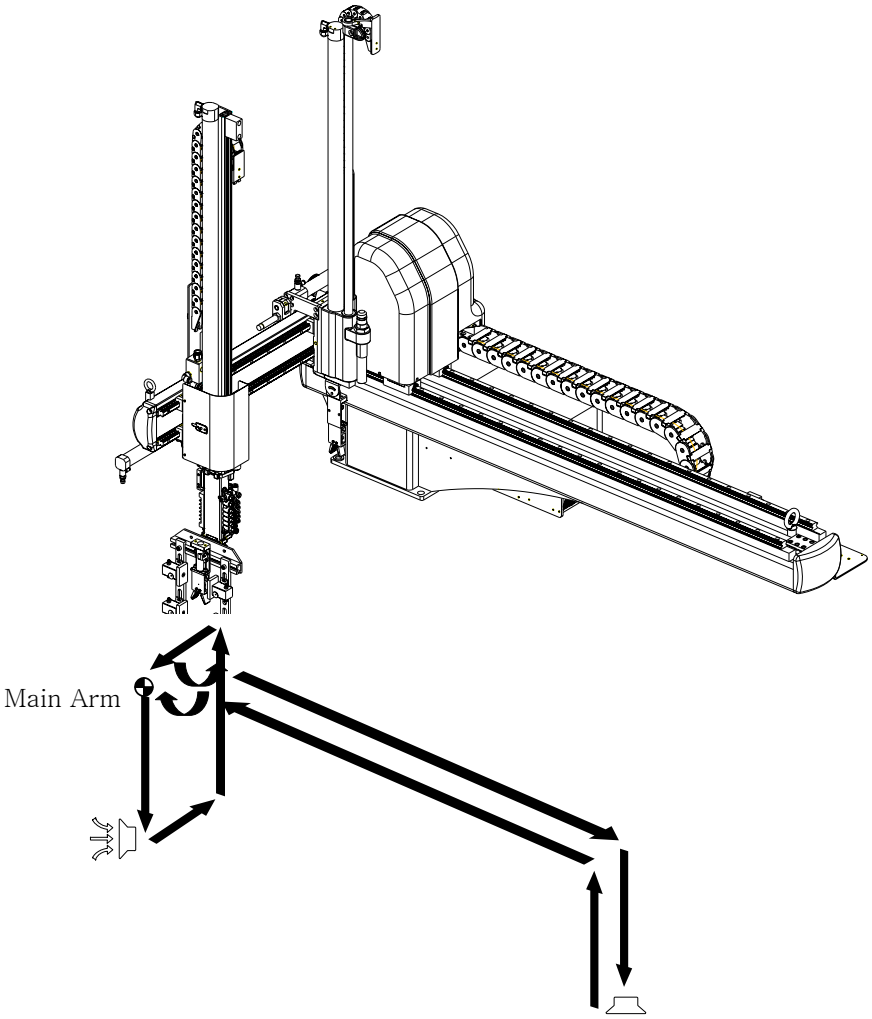


Screen

Method	Vacuum	◀	MarmOff	Off	◀	MulOff	NoUse	◀
ChuckOk	Use		EjtCtrl	Off		Pitch	0mm	
MArmDn	Nozzle					Cycle	1	
ChuckRot	BeforeT							

04 MAIN_U	Main Arm U Type

Motion

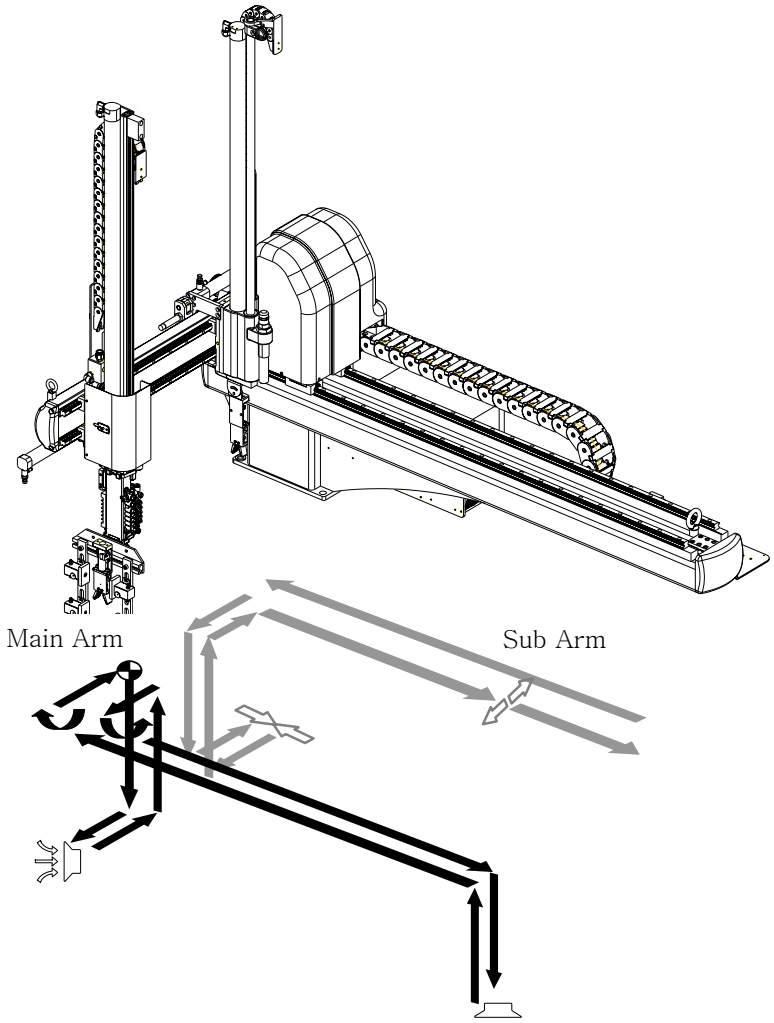


Screen

Method	Vacuum	◀	MarmOff	Off	◀	MulOff	NoUse	◀
ChuckOk	Use		EjtCtrl	Off		Pitch	0mm	
MArmDn	Nozzle					Cycle	1	
ChuckRot	BeforeT							

05 MS_L	Main and Sub Arm L Type

Motion

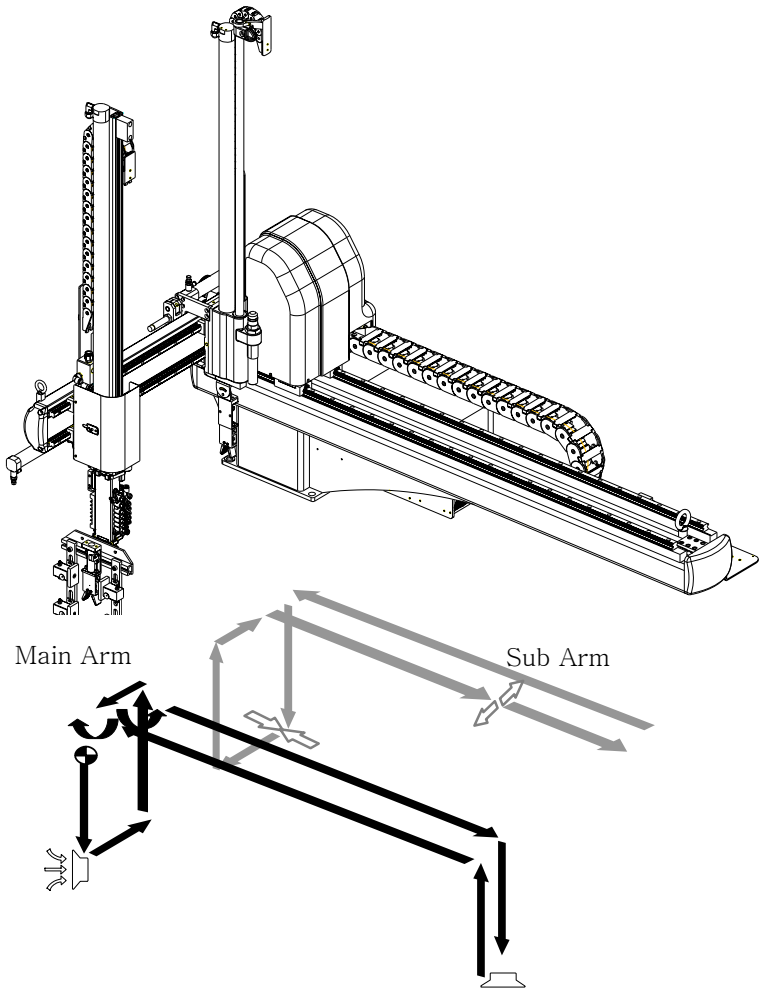


Screen

Method	Vacuum ◀	ChuckRot	BeforeT ◀	MulOff	NoUse ◀
ChuckOk	Use	MArmOff	Off	Pitch	0mm
MArmDn	Nozzle	SArmOff	Off	Cycle	1
SArmDn	Clamp	EjtCtrl	Off		

06 MS_U	Main and Sub Arm U Type

Motion

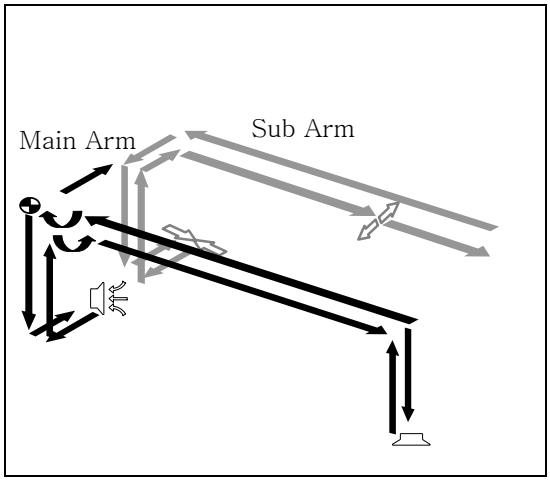


Screen

Method	Vacuum	◀	ChuckRot	BeforeT	◀	MulOff	NoUse	◀
ChuckOk	Use		MArmOff	Off		Pitch	0mm	
MArmDn	Nozzle		SArmOff	Off		Cycle	1	
SArmDn	Clamp		EjtCtrl	Off				

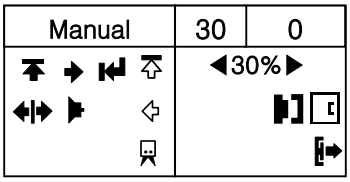
(2) Selecting Basic Motion Pattern

Example) Arm Selection(Main Arm), Take Out Method(Vacuum), Outside Waiting(NoUse), Motion Parttern(LType), Main Arm Down(Clamp), Sub Arm Down(Clamp), Chuck Rotation Timing(BeforeT)



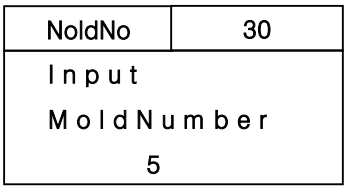
● **STEP 1**

Set Mold Number 5 which is similar with Example except Main Arm Down.



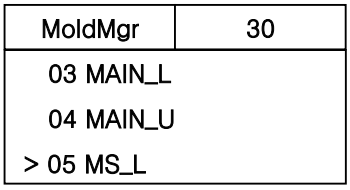
● **STEP 2**

Press SHIFT S and MODE MOLD, move to Mold Number screen.



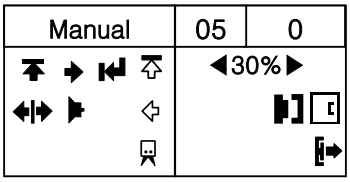
● **STEP 3**

Pressing 5 SUCTION will input 5 and ENTER will move to mold maintenance screen.



● **STEP 4**

Cuseor is located at 5 mold, press ENTER moves to Manual mode with 5 Mold Motion Pattern.



● **STEP 5**

Pressing MODE MOLD button moves to mode screen.

Method	Vacuum	◀
MArmDn	Nozzle	
SArmDn	Clamp	
ChukRot	BeforeT	

Method	Vacuum	
MArmDn	Clamp	◀
SArmDn	Clamp	
ChukRot	BeforeT	

- **STEP 6**

Press  moves "▶"to ChuckRot(Chuck Rotation), and Press  change Main Arm Down to BeforeT(Chuck Rotation Before Traverse).

- **STEP 7**

Press 

to move to Manual screen.

4.1.7 Step Run

(1) Description of Step Run

Step operation will operate the robot step by step of each motion.

After origin, will not displays ">" cursor, pressing ▼ will displays ">" at the first step.

StepRun	30
>Down	
Kick	
ChuckON	

(2) Button Function

NO	Button	Description
1	▼	Press Down Arrow Key will Operate Step Operation. Press and hole 2~3 second operate 1 cycle
2	STOP MANUAL	Move to Manual Mode.

(3) Step Operation

Manual	30	0
	◀30%▶	

- **STEP 1**

Press STEP I/O moves to Step Operation Screen.

StepRun	30
>Down	
Kick	
ChuckON	

- **STEP 2**

Pressing ▼ button will operate on step.

Press STOP MANUAL will move to manual mode.

4.1.8 Input and Output signal check

(1) Description

Confirm Input, Output, Interlock.

Input(Out▶)	30
IA1MArmUpOk	●
IA2M-KickOk	○
IA4RotateOk	○

<Input screen>

Output(In◀)	30
OA0MArmDown	●
OA2MArmKick	○
OA4ChKRotate	○

<Output screen>

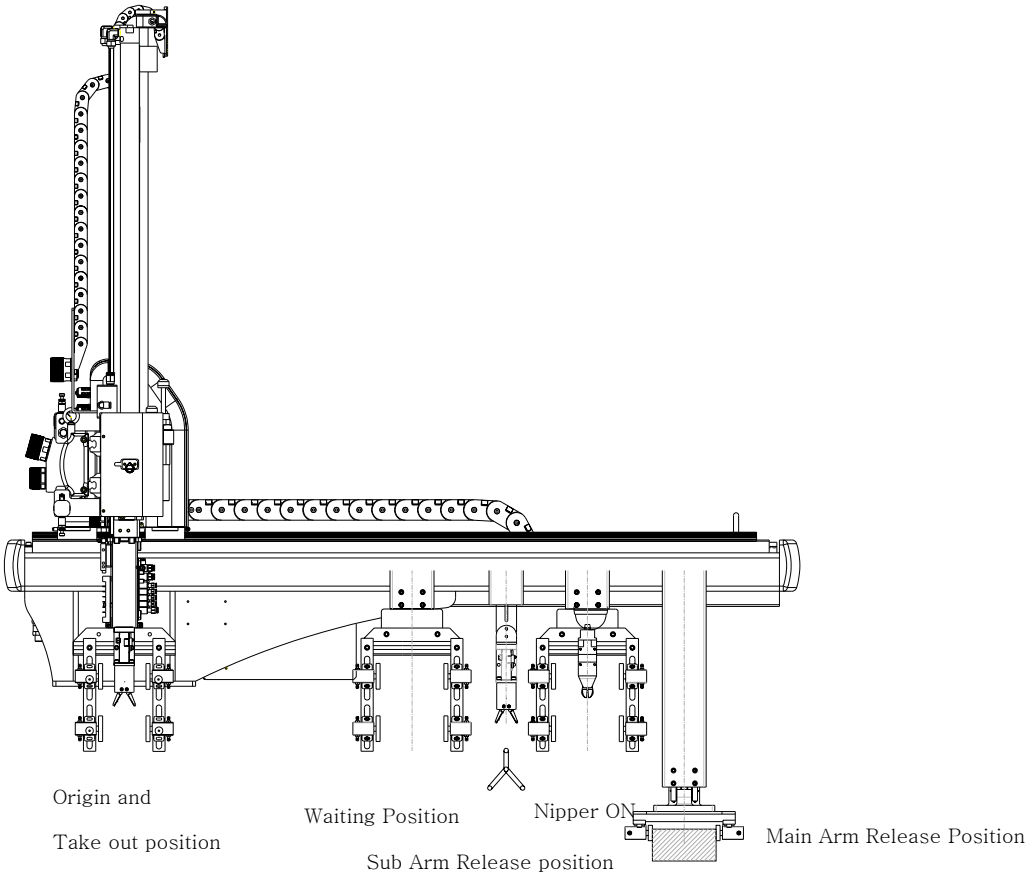
Input			Output		
IA1	MArmUpOk	Main Arm Up Complete	OA0	MArmDown	Main Arm Down
IA2	M-KickOk	Main Arm Kick Complete	OA2	MArmKick	Main Arm Kick
IA4	RotateOk	Rotation Complete	OA4	ChkRotate	Chuck Rotation
IA5	RotRetOk	Rotation Return Complete	OA5	RotReturn	Chuck Rotation Return
IA6	SwivelOk	Swivel Complete	OA6	ChkSwivel	Chuck Swivel
IA7	SvlReOk	Swivel Return Complete	OA7	SvlReturn	Chuck Swivel Return
IB0	ChuckOk	Chuck Confirm	OB0	Chuck	Chuck
IB1	VacuumOk	Vacuum Confirm	OB1	Vacuum	Vacuum & Multi Release1
IB3	SArmGripOk	Sub Arm Grip Confirm	OB2	MArmGrip	Main Arm Grip
IB5	SArmUpOk	Sub Arm Up Confirm	OB3	SArmGrip	Sub Arm Grip
IC0	TrvRtOk	Traverse Return Complete	OB4	SArmDown	Sub Arm Up/Down
IC1	SafetyDown	Safety Down	OB5	SArmKickRt	Sub Arm Kick/Return
IC4	Obstacle	Obstacle Detection	OB6	NipFwd	Nipper Forward
ID0	AddGripOK	Add Gripper Comfirm	OB7	MulOff2	Multi Release(Off)2
			OC0	MulOff3	Multi Release(Off)3
			OC1	MulOff4	Multi Release(Off)4
			OD0	AddGripper	Add Gripper
			OD1	PitchChg	Pitch Change
			OD2	Flee	Traverse (Flee) in Mold
			OD4	Nipper	Nipper (Internal. External)
			OD6	ExNipCls	External Nipper Close
IF0	ReadyCut	Ready to Cutting	OF0	CutStart	Cutting Start
IF1	RdyStack	Ready to Stacking	OF1	StackingOK	Stacking Complete
IF2	Reject	Part Reject			
Interlock Input			Interlock Output		
IE0	AutoInject	Auto Injection	OE0	ConveyOn	Conveyor On
IE1	MoldOpen	Mold Open Complete	OE1	TakeoutOk	Take Out Complete
IE2	SafeDoor	Safety Door Open	OE2	MoldOpen	Mold Open
IE3	FullAuto	Fully Automatic	OE3	MoldClose	Mold Close
IE5	EjtFwdOk	Ejector Forward Complete	OE4	EjectorSig	Ejector Signal
IE6	ImmEmg	IMM Emergency			

(2) Button Function

NO	Button	Description
1		Displays 3 information in one page and move to next page.
2		Change Input Information screen to Output Information screen.
3		Change Output Information screen to Input Information screen.
4		Press Stop Button to change to Manual Mode.
5		Press Stop Button to change to Manual Mode.

4.1.9 Traverse Position Set with Number Input

(1) Position



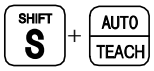
NO		Basic Position	Description
1	P0	Sub Arm Release Position	Release(Off) position for Sprue or Runner
2	P1	Reject Position	Defective Parts Release (Off) Position (Signal Required from IMM)
3	P2	Nipper ON	Sprue or Runner cutting position in Traverse Axis
4	P3	Main Arm Release Position	Release(Off) position for Parts
5	P4	Waiting Position	This position is for waiting outside of the mold until mold is completely open. If Core and other special attachments have added on the top of mold, this feature may required to prevent EOAT from crash.

(2) Description

In the auto operation, each position can change within ±100mm, The robot will have only one of Each position value . Origin and Take out position is 0 mm, do not required setting.

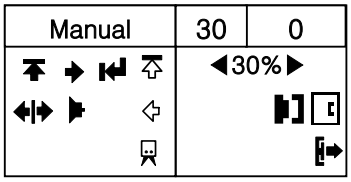
Number	30	0000
>P0SubOff	0000mm	
P1RjtOff	0000mm	
P2NipOn	0000mm	

(3) Button Function

NO	Button	Description
1		Pressing Up and Down arrow key scroll the > key and line.
2		Change Number Input screen to Speed Input screen.
3	Numeric Key	Input Position Number
4		Cancel the Input.
5		Press the Enter Button to save the Input.
6		When only move from Manual Operation Mode to Number Input mode, it can move to Jog Input screen.
7		Press Stop Button to change to Manual Mode.

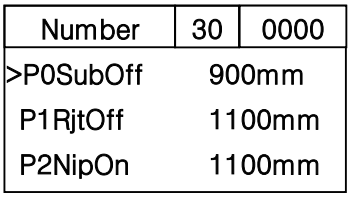
(4) Example

Set Sub Arm Release Position to 1000mm



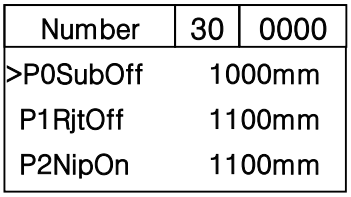
● **STEP 1**

Hold SHIFT S and press AUTO TEACH, move to Mold Number Screen.



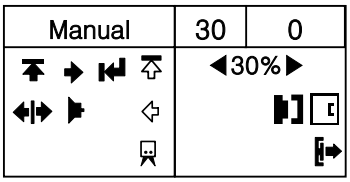
● **STEP 2**

Press 1 FORWARD, 0 RETURN, 0 RETURN, 0 RETURN to input 1000, Press Enter to save Position data.



● **STEP 3**

Press STOP MANUAL to move to manual mode.



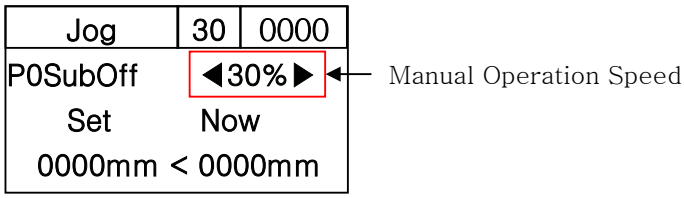
4.1.10 Position Setting with Jog Input

(1) Description

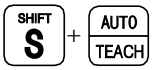
Press 

or 

set each position value

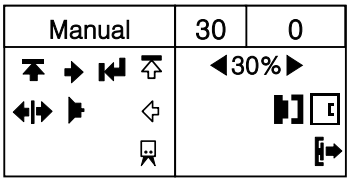


(2) Button Function

NO	Button	Description	
1		Reduce Speed	30%, 20%, 10%, 5% 10mm, 1mm
2		Increase Speed	
3		Move cursor to up or down item	
4		Traverse Movement (X+)	
5		Traverse Return Movement (X-)	
6		Save the input value and Current and set value synchronized.	
7		Press Stop Button to change to Manual Mode.	
8		Press Auto Button with Shift Button, move to Number Input Screen.	

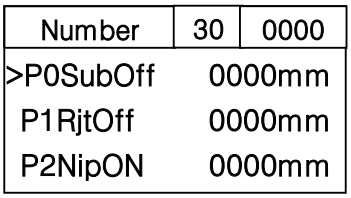
(3) Position setting with Jog Key

Set Reject Position to 100mm.



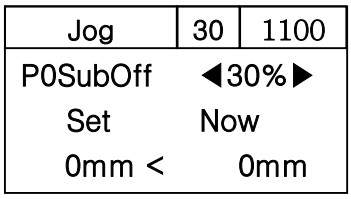
● **STEP 1**

Hold [SHIFT S] and press [AUTO TEACH], move to Mold Number Screen.



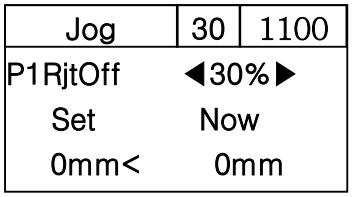
● **STEP 2**

Hold [SHIFT S] and press [AUTO TEACH] again, move to Jog Input Screen.



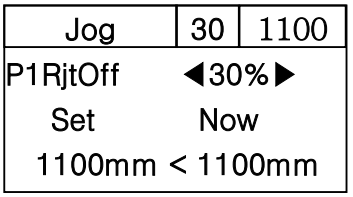
● **STEP 3**

Press [▼] to select Reject Position.



● **STEP 4**

Press [1 FORWARD] or [0 RETURN] move robot to Defective parts Release(Off) position.



● **STEP 5**

Press [ENTER] to save position data, press [STOP MANUAL] to move Manual Mode Screen.

4.1.11 Speed Setting

(1) Description

Setting Robot Movement (-X+) Speed in Auto Operation Mode

Speed	30	0000
> S0 SubOff	80%	
S1 RjtOff	80%	
S2 NipOn	80%	

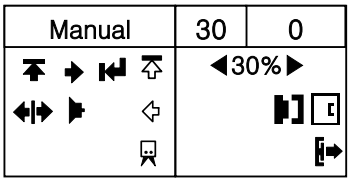
NO		Display	Description
1	S0	SubOff	Speed (When Robot moves to Sub Arm Release(Off) Position.)
2	S1	Reject	Speed (When robot moves to Defective (Reject) Position.)
3	S2	NipOn	Speed (When robot moves to Nipper ON Position.)
4	S3	MaiOff	Speed (When robot moves to Main Arm Release(Off) Position.)
5	S4	Wait	Speed (When robot moves to Waiting Position.)
6	S5	TakOut	Speed (When robot moves to Take-out Position (Chuck or Vacuum in Mold .)

(2) Button Function

NO	Button	Description
1		Scroll the cursor to select item.
2		Move and display “number input screen”
3	Numeric Key	Input the speed value
4		Cancel the input.
5		Save input value
6		Press Stop Button to change to Manual Mode.
7		Press Auto Button to change to Auto Mode.

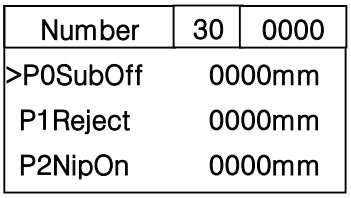
(3) Example

Set Sub Arm Release Position to 100%.



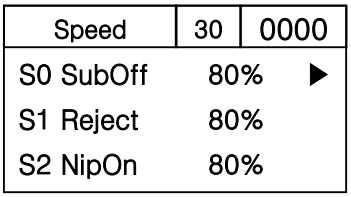
● **STEP 1**

Hold [SHIFT S] and press [AUTO TEACH], movet to Number Input Screen.



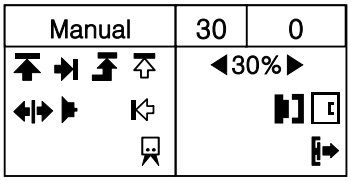
● **STEP 2**

Pressing [▶] changes Speed Input Screen.



● **STEP 3**

Press [1 FORWARD] [0 RETURN] [0 RETURN] to input 100, Press [ENTER] to save speed data.

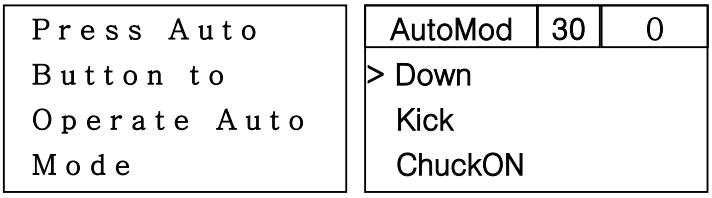


● **STEP 4**

Press [STOP MANUAL] to move to manual mode.

4.5Auto Operation

(1) Description



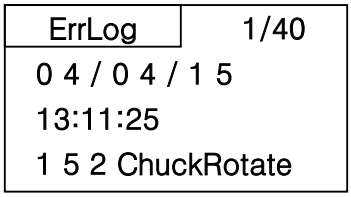
[Auto Message] [Auto Mode Screen]

2) Button Function

NO	Button	Description
1	STOP / MANUAL	Stop Auto Operation and move to Manual Mode.
2	MODE / MOLD	Move to Mode Screen.
3	SHIFT S + STEP I/O	Move to Input Screen.
4	TIMER / COUNT	Move to Timer Screen.

4.6Error Log

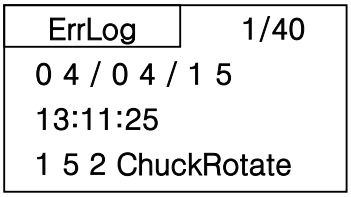
(1) Description

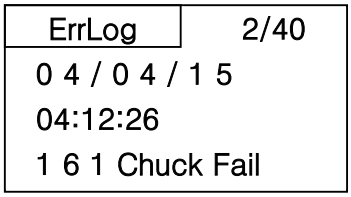


(2) Each Button Function

NO	Button	Description
1	▲ ▼	Move the cursor to different error log.
2	STOP / MANUAL	Change to the Manual Mode
3	AUTO / TEACH	Change to the Auto Mode

(3) Checking Error Log





- **STEP 1**

Press SHIFT S and ▲ at the same time, displays Error Log screen.

- **STEP 2**

Find eror with pressing ▲ or ▼ button.

- **STEP 3**

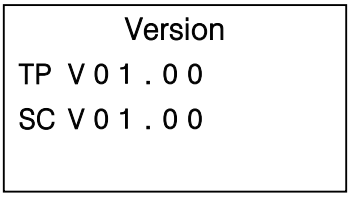
To move to Manual Mode, press STOP / MANUAL.

To move to Auto Mode, press AUTO / TEACH.

4.7Version Information

(1) Description

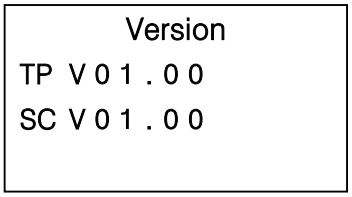
Check Version Information.



(2) Each Button Function

NO	Button	Description
1	STOP / MANUAL	Change to the Manual Mode
2	AUTO / TEACH	Change to the Auto Mode

(3) Checking Version Information



- **STEP 1**

Press SHIFT / S and ▼ at the same time, displays version.

- **STEP 2**

To move to Manual Mode, press STOP / MANUAL.

To move to Auto Mode, Press AUTO / TEACH.

4.8 Error Recovery

(1) Error Description

Displays error recovery method.

Error	30
152 ChuckRotate	
Check Chuck	
Rotate IA4	

(2) Each Button Function

NO	Button	Description
1	CLEAR C	Press Clear button, Stop Alarm and Buzzer , Press again Clear button error message.

(3) Error Recovery

Error	30
152 ChuckRotate	
Check Chuck	
Rotate IA4	

- **STEP 1**

Pressing CLEAR C, Stop Buzzer.

- **STEP2**

Pressing CLEAR C again will close message screen.

4.9Change Language

Press SHIFT S and ▶ at the same time, change Korean, English.

4.10 Robot and Program maintenance Screen : Factory Set (Contact Factory 1st)

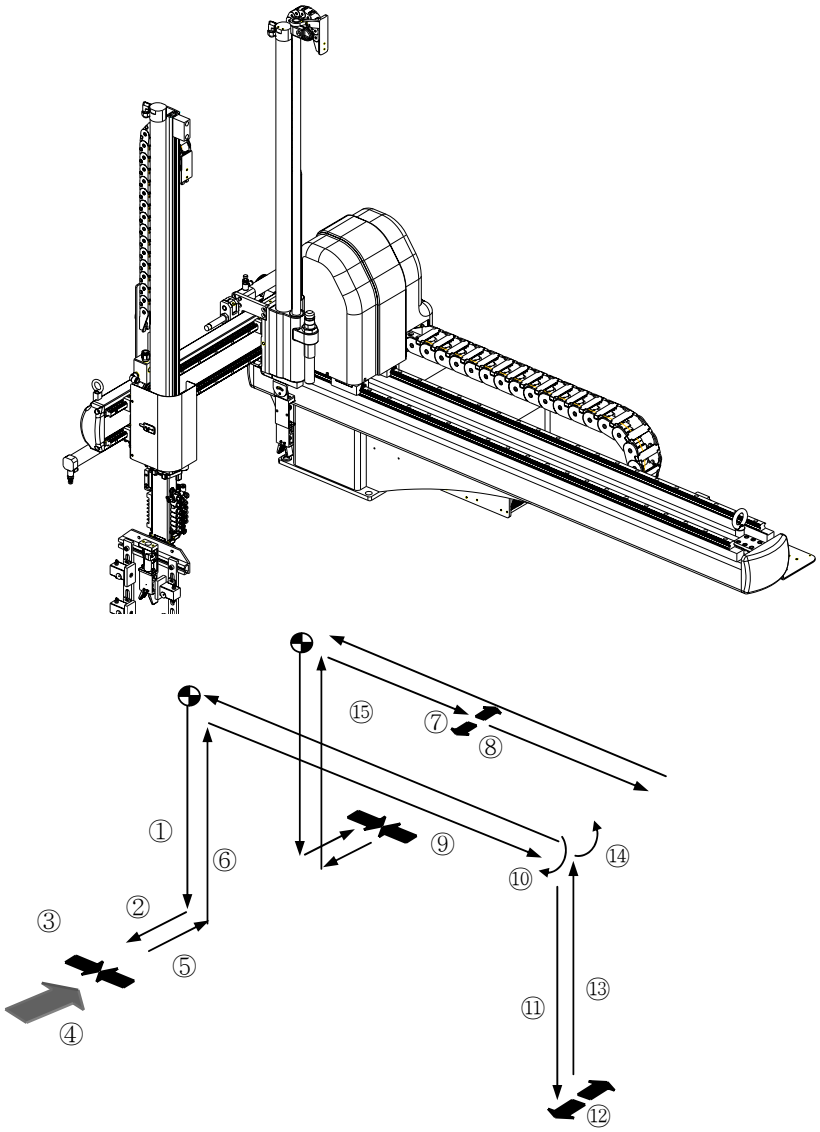
Turn power on with pressing 

NO	Screen	Mode	Order	Default/Setting	Description	Etc
1	TrvsLimit -00mm▶ 0000mm DownLimit 0000mm	Limit for Traverse			- Traverse Limit Range	
					+ Traverse Limit Range	
2	FleeLimit ±00mm	Limit for Down			Descent Range	
3		In Mold Traverse Limit			Traverse Limit in Mold	
4		Origin	①	NoSet (=default)	Press Enter will not current position to origin point	
			②	Set	Press Enter will change current position to Origin Point	
5	Orgin NoSet ▶ Safety NoUse AutoInp NoUse TKOFail NoUse	Safety Use	①	NoUse(=default)	Not In Usa	
			②	Use	Ultra Sound Safety Cont.	
6		Auto Input	①	NoUse (=default)	Auto Input Signal from IMM is not required	
			②	Use	Auto Input Signal from IMM is required for Auto Operation.	
7		Take Out Fail	①	Use (=default)	Not sending Take Out Fail signal to IMM	
			②	NoUse	Send Signal to IMM when robot can take out the part or sprue	
8	IMAlarm NoUse ▶ IMRejec NoUse AllDelMold Yes DelErrLog Yes	IMM Alarm	①	NoUse (=default)	IMM E-stop Input don't activate Robot E-Stop	
			②	Use	IMM E-Stop activate Robot E-Stop	

9		IMM Reject	①	NoUse (=default)	IMM defective Input don't separate reject part by robot	
			②	Use	IMM defective Input activate Robot to separate reject part to set position	
10		Total Mold Delete	①	No (=default)	Enter will not delete mold file	
			②	Yes	Enter will delete All mold file	
11		Error Log Delete	①	No (=default)	Enter will not delete Error Log	
			②	Yes	Enter will delete Error Log	
12		Time Date			Set Robot time by Hour, Minute, and Seconds.	
13					Set Robot time by Year, Month, Date	
14	Time 00:00:00 ▶ Date 00/00/00 FindError00.0 EjectFwd NoUse					
15		Find Error			Finding Error Time	##.#Sec
16		Eject Forward	①	NoUse (=default)	No Confirmation for Ejector Kick Complete Signal	
			②	Use	Confirm for Ejector Kick Complete Signal	
17	CutTime 0.0s	Cutting Time			Cutting time can set from 0.1 sec to 9.9 Sec.	

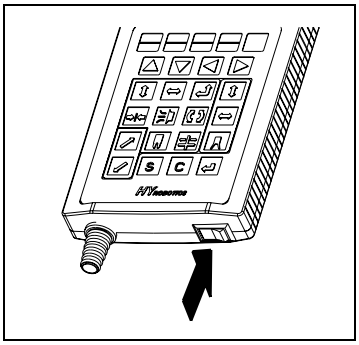
5 Follow Up

5.1Motion Pattern Selection



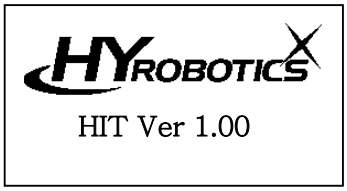
①. Down
②. Kick
③. Chuck ON
④. Ejector Forward
⑤. Kick Return
⑥. Up
⑦. Sub Off Position
⑧. Sub Arm Off
⑨. Main Arm Release Position
⑩. Chuck Rotation
⑪. 2nd Descent
⑫. Main Arm Release
⑬. 2nd Ascent
⑭. Chuck Rotation Return
⑮. Take Out Position

5.2 Start Up



● **STEP 1**

Turn On Power.



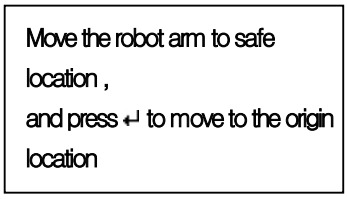
● **STEP 2**

Displays Logo and moves to Origin screen.

5.3 Move to Origin

⚠DANGER

Before operate Servo Origin, make sure the robot arm is in safe location. If robot arm is not if safe location, move robot arm manually to safe location with manual button.

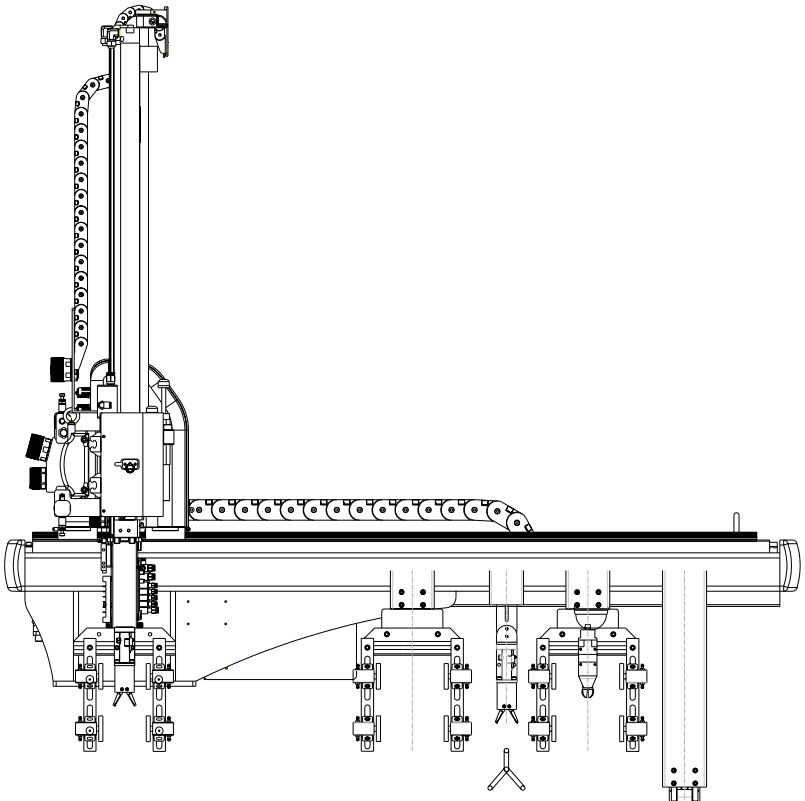


● **STEP 3**

Press 

will move each axis arm to servo origin point. And then screen will display manual operation screen.

5.4 Set Position



Manual		0
	◀30%▶	

● **STEP 4**

[Move to Number Input screen]

Press SHIFT S and AUTO TEACH, moves to Number Input screen.

Number		0
>P0SubOff	0000mm	
P1RjtOff	0000mm	
P2NipOn	0000mm	

● **STEP 5**

[Move to Jog Input screen.]

To set up Each position with Actual Robot movement, moves to Jog Input Screen with pressing SHIFT S and AUTO TEACH at the same time

Jog	05	0
P0SubOff	◀10%▶	
Set	Now	
0mm <	0mm	

● STEP 6

[Set Sub Arm Release Position]

Press  or  , move Sub Arm to the Parts Release (Off) Position.

* Press  or  to adjust manual mode speed. Can set up 30%, 20%, 10%, and 5% of Normal Speed. Distance can be set 10mm, or 1mm.

Jog	05	750
P0SubOff	◀10%▶	
Set	Now	
750mm <	750mm	

● STEP 7

Press  , save current value to setting value.

Press  , move to screen for setting of the defect parts separate position

Jog	05	750
P0SubOff	◀10%▶	
Set	Now	
0mm <	750mm	

● STEP 8

[Set Reject Position]

Press  or  , move robot arm to the position for separating of defect (Reject) parts. Press  to save current value to setting value.

Jog	05	750
P0SubOff	◀10%▶	
Set	Now	
750mm <	750mm	

● STEP 9

Press  , move to screen to set Nipper Operation Position.

Jog	05	750
P2NipOn	◀10%▶	
Set	Now	
0mm <	750mm	

● STEP 10

[Set Nipper Position]

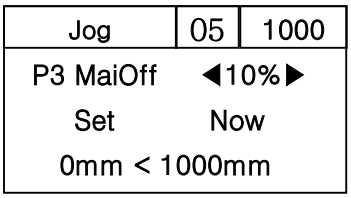
Press  or  , move robot arm to desired Nipper Cutting Position.

Jog	05	1000
P2 NipOn	◀10%▶	
Set	Now	
1000mm <	1000mm	

● STEP 11

Press  , save current value to set.

Press  , move to Main arm release (Off) setting screen.



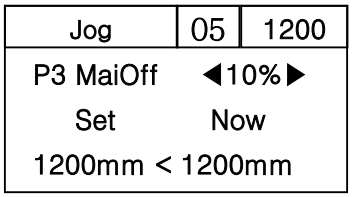
● STEP 12

[Set Main Arm Release Position]

Press 

or 

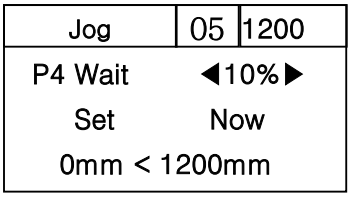
, move main arm to the desired position for parts release (off).



● STEP 13

Press 

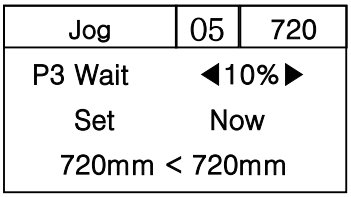
, save current value to set



● STEP 14

[Set Waiting Position]

Press 
, move to waiting position setting screen.



● STEP 15

Press 

or 

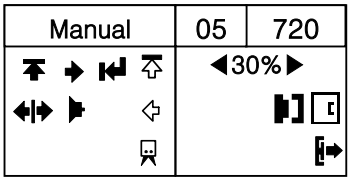
, move robot arm to the desired out side waiting position.

Press 

, save current value to set

Press 

, move to manual operation mode.



5.5 Speed Setting

Number	05	720
>P0SubOff	750mm	
P1RjtOff	750mm	
P2NipOn	1000mm	

● **STEP 16**

[Set Main Arm Release Speed to 100%]

Press AUTO/TEACH with SHIFT S at the same time, move to the number input screen.

Speed	05	720
>S0SubOff	80 %	
S1RjtOff	80 %	
S2NipOn	80 %	

● **STEP 17**

Press ▶, move to speed input screen.

Press ▼ twice, move cursor '>' to main arm off (Release)

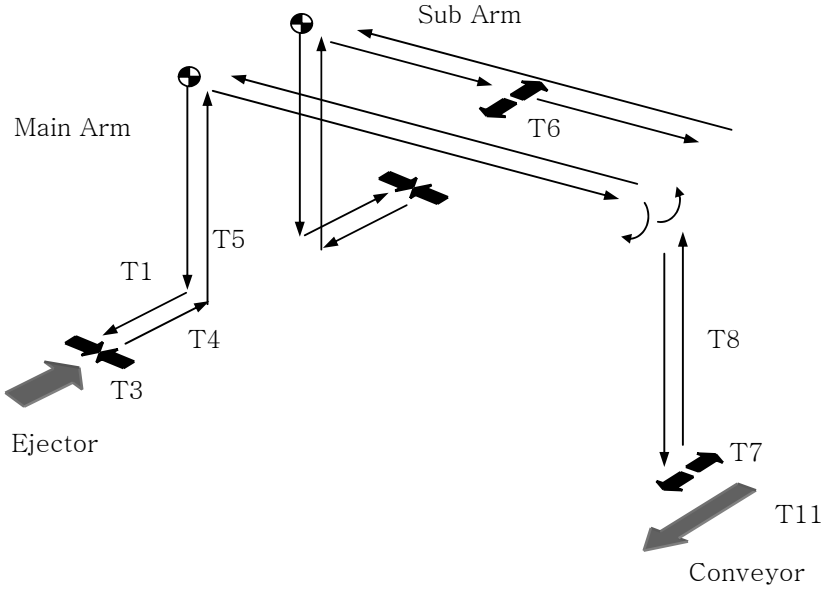
Speed	05	720
>S3MaiOff	100 %	
S4Wait	80 %	
S5TakOut	80 %	

● **STEP 18**

Press 1FORWARD 0RETURN 0RETURN in order, Main arm Off(Release) speed is 100% , Press ENTER to save. Press STOP/MANUAL, move to manual mode

Manual	05	720
	◀30%▶	

5.6 Timer Setting



NO	Default	Name
T1	0.3sec	Kick
T3	0 sec	Chuck
T4	0.2 sec	KicRt
T5	0.5 sec	Up
T6	0.1 sec	S-Off
T7	0.2 sec	M-Off
T8	0.5 sec	2Up
T11	3 sec	Conve

Timer	05	720
>T0 Down	0.0 < 0.0	
T1 Kick	0.3	0.0
T2 Eject	0.1	0.0

- **STEP 19**

[Move to timer screen, set T0 chuck delay 0.5 sec]

Press TIMER/COUNT, move to timer screen.

Timer	05	720
>T0 Down	0.0	0.0
T1 Kick	0.5 < 0.5	
T2 Eject	0.1	0.0

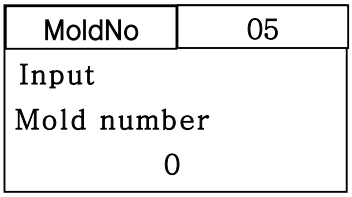
- **STEP 20**

Press 5SUCTION and input 0.5sec, Press ENTER to save data.

Press STOP/MANUAL, move to manual mode.

Manual	05	720
	◀30%▶	

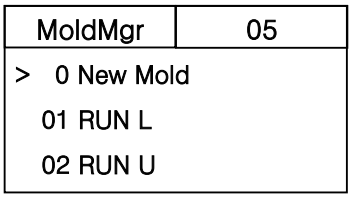
5.7Mold Create



● STEP 21

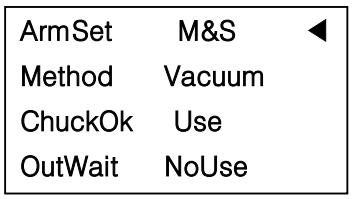
Hold [SHIFT S] and Press [MODE MOLD], displays Mold search mode.

Press [ENTER] moves to mold manager screen and cursor will be on 0.



● STEP 22

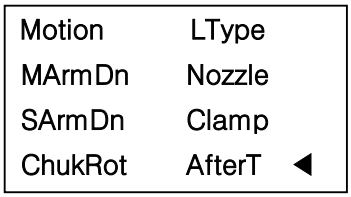
Pressing [ENTER] on the 0 Mold (New Mold) and moves to mode screen.



● STEP 23

[To set Chuck(EOAT) after traverse]

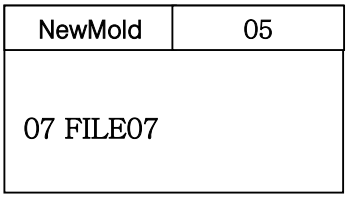
Press [▼] until cursor move to Chuck Rot.



● STEP 24

Press [▶] until display AfterT,

Press [ENTER] to save it..

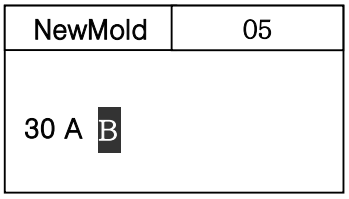


● STEP 25

[Set Mold Number to 30]

Press [CLEAR C] to cancel Mold Number, Press [3 WAITPOS] [0 RETURN] to input 30.

Press [ENTER] to save data.



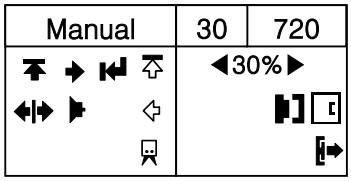
● STEP 26

[Set Mold Name to AB]

Press [▶], cursor will move to first character and blinking.

Press [Clear C], select A with pressing [▲] [▼], pressing [▶] move to next character space, press [▲] [▼] select “B”, and

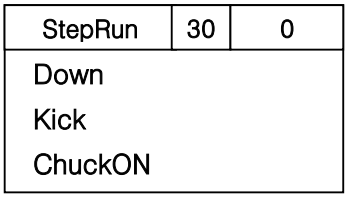
Press [ENTER] to save data.



- **STEP 27**

Press STOP/MANUAL will create Mold File and moves to Manual Mode.

5.8 Step Run



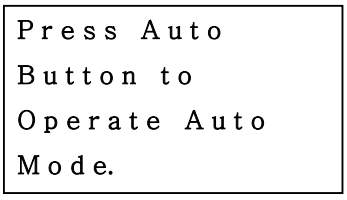
- **STEP 28**

Pressing STEP/I/O, move to Step Run screen.

Pressing ▼ will operate motion step by step.

Press STOP/MANUAL and moves to manual mode.

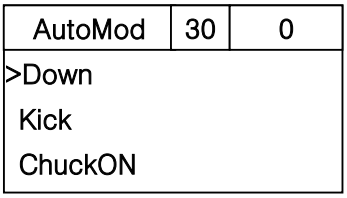
5.9 Auto Operation



- **STEP 29**

Press AUTO/TEACH change to Auto Message screen.

Press AUTO/TEACH again will start Auto Operation.



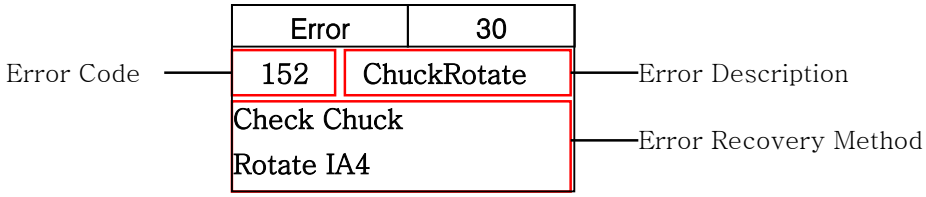
- **STEP 30**

To Stop Operation press STOP/MANUAL.

6 Error

6.1Error Screen

This Chapter describes Error Code and Error recovery method.



Error cause Alarm and Buzzer, display the error message.

Press CLEAR C Stop Alarm and Buzzer, Press again CLEAR C clear error messages.

6.2 Error List

6.2.1 Motor Related

NO	Description	Cause	Recovery Method
48	TrvsCWLimt	Traverse Movement stop by touching CW Limit Proximity Sensor.	Operate robot arm to other direction (End of Stroke)
55	TrvsCCWLimt	Traverse Movement stop by touching CCW Limit Proximity Sensor.	Operate robot arm to other direction (End of Stroke)
64	TraverOrigin	Error for searching Origin Point	Confirm Touch Plate or Sensor
71	TrvsInitial	Communication Error of Each Axis and Controller.	1. Press CLEAR C and restart robot. 2. Check each connector and Tighten screw of Error Drive and Controller.
80	Servo Alarm	1. Motor Overload 2. Motor Overpower 3. Bad Encorder Connector 4. Motor Power 5. Crash	1. Confirm Servo Motor Drive Alarm Code. 2. If motor overload error occur, robot may hit barrier or operate mistake crash. **Restart robot after completely shutdown robot for more than 20 seconds.**

96	ROBOT E-Stop	Stop by emergency switch	Remove cause of emergency stop and then cancel it by turning emergency stop button.
98	IMM E-Stop	Stop by Injection Molding Machine emergency switch	Remove cause of emergency stop and then cancel it by turning Injection Molding Machine emergency stop button.

6.2.2 Pneumatic

NO	Description	Cause	Recovery Method
132	RotateSensor	Chuck Rotation and Rotation Return Sensor confirm(OK) at the same time.	Check Chuck Rotation and Rotation Return Sensor.
134	SubArmUpOk	When Sub Arm Down ok signal should not be Off.	Check Sub Arm up Ok Sensor Check Main Arm up Ok Sensor
135	MainArmUpOk	When Main Arm Down ok signal should not be Off.	
146	MainKick	1. Air Pressure is Low 2. Sensor is not confirm position 3. Bad Sensor 4. Wire damaged	1. Check Air Regulator 2. Check I/O 3. Check Sensor Touch Plate 4. Fix and Move Origin Point.. 5. Check Wire connection on board
148	SubArmUp		
150	MainArmUp		
152	ChuckRotate		
153	RotateReturn		

6.2.3 Sol valve

NO	Description	Cause	Recovery Method
160	VacuumFail	A. Vacuum Failure B. Check Suction Pad C. Leaking at Stem and Fitting D. Adjust Vacuum sensitivity	1. Open Safety Door and Fix Problem in Manual Mode 2. Replace Pad. 3. Tight Stem and Fitting Screw
161	ChuckFail	1. Chuck Motion Failure 2. Chuck Sensor Touch Failure 3. Bad Sensor	1. Open Safety Door and Fix Problem in Manual Mode 2. Adjust location of Sensor 3. Replace Sensor
163	SArmGripFail	1. Gripper Motion Failure 2. Wrong Sensor Location 3. Bad Sensor	

6.2.4 Machine Abnormality

NO	Description	Cause	Recovery Method
176	SCInitiError	1. Noise 2. Program Failure	Reboot, Secure cable connection Contact Factory
178	OriginFail (Touch Plate : Origin Sensor Touch Plate)	1. Touch Plate Setting 2. Toucch Plate Sensor Bad 3. Servo Motor Pulley loosened 4. Bad Belt	1. Reset Touch Plate 2. Change Touch Plate Sensor 3. Tighten motor Pully 4. Belt change
179	DownProhibit	1. Servo Motor Pulley loosened 2. Bad Belt	Check Touch Plate or Traverse Pully.
180	DownLimitEr	Discordance between Down Limit setting and distance from orgin to Down Limit.	Check Down Limit.

6.2.5 Interlock Related

NO	Description	Cause	Recovery Method
202	MoldOpenOk	Rarely some Molding Machine loses Mold Open Complete Signal momentarily when Robot arm in Take-Out Position.	1. Reboot 2. Contact Factory
203	AutoInject	Bad Auto Injection relay	Replace Auto injection relay.

6.2.6 Operation Error

NO	Description	Cause	Recovery Method
208	ArmIsNotUp	Traverse Movement without Up (Ascent) Complete	Ascent Main and Sub Arm
209	NoMotionArea	When Robot can not move due to out of operation range	Move the robot arm to other direction
210	OverLimit	Pallet setting is wrong	Reset Number and Pitch
214	NoMoldOpen	In Manual Mode, activate Robot Arm Down without Mold Open Complete	Check Mold completely opened. (Check Mold Open Complete Sensor)

208	ArmIsNotUp	Traverse Movement without Up (Ascent) Complete	Ascent Main and Sub Arm
223	SafeDoorStop	Open safety door in auto mode.	Close Safety Door.

6.2.7 Internal Program Error

NO	Description	Cause	Recovery Method
231	OverFileNum	Mold file is full.	Delete old mold files.
236	SC InfoError	SC Wrong Version	Contact Factory

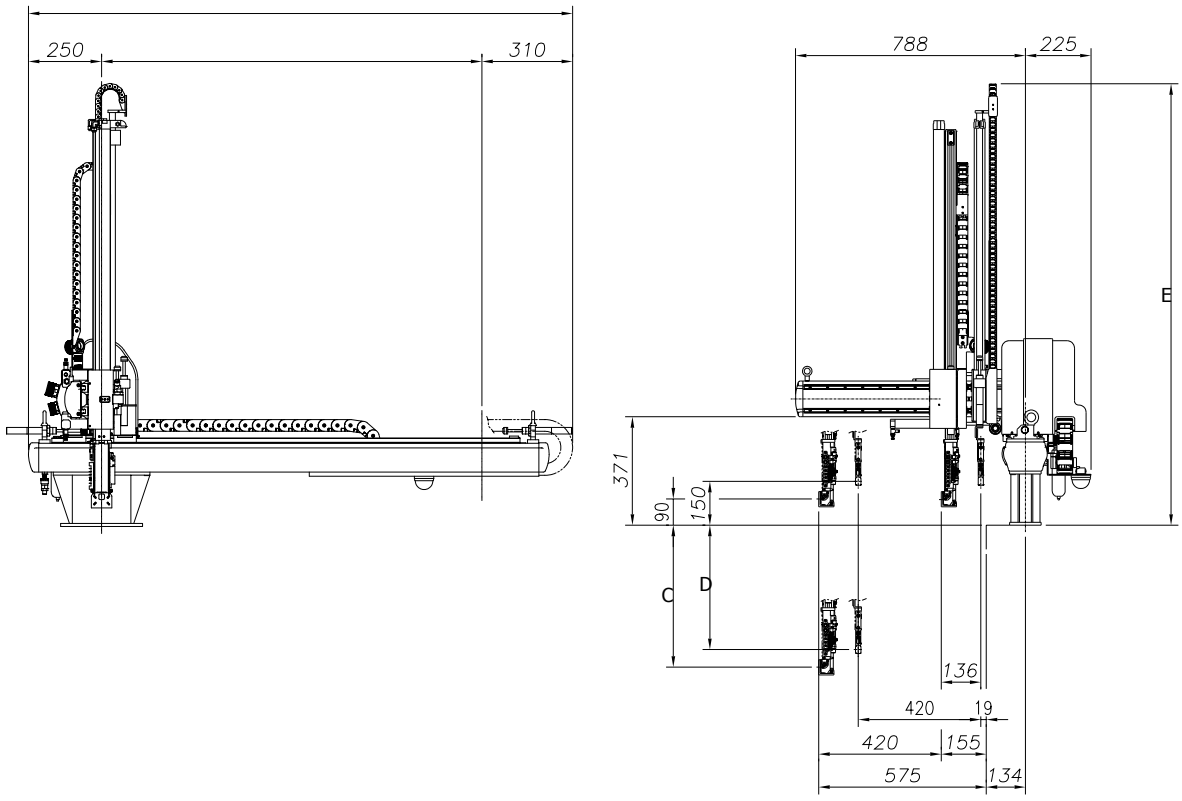
Appendix

A. Specification

Power	Driven Method	Control Method	Pneumatic Pressure
100Vac–240Vac 50/60Hz	Servo Motor(Traverse)	Sequence Program	0.5 to 0.6 Mpa

MODEL	Applicable injection molding machine	Traverse stroke (mm)	Kick stroke (mm)		Descent stroke (mm)		Pneumatic consumption (Nl/cycle)	Robot body weght (kg)	Maximum weight capacity (kg)	Take-out dry cycle (sec)	Entire dry cycle (sec0	Noise level (dB)
		standard	Main Arm	Sub Arm	Main Arm	Sub Arm						
HIT-100S	Down to 250 ton	1100	150	-	700	-	22		3			
HIT-100D			150	90	700	750	30					
HIT-200S	Down to 250 ton	1300	150	-	800	-	25					
HIT-200D			150	90	800	850	35					

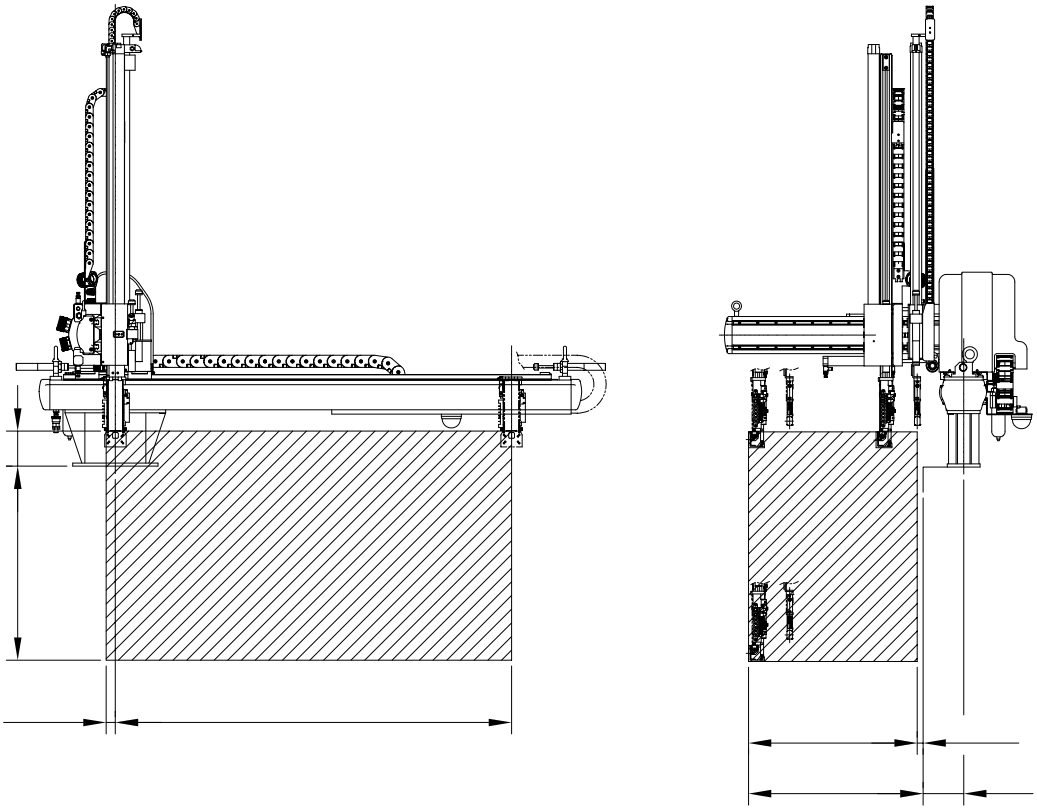
B. External Dimension



Type	A	B	C	D	E
HIT-100(S/D)	1660	1100	610	A 600	1410
HIT-200(S/D)	1860	1300	710	700	1510

B

C. Safe guarded space



Type	A	B	C	D	E	F	G	H
HIT-100(S/D)	1100	30	585	115	555	20	575	134
HIT-200S(S/D)	1300	30	685	115	555	20	575	134

* Safety guard recommend by robot manufacturing company, and dimension is not proper with molding machine and required to modification of this dimension.

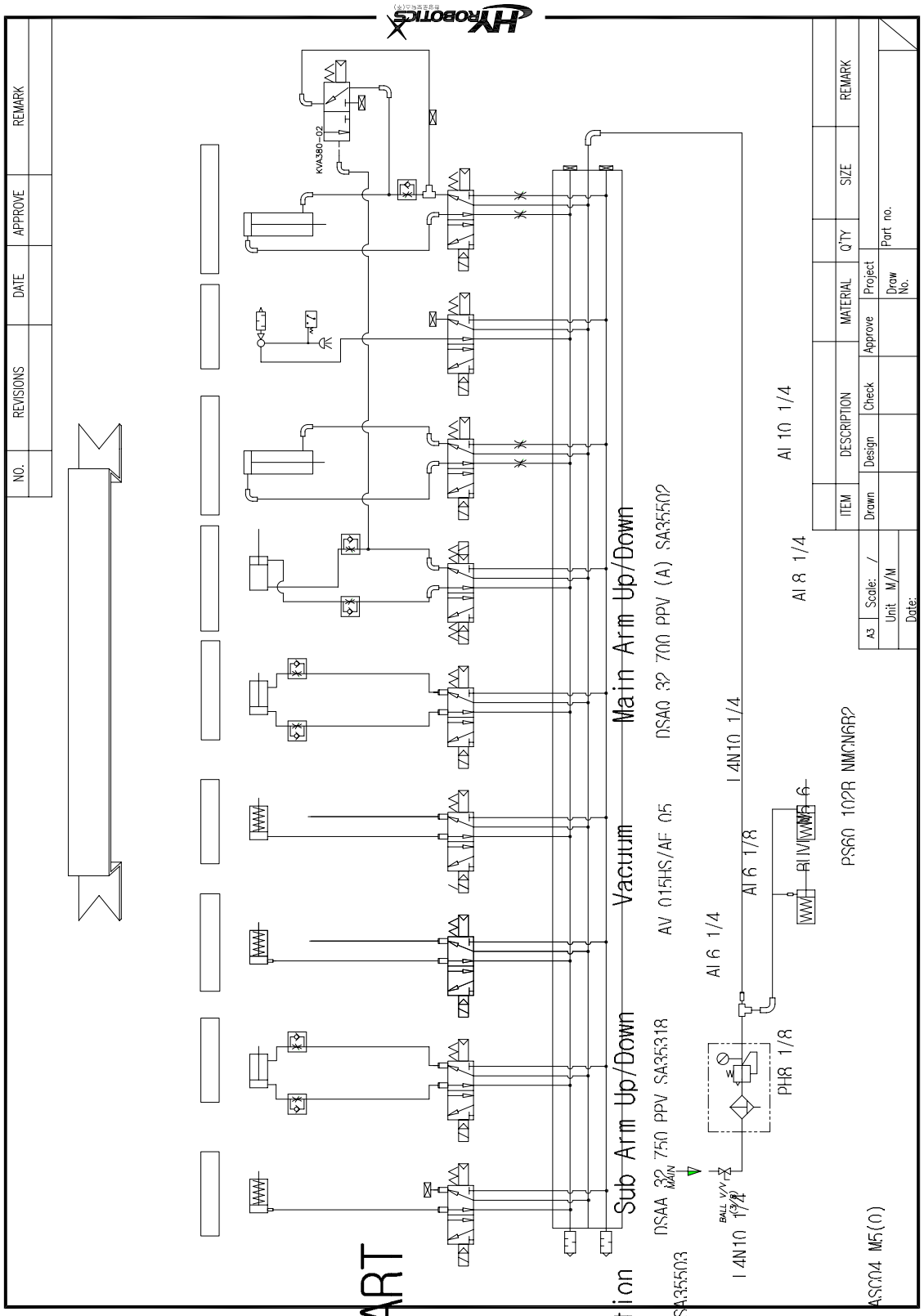
D

C

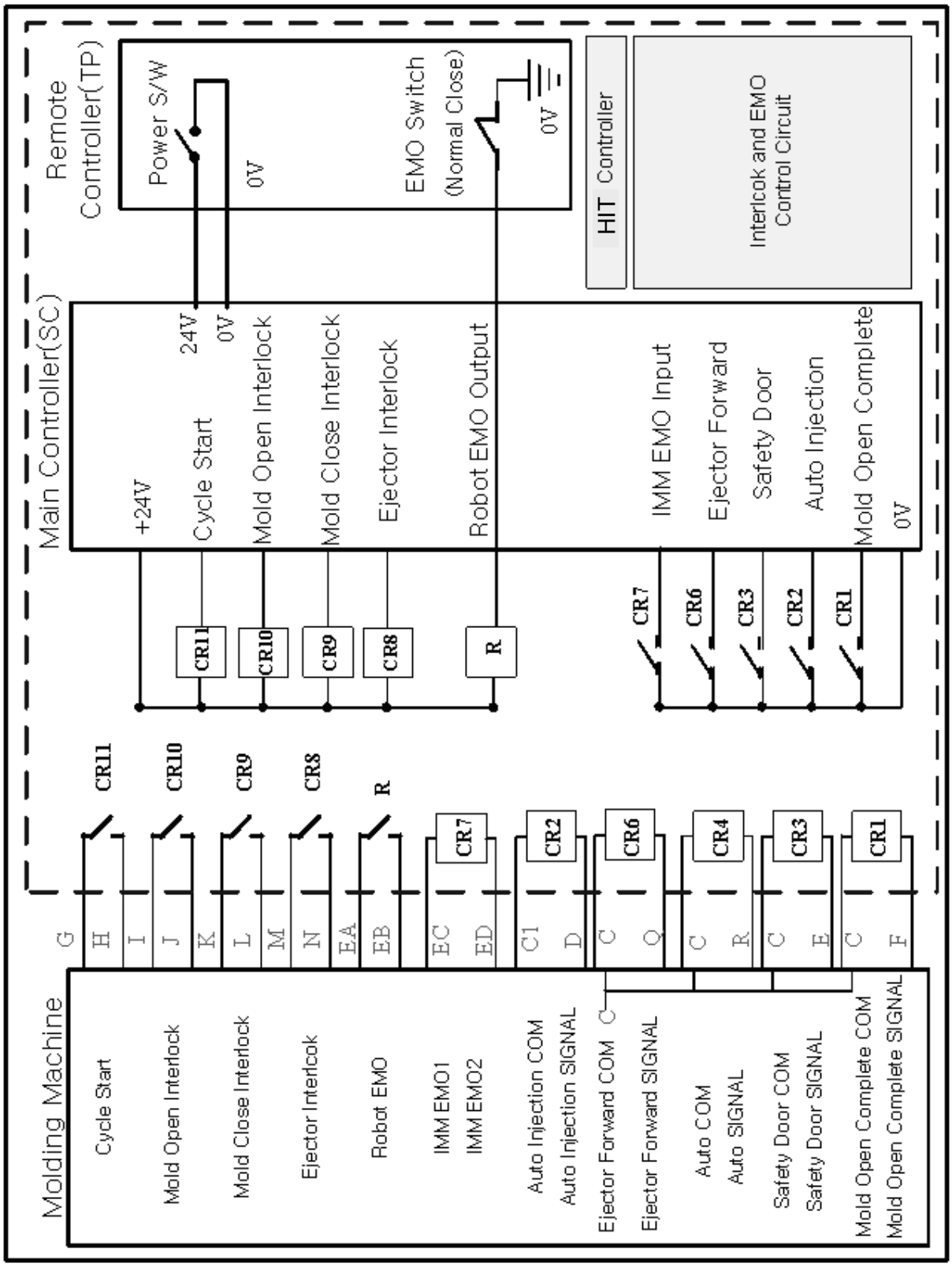
B

A

D. Air Chart


AIR-CHART
Chuck Rotation
Sub Arm Up/Down
Vacuum
Main Arm Up/Down
KVA350-02
NO.
REVISIONS
DATE
APPROVE
REMARK
ITEM
DESCRIPTION
MATERIAL
Q'TY
SIZE
REMARK
Drawn
Design
Check
Approve
Project
Draw No.
Part no.
A3
Scale: /
Unit M/M
Date:
AS004 M5(0)
PS60 102R NMCN6R2
AV 015HS/AF 05
I 4N10 1/4
PHR 1/8
BALL VV
AI 10 1/4
AI 8 1/4
AI 6 1/4
AI 6 1/8
AI 4 M5
ASQ8 1/4(In)
PHF10 1/4

E. Interlock


Molding Machine
Cycle Start
Mold Open Interlock
Mold Close Interlock
Ejector Interlock
Robot EMO
IMM EMO1
IMM EMO2
Auto Injection COM
Auto Injection SIGNAL
Ejector Forward COM
Ejector Forward SIGNAL
Auto COM
Auto SIGNAL
Safety Door COM
Safety Door SIGNAL
Mold Open Complete COM
Mold Open Complete SIGNAL
G
H
I
J
K
L
M
N
EA
EB
EC
ED
C1
D
C
Q
C
R
C
E
C
F
CR11
CR10
CR9
CR8
R
CR7
CR2
CR6
CR4
CR3
CR1
Main Controller(SC)
+24V
Cycle Start
Mold Open Interlock
Mold Close Interlock
Ejector Interlock
Robot EMO Output
IMM EMO Input
Ejector Forward
Safety Door
Auto Injection
Mold Open Complete
0V
24V
0V
CR11
CR10
CR9
CR8
R
CR7
CR6
CR3
CR2
CR1
Remote Controller(TP)
Power S/W
0V
EMO Switch (Normal Close)
0V
HIT Controller
Interlock and EMO Control Circuit

F. Input/ Output

Input			Output		
IA1	MArmUpOk	Main Arm Up Complete	OA0	MArmDown	Main Arm Down
IA2	M-KickOk	Main Arm Kick Complete	OA2	MArmKick	Main Arm Kick
IA4	RotateOk	Rotation Complete	OA4	ChkRotate	Chuck Rotation
IA5	RotRetOk	Rotation Return Complete	OA5	RotReturn	Chuck Rotation Return
IA6	SwivelOk	Swivel Complete	OA6	ChkSwivel	Chuck Swivel
IA7	SvlReOk	Swivel Return Complete	OA7	SvlReturn	Chuck Swivel Return
IB0	ChuckOk	Chuck Confirm	OB0	Chuck	Chuck
IB1	VacuumOk	Vacuum Confirm	OB1	Vacuum	Vacuum & Multi Release1
IB3	SArmGripOk	Sub Arm Grip Confirm	OB2	MArmGrip	Main Arm Grip
IB5	SArmUpOk	Sub Arm Up Confirm	OB3	SArmGrip	Sub Arm Grip
IC0	TrvRtOk	Traverse Return Complete	OB4	SArmDown	Sub Arm Up/Down
IC1	SafetyDown	Safety Down	OB5	SArmKickRt	Sub Arm Kick/Return
IC4	Obstacle	Obstacle Detection	OB6	NipFwd	Nipper Forward
ID0	AddGripOK	Add Gripper Comfirm	OB7	MulOff2	Multi Release(Off)2
			OC0	MulOff3	Multi Release(Off)3
			OC1	MulOff4	Multi Release(Off)4
			OD0	AddGripper	Add Gripper
			OD1	PitchChg	Pitch Change
			OD2	Flee	Traverse (Flee) in Mold
			OD4	Nipper	Nipper (Internal. External)
			OD6	ExNipCls	External Nipper Close
IF0	ReadyCut	Ready to Cutting	OF0	CutStart	Cutting Start
IF1	RdyStack	Ready to Stacking	OF1	StackingOK	Stacking Complete
IF2	Reject	Part Reject			
Interlock Input			Interlock Output		
IE0	AutoInject	Auto Injection	OE0	ConveyOn	Conveyor On
IE1	MoldOpen	Mold Open Complete	OE1	TakeoutOk	Take Out Complete
IE2	SafeDoor	Safety Door Open	OE2	MoldOpen	Mold Open
IE3	FullAuto	Fully Automatic	OE3	MoldClose	Mold Close
IE5	EjtFwdOk	Ejector Forward Complete	OE4	EjectorSig	Ejector Signal
IE6	ImmEmg	IMM Emergency			

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