

Presenting

TOSHIBA MACHINE V50 CONTROLLER

Tomorrow's Technology Today

Security Classification :	Presentation Purpose Only
Distribution Scope :	TMA Sales
Information Owner :	IM Sales

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

M.T.SETTING IS NOT FINISHED
COLD START PREVENTION IS WORKING

MEMORY 000 ALTER RUN 04/24/06 14:53

H N

32.0

H 1

32.0

H 2

32.0

H 3

32.0

***,*

***,*

0

0

0

0

0

0

0

0

THROAT

°F

***,*

°F

%

INJECT

0.00

COOL

0.00

INT

0.00

0.00

s

TEMP INJ

MENU

LIST

CLAMP

PROD

OPTION

TEMP

INJECT

MON

REC

INJECTROL

SPRUE BK

CONTINUE

TRH 3

0.00

TRH 2

0.00

TRH 1

0.00

CHG. DLY

0.0

CHG TRQ

0.0

INJ PRESS

87

SCREW SPEED

0

PH 4

0

PH 3

0

PH 2

0

PH 1

0

PI 1

0

BP

0

SRN

0

VH 1

0.00

VI 5

0.00

VI 4

0.00

VI 3

0.00

VI 2

0.00

VI 1

0.00

VSB

1.96

in/s

VH D

0.00

LS 4

0.000

LS 4D

0.000

LS 4C

0.000

LS 4B

0.000

LS 4A

0.000

LS 5

0.000

LS 10

0.000

in

SCREW POS

5.039

in

EJECTROL

LS 31A

0.00

LS 31

0.00

PEJ

2.3

VE 1

0.00

VE 2

0.00

in/s

VR

0.00

in/s

EJECT POS

0.00

in

LS 32

0.00

LS 32A

0.00

in

EJ.DELAY

0.00

s

EJC COUNTS

1

HOLD

EJECT MODE

OFF

A

B

CLAMPTROL

LS 2D

0.00

LS 2E

0.00

LS 2A

0.00

LS 2

0.000

in

VC 1

0

VC 2

0

VC 3

0

VC S

0.0

PCL

60

%

PCH

40

tf

VO S2

10.0

VO 3

0

VO 2

0

VO 1

0

VO S1

0.0

%

LS 3

10.00

LS 3B

0.00

LS 3E

0.00

LS 3D

0.00

LS 3A

0.00

in

LS 30

30.00

LS 100

0.00

in

CLAMP

0

CLAMP

PLATEN POS

10.00

in

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

M.T.SETTING IS NOT FINISHED
COLD START PREVENTION IS WORKING

MEMORY 000 ALTER RUN 04/24/06 14:53

H N	H 1	H 2	H 3
32.0	32.0	32.0	32.0
***.*	***.*	***.*	***.*
0	0	0	0

THROAT °F
***.* °F
%

INJECT 0.00
COOL 0.00
INT 0.00

TEMP INJ
MENU

LIST
CLAMP
PROD 9999
OPTION
TEMP °F
INJECT
MON
REC

INJECTROL

SPRUE BK CONTINUE
TRH 3 0.00
TRH 2 0.00
TRH 1 0.00 s

CHG. DLY 0.0 s

CHG TRQ 0.0 %
INJ PRESS 87 PSI
SCREW SPEED 0 min-1

PH 4 0
PH 3 0
PH 2 0
PH 1 0

PI 1 0

BP 0 PSI

SRN 0

VH 1 0.00

VI 5 0.00

VI 4 0.00

VI 3 0.00

VI 2 0.00

VI 1 0.00

VSB 1.96 in/s

VH D 0.00 in/s

LS 4 0.000

LS 4D 0.000

LS 4C 0.000

LS 4B 0.000

LS 4A 0.000

LS 5 0.000

LS 10 0.000 in

SCREW POS 5.039 in

EJECTROL

LS 31A 0.00

LS 31 0.00 in

PEJ 2.3 tf

VE 1 0.00

VE 2 0.00 in/s

VR 0.00 in/s

EJECT POS 0.00 in

LS 32 0.00

LS 32A 0.00 in

EJ.DELAY 0.00 s

EJC COUNTS 1 · HOLD

EJECT MODE OFF · A · B

CLAMPTROL

LS 2D 0.00

LS 2E 0.00

LS 2A 0.00

LS 2 0.000 in

CLAMP 0 tf

VC 1 0

VC 2 0

VC 3 0

VC S 0.0

PCL 60 %

PCH 40 tf

VO S2 10.0

VO 3 0

VO 2 0

VO 1 0

VO S1 0.0 %

LS 3 10.00

LS 3B 0.00

LS 3E 0.00

LS 3D 0.00

LS 3A 0.00 in

LS 30 30.00

LS 100 0.00 in

PLATEN POS 10.00 in

SHORTCUT
TOOL
SNAP SHOT
MESSAGE
LADDER
SUP-PORT

COLD START PREVENTION IS WORKING

MEMORY 001

NO ALTR

RUN

05/08/08

10:12

TEMP

BARREL BR PID

CLAMP

CLAMP EJECT MLD PROT EJE MON

INJECT

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR

PROD

PRD MGT PRD GRPH START UP PRD PLAN

MON

DET. SET TABLE 1 TABLE 2 TREND 1 TREND 2 L RESULT

OPTION

INIT SET MOLDLZ1 MOLDLZ2

REC

SET-UP HISTORY MEMO2

INJECT VISOR

TEMP INJ

SETUP

LIST	TEMP
CLAMP	INJECT
PROD	MON
OPTION	REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

M.T.SETTING IS NOT FINISHED

COLD START PREVENTION IS WORKING

MEMORY 000 ALTER RUN 04/24/08 14:53

H N	H 1	H 2	H 3
32.0	32.0	32.0	32.0
***,*	***,*	***,*	***,*
0	0	0	0

THROAT
°F
***,*
°F
%

INJECT 0.00
COOL 0.00
INT 0.00

TEMP INJ
MENU

LIST
CLAMP
PROD 9999
OPTION
TEMP °F
INJECT
MON
REC

INJECTROL

SPRUE BK
CONTINUE

TRH 3 0.00
TRH 2 0.00
TRH 1 0.00 s

CHG. DLY 0.0 s

CHG TRQ 0.0 %
INJ PRESS 87 PSI
SCREW SPEED 0 min-1

PH 4 0
PH 3 0
PH 2 0
PH 1 0

PI 1 0

BP 0 PSI

SRN 0 min-1

VH 1 0.00
VI 5 0.00
VI 4 0.00
VI 3 0.00
VI 2 0.00
VI 1 0.00
VSB 1.96 in/s
VH D 0.00 in/s
LS 4 0.000
LS 4D 0.000
LS 4C 0.000
LS 4B 0.000
LS 4A 0.000
LS 5 0.000
LS 10 0.000 in

SCREW POS
5.039 in

EJECTROL

LS 31A 0.00
LS 31 0.00 in
VE 1 0.00
VE 2 0.00 in/s
VR 0.00 in/s
EJECT POS 0.00 in
LS 32 0.00
LS 32A 0.00 in
EJC COUNTS 1 · HOLD
EJECT MODE OFF · A · B

CLAMPTROL

LS 2D 0.00
LS 2E 0.00
LS 2A 0.00
LS 2 0.000 in
VC 1 0
VC 2 0
VC 3 0
VC S 0.0
POL 60 %
PCH 40 tf
VO S2 10.0
VO 3 0
VO 2 0
VO 1 0
VO S1 0.0 %
LS 3 10.00
LS 3B 0.00
LS 3E 0.00
LS 3D 0.00
LS 3A 0.00 in
LS 30 30.00
LS 100 0.00 in
CLAMP 0
CLAMP

PLATEN POS
10.00 in

SHORTCUT
TOOL
SNAP SHOT
MESSAGE
LADDER
SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING (2/2) MEMORY 000 ALTER RUN 04/24/06 15:31

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCATR

		H N	H 1	H 2	H 3		THROAT
ACT	°F	999.9	999.9	999.9	999.9		999.9
DEV	°F	***.*	***.*	***.*	***.*		
ON RATIO %		0	0	0	0		

INJECTION	0.00	s	SCREW POS	5.039	in	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	10.00	in	INJ/BP PRESS	98	PSI
INTERVAL	0.00	s	EJECT POS	0.00	in	SCREW SPEED	0	min-1

HEATROL

H N	H 1	H 2	H 3
32.0	32.0	32.0	32.0
***.*	***.*	***.*	***.*
0	0	0	0

THROAT °F
***.* °F
%

TIMER

INJECT	COOL	INT
3.00	5.00	0.20

0.00 s

INJECT VISOR

MENU

INJECTROL

SPRUE BK CONTINUE

TRH 3	TRH 2	TRH 1
0.75	0.75	0.75

s

CHG. DLY

0.0 s

CHG TRQ 0.0 %

INJ PRESS 87 PSI

SCREW SPEED 0 min-1

BP 800 PSI

SRN 200

PH 4	PH 3	PH 2	PH 1	PI 1
3000	5000	7000	10000	21000

VH 1	VI 5	VI 4	VI 3	VI 2	VI 1	VSB
5.00	0.50	1.00	2.00	9.00	1.00	1.96

in/s

VH D	LS 4	LS 4D	LS 4C	LS 4B	LS 4A	LS 5	LS 10
0.00	0.125	0.300	0.500	2.000	3.000	4.000	0.250

in

SCREW POS

5.039 in

LIST TEMP

CLAMP INJECT

PROD MON

OPTION REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Screen Title

Product code or title

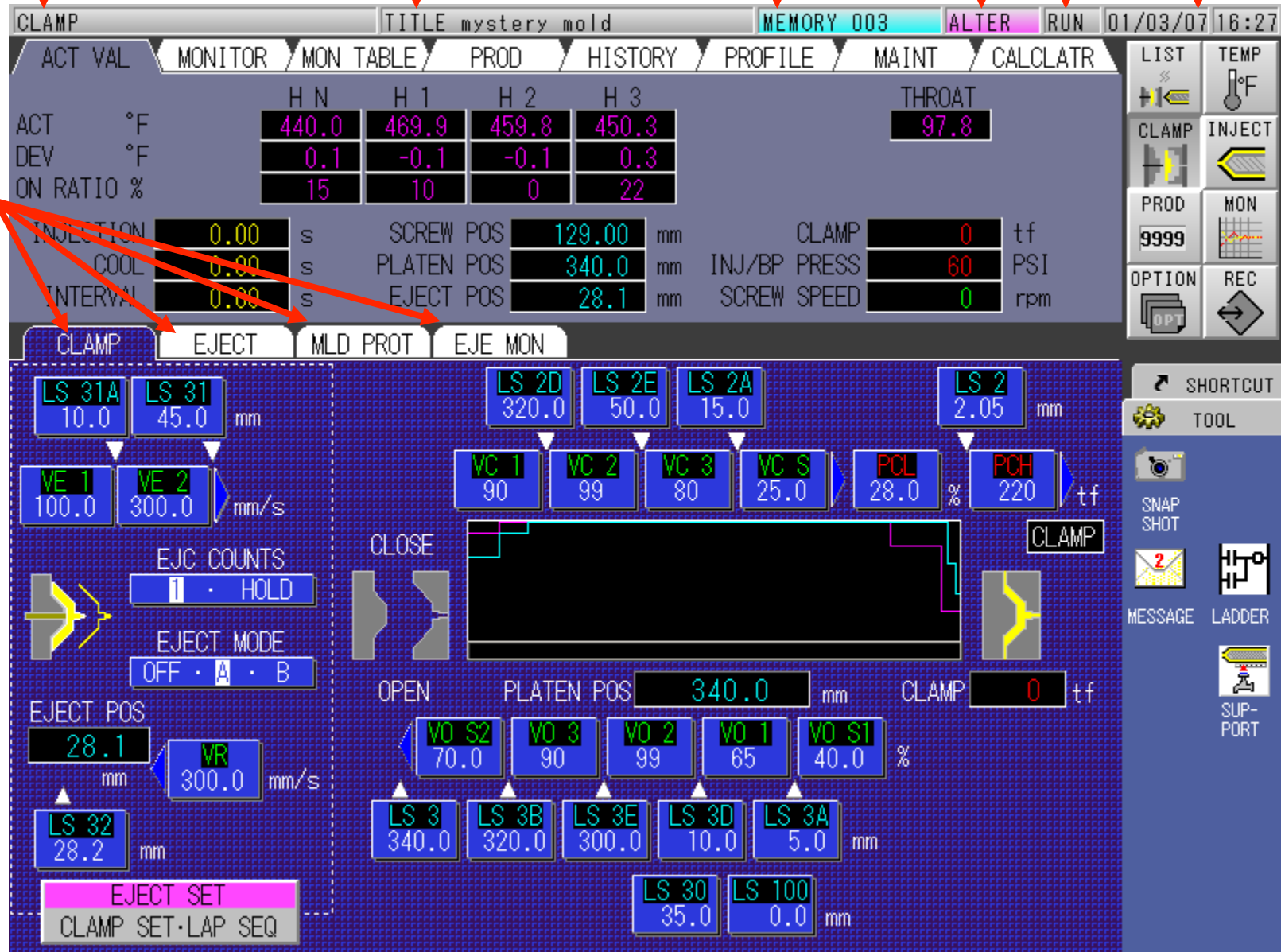
Memory currently running

Molding condition has
been altered

Run
condition

Date and
Time

Main
screen
group
and sub
groups



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

M.T.SETTING IS NOT FINISHED
COLD START PREVENTION IS WORKING

MEMORY 000 ALTER RUN 04/24/06 14:53

H N32.0

H 132.0

H 232.0

H 332.0

***,*

***,*

***,*

***,*

0

0

0

0

THROAT

°F

°F

%

0.00

0.00

0.00

0.00

0.00

s

INJECTROL

SPRUE BK

CONTINUE

TRH 30.00

TRH 20.00

TRH 10.00

s

CHG. DLY

0.0

s

CHG TRQ

0.0

%

INJ PRESS

87

PSI

SCREW SPEED

0

min-1

PH 40

PH 30

PH 20

PH 10

PI 10

BP 0

PSI

SRN 0

min-1

VH 1

0.00

in/s

VI 5

0.00

in

VI 4

0.00

in

VI 3

0.00

in

VI 2

0.00

in

VI 1

0.00

in

VSB

1.96

in/s

VH D

0.00

in/s

LS 4

0.000

in

LS 4D

0.000

in

LS 4C

0.000

in

LS 4B

0.000

in

LS 4A

0.000

in

LS 5

0.000

in

LS 10

0.000

in

SCREW POS

5.039

in

EJECTROL

LS 31A

0.00

in

LS 31

0.00

in

PEJ

2.3

tf

VE 1

0.00

in/s

VE 2

0.00

in/s

VR

0.00

in/s

EJECT POS

0.00

in

LS 32

0.00

in

LS 32A

0.00

in

EJ.DELAY

0.00

s

EJC COUNTS

1

HOLD

EJECT MODE

OFF

A

B

CLAMPTROL

LS 2D

0.00

in

LS 2E

0.00

in

LS 2A

0.00

in

LS 2

0.000

in

CLAMP

0

tf

VC 1

0

%

VC 2

0

%

VC 3

0

%

VC S

0.0

%

PCL

60

%

PCH

40

tf

CLAMP

CLAMP

VO S2

10.0

%

VO 3

0

%

VO 2

0

%

VO 1

0

%

VO S1

0.0

%

LS 3

10.00

in

LS 3B

0.00

in

LS 3E

0.00

in

LS 3D

0.00

in

LS 3A

0.00

in

LS 30

30.00

in

LS 100

0.00

in

PLATEN POS

10.00

in

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

01/02/07 11:40

MESSAGE

MESSAGE MAKING

Look for flash, cavity 7, parting line.

SAVE

MESSAGE TOP

DATE

NEW CREATION

DEL

☐ MESSAGE1

☐ MESSAGE2

☐ MESSAGE3

☐ MESSAGE4

☐ MESSAGE5

UN RATIO %	10	46	46	100
TOL °F±	10.0	10.0	10.0	10.0
AL ARM SELECT	OFF	OFF	OFF	OFF

COLD PREVENT

REMAIN 0 min

Keyboard

q w e r t y u i o p Enter

a s d f g h j k l -

Shift z x c v b n m , * / +

Symbol Space ← ↓ → 0 . -

LIST

CLAMP

PROD

9999

OPTION

TEMP

INJECT

MON

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/02/07 11:42

MESSAGE

MESSAGE1 Break is over !

MESSAGE TOP DATE

MESSAGE1 Break is over ! 01/02/07

MESSAGE2 Look for flash, cavity 7, 01/02/07

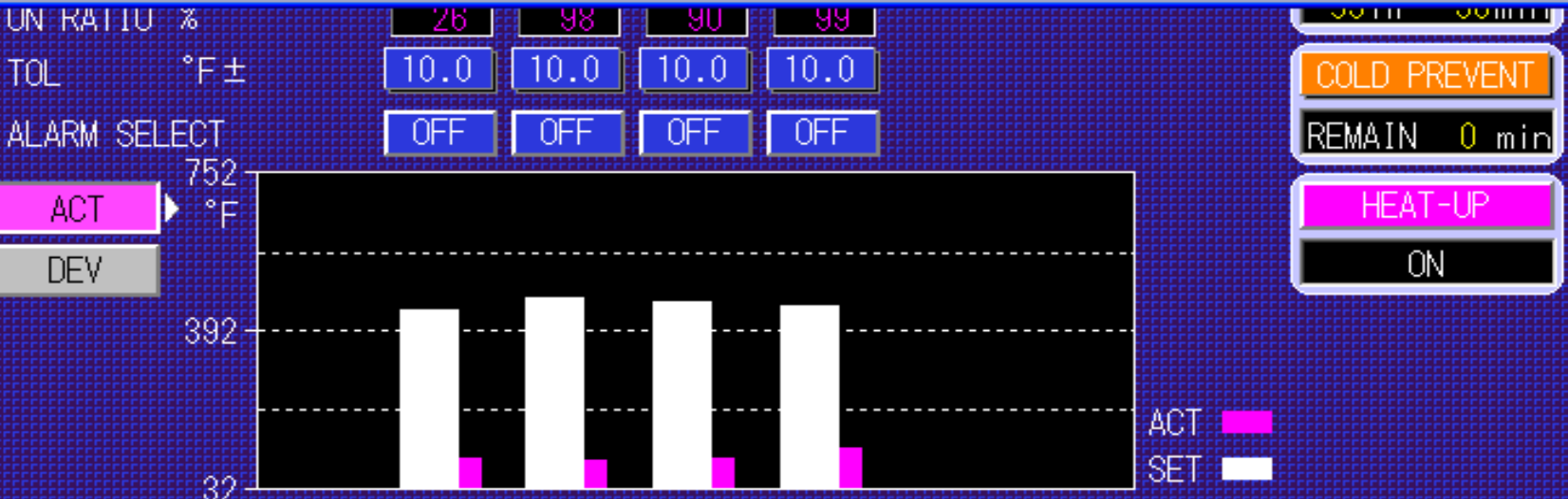
MESSAGE3

MESSAGE4

MESSAGE5

NEW CREATION

DEL



LIST TEMP

CLAMP INJECT

PROD MON

9999

OPTION REC

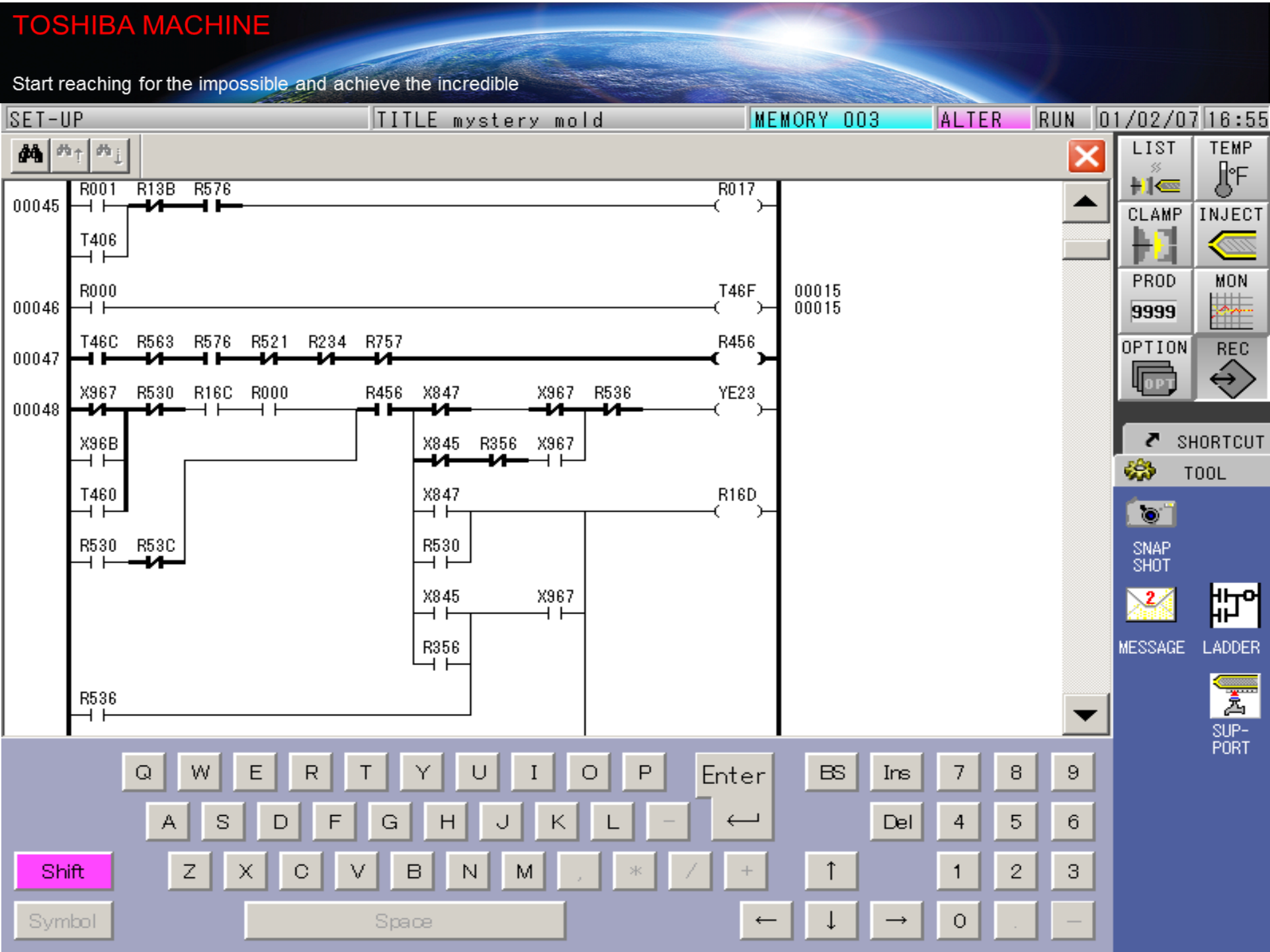
SHORTCUT

TOOL

SNAP SHOT

MESSAGE LADDER

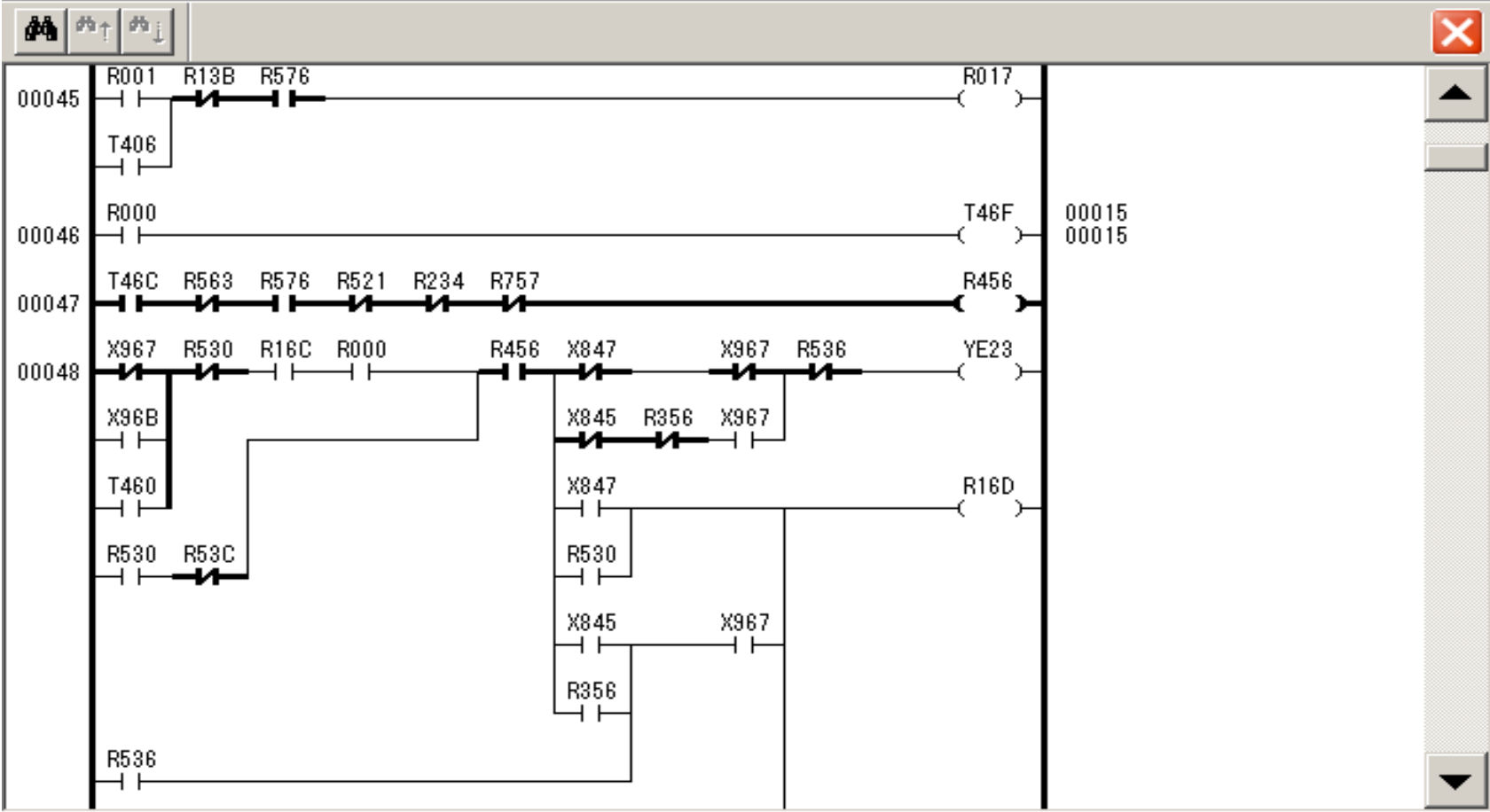
SUP-PORT



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

SET-UP TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 16:55



LIST

CLAMP

PROD

9999

OPTION

OPT

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TEMP

INJECT

MON

REC

2

2

2

Q

W

E

R

T

Y

U

I

O

P

Enter

ES

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7

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9

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K

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4

5

6

Shift

Z

X

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+

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1

2

3

Symbol

Space

←

↓

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0

.

-

SET-UP TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 16:56

SUPPORT



RESIN

PP

COOLING TIME

CHG STROKE

AVG THKNS

2.5

mm

MOLD TEMP

125.0

°F

MATL TEMP

540.0

°F

TAKE TEMP

225.0

°F

COOLING TIME
+HOLD TIME

12.0

s



ID

SAVE DATE 09/22/06

PHOTO

EDIT

ERASE

SAVE-LOAD



MEMORY



EXT_MEMO

RUN

EDIT

SAVE

LOAD

EXEC

STOP

MEMORY
TAKEOUT



FIND PAGE

001 syringe plunger

011

021

002 grip lock

012

022

003 mystery mold

013

023

004

014

024

005

015

025

006

016

026

007

017

027

008

018

028

009

019

029

010

020

030

ALL COPY



LIST



TEMP



CLAMP



INJECT



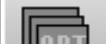
PROD

9999

MON



OPTION



REC



SHORTCUT

TOOL



SNAP
SHOT



MESSAGE



LADDER



SUP-
PORT

Start reaching for the impossible and achieve the incredible

SUPPORT

RESIN

PP

COOLING TIME

CHG STROKE

AVG THKNS

MOLD TEMP

MATL TEMP

TAKE TEMP

COOLING TIME +HOLD TIME

2.5

125.0

540.0

225.0

12.0

mm

°F

°F

°F

s

- SAVE-LOAD
- 001 syringe plu
- 002 grip lock
- 003 mystery mo
- 004
- 005
- 006
- 007
- 008
- 009
- 010

RESIN SELECT

RESIN	SPECIFIC GRAVITY (g/cm3)	RESIN	SPECIFIC GRAVITY (g/cm3)
<input type="radio"/> PE	0.75	<input type="radio"/> LDPE	5.00
<input checked="" type="radio"/> PP	0.73	<input type="radio"/>	0.00
<input type="radio"/> POM	1.30	<input type="radio"/>	0.00
<input type="radio"/> PA66	1.00	<input type="radio"/>	0.00
<input type="radio"/> ABS	0.95	<input type="radio"/>	0.00
<input type="radio"/> PS	0.95	<input type="radio"/>	0.00
<input type="radio"/> PC	1.09	RESIN SET	
<input type="radio"/> AS	1.02	MAY SET RESIN NAME & SP GRAVITY IN RESIN SETTING.	
<input type="radio"/> R-PVC	1.30		

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

SET-UP TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 16:57

SUPPORT



RESIN

PP

COOLING TIME

CHG STROKE

SHOTWEIGHT

220.0

>

SCREW TIP

STD

>

CHARGE STROKE(LS5)

130.48

g

mm



ID

SAVE DATE 09/22/06

PHOTO

EDIT

ERASE

SAVE-LOAD



MEMORY

RUN

SAVE

EXEC



EXT_MEMO

EDIT

LOAD

STOP

MEMORY TAKEOUT



001 syringe plunger

011

021

002 grip lock

012

022

003 mystery mold

013

023

004

014

024

005

015

025

006

016

026

007

017

027

008

018

028

009

019

029

010

020

030

FIND PAGE

ALL COPY



LIST



TEMP



CLAMP



INJECT



PROD

9999

MON



OPTION



REC



SHORTCUT



TOOL



SNAP SHOT



MESSAGE



LADDER



SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 003 ALTER RUN 12/14/06 14:05

HEATROL

H N	H 1	H 2	H 3
440.0	470.0	460.0	450.0
86.5	88.8	89.7	85.2
0	0	0	0

THROAT
79.5 °F
%

TIMER

INJECT	COOL	INT
10.00	20.00	0.50
0.00 s		

TEMP INJ
MENU

LIST
CLAMP
INJECT

INJECTROL

SPRUE BK	TRH 3	TRH 2	TRH 1
CONTINUE	2.00	2.00	2.00 s

CHG. DLY
0.0 s

CHG TRQ 15.4 %
INJ PRESS 20 PSI
SCREW SPEED 85 rpm

PH 4	PH 3	PH 2	PH 1
4500	4000	3500	3000

PI 1
23000

BP
1000 PSI

VH 1
80.0

VI 3 20.0
VI 2 80.0
VI 1 50.0

VSB
10.0 mm/s

VH D
60.0 mm/s

LS 4
10.00

LS 4B 20.00
LS 4A 100.00
LS 5 123.00

LS 10
6.00 mm

SCREW POS
0.00 mm

EJECTROL

LS 31A 10.0
LS 31 45.0 mm

PEJ
2.0 tf

VE 1 100.0
VE 2 300.0 mm/s

VR 300.0 mm/s

EJECT POS
28.1 mm

LS 32 28.2
LS 32A 40.0 mm

EJ.DELAY
0.00 s

EJC COUNTS
HOLD

EJECT MODE
OFF A B

CLAMPTROL

LS 2D 320.0
LS 2E 50.0
LS 2A 15.0

LS 2
2.05 mm

CLAMP
0 tf

VC 1 90
VC 2 99
VC 3 80
VC S 25.0

PCL 7 %
PCH 220 tf

CLAMP

VO S2 70.0
VO 3 90
VO 2 99
VO 1 65
VO S1 40.0 %

LS 3 340.0
LS 3B 320.0
LS 3E 300.0
LS 3D 10.0
LS 3A 5.0 mm

LS 30 35.0
LS 100 0.0 mm

PLATEN POS
340.0 mm

PROD 9999
MON
OPTION REC

TOOL
SHORTCUT

VC 3 80
VH 1 80.0

EJE TRQ MAX VE
99

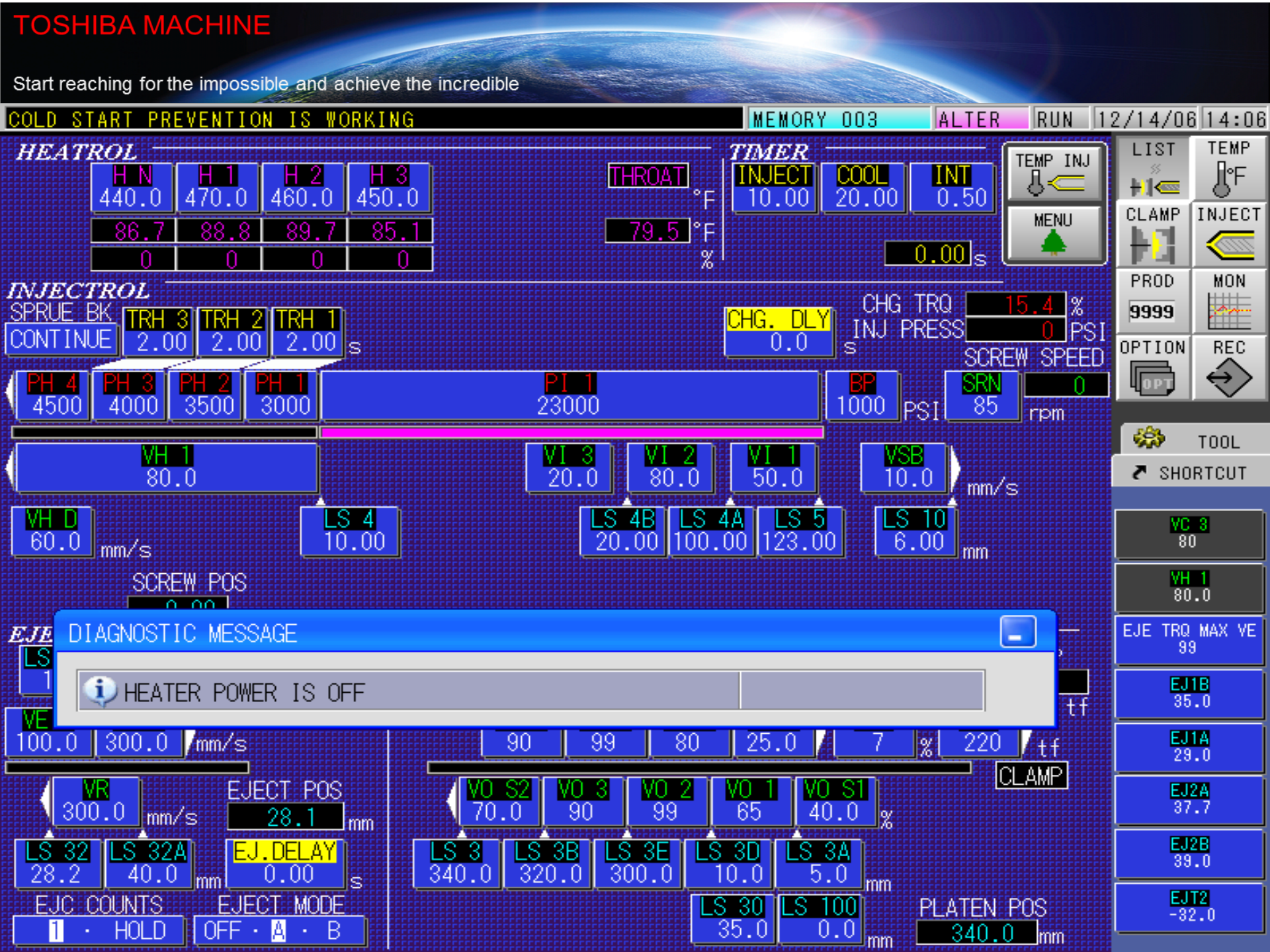
EJ1B 35.0

EJ1A 29.0

EJ2A 37.7

EJ2B 39.0

DIAG MESSG
1



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

12/14/06

14:28

HEATROL

H N	H 1	H 2	H 3
440.0	470.0	460.0	450.0
86.0	88.1	88.3	84.3
0	0	0	0

THROAT

°F
°F
%

79.3

TIMER

INJECT	COOL	INT
10.00	20.00	0.50

0.00 s

TEMP INJ
MENU

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

INJECTROL

SPRUE BK	TRH 3	TRH 2	TRH 1
CONTINUE	2.00	2.00	2.00 s

CHG. DLY
0.0 s

CHG TRQ 15.4 %
INJ PRESS 30 PSI
CODEW SPEED 0 rpm

PH 4	PH 3	PH 2
4500	4000	3500

VH 1
80.0

VH 0
60.0 mm/s

SCREW
0.00

EJECTROL

LS 31A	LS 31
10.0	45.0

VE 1	VE 2
100.0	300.0 mm/s

VR
300.0 mm/s

LS 32	LS 32A
28.2	40.0 mm

EJC COUNTS
1 · HOLD

LS2D MLD CLOSEHIGH SPD POS 0000.0~0520.0mm

0 3 2 0 . 0

EJECT POS
28.1 mm

EJ.DELAY
0.00 s

EJECT MODE
OFF · A · B

VC 1	VC 2	VC 3	VC 4
90	99	80	25.0

VO S2	VO 3	VO 2	VO 1	VO S1
70.0	90	99	65	40.0 %

LS 3	LS 3B	LS 3E	LS 3D	LS 3A
340.0	320.0	300.0	10.0	5.0 mm

LS 30	LS 100
35.0	0.0 mm

PLATEN POS 340.0 mm

SHORTCUT
TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

DIAG MESSG

1

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

12/14/06 14:27

HEATROL

H N	H 1	H 2	H 3
440.0	470.0	460.0	450.0
86.0	87.9	88.5	84.3
0	0	0	0

THROAT

°F
79.3
°F
%

TIMER

INJECT	COOL	INT
10.00	20.00	0.50
0.00 s		

TEMP INJ



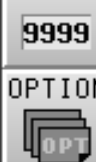
LIST



TEMP



CLAMP



INJECT



PROD



MON



OPTION



REC



SHORTCUT



TOOL



MESSAGE



LADDER



SUP-PORT



RATION



DIAG MESSG

1

INJECTROL

SPRUE BK	TRH 3	TRH 2	TRH 1
CONTINUE	2.00	2.00	2.00 s

CHG. DLY 0.0 s

CHG TRQ 15.4 %
INJ PRESS 0 PSI

SCREW SPEED

SRN 85 rpm

PH 4	PH 3	PH 2
4500	4000	3500

VH 1
80.0

VH 0
60.0 mm/s

SCREW
0.00

EJECTROL

LS 31A	LS 31
10.0	45.0

VE 1	VE 2
100.0	300.0

VR
300.0 mm/s

LS 32	LS 32A
28.2	40.0

EJC COUNTS
1 · HOLD

EJECT POS 28.1 mm

EJ.DELAY 0.00 s

EJECT MODE OFF · A · B

VO S2	VO 3	VO 2	VO 1	VO S1
70.0	90	99	65	40.0 %

LS 3	LS 3B	LS 3E	LS 3D	LS 3A
340.0	320.0	300.0	10.0	5.0

LS 30	LS 100
35.0	0.0

PLATEN POS 340.0 mm

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 12/14/06 14:27

SET HIS

MM/DD/YY hr min	SET UP	MEMORY	ID
12/01/06 10:29	320.0	2	
09/19/06 12:18	300.0	131	
09/19/06 09:10	320.0	131	
09/19/06 08:28	10.00	131	
09/15/06 14:46	13.00	131	
09/14/06 13:05	19.00	131	

TEMP INJ MENU

79.3 °F

0.00 s

CHG. DLY 0.0 s

CHG TRQ 15.4 %

INJ PRESS 30 PSI

SCREW SPEED 85 rpm

LIST

CLAMP

PROD 9999

OPTION

TEMP °F

INJECT

MON

REC

VH 1 80.0

VH D 60.0 mm/s

SCREW 0.00

EJECTROL

LS 31A 10.0

LS 31 45.0

VE 1 100.0

VE 2 300.0

VR 300.0 mm/s

LS 32 28.2

LS 32A 40.0

EJC COUNTS

HOLD

0320.0

7 8 9

4 5 6

1 2 3

0 . +/-

ENT

EJECT POS 28.1 mm

EJ.DELAY 0.00 s

EJECT MODE

OFF A B

VO S2 70.0

VO 3 90

VO 2 99

VO 1 65

VO S1 40.0 %

LS 3 340.0

LS 3B 320.0

LS 3E 300.0

LS 3D 10.0

LS 3A 5.0

LS 30 35.0

LS 100 0.0

mm/s

10 mm

CLAMP 0 tf

PCH 220 tf

CLAMP

PLATEN POS 340.0 mm

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

DIAG MESSG

1

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 12/14/06 14:29

HEATROL

H N	H 1	H 2	H 3
440.0	470.0	460.0	450.0
90.6	89.2	89.9	88.3
0	36	48	100

TIMER

THROAT	INJECT	COOL	INT
	10.00	20.00	0.50
79.3 °F			0.00 s

TEMP INJ

MENU

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

INJECTROL

SPRUE BK	TRH 3	TRH 2	TRH 1
CONTINUE	2.00		

CHG. DLY

CHG TRQ	15.4 %
INJ PRESS	0 PSI
W SPEED	0 rpm

PH 4	PH 3	PH 2
4500	4000	3500

VH 1
80.0

VH 0
60.0 mm/s

SCREW F
0.00

EJECTROL

LS 31A	LS 31
10.0	45.0

VE 1	VE 2
100.0	300.0 mm/s

VR
300.0 mm/s

LS 32	LS 32A
28.2	40.0 mm

EJC COUNTS	EJECT MODE
I · HOLD	OFF · A · B

LS2D MLD CLOSEHIGH SPD POS 0000.0~0520.0mm

-

-

-

-

-

0320.0

+

+

+

+

+

✖

📊

VC 1	VC 2	VC 3	VC S	PCL	PCH
90	99	80	25.0	7 %	220 tf
VO S2	VO 3	VO 2	VO 1	VO S1	
70.0	90	99	65	40.0 %	
LS 3	LS 3B	LS 3E	LS 3D	LS 3A	
340.0	320.0	300.0	10.0	5.0 mm	
LS 30	LS 100				
35.0	0.0 mm				
PLATEN POS					
340.0 mm					

TOOL

SHORTCUT

VC 3

80

VH 1

80.0

VO S2

70.0

VE 2

300.0

LS 31A

10.0

VH 0

60.0

LS 32A

40.0

LS 2D

320.0

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

12/14/06 14:05

HEATROL

H N	H 1	H 2	H 3
440.0	470.0	460.0	450.0
86.5	88.8	89.7	85.2
0	0	0	0

THROAT
°F
79.5
°F
%

TIMER

INJECT	COOL	INT
10.00	20.00	0.50
0.00 s		

TEMP INJ
MENU

LIST
CLAMP
INJECT

INJECTROL

SPRUE BK	TRH 3	TRH 2	TRH 1
CONTINUE	2.00	2.00	2.00

CHG. DLY
0.0

CHG TRQ 15.4 %
INJ PRESS 20 PSI
SCREW SPEED

PH 4	PH 3	PH 2	PH 1
4500	4000	3500	3000

PI 1
23000

BP 1000 PSI
SRN 85 rpm

VH 1
80.0

VI 3 20.0
VI 2 80.0
VI 1 50.0

VSB 10.0 mm/s

VH D 60.0 mm/s

LS 4 10.00

LS 4B 20.00
LS 4A 100.00
LS 5 123.00

LS 10 6.00 mm

SCREW POS
0.00 mm

EJECTROL

LS 31A 10.0
LS 31 45.0 mm
PEJ 2.0 tf

VE 1 100.0
VE 2 300.0 mm/s

VR 300.0 mm/s
EJECT POS 28.1 mm

LS 32 28.2
LS 32A 40.0 mm
EJ.DELAY 0.00 s

EJC COUNTS 1 · HOLD
EJECT MODE OFF · A · B

CLAMPTROL

LS 2D 320.0
LS 2E 50.0
LS 2A 15.0
LS 2 2.05 mm
CLAMP 0

VC 1 90
VC 2 99
VC 3 80
VC S 25.0
PCL 7 %
PCH 220 tf

VO S2 70.0
VO 3 90
VO 2 99
VO 1 65
VO S1 40.0 %

LS 3 340.0
LS 3B 320.0
LS 3E 300.0
LS 3D 10.0
LS 3A 5.0 mm

LS 30 35.0
LS 100 0.0 mm
PLATEN POS 340.0 mm

PROD 9999
MON
OPTION REC

TOOL
SHORTCUT

VC 3 80

VH 1 80.0

EJE TRQ MAX VE 99

EJ1B 35.0

EJ1A 29.0

EJ2A 37.7

EJ2B 39.0

DIAG MESSG
1

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

M.T.SETTING IS NOT FINISHED

(1/2) MEMORY 000

ALTER

RUN

04/24/06 15:03

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

		H N	H 1	H 2	H 3
ACT	°F	999.9	999.9	999.9	999.9
DEV	°F	**.*	**.*	**.*	**.*
ON RATIO %		0	0	0	0

THROAT

999.9

INJECTION	0.00	s	SCREW POS	5.039	in	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	10.00	in	INJ/BP PRESS	87	PSI
INTERVAL	0.00	s	EJECT POS	0.00	in	SCREW SPEED	0	min-1

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR

SPRUE BK CONTINUE

SPEED STEP 5

PRESS STEP 1

INJ PRESS 87 PSI

CHG. DLY 0.0 s

SRN 200 min-1

TRH 3 0.75

TRH 2 0.75

TRH 1 0.75 s

PH 4 3000

PH 3 5000

PH 2 7000

PH 1 10000

PI 1 21000

BACK PRESS 800 PSI

INJECT 3.00

COOL 5.00

INT 0.20

0.00 s

SCREW POS 5.039 in

VH 1 5.00

VI5 0.50

VI4 1.00

VI3 2.00

VI2 9.00

VI1 1.00

VSB 1.96 in/s

VH D 0.00 in/s

LS 4 0.125

LS 4D 0.300

LS 4C 0.500

LS 4B 2.000

LS 4A 3.000

LS 5 4.000

LS 10 0.250 in

LS 10A 0.000 in

LIST

TEMP °F

CLAMP

INJECT

PROD 9999

MON

OPTION OPT

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

MONITOR:THROAT TEMPERATURE

MEMORY 003

ALTER

RUN

01/16/07 12:01

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALC LTR

		H N	H 1	H 2	H 3
ACT	°F	439.8	469.0	459.6	449.0
DEV	°F	-0.1	-1.0	-0.3	-0.9
ON RATIO %		14	14	37	62

THROAT

117.1

INJECTION	0.00	s	SCREW POS	25.17	mm
COOL	2.41	s	PLATEN POS	0.0	mm
INTERVAL	0.00	s	EJECT POS	28.1	mm

CLAMP	220	tf
INJ/BP PRESS	504	PSI
SCREW SPEED	95	rpm

LIST



TEMP



CLAMP



INJECT



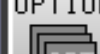
PROD

9999

MON



OPTION



REC



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

MONITOR:THROAT TEMPERATURE MEMORY 003 ALTER RUN 01/16/07 11:57

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

MD CLOSE

LOCK UP

INJECT

MD OPEN

EJECT

INT

FILL

2.13 s

CHARGE

12.98 s

CYCLE

34.51 s

MIN-CUSH

1.68 mm

FPC PRESS

6562 PSI

INJ PEAK

7874 PSI

INJ

CHG

CLMP

EJE

16 %

27 %

23 %

20 %

LIST

TEMP

CLAMP

INJECT

PROD

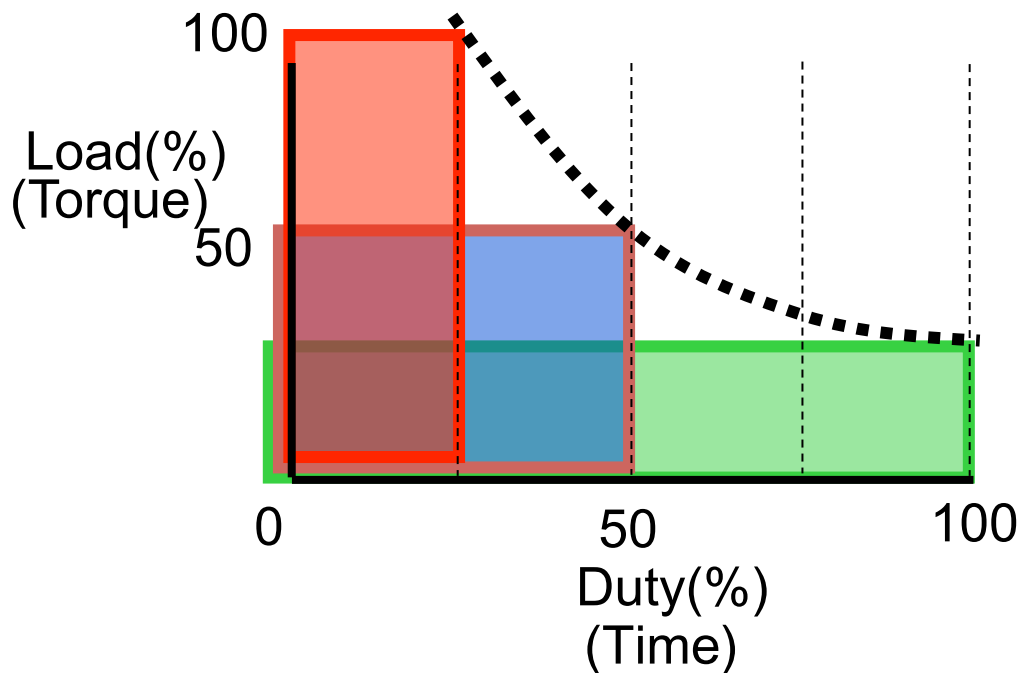
MON

OPTION

REC

9999

Machine Duty (Load Ratio)



How to improve the duty?

- a) Longer cycle / cooling time.
- b) Lower screw torque (for charging motor).
 - > Higher temperature.
 - > Slower screw speed.
- c) Lower injection torque. (for injection motor).
 - > Higher temperature.
 - > Lower injection pressure.
 - > Shorter injection time / holding time.

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

MONITOR:THROAT TEMPERATURE

MEMORY 003

ALTER

RUN

01/16/07 11:58

ACT VAL	MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR	
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
1072	37.28 A	4422 *	0.00	6.54	86.79 *	86.83 *	4436 *	0.80 A
1073	3.50	5346	0.00	36.91	33.99 *	33.99 *	5389 *	0.80
1074	3.50	3057 *	0.00	24.81	0.00	0.00 *	4351 *	0.82
1075	22.24	5360	3.03	37.05	0.00	0.00 *	6811	2.13
1076	15.37	6029	3.47	34.51	0.37	0.37 *	7593 *	2.13
1077	13.60	6285	3.47	34.51	1.09	1.09 *	7906 *	2.13
1078	12.98	6555 *	3.47	34.51	1.68	1.68 *	7863 *	2.13

LIST



TEMP



CLAMP



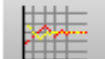
INJECT



PROD



MON



OPTION



REC



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

01/16/07 10:53

ACT VAL	MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR	LIST	TEMP
PRODUCT CODE	TOTAL PROD		TOTAL PROD	10048	RUN RATIO	3 %		CLAMP	INJECT
REQUIRED	100000		GOOD PROD	9408	ELAPSED PROCESS	10 %		PROD	MON
CAVITY	16		REJECT PROD	640	REJECT RATIO	6 %		9999	
SHOT COUNTER	628 shots		REMAIN PROD	89952	PROD START TIME	10/11 10:32		OPTION	REC
GOOD SHOT	588 shots		RESIN USED	0 kg	PROD REMAIN TIME	10 h 13 min			
REMAIN SHOT	5622 shots		ESTIMATE RESIN	0 kg	TOTAL SHOT	2381 shots			
					TOTAL TIME	223 hr			

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

MONITOR:THROAT TEMPERATURE MEMORY 003 ALTER RUN 01/16/07 11:58

ACT VAL / MONITOR / MON TABLE / PROD / HISTORY / PROFILE / MAINT / CALCLATR

MM/DD/YY hr min	CONTENTS	MEMORY	ID
01/16/07 11:55	SRN SCREW SPEED 85 > 95rpm	3	
01/16/07 11:55	CHANGED FROM AUTO/SA MODE TO MAN/MT-SET MODE	3	
01/16/07 11:55	CHANGED FROM MAN/MT-SET MODE TO AUTO/SA MODE	3	
01/16/07 11:54	PROCESS:CHARGING TIME IS LONG	3	
01/16/07 11:54	PROCESS:FILLING TIME IS LONG	3	
01/16/07 11:54	CHANGED FROM AUTO/SA MODE TO MAN/MT-SET MODE	3	
01/16/07 11:54	CHANGED FROM MAN/MT-SET MODE TO AUTO/SA MODE	3	

LIST

TEMP

CLAMP

INJECT

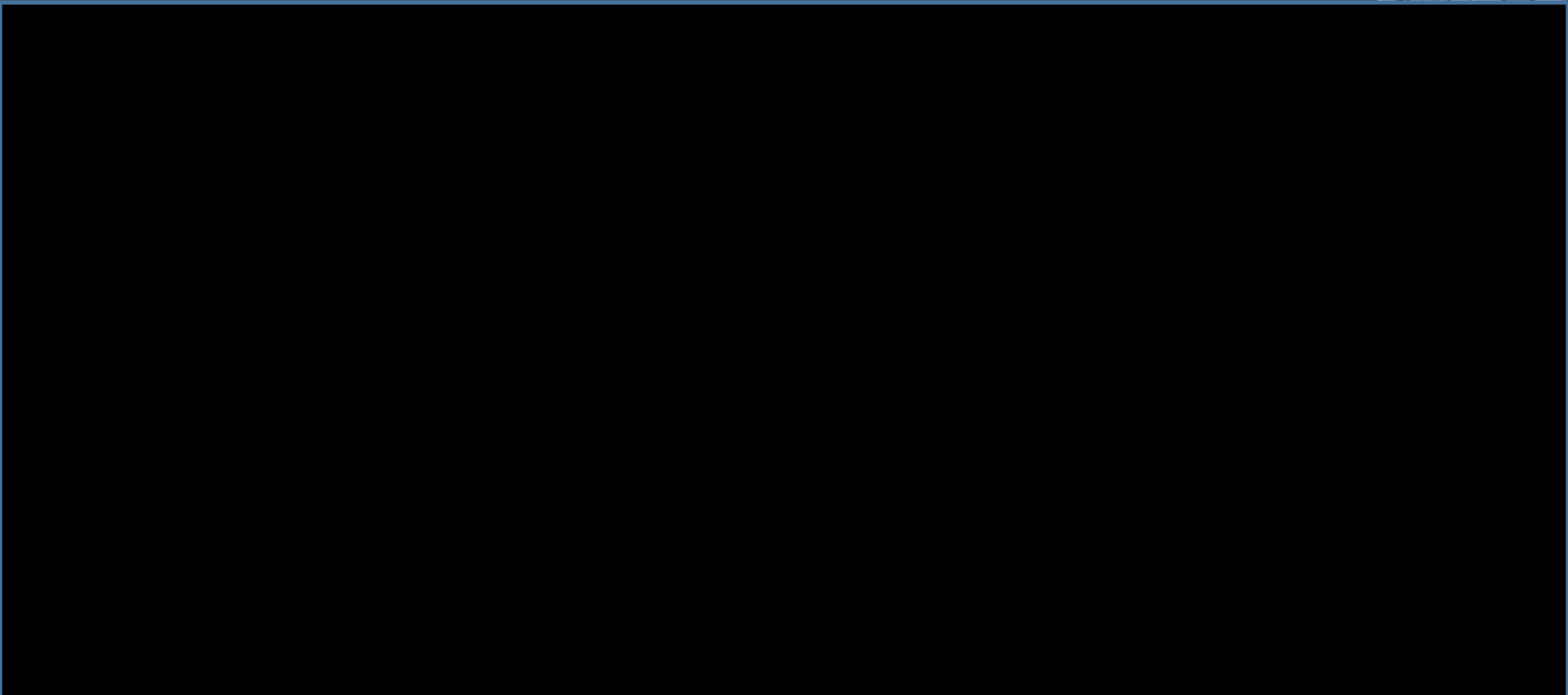
PROD

9999

MON

OPTION

REC



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

MONITOR:THROAT TEMPERATURE

MEMORY 003

ALTER

RUN

01/16/07 11:56

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

LIST

TEMP

9000

INJ PRS
SET - ACT

0

100

INJ SPD
SET - ACT

CHARGE

0

CLAMP

INJECT

PROD

MON

OPTION

REC

OPT

→

TEMP

°F

CLAMP

INJECT

PROD

MON

OPTION

REC

OPT

→

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

MONITOR:THROAT TEMPERATURE MEMORY 003 ALTER RUN 01/16/07 12:00

ACT VAL / MONITOR / MON TABLE / PROD / HISTORY / PROFILE / MAINT / CALCLATR

TRQ MONITOR
CHG

ACT 21.8 %
MAX 24.8 %
MIN 18.6 %
AVG 21.4 %

DELAY
0.20
S

REC
13.00
S

☐ X006 ☐ X007 ☐ X008 ☐ X009
☐ X00A ☐ X00B ☐ X010 ☐ X018
☐ X001 ☐ Y302 ☐ Y040 ☐ X022

☐ = ON ☐ = OFF

SEQ MON

REGISTER No.
P01F

TIMER/COUNT
03000

SET MON

RESET

SPEC
CLAMP INJ

MAINT
DISPLAY

VERSION
DISPLAY

LIST
CLAMP
PROD 9999
OPTION


TEMP
INJECT
MON
REC



Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/16/07 10:55

MAINTENANCE

CHECK THE RED ITEMS.(AND ALSO CHECK ALL ITEMS IN THE INSTRUCTION MANUAL.)

150h INSPECT

HEATER

700h INSPECT

SAFE DEVICE

POWER SUPPLY

ELEC WIRING

LUBRICATION

2000hINSPECT

TIMING BELT

4000hINSPECT

COOLING FANS

CONFIR-MATION

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/16/07 10:58

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

TRQ MONITOR CLMP

DELAY

0.20

S

REC

3.00

S

ACT

0.0

%

MAX

0.0

%

MIN

0.0

%

AVG

0.0

%

X006

X007

X008

X009

X00A

X00B

X010

X018

X001

Y302

Y040

X022

= ON

= OFF

SEQ MON

<

>

REGISTER No.

P01F

TIMER/COUNT

03000

SET

MON

RESET

SPEC

CLAMP

INJ

MAINT

DISPLAY

VERSION

DISPLAY

CLAMP

EJECT

MLD PROT

EJE MON

LS 31A

10.0

LS 31

45.0

mm

VE 1

100.0

VE 2

300.0

mm/s

LS 2D

320.0

LS 2E

50.0

LS 2A

15.0

LS 2

2.05

mm

VC 1

90

VC 2

99

VC 3

80

VC S

25.0

PCL

28.0

%

PCH

220

tf

EJC COUNTS

HOLD

CLOSE

340.0

mm

CLAMP

0

tf

2

VO 1

65

VO S1

40.0

%

LS 3D

10.0

LS 3A

5.0

mm

S 30

75.0

LS 100

0.0

mm

TRQ MONITOR

OFF

INJ

CHG

CLMP

EJE

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

MONITOR:THROAT TEMPERATURE

MEMORY 003ALTERRUN01/16/0712:00

ACT VAL / MONITOR / MON TABLE / PROD / HISTORY / PROFILE / MAINT / CALCLATR

TRQ MONITOR CHG

ACT21.8%
MAX24.8%
MIN18.6%
AVG21.4%

DELAY0.20
REC13.00

☐X006☐X007☐X008☐X009

☐X00A☐X00B☐X010☐X018

☐X001☐Y302☐Y040☐X022

☐=ON☐=OFF

SEQ MON<>

REGISTER No. P01F

TIMER/COUNT 03000

SETMONRESET

SPEC

CLAMPINJ

MAINT

DISPLAY

VERSION

DISPLAY

LISTTEMP

CLAMPINJECT

PROD9999MON

OPTIONRECOPT



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/16/07 10:58

ACT VAL / MONITOR / MON TABLE / PROD / HISTORY / PROFILE / MAINT / CALCLATR

TRQ MONITOR CLMP

ACT 0.0 %
MAX 0.0 %
MIN 0.0 %
AVG 0.0 %

DELAY 0.20 s
REC 3.00 s

X006 X007 X008 X009
X00A X00B X010 X018
X001 Y302 Y040 X022

REGISTER No. P01F
TIMER/COUNT 03000
SET MON
RESET

SPEC
CLAMP INJ
MAINT
DISPLAY
VERSION
DISPLAY

SEQ MON

< >

CLAMP EJECT MLD PROT EJE MON

LS 31A 10.0
VE 1 100.0

LS 31 45.0
VE 2 300.0

mm

mm/s

LS 2D 320.0
VC 1 90

LS 2E 50.0
VC 2 99

LS 2A 15.0
VC 3 80

VC S 25.0

PCL 28.0 %

LS 2 2.05 mm
PCH 220 tf

CLAMP

EJC COUNTS CLOSE

ADDRESS Y024 CLR ENT

X Y R L T C S E A
8 9 A B C D E F G
0 1 2 3 4 5 6 7 H

LIST TEMP
CLAMP INJECT
PROD MON
9999
OPTION REC

SHORTCUT TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/16/07 10:54

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCULATR

TRQ MONITOR CLMP

DELAY 0.20

☐ X005 ☐ X006 ☐ X007 ☐ X008
☐ X009 ☐ X00A ☒ X00B ☐ X010

REGISTER No. P01F

SPEC

CLAMP

INJ

LIST

TEMP

CLAMP

INJECT

PROD 9999

MON

OPTION

REC

CLAMP SPECIFICATIONS

ITEM	UNIT	DIMENSIONS AND VALUES
CLAMPING FORCE	tf	2157
DISTANS BETWEEN TIE RODS (HxV)	mm	610.0×560.0
PLATEN DIMENSIONS (HxV)	mm	870.0×820.0
CLAMP STROKE	mm	520.0
OPEN DAYLIGHT (Max.)	mm	1090.0
COLSED DAYLIGHT (MIN.MOLD)	mm	250.0~570.0
MINIMUM MOLD DIMENSIONS (HxV)	mm	360.0×335.0
EJECTION FORCE	tf	5.0
EJECTOR STROKE	mm	130.0

28.1 mm

VR 300.0 mm/s

LS 32 28.2 mm

EJECT SET CLAMP SET-LAP SEQ

70.0 90 99 65 40.0 %

LS 3 340.0 LS 3B 320.0 LS 3E 300.0 LS 3D 10.0 LS 3A 5.0 mm

LS 30 75.0 LS 100 0.0 mm

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

M.T.SETTING IS NOT FINISHED (1/2) MEMORY 000 ALTER RUN 04/24/06 15:47

ACT VAL / MONITOR / MON TABLE / PROD / HISTORY / PROFILE / MAINT / CALCLATR

TRQ MONITOR OFF

DELAY 0.00

☐ X000 ☐ X001 ☐ X002 ☐ X003
☐ X004 ☐ X005 ☒ X006 ☒ X007

REGISTER No. P000

SPEC

CLAMP

INJ

INJECTION SPECIFICATIONS

ITEM	UNIT	DIMENSIONS AND VALUES
INJECTION UNIT CODE		i2
BARREL CODE		B
SCREW DIAMETER	in	1.41
INJECTION VOLUME CALCULATED	in3	130
INJECTION PRESSURE	PSI	22922
HOLDING PRESSURE	PSI	22922
INJECTION RATE (Max.)	in3/s	280
INJECTION SPEED	in/s	10.82
MAXIMUM SCREW SPEED	min-1	350

VH D 0.00 in/s

LS 4 0.125

LS 4D 0.300

LS 4C 0.500

LS 4B 2.000

LS 4A 3.000

LS 5 4.000

LS 10 0.250 in

SCREW POS
5.039 in

LIST

TEMP °F

CLAMP

INJECT

PROD 9999

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

M.T.SETTING IS NOT FINISHED (1/2) MEMORY 000 ALTER RUN 04/24/06 15:46

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

TRQ MONITOR OFF

DELAY 0.00

ACT 0.0 %

MAX 0.0 %

MIN 0.0 %

AVG 0.0 %

REC 0.00

SEQ MON

<

>

REGISTER No. P000

TIMER/COUNT 00000

SET

MON

RESET

SPEC

CLAMP

INJ

MAINT

DISPLAY

VERSION

DISPLAY

☐ X000

☐ X001

☐ X002

☐ X003

☐ X004

☐ X005

☒ X006

☒ X007

☒ X008

☒ X009

☒ X00A

☐ X00B

☐ = ON

☒ = OFF

HEATROL

H N

H 1

H 2

H 3

32.0

32.0

32.0

32.0

***.*

***.*

***.*

***.*

0

0

0

0

INJECTROL

SPRUE BK

CONTINUE

TRH 3

TRH 2

TRH 1

0.75

0.75

0.75

s

PH 4

PH 3

PH 2

PH 1

3000

5000

7000

10000

VH 1

VI 5

5.00

0.50

VH D

LS 4

0.00

0.125

in/s

SCREW POS

5.039 in

VERSION DISPLAY

PRINT BOARD

NAME

VERSION No.

V5CU

B-04A-A

V5CI

A-01C-A

V5PC

A-01B-A

V5PA

A-01A-A

V5SV-1

A-04A-A

V5SS-1

A-02B-A

V5SV-2

V5SS-2

V5SV-3

V5SS-3

V5SV-4

V5SS-4

HMAIA

04-00

HMAIAOS

02-00 512M

V5CU

A-03A-A

PRINT BOARD

NAME

VERSION No.

V5TEMP-1

00102

V5TEMP-2

V5TEMP-3

V5TEMP-4

V5TEMP-5

V5TEMP-6

V5TEMP-7

V5TEMP-8

V5TEMP-9

V5TEMP-10

V5TEMP-11

V5TEMP-12

V5TEMP-13

V5TEMP-14

V5TEMP-15

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

9999

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

01/16/07 10:58

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

LIST

TEMP

10MPa→psi

1450.3

7

8

9

C

AC

4

5

6

×

÷

1

2

3

+

-

0

.

√

ANS

=

CLAMP

INJECT

PROD

MON

OPTION

REC

OPT

↩

UNIT CONVERS

kN

↔

tf

lbs

↔

kg

MPa

↔

kgf

↔

psi

°C

↔

°F

mm

↔

in

g

↔

oz

CLAMP

EJECT

MLD PROT

EJE MON

LS 31A
10.0

LS 31
45.0

mm

VE 1
100.0

VE 2
300.0

mm/s

EJC COUNTS

1 · HOLD

EJECT MODE

OFF · A · B

EJECT POS

28.1

mm

VR

300.0

mm/s

LS 32
28.2

mm

EJECT SET

CLAMP SET · LAP SEQ

LS 2D
320.0

LS 2E
50.0

LS 2A
15.0

LS 2
2.05

mm

VC 1
90

VC 2
99

VC 3
80

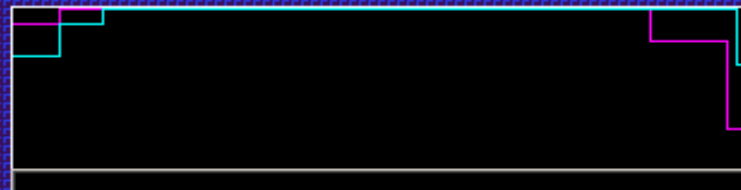
VC S
25.0

PCL
28.0

PCH
220

tf

CLOSE



CLAMP



OPEN

PLATEN POS

340.0

mm

CLAMP

0

tf

VO S2
70.0

VO 3
90

VO 2
99

VO 1
65

VO S1
40.0

%

LS 3
340.0

LS 3B
320.0

LS 3E
300.0

LS 3D
10.0

LS 3A
5.0

mm

LS 30
75.0

LS 100
0.0

mm

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

SUP-PORT



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

THE TEMPERATURE SCREENS

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

M.T.SETTING IS NOT FINISHED
COLD START PREVENTION IS WORKING

MEMORY 000 ALTER RUN 04/24/06 14:53
OFFILE MAINT CALCLATR

	H N	H 1	H 2	H 3	THROAT
ACT °F	999.9	999.9	999.9	999.9	999.9
DEV °F	***	***	***	***	
ON RATIO %	0	0	0	0	
INJECTION	0.00 s	SCREW POS	5.039 in	CLAMP	0 tf
COOL	0.00 s	PLATEN POS	10.00 in	INJ/BP PRESS	87 PSI
INTERVAL	0.00 s	EJECT POS	0.00 in	SCREW SPEED	0 min-1

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

BARREL BR PID

	H N	H 1	H 2	H 3	THROAT
SET °F	32.0	32.0	32.0	32.0	
TC BREAK					
ACT °F	999.9	999.9	999.9	999.9	999.9
DEV °F	***	***	***	***	
ON RATIO %	0	0	0	0	
TOL °F±	0.0	0.0	0.0	0.0	
ALARM SELECT	OFF	OFF	OFF	OFF	

SHIFT MODE CONDITION

OFF

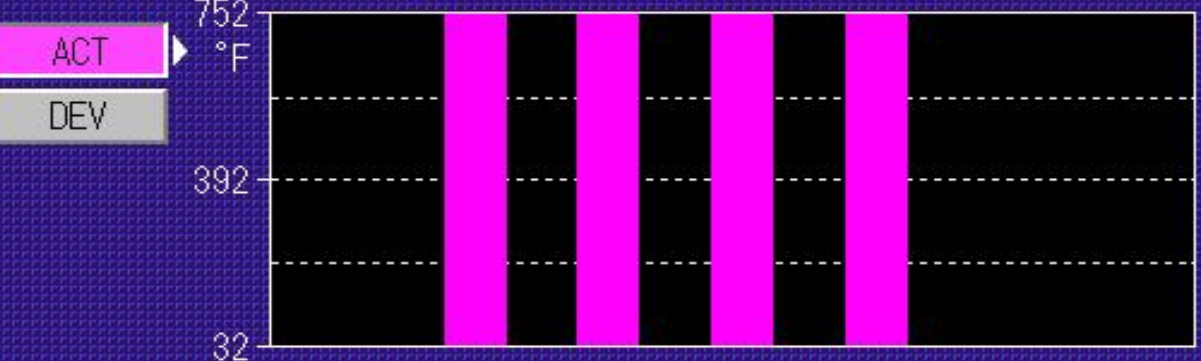
TIME REMAIN 0hr 0min

COLD PREVENT

REMAIN 0 min

HEAT-UP

OFF



ACT
SET

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

BARREL PRD CODE MEMORY 000 ALTER RUN 05/03/06 11:24

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

ACT °F
DEV °F
ON RATIO %

H N	H 1	H 2	H 3
464.7	485.0	474.8	464.9
-0.3	0.1	-0.2	-0.1
26	8	10	25

THROAT

79.1

INJECTION

0.00

s

SCREW POS

0.352

in

CLAMP

0

tf

COOL

0.00

s

PLATEN POS

10.00

in

INJ/BP PRESS

229

PSI

INTERVAL

0.00

s

EJECT POS

1.09

in

SCREW SPEED

0

min-1

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

BARREL BR PID

SET °F

TC BREAK

ACT °F

DEV °F

ON RATIO %

TOL °F±

ALARM SELECT

H N	H 1	H 2	H 3	THROAT
465.0	485.0	475.0	465.0	
465.0	485.0	474.8	464.9	79.1
0.1	0.1	-0.2	-0.1	
19	10	10	25	
0.0	0.0	0.0	0.0	
OFF	OFF	OFF	OFF	

SHIFT MODE CONDITION

OFF

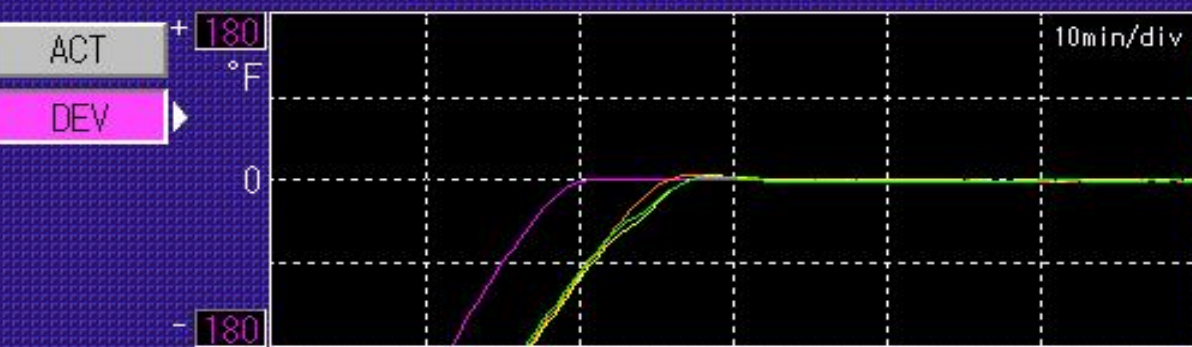
TIME REMAIN 0hr 0min

COLD PREVENT

CMPL

HEAT-UP

ON



H N

H 1

H 2

H 3

DISP. SET

SHORTCUT TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

BARREL PRD CODE MEMORY 000 ALTER RUN 05/03/06 11:23

ACT VAL MONIT

ACT °F
DEV °F
ON RATIO %
INJECTION 0.0
COOL 0.0
INTERVAL 0.0

BARREL BR P

SET °F
TC BREAK
ACT °F
DEV °F
ON RATIO %
TOL °F±
ALARM SELECT

ACT +180 °F
DEV

DISP. SET

DISPLAY ITEM	VIRT ±°F	HORIZ min/div
<input checked="" type="checkbox"/> H 3	<input type="radio"/> 18	<input type="radio"/> 5
<input type="radio"/> H N	<input type="radio"/> 36	<input checked="" type="radio"/> 10
<input checked="" type="checkbox"/> H 1	<input type="radio"/> 90	<input type="radio"/> 20
<input checked="" type="checkbox"/> H 2	<input checked="" type="radio"/> 180	<input type="radio"/> 30

465.0	485.0	475.0	465.0
465.0 0.1	485.0 0.1	474.9 0.0	464.7 -0.3
19	7	1	25
0.0	0.0	0.0	0.0
OFF	OFF	OFF	OFF



SHIFT MODE CONDITION

OFF

TIME REMAIN
0hr 0min

COLD PREVENT

CMPL

HEAT-UP

ON

DISP. SET

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 12/14/06 15:51

ACT VAL	MONITOR	MON TABLE	
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s
447	16.12 *	8998 *	3.59 *
448	16.39 *	7053 *	3.62 *
449	16.43 *	7337 *	15.46 *
450	17.15 *	6399 *	3.59 *

FILL TIME CHARGE TIME MIN-
1.37 s 14.70 s

BARREL BR PID

SET °F

TC BREAK

ACT °F

DEV °F

ON RATIO %

TOL °F±

ALARM SELECT

H N
440.0

H 1
470.0

H 2
460.0

H 3
450.0

THROAT
156.5

431.2
-8.8

469.2
-0.8

459.8
-0.1

448.8
-1.1

0

0

0

0

5.0

5.0

5.0

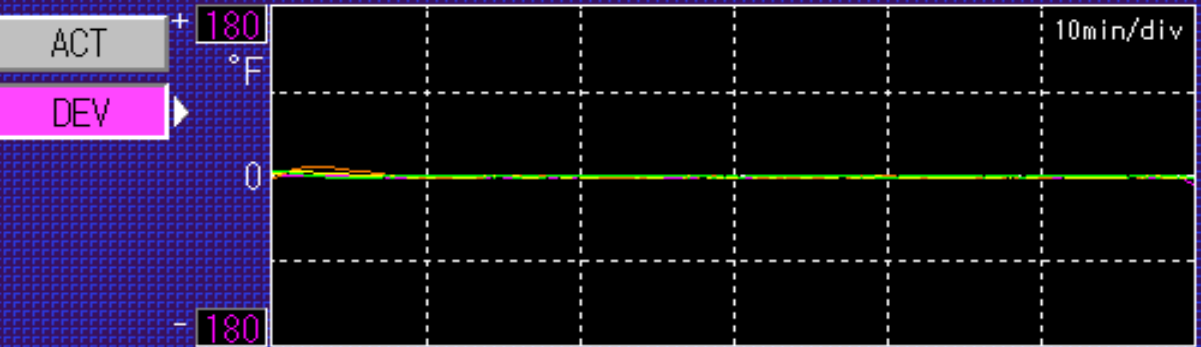
5.0

OFF

OFF

OFF

OFF



SHIFT MODE CONDITION

SHIFT MODE
OFF · ON · CMPL

SHIFT TIME
059h30m

MODE SELECT
MINUS TEMP

SHIFT TEMP
-300.0 °F

ABSOLUTE TEMP

200.0 °F

SHIFT MODE CONDITION

OFF

TIME REMAIN
59 hr 30 min

COLD PREVENT

REMAIN 0 min

HEAT-UP

ON

LIST

TEMP

CLAMP

INJECT

PROD 9999

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

DIAG MESSG

1

DISP. SET

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

BARREL TITLE mystery mold MEMORY 003 ALTER RUN 12/14/06 15:53

ACT VAL	MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR	
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
447	16.12 *	6996 *	3.59 *	34.65 *	2.65 *	2.65 *	7280 *	2.13 *
448	16.39 *	7053 *	3.62 *	34.63 *	2.72 *	2.72 *	7309 *	2.13 *
449	16.43 *	7337 *	15.46 *	11.89 *	3.20 *	3.20 *	7337 *	2.13 *
450	17.15 *	6399 *	3.59 *	34.62 *	1.60 *	1.60 *	7010 *	2.13 *
FILL TIME		CHARGE TIME		MIN-CUSH		ACT-CUSH		FPC PRESS
1.37 s		14.70 s		0.00 mm		0.00 mm		90 PSI
						INJ START		0.07 mm

BARREL

BR PID

SET °F

TC BREAK

ACT °F

DEV °F

ON RATIO %

TOL °F±

ALARM SELECT

H N

440.0

H 1

470.0

H 2

460.0

H 3

450.0

THROAT

157.1

418.2

466.8

458.6

443.1

-21.7

-3.1

-1.4

-6.9

0

0

0

0

5.0

5.0

5.0

5.0

ON

ON

OFF

OFF

ACT

DEV

+ 180

°F

0

- 180

10min/div

H N

H 1

H 2

H 3

SHIFT MODE

CONDITION

OFF

TIME REMAIN

59hr 30min

COLD PREVENT

OFF

HEAT-UP

ON

DISP. SET

LIST

CLAMP

PROD

9999

OPTION

TEMP

INJECT

MON

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT


DIAG MESSG

1

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING
EMERGENCY STOP ON

 MEMORY 001 ALTER RUN 05/09/08 09:52

OFFILE MAINT CALCATR

		H N	H 1	H 2	H 3		THROAT
ACT °F		73.2	73.7	73.2	72.5		71.4
DEV °F		-**.*	-**.*	-**.*	-**.*		
ON RATIO %		0	0	0	0		

INJECTION	0.00	s	SCREW POS	0.576	in	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	10.00	in	INJ/BP PRESS	317	PSI
INTERVAL	0.00	s	EJECT POS	1.09	in	SCREW SPEED	0	min-1

BARREL BR PID

H N H 1 H 2 H 3

SET PID

FORMAT	P °F	18.0	27.0	21.6	21.6
	I s	120	180	160	160
	D s	30	45	40	40

TUNING SEL

AUTO	OFF · ON	OFF · ON	OFF · ON	OFF · ON
SELF	CMPL	CMPL	CMPL	CMPL

AUTO: REPEATS SET TEMP. ON/OFF CONTROL & FINDS PID.
SELF: FINDS PID IN HEATING.

FF CONTROL

LIST TEMP

CLAMP INJECT

PROD MON

OPTION REC

SHORTCUT TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

EMERGENCY STOP 0

MEMORY 001

ALTER

RUN

05/09/06 10:00

FF CONTROL

RATIO FF AMOUNT AUT

EXEC STOP

H 1H 2H 3

RUN ON RATIO %0.00.00.0

STOP ON RATIO %0.00.00.0

RAT. FF AMOUNT%20.020.020.0

FF CONTROL SELONONON

?

ACT °F

DEV °F

ON RATIO %

INJECTION 0

COOL 0

INTERVAL 0

BARREL BR

SET PID

FORMAT P °F

18.027.021.621.6

I s

120180160160

D s

30454040

TUNING SEL

AUTO

SELF

OFF · ONCMPL

OFF · ONCMPL

OFF · ONCMPL

OFF · ONCMPL

AUTO: REPEATS SET TEMP. ON/OFF CONTROL & FINDS PID.

SELF: FINDS PID IN HEATING.

FF CONTROL

LIST

TEMP °F

CLAMP

INJECT

PROD 9999

MON

OPTION OPT

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

OPERATION MODE IS SET TO MAN OR MOLD SET-UP (1/2) MEMORY 012 ALTER RUN 03/07/13 12:42

ACT VAL		MONITOR		MON TABLE		PROD		HISTORY		PROFILE		MAINT		CALCLATR		LIST		TEMP	
TRQ MONITOR EJE		DELAY 0.01		<input type="checkbox"/> X001 <input type="checkbox"/> XD4B <input type="checkbox"/> XD4C <input type="checkbox"/> G802		REGISTER No. P001		SPEC		CLAMP		INJ		CLAMP		INJECT			
ACT 0.0 %		sec		<input type="checkbox"/> G803 <input type="checkbox"/> G804 <input type="checkbox"/> G805 <input type="checkbox"/> G806		TIMER/COUNT 00100		MAINTENANCE		DISPLAY		PROD		MON					
MAX -0.4 %		REC 6.00		<input type="checkbox"/> G807 <input type="checkbox"/> G15D <input type="checkbox"/> G15B <input type="checkbox"/> G15C		SET MON		VERSION		DISPLAY		9999		REC					
MIN -1.0 %				<input type="checkbox"/> = ON <input type="checkbox"/> = OFF		RESET													
AVG -0.8 %		sec		SEQ MON		< >													

BARREL BR PID

	H N	H 1	H 2	H 3	THROAT
SET PID					
FORMAT P °F	18.0	18.0	18.0	18.0	18.0
I s	80	180	140	140	140
D s	20	45	30	35	0

TUNING SEL					
AUTO	OFF • ON	OFF • ON	OFF • ON	OFF • ON	OFF • ON
SELF	CMPL	CMPL	CMPL	CMPL	CMPL
AUTO: REPEATS SET TEMP. ON/OFF CONTROL & FINDS PID. SELF: FINDS PID IN HEATING.					

RESIN DEGRADE PREVENTION				MON. TIME		PURGE COUNT		FF CONTROL	
DEGRADE PREV. TEMP CONTROL				1 min		1		SIM HEATING SETTING	
OFF				MON. TIME 1 min		PURGE COUNT 1			

SHORTCUT TOOL

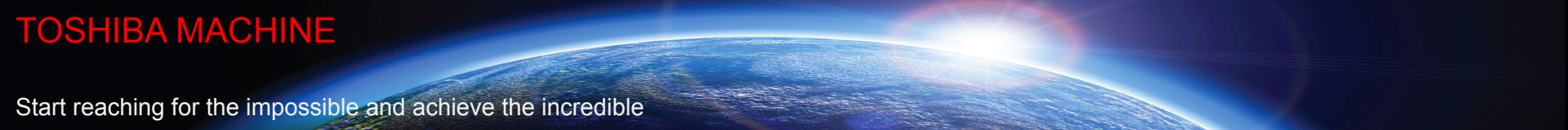
SNAP SHOT

MESSAGE LADDER

SUP-PORT

RATION EQUIPME

LAN-GUAGE



TOSHIBA MACHINE

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THE CLAMP SCREENS

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

PARAMETER MODE (2/2) MEMORY 004 ALTER RUN 01/21/13 12:20

ACT VAL		MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR
		H N	H 1	H 2	H 3	THROAT		
ACT	°F	69.9	70.3	69.8	69.6	69.8		
DEV	°F	-**.*	-**.*	-**.*	-**.*	-90.2		
ON RATIO	%	0	0	0	0	0		
INJECTION	0.00	sec	SCREW POS	1.20	mm	CLAMP	0.0	tf
COOL	0.00	sec	PLATEN POS	370.0	mm	INJ/BP PRESS	389	PSI
INTERVAL	0.00	sec	EJECT POS	29.96	mm	SCREW SPEED	0	rpm

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

CLAMP EJECT MLD PROT EJE MON CORE 1 CLAMP PRESTROL

LAP SEQUENCE

OFF

INJ. DELAY

INJDLY

0.000

sec

LOCKUP DELAY

LOCKUPDL

0.001

sec

LOCKUP SPEED

LOCKUP

600.0

mm/s

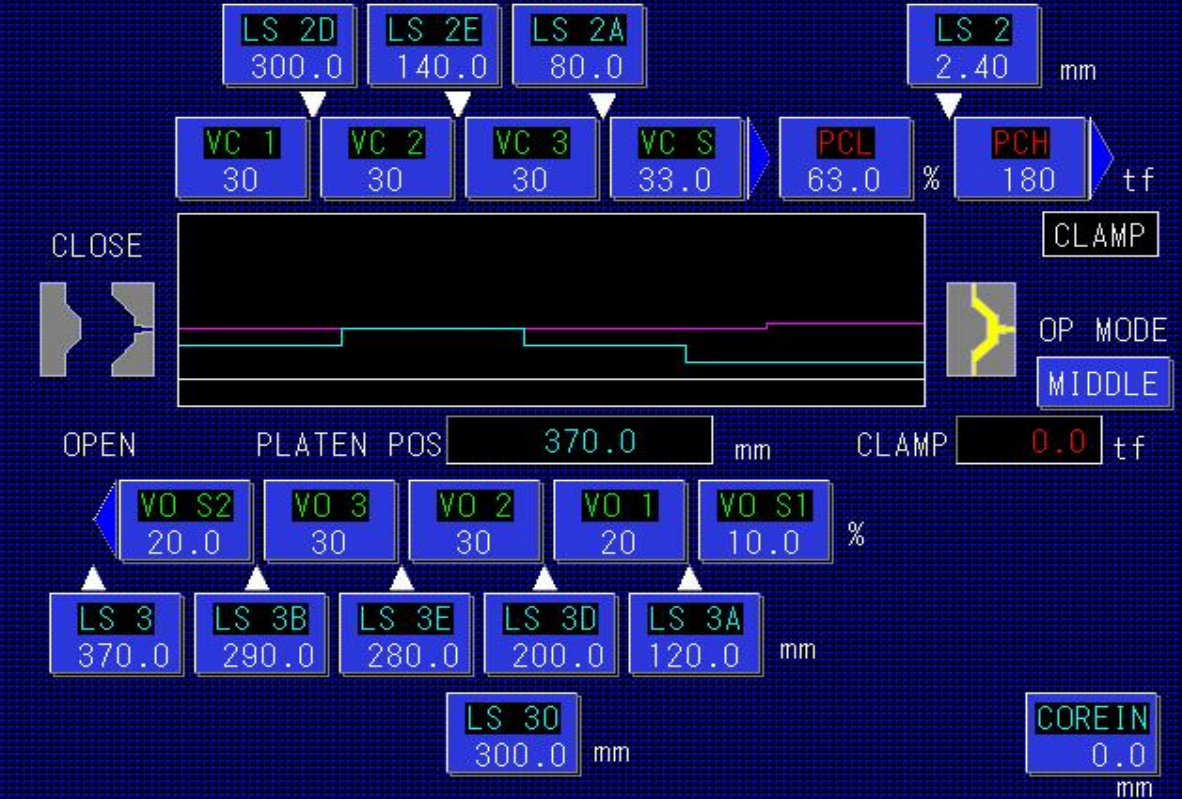
CLMP AUT ADJ

ON

MLD ADJ IN PRG

OFF

LOCK UP



SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

LAN-GUAGE

EJECT SET
CLAMP SET • LAP SEQ

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

PARAMETER MODE (2/2) MEMORY 004 ALTER RUN 01/21/13 12:20

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

			H N	H 1	H 2	H 3		THROAT
ACT	°F		69.9	70.3	69.8	69.6		69.8
DEV	°F		***.	***.	***.	***.		-90.2
ON RATIO	%		0	0	0	0		0

INJECTION	0.00	sec	SCREW POS	1.20	mm	CLAMP	0.0	tf
COOL	0.00	sec	PLATEN POS	370.0	mm	INJ/BP PRESS	389	PSI
INTERVAL	0.00	sec	EJECT POS	29.96	mm	SCREW SPEED	0	rpm

CLAMP EJECT MLD PROT EJE MON CORE 1 CLAMP PRESTROL

LAP SEQUENCE OFF

INJ. DELAY INJDLY 0.000 sec

LOCKUP DELAY LOCKUPDL 0.001 sec

LOCKUP SPEED LOCKUP 600.0 mm/s

CLMP AUT ADJ ON

MLD ADJ IN PRG LOCK UP OFF

EJECT SET CLAMP SET • LAP SEQ

LS 2D 300.0 LS 2E 140.0 LS 2A 80.0 LS 2 2.40 mm

VC 1 30 VC 2 30 VC 3 30 VC S 33.0 PCL 63.0 % PCH 180 tf

CLOSE

OPEN PLATEN POS 370.0 mm CLAMP 0.0 tf

VO S2 20.0 VO 3 30 VO 2 30 VO 1 20 VO S1 10.0 %

LS 3 370.0 LS 3B 290.0 LS 3E 280.0 LS 3D 200.0 LS 3A 120.0 mm

LS 30 300.0 mm

COREIN 0.0 mm

SHORTCUT TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

RATION EQUIPME

LAN-GUAGE

Start reaching for the impossible and achieve the incredible

PARAMETER MODE

(2/2) MEMORY 004

ALTER




RUN

01/21/13

12:20

ACT VAL	MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR	LIST	TEMP
---------	---------	-----------	------	---------	---------	-------	----------	------	------

		H N	H 1	H 2	H 3	THROAT
ACT	°F	69.9	70.3	69.8	69.6	69.8
DEV	°F	-**.*	-**.*	-**.*	-**.*	-90.2
ON RATIO	%	0	0	0	0	0

INJECTION	0.00	sec	SCREW POS	1.20	mm	CLAMP	0.0	tf	9999	
COOL	0.00	sec	PLATEN POS	370.0	mm	INJ/BP PRESS	389	PSI	OPTION	REC
INTERVAL	0.00	sec	EJECT POS	29.96	mm	SCREW SPEED	0	rpm		

CLAMP EJECT MLD PROT EJE MON CORE 1 CLAMP PRESTROL

The screenshot displays the MACH2 CNC control interface with the following elements:

- Left Panel (Parameters):**
 - LAP SEQUENCE: OFF
 - INJ. DELAY: INJDLY 0.000 sec
 - LOCKUP DELAY: LOCKUPDL 0.001 sec
 - LOCKUP SPEED: LOCKUP 600.0 mm/s
 - CLMP AUT ADJ: ON
 - MLD ADJ IN PRG LOCK UP: OFF
 - EJECT SET: CLAMP SET • LAP SEQ
- Top Center (Positioning Data):**
 - LS 2D: 300.0
 - LS 2E: 140.0
 - LS 2A: 80.0
 - LS 2: 2.40 mm
- Top Right (Clamp Data):**
 - VC 1: 30
 - VC 2: 30
 - VC 3: 30
 - VC S: 33.0
 - PCL: 63.0 %
 - PCH: 180 tf
- Center (Graphical Display):**
 - Labels: CLOSE, OPEN, PLATEN POS, CLAMP
 - Graph: A plot showing a step function with multiple levels, likely representing a sequence of operations or positions.
 - OP MODE: MIDDLE
- Bottom Center (Positioning Data):**
 - VO S2: 20.0
 - VO 3: 30
 - VO 2: 30
 - VO 1: 20
 - VO S1: 10.0 %
 - LS 3: 370.0
 - LS 3B: 290.0
 - LS 3E: 280.0
 - LS 3D: 200.0
 - LS 3A: 120.0 mm
 - LS 30: 300.0 mm
- Bottom Right (Clamp Data):**
 - CLAMP: 0.0 tf
 - COREIN: 0.0 mm
- Right Panel (Tools and Settings):**
 - SHORTCUT
 - TOOL
 - SNAP SHOT
 - MESSAGE
 - LADDER
 - SUP-PORT
 - VSD EX
 - RATION EQUIPME
 - LAN-GUAGE

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

PARAMETER MODE

(2/2) MEMORY 004

ALTER

RUN

01/21/13 12:20

ACT VAL		MONITOR		MON TABLE		PROD		HISTORY		PROFILE		MAINT		CALCLATR	
		H N		H 1		H 2		H 3				THROAT			
ACT °F		69.9		70.3		69.8		69.6				69.8			
DEV °F		-**.*		-**.*		-**.*		-**.*				-90.2			
ON RATIO %		0		0		0		0				0			
INJECTION		0.00	sec	SCREW POS		1.20	mm			CLAMP		0.0	tf		
COOL		0.00	sec	PLATEN POS		370.0	mm			INJ/BP PRESS		389	PSI		
INTERVAL		0.00	sec	EJECT POS		29.96	mm			SCREW SPEED		0	rpm		

LIST	TEMP
CLAMP	INJECT
PROD	MON
9999	
OPTION	REC

CLAMP	EJECT	MLD PROT	EJE MON	CORE 1	CLAMP	PRESTROL
-------	-------	----------	---------	--------	-------	----------

LAP SEQUENCE

OFF

INJ. DELAY

INJDLY

0.000

sec

LOCKUP DELAY

LOCKUPDL

0.001

sec

LOCKUP SPEED

LOCKUP

600.0

mm/s

CLMP AUT ADJ

ON

MLD ADJ IN PRG


LOCK UP

OFF


EJECT SET

CLAMP SET•LAP SEQ

CLOSE



OPEN



PLATEN POS

370.0

mm

CLAMP

0.0

tf

LS 2D

300.0

LS 2E

140.0

LS 2A

80.0

LS 2

2.40

mm

VC 1

30

VC 2

30

VC 3

30

VC S

33.0

PCL

63.0

%

PCH

180

tf

VO S2

20.0

VO 3

30

VO 2

30

VO 1

20

VO S1

10.0

%

LS 3

370.0

LS 3B

290.0

LS 3E

280.0

LS 3D

200.0

LS 3A

120.0

mm

LS 30

300.0

mm

COREIN

0.0

mm

SHORTCUT

TOOL

SNAP SHOT



MESSAGE



LADDER



SUP-PORT



RATION EQUIPME



LAN-GUAGE



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

(2/2) MEMORY 000

ALTER

RUN

04/24/06 14:55

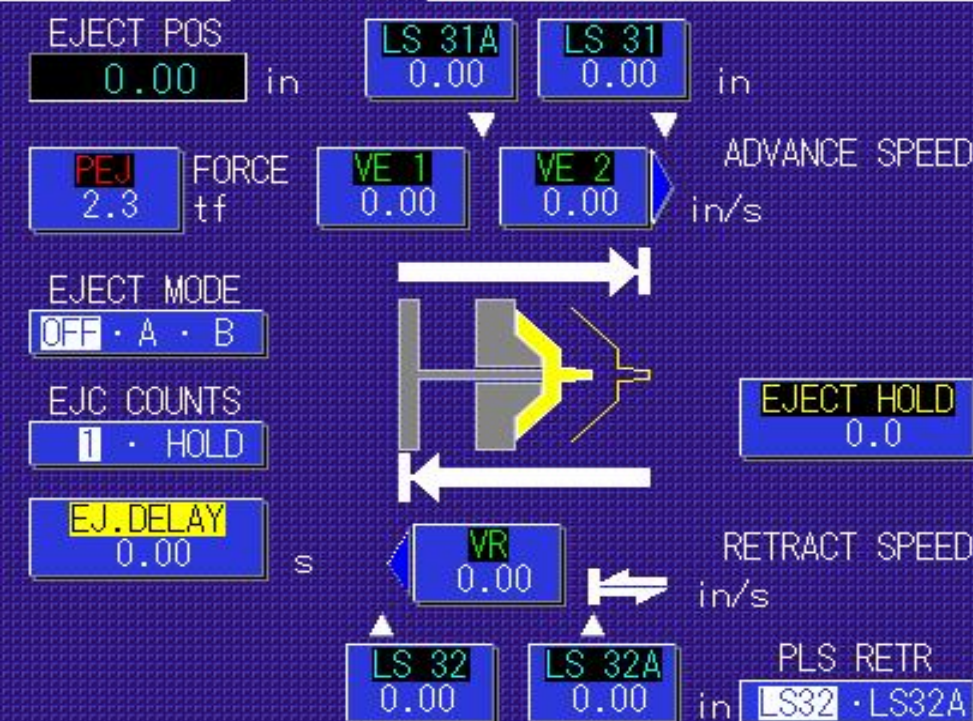
ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALC LTR

	H N	H 1	H 2	H 3
ACT °F	999.9	999.9	999.9	999.9
DEV °F	***	***	***	***
ON RATIO %	0	0	0	0

THROAT
999.9

INJECTION	0.00	s	SCREW POS	5.039	in	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	10.00	in	INJ/BP PRESS	87	PSI
INTERVAL	0.00	s	EJECT POS	0.00	in	SCREW SPEED	0	min-1

CLAMP EJECT MLD PROT EJE MON



Return positions and speed

LIST TEMP

CLAMP INJECT

PROD MON

OPTION REC

SHORTCUT TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

01/22/07 14:25

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

	H N	H 1	H 2	H 3
ACT °F	73.5	73.4	73.5	73.9
DEV °F	-**.*	-**.*	-**.*	-**.*
ON RATIO %	0	0	0	0

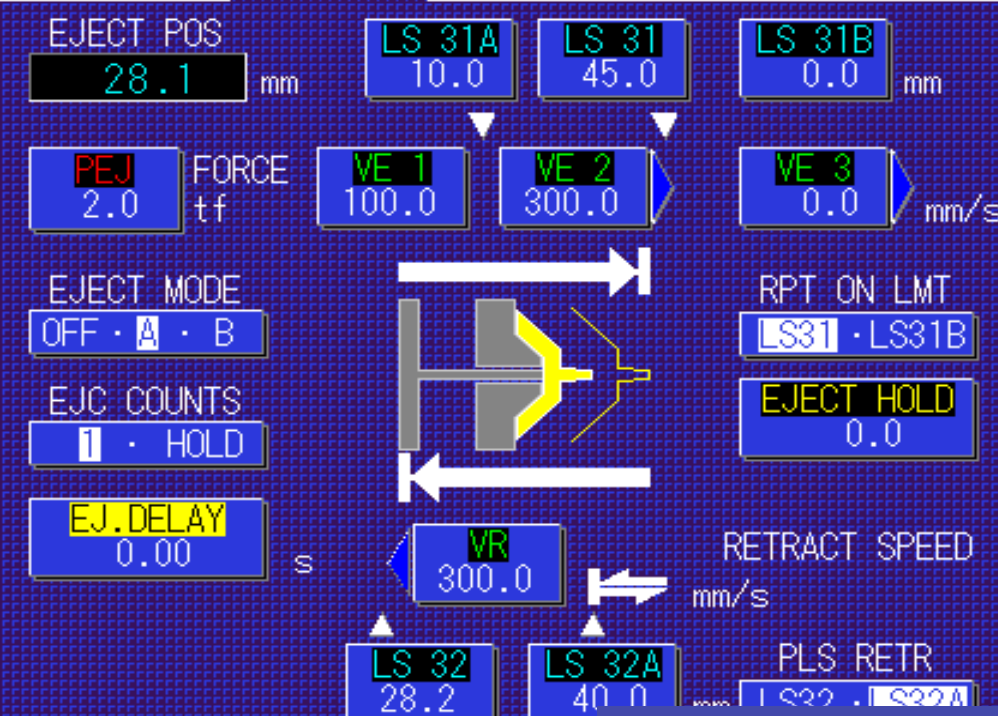
THROAT

74.3

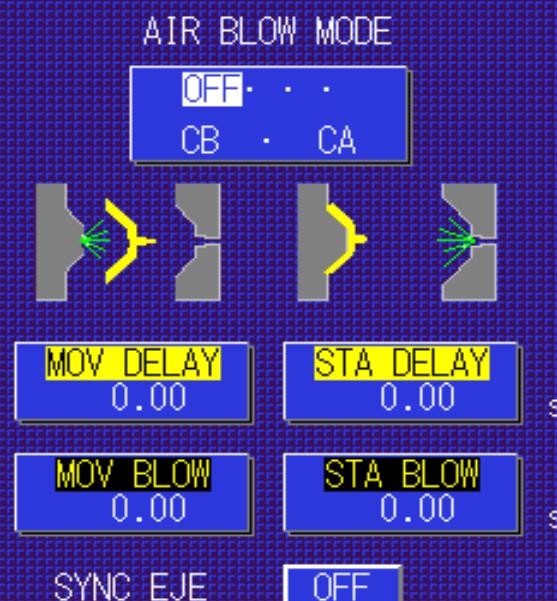
INJECTION	0.00	s	SCREW POS	0.00	mm
COOL	0.00	s	PLATEN POS	340.0	mm
INTERVAL	0.00	s	EJECT POS	28.1	mm

CLAMP	0	tf
INJ/BP PRESS	0	PSI
SCREW SPEED	0	rpm

CLAMP EJECT MLD PROT EJE MON



Pulse retract feature



LIST

TEMP °F

CLAMP

INJECT

PROD 9999

MON

OPTION

REC

SHORTCUT

TOOL



SNAP SHOT



MESSAGE



LADDER

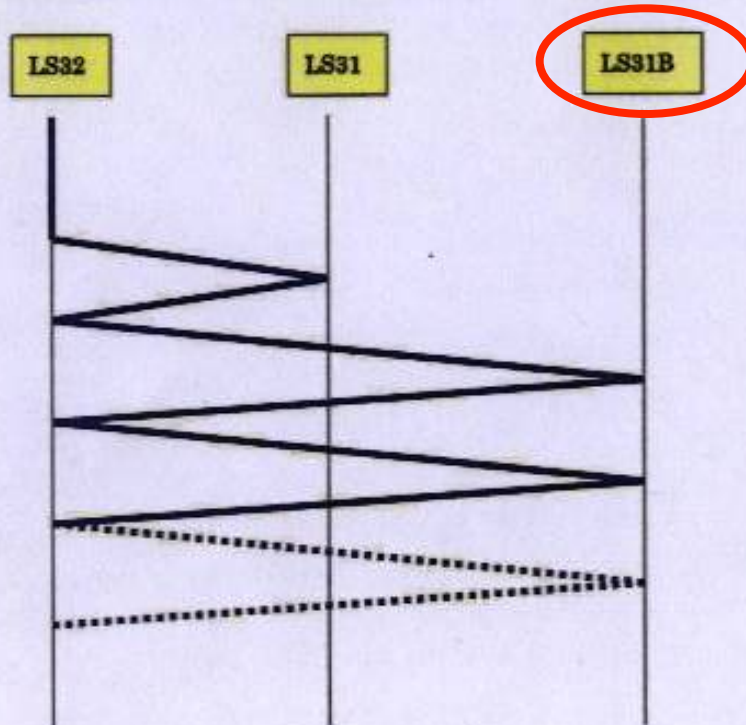


SUP-PORT

Information for 2 Steps Eject IN Limit Control System

Information for 2 steps eject IN limit control system on the EC (ECN) machine is follows.

1. Contents of movement for 2 steps IN limit control system



LS32 : Eject Retract Limit

LS31 : Eject IN Limit

LS31B : 2 Steps Eject IN Limit
(Parameter# 51 : [101] → [111])

If we use 2 steps IN limit control system for EC(N)
Machine, Movement is as left flow drawing.

(Example)

If Eject count are 4 times, First eject movement
Advance until LS31 on (This is a our normal).
And advance until 31B from second eject to fourth
Eject.

Start reaching for the impossible and achieve the incredible

EJECT TITLE test save MEMORY 001 NO ALTR RUN 07/01/02 12:43

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

ACT °C
DEV °C
ON RATIO %

INJECTION	0.00	s	SCREW POS	*****	in	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	*****	in	INJ/BP PRESS	3341	PSI
INTERVAL	0.00	s	EJECT POS	*****	in	SCREW SPEED	0	min-1

CLAMP EJECT MLD PROT



AIR BLOW MODE

OFF · · ·
CB · CA

MOV DELAY 0.00 STA DELAY 0.00 s

MOV BLOW 0.00 STA BLOW 0.00 s

SYNC EJE OFF

LIST TEMP
CLAMP INJECT
PROD MON
9999
OPTION REC

SHORTCUT
TOOL

SNAP SHOT
MESSAGE LADDER
SUP-PORT

DIAG MESSG
6

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

MLD PROT TITLE frisby MEMORY 001 ALTER RUN 05/09/08 12:00

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

MD CLOSE

LOCK UP

INJECT

CHARGE

COOLING

MD OPEN

EJECT

INT

FILL2.00s

CHARGE10.77s

CYCLE33.54s

INJ

CHG

CLMP

EJE

0%

0%

0%

0%

MIN-CUSH0.591in

FPC PRESS1018PSI

INJ PEAK1369PSI

CLAMP EJECT MLD PROT EJE MON

LIST

TEMP

CLAMP

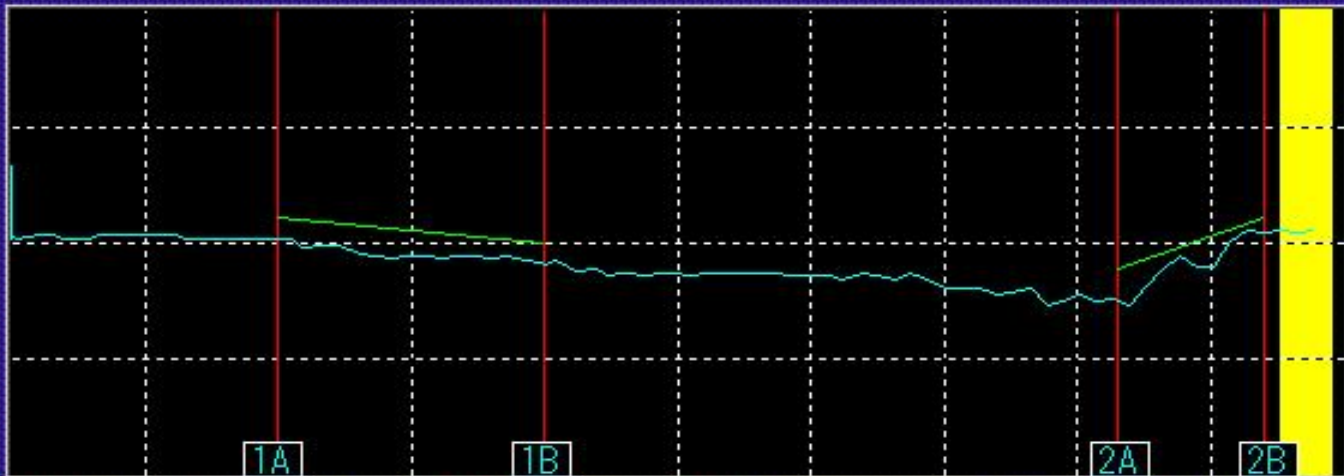
INJECT

PROD9999

MON

OPTION

REC



1

CLAMPtf

0

SET

ACT

-1

10.00

PLATEN POS

9.80

in

5.00

PCL AREA

0.26

s

0.0

in

MON. ZONE1

OFF

MD1A

8.00

MD1B

6.00

in

P1A

0.1

P1B

0.0

tf

MDAST

1

STOP ALARM

DET. MODE

TORQUE

TIME

MON. ZONE2

OFF

MD2A

1.70

MD2B

0.60

in

P2A

-0.1

P2B

0.1

tf

MDAS2

1

SHOT

TORQUE

DET. TIME

PCL

10.0

%

TRDET

0.30

s

OVERLAP

OFF

GRAPH

STOP

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 12/14/06 11:16

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

		H N	H 1	H 2	H 3		THROAT
ACT	°F	80.4	80.6	79.8	77.9		76.6
DEV	°F	-.*. *	-.*. *	-.*. *	-.*. *		
ON RATIO %		0	0	0	0		

INJECTION

COOL

INTERVAL

0.00

s

SCREW POS

0.00

mm

CLAMP

0

tf

INJ/BP PRESS

20

PSI

PLATEN POS

340.0

mm

EJECT POS

28.1

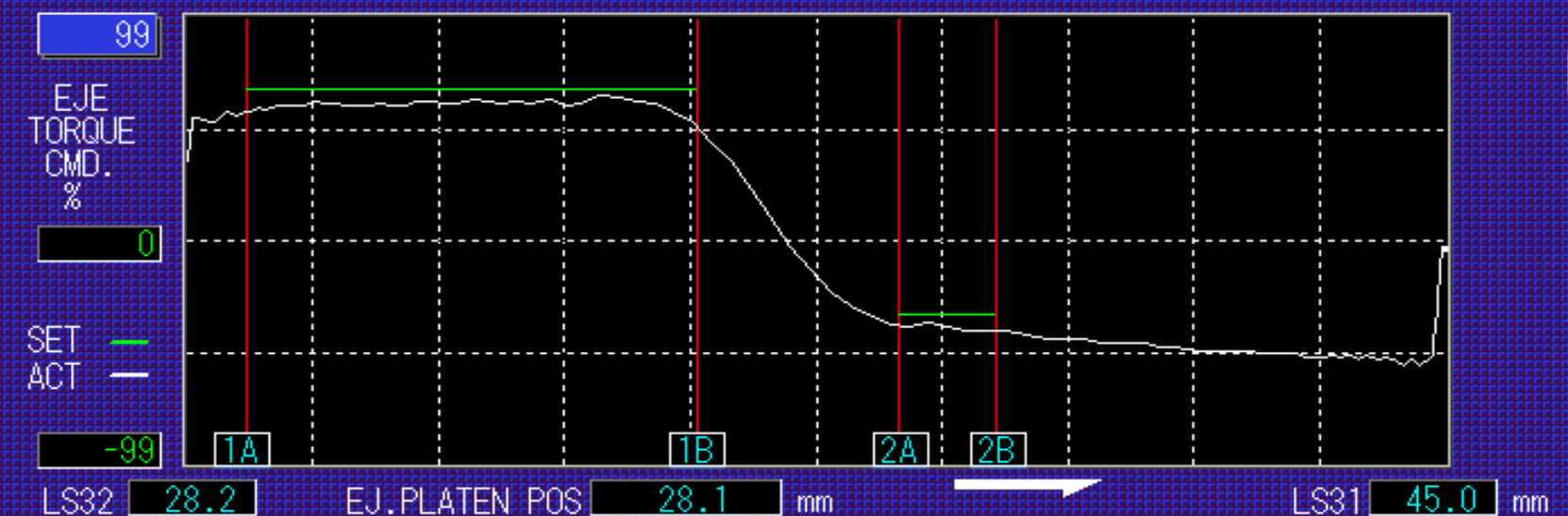
mm

SCREW SPEED

0

rpm

CLAMP EJECT MLD PROT EJE MON



MON. ZONE1

OFF

EJ1A

29.0

mm

EJ1B

35.0

mm

EJT1

68.0

%

EJAS1

3

SHOT

GRAPH STOP

MON. ZONE2

OFF

EJ2A

37.7

mm

EJ2B

39.0

mm

EJT2

-32.0

%

EJAS2

5

SHOT

OVERLAP

OFF

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 013 ALTER RUN 03/06/13 11:14

ACT VAL		MONITOR		MON TABLE		PROD		HISTORY		PROFILE		MAINT		CALCLATR									
shots		FILL		CHARGE		INJ START		CYCLE TIME		CUSH		MIN-CUSH		FPC PRESS		TAKEOUT							
		s		s		in		s		in		in		PSI		s							
22509		1.68		6.28		2.379		25.47		0.207		0.207		9518		8.97							
22510		1.68		6.41		2.379		25.43		0.197		0.197		8859		8.92							
22511		1.68		6.65		2.379		25.43		0.186		0.186		8190		8.93							
FILL TIME		CHARGE TIME		MIN-CUSH		ACT-CUSH		FPC PRESS		INJ START													
2.86		s		1.56		s		0.244		in		0.244		in		8190		PSI		2.467		in	

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

CLAMP EJECT MLD PROT EJE MON CORE 1 CLAMP

GATE CUT

OFF

IN LIMIT

0.000

in

IN DELAY

0.00

s

ON TIME

0.00

s

IN SPEED

0.00

in/s

RET SPEED

0.00

in/s

IN FORCE

0.0

tf

OUT FORCE

0.0

tf

MOLD OPENING STOP

OFF

STOP POS.

0.000

in

STOP TIME

0.0

s

SHORTCUT

TOOL

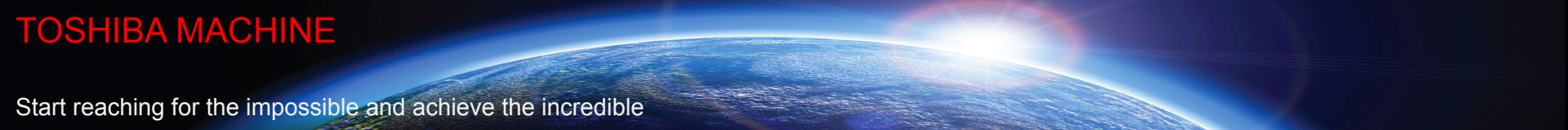
SNAP SHOT

MESSAGE

LADDER

SUP-PORT

LAN-GUAGE



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

THE INJECTION SCREENS

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

PARAMETER MODE (2/2) MEMORY 004 ALTER RUN 01/21/13 12:24

ACT VAL		MONITOR		MON TABLE		PROD		HISTORY		PROFILE		MAINT		CALCLATR	
		H N		H 1		H 2		H 3		THROAT					
ACT	°F	69.9		70.1		69.9		69.6		69.6					
DEV	°F	-***.*		-***.*		-***.*		-***.*		-90.4					
ON RATIO	%	0		0		0		0		0					
INJECTION		0.00	sec	SCREW POS		1.20	mm	CLAMP		0.0	tf				
COOL		0.00	sec	PLATEN POS		370.0	mm	INJ/BP PRESS		384	PSI				
INTERVAL		0.00	sec	EJECT POS		29.96	mm	SCREW SPEED		0	rpm				

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR AUTO AJD V.GATE1

SPRUE BK CONTINUE

SPEED STEP 3STEP

PRESS STEP 1STEP

INJ PRESS 389 PSI

CHG. DLY 0.0 s

SRN 0 rpm

TRH 3 0.00

TRH 2 0.00

TRH 1 0.00 s

PH 4 100

PH 3 100

PH 2 100

PH 1 100

PI 1 150

BACK PRESS 0 PSI

BPM 0 PSI

INJECT 0.00

COOL 0.00

INT 5.00

0.00 sec

SCREW POS 1.20 mm

VH 1 0.0

VI3 0.0

VI2 0.0

VI1 0.0

VSB 0.0 mm/s

VH D 0.0 mm/s

LS 4 0.00

LS 4B 11.00

LS 4A 29.00

LS 5 0.00

LS 10 0.00 mm

LS 10A 0.00 mm

LIST

TEMP °F

CLAMP

INJECT

PROD 9999

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

LAN-GUAGE

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING (1/2) MEMORY 004 ALTER RUN 01/21/13 12:24

ACT VAL		MONITOR		MON TABLE		PROD		HISTORY		PROFILE		MAINT		CALCLATR	
		H N		H 1		H 2		H 3				THROAT			
ACT	°F	69.9		70.1		69.8		69.4				69.6			
DEV	°F	-*.*		-*.*		-*.*		-*.*				-90.4			
ON RATIO	%	0		0		0		0				0			
INJECTION	0.00	sec	SCREW POS	1.20	mm	CLAMP	0.0	tf							
COOL	0.00	sec	PLATEN POS	370.0	mm	INJ/BP PRESS	381	PSI							
INTERVAL	0.00	sec	EJECT POS	29.96	mm	SCREW SPEED	0	rpm							

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR AUTO AJD V.GATE1

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

INJ FF CONTROL

OFF

VHI CONTROL

SPD OFF • PRESS OFF

INJECT

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FPC DECELERATION

OFF

FILL SPEED CONTROL

STD

PEAK CUT

ON

INJ PRESS RESPONSE

MIDDLE

CHG • BP

SCREW DECELERATION

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

NOZZLE

NOZZLE RET TIME

00.0s

PLASTROL

PRE. INJECTION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 1

OFF

SCREW INVERSION 2

OFF

BP AFTER CHARGE

HOLD

MANUAL BACK PRESS

ON • OPSI

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

LAN-GUAGE

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING (2/2) MEMORY 000 ALTER RUN 04/24/06 14:59

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

		H N	H 1	H 2	H 3	THROAT
ACT	°F	999.9	999.9	999.9	999.9	999.9
DEV	°F	**.*	**.*	**.*	**.*	
ON RATIO %		0	0	0	0	

INJECTION	0.00	s	SCREW POS	5.039	in	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	10.00	in	INJ/BP PRESS	87	PSI
INTERVAL	0.00	s	EJECT POS	0.00	in	SCREW SPEED	0	min-1

INJECT

INJ SET

INJ PRL

CHG PRL

AT PURGE

LAMINAR

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

FF CONTROL

OFF

VHI CONTROL

SPD OFF·PRESS OFF

NOZZLE

NOZZLE RET TIME

00.0s

INJECT

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FPC DECELERATION

OFF

FILL SPEED CONTROL

STD

PEAK CUT

OFF

INJ PRESS RESPONSE

MIDDLE

PLASTROL

PRE. INJECTION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 1

OFF

SCREW INVERSION 2

OFF

CHG·BP

SCREW DECELERATION

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

BP AFTER CHARGE

HOLD

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

ACT VAL
ACT
DEV
ON RATIO %
INJECTION
COOL
INTERVAL
INJECT

FIT CONTROL

FIT CONTROL

OFF

START POS

FIN POS

ALARM SELECT

REF SAMPLING

LS5+10

LS4

OFF

OFF · START · CMPL

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

FF CONTROL

OFF

VHI CONTROL

SPD OFF · PRESS OFF

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

INJECT

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FPC DECELERATION

OFF

PLASTROL

PRE. INJECTION

OFF

PRE. INJECTION 2

OFF

CHG · BP

FILL SPEED CONTROL

SLOP(MID)

SCREW DECELERATION

OFF

START POS

LS5+10

LS 4A

LS 4

TRH 1

TRH 2

TRH 3

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

DIAG MESSG

1

Start reaching for the impossible and achieve the incredible

ACT VAL
ACT
DEV
ON RATIO %
INJECTION
COOL
INTERVAL
INJECT

FIT CONTROL

FIT CONTROL

OFF

START POS

FIN POS

ALARM SELECT

REF SAMPLING

LS5+10

LS4

OFF

OFF · START · CMPL

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

FF CONTROL

OFF

VHI CONTROL

SPD OFF · PRESS OFF

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

INJECT

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FPC DECELERATION

OFF

PLASTROL

PRE. INJECTION

OFF

PRE. INJECTION 2

OFF

CHG·BP

FILL SPEED CONTROL

SLOP(MID)

SCREW DECELERATION

OFF

FIN POS

LS5+10

LS 4A

LS 4

TRH 1

TRH 2

TRH 3

LIST

CLAMP

PROD

9999

OPTION

OPT

TEMP

°F

INJECT

MON

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

DIAG MESSG

1

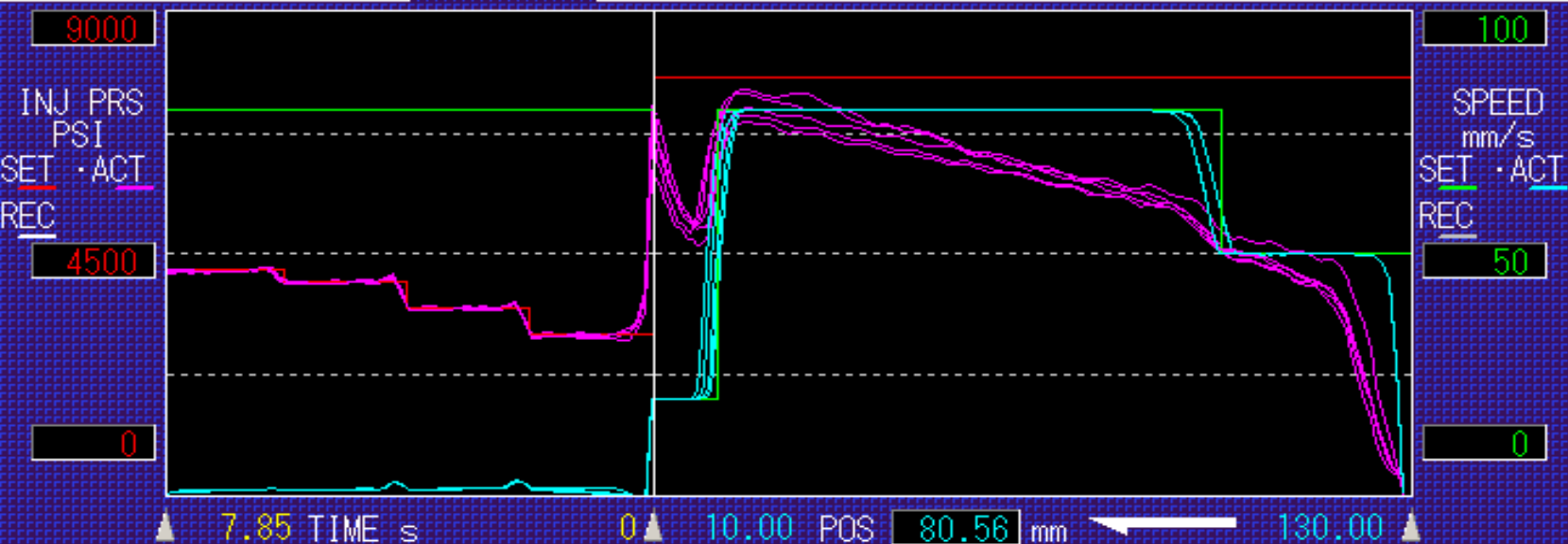
TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ PRFL TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 14:39

ACT VAL	MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR	
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
9	14.12	6726 *	3.46	34.51	2.24 *	2.24 *	7536 *	2.13 *
10	14.04	6697 *	3.46	34.51	2.28 *	2.28 *	7579 *	2.13 *
11	13.98	6683 *	3.46	34.52	2.18 *	2.18 *	7550 *	2.13 *
12	14.05	7181 *	0.00	46.11	2.79 *	2.79 *	7252 *	2.13 *
13	12.22 *	6071	3.47	34.51	9.52 *	9.52 *	7024 *	2.13 *
14	12.83 *	6797 *	3.47	34.52	8.03 *	8.03 *	7195 *	2.12 *
15	12.99 *	7266 *	3.46	34.52	6.86 *	6.86 *	7550 *	2.15 *

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



CURSOR DISPLAY MIN-CUSH 7.19 mm SHIFT POS 7006 PSI 9.54 mm INJ START 129.00 mm

SETUP DISPLAY HORIZON SELECT SCRW POS PROFILE OVERLAP ON ERASE PROFILE COLLECT COLLECT FINISH PRFL DRAW PRFL ERASE

LIST TEMP °F
CLAMP INJECT
PROD MON
9999
OPTION REC

SHORTCUT TOOL
SNAP SHOT
MESSAGE LADDER
SUP-PORT

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 002

ALTER

RUN

10/06/06 16:08

ACT VAL

ACT °F
DEV °F
ON RATIO %

INJECTION
COOL
INTERVAL

INJECT

MOLDING

FIT CONT

OFF

LAMINA

OFF

FF CONT

OFF

VHI CONTROL

SPD OFF · PRESS OFF

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

LAMINAR



【OPERATION METHOD】

- 1.RECORD FILLING SPEED PROFILE WHEN PRESSURE CONTROL USING REFERENCE VALUE COLLECTION.
CONVERT SPEED PROFILE INTO SPEED SETTING.
- 2.ENABLE LAMINA CONTROL.
- 3.SET SPEED ON LAMINAR SCREEN.

【EFFECT】

THIS DEVICE IS INTENDED TO REDUCE RESIDUAL STRESS,
IMPROVE TRANSFERABILITY AND SMOOTH LOW-PRESSURE MOLDING.



LAMINAR

OFF

REF SAMPL

OFF · START · CMPL



FPC DECELERATION

OFF

PLASTROL

PRE. INJECTION 1

OFF

SCREW INVERSION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 2

OFF

BP PROGRAM

OFF

BP AFTER CHARGE

HOLD

LIST



TEMP



CLAMP



INJECT



PROD



MON



OPTION



REC



SHORTCUT



TOOL



SNAP SHOT



MESSAGE



LADDER



SUP-PORT

DIAG MESSG

1



TOSHIBA MACHINE

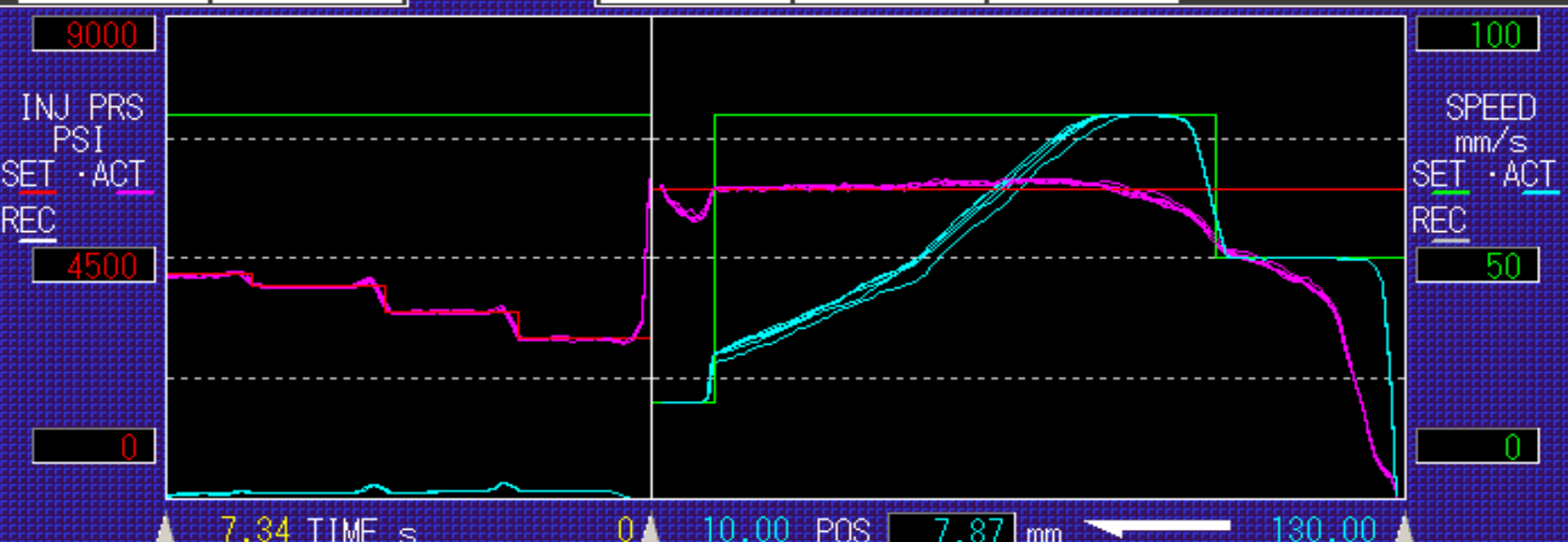
Start reaching for the impossible and achieve the incredible

INJ PRFL TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 14:25

ACT VAL		MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
506	14.15 *	6484 *	3.47 *	34.51 *	1.14 *	1.14 *	7479 *	2.16 *
507	13.82 *	6498 *	3.47 *	34.52 *	1.11 *	1.11 *	7678 *	2.13 *
508	13.90 *	5958 *	3.46 *	34.51 *	1.43 *	1.43 *	6015 *	2.70 *
509	13.92 *	5872 *	3.47 *	34.51 *	1.62 *	1.62 *	6015 *	2.76 *
510	14.01 *	5929 *	3.47 *	34.51 *	1.50 *	1.50 *	6029 *	2.69 *
511	14.08 *	5943 *	3.48 *	34.52 *	1.59 *	1.59 *	6029 *	2.67 *
512	14.14 *	6000 *	3.47 *	34.52 *	1.47 *	1.47 *	6043 *	2.65 *

LIST
TEMP
CLAMP
INJECT
PROD
MON
9999
REC
OPTION
OPT

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



SHORTCUT
TOOL
SNAP SHOT
MESSAGE
LADDER
SUP-PORT

CURSOR DISPLAY
SETUP DISPLAY
HORIZON SELECT
SCRW POS PROFILE
MIN-CUSH 1.47 mm
SHIFT POS 5996 PSI 9.99 mm
INJ START 129.00 mm
OVERLAP ON
ERASE
PROFILE COLECT
COLLECT FINISH
PRFL DRAW
PRFL ERASE

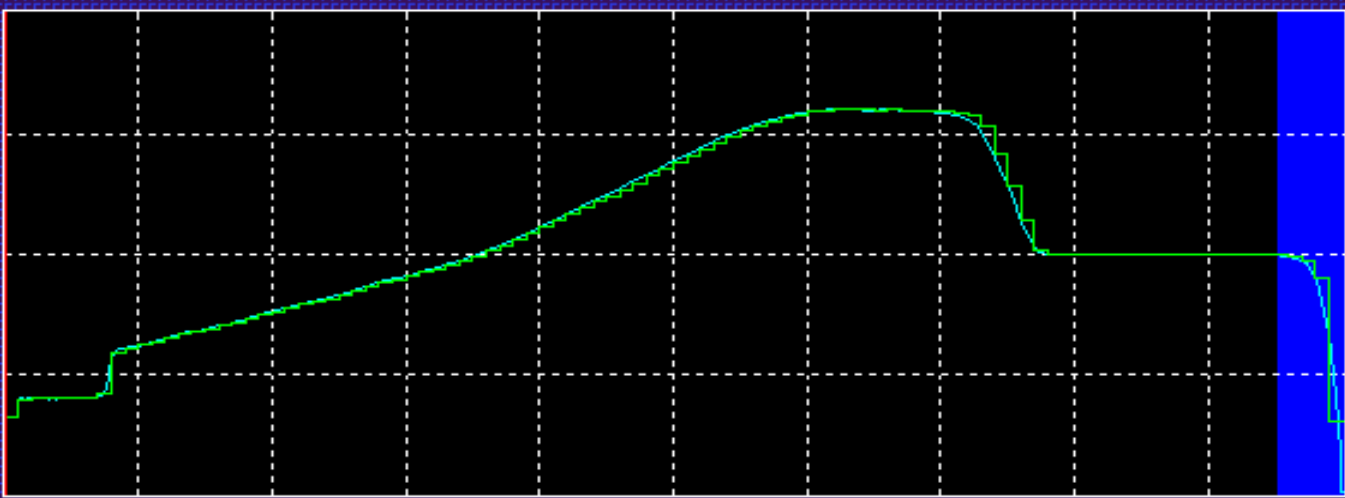
TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

LAMINAR TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 14:25

ACT VAL	MONITOR	MON	TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
507	13.82 *	6498 *	3.47 *	34.52 *	1.11 *	1.11 *	7678 *	2.13 *
508	13.90 *	5958 *	3.46 *	34.51 *	1.43 *	1.43 *	6015 *	2.70 *
509	13.92 *	5872 *	3.47 *	34.51 *	1.62 *	1.62 *	6015 *	2.76 *
510	14.01 *	5929 *	3.47 *	34.51 *	1.50 *	1.50 *	6029 *	2.69 *
511	14.08 *	5943 *	3.48 *	34.52 *	1.59 *	1.59 *	6029 *	2.67 *
512	14.14 *	6000 *	3.47 *	34.52 *	1.47 *	1.47 *	6043 *	2.65 *
513	14.20 *	5986 *	3.46 *	34.52 *	1.62 *	1.62 *	6043 *	2.66 *

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



100
INJ SPEED
mm/s
50
SET ACT

10.00 21.90 33.80 45.70 57.60 69.50 81.40 93.30 105.20 117.10 129.00 mm

LAMINAR ON

REF SAMPL

>

VI404 49.8

VI403 49.5

VI402 48.6

VI401 44.9

VI400 15.4

mm/s

VERTICAL SCALE

<

LS404 123.05

LS403 124.24

LS402 125.43

LS401 126.62

LS400 127.81

LS5+10 129.00

mm

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

OPT

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

LAMINAR FLOW CONTROL IS IN PROGRESS

MEMORY 003

ALTER

RUN

01/02/07 14:30

ACT VAL		MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
0	14.20 *	6114	3.46	34.51	1.87	1.87	6114	2.71
1	14.06	6157	3.47	34.51	2.00 *	2.00 *	6171	2.71
2	14.07	5958	3.47	34.51	1.90	1.90	6043	2.65
3	14.11	6185	3.47	34.51	2.17 *	2.17 *	6242	2.75 *
4	14.06	6128	3.46	34.51	2.09 *	2.09 *	6157	2.76 *
5	14.11	6157	3.47	34.52	2.12 *	2.12 *	6185	2.75 *
6	14.08	6228	3.47	34.51	2.24 *	2.24 *	6228	2.76 *

LIST

TEMP



CLAMP

INJECT



PROD

MON

9999



OPTION

REC



INJECT

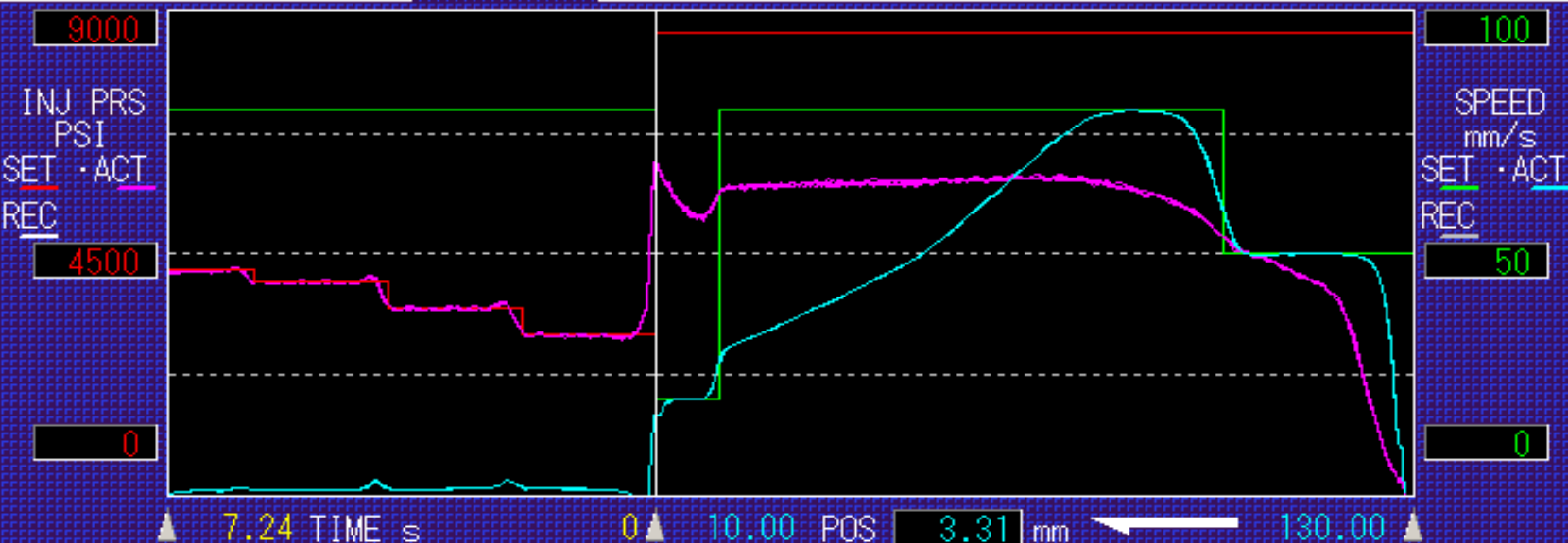
INJ SET

INJ PRFL

CHG PRFL

AT PURGE

LAMINAR



SHORTCUT

TOOL



SNAP SHOT



MESSAGE



LADDER



SUP-PORT

CURSOR
DISPLAY

MIN-CUSH 2.24 mm

SHIFT POS 6168 PSI
9.99 mm

INJ START 129.00 mm

SETUP
DISPLAY

HORIZON
SELECT

SCRW POS
PROFILE

OVERLAP
ON

ERASE

COLLECT
FINISH

PRFL
DRAW

PRFL
ERASE

PROFILE COLECT

Start reaching for the impossible and achieve the incredible

ACT VAL MO

INJ FF CONTROL

IMPROVES INJECTION SPEED STARTING AND ENDING RESPONSES.
USED WHEN QUICK STARTING RESPONSE OF INJECTION SPEED IS
NEEDED.
WHOLE INJECTION AREA:FF CONTROL IS CARRIED OUT IN WHOLE
INJECTION AREA.
1ST FILL SPEED: FF CONTROL IS CARRIED OUT AT START OF VI1.

☒ OFF
☐ WH INJ A
☐ 1ST FIL SP

ACT °F
DEV °F
ON RATIO %
INJECTION
COOL
INTERVAL

INJECT IN

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

FF CONTROL

OFF

VHI CONTROL

SPD OFF · PRESS OFF

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

FPC PRESS

LS4

FPC DECELERATION

OFF

INJ PRESS RESPONSE

MIDDLE

PLASTROL

PRE. INJECTION 1

OFF

SCREW INVERSION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 2

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

BP AFTER CHARGE

HOLD

LIST
TEMP
CLAMP
INJECT
PROD
MON
9999
OPTION
REC

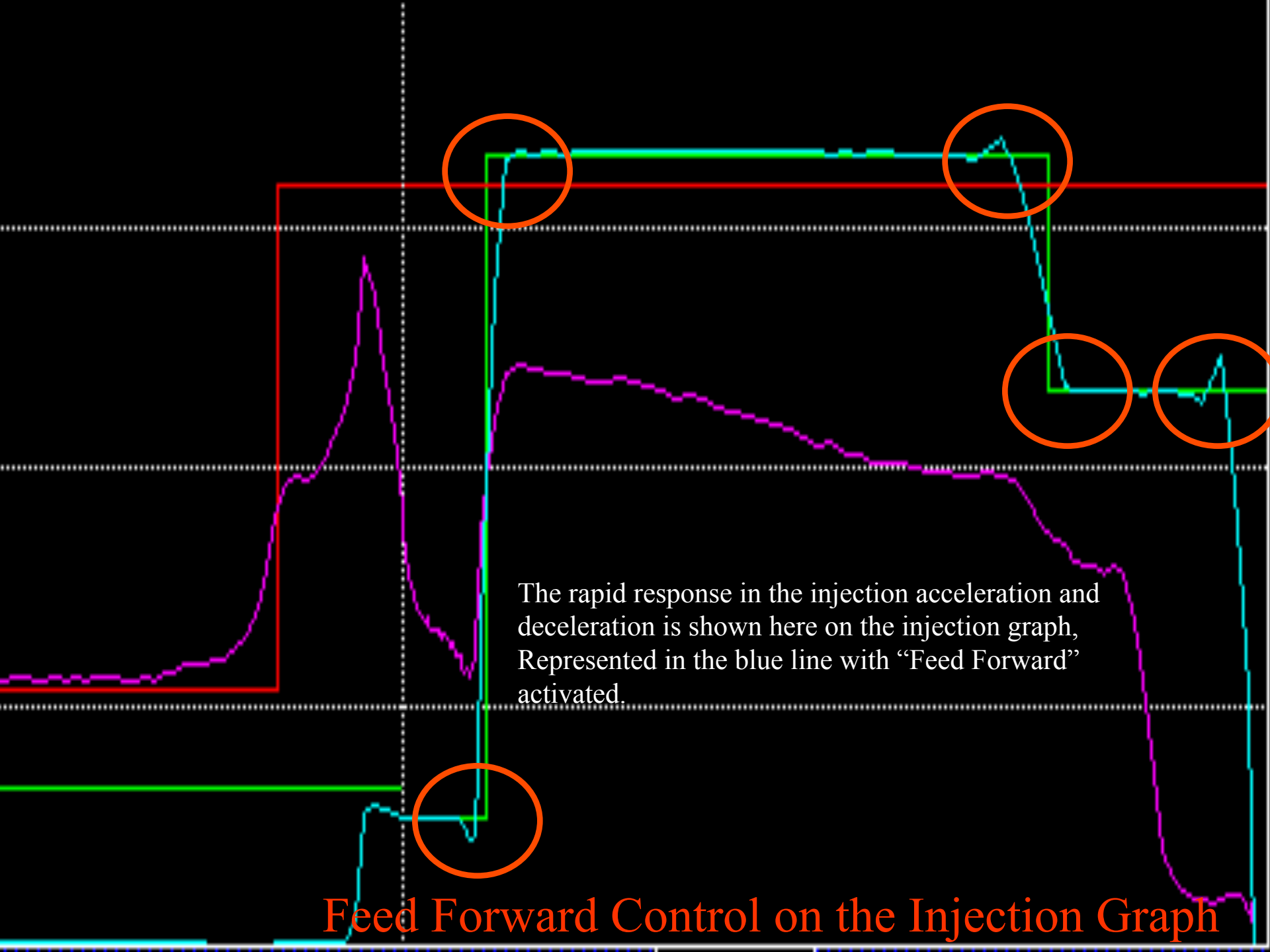
SHORTCUT
TOOL

SNAP
SHOT

MESSAGE
LADDER

SUP-
PORT

DIAG MESSG
1



Start reaching for the impossible and achieve the incredible

VHI CONTROL

【SPEED MODE】

VHI WILL CORRECT INJECTION SPEED AS INJECTION PRESSURE CHANGES.
THIS REGENERATES PHENOMENON OF HYDRAULIC TYPE MACHINE THAT HYDRAULIC
FLUID IS COMPRESSED BY ITS COMPRESSIBILITY AS INJECTION PRESSURE
RISES CAUSING INJECTION SPEED TO LOWER BELOW SET VALUE.

【PRESSURE MODE】

VHI WILL PROVIDE SMOOTH INJECTION PRESSURE CONTROL AS ATTAINED ON
THE HYDRAULIC TYPE MACHINE.
THE HYDRAULIC TYPE MACHINE USES RELIEF VALVE TO CONTROL HYDRAULIC
PRESSURE.
THE RELIEF VALVE HAS OVERRIDE CHARACTERISTIC TO CHANGE INJECTION
PRESSURE SMOOTH.
THIS CIRCUIT IS TO REGENERATE SUCH INJECTION PRESSURE CHARACTERISTIC.

【USAGE】

SELECT [ON] OF BOTH SPEED AND PRESS ON VHI WINDOW, TO OPERATE THE
MOTOR-DRIVEN MACHINE IN THE SIMILAR MANNER AS WITH THE HYDRAULIC TYPE
MACHINE.
SELECT [ON] OF PRESS ON VHI WINDOW, TO SMOOTH INJECTION PRESSURE
RESPONSE.

☐ SPEED

☐ PRESS

OFF OFF

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

SHORTCUT
TOOL

SNAP SHOT

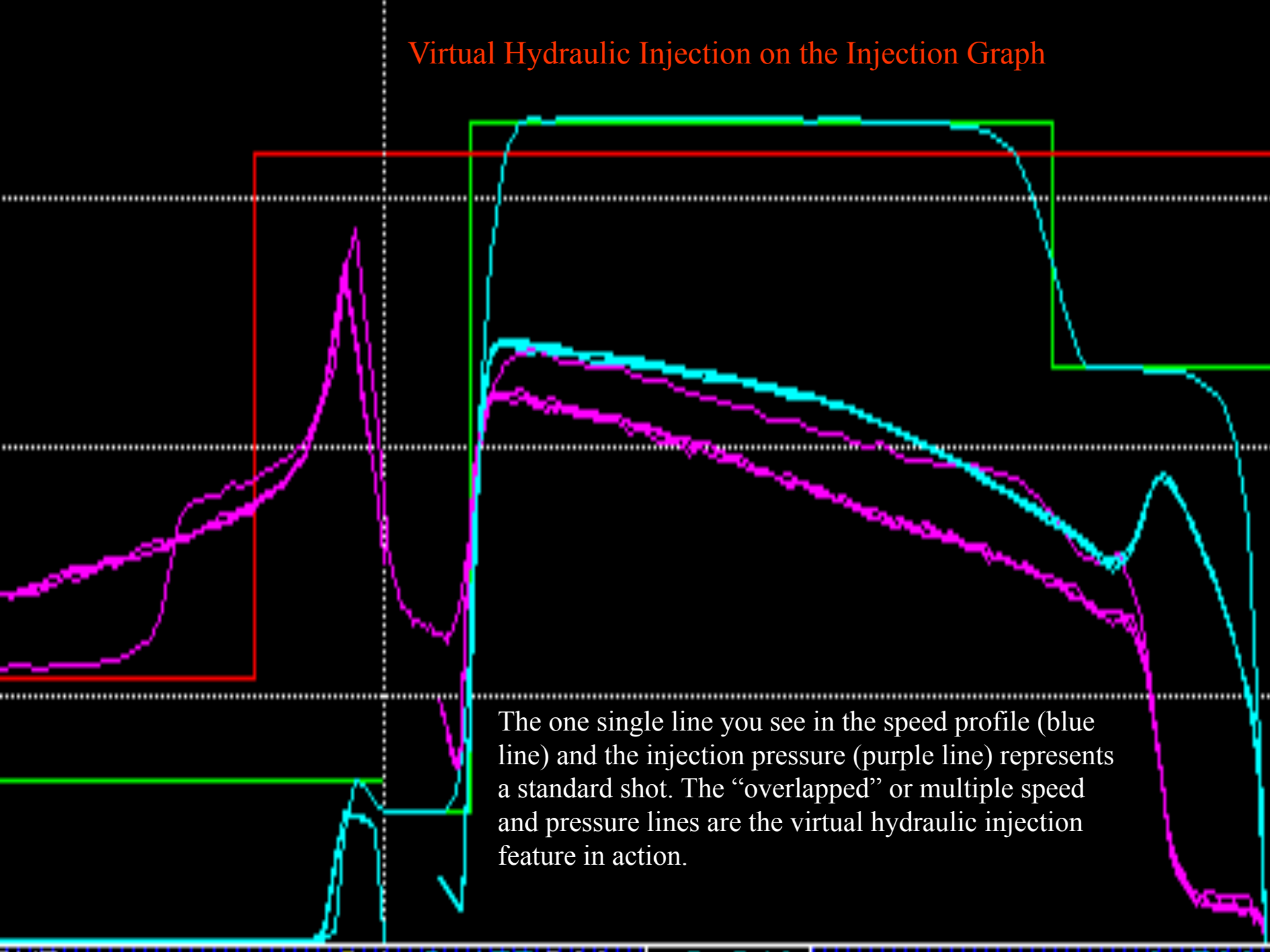
MESSAGE

LADDER

SUP-PORT

DIAG MESSG
1

Virtual Hydraulic Injection on the Injection Graph



The one single line you see in the speed profile (blue line) and the injection pressure (purple line) represents a standard shot. The “overlapped” or multiple speed and pressure lines are the virtual hydraulic injection feature in action.

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING (1/2) MEMORY 004 ALTER RUN 01/21/13 12:24

ACT VAL		MONITOR		MON TABLE		PROD		HISTORY		PROFILE		MAINT		CALCLATR	
		H N		H 1		H 2		H 3		THROAT					
ACT	°F	69.9		70.1		69.8		69.4		69.6					
DEV	°F	-*. *		-*. *		-*. *		-*. *		-90.4					
ON RATIO	%	0		0		0		0		0					
INJECTION		0.00		sec		SCREW POS		1.20		mm		CLAMP		0.0	
COOL		0.00		sec		PLATEN POS		370.0		mm		INJ/BP PRESS		381	
INTERVAL		0.00		sec		EJECT POS		29.96		mm		SCREW SPEED		0	
														tf	
														PSI	
														rpm	

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR AUTO AJD V.GATE1

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

INJ FF CONTROL

OFF

VHI CONTROL

SPD OFF • PRESS OFF

INJECT

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FPC DECELERATION

OFF

FILL SPEED CONTROL

STD

PEAK CUT

ON

INJ PRESS RESPONSE

MIDDLE

CHG • BP

SCREW DECELERATION

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

NOZZLE

NOZZLE RET TIME

00.0s

PLASTROL

PRE. INJECTION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 1

OFF

SCREW INVERSION 2

OFF

BP AFTER CHARGE

HOLD

MANUAL BACK PRESS

ON • OPSI

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

LAN-GUAGE

Start reaching for the impossible and achieve the incredible

ACT VAL
ACT °F
DEV °F
ON RATIO %
INJECTION
COOL
INTERVAL
INJECT
MOLDING
FIT C
C
LAM
C
FF CONTROL
OFF
VHI CONTROL
SPD OFF · PRESS OFF
NOZZLE
NOZZLE RET TIME
00.0s
SHUT OFF NOZZLE
OFF

HOLD PRESS CNTRL

SELECT PRESSURE HOLDING CONTROL METHOD FROM [STANDARD],[PTP],[SLOPE(FAST)],[SLOPE(MID)],[SLOPE(SLOW)] AND [SLOPE MANUAL].
USE SLOPE MANUAL TO SELECT GENTLER SLOPE THAN SLOPE(SLOW).
PTP MODE IS OPTIONAL.
THE SLOPE MANUAL MODE BECOMES THE SPECIFICATION OF THE ELECTRIC INJECTION MOLDING MACHINE.

☒

STD

☐

PTP

☐

SLOP(FAST)

☐

SLOP(MID)

☐

SLOP(SLOW)

☐

SLOP MANUAL

SLOP MANUAL SET

PSSLP

0

ms

LS4	MIDDLE	OFF
FPC DECELERATION		BP PROGRAM
OFF		OFF
PLASTROL		
PRE. INJECTION 1	SCREW INVERSION 1	BP AFTER CHARGE
OFF	OFF	HOLD
PRE. INJECTION 2	SCREW INVERSION 2	
OFF	OFF	

LIST	TEMP
CLAMP	INJECT
PROD	MON
9999	
OPTION	REC
OPT	
SHORTCUT	
TOOL	
SNAP SHOT	
MESSAGE	LADDER
SUP-PORT	

Start reaching for the impossible and achieve the incredible

ACT VAL MON

ACT °F
DEV °F
ON RATIO %

INJECTION
COOL
INTERVAL

INJECT INJ

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

FF CONTROL

OFF

VHI CONTROL

SPD OFF · PRESS OFF

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

HOLD SPD STEP

SELECT NUMBER OF SPEED STEPS IN PRESSURE HOLDING PROCESS.

1

2

SID	SLOP(MID)
HOLD SPD STEP	PEAK CUT
1	OFF
FPC PRESS	INJ PRESS RESPONSE
LS4	MIDDLE
FPC DECELERATION	
OFF	

PRE. INJECTION 1	SCREW INVERSION 1
OFF	OFF
PRE. INJECTION 2	SCREW INVERSION 2
OFF	OFF

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

BP AFTER CHARGE

HOLD

LIST 	TEMP
CLAMP 	INJECT
PROD 9999	MON
OPTION 	REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

ACT VAL

ACT °F

DEV °F

ON RATIO %

INJECTION

COOL

INTERVAL

INJECT

MOLDING

FIT CO

OF

LAMI

OF

FF CO

FPC PRESS

SELECT PRESSURE HOLDING SWITCHING METHOD FROM [LS4],[PLASTICS],[EXT] AND [CAV].

SET PRESSURE HOLDING SWITCHING PRESSURE IF PLASTICS OR CAV IS SELECTED.

USE TWO OR MORE FILLING SPEED STEPS IF PLASTICS, EXT OR CAV IS SELECTED.

EXT AND CAV ARE OPTIONAL.

LS4

EXTERNAL

PLASTIC

OFF

VHI CONTROL

SPD OFF · PRESS OFF

LS4

FPC DECELERATION

OFF

MIDDLE

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

PLASTROL

PRE. INJECTION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 1

OFF

SCREW INVERSION 2

OFF

OFF

BP PROGRAM

OFF

BP AFTER CHARGE

HOLD

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

INJ SET PRD CODE E.J. Brooks MEMORY 002 ALTER RUN 10/09/06 14:25

ACT FPC DECELERATION

SELECT TARGET VALUE OF REDUCING INJECTION SPEED RAPIDLY AT PRESSURE HOLDING SHIFT POSITION (LS4) FROM [OFF],[SLOW],[MID],[FAST] AND [MANUAL].

SLOW=0.10(mm)·0.003(in)
MID =0.50(mm)·0.019(in)
FAST=1.00(mm)·0.039(in)
USE MANUAL SETTING FOR FINE ADJUST.
USE FPCSLP TO SET TARGET SPEED REDUCTION VALUE IF MANUAL SETTING IS SELECTED.

☒ OFF
☒ MANUAL SET

MANUAL SET
FPCSLP 0.00 mm

☐ SLOW
☐ MIDDLE
☐ FAST

SPD OFF·PRESS OFF

NOZZLE

NOZZLE RET TIME 00.0s

SHUT OFF NOZZLE OFF

PLASTROL

PRE. INJECTION 1 OFF

SCREW INVERSION 1 OFF

PRE. INJECTION 2 OFF

SCREW INVERSION 2 OFF

BP AFTER CHARGE

HOLD

LIST TEMP CLAMP INJECT PROD MON OPTION REC SHORTCUT TOOL SNAP SHOT MESSAGE LADDER SUP-PORT

INJ SET	PRD CODE E.J. Brooks	MEMORY 002	ALTER	RUN	10/09/06	14:25
---------	----------------------	------------	-------	-----	----------	-------

ACT FPC DECELERATION LIST TEMP

ACT
DEV
ON RAT
INJEC
INT

SELECT TARGET VALUE OF REDUCING INJECTION SPEED RAPIDLY AT PRESSURE HOLDING SHIFT POSITION (LS4) FROM [OFF],[SLOW],[MID],[FAST] AND [MANUAL].

SLOW=0.10(mm)·0.003(in)

MID =0.50(mm)·0.019(in)

FAST=1.00(mm)·0.039(in)

USE MANUAL SETTING FOR FINE ADJUST.

USE FPCSLP TO SET TARGET SPEED REDUCTION VALUE IF MANUAL SETTING IS SELECTED.

CLAMP INJECT

PROD MON

9999

OPTION REC

MANUAL SET

0.00 mm

SHORTCUT

TOOL

SNAP SHOT

FAST

[illegible]

Three screenshots of the 'OFF' status on the SPD OFF PRESS indicator. The first screenshot shows 'SPD OFF PRESS OFF' with a blue bar above it. The second screenshot shows 'OFF' with a blue bar above it. The third screenshot shows 'OFF' with a blue bar above it.

NOZZLE  PLASTROL     SUP-
CONT

NOZZLE RET TIME PRE. INJECTION 1 SCREW INVERSION 1

00.0s	OFF	OFF	BP AFTER CHARGE
-------	-----	-----	-----------------


SHUT OFF NOZZLE

OFF PRE. INJECTION 2 SCREW INVERSION 2

OFF OFF

--	--	--	--

LIST	TEMP
------	------




CLAMP INJECT

PROD	MON



OPTION REC


 SHORTCUT TOOL

SNAPSHOT

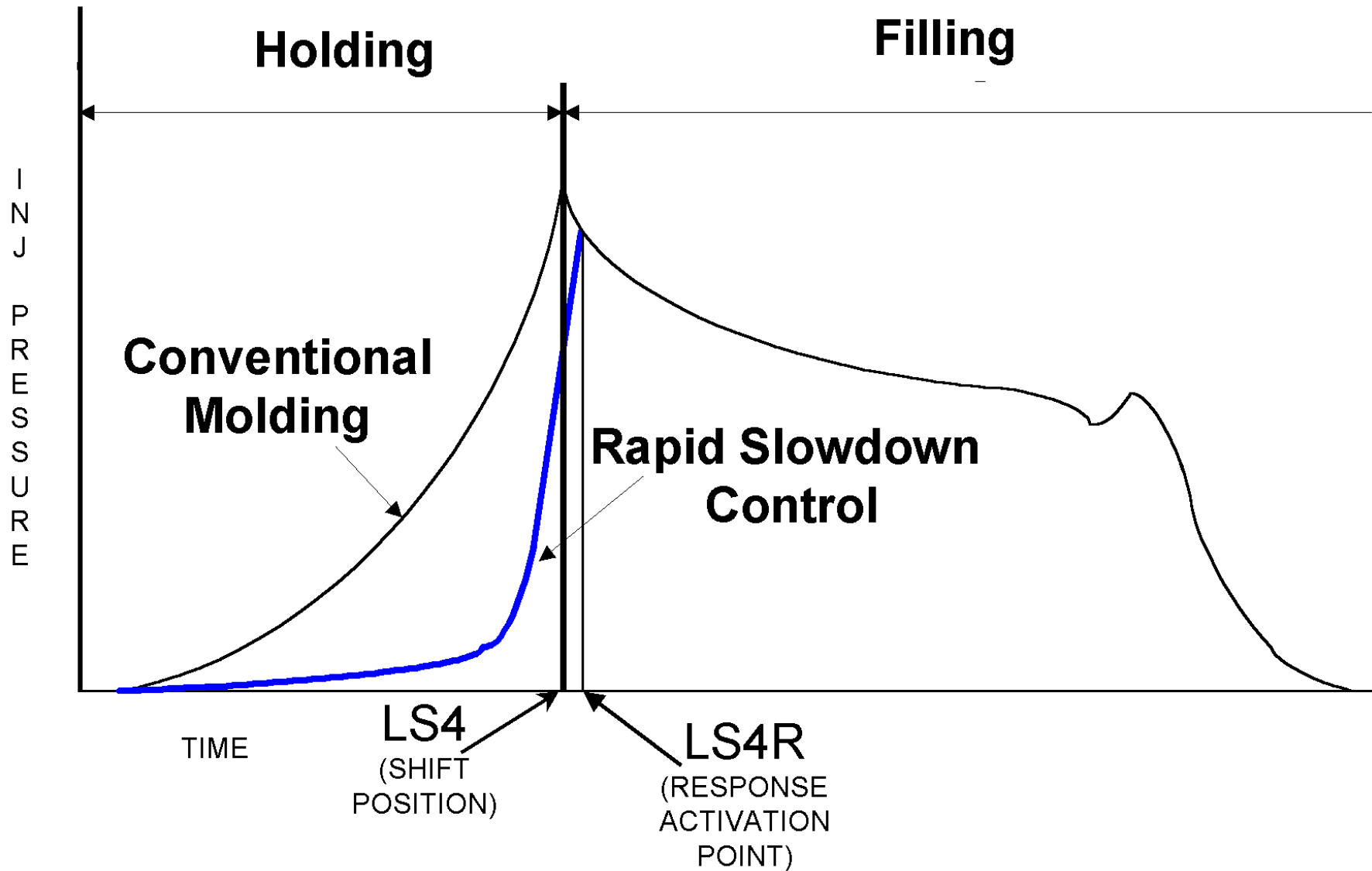



MESSAGE LADDER

MESSAGE LADDER

SUP-
PORT

PORT



With the deceleration response, slowdown is already complete by the time we make LS 4. With this feature off , we do not respond to the hold pressure until AFTER LS4 achieved.

Start reaching for the impossible and achieve the incredible

INJ SET PRD CODE E,J, Brooks MEMORY 002 ALTER RUN 10/09/06 15:59

ACT VAL MONITOR

ACT °F
DEV °F
ON RATIO %
INJECTION 0.00
COOL 0.00
INTERVAL 0.00

INJECT INJ SET

MOLDING

FIT CONTROL
OFF
LAMINAR
OFF
FF CONTROL
OFF
VHI CONTROL
SPD OFF · PRESS OFF

NOZZLE

NOZZLE RET TIME
00.0s
SHUT OFF NOZZLE
OFF

FILL SPEED CONTROL

☐ STD
 ☐ SLOP(SLOW)
 ☐ PTP
 ☐ SLOP MANUAL
 ☐ SLOP(FAST)
 SLOP MANUAL SET
SPSLP 0 ms
 ☒ SLOP(MID)

INJECT

HOLD PRESS CNTRL
STD
HOLD SPD STEP
1
FPC PRESS
LS4
FPC DECELERATION
OFF
FILL SPEED CONTROL
SLOP(MID)
PEAK CUT
OFF
INJ PRESS RESPONSE
MIDDLE

PLASTROL

PRE. INJECTION 1
OFF
PRE. INJECTION 2
OFF
SCREW INVERSION 1
OFF
SCREW INVERSION 2
OFF

CHG · BP

SCREW DECELERATION
OFF
SCREW SPEED PROGRAM
OFF
BP RELEASE
OFF
BP PROGRAM
OFF
BP AFTER CHARGE
HOLD

LIST

TEMP °F

CLAMP

INJECT

PROD 9999

MON

OPTION OPT

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ SET PRD CODE E,J, Brooks MEMORY 002 ALTER RUN 10/09/06 16:00

PEAK CUT

PREVENTS RAPID PRESSURE RISE AT FILLING.

OFF

PROFILE MAINT CALCLATR

THROAT
159.2

CLAMP 0 tf
INJ/BP PRESS 20 PSI
SCREW SPEED 0 rpm

LAMINAR

LIST TEMP °F

CLAMP INJECT

PROD 9999 MON

OPTION REC

FIT CONTROL

OFF

LAMINAR

OFF

FF CONTROL

OFF

VHI CONTROL

SPD OFF · PRESS OFF

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FPC DECELERATION

OFF

FILL SPEED CONTROL

SLOP(MID)

PEAK CUT

OFF

INJ PRESS RESPONSE

MIDDLE

CHG · BP

SCREW DECELERATION

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

BP AFTER CHARGE

HOLD

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

PLASTROL

PRE. INJECTION 1

OFF

PRE. INJECTION 2

OFF

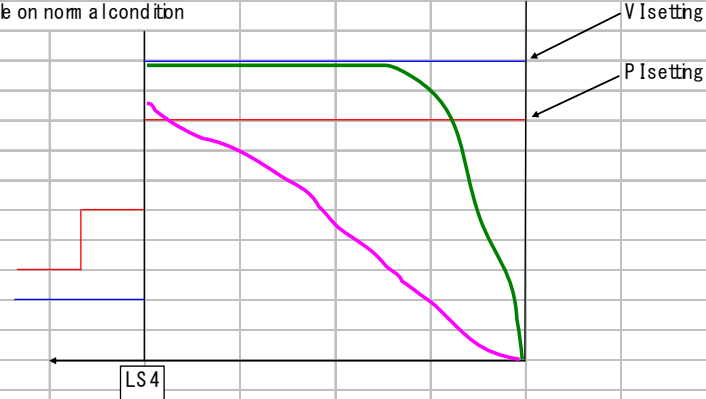
SCREW INVERSION 1

OFF

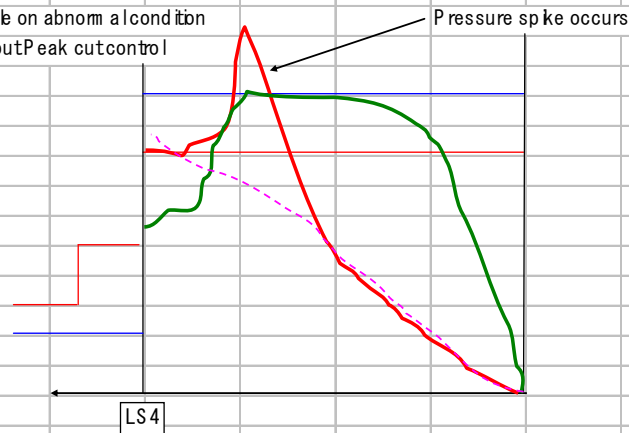
SCREW INVERSION 2

OFF

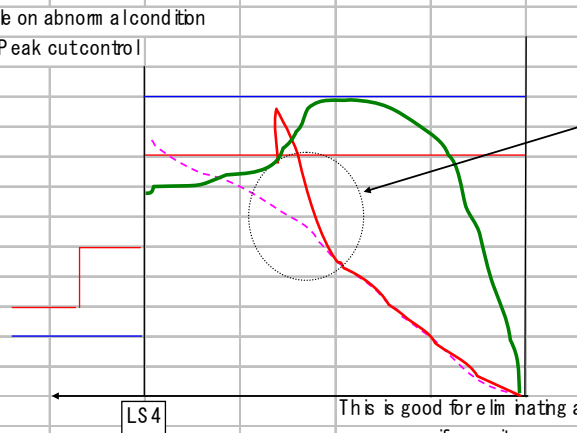
Profile on normal condition



Profile on abnormal condition without peak cut control



Profile on abnormal condition with peak cut control



Peak cut control is checking the abnormal ramp up profile curve until reached P I setting.

Filling velocity will be reduced if abnormal ramp up pressure condition has occurred

This is good for eliminating any belt jumping issue that may occur if a cavity or multiple cavities are present and abnormal breaking of the servo motor occurs. It can also reduce the possibility of damage to the injection ball screw

Start reaching for the impossible and achieve the incredible

INJ PRESS RESPONSE

SELECT PRESSURE RESPONSE IN INJECTION PROCESS FROM [SLOW], [MID] AND [FAST].

☐ SLOW

☒ MIDDLE

☐ FAST

LAMINAR

OFF

FF CONTROL

OFF

VHI CONTROL

SPD OFF · PRESS OFF

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

HOLD SPD STEP

1

FPC PRESS

LS4

FPC DECELERATION

OFF

PEAK CUT

OFF

INJ PRESS RESPONSE

MIDDLE

PLASTROL

PRE. INJECTION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 1

OFF

SCREW INVERSION 2

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

BP AFTER CHARGE

HOLD

NT / CALCLATR

THROAT

159.2

tf

0

PSI

0

rpm

0

DECELERATION

OFF

LIST

CLAMP

PROD

9999

OPTION

TEMP

°F

INJECT

MON

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

(2/2)

MEMORY 000

ALTER

RUN

04/24/06 14:59

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

		H N	H 1	H 2	H 3
ACT	°F	999.9	999.9	999.9	999.9
DEV	°F	**.*	**.*	**.*	**.*
ON RATIO %		0	0	0	0

THROAT

999.9

INJECTION	0.00	s	SCREW POS	5.039	in	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	10.00	in	INJ/BP PRESS	87	PSI
INTERVAL	0.00	s	EJECT POS	0.00	in	SCREW SPEED	0	min-1

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR

MOLDING

FIT CONTROL
OFF
LAMINAR
OFF
FF CONTROL
OFF
VHI CONTROL
SPD OFF·PRESS OFF

NOZZLE

NOZZLE RET TIME
00.0s

INJECT

HOLD PRESS CNTRL	FILL SPEED CONTROL
STD	STD
HOLD SPD STEP	PEAK CUT
1	OFF
FPC PRESS	INJ PRESS RESPONSE
LS4	MIDDLE
FPC DECELERATION	
OFF	

PLASTROL

PRE. INJECTION 1	SCREW INVERSION 1
OFF	OFF
PRE. INJECTION 2	SCREW INVERSION 2
OFF	OFF

CHG·BP

SCREW DECELERATION
OFF
SCREW SPEED PROGRAM
OFF
BP RELEASE
OFF
BP PROGRAM
OFF
BP AFTER CHARGE
HOLD

LIST TEMP
CLAMP INJECT
PROD MON
OPTION REC

SHORTCUT TOOL

SNAP SHOT
MESSAGE LADDER
SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ SET PRD CODE E,J, Brooks MEMORY 002 ALTER RUN 10/09/06 16:02

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

	H N	H 1	H 2	H 3	THROAT
ACT °F	389.6	399.9	390.0	380.1	159.4
DEV °F	-0.1	0.0	0.1	0.1	
ON RATIO %	9	5	0	12	

INJECTION
COOL
INTERVAL

INJECT
MOLDING
FIT CONTR
OFF

LAMINAR
OFF
FF CONTROL
OFF
VHI CONTROL
SPD OFF · PRESS OFF

NOZZLE
NOZZLE RET TIME
00.0s
SHUT OFF NOZZLE
OFF

PRE. INJ 1

PRE. INJ 1

INJ SPEED
VP11
0.0 mm/s

INJ PRESS
PP11
0 PSI

INJ TIME
TRPI
0.00 s

HOLD SPD STEP
1
FPC PRESS
LS4
FPC DECELERATION
OFF
PEAK CUT
OFF
INJ PRESS RESPONSE
MIDDLE

PLASTROL
PRE. INJECTION 1
OFF
PRE. INJECTION 2
OFF
SCREW INVERSION 1
OFF
SCREW INVERSION 2
OFF

SCREW SPEED PROGRAM
OFF
BP RELEASE
OFF
BP PROGRAM
OFF
BP AFTER CHARGE
HOLD

LIST
CLAMP
PROD
9999
OPTION
OPT

TEMP
°F
INJECT
MON
REC

SHORTCUT
TOOL

SNAP
SHOT
MESSAGE

LADDER
SUP-
PORT

Start reaching for the impossible and achieve the incredible

LIST
TEMP
CLAMP
INJECT
PROD
MON
OPTION
REC

SHORTCUT
TOOL

SNAP SHOT
MESSAGE
LADDER
SUP-PORT

PRE. INJ 1

【OPERATION】
THE MACHINE CARRIES OUT INJECTION AT LOW PRESSURE FOR SET TIME TO UNIFORM THE DENSITY OF CHARGED VOLUME OF MATERIAL.
WHEN SUCK BACK AMOUNT HAS BEEN SET, THE MACHINE CONDUCTS SUCK BACK MOVEMENT FROM THE POSITION AFTER COMPRESSION BY THE MOVEMENT AMOUNT SET ON LS10.
THE DIFFERENCE OF SCREW POSITION CAUSED BY PRE-INJECTION 1 IS CORRECTED BY MEANS OF SPEED SHIFT POSITION AT INJECTION.
【REFERENCE VALUE FOR SETTING EACH ITEM】
1.INJ SPEED VPI1 5~15(mm/s) OR 0.2~0.59(in/s)
2.INJ PRESS PPI1 2~3 TIMES OF SET SCREW BACK PRESSURE(BP)
3.INJ TIME TRPI1 1.5~3.0(s)
(NOTE)VALUES ARE FOR REFERENCE ONLY.
ADJUST THEM DEPENDING ON SCREW DIAMETER OR USING MATERIAL.
【EFFECT】
STABILIZATION OF PLASTIZATION RESIN QUANTITY.

PRE. INJ 1	INJ SPEED	INJ PRESS	INJ TIME
OFF	VPI1 0.0 mm/s	PPI1 0 PSI	TRPI 0.00 s

OFF

PRE. INJECTION 2
OFF

SCREW INVERSION 2
OFF

Start reaching for the impossible and achieve the incredible

PRE. INJ 2

【OPERATION】

THE MACHINE CARRIES OUT INJECTION BY THE SET MOVEMENT AMOUNT AFTER SUCK BACK COMPLETION,
AND CLOSES THE CHECK RING DURING COOLING TIME TO QUICKEN THE RESPONSE OF CHECK RING AT INJECTION.
WHEN SUCK BACK AMOUNT HAS NOT BEEN SET, THE MACHINE CONDUCTS INJECTION ONLY BY THE SET MOVEMENT AMOUNT FROM THE CHARGE OUT POSITION.
THE DIFFERENCE OF SCREW POSITION CAUSED BY PRE-INJECTION 2 IS CORRECTED BY MEANS OF SPEED SHIFT POSITION AT INJECTION.

【REFERENCE VALUE FOR SETTING EACH ITEM】

- 1. INJ SPEED VPI2 30~50(mm/s) OR 1.18~1.97(in/s)
 - 2. MOVEMENT AMOUNT LS10B 1.0~3.0(mm) OR 0.039~0.118(in)
- SET ADVANCE AMOUNT SMALLER THAN SUCK BACK AMOUNT AS LS10>LS10B.
ENLARGE SUCK BACK AMOUNT BY THE AMOUNT OF LS10B SETTING.
(NOTE) VALUES ARE FOR REFERENCE ONLY.
ADJUST THEM DEPENDING ON SCREW DIAMETER OR USING MATERIAL.

【EFFECT】

STABILIZATION OF A CHECK RING RESPONSE.

PRE. INJ 2

OFF

INJ SPEED

VPI2
0.0 mm/s

INJ STROKE

LS10B
0.00 mm

SHUT OFF NOZZLE

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 2

OFF

HOLD

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT
TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

SCREW INV1

【OPERATION】
THE MACHINE INVERTS SCREW ROTATION DURING SUCK BACK FOR THE SET TIME.
INVERTING THE SCREW LOWERS THE MELT PRESSURE BETWEEN THE CHECK RING
AND SPACER TO QUICKEN CHECK RING RESPONSE.
WHEN SUCK BACK AMOUNT HAS NOT BEEN SET, THE MACHINE INVERTS SCREW
ROTATION AT THE CHANGE OUT POSITION.

【REFERENCE VALUE FOR SETTING EACH ITEM】
1.SCREW INVERSE SPEED SRNI1 20~50(min-1)
2.SCREW INVERSE TIME TRIT1 0.1~0.3(s)
(NOTE)VALUES ARE FOR REFERENCE ONLY.
ADJUST THEM DEPENDING ON SCREW DIAMETER OR USING MATERIAL.

【EFFECT】
STABILIZATION OF A CHECK RING RESPONSE.

SCREW INV1

SCREW SPEED

SCREW SPEED TIME

OFF

SRNI1

0

rpm

TRIT1

0.00

s

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

PLASTROL

PRE. INJECTION 1

OFF

SCREW INVERSION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 2

OFF

BP AFTER CHARGE

HOLD

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

SCREW INV2

【OPERATION】
THE MACHINE INVERTS SCREW ROTATION BEFORE INJECTION. INVERTING THE SCREW LOWERS THE MELT PRESSURE BETWEEN THE CHECK RING AND SPACER TO QUICKEN CHECK RING RESPONSE. THE MACHINE STARTS INJECTION AFTER COMPLETION OF SCREW INVERSE.

【REFERENCE VALUE FOR SETTING EACH ITEM】
1.SCREW INVERSE SPEED SRNI2 20~50(min-1)
2.SCREW INVERSE TIME TRIT2 0.1~0.3(s)
(NOTE)VALUES ARE FOR REFERENCE ONLY.
ADJUST THEM DEPENDING ON SCREW DIAMETER OR USING MATERIAL.

【EFFECT】
STABILIZATION OF A CHECK RING RESPONSE.

SCREW INV2 SCREW SPEED SCREW SPEED TIME

OFF

SRNI2

0

rpm

TRIT2

0.00

s

SPD OFF · PRESS OFF OFF OFF

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

PLASTROL

PRE. INJECTION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 1

OFF

SCREW INVERSION 2

OFF

BP AFTER CHARGE

HOLD

LIST

CLAMP

PROD

9999

OPTION

OPT

TEMP

°F

INJECT

MON

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

(1/2)

MEMORY 004

ALTER

RUN

01/21/13

12:24

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

		H N	H 1	H 2	H 3	THROAT	
ACT	°F	69.9	70.1	69.8	69.4	69.6	
DEV	°F	***.*	***.*	***.*	***.*	-90.4	
ON RATIO	%	0	0	0	0	0	
INJECTION	0.00	sec	SCREW POS	1.20	mm	CLAMP	0.0
COOL	0.00	sec	PLATEN POS	370.0	mm	INJ/BP PRESS	381
INTERVAL	0.00	sec	EJECT POS	29.96	mm	SCREW SPEED	0
						tf	
						PSI	
						rpm	

LIST

TEMP

CLAMP

INJECT

PROD 9999

MON

OPTION

REC

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR AUTO AJD V.GATE1

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

INJ FF CONTROL

OFF

VHI CONTROL

SPD OFF·PRESS OFF

INJECT

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FPC DECELERATION

OFF

FILL SPEED CONTROL

STD

PEAK CUT

ON

INJ PRESS RESPONSE

MIDDLE

CHG·BP

SCREW DECELERATION

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

NOZZLE

NOZZLE RET TIME

00.0s

PLASTROL

PRE. INJECTION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 1

OFF

SCREW INVERSION 2

OFF

BP AFTER CHARGE

HOLD

MANUAL BACK PRESS

ON·OPSI

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

LAN-GUAGE

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ SET PRD CODE E,J, Brooks MEMORY 002 ALTER RUN 10/09/06 16:31

SCREW DECELERATION

230 rpm

0

DECEL

OFF

MAINT / CALCLATR

THROAT

160.3

AMP 0 tf

ESS 0 PSI

PEED 0 rpm

LIST

TEMP °F

CLAMP

INJECT

PROD 9999

MON

OPTION OPT

REC

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

FF CONTROL

OFF

VHI CONTROL

SPD OFF · PRESS OFF

INJECT

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FPC DECELERATION

OFF

FILL SPEED CONTROL

SLOP(MID)

PEAK CUT

OFF

INJ PRESS RESPONSE

MIDDLE

CHG · BP

SCREW DECELERATION

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

PLASTROL

PRE. INJECTION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 1

OFF

SCREW INVERSION 2

OFF

BP AFTER CHARGE

HOLD

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ SET TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 14:35

ACT VAL		MONITOR		MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s		CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
8	14.10	6711 *	3.47		34.52	2.24 *	2.25 *	7465 *	2.13 *
9	14.12	6726 *	3.46		34.51	2.24 *	2.24 *	7536 *	2.13 *
10	14.04	6697 *	3.46		34.51	2.28 *	2.28 *	7579 *	2.13 *
11	13.98	6683 *	3.46		34.52	2.18 *	2.18 *	7550 *	2.13 *

FILL TIME 2.13 s CHARGE TIME 13.98 s MIN-CUSH 2.18 mm ACT-CUSH 2.18 mm FPC PRESS 6683 PSI INJ START 129.00 mm

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

FF CONTROL

OFF

INJECT

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FILL SPEED CONTROL

SLOP(MID)

PEAK CUT

ON

INJ PRESS RESPONSE

MIDDLE

CHG-BP

SCREW DECELERATION

OFF

SCREW SPEED PROGRAM

ON-60.00mm-20 rpm

BP RELEASE

OFF

BP PROGRAM

OFF

SCREW SPEED PROGRAM

PROGRAM CNTR PRGM START FIN SPD

ON

LS 5B 60.00 mm

SRNF 20 rpm

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

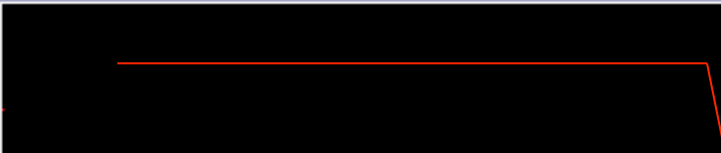
SUP-PORT

Start reaching for the impossible and achieve the incredible

BP RELEASE

BACK PRESSURE IS RELEASED BEFORE LS5.
THIS IS HELPFUL TO STABILIZE CHARGING.

7110
PSI



RELEASE

OFF

LAMINAR

OFF

FF CONTROL

OFF

VHI CONTROL

SPD OFF · PRESS OFF

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

HOLD SPD STEP	1	PEAK CUT	OFF
FPC PRESS	LS4	INJ PRESS RESPONSE	MIDDLE
FPC DECELERATION	OFF		

PLASTROL

PRE. INJECTION 1	OFF	SCREW INVERSION 1	OFF
PRE. INJECTION 2	OFF	SCREW INVERSION 2	OFF

MAINT / CALC LTR

THROAT

160.1

AMP 0 tf

ESS 0 PSI

PEED 0 rpm

CHG · BP

SCREW DECELERATION

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

BP AFTER CHARGE

HOLD

LIST

TEMP

CLAMP

INJECT

PROD

9999

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ SET TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 14:38

ACT VAL	MONITOR	MON	TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
8	14.10	6711 *	3.47	34.52	2.24 *	2.25 *	7465 *	2.13 *
9	14.12	6726 *	3.46	34.51	2.24 *	2.24 *	7536 *	2.13 *
10	14.04	6697 *	3.46	34.51	2.28 *	2.28 *	7579 *	2.13 *
11	13.98	6683 *	3.46	34.52	2.18 *	2.18 *	7550 *	2.13 *
FILL TIME		CHARGE TIME	MIN-CUSH	ACT-CUSH	FPC PRESS	INJ START		
2.13 s		13.98 s	2.18 mm	2.18 mm	6683 PSI	129.00 mm		

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

FF CONTROL

OFF

INJECT

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FILL SPEED CONTROL

SLOP(MID)

PEAK CUT

ON

INJ PRESS RESPONSE

MIDDLE

CHG·BP

SCREW DECELERATION

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

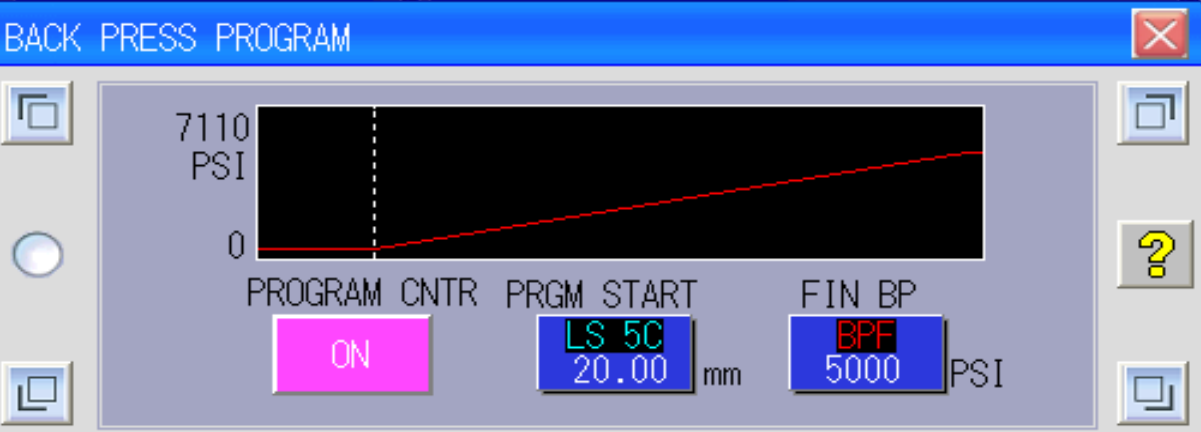
OFF

BP PROGRAM

ON·20.00mm·5000PSI

BP AFTER CHARGE

HOLD



LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ SET TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 15:39

BP DURING CHARGE

☒ CONTROL

☐ DRAIN

HISTORY / PROFILE / MAINT / CALCLATR

MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
0.66 *	0.66 *	7095 *	2.13 *
0.00 *	0.00 *	5474 *	2.13 *
1.03 *	1.03 *	7237 *	2.13 *
1.45	1.45	7408 *	2.13 *

ACT-CUSH FPC PRESS INJ START
1.45 mm 6521 PSI 129.00 mm

AT PURGE LAMINAR

LIST



TEMP



CLAMP



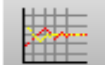
INJECT



PROD



MON



OPTION



REC



MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

FF CONTROL

OFF

VHI CONTROL

SPD OFF · PRESS OFF

INJECT

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FPC DECELERATION

OFF

FILL SPEED CONTROL

SLOP(MID)

PEAK CUT

ON

INJ PRESS RESPONSE

MIDDLE

CHG·BP

SCREW DECELERATION

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

BP DURING CHARGE

DRAIN

BP AFTER CHARGE

HOLD

SHORTCUT

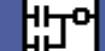
TOOL



SNAP
SHOT



MESSAGE



LADDER



SUP-
PORT

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

PLASTROL

PRE. INJECTION 1

OFF

SCREW INVERSION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 2

OFF

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

CHG PRFL TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 15:37

ACT VAL	MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR	
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
19	13.48	6242	3.47	34.51	2.26 *	2.26 *	7280 *	2.55 *
20	13.69	6697 *	3.47	34.51	2.34 *	2.34 *	7437 *	2.13 *
21	13.76	6484	0.00	41.16	0.94 *	0.95 *	6953 *	2.13 *
22	5.26 *	3924 *	3.47	52.29 *	0.00 *	0.00 *	5488	2.13 *
23	4.62 *	3782 *	3.47	34.51	0.00 *	0.00 *	5332 *	2.13 *
24	11.93	6640 *	0.00	4.38	1.48	1.48	6740 *	2.13 *
25	11.79 *	6271	3.47	34.51	0.66 *	0.66 *	7095 *	2.13 *

LIST

TEMP

CLAMP

INJECT

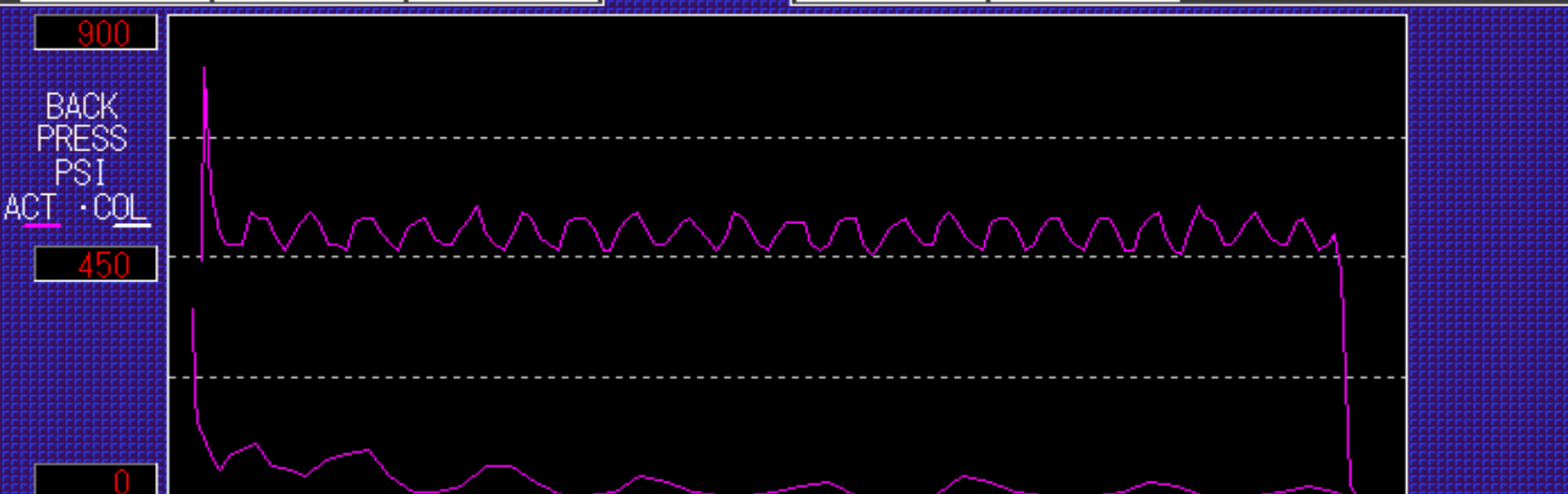
PROD

MON

OPTION

REC

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



900

BACK PRESS PSI

ACT - COL

450

0

0.0

SCREW POS

5.94 mm

130.00

CURSOR DISPLAY

SCREW SP

0 rpm

BP

3069 PSI

CHARGE TIME

4.39 s

CHG CMPLT

123.04 mm

OVERLAP

ON

ERASE

COLLECT START

PROFILE COLLECT

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

BP AFTER CHARGE

SELECT BACK PRESSURE MODE IN AFTER CHARGE FROM [HOLD], [DRAIN] AND [BLOCK].
HOLD :SET BACK PRESSURE AFTER COMPLETION OF CHARGE IS SAME AS SETTING IN MEASUREMENT.
DRAIN:BACK PRESSURE IN AFTER CHARGE IS SET TO ZERO.
BLOCK:BACK PRESSURE IN AFTER CHARGE IS BLOCKED.
(NOTE)THE CONTENT OF THE SELECTION MIGHT CHANGE DEPENDING ON THE SPECIFICATION.

☒ HOLD

☐ DRAIN

CALCLATR

ROAT
30.3

0

tf

9

PSI

0

rpm

DECELERATION
OFF

SPEED PROGRAM
OFF

RELEASE
OFF

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

VHI CONTROL

SPD OFF · PRESS OFF

NOZZLE

NOZZLE RET TIME

00.0s

SHUT OFF NOZZLE

OFF

FPC DECELERATION

OFF

PLASTROL

PRE. INJECTION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 1

OFF

SCREW INVERSION 2

OFF

BP PROGRAM

OFF

BP AFTER CHARGE

HOLD

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING (1/2) MEMORY 004 ALTER RUN 01/21/13 12:24

ACT VAL		MONITOR		MON TABLE		PROD		HISTORY		PROFILE		MAINT		CALCLATR	
		H N		H 1		H 2		H 3				THROAT			
ACT	°F	69.9		70.1		69.8		69.4				69.6			
DEV	°F	-*.*		-*.*		-*.*		-*.*				-90.4			
ON RATIO	%	0		0		0		0				0			
INJECTION	0.00	sec	SCREW POS	1.20	mm	CLAMP	0.0	tf							
COOL	0.00	sec	PLATEN POS	370.0	mm	INJ/BP PRESS	381	PSI							
INTERVAL	0.00	sec	EJECT POS	29.96	mm	SCREW SPEED	0	rpm							

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR AUTO AJD V.GATE1

MOLDING

FIT CONTROL

OFF

LAMINAR

OFF

INJ FF CONTROL

OFF

VHI CONTROL

SPD OFF • PRESS OFF

INJECT

HOLD PRESS CNTRL

STD

HOLD SPD STEP

1

FPC PRESS

LS4

FPC DECELERATION

OFF

FILL SPEED CONTROL

STD

PEAK CUT

ON

INJ PRESS RESPONSE

MIDDLE

CHG • BP

SCREW DECELERATION

OFF

SCREW SPEED PROGRAM

OFF

BP RELEASE

OFF

BP PROGRAM

OFF

NOZZLE

NOZZLE RET TIME

00.0s

PLASTROL

PRE. INJECTION 1

OFF

PRE. INJECTION 2

OFF

SCREW INVERSION 1

OFF

SCREW INVERSION 2

OFF

BP AFTER CHARGE

HOLD

MANUAL BACK PRESS

ON • OPSI

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

LAN-GUAGE

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

PARAMETER MODE (2/2) MEMORY 004 ALTER RUN 01/21/13 12:24

ACT VAL		MONITOR		MON TABLE		PROD		HISTORY		PROFILE		MAINT		CALCLATR	
		H N		H 1		H 2		H 3				THROAT			
ACT	°F	69.9		70.1		69.9		69.6				69.6			
DEV	°F	-***.*		-***.*		-***.*		-***.*				-90.4			
ON RATIO	%	0		0		0		0				0			
INJECTION	0.00	sec	SCREW POS	1.20	mm	CLAMP	0.0	tf							
COOL	0.00	sec	PLATEN POS	370.0	mm	INJ/BP PRESS	384	PSI							
INTERVAL	0.00	sec	EJECT POS	29.96	mm	SCREW SPEED	0	rpm							

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR AUTO AJD V.GATE1

SPRUE BK CONTINUE

SPEED STEP 3STEP

PRESS STEP 1STEP

INJ PRESS 389 PSI

CHG. DLY 0.0 s

SRN 0 rpm

TRH 3 0.00

TRH 2 0.00

TRH 1 0.00 s

BACK PRESS 0 PSI

BP 0

BPM 0

PH 4 100

PH 3 100

PH 2 100

PH 1 100

PI 1 150

INJECT 0.00

COOL 0.00

INT 5.00

0.00 sec

SCREW POS 1.20 mm

VH 1 0.0

VI3 0.0

VI2 0.0

VI1 0.0

VSB 0.0 mm/s

VH 0 0.0 mm/s

LS 4 0.00

LS 4B 11.00

LS 4A 29.00

LS 5 0.00

LS 10 0.00 mm

LS 10A 0.00 mm

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

LAN-GUAGE

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ PRFL TITLE frisby MEMORY 001 ALTER RUN 05/08/06 15:04

ACT VAL / MONITOR / MON TABLE / PROD

TRQ MONITOR OFF

DELAY 0.00

REC 0.00

ACT 0.0 %

MAX 0.0 %

MIN 0.0 %

AVG 0.0 %

☐ X000 ☐ X001 ☐ X004 ☐ X005 ☐ X008 ☐ X009

☐ = ON ☐ = OFF

SEQ MON

INJECT / INJ SET / INJ PRFL / CHG PRFL

VERTICAL

INJ PRESS ON

INJ SPEED ON

MAX 10000

MIN 0

PSI

2.5

0.0

in/s



LIST

TEMP

CLAMP

INJECT

PROD 9999

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ PRFL TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 14:22

ACT VAL	MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR	
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
500	14.02 *	6910 *	3.60 *	34.63 *	2.66 *	2.66 *	7678 *	2.13 *
501	14.01 *	7166 *	14.33 *	10.75 *	3.20 *	3.20 *	7479 *	2.13 *
502	42.35 *	6015 *	0.00	4.64	0.00	0.00	7394 *	2.13 *
503	19.65 *	5702 *	6.04 *	46.93 *	0.00	0.00	7209 *	2.13 *
504	15.44 *	6015 *	3.46 *	34.51 *	0.00	0.00	7422 *	2.15 *
505	14.73 *	6242 *	3.47 *	34.51 *	0.40 *	0.40 *	7465 *	2.15 *
506	14.15 *	6484 *	3.47 *	34.51 *	1.14 *	1.14 *	7479 *	2.16 *

LIST

TEMP

CLAMP

INJECT

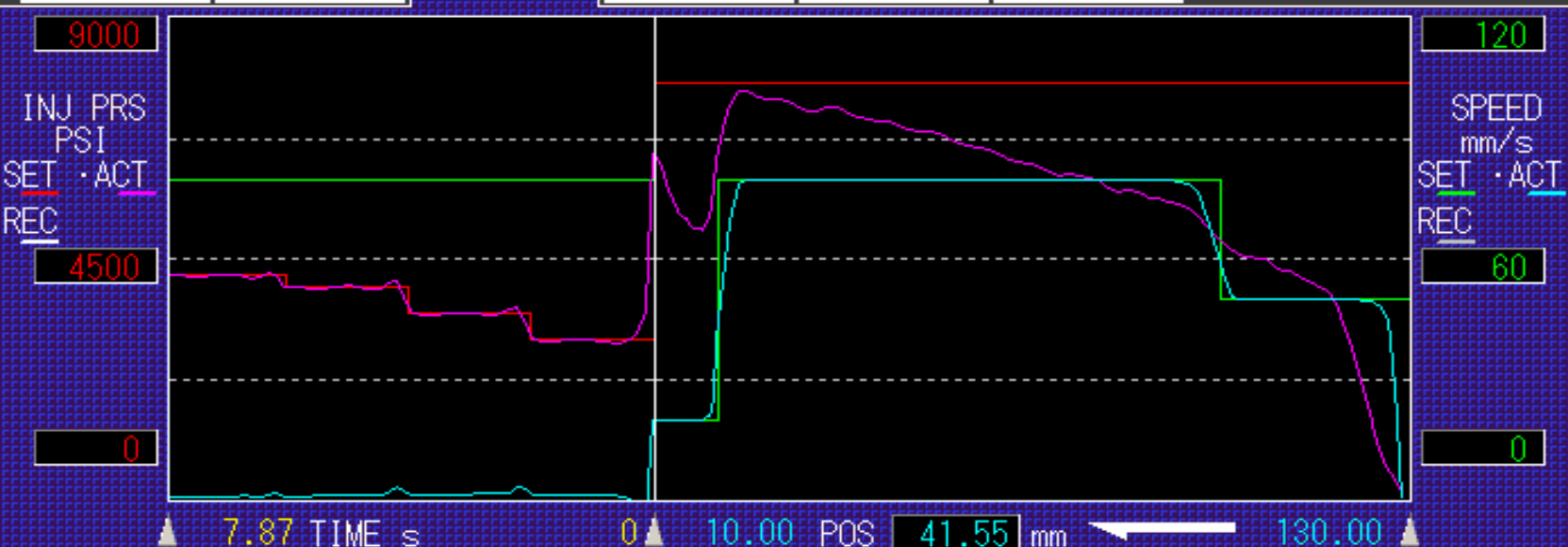
PROD 9999

MON

OPTION

REC

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



CURSOR DISPLAY

PROFILE SET

HOLD 2.00 2.00 2.00 s

4200 4000 3500 3000 PSI

80.0 mm/s 10.00

7800 PSI INJ 10.00 s

20.0 80.0 50.0 mm/s

20.00 100.00 123.00 6.00 mm

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ PRFL TITLE mystery mold MEMORY 003 ALTER RUN 01/03/07 12:00

ACT VAL MONITOR MON TABLE PROD HISTORY

		H N	H 1	H 2	H 3
ACT	°F	437.5	470.6	455.0	441.5
DEV	°F	-2.5	0.7	-5.0	-8.5
ON RATIO %		15	6	44	88

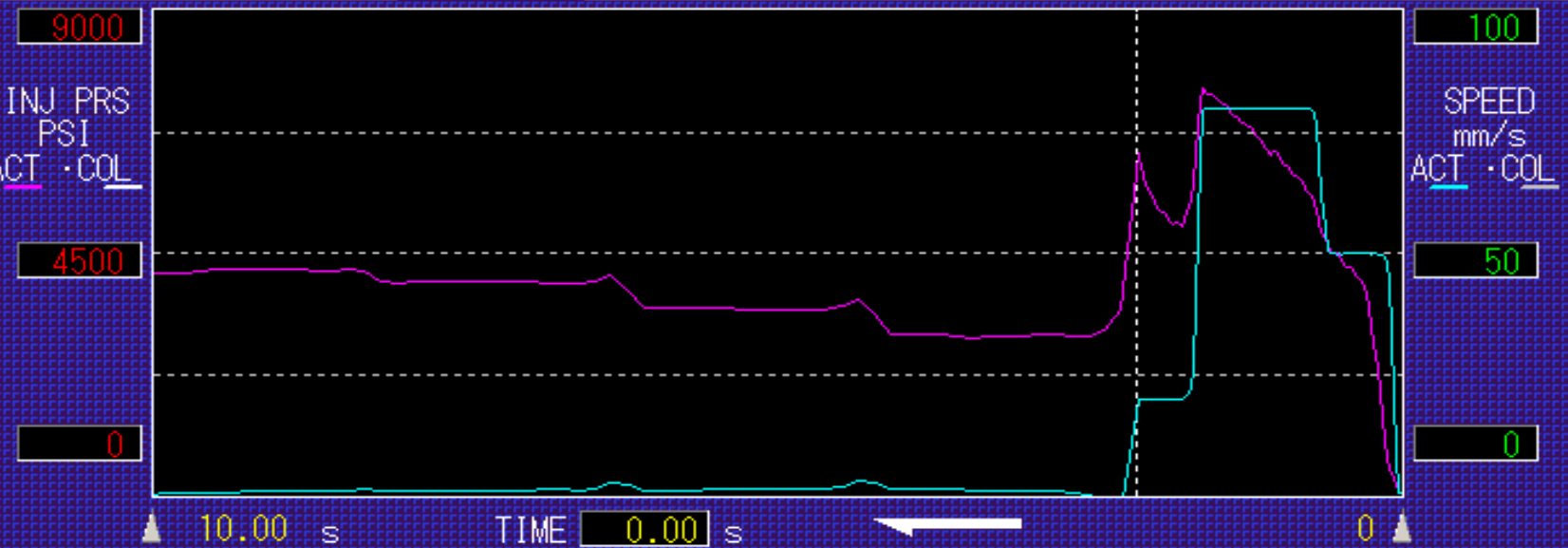
INJECTION	0.00	s	SCREW POS	116.06	mm
COOL	13.15	s	PLATEN POS	0.0	mm
INTERVAL	0.00	s	EJECT POS	28.1	mm

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE

HORIZONTAL DISPLAY SELECT

☐ POSITION

☒ TIME(INJ)



LIST

TEMP °F

CLAMP

INJECT

PROD 9999

MON

OPTION OPT

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE 2

LADDER

SUP-PORT

CURSOR DISPLAY

MIN-CUSH 1.07 mm

SHIFT POS 6390 PSI 9.99 mm

INJ START 129.00 mm

PROFILE COLLECT

COLECT FINISH

PRFL DRAW

PRFL ERASE

SETUP DISPLAY

HORIZON SELECT

SCRW POS PROFILE

VERTICAL CHANGE

OVERLAP OFF

GRAPH

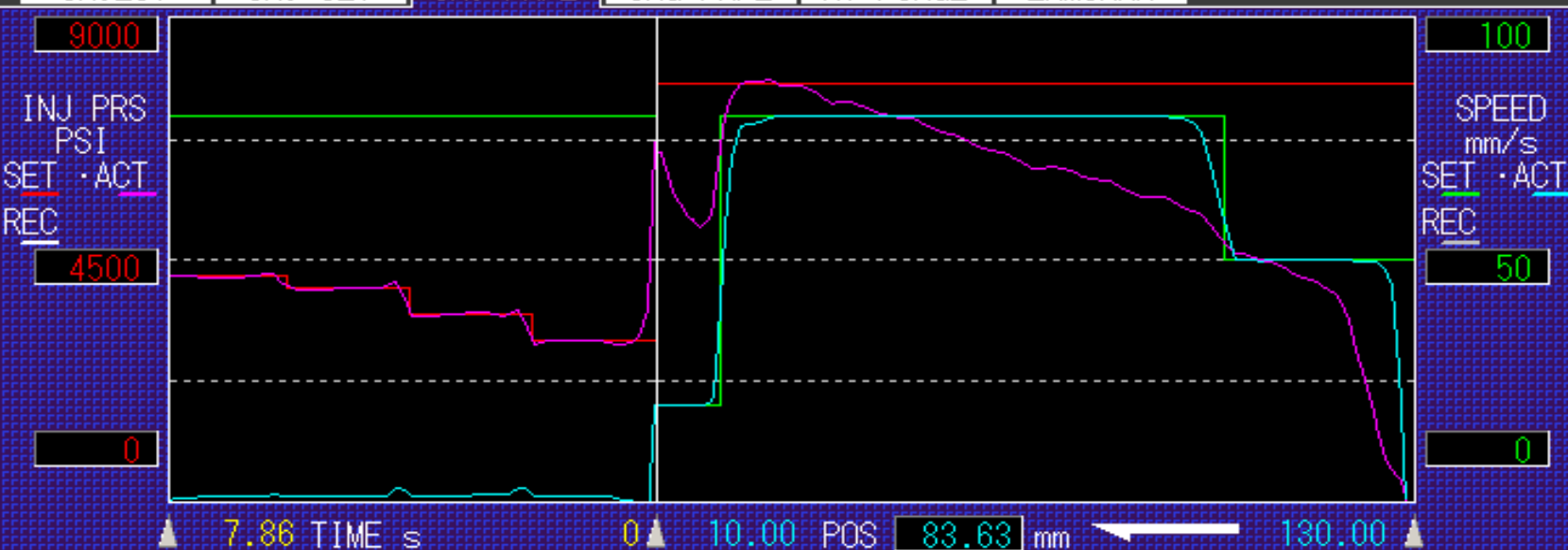
TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ PRFL TITLE mystery mold MEMORY 003 ALTER RUN 01/03/07 12:01

ACT VAL	MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR	
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
32	4.63 *	3654 *	3.47	34.52	0.00 *	0.00 *	5161 *	2.13 *
33	13.08	5602	0.00	0.74	0.00 *	0.00 *	6640 *	2.13 *
34	34.13 *	5403	0.00	34.30	0.00 *	0.00 *	7337 *	2.13 *
35	14.71	5517	7.15 *	55.97 *	0.00 *	0.00 *	7508 *	2.13 *
36	14.72	6114	3.47	34.51	0.19 *	0.19 *	7522 *	2.13 *
37	14.44	6384	3.46	34.52	1.07 *	1.07 *	7579 *	2.13 *
38	14.01	6669 *	3.47	34.51	1.81	1.81	7806 *	2.13 *

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



CURSOR DISPLAY MIN-CUSH 2.15 mm SHIFT POS 6693 PSI 9.99 mm INJ START 129.00 mm

PROFILE COLLECT

COLLECT FINISH PRFL DRAW PRFL ERASE

SETUP DISPLAY HORIZON SELECT SCRWB POS PROFILE VERTICAL CHANGE OVERLAP OFF GRAPH

LIST TEMP °F

CLAMP INJECT

PROD MON

9999

OPTION REC

SHORTCUT TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ PRFL TITLE mystery mold MEMORY 003 ALTER RUN 01/03/07 11:59

ACT VAL MONITOR MON TABLE

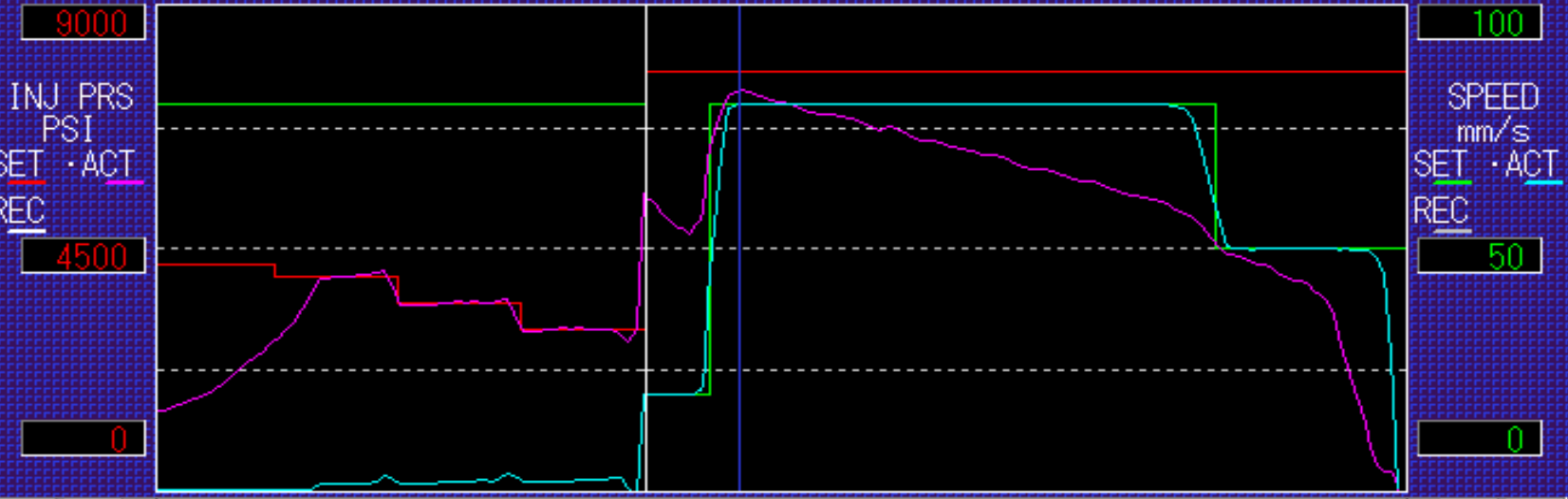
ACT °F 439.5 H N 470.8 H 1
DEV °F -0.5 0.8
ON RATIO % 9 7
INJECTION 0.00 s SCREW
COOL 5.46 s PLATEN
INTERVAL 0.00 s EJECT

CURSOR INFORMATION

ITEM	INFORMATION	UNIT
INJ PRESS	7470	PSI
INJ SPEED	80.0	mm/s
SCREW POSITION	24.59	mm

LIST TEMP
CLAMP INJECT
PROD MON
9999
OPTION REC
OPT

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



SHORTCUT TOOL
SNAP SHOT
MESSAGE LADDER
SUP-PORT

<< < > >>

SCALE DISPLAY MIN-CUSH 0.00 mm SHIFT POS 5522 PSI 9.99 mm INJ START 129.00 mm
SETUP DISPLAY HORIZON SELECT SCRWB POS PROFILE VERTICAL CHANGE OVERLAP OFF GRAPH
PROFILE COLLECT COLLECT FINISH PRFL DRAW PRFL ERASE

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INJ PRFL TITLE **mystery mold** MEMORY 003 ALTER RUN 01/03/07 12:01

ACT VAL	MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR	
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
32	4.63 *	3654 *	3.47	34.52	0.00 *	0.00 *	5161 *	2.13 *
33	13.08	5602	0.00	0.74	0.00 *	0.00 *	6640 *	2.13 *
34	34.13 *	5403	0.00	34.30	0.00 *	0.00 *	7337 *	2.13 *
35	14.71	5517	7.15 *	55.97 *	0.00 *	0.00 *	7508 *	2.13 *
36	14.72	6114	3.47	34.51	0.19 *	0.19 *	7522 *	2.13 *
37	14.44	6384	3.46	34.52	1.07 *	1.07 *	7579 *	2.13 *
38	14.01	6669 *	3.47	34.51	1.81	1.81	7806 *	2.13 *

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



CURSOR DISPLAY MIN-CUSH 2.15 mm SHIFT POS 6693 PSI 9.99 mm INJ START 129.00 mm

PROFILE COLLECT

COLECT FINISH PRFL DRAW PRFL ERASE

SETUP DISPLAY HORIZON SELECT SCRWB POS PROFILE VERTICAL CHANGE OVERLAP OFF GRAPH

LIST TEMP

CLAMP INJECT

PROD MON

9999

OPTION REC

OPT

SHORTCUT

TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

TOSHIBA MACHINE

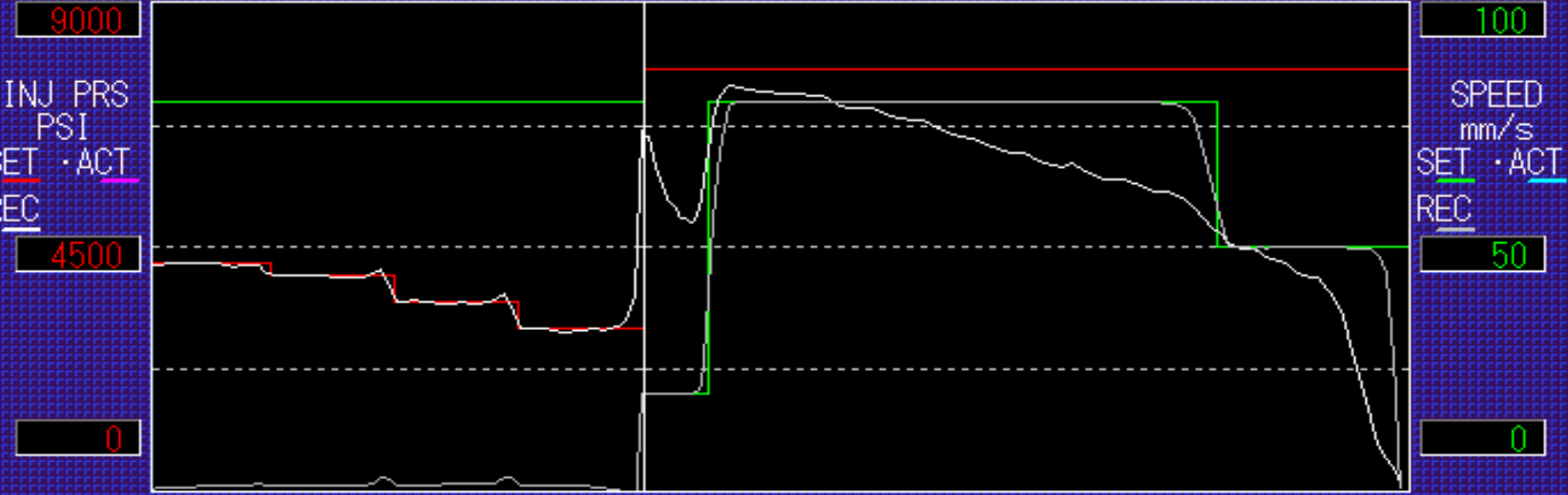
Start reaching for the impossible and achieve the incredible

INJ PRFL TITLE mystery mold MEMORY 003 ALTER RUN 01/02/07 14:33

ACT VAL	MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR	
shots	CHARGE s	FPC PRESS PSI	TAKEOUT s	CYCLE s	MIN-CUSH mm	CUSH mm	INJ PEAK PSI	FILL s
8	14.10	6711 *	3.47	34.52	2.24 *	2.25 *	7465 *	2.13 *
9	14.12	6726 *	3.46	34.51	2.24 *	2.24 *	7536 *	2.13 *
10	14.04	6697 *	3.46	34.51	2.28 *	2.28 *	7579 *	2.13 *
11	13.98	6683 *	3.46	34.52	2.18 *	2.18 *	7550 *	2.13 *

FILL TIME 2.13 s CHARGE TIME 13.98 s MIN-CUSH 2.18 mm ACT-CUSH 2.18 mm FPC PRESS 6683 PSI INJ START 129.00 mm

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



7.87 TIME s 10.00 POS 129.00 mm 130.00

CURSOR DISPLAY MIN-CUSH 2.18 mm SHIFT POS 6683 PSI 9.99 mm INJ START 129.00 mm

PROFILE COLECT COLLECT FINISH PRFL DRAW PRFL ERASE

LIST TEMP CLAMP INJECT PROD MON OPTION REC

SHORTCUT TOOL SNAP SHOT MESSAGE LADDER SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

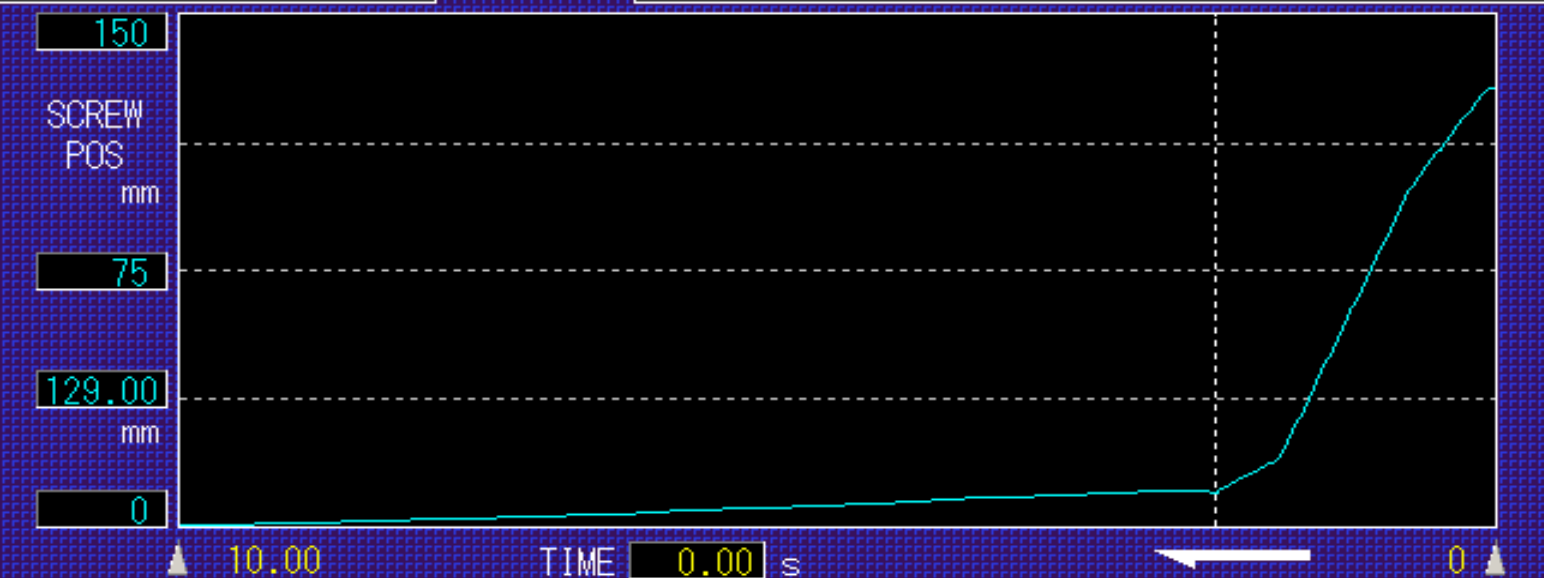
INJ PRFL TITLE mystery mold MEMORY 003 ALTER RUN 01/03/07 12:00

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCATR

		H N	H 1	H 2	H 3	THROAT
ACT	°F	438.0	470.8	455.0	442.4	127.9
DEV	°F	-1.9	0.8	-5.0	-7.6	
ON RATIO %		16	4	42	80	

INJECTION	0.00	s	SCREW POS	129.00	mm	CLAMP	220	tf
COOL	16.59	s	PLATEN POS	0.0	mm	INJ/BP PRESS	20	PSI
INTERVAL	0.00	s	EJECT POS	28.1	mm	SCREW SPEED	0	rpm

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



MIN-CUSH 0.19 mm SHIFT POS 6118 PSI INJ START 129.00 mm

9.99 mm

SETUP DISPLAY HORIZON SELECT SP/PRESS PROFILE VERTICAL CHANGE OVERLAP OFF GRAPH

LIST TEMP
CLAMP INJECT
PROD MON
OPTION REC

SHORTCUT
TOOL

SNAP SHOT
MESSAGE LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

M.T.SETTING IS NOT FINISHED (1/2) MEMORY 000 ALTER RUN 04/24/06 15:05

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

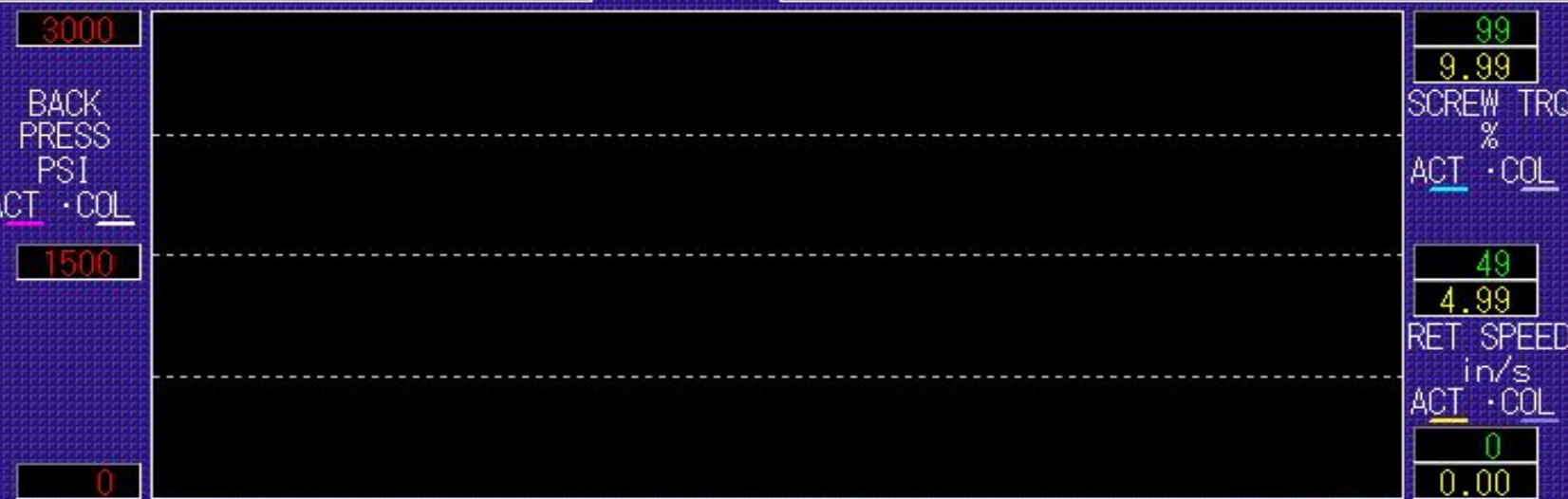
MAINT

CALCLATR

		H N	H 1	H 2	H 3		THROAT
ACT	°F	999.9	999.9	999.9	999.9		999.9
DEV	°F	***	***	***	***		
ON RATIO %		0	0	0	0		

INJECTION	0.00	s	SCREW POS	5.039	in	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	10.00	in	INJ/BP PRESS	87	PSI
INTERVAL	0.00	s	EJECT POS	0.00	in	SCREW SPEED	0	min-1

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



0.0

SCREW POS

5.039

in

4.289

SCREW SP

0

min-1

CHARGE TIME

0.00

s

CHG CMPLT

0.00

in

PROFILE COLECT

COLLECT START

CURSOR DISPLAY

BP

87

PSI

VERTICAL SCALE

OVERLAP OFF

GRAPH

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

CHG PRFL TITLE frisby MEMORY 001 ALTER RUN 05/08/06 15:03

ACT VAL MONITOR MON TAB

TRQ MONITOR OFF

DELAY 0.00

REC 0.00

ACT	0.0	%
MAX	0.0	%
MIN	0.0	%
AVG	0.0	%

VERTICAL

	BACK PRESS	SCREW TRQ	SCRW RET SPD
	ON	ON	ON
MAX	1500	30	1.00
MIN	0	0	0.00
	PSI	%	in/s

LIST

TEMP °F

CLAMP

INJECT

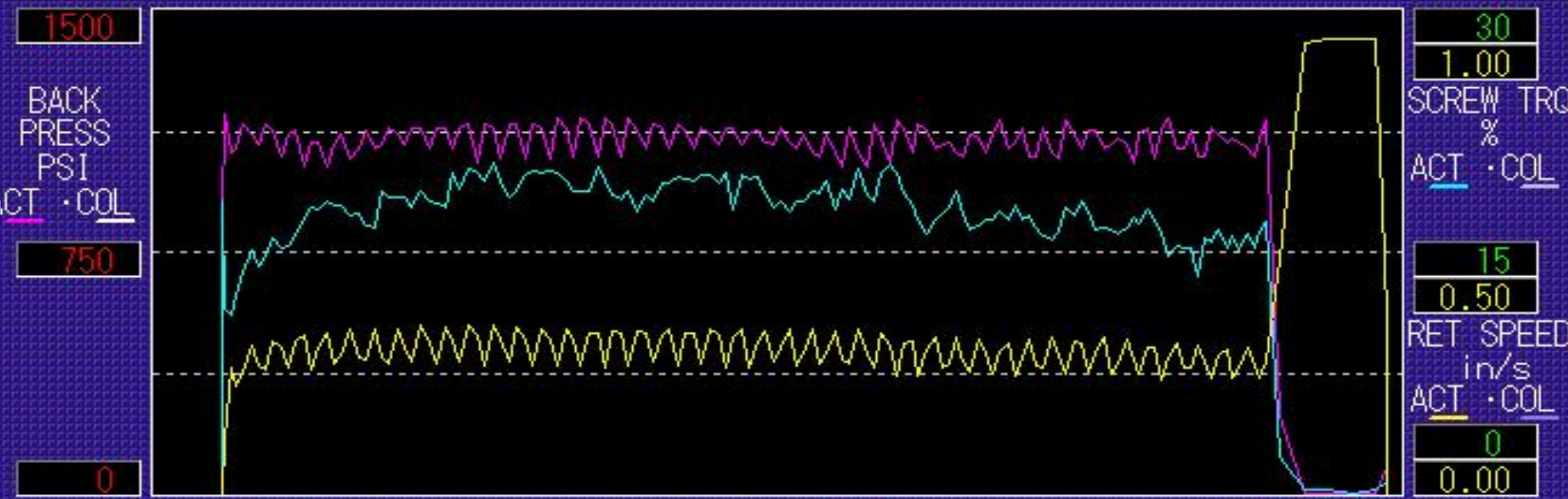
PROD 9999

MON

OPTION OPT

REC

INJECT INJ SET INJ PR



SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

CURSOR DISPLAY

SCREW SP 0 min-1

BP 3636 PSI

SCREW POS 0.144 in

CHARGE TIME 10.64 s

CHG CMPLT 3.30 in

PROFILE COLECT

COLLECT START

VERTICAL SCALE

OVERLAP OFF

GRAPH

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

AT PURGE TITLE frisby MEMORY 001 ALTER RUN 05/08/06 15:05

ACT VAL

TRQ MONITOR
OFF

ACT 0.0 %
MAX 0.0 %
MIN 0.0 %
AVG 0.0 %

MONITOR

DELAY 0.00
REC 0.00

MON TABLE

☐ X000 ☐ X001 ☐ X002 ☐ X003
☐ X004 ☐ X005 ☒ X006 ☒ X007
☒ X008 ☒ X009 ☒ X00A ☐ X00B

☐ = ON ☒ = OFF

SEQ MON < >

PROD

REGISTER No.
P442

TIMER/COUNT
12000

SET MON

RESET

HISTORY

SPEC
CLAMP INJ

MAINT
DISPLAY

VERSION
DISPLAY

PROFILE

MAINT

CALCLATR

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR

SCREW POS 2.007 in
TIME 0.00 s

INJ PRESS 1150 PSI
COUNT REMAIN 3

PURGE MODE
OFF
PROGRAM
SCREW SPD

COMPLETE
COUNT
TIME

COUNTER 3

AT PURGE 70.00 s

SCREW SPEED 120 min-1

LIST

TEMP °F

CLAMP

INJECT

PROD 9999

MON

OPTION OPT

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

MACHINE IS AUTO PURGING

MEMORY 001

ALTER

RUN

05/08/06 15:45

ACT VAL		MONITOR	MON TABLE	PROD	HISTORY	PROFILE	MAINT	CALCLATR
shots	FILL s	CHARGE s	TAKEOUT s	CYCLE s	MIN-CUSH in	CUSH in	SCREW SPD min-1	INJ START in
60	2.97	10.84 *	2.41	21.95	0.146 *	0.162 *	119	3.650
61	2.97	10.87 *	2.40	21.95	0.150 *	0.168 *	119	3.650
62	3.03 *	10.78 *	2.40	21.95	0.152 *	0.170 *	119	3.650
63	3.03 *	10.60 *	2.41	21.95	0.157 *	0.174 *	119	3.650

FILL TIME
3.03 s

CHARGE TIME
10.60 s

MIN-CUSH
0.157 in

ACT-CUSH
0.174 in

FPC PRESS
5356 PSI

INJ START
3.650 in

INJECT

INJ SET

INJ PRFL

CHG PRFL

AT PURGE

LAMINAR

SCREW POS
3.650 in
TIME
14.88 s

INJ PRESS
547 PSI

SCREW SPEED
50 min-1

PURGE MODE

OFF
PROGRAM
SCREW SPD

SCRWSPEED
80.00 s



SRNPG
50 min-1

LIST



TEMP



CLAMP



INJECT



PROD

9999

MON



OPTION



REC



SHORTCUT



TOOL



SNAP
SHOT



MESSAGE



LADDER



SUP-
PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

AT PURGE PRD CODE E,J, Brooks MEMORY 002 ALTER RUN 10/06/06 12:02

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

		H N	H 1	H 2	H 3	THROAT
ACT	°F	389.6	400.1	389.8	380.3	89.2
DEV	°F	-0.1	0.1	0.0	0.3	
ON RATIO %		11	3	3	18	

INJECTION	0.00	s	SCREW POS	0.00	mm	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	340.0	mm	INJ/BP PRESS	221	PSI
INTERVAL	0.00	s	EJECT POS	0.0	mm	SCREW SPEED	0	rpm

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR

SCREW POS 0.00 mm INJ PRESS 161 PSI SCREW SPEED 0 rpm

TIME 0.00 s COUNT REMAIN 4

PURGE MODE
OFF
PROGRAM
SCREW SPD

COMPLETE
COUNT
TIME

COUNTER
4

AT PURGE
70.00 s

PURGE
2.00 s

FIRST CHG
3.00 s

ADV CHG
5.00 s

RET CHG
2.00 s

PIPG
10000 PSI

BPPG
700 PSI

LS5PG
100.00 mm

VIPG
70.0 mm/s

SRNPG
170 rpm

LIST TEMP

CLAMP INJECT

PROD MON

OPTION REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

shots	FILL s	CHARGE s	TAKEOUT s	CYCLE s	MIN-CUSH in	CUSH in	SCREW SPD min-1	INJ START in
60								3.650
61								3.650
62								3.650
63								3.650

LIST

TEMP
°F

CLAMP

INJECT

PROD
9999

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

PURGE (PROGRAM)

DATA SETTING OF THE AUTO PURGE CONDITIONS.
SELECTION OF THE PURGE CONDITIONS AND PUSH THE EXEC KEY.

		PRODUCT	PREVIOUS	INITIAL
PURGE PRESS	PSI	6300	0	6300
PURGE SPEED	in/s	8.00	0.00	1.96
PURGE TIME	s	6.00	0.00	2.68
BACK	PSI	1100	0	1100
SCREW SPEED	min-1	120	50	120
RETRACT LIMIT	in	3.300	0.000	3.300

EXEC

PIPG 0 PSI

BPPG 0 PSI

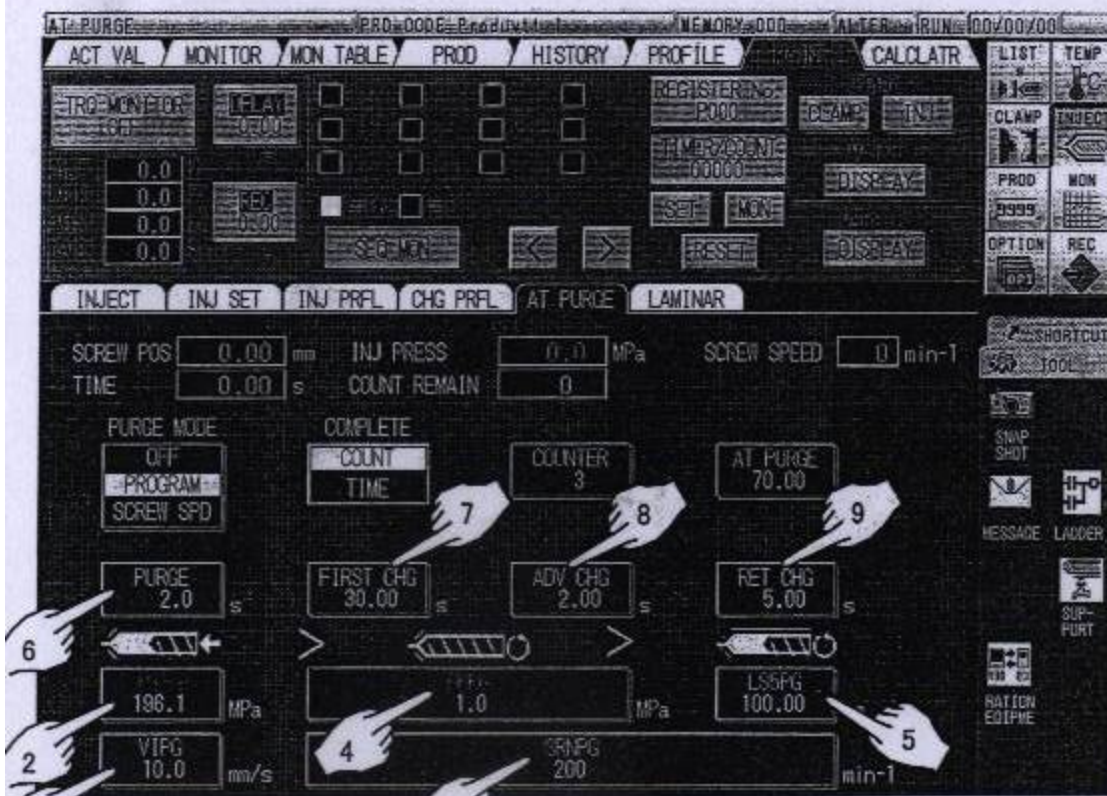
LS5PG 0.000 in

VIPG 0.00 in/s

SRNPG 50 min-1

Item	Production conditions	Previous conditions	Initial values
Purge time	Injection time setting	Purge time setting	(LS5 setting/50) + 1
Purge out position	LS4 setting	Purge out position setting	LS4 setting
Initial charge time	30(s)	Initial charge time setting	30(s)
Advance limit charge time	2(s)		2(s)
Retract limit charge time	5(s)		5(s)
Purge pressure: PIPG	PI1 setting	PIPG setting	PI1 setting
Purge speed: VIPG	VI1 setting	VIPG setting	50(mm/s)
Back pressure: BPPG	BP setting	BPPG setting	BP setting
Screw speed: SRNPG	SRN setting	SRNPG setting	SRN setting
Screw retract limit: LS5PG	LS5 setting	LS5PG setting	LS5 setting

* Read respective values to set automatic purge conditions. Such setting will not be reflected on production conditions, however. These values function as exclusive conditions for automatic purging even after setting change.



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

AT PURGE PRD CODE E,J, Brooks MEMORY 002 ALTER RUN 10/06/08 12:02

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCATR

		H N	H 1	H 2	H 3		THROAT
ACT	°F	390.0	399.9	389.8	380.1		89.0
DEV	°F	0.1	0.0	0.0	0.1		
ON RATIO %		11	10	4	18		

INJECTION	0.00	s	SCREW POS	0.00	mm	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	340.0	mm	INJ/BP PRESS	211	PSI
INTERVAL	0.00	s	EJECT POS	0.0	mm	SCREW SPEED	0	rpm

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR

LIST TEMP

CLAMP INJECT

PROD MON

OPTION REC

SCREW POS 0.00 mm INJ PRESS 151 PSI SCREW SPEED 0 rpm

TIME 0.00 s TIME REMAIN 70.0 s

PURGE MODE

OFF

PROGRAM

SCREW SPD

COMPLETE

COUNT

TIME

COUNTER

4

AT PURGE

70.00

s

PURGE

2.00

s

FIRST CHG

3.00

s

ADV CHG

5.00

s

RET CHG

2.00

s

PIPG

10000

PSI

BPPG

700

PSI

LS5PG

100.00

mm

VIPG

70.0

mm/s

SRNPG

170

rpm

SHORTCUT TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

LAMINAR TITLE frisby MEMORY 001 ALTER RUN 05/08/06 15:07

ACT VAL MONITOR MON TABLE PROD HIST

TRQ MONITOR
OFF

DELAY
0.00
s

ACT 0.0 %
MAX 0.0 %
MIN 0.0 %
AVG 0.0 %

REC
0.00
s

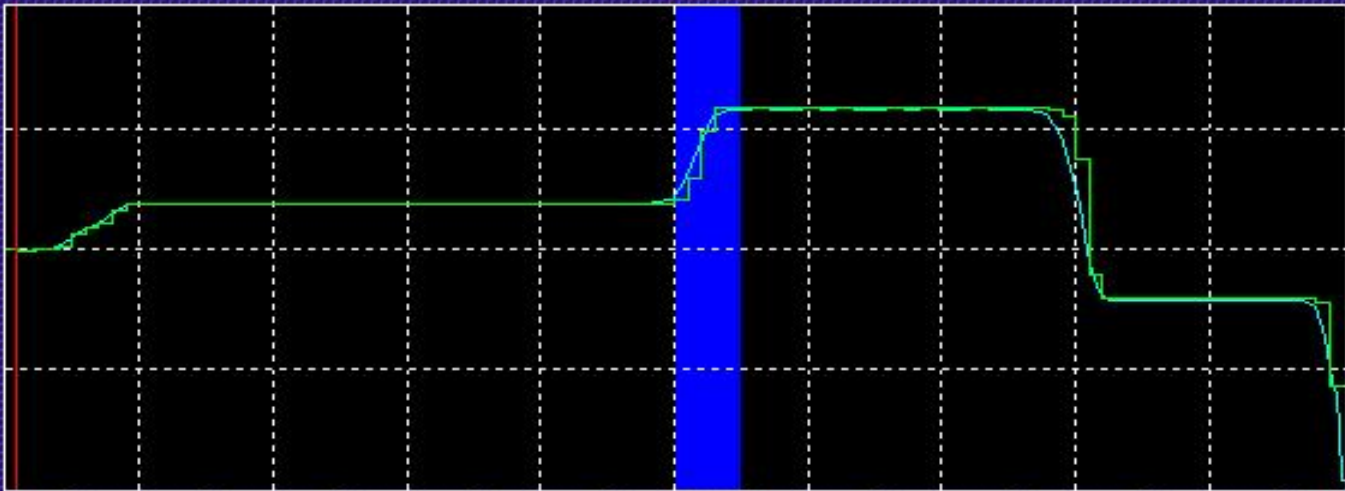
☐ X000 ☐ X001 ☐ X002
☐ X004 ☐ X005 ☐ X006
☐ X008 ☐ X009 ☐ X00A

☐ =ON ☐ =OFF
SEQ MON

REF SAMPLING

OFF · START · CMPL

INJECT INJ SET INJ PRFL CHG PRFL AT PURGE LAMINAR



2
INJ SPEED
in/s
1
SET ACT
0

0.567 0.909 1.252 1.594 1.937 2.279 2.622 2.965 3.307 3.650 in

LAMINAR ON REF SAMPL > VI449 1.20 VI448 1.29 VI447 1.49 VI446 1.59 VI445 1.59 in/s

VERTICAL SCALE < LS449 1.937 LS448 1.971 LS447 2.005 LS446 2.040 LS445 2.074 LS444 2.108 in

LIST TEMP
CLAMP INJECT
PROD MON
9999
OPTION REC
OPT

SHORTCUT TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 013 ALTER RUN 03/06/13 11:14

ACT VAL		MONITOR		MON TABLE		PROD		HISTORY		PROFILE		MAINT		CALCLATR	
shots	FILL	CHARGE	INJ START	CYCLE TIME	CUSH	MIN-CUSH	FPC PRESS	TAKEOUT							
	s	s	in	s	in	in	PSI	s							
22509	1.68	6.28	2.379	25.47	0.207	0.207	9518	8.97							
22510	1.68	6.41	2.379	25.43	0.197	0.197	8859	8.92							
22511	1.68	6.65	2.379	25.43	0.186	0.186	8190	8.93							
FILL TIME		CHARGE TIME		MIN-CUSH		ACT-CUSH		FPC PRESS		INJ START					
2.86		s		1.56		s		0.244		in		0.244		in	
								8190		PSI		2.467		in	

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 013 ALTER RUN 03/06/13 11:14

ACT VAL / MONITOR / MON TABLE / PROD / HISTORY / PROFILE / MAINT / CALCLATR

shots	FILL	CHARGE	INJ START	CYCLE TIME	CUSH	MIN-CUSH	FPC PRESS	TAKEOUT
	s	s	in	s	in	in	PSI	s
22509	1.68	6.28	2.379	25.47	0.207	0.207	9518	8.97
22510	1.68	6.41	2.379	25.43	0.197	0.197	8859	8.92
22511	1.68	6.65	2.379	25.43	0.186	0.186	8190	8.93

FILL TIME

2.86 s

CHARGE TIME

1.56 s

MIN-CUSH

0.244 in

ACT-CUSH

0.244 in

FPC PRESS

8190 PSI

INJ START

2.467 in

INJECT / INJ SET / INJ PRFL / CHG PRFL / AT PURGE / LAMINAR / AUTO AJD / V.GATE1

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

1

UNUSED

OPEN MODE SELECT

POS.

TR

POS. (in)

VG01OP

0.000

TIMER (s)

VG01OT

0.00

CLOSE MODE SELECT

POS.

TR

POS. (in)

VG01CP

0.000

TIMER (s)

VG01CT

0.00

SHORTCUT

TOOL

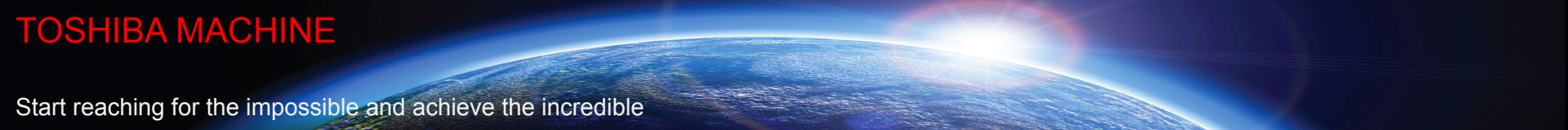
SNAP SHOT

MESSAGE

LADDER

SUP-PORT

LAN-GUAGE



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

Production Screens

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:30

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

	H N	H 1	H 2	H 3		THROAT
ACT °F	80.7	77.9	77.1	75.9		72.8
DEV °F	-.*. *	-.*. *	-.*. *	-.*. *		
ON RATIO %	0	31	37	100		

INJECTION	0.00	s	SCREW POS	0.00	mm	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	340.1	mm	INJ/BP PRESS	0	PSI
INTERVAL	0.00	s	EJECT POS	0.0	mm	SCREW SPEED	0	rpm

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

PROD MGT PRD GRPH START UP PRD PLAN

PRODUCTION SETUP

COUNT SEL

TOTAL SHOT

GOOD SHOT

TOTAL PROD

GOOD PROD

SHOTWEIGHT 0.0 g

REQUIRED 100000 shots

CAVITY 16

PROD WEIGHT 0.0 g

REJECT SHOT 0 shots

PRODUCT

940 shots

RESET

GOOD 15040

REJECT 0

COUNTER 1

0 shots

RESET

GOOD 0

REJECT 0

UNUSED

COUNTER 2

0 shots

RESET

GOOD 0

REJECT 0

UNUSED

AFTER PROD COMPLETE

MOLDING

CONTINUE

STOP

DATA CHANGE

OFF

NEXT MEMO No

MEMORY 000

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:30

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALC LTR

		H N	H 1	H 2	H 3		THROAT
ACT	°F	79.1	77.7	76.8	74.6		72.8
DEV	°F	-**.*	-**.*	-**.*	-**.*		
ON RATIO %		0	22	30	100		

INJECTION	0.00	s	SCREW POS	0.00	mm	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	340.1	mm	INJ/BP PRESS	40	PSI
INTERVAL	0.00	s	EJECT POS	0.0	mm	SCREW SPEED	0	rpm

LIST TEMP

CLAMP INJECT

PROD MON

OPTION REC

PROD MGT PRD GRPH START UP PRD PLAN

PRODUCTION SETUP

COUNT SEL

TOTAL SHOT

GOOD SHOT

TOTAL PROD

GOOD PROD

SHOTWEIGHT 0.0 g

REQUIRED 100000

CAVITY 16

PROD WEIGHT 0.0 g

REJECT SHOT 0 shots

PRODUCT

15040

RESET

GOOD 15040

REJECT 0

COUNTER 1

0

RESET

GOOD 0

REJECT 0

UNUSED

COUNTER 2

0

RESET

GOOD 0

REJECT 0

UNUSED

AFTER PROD COMPLETE

MOLDING

CONTINUE

STOP

DATA CHANGE

OFF

NEXT MEMO No

MEMORY 000

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:30

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

	H N	H 1	H 2	H 3	
ACT °F	79.1	77.7	76.8	74.6	THROAT 72.8
DEV °F	-.*. *	-.*. *	-.*. *	-.*. *	
ON RATIO %	0	22	30	100	

INJECTION	0.00	s	SCREW POS	0.00	mm	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	340.1	mm	INJ/BP PRESS	40	PSI
INTERVAL	0.00	s	EJECT POS	0.0	mm	SCREW SPEED	0	rpm

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

PROD MGT PRD GRPH START UP PRD PLAN

PRODUCTION SETUP

COUNT SEL

TOTAL SHOT

GOOD SHOT

TOTAL PROD

GOOD PROD

SHOTWEIGHT 0.0 g

REQUIRED 100000

CAVITY 16

PROD WEIGHT 0.0 g

REJECT SHOT 0 shots

PRODUCT

15040

RESET

GOOD 15040

REJECT 0

COUNTER 1

0

RESET

GOOD 0

REJECT 0

UNUSED

COUNTER 2

0

RESET

GOOD 0

REJECT 0

UNUSED

AFTER PROD COMPLETE

MOLDING

CONTINUE

STOP

DATA CHANGE

OFF

NEXT MEMO No

MEMORY 000

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 002

ALTER

RUN

10/11/06 10:32

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

			H N	H 1	H 2	H 3		THROAT
ACT	°F		86.5	84.0	85.6	95.5		73.2
DEV	°F		-.*. *	-.*. *	-.*. *	-.*. *		
ON RATIO %			14	61	55	100		
INJECTION	0.00	s	SCREW POS	0.00	mm	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	340.1	mm	INJ/BP PRESS	0	PSI
INTERVAL	0.00	s	EJECT POS	0.0	mm	SCREW SPEED	0	rpm

PROD MGT PRD GRPH START UP PRD PLAN

RUN RATIO 0 %

ELAPSED PROCESS 0 %

PRODUCT CODE GOOD SHOT

REQUIRED 100000

CAVITY 16

SHOT COUNTER 0 shots

GOOD SHOT 0 shots

REMAIN SHOT 100000 shots

TOTAL PROD 0

GOOD 0

REJECT 0

REMAIN PROD 1600000

REQUIRED RESET

REJECT RATIO 0 %

RESIN USED 0 kg

ESTIMATE RESIN 0 kg

TRANSFER

GOOD→REJECT 0

REJECT→GOOD 0

SET 0 SET 0

PROD START TIME

10/11 10:32

PROD REMAIN TIME

218 hr 54 min

LAST CYCLE TIME

7.88 s

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

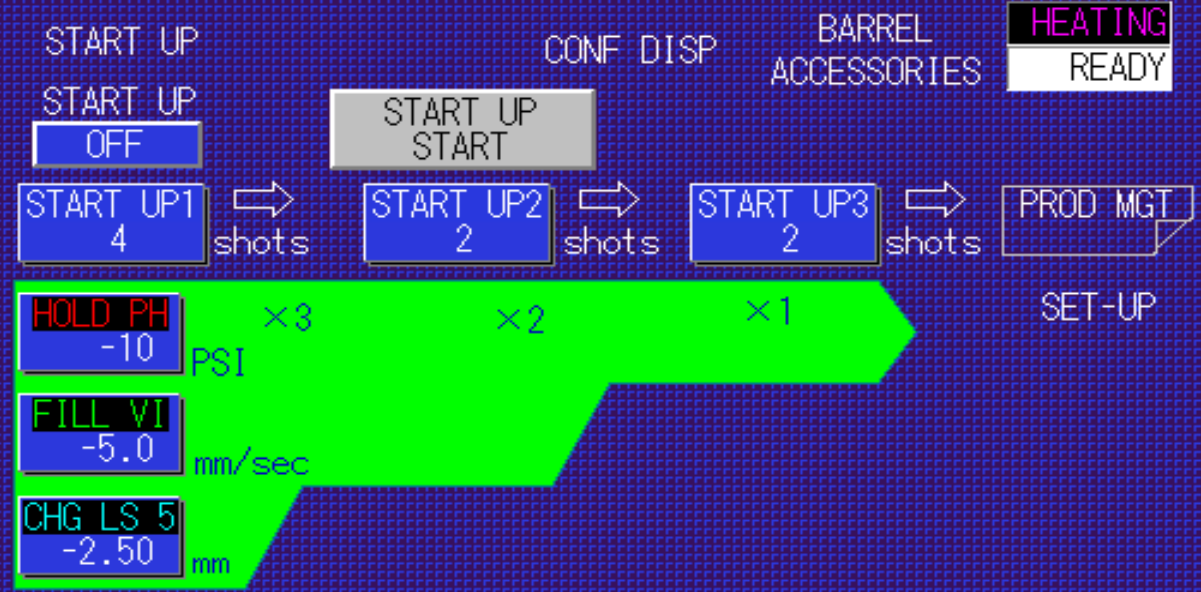
COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:33

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

			H N	H 1	H 2	H 3		THROAT
ACT	°F		95.0	90.3	93.0	109.5		73.7
DEV	°F		-.*. *	-.*. *	-.*. *	-.*. *		
ON RATIO %			25	80	73	100		

INJECTION	0.00	s	SCREW POS	0.00	mm	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	340.1	mm	INJ/BP PRESS	0	PSI
INTERVAL	0.00	s	EJECT POS	0.0	mm	SCREW SPEED	0	rpm

PROD MGT PRD GRPH START UP PRD PLAN



LIST TEMP

CLAMP INJECT

PROD MON

OPTION REC

SHORTCUT TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:33

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

ACT °F
DEV °F
ON RATIO %

H N	H 1	H 2	H 3
98.7	93.0	96.0	114.4
-**.*	-**.*	-**.*	-**.*
24	84	75	100

THROAT
74.1

INJECTION	0.00	s	SCREW POS	0.00	mm	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	340.1	mm	INJ/BP PRESS	0	PSI
INTERVAL	0.00	s	EJECT POS	0.0	mm	SCREW SPEED	0	rpm

LIST

CLAMP

PROD

OPTION

TEMP °F

INJECT

MON

REC

PROD MGT PRD GRPH START UP PRD PLAN

ORDER	MEMO No.	PRODUCT CODE	REQUIRED	MOLDING
1	0	E,J. Brooks	100000	STOP
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
15				
16				
17				
18				
19				
20				

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

The Monitor Management Screens

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:33

DET. SET TABLE1 TABLE2 TREND1 TREND2 L RESULT

PROCESS MON				
PROCESS ALARM	MONITOR DATA	OVER LIMIT	ALARM	STOP OPERATION SELECT
CYCLE TIME	7.88 s	0.00 s	OFF	CYCLE STOP
FILL TIME	0.60 s	0.00 s	OFF	MOLD OP LIMIT
CHARGE TIME	0.00 s	0.00 s	OFF	EJECT FIN POS
CHG TRQ DECREASE	0.0 %	0.0 %	OFF	EJECT FIN POS
CHG TRQ OVER	0.0 %	0.0 %	OFF	EJECT FIN POS
MOLD PROTECTION				EJECT FIN POS

QUALITY WATCH				
MONITORING ALARM	0 shots	0 shots	OFF	MOLD OP LIMIT
<input type="radio"/> CHARGE	<input type="radio"/> SAFETY GATE OPEN	<input type="radio"/> HEN TEMP	<input type="radio"/> H3 TEMP	
<input type="radio"/> FPC PRESS	<input type="radio"/> CUSH	<input type="radio"/> HN TEMP	<input type="radio"/> CYCLE	
<input type="radio"/> CYCLE	<input type="radio"/> INJ PEAK	<input type="radio"/> H1 TEMP	<input type="radio"/> H5 TEMP	
<input type="radio"/> TAKEOUT	<input type="radio"/> FILL	<input type="radio"/> H2 TEMP	<input type="radio"/> THROAT	

OPERATION

OPERATION BUZZER

MAN OFF

UNMAN OFF

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:34

DET SET TABLE1 TABLE2 TREND1 TREND2 L RESULT

PROCESS MON				
PROCESS ALARM	MONITOR DATA	OVER LIMIT	ALARM	STOP OPERATION SELECT
CYCLE TIME	7.88 s	0.00 s	OFF	CYCLE STOP
FILL TIME	0.60 s	0.00 s	OFF	MOLD OP LIMIT
CHARGE TIME	0.00 s	0.00 s	OFF	EJECT FIN POS
CHG TRQ DECREASE	0.0 %	0.0 %	OFF	EJECT FIN POS
CHG TRQ OVER	0.0 %	0.0 %	OFF	EJECT FIN POS
MOLD PROTECTION				EJECT FIN POS

QUALITY WATCH		
MONITORING ALARM	0 shots	0
<input type="radio"/> CHARGE	<input type="radio"/> SAFETY GATE	
<input type="radio"/> FPC PRESS	<input type="radio"/> CUSH	
<input type="radio"/> CYCLE	<input type="radio"/> INJ PEAK	
<input type="radio"/> TAKEOUT	<input type="radio"/> FILL	

OPERATION

OPERATION BUZZER

MAN OFF

UNMAN OFF

CYCLE TIME STOP OPERATION SELECT

☒ CYCLE STOP

☐ MLD OP LIMIT(NZL BACK)

☐ MOLD OP LIMIT

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:33

DET. SET TABLE1 TABLE2 TREND1 TREND2 L RESULT

PROCESS MON				
PROCESS ALARM	MONITOR DATA	OVER LIMIT	ALARM	STOP OPERATION SELECT
CYCLE TIME	7.88 s	0.00 s	OFF	CYCLE STOP
FILL TIME	0.60 s	0.00 s	OFF	MOLD OP LIMIT
CHARGE TIME	0.00 s	0.00 s	OFF	EJECT FIN POS
CHG TRQ DECREASE	0.0 %	0.0 %	OFF	EJECT FIN POS
CHG TRQ OVER	0.0 %	0.0 %	OFF	EJECT FIN POS
MOLD PROTECTION				EJECT FIN POS

QUALITY WATCH				
MONITORING ALARM	0 shots	0 shots	OFF	MOLD OP LIMIT
<input type="radio"/> CHARGE	<input type="radio"/> SAFETY GATE OPEN	<input type="radio"/> HEN TEMP	<input type="radio"/> H3 TEMP	
<input type="radio"/> FPC PRESS	<input type="radio"/> CUSH	<input type="radio"/> HN TEMP	<input type="radio"/> CYCLE	
<input type="radio"/> CYCLE	<input type="radio"/> INJ PEAK	<input type="radio"/> H1 TEMP	<input type="radio"/> H5 TEMP	
<input type="radio"/> TAKEOUT	<input type="radio"/> FILL	<input type="radio"/> H2 TEMP	<input type="radio"/> THROAT	

OPERATION

OPERATION BUZZER

MAN OFF

UNMAN OFF

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/08/07 15:31

DET SET TABLE1 TABLE2 TREND1 TREND2 L RESULT

PROCESS MON				
PROCESS ALARM	MONITOR DATA	OVER LIMIT	ALARM	STOP OPERATION SELECT
CYCLE TIME	35.20 s	36.00 s	ON	CYCLE STOP
FILL TIME	0.71 s	0.80 s	ON	MOLD OP LIMIT
CHARGE TIME	2.97 s	3.50 s	ON	EJECT FIN POS
CHG TRQ DECREASE	0.0 %	0.0 %	OFF	EJECT FIN POS
CHG TRQ OVER	0.0 %	0.0 %	OFF	EJECT FIN POS
MOLD PROTECTION				EJECT FIN POS

QUALITY WATCH				
MONITORING ALARM	0 shots	4 shots	ON	EJECT FIN POS
<input checked="" type="radio"/> CHARGE	<input type="radio"/> MIN-CUSH	<input type="radio"/> HEN TEMP	<input checked="" type="radio"/> H3 TEMP	
<input type="radio"/> FPC PRESS	<input type="radio"/> CUSH	<input checked="" type="radio"/> HN TEMP	<input type="radio"/> H5 TEMP	
<input checked="" type="radio"/> TAKEOUT	<input type="radio"/> INJ PEAK	<input checked="" type="radio"/> H1 TEMP	<input type="radio"/> THROAT	
<input checked="" type="radio"/> CYCLE	<input checked="" type="radio"/> FILL	<input checked="" type="radio"/> H2 TEMP		

OPERATION

OPERATION	BUZZER	SIGNAL TOWER
MAN	ON	LIGHT
UNMAN	OFF	OFF

LIST

CLAMP

PROD

OPTION

TEMP

INJECT

MON

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 002

ALTER

RUN

10/11/06 10:34

DET. SET	TABLE1	TABLE2	TREND1	TREND2	L RESULT			
shots	CHARGE	FPC PRESS	CYCLE	TAKEOUT	SAF GATE OP TIME	CUSH	INJ PEAK	FILL
	s	PSI	s	s	s	mm	PSI	s
774	0.00	0*	7.60*	4.56*	0.00	0.00*	0*	0.00*
775	0.00	0*	7.60*	4.56*	0.00	0.00*	0*	0.00*
776	0.00	28*	7.60*	4.55*	0.00	0.00*	28*	0.00*
777	0.00	0*	7.59*	4.55*	0.00	0.00*	0*	0.00*
778	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
779	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
780	0.00	0*	7.59*	4.55*	0.00	0.00*	0*	0.00*
781	0.00	0*	7.59*	4.55*	0.00	0.00*	0*	0.00*
782	0.00	0*	7.59*	4.55*	0.00	0.00*	0*	0.00*
783	0.00	14*	7.60*	4.55*	0.00	0.00*	14*	0.00*
784	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
785	0.00	0*	7.60*	4.56*	0.00	0.00*	0*	0.00*
786	0.00	14*	7.60*	4.55*	0.00	0.00*	28*	0.00*
787	0.00	14*	7.60*	4.55*	0.00	0.00*	14*	0.00*
788	0.00	14*	7.60*	4.55*	0.00	0.00*	14*	0.00*
789	0.00	14*	7.60*	4.56*	0.00	0.00*	14*	0.00*
790	0.00	14*	7.60*	4.55*	0.00	0.00*	14*	0.00*
791	0.00	28*	7.59*	4.55*	0.00	0.00*	28*	0.00*
792	0.00	28*	7.59*	4.55*	0.00	0.00*	28*	0.00*
793	0.00	14*	7.60*	4.55*	0.00	0.00*	28*	0.00*
794	0.00	0*	7.60*	4.56*	0.00	0.00*	0*	0.00*
795	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
796	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
797	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
798	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

OPT

SHORTCUT
TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

START No. 0 shots MON SHOT No. SET

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:34

DET.	SET	TABLE1	TABLE2	TREND1	TREND2	L RESULT			
shots	CHARGE	FPC PRESS	CYCLE	TAKEOUT	SAF GATE OP TIME	CUSH	INJ PEAK	FILL	
	s	PSI	s	s	s	mm	PSI	s	
774	0.00	0*	7.60*	4.56*	0.00	0.00*	0*	0.00*	↑
775	0.00	0*	7.60*	4.56*	0.00	0.00*	0*	0.00*	

SELECT ITEMS

ITEM MOVE KEY<>

CLOSE TIME

FILL

CHARGE

OPEN TIME

EJECT

TAKE

CYCLE

SAFETY GATE

TIME

MIN CUSH

CUSH

SHIFT POS

INJ START

SCREW SPD

FPC PRESS

INJ PEAK

LS4A INJ-P

LS4B INJ-P

LS4C INJ-P

LS4D INJ-P

LS4E INJ-P

LS4F INJ-P

LS4G INJ-P

LS4H INJ-P

LS4I INJ-P

INJ STROKE

MAX INJ STROKE

CHARGE TORQUE

HN

H1

H2

H3

THROAT

BLANK

781	0.00	28*	7.58*	4.55*	0.00	0.00*	28*	0.00*	
792	0.00	28*	7.59*	4.55*	0.00	0.00*	28*	0.00*	↓
793	0.00	14*	7.60*	4.55*	0.00	0.00*	28*	0.00*	↓
794	0.00	0*	7.60*	4.56*	0.00	0.00*	0*	0.00*	↓
795	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*	↓
796	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*	↓
797	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*	↓
798	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*	↓

START No. 0 shots MON SHOT No. SET

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

REC

OPTION

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 002

ALTER

RUN

10/11/06 10:34

DET.	SET	TABLE1	TABLE2	TREND1	TREND2	L RESULT		
shots		HN TEMP	H1 TEMP	H2 TEMP	H3 TEMP	CYCLE		THROAT
		°F	°F	°F	°F	s		°F
774		389.6	399.9	389.6	379.7	7.60*		122.0
775		390.2	400.2	389.6	379.9	7.60*		122.0
776		390.0	400.1	389.8	379.9	7.60*		122.0
777		390.0	400.1	389.8	379.7	7.59*		122.1
778		389.8	400.1	390.0	379.7	7.60*		122.1
779		389.8	400.1	389.8	379.9	7.60*		122.3
780		389.8	400.1	389.8	379.7	7.59*		122.3
781		389.8	399.9	390.0	379.9	7.59*		122.3
782		389.8	399.9	389.8	379.9	7.59*		122.3
783		389.8	400.1	389.8	379.7	7.60*		122.5
784		389.6	400.1	389.6	379.7	7.60*		122.5
785		389.6	400.1	389.8	379.9	7.60*		122.7
786		389.6	400.1	389.8	379.7	7.60*		122.7
787		389.6	400.1	389.8	379.9	7.60*		122.9
788		389.8	400.1	389.8	379.9	7.60*		122.9
789		390.0	400.1	389.8	379.9	7.60*		123.0
790		390.2	400.1	390.0	379.9	7.60*		123.0
791		390.0	400.1	389.8	380.1	7.59*		123.0
792		390.0	399.9	389.8	379.9	7.59*		123.0
793		389.6	399.9	389.8	379.9	7.60*		123.2
794		389.4	399.9	389.8	379.9	7.60*		123.2
795		389.4	399.9	389.8	379.7	7.60*		123.2
796		389.6	399.9	390.0	379.9	7.60*		123.4
797		389.8	400.1	389.8	379.9	7.60*		123.6
798		390.0	400.1	389.8	379.9	7.60*		123.4

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT
TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

START No. 0 shots MON SHOT No. SET

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:35

DET. SET		TABLE1		TABLE2		TREND1		TREND2		L RESULT	
shots		HN TEMP	H1 TEMP	H2 TEMP	H3 TEMP					THROAT	
		°F	°F	°F	°F					°F	
774		389.6	399.9	389.6	379.7					122.0	
775		390.2	400.2	389.6	379.9					122.0	

SELECT ITEMS

ITEM MOVE KEY<>

CLOSE TIME

FILL

CHARGE

OPEN TIME

EJECT

TAKE

CYCLE

SAFETY GATE

TIME

MIN CUSH

CUSH

SHIFT POS

INJ START

SCREW SPD

FPC PRESS

INJ PEAK

LS4A INJ-P

LS4B INJ-P

LS4C INJ-P

LS4D INJ-P

LS4E INJ-P

LS4F INJ-P

LS4G INJ-P

LS4H INJ-P

LS4I INJ-P

INJ STROKE

MAX INJ STROKE

CHARGE TORQUE

HN

H1

H2

H3

THROAT

BLANK

781		389.6	400.1	389.8	379.7					123.0	
792		390.0	399.9	389.8	379.9					123.0	
793		389.6	399.9	389.8	379.9					123.2	
794		389.4	399.9	389.8	379.9					123.2	
795		389.4	399.9	389.8	379.7					123.2	
796		389.6	399.9	390.0	379.9					123.4	
797		389.8	400.1	389.8	379.9					123.6	
798		390.0	400.1	389.8	379.9					123.4	

START No. 0shots MON SHOT No. SET

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

M.T.SETTING IS NOT FINISHED (1/2) MEMORY 000 ALTER RUN 04/24/06 15:08

DET. SET TABLE1 TABLE2 TREND1 TREND2 L RESULT

	FILL	CHARGE	TAKEOUT	CYCLE	MIN-CUSH	CUSH	SCREW SPD	INJ START
TOL	s	s	s	s	in	in	min-1	in
GRP WID	± 0.00	± 0.00	± 0.00	± 0.00	±0.000	±0.000	± 0	±0.000
DISP SHOT								
AUTO UPDATE								
LAST SHOT								
REF	0.00	0.00	0.00	0.00	0.000	0.000	0	0.000

0	0.00	0.00	0.00	0.00	0.000	0.000	0	0.000
0	0.00	0.00	0.00	0.00	0.000	0.000	0	0.000
0	0.00	0.00	0.00	0.00	0.000	0.000	0	0.000
0	0.00	0.00	0.00	0.00	0.000	0.000	0	0.000

TOL	± 0.00	± 0.00	± 0.00	± 0.00	±0.000	±0.000	± 0	±0.000
PRESET	ALM OFF	ALM OFF	ALM OFF	ALM OFF	ALM OFF	ALM OFF	ALM OFF	ALM OFF

L STA AREA S STATISTI Q MONITOR

LIST

CLAMP

PROD

9999

OPTION

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

TEMP

INJECT

MON

REC

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

01/09/07 10:11

DET. SET	TABLE1	TABLE2	TREND1	TREND2	L RESULT			
CHARGE	FPC PRESS	TAKEOUT	CYCLE	MIN-CUSH	CUSH	INJ PEAK	FILL	
s	PSI	s	s	mm	mm	PSI	s	
TOL	± 1.00	± 583	± 0.30	± 0.40	± 0.30	± 0.30	± 583	± 0.05
GRP WID								
55								
DISP SHOT								
40								
AUTO UPDATE								
LAST SHOT								
REF	14.20	5986	3.46	34.52	1.62	1.62	6043	2.66
37	14.44	6384	3.46	34.52	1.07*	1.07*	7579*	2.13*
38	14.01	6669*	3.47	34.51	1.81	1.81	7806*	2.13*
39	13.74	6683*	3.47	34.51	2.15*	2.15*	7892*	2.14*
40	13.92	6768*	3.47	34.51	2.13*	2.13*	7934*	2.14*
TOL	± 1.00	± 583	± 0.30	± 0.40	± 0.30	± 0.30	± 583	± 0.05
PRESET	ALM ON	ALM OFF	ALM ON	ALM ON	ALM OFF	ALM OFF	ALM OFF	ALM ON

tolerance>graph width

SET TOLERANCE VALUE TO GRAPH WIDTH.
IS IT OK?

YES CANCEL

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

L STA AREA

S STATISTI

Q MONITOR

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

01/09/07 10:11

DET. SET	TABLE1	TABLE2	TREND1	TREND2	L RESULT			
CHARGE	FPC PRESS	TAKEOUT	CYCLE	MIN-CUSH	CUSH	INJ PEAK	FILL	
s	PSI	s	s	mm	mm	PSI	s	
± 1.00	± 583	± 0.30	± 0.40	± 0.30	± 0.30	± 583	± 0.05	
GRP WID								
55								
DISP SHOT								
40								
AUTO UPDATE								
LAST SHOT								
REF	14.20	5986	3.46	34.52	1.62	1.62	6043	2.66
37	14.44	6384	3.46	34.52	1.07*	1.07*	7579*	2.13*
38	14.01	6669*	3.47	34.51	1.81	1.81	7806*	2.13*
39	13.74	6683*	3.47	34.51	2.15*	2.15*	7892*	2.14*
40	13.92	6768*	3.47	34.51	2.13*	2.13*	7934*	2.14*
TOL	± 1.00	± 583	± 0.30	± 0.40	± 0.30	± 0.30	± 583	± 0.05
PRESET	ALM ON	ALM OFF	ALM ON	ALM ON	ALM OFF	ALM OFF	ALM OFF	ALM ON

AUTO UPDATE>REFERENCE

SET AUTO UPDATE (MOVE AVG) TO REFERENCE VALUE.
IS IT OK?

YES CANCEL

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

L STA AREA

S STATISTI

Q MONITOR

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/10/07 12:02

DET. SET TABLE1 TA

START No. 00000~99999shots

- - - - -

0 1 0 0 0

+ + + + +

✖

📄

TOL CHARGE FPC PRESS

s PSI

± 1.00 ± 583

GRP WID 355

DISP SHOT

40

REF 12.75 5773 3.52 27.64 2.56 2.61 6256 1.93

LIST TEMP

CLAMP INJECT

PROD MON

9999

OPTION REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

LONG STATISTICS AREA SET

SET SAMPLE QTY & PRESS START BUTTON.

SAMPLE 0 shots START STOP

START No. 1000 shots

MON SHOT No. SET

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/10/07 12:01

DET. SET TABLE1 TABLE2 TREND1 TREND2 L RESULT

	CHARGE	FPC PRESS	TAKEOUT	CYCLE	MIN-CUSH	CUSH	INJ PEAK	FILL
	s	PSI	s	s	mm	mm	PSI	s
TOL	± 1.00	± 583	± 0.30	± 0.40	± 0.30	± 0.30	± 583	± 0.05
GRP WID	355							
DISP SHOT								
REF	12.75	5773	3.52	27.64	2.56	2.61	6256	1.93

LIST TEMP

CLAMP INJECT

PROD MON

9999

OPTION REC

OPT

SHORTCUT

TOOL

SNAP SHOT

2

MESSAGE LADDER

SUP-PORT

LONG STATISTICS AREA SET

SET SAMPLE QTY & PRESS START BUTTON.

SAMPLE 0 shots COLLECTING STOP

START No. 0 shots

MON SHOT No. SET

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:40

DET. SET

TABLE1

TABLE2

TREND1

TREND2

L RESULT

	CHARGE	FPC PRESS	CYCLE	TAKEOUT	SAF GATE OP TIME	CUSH	INJ PEAK	FILL
	s	PSI	s	s	s	mm	PSI	s
TOL								
GRP WID	± 1.00	± 583	± 0.40	± 0.30	± 0.00	± 0.30	± 583	± 0.05
299								
DISP SHOT								
798								
REF	0.00	0	7.60	4.				

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

SETS S STATISTIC RANGE.

START SH

1. PRESS GRAPH LOCK BUTTON.

2. SET STATISTIC RANGE.

3. PRESS ENT BTN TO DISP RESULTS.

GRAPH

LOCK

RELEASE

▲

100

▼

DISPLAY RANGE

50shots

100shots

200shots

☒

500shots

1000shots

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:41

DET. SET TABLE1 TABLE2 TREND1 TREND2 L RESULT

	CHARGE	FPC PRESS	CYCLE	TAKEOUT	SAF GATE OP TIME	CUSH	INJ PEAK	FILL
	s	PSI	s	s	s	mm	PSI	s
TOL	± 1.00	± 583	± 0.40	± 0.30	± 0.00	± 0.30	± 583	± 0.05
GRP WID	299							
DISP SHOT								
REF	0.00	0	7.60	4.55	0.00	0.00	0	0.00

LIST TEMP

CLAMP INJECT

PROD MON

9999

OPTION REC

OPT

SHORTCUT

TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

SETS S STATISTIC RANGE.

1. PRESS GRAPH LOCK BUTTON.

2. SET STATISTIC RANGE.

3. PRESS ENT BTN TO DISP RESULTS.

START SHOT 00299 FIN. SHOT 00798 SAMPLE 00500

100 10 1 ~ 100 10 1

ENT

GRAPH LOCK RELEASE

L STA AREA S STATISTI Q MONITOR

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

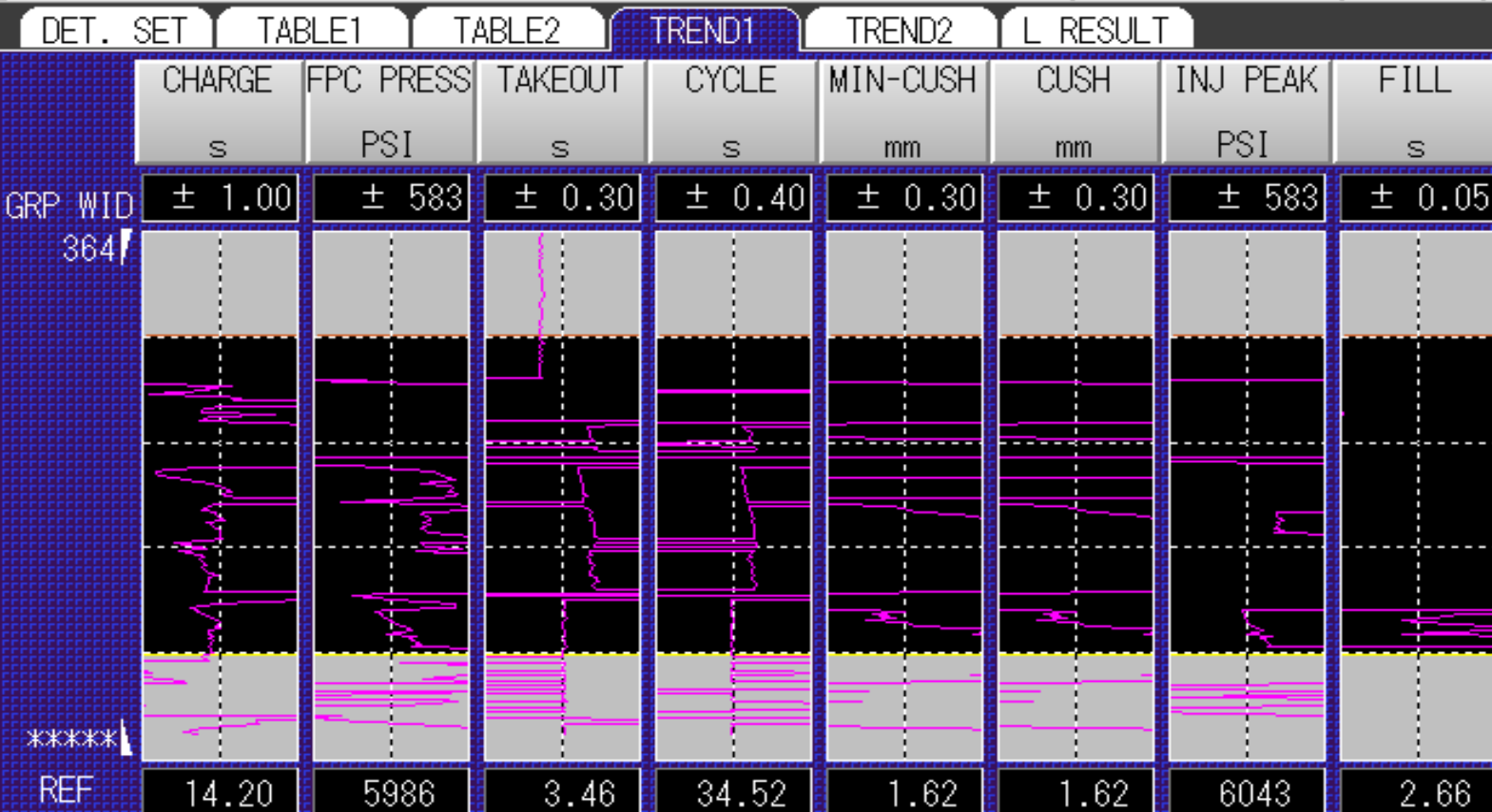
COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

01/10/07 11:58



MAX	42.35	9385	15.46	46.93	9.70	10.48	9427	2.76
MIN	0.00	14	0.00	0.62	0.00	0.00	28	0.00
AVG	12.75	5773	3.52	27.64	2.56	2.61	6264	1.93
MX-MN	42.35	9370	15.46	46.31	9.70	10.48	9399	2.76
REF	12.75	5773	3.52	27.64	2.56	2.61	6264	1.93
TOL	± 29.60	± 5759	± 11.94	± 27.02	± 7.13	± 7.86	± 6236	± 1.93

REF·TOL REFLECT

RE-CALC

RANGE 00010 ~ 00404 shots CALC DAT 07/01/10 11:58

L STA AREA

S STATISTI

Q MONITOR

LIST

TEMP

CLAMP

INJECT

PROD

9999

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

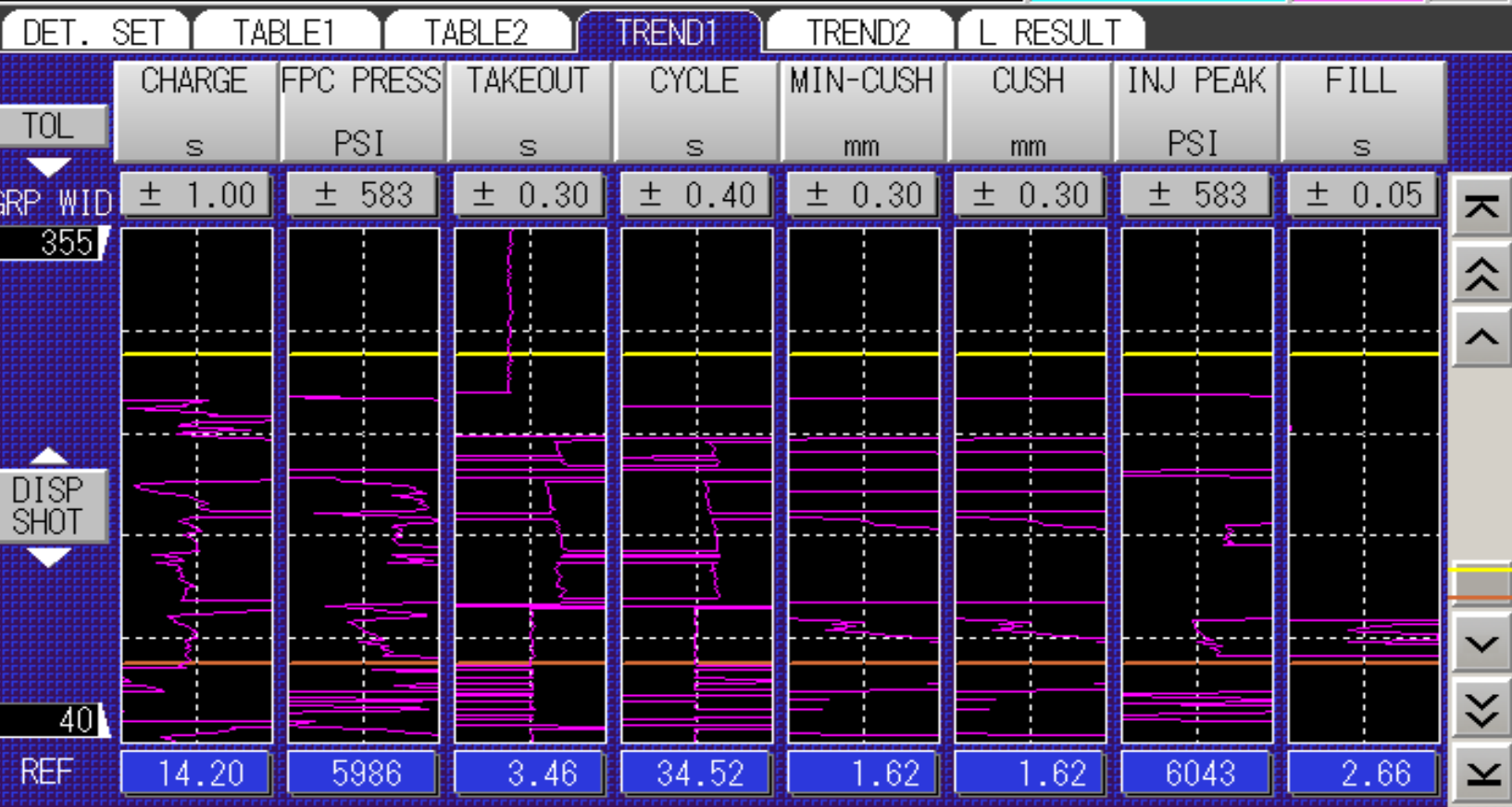
2

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/10/07 11:58



LIST

TEMP

CLAMP

INJECT

PROD

9999

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

SETS S STATISTIC RANGE. START SHOT 00404 FIN. SHOT 00010 SAMPLE 00121

- 1. PRESS GRAPH LOCK BUTTON.
- 2. SET STATISTIC RANGE.
- 3. PRESS ENT BTN TO DISP RESULTS.

GRAPH LOCK RELEASE

100 10 1 ~ 100 10 1

ENT

RESULT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:44

DET. SET TABLE1 TABLE2 TREND1 TREND2 L RESULT

TOL

GRP WID

63

DISP SHOT

798

AUTO UPDATE

LAST SHOT

REF

	HN TEMP	H1 TEMP	H2 TEMP	H3 TEMP			THROAT
	°F	°F	°F	°F			°F
	±95.0	±95.0	±95.0	±95.0			±20.0
	400.0	400.0	400.0	400.0			80.0

795		389.4	399.9	389.8	379.7		123.2
796		389.6	399.9	390.0	379.9		123.4
797		389.8	400.1	389.8	379.9		123.6
798		390.0	400.1	389.8	379.9		123.4
TOL		± 5.0	± 5.0	± 5.0	± 5.0		±20.0
PRESET		ALM OFF	ALM OFF	ALM OFF	ALM OFF		ALM OFF

L STA AREA S STATISTI Q MONITOR

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

01/09/07 10:11

DET. SET	TABLE1	TABLE2	TREND1	TREND2	L RESULT			
CHARGE	FPC PRESS	TAKEOUT	CYCLE	MIN-CUSH	CUSH	INJ PEAK	FILL	
s	PSI	s	s	mm	mm	PSI	s	
TOL	± 1.00	± 583	± 0.30	± 0.40	± 0.30	± 0.30	± 583	± 0.05
GRP WID	55							
DISP SHOT	40							
AUTO UPDATE								
LAST SHOT								
REF	14.20	5986	3.46	34.52	1.62	1.62	6043	2.66
37	14.44	6384	3.46	34.52	1.07*	1.07*	7579*	2.13*
38	14.01	6669*	3.47	34.51	1.81	1.81	7806*	2.13*
39	13.74	6683*	3.47	34.51	2.15*	2.15*	7892*	2.14*
40	13.92	6768*	3.47	34.51	2.13*	2.13*	7934*	2.14*
TOL	± 1.00	± 583	± 0.30	± 0.40	± 0.30	± 0.30	± 583	± 0.05
PRESET	ALM ON	ALM OFF	ALM ON	ALM ON	ALM OFF	ALM OFF	ALM OFF	ALM ON

PRESET>TOLERANCE

SET RECOMMENDED VALUE TO TOL VALUE.
IS IT OK?

YES CANCEL

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

L STA AREA

S STATISTI

Q MONITOR

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 002

ALTER

RUN

10/11/06 10:36

DET. SET	TABLE1	TABLE2	TREND1	TREND2	L RESULT			
CHARGE	FPC PRESS	CYCLE	TAKEOUT	SAF GATE OP TIME	CUSH	INJ PEAK	FILL	
s	PSI	s	s	s	mm	PSI	s	
GRP WID	± 1.00	± 583	± 0.40	± 0.30	± 0.00	± 0.30	± 583	± 0.05
749								
DISP SHOT								
798								
AUTO UPDATE								
LAST SHOT								
REF	0.00	0	7.60	4.55	0.00	0.00	0	0.00
795	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
796	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
797	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
798	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
TOL	± 1.00	± 583	± 0.40	± 0.30	± 0.00	± 0.30	± 583	± 0.05
PRESET	ALM OFF	ALM OFF	ALM OFF	ALM OFF		ALM OFF	ALM OFF	ALM OFF

AUTO UPDATE>REFERENCE

SET AUTO UPDATE (MOVE AVG) TO REFERENCE VALUE.
IS IT OK?

YES CANCEL

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

L STA AREA

S STATISTI

Q MONITOR

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:37

DET. SET	TABLE1	TABLE2	TREND1	TREND2	L RESULT			
CHARGE	FPC PRESS	CYCLE	TAKEOUT	SAF GATE OP TIME	CUSH	INJ PEAK	FILL	
s	PSI	s	s	s	mm	PSI	s	
TOL	± 1.00	± 583	± 0.40	± 0.30	± 0.30	± 583	± 0.05	
GRP WID	749							
DISP SHOT	798							
AUTO UPDATE								
LAST SHOT								
REF	0.00	0	7.60	4.55	0.00	0.00	0	0.00
795	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
796	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
797	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
798	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
TOL	± 1.00	± 583	± 0.40	± 0.30	± 0.30	± 583	± 0.05	
PRESET	ALM OFF	ALM OFF	ALM OFF	ALM OFF		ALM OFF	ALM OFF	ALM OFF

LAST SHOT>REFERENCE

THE LAST SHOT IS SET REFERENCE.
IS IT OK?

YES

CANCEL

LIST

TEMP

CLAMP

INJECT

PROD

9999

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

MEMORY 002

ALTER

RUN

10/11/06 10:37

DET. SET	TABLE1	TABLE2	TREND1	TREND2	L RESULT			
CHARGE	FPC PRESS	CYCLE	TAKEOUT	SAF GATE OP TIME	CUSH	INJ PEAK	FILL	
s	PSI	s	s	s	mm	PSI	s	
± 1.00	± 583	± 0.40	± 0.30	± 0.00	± 0.30	± 583	± 0.05	
GRP WID								
749								
DISP SHOT								
798								
AUTO UPDATE								
LAST SHOT								
REF	0.00	0	7.60	4.55	0.00	0.00	0	0.00
795	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
796	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
797	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
798	0.00	0*	7.60*	4.55*	0.00	0.00*	0*	0.00*
TOL	± 1.00	± 583	± 0.40	± 0.30	± 0.00	± 0.30	± 583	± 0.05
PRESET	ALM OFF	ALM OFF	ALM OFF	ALM OFF		ALM OFF	ALM OFF	ALM OFF

PRESET>TOLERANCE



SET RECOMMENDED VALUE TO TOL VALUE.
IS IT OK?

YES

CANCEL

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

L STA AREA

S STATISTI

Q MONITOR

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:44

DET. SET TABLE1 TABLE2 TREND1 TREND2 L RESULT

L STATUS 1	CHARGE	FPC PRESS	CYCLE	TAKEOUT	SAF GATE OP TIME	CUSH	INJ PEAK	FILL
	s	PSI	s	s	s	mm	PSI	s
LATEST	0.00	0	7.60	4.55	0.00	0.00	0	0.00
MAXIMUM	0.00	0	0.00	0.00	0.00	0.00	0	0.00
MINIMUM	0.00	0	0.00	0.00	0.00	0.00	0	0.00
AVERAGE	0.000	0.0	0.000	0.000	0.000	0.000	0.0	0.000
MAX-MIN	0.00	0	0.00	0.00	0.00	0.00	0	0.00
DIST(%)	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
STD DEV	0.000	0.0	0.000	0.000	0.000	0.000	0.0	0.000
VARIATION	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
REJECT	0	0	0	0	0	0	0	0

L STATUS 2	HN TEMP	H1 TEMP	H2 TEMP	H3 TEMP		THROAT
	°F	°F	°F	°F		°F
LATEST	390.0	400.1	389.8	379.9		123.4
MAXIMUM	32.0	32.0	32.0	32.0		32.0
MINIMUM	32.0	32.0	32.0	32.0		32.0
AVERAGE	32.00	32.00	32.00	32.00		32.00
MAX-MIN	32.0	32.0	32.0	32.0		32.0
DIST(%)	0.00	0.00	0.00	0.00		0.00
STD DEV	32.000	32.000	32.000	32.000		32.000
VARIATION	100.00	100.00	100.00	100.00		100.00
REJECT	0	0	0	0		0

START SHOT UPDATE DATE FIN. SHOT UPDATE DATE REMAIN SHOT
0 00/00/00 00:00 0 00/00/00 00:00 0 shots

STATIC PROCESS EQUATION

AVERAGE $\bar{x} = \frac{1}{n} \sum_{i=1}^n x_i$

MAX-MIN $= x_{\max} - x_{\min}$

DIST $R = [(x_{\max} - x_{\min}) / |\bar{x}|] \times 100$

STD DEV $\sigma = \sqrt{\frac{1}{n} (\sum_{i=1}^n x_i^2 - n\bar{x}^2)}$

VARIA $C = (\sigma / |\bar{x}|) \times 100$

$\sigma \cdot 3\sigma$

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

THE OPTION SCREENS

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:45

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

MM/DD/YY hr min	CONTENTS			MEMORY	ID
10/11/06 10:43	HN TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H1 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H2 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H3 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:42	THROAT TEMP REF	60.0	> 80.0°F	2	
10/11/06 10:42	THROAT TEMP REF	500.0	> 60.0°F	2	
10/11/06 10:42	THROAT TEMP REF	0.0	> 500.0°F	2	

INIT SET

VARIOUS SL

DISP SELECT

STD

USER SET

LAST SEL

DISP SEL

NETWORK

IP SET

OPERAT HIST

ITEM SEL

LOADCELL

LOADCELL CALIB

SNAP SHOT EDIT

BMP

USER SET

PASSWORD

INVAL · VALID

DISP. SET

CALENDAR

DATE SET

TIME SET

HEADER

PRD CODE

TITLE

LANGUAGE

ENGLISH

LIST

TEMP

CLAMP

INJECT

PROD

9999

MON

OPTION

REC

SHORTCUT

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MESSAGE

LADDER

SUP-PORT

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DIRECT DISPLAY SELECT

LIST

☒ VISOR

☐ TEMP INJ

☐ MENU

TEMP

☒ BARREL

☐ BR PID

CLAMP

☒ CLAMP

☐ EJECT

☐ MLD PROT

☐ EJE MON

INJECT

☒ INJECT

☐ INJ SET

☐ INJ PRFL

☐ CHG PRFL

☐ AT PURGE

☐ LAMINAR

PROD

☒ PROD MGT

☐ PRD GRPH

☐ START UP

☐ PRD PLAN

MON

☒ DET. SET

☐ TABLE1

☐ TABLE2

☐ TREND1

☐ TREND2

☐ L RESULT

OPTION

☐ INIT SET

REC

☒ SET-UP

☐ HISTORY

☐ SORT

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:45

ACT VAL / MONITOR / MON TABLE / PROD / HISTORY / PROFILE / MAINT / CALCLATR

MM/DD/YY hr min	CONTENTS			MEMORY	ID
10/11/06 10:43	HN TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H1 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H2 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H3 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:42	THROAT TEMP REF	60.0	> 80.0°F	2	
10/11/06 10:42	THROAT TEMP REF	500.0	> 60.0°F	2	
10/11/06 10:42	THROAT TEMP REF	0.0	> 500.0°F	2	

LIST

CLAMP

PROD

9999

OPTION

TEMP

INJECT

MON

REC

INIT SET

VARIOUS SL

DISP SELECT

STD

USER SET

LAST SEL

DISP SEL

NETWORK

IP SET

OPERAT HIST

ITEM SEL

LOADCELL

OPERATION HISTORY SELECT

SELECT ITEM TO BE LEFT IN OPERAT HISTORY.

CHANGE OPERATION MODE

SAFETY GATE

TURN ON THE POWER SUPPLY

EMERGENCY STOP

YES

CANCEL

USER SET

PASSWORD

DISP. SET

CALENDAR

DATE SET

TIME SET

HEADER

PRD CODE

TITLE

LANGUAGE

ENGLISH

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

HISTORY TITLE mystery mold MEMORY 003 ALTER RUN 12/13/06 12:15

SET-UP

HISTORY

MEMO2

SORT

MM/DD/YY hr min	CONTENTS	MEMORY	ID
09/15/06 15:02	VCS MOLD CLOSE LOW SPEED 28.0 > 18.0%	131	
09/15/06 15:02	ERROR OCCUR IN LOW-PRESS MOLD CLAMP ZONE	131	
09/15/06 15:02	PCL LOW PRESSURE CLAMPING 60.0 > 1.0%	131	
09/15/06 15:02	REC 0.20 > 0.90sec	131	
09/15/06 14:48	LS32 RETRACT LIMIT 1.00 > 1.09in	131	
09/15/06 14:47	LS31A EJ SPD SWITCHING POS0.50 > 1.25in	131	
09/15/06 14:47	LS32 RETRACT LIMIT 0.00 > 1.00in	131	
09/15/06 14:47	LS31 ADVANCE LIMIT 2.00 > 1.90in	131	
09/15/06 14:46	LS2D MLD CLOSEHIGH SPD POS19.00 > 13.00in	131	
09/15/06 14:46	LS3 MLD OPEN LIMIT POS 19.50 > 13.50in	131	
09/15/06 14:46	LS3B MLD OPENHIGH SPD POS 18.00 > 13.00in	131	
09/15/06 14:45	PCL LOW PRESSURE CLAMPING 10.0 > 60.0%	131	
09/15/06 14:37	EMERGENCY STOP ON	131	
09/15/06 14:22	EMERGENCY STOP ON	131	
09/15/06 10:06	POWERED ON	131	
09/14/06 14:20	EMERGENCY STOP ON	131	
09/14/06 14:04	SP VI STARTUP SP SET -3.00 > -.50in/s	131	
09/14/06 14:03	START UP3 0 > 2shots	131	
09/14/06 14:03	START UP2 0 > 3shots	131	
09/14/06 14:03	START UP1 0 > 3shots	131	
09/14/06 14:03	CHGLS5 START-UP CHRGE SET 0.000 > -.250in	131	
09/14/06 14:03	SP VI STARTUP SP SET 0.00 > -3.00in/s	131	
09/14/06 14:03	HOLDPH START-UP HOLD PRESS0 > -10PSI	131	
09/14/06 14:00	CAVITY 1 > 16	131	
09/14/06 13:41	PI1 FILLING PRESSURE1 0 > 20000PSI	131	
09/14/06 13:36	SCREW COLD START PREVENTION SHUTOFF	131	

LIST

TEMP



CLAMP

INJECT



PROD

MON

9999



OPTION

REC



SHORTCUT



TOOL



SNAP
SHOT



MESSAGE



LADDER



SUP-
PORT



RATION
EQUIPME

DISPLAY ITEM

SET UP

ALARM

STOP

OPERATION

R EQ

TOSHIBA MACHINE

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COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:46

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

MM/DD/YY hr min	CONTENTS			MEMORY	ID
10/11/06 10:43	HN TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H1 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H2 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H3 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:42	THROAT TEMP REF	60.0	> 80.0°F	2	
10/11/06 10:42	THROAT TEMP REF	500.0	> 60.0°F	2	
10/11/06 10:42	THROAT TEMP REF	0.0	> 500.0°F	2	

LIST

TEMP

CLAMP

INJECT

PROD 9999

MON

OPTION

REC

INIT SET

VARIOUS SL

DISP SELECT

STD

USER SET

LAST SEL

DISP SEL

NETWORK

IP SET

OPERAT HIST

ITEM SEL

LOADCELL

LOADCELL CALIB

SNAP SHOT E

BMP

USER SET

PASSWORD

INVAL · VALID

DISP. SET

CALENDAR

DATE SET

TIME SET

HEADER

PRD CODE

TITLE

LANGUAGE

ENGLISH

LOADCELL CALIB

INJECT

EXEC

HISTORY

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:48

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

MM/DD/YY hr min	CONTENTS			MEMORY	ID
10/11/06 10:43	HN TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H1 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H2 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H3 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:42	THROAT TEMP REF				
10/11/06 10:42	THROAT TEMP REF				
10/11/06 10:42	THROAT TEMP REF				

INIT SET

VARIOUS SL

DISP SELECT

STD

USER SET

LAST SEL

DISP SEL

NETWORK

IP SET

OPERAT HIST

ITEM SEL

LOAD

LOADCE

SNAP S

DISP. SET

CALENDAR

DATE SET

TIME SET

HEADER

PRD CODE

TITLE

LANGUAGE

ENGLISH

CALIB HIST(INJ)

MM/DD/YYYY hr mir SET

1 10 09 2006 13 39 486 8888

2

3

4

5

6

7

8

9

10

11

12

13

14

15

16

17

18

19

20

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

INIT SET TITLE mystery mold MEMORY 003 ALTER RUN 12/13/06 14:29

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCATR

MM/DD/YY hr min	CONTENTS	MEMORY	ID
12/13/06 12:13	POWERED ON	3	
12/13/06 12:13	CHANGED FROM MAN/MT-SET MODE TO AUTO/SA MODE	3	
12/13/06 10:45	NEXT MEMO 3 > 1	3	
12/13/06 10:45	SCREW COLD START PREVENTION COMPLETED	3	
12/13/06 10:45	NEXT MEMO 0 > 3	3	
12/01/06 12:36	ERROR OCCURR IN LOW-PRESS MOLD CLAMP ZONE	3	
12/01/06 12:33	ERROR OCCURR IN LOW-PRESS MOLD CLAMP ZONE	?	

LIST

TEMP

CLAMP

INJECT

PROD 9999

MON

OPTION

REC

INIT SET

VARIOUS SL

DISP SELECT
STD
USER SET
LAST SEL
DISP SEL

NETWORK
IP SET
OPERAT HIST
ITEM SEL

LOADCELL
LOADCELL CALIB
SNAP SHOT EDIT
BMP

SAVE TYPE

☐ JPG

☒ BMP

DISP. SET

CALENDAR
DATE SET
TIME SET

HEADER
PRD CODE
TITLE
LANGUAGE
ENGLISH

R EQ SET

ROBOT SET

OFF

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 002 ALTER RUN 10/11/06 10:45

ACT VAL / MONITOR / MON TABLE / PROD / HISTORY / PROFILE / MAINT / CALCLATR

MM/DD/YY hr min	CONTENTS			MEMORY	ID
10/11/06 10:43	HN TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H1 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H2 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:43	H3 TEMP GRAPH WIDTH	5.0	> 95.0°F	2	
10/11/06 10:42	THROAT TEMP REF	60.0	> 80.0°F	2	
10/11/06 10:42	THROAT TEMP REF	500.0	> 60.0°F	2	
10/11/06 10:42	THROAT TEMP REF	0.0	> 500.0°F	2	

LIST

CLAMP

PROD

9999

OPTION

TEMP

INJECT

MON

REC

INIT SET

VARIOUS SL

DISP SELECT

STD

USER SET

LAST SEL

DISP SEL

NETWORK

IP SET

OPERAT HIST

ITEM SEL

LOADCELL

LOADCELL CALIB

SNAP SHOT EDIT

BMP

USER SET

PASSWORD

INVAL · VALID

DISP. SET

CALENDAR

DATE SET

TIME SET

HEADER

PRD CODE

TITLE

LANGUAGE

ENGLISH

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

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ACT VAL

MONIT

MM/DD/YY	hr	min
12/13/06	12:13	
12/13/06	12:13	
12/13/06	10:45	
12/13/06	10:45	
12/13/06	10:45	
12/01/06	12:36	
12/01/06	12:33	

INIT SET

VARIOUS SL

- DISP SELECT
- STD
- USER SET
- LAST SEL
- DISP SEL

- NETWORK
- IP SET
- OPERAT HIST
- ITEM SEL
- LOADCELL
- LOADCELL CALIB
- SNAP SHOT EDIT
- BMP

PASSWORD

INVAL · VALID

ADMINISTRATOR CHECK

INPUT ADMINISTRATOR PASSWORD.

ADMINISTRATOR ID ADM

PASSWORD ADMIN

ENT

CANCEL

Keyboard

Q W E R T Y U I O P Enter BS Ins 7 8 9

A S D F G H J K L - ← Del 4 5 6

Shift Z X C V B N M , * / + ↑ 1 2 3

Symbol Space ← ↓ → 0 . -

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

OPT

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/12/07 12:23

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCLATR

		H N	H 1	H 2	H 3		THROAT
ACT	°F	73.5	73.4	73.5	74.8		75.3
DEV	°F	-**.*	-**.*	-**.*	-**.*		
ON RATIO %		0	0	0	0		

INJECTION	0.00	s	SCREW POS	0.43	mm	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	340.0	mm	INJ/BP PRESS	9	PSI
INTERVAL	0.00	s	EJECT POS	28.1	mm	SCREW SPEED	0	rpm

LIST TEMP

CLAMP INJECT

PROD MON

OPTION REC

INIT SET

VARIOUS SL

DISP SELECT

STD

USER SET

LAST SEL

DISP SEL

NETWORK

IP SET

OPERAT HIST

ITEM SEL

LOADCELL

LOADCELL CALIB

SNAP SHOT EDIT

BMP

USER SET

PASSWORD

INVAL · VALID

AUTO LOGOFF TIME

OFF

AUTO LOGON SELECT

USER SELECT

DISP. SET

CALENDAR

DATE SET

TIME SET

HEADER

PRD CODE

TITLE

LANGUAGE

ENGLISH

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LOGOFF

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

ACT VAL MONITOR MON TA

MM/DD/YY	hr min	
12/13/06	12:13	POWERED ON
12/13/06	12:13	CHANGED FR
12/13/06	10:45	NEXT MEMO
12/13/06	10:45	SCREW COLD
12/13/06	10:45	NEXT MEMO
12/01/06	12:36	ERROR OCCU
12/01/06	12:33	ERROR OCCU

INIT SET

VARIOUS SL

DISP SELECT

STD

USER SET

LAST SEL

DISP SEL

NETWORK

IP SET

OPERAT HIST

ITEM SEL

LOADCELL

LOADCELL CALIB

SNAP SHOT EDIT

BMP

PASSWORD

INVAL · VALID

AUTO LOGOFF TIME

OFF

AUTO LOGON SELECT

USER SELECT

DISP. SET

CALENDAR

DATE SET

TIME SET

HEADER

PRD CODE

TITLE

LANGUAGE

ENGLISH

R EQ SET

ROBOT SET

OFF

AUTO LOGOFF TIME

LOGS OFF AUTOMATICALLY
IF NO-OPERATION TIME EXCEEDS FOLLOWING.

☒ OFF

☐ 10min ☐ 40min

☐ 20min ☐ 50min

☐ 30min ☐ 60min

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LOGOFF

RATION EQUIPME

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

ACT VAL MONITOR MON TABL

MM/DD/YY	hr min	
12/13/06	12:13	POWERED ON
12/13/06	12:13	CHANGED FROM
12/13/06	10:45	NEXT MEMO
12/13/06	10:45	SCREW COLD ST
12/13/06	10:45	NEXT MEMO
12/01/06	12:36	ERROR OCCURR
12/01/06	12:33	ERROR OCCURR

INIT SET

VARIOUS SL

DISP SELECT

STD

USER SET

LAST SEL

DISP SEL

NETWORK

IP SET

OPERAT HIST

ITEM SEL

LOADCELL

LOADCELL CALIB

SNAP SHOT EDIT

BMP

PASSWORD

INVAL · VALID

AUTO LOGOFF TIME

OFF

AUTO LOGON SELECT

USER SELECT

DISP. SET

CALENDAR

DATE SET

TIME SET

HEADER

PRD CODE

TITLE

LANGUAGE

ENGLISH

R EQ SET

ROBOT SET

OFF

AUTO LOGON SELECT

SELECT POWER ON LOGON METHOD.

USER SELECT

USER AT END

GUEST

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

LOGOFF

SUP-PORT

RATION EQUIPME

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/12/07 12:23

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

	H N	H 1	H 2	H 3	THROAT
ACT °F	73.5	73.4	73.5	74.8	75.3
DEV °F	-**.*	-**.*	-**.*	-**.*	
ON RATIO %	0	0	0	0	

INJECTION	0.00	s	SCREW POS	0.43	mm	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	340.0	mm	INJ/BP PRESS	9	PSI
INTERVAL	0.00	s	EJECT POS	28.1	mm	SCREW SPEED	0	rpm

LIST

TEMP °F

CLAMP

INJECT

PROD 9999

MON

OPTION OPT

REC

INIT SET

VARIOUS SL

DISP SELECT

STD

USER SET

LAST SEL

DISP SEL

NETWORK

IP SET

OPERAT HIST

ITEM SEL

LOADCELL

LOADCELL CALIB

SNAP SHOT EDIT

BMP

USER SET

PASSWORD

INVAL · VALID

AUTO LOGOFF TIME

OFF

AUTO LOGON SELECT

USER SELECT

DISP. SET

CALENDAR

DATE SET

TIME SET

HEADER

PRD CODE

TITLE

LANGUAGE

ENGLISH

SHORTCUT

TOOL

SNAP SHOT

MESSAGE 2

LOGOFF

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/12/07 12:23

ACT VAL

MONITOR

MON TABLE

PROD

HISTORY

PROFILE

MAINT

CALCLATR

		H N	H 1	H 2	H 3	THROAT
ACT	°F	73.4	73.4	73.4	74.6	75.3
DEV	°F	-.*. *	-.*. *	-.*. *	-.*. *	
ON RATIO %		0	0	0	0	

INJECTION	0.00	s	SCREW POS	0.43	mm	CLAMP	0	tf
COOL	0.00	s	PLATEN POS	340.0	mm	INJ/BP PRESS	30	PSI
INTERVAL	0.00	s	EJECT POS	28.1	mm	SCREW SPEED	0	rpm

USER SET

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

USER SET

NEW ADDITION

BOB

DEL

CHNG

USER GROUP

LEVEL SET

USER PROFILE

SAVE

LOAD

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LOGOFF

LADDER

SUP-PORT

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COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/12/07 12:57

ACT VAL

ACT °F
DEV °F
ON RATIO %
INJECTION
COOL
INTERVAL

USER SET

USER NAME BOB
MAX FULL WIDTH EIGHT CHARACTER

USER ID OP1
MAX FULL WIDTH THREE CHARACTER

USER GROUP SELECT

ADMINISTRATOR

RESP PERSON

SET RESP PERS

☒ OPERATOR1

OPERATOR2

MAINTENANCE

ENT

CANCEL

USER SET

NEW ADD

BOB DEL CHNG

USER PROFILE

Keyboard

Q W E R T Y U I O P Enter BS Ins 7 8 9

A S D F G H J K L - ← Del 4 5 6

Shift Z X C V B N M , * / + ↑ 1 2 3

Symbol Space ← ↓ → 0 . -

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LOGOFF

LADDER

SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

PASSWORD TITLE mystery mold MEMORY 003 ALTER RUN 12/13/06 15:49

ACT VAL MONITOR MON TABLE PROD HISTORY PROFILE MAINT CALCATR

MM/DD/YY hr min	CONTENTS	MEMORY	ID
12/13/06 12:13	POWERED ON	3	
12/13/06 12:13	CHANGED FROM MAN/MT-SET MODE TO AUTO/SA MODE	3	
12/13/06 10:45	NEXT MEMO 3 > 1	3	
12/13/06 10:45	SCREW COLD START PREVENTION COMPLETED	3	
12/13/06 10:45	NEXT MEMO 0 > 3	3	
12/01/06 12:36	ERROR OCCURR IN LOW-PRESS MOLD CLAMP ZONE	3	
12/01/06 12:33	ERROR OCCURR IN LOW-PRESS MOLD CLAMP ZONE	2	

USER SET

USER SET

NEW ADDITION

DEL

CHNG

USER GROUP

LEVEL SET

USER PROFILE

SAVE

LOAD

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LOGOFF

RATION EQUIPME

LADDER

SUP-PORT

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

01/12/07 12:04

USER GROUP SET

ADMINISTRATOR

RESP PERSON

SET RESP PERS

OPERATOR1

OPERATOR2

MAINT

CHANGE SCREEN FOR ENABLING SETTING OF EACH USER GROUP

FORMAT

WH BTN: ENABLED ITEM, GY BTN: DISABLED ITEM

TEMP



BARREL



BR PID

Check off the screens you want the account to access and press enter.

CLAMP



CLAMP



EJECT



MLD PROT



EJE MON

INJECT



INJECT



INJ SET



INJ PRFL



CHG PRFL



AT PURGE



LAMINAR

PROD



PRD MGT



PRD GRPH



START UP

MON



DET. SET



TABLE



TREND



L STATIS

OPTION



INIT SET

Some customized accessibilities can be set up in the detailed set section

REC



SET-UP



HISTORY



MEMORY

ENT

CANCEL

DETAILED SET

COLD START PREVENTION IS WORKING

MEMORY 003

ALTER

RUN

01/12/07

14:21

USER GROUP SET



ADMINISTRATOR

RESP PERSON

SET RESP PERS

OPERATOR1

OPERATOR2

MAINT

CHANGE SCREEN FOR ENABLING SETTING OF EACH USER GROUP.

FORMAT

WH BTN: ENABLED ITEM, GY BTN: DISABLED ITEM

BARREL



TOL SET-ALARM SELECT



COLD PREVENT BUTTON



SHIFT MODE CONDITION

TREND



LONG STATISTICS SET



S STATISTIC -> REF & TOL SETTING



QUALITY MONITOR SET

OTHER



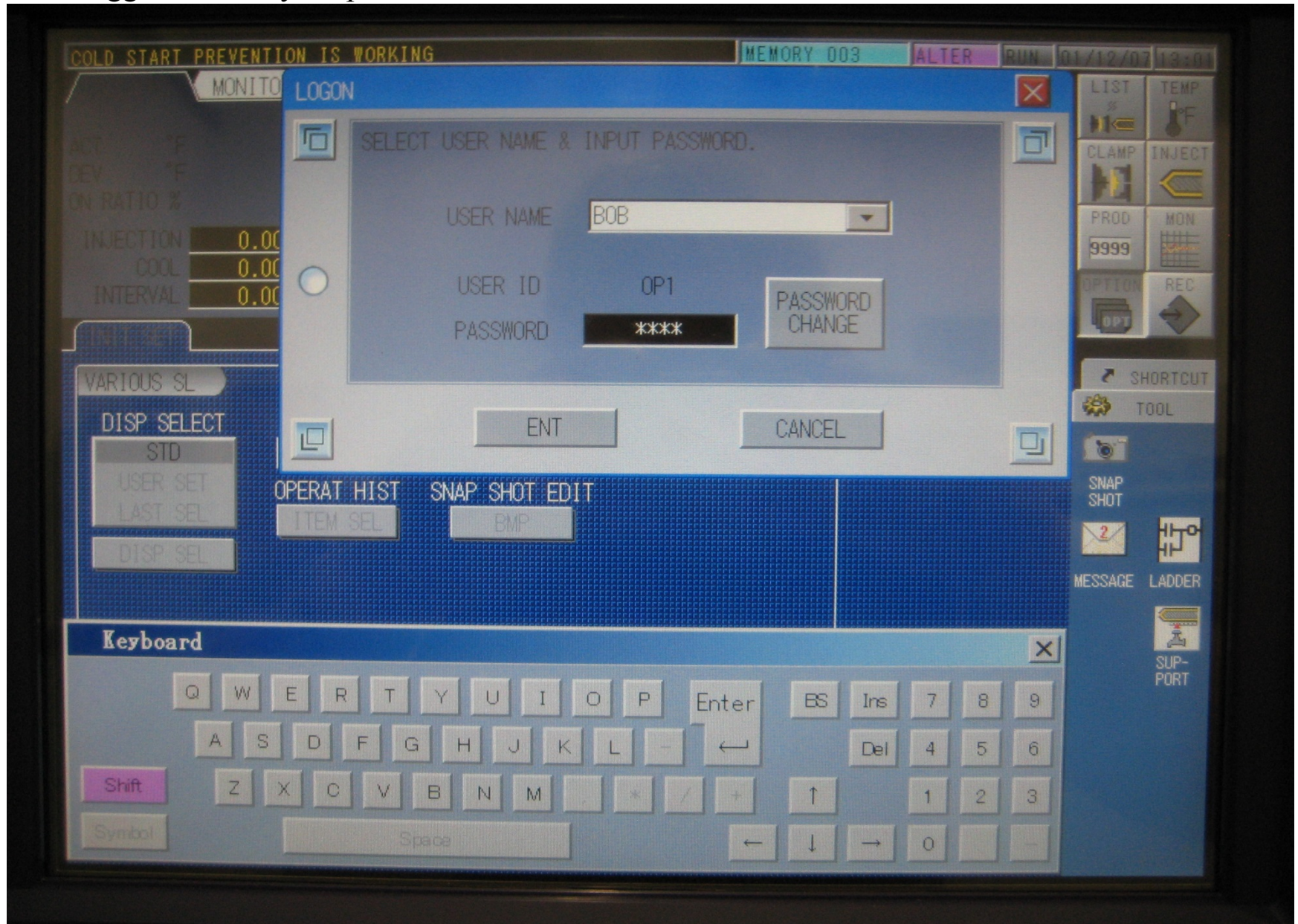
MESSAGE DELETE

ENT

CANCEL

BACK

Once accounts have been set up and the screens are “locked out”, any time you touch the screen a logon screen will appear. Enter your name and password (you can also change your password here) and you will be logged on with your particular accessibilities.



Start reaching for the impossible and achieve the incredible

INIT SET | TITLE mystery mold | MEMORY 003 | ALTER | RUN | 12/13/06 | 14:36

ACT VAL | MONITOR | MON TABLE | PROD | HISTORY | PROFILE | MAINT | CALCATR

MM/DD/YY hr min	CONTENTS	MEMORY	ID
12/13/06 12:13	POWERED ON	3	
12/13/06 12:13	CHANGED FROM MAN/MT-SET MODE TO AUTO/SA MODE	3	
12/13/06 10:45	NEXT MEMO 3 > 1	3	
12/13/06 10:45	SCREW COLD START PREVENTION COMPLETED	3	
12/13/06 10:45	NEXT MEMO 0 > 3	3	
12/01/06 12:36	ERROR OCC	3	
12/01/06 12:33	ERROR OCC	2	

LIST
TEMP
CLAMP
INJECT
PROD
MON
9999
OPTION
REC

INIT SET

VARIOUS SL

DISP SELECT

STD

USER SET

LAST SEL

DISP SEL

NETWORK

IP SET

OPERAT H

ITEM S

ROBOT MFR SET

OFF

YUSHIN

SAILOR

HARMO

USER SET

PASSWORD

INVAL · VALID

AUTO LOGOFF TIME

OFF

AUTO LOGON SELECT

USER SELECT

DISP. SET

CALENDAR

DATE SET

TIME SET

HEADER

PRD CODE

TITLE

LANGUAGE

ENGLISH

R EQ SET

ROBOT SET

OFF

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LOGOFF

RATION EQUIPME

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

取出機

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メンテナンス

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後工程機

STDA5

標準5軸(モ対付)

1-B8888

作業者

運転

手動

簡易

多機能

確認運転

自動運転

リサイクル運転

軸情報

箱詰

生産モニタ

	製品	ランナ
フロー	040	040
ブロック	010	010
速度	S00	S12
タイマ	T15	T17
引抜	214.5	99.8
上下	0.0	0.0
横行	1300.0	

ブザー

ランプリング

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詳細

生産モニタ

入力信号

出力信号

その他

位置決完了

位置修正

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モニタ

9999

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取出機リンク

開始

終了

EJECTROL

押出回数

押出動作

押出遅延

反復戻限

押出位置

17.66 mm

PEJ

LS31A

LS31

LS31B

VE 1

VE 2

VR

LS32

LS32A

押出入限

押出保持

押出連動

CLAMPTROL

LS3

LS100

LS30

ダイプレート

7.9 mm

メンテナンス

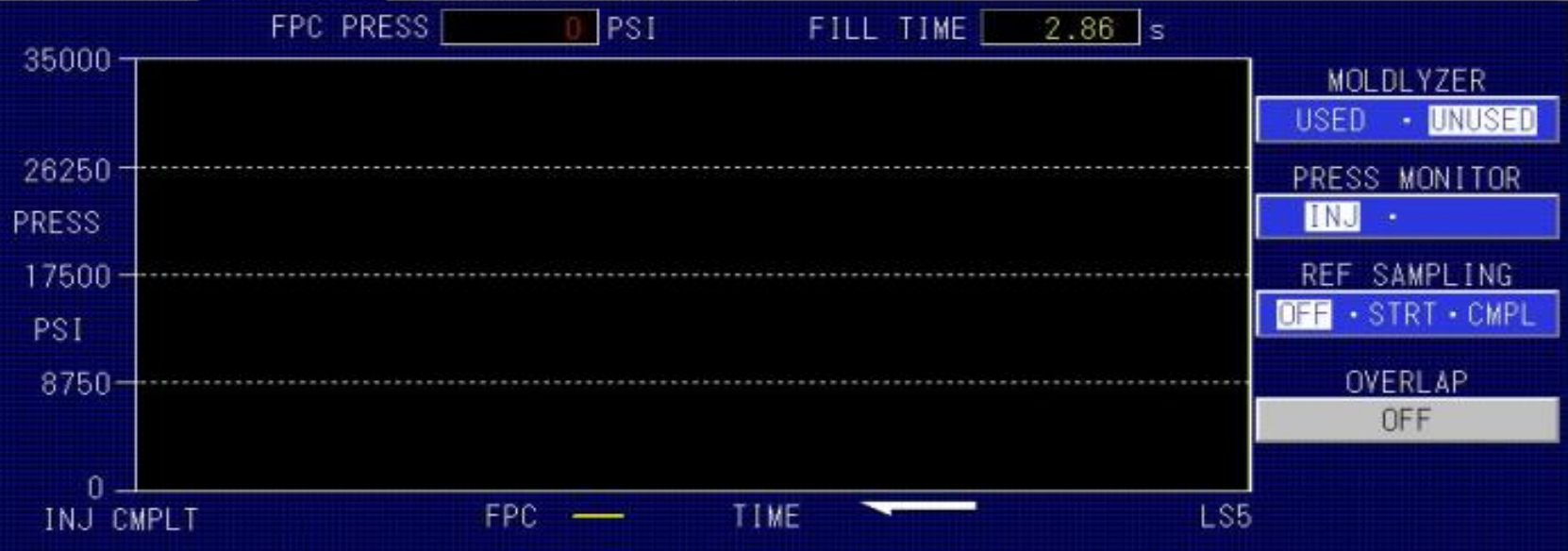
TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 013 ALTER RUN 03/06/13 11:17

ACT VAL		MONITOR		MON TABLE		PROD	HISTORY	PROFILE	MAINT	CALCLATR
shots	FILL	CHARGE	INJ START	CYCLE TIME	CUSH	MIN-CUSH	FPC PRESS	TAKEOUT		
	s	s	in	s	in	in	PSI	s		
22509	1.68	6.28	2.379	25.47	0.207	0.207	9518	8.97		
22510	1.68	6.41	2.379	25.43	0.197	0.197	8859	8.92		
22511	1.68	6.65	2.379	25.43	0.186	0.186	8190	8.93		
FILL TIME		CHARGE TIME		MIN-CUSH		ACT-CUSH		FPC PRESS		INJ START
2.86		1.56		0.244		0.244		8190		2.467

INIT SET MOLDLZ1 MOLDLZ2 SIG. OUT



JUDGMENT	AREA	[HOLD]	[PACK]	[MIDDLE]	[START]	DISP SELECT
ACT PRESS	PSI	0	0	0	0	ACT • DEV
TOLERANCE	PSI	±0	±0	±0	±0	PEAK HOLD OFF • ON

GRAPH STOP

LIST TEMP

CLAMP INJECT

PROD MON

9999

OPTION REC

SHORTCUT TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

LAN-GUAGE

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 013 ALTER RUN 03/06/13 11:17

ACT VALMONITORMON TABLEPRODHISTORYPROFILEMAINTCALCLATR

shots	FILL	CHARGE	INJ START	CYCLE TIME	CUSH	MIN-CUSH	FPC PRESS	TAKEOUT
	s	s	in	s	in	in	PSI	s
22509	1.68	6.28	2.379	25.47	0.207	0.207	9518	8.97
22510	1.68	6.41	2.379	25.43	0.197	0.197	8859	8.92
22511	1.68	6.65	2.379	25.43	0.186	0.186	8190	8.93

FILL TIME

2.86 s

CHARGE TIME

1.56 s

MIN-CUSH

0.244 in

ACT-CUSH

0.244 in

FPC PRESS

8190 PSI

INJ START

2.467 in

INIT SETMOLDLZ1MOLDLZ2SIG. OUT

LISTTEMP

CLAMPINJECT

PROD9999MON

OPTIONREC

ALARM JUDG

AREA

MULTIPOINTS

1POINT

[ZONE] & ITEMS

[HOLD]

[PACK]

[MIDDLE]

[START]

PEAK

ACT PRESS PSI

0

0

0

0

0

TOLERANCE PSI

± 0

± 0

± 0

± 0

0

ALARM SELECT

OFF

OFF

OFF

OFF

OFF

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

LAN-GUAGE

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 013 ALTER RUN 03/06/13 11:18

ACT VAL		MONITOR		MON TABLE		PROD	HISTORY	PROFILE	MAINT	CALCLATR
shots	FILL	CHARGE	INJ START	CYCLE TIME	CUSH	MIN-CUSH	FPC PRESS	TAKEOUT		
	s	s	in	s	in	in	PSI	s		
22509	1.68	6.28	2.379	25.47	0.207	0.207	9518	8.97		
22510	1.68	6.41	2.379	25.43	0.197	0.197	8859	8.92		
22511	1.68	6.65	2.379	25.43	0.186	0.186	8190	8.93		
FILL TIME		CHARGE TIME		MIN-CUSH		ACT-CUSH		FPC PRESS		INJ START
2.86		s	1.56	s	0.244	in	0.244	in	8190	PSI 2.467 in

INIT SET MOLDLZ1 MOLDLZ2 SIG. OUT

	OPERAT.	SIGNAL A	SIGNAL B	MOTION	TIME	OUTPUT	NAME/CONDITION
1	A	REJECT SHOT		CONTINUE	25.00	ON	
2	A	MONITOR ALARM		SYNCHRO		ON	
3	A			SYNCHRO		OFF	

SET CHNG

DATA CALL

SIGNAL NAME EDIT

SIGNAL OUTPUT

LIST

TEMP

CLAMP

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PROD

MON

9999

OPTION

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LAN-GUAGE



TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

THE MEMORY SCREENS

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

SET-UP TITLE mystery mold MEMORY 003 ALTER RUN 12/01/06 14:28

SET-UP HISTORY MEMO2 SORT

RUN MEMO

CODE·NUMBER

TITLE
mystery mold

PRODUCT CODE
Toshiba

MOLD CODE

MOLD No.
001

MATERIAL CODE
PP

MATERIAL No.
0

ID

SAVE DATE 09/22/06

MEMO

EXT MEMO

PHOTO

EDIT

ERASE

SAVE·LOAD

MEMORY

EXT_MEMO

RUN

SAVE

EXEC

EDIT

LOAD

STOP

MEMORY TAKEOUT

001	syringe plunger	011		021	
002	grip lock	012		022	
003	mystery mold	013		023	
004		014		024	
005		015		025	
006		016		026	
007		017		027	
008		018		028	
009		019		029	
010		020		030	

LIST

TEMP

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MON

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SHORTCUT

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SNAP SHOT

MESSAGE

LADDER

FIND PAGE

SUP-PORT

RATION EQUIPME

ALL COPY

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

SET-UP | TITLE mystery mold | MEMORY 003 | ALTER | RUN | 12/15/06 | 12:21

SET-UP

HISTORY

MEMO2

SORT

MEMO No.003

CODE·NUMBER

TITLE

mystery mold

PRODUCT CODE

Toshiba

MOLD CODE

MOLD No.

001

MATERIAL CODE

PP

MATERIAL No.

0

ID


SAVE DATE

12/01/06

MEMO

EXT MEMO

PHOTO



SAVE·LOAD

MEMORY

PARAMETER

EXT_MEMO

RUN

EDIT

SAVE

LOAD

EXEC

STOP

MEMORY TAKEOUT

001	syringe plunger	011		021	
002	grip lock	012		022	
003	mystery mold	013		023	
004		014		024	
005		015		025	
006		016		026	
007		017		027	
008		018		028	
009		019		029	
010		020		030	

<<

>>

FIND PAGE

ALL COPY

LIST

TEMP

CLAMP

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PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

DIAG MESSG

Start reaching for the impossible and achieve the incredible

SET-UP HISTORY MEMO2 SORT

MEMO No.003 CODE·NUMBER

TITLE mystery mold

PRODUC MOLD MOLD MATERIAL MATERIAL I SAVE SAVE·L PARA 001 sy 002 gr 003 my 004 005 006 007 008 009 010

Watch for flash here



LIST TEMP CLAMP INJECT PROD MON OPTION REC SHORTCUT TOOL SNAP SHOT MESSAGE LADDER SUP-PORT DIAG MESSG 1

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

SET-UP TITLE mystery mold MEMORY 003 ALTER RUN 12/15/06 12:21

SET-UP

HISTORY

MEMO2

SORT

MEMO No.003

CODE·NUMBER

TITLE
mystery mold

PRODUCT CODE
Toshiba

MOLD CODE

MOLD No.
001

MATERIAL CODE
PP

MATERIAL No.
0


ID

SAVE DATE 12/01/06

MEMO

EXT MEMO

PHOTO



SAVE·LOAD

MEMORY

PARAMETER

EXT_MEMO

RUN

EDIT

SAVE

LOAD

EXEC

STOP

MEMORY TAKEOUT

001	syringe plunger	011		021	
002	grip lock	012		022	
003	mystery mold	013		023	
004		014		024	
005		015		025	
006		016		026	
007		017		027	
008		018		028	
009		019		029	
010		020		030	

ALL COPY

LIST

TEMP

CLAMP

INJECT

PROD

MON

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

DIAG MESSG

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

HISTORY TITLE mystery mold MEMORY 003 ALTER RUN 12/01/06 14:27

SET-UP HISTORY MEMO2 SORT

MM/DD/YY hr min	CONTENTS	MEMORY	ID
11/10/06 14:48	MONITOR ALARMS OCCUR CONTINUOUSLY	2	
11/10/06 14:48	MONITOR:MOLD CLOSE TIME	2	
11/10/06 14:46	MONITOR ALARMS OCCUR CONTINUOUSLY	2	
11/10/06 14:46	MONITOR:MOLD CLOSE TIME	2	
11/10/06 14:45	MOLD CLOSE TIME REF 1.73 > 2.73s	2	
11/10/06 14:41	MONITOR ALARMS OCCUR CONTINUOUSLY	2	
11/10/06 14:40	MONITOR ALARMS OCCUR CONTINUOUSLY	2	
11/10/06 14:39	MONITOR ALARMS OCCUR CONTINUOUSLY	2	
11/10/06 14:39	QUALITY_WACTH MON_ALM_COUNO > 1shots	2	
11/10/06 14:34	INJ : OVER STROKE	2	
11/10/06 14:34	INJECTION SERVO ERROR OCCURS	2	
11/10/06 14:34	VSB DECOMPRESSION SPEED 20.0 > 0.0mm/s	2	
11/10/06 14:34	VH1 PRESSURE HOLD SPEED1 30.0 > 0.0mm/s	2	
11/10/06 14:34	LS4 FPC POSITION 8.00 > 0.00mm	2	
11/10/06 14:34	LS4A FILL SPEED SHIFT POS 18.00 > 0.00mm	2	
11/10/06 14:34	VI1 FILLING SPEED1 110.0 > 0.0mm/s	2	
11/10/06 14:34	VI2 FILLING SPEED2 80.0 > 0.0mm/s	2	
11/10/06 14:34	INJ : OVER STROKE	2	
11/10/06 14:34	INJECTION SERVO ERROR OCCURS	2	
11/10/06 14:33	INJ : OVER STROKE	2	
11/10/06 14:33	INJECTION SERVO ERROR OCCURS	2	
11/10/06 14:33	SCREW COLD START PREVENTION SHUTOFF	2	
11/10/06 14:33	SRN SCREW SPEED 63 > 0rpm	2	
11/10/06 14:33	BP BACK PRESS 2200 > 0PSI	2	
11/10/06 14:33	INJECT 4.00 > 0.00s	2	
11/10/06 14:33	PI1 FILLING PRESSURE1 8800 > 0PSI	2	

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

RATION EQUIPME

DISPLAY ITEM SET UP ALARM STOP OPERATION R EQ

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 12/13/06 17:29

SET-UP HISTORY MEMO2 SORT

DATA SAVE

INSPECT. DATA MONITOR HISTORY PROFILE

SAVE MODE

FILE NAME

FILE INFO

FILE NAME CHNG

SEL FOLD DEL

MEMORY TAKEOUT

NAME	SIZE	UPDATE DATE	MODE	ID
E,J, Brooks.bmp	427KB	08/24/06 14:06	PHOTO	
MEMO302.TXT	121KB	09/22/06 10:09	SET-UP	
support.BMP	1,406KB	12/13/06 17:27	PHOTO	
support1.BMP	1,406KB	12/13/06 17:28	PHOTO	

FILE INFO.: TOTAL 249.7MB USED 41.9MB FREE 207.8MB

MON DATA 0FILE 0.0MB

HST DATA 0FILE 0.0MB

PRFL DATA 0FOLDER 0.0MB

SET-UP 5FILE 0.3MB

PHOTO-MEM 3FILE 3.2MB

ALL 8FILE 3.4MB

FOLDER ALL DEL

LIST TEMP

CLAMP INJECT

PROD MON

9999

OPTION REC

SHORTCUT TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

RATION EQUIPME

DIAG MESSG

1

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/05/07 14:54

SET-UP HISTORY MEMO2 SORT

DATA SAVE

MONITOR HISTORY PROFILE

SAVE MODE LOG MODE

FILE NAME

FILE INFO

METHOD SELECT

SELECT THE SAVE METHOD.

☒ ALL COPY

☐ DATE COPY

< BACK

NEXT >

CANCEL

BARREL.BMP

MEMO302.TXT

MEMORY2.BMP

mystery mold.

MEMORY TAKEOUT

SHORTCUT TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

FILE INFO.: TOTAL 249.7MB USED 41.5MB FREE 208.2MB

MON DATA 0FILE 0.0MB

HST DATA 0FILE 0.0MB

PRFL DATA 0FOLDER 0.0MB

SET-UP 5FILE 0.3MB

PHOTO-MEM 3FILE 2.8MB

ALL 8FILE 3.1MB

FOLDER ALL DEL

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/05/07 14:54

SET-UP HISTORY MEMO2 SORT

DATA SAVE

MONITOR HISTORY PROFILE

SAVE MODE ALL COPY

FILE NAME

- FILE INFO
- BARREL.BMP
 - MEMO302.TXT
 - MEMORY2.BMP
 - MEMORY3.BMP
 - mystery mold.

SAVE FILE NAME SELECT

CHOOSE A FILE NAME.

☒ TITLE

mystery mold

☐ PRODUCT CODE

Toshiba

☐ MOLD CODE

< BACK

NEXT >

CANCEL

MEMORY TAKEOUT

ID

↑

↑

↑

↓

↓

↓

LIST TEMP

CLAMP INJECT

PROD MON

9999

OPTION REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

FILE INFO.: TOTAL 249.7MB USED 42.9MB FREE 206.8MB

MON DATA 0FILE 0.0MB

HST DATA 0FILE 0.0MB

PRFL DATA 0FOLDER 0.0MB

SET-UP 5FILE 0.3MB

PHOTO-MEM 4FILE 4.2MB

ALL 9FILE 4.4MB

FOLDER ALL DEL

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 01/05/07 14:55

SET-UP HISTORY MEMO2 SORT

DATA SAVE

MONITOR HISTORY PROFILE

SAVE MODE

FILE NAMEmystery mold

FILE INFO

FILE NAME CHNG SEL FOLD MEMORY TAKEOUT

SAVE START

? EXECUTES MONITOR DATA SAVING.
IS IT OK?

YES CANCEL

	ID	
▶ BARREL.BMP		⏏
▶ MEMO302.TXT		⏏
▶ MEMORY2.BMP		⏏
▶ MEMORY3.BMP	1,406KB01/05/07 14:54 PHOTO	⏏
▶ MEMORY4.BMP	1,406KB01/05/07 14:54 PHOTO	⏏
▶ MEMORY5.BMP	1,406KB01/05/07 14:55 PHOTO	⏏
▶ mystery mold.bmp	54KB12/15/06 11:51 PHOTO	⏏
▶		⏏
▶		⏏

FILE INFO.: TOTAL 249.7MB USED 45.7MB FREE 204.1MB

MON DATA
0FILE
0.0MB

HST DATA
0FILE
0.0MB

PRFL DATA
0FOLDER
0.0MB

SET-UP
5FILE
0.3MB

PHOTO·MEM
6FILE
6.9MB

ALL
11FILE
7.2MB

FOLDER
ALL
DEL

LIST TEMP

CLAMP INJECT

PROD MON

9999

OPTION REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE LADDER


SUP-PORT

TOSHIBA MACHINE

Start reaching for the impossible and achieve the incredible

COLD START PREVENTION IS WORKING

IN PROCESS OF RETAINING DATA IN MONITOR

 MEMORY 003 ALTER RUN 01/05/07 14:58

SORT

DATA SAVE

MONITOR

HISTORY

PROFILE

SAVE MODE

LOG MODE


ALL COPY

FILE NAME

mystery mold

FILE INFO

FILE NAME CHNG

 SEL FOLD DEL

MEMORY TAKEOUT

NAME	SIZE	UPDATE DATE	MODE	ID	
▶ BARREL.BMP	1,406KB	01/04/07 10:40	PHOTO		⌵
▶ MEMO302.TXT	121KB	09/22/06 10:09	SET-UP		⌵
▶ MEMORY2.BMP	1,406KB	01/05/07 14:53	PHOTO		⌵
▶ MEMORY3.BMP	1,406KB	01/05/07 14:54	PHOTO		⌵
▶ MEMORY4.BMP	1,406KB	01/05/07 14:54	PHOTO		⌵
▶ MEMORY5.BMP	1,406KB	01/05/07 14:55	PHOTO		⌵
▶ MEMORY6.BMP	1,406KB	01/05/07 14:55	PHOTO		⌵
▶ mystery mold.bmp	54KB	12/15/06 11:51	PHOTO		⌵
▶					⌵

FILE INFO.: TOTAL 249.7MB USED 47.0MB FREE 202.7MB

MON DATA

0FILE

0.0MB

HST DATA

0FILE

0.0MB

PRFL DATA

0FOLDER

0.0MB

SET-UP

5FILE

0.3MB

PHOTO·MEM

7FILE

8.3MB

ALL

12FILE

8.6MB

 FOLDER ALL DEL

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

Start reaching for the impossible and achieve the incredible

DATA SAVE

MONITOR

HISTORY

PROFILE

SAVE MODE

MANUAL MODE


ALL COPY

FILE NAME

mystery mold070112161934

FILE INFO

FILE NAME CHNG

SEL FOLD DEL

MEMORY TAKEOUT

NAME	SIZE	UPDATE DATE	MODE	ID	
MANUAL1		01/12/07 16:18	INJ	PRFL	⏏
MEMO302.TXT	121KB	09/22/06 10:09	SET-UP		⏏
MEMORY2.BMP	1,406KB	01/12/07 16:18	PHOTO		⏏
mystery mold.bmp	54KB	12/15/06 11:51	PHOTO		⏏
mystery mold070112161934.txt	129KB	01/12/07 16:19	HISTORY		⏏
					⏏
					⏏
					⏏
					⏏

FILE INFO.: TOTAL 249.7MB USED 40.3MB FREE 209.4MB

MON DATA

0FILE

0.0MB

HST DATA

1FILE

0.1MB

PRFL DATA

1FOLDER

0.0MB

SET-UP

5FILE

0.3MB

PHOTO-MEM


2FILE

1.4MB

ALL

9FILE

1.8MB

FOLDER ALL DEL

LIST

TEMP

CLAMP

INJECT

PROD

MON

9999

OPTION

REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE

LADDER

SUP-PORT

TOSHIBA MACHINE

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MEMO1 TITLE mystery mold MEMORY 003 ALTER RUN 01/12/07 16:18

SET-UP HISTORY MEMO2 SORT

DATA SAVE

MONITOR HISTORY PROFILE

SAVE MODE MANUAL MODE
RUN
SAVE PRFL INJECT
FILE NAME mystery mold070112161832

FILE INFO

FILE NAME CHNG

SEL FOLD DEL

MEMORY TAKEOUT

NAME	SIZE	UPDATE DATE	MODE	ID	
MANUAL1		01/12/07 16:18	INJ PRFL		⬆
MEMO302.TXT	121KB	09/22/06 10:09	SET-UP		⬆
mystery mold.bmp	54KB	12/15/06 11:51	PHOTO		⬆
					⬆
					⬆
					⬆
					⬆
					⬆
					⬆
					⬆

FILE INFO.: TOTAL 249.7MB USED 38.8MB FREE 210.9MB

MON DATA 0FILE 0.0MB

HST DATA 0FILE 0.0MB

PRFL DATA 1FOLDER 0.0MB

SET-UP 5FILE 0.3MB

PHOTO-MEM 1FILE 0.1MB

ALL 7FILE 0.3MB

FOLDER ALL DEL

LIST TEMP

CLAMP INJECT

PROD MON

9999

OPTION REC

SHORTCUT

TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

TOSHIBA MACHINE

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COLD START PREVENTION IS WORKING MEMORY 003 ALTER RUN 12/13/06 17:29

SET-UP HISTORY MEMO2 SORT

No.	TITLE	PRODUCT CODE	UPDATE DATE
▶001	syringe plunger	Plas-Pak	09/20/06 14:24:07
▶002	grip lock	E,J, Brooks	10/04/06 13:09:43
▶003	mystery mold	Toshiba	12/01/06 12:34:04
▶004			
▶005			
▶006			
▶007			
▶008			
▶009			
▶010			
▶011			
▶012			
▶013			
▶014			
▶015			
▶016			
▶017			
▶018			
▶019			
▶020			

LIST TEMP

CLAMP INJECT

PROD MON

9999

OPTION REC

SHORTCUT TOOL

SNAP SHOT

MESSAGE LADDER

SUP-PORT

RATION EQUIPME

DIAG MESSG 1

DISPLAY ITEM

MEMORY

EXT_MEMO

RUN

EDIT

LOAD

EXEC

STOP

TOSHIBA MACHINE

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Security Classification :	Presentation Purpose Only
Distribution Scope :	TMA Sales
Information Owner :	IM Sales