

Mold open limit Ejector retracted Interval Cooling Delay Hold Filling Plast. Plast.end
 Mold full close Nozzle touch

Z-Screen [INITIAL] Disp-
lay RESULT

Real time actual		Position actual		Pres force actual		Time actual	
Screw pos.	0.00 mm	Fill start pos.	0.00 mm	Fill peak pres	0.0 MPa	Cycle time	0.0 sec
Fill pres.	0.0 MPa	V-P switch pos.	0.00 mm	All peak pres	0.0 MPa	Fill time	0.00 sec
Screw rev.	0 rpm	Cushion pos.	0.00 mm	Pack pres.	0.0 MPa	Plast time	0.00 sec
Plast.torq	0.2 %	Hold end pos.	0.00 mm	Clamp force peak	0 kN	Fill cnt.[Vel.] HP cnt. [Vel.]	
Clamp force	1 kN	Plast start pos.	0.00 mm	Plast end Back pres.	0.0 MPa	VP Actual [Pos.] Cnd. Z-Screen	
						Rev. ACT[]	

TEMP

15(15b)	5(15a)	4	3	2	1	0	Water
Actual	19.9	19.9	20.6	19.9	19.9		21.1
Process temp.	200.0	200.0	200.0	190.0	170.0		40.0

Flow front check OFF mm

Fill.delay sec

Filling time sec

Hold Pres. Vel. mm/s

Flash cnt. sec

	4th	3rd	2nd	1st	
Time	OFF	OFF	OFF	1.00	sec
Pres.	0.0	0.0	0.0	0.0	MPa

V-P — 4th 3rd 2nd 1st stg Filling
 Pos. OFF OFF OFF OFF mm
 Vel. mm/s
 Pres. MPa

Clamp. force kN

Plast.delay sec

Cooling sec

Interval sec

Min. Clp. F. result [~] kN

Pull back	2nd	Plast.	Pull back
<input type="text" value="0.00"/> mm	Pos. <input type="text" value="0.00"/> mm	<input type="text" value="0.00"/> mm	<input type="text" value="0.00"/> mm
<input type="text" value="25.0"/> mm/sec	Back pres. <input type="text" value="0.0"/> MPa	<input type="text" value="0.0"/> MPa	<input type="text" value="25.0"/> mm/s
	Rev. <input type="text" value="0"/> rpm	<input type="text" value="0"/> rpm	