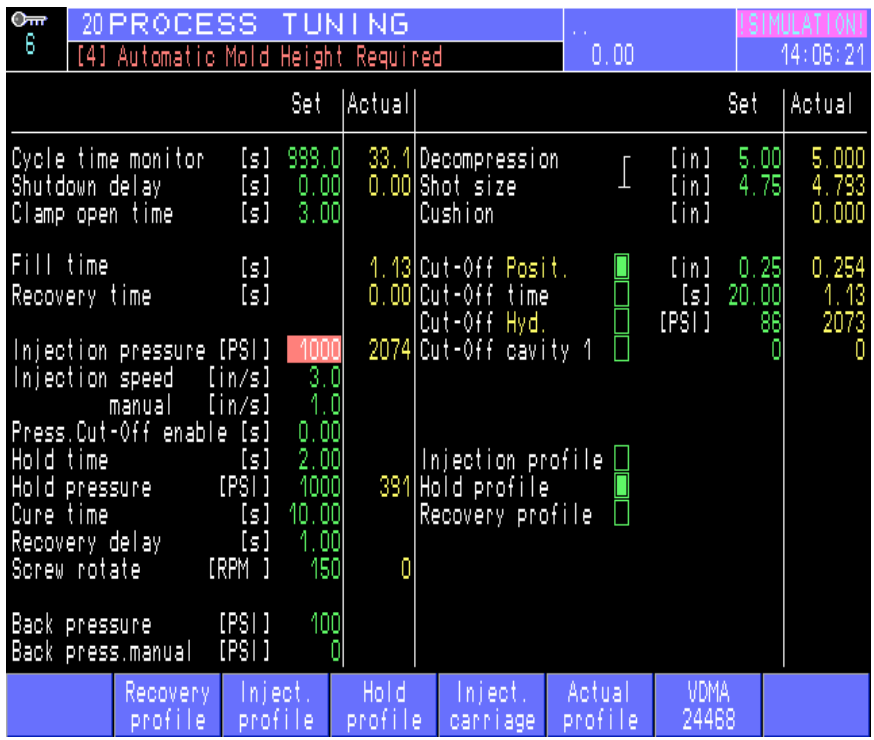


To determine Injection intensification ratios on Demag Ergotech NC4 and Ergo control machines:

1) On screen 83 SETUP select the “Pressure type” for Hyd.



2) Now select screen 20 PROCESS TUNING and set the injection holding pressure for 1000 psi.



3) Return to screen 83 SETUP and select “Pressure type” Spec. (Specific = plastic pressure).

The screenshot shows the '83 SETUP' screen with the following details:

- Header: 83 SETUP, [4] Automatic Mold Height Required, 0.00, SIMULATION, 14:03:04
- Printer settings: Type Graphic(Disk), Channel Parallel 1, Page length 40 Lines
- COM1 and COM2 settings: Baudrate 19200, Stop bits 1/NO, Parity NO, Report NO
- Units configuration:
  - in Stroke
  - in/s Injection
  - °F Temperature
  - RPM Rotation
  - in Stroke
  - PSI Pressure unit
  - Spec. Pressure type
  - tons Force
- Change reason list on the right with values 1, 5, and 10.
- Bottom navigation buttons: General info 1, Auto print, Password screen, Service screen, Change log, Change language

4) Go back to screen 20 PROCESS TUNING and look at the injection pressure setting value (not the “actual”). Divide that value (in this case 14,067 by the 1,000 that we saw on screen 20 in the first screen) and the result will be the intensification ratio.

The screenshot shows the '20 PROCESS TUNING' screen with the following data:

Parameter	Set	Actual	Parameter	Set	Actual
Cycle time monitor [s]	999.0	33.1	Decompression [in]	5.00	5.000
Shutdown delay [s]	0.00	0.00	Shot size [in]	4.75	4.793
Clamp open time [s]	3.00		Cushion [in]		0.000
Fill time [s]		1.13	Cut-Off Posit. <input checked="" type="checkbox"/>	[in] 0.25	0.254
Recovery time [s]		0.00	Cut-Off time <input type="checkbox"/>	[s] 20.00	1.13
Injection pressure [PSI]	14067	29167	Cut-Off Spec. <input type="checkbox"/>	[PSI] 1208	29154
Injection speed [in/s]	3.0		Cut-Off cavity 1 <input type="checkbox"/>	0	0
Injection speed manual [in/s]	1.0				
Press.Cut-Off enable [s]	0.00				
Hold time [s]	2.00		Injection profile <input type="checkbox"/>		
Hold pressure [PSI]	14067	5502	Hold profile <input checked="" type="checkbox"/>		
Cure time [s]	10.00		Recovery profile <input type="checkbox"/>		
Recovery delay [s]	1.00				
Screw rotate [RPM]	150	0			
Back pressure [PSI]	1407				
Back press.manual [PSI]	0				

Bottom navigation buttons: Recovery profile, Inject. profile, Hold profile, Inject. carriage, Actual profile, VDMA 24468