

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

MLT. TOGGLE UP Z-INJ.DET. [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.torg - 0.1 %	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	YP Actual [Pos.] Cnd. Z-Screen
			Rev. ACT[]

Clamp Control

Mode OFF Low pres. 0.0 % Screw 0.00 mm CL force 490 kN Pull out 50.0 % Cooling 10.0 sec

CL force alarm OFF 0.00 mm Time 0.00 sec Vel. 50.0 % Delay 0.0 sec Interval 5.0 sec

Hold Pres. 25.0 mm/s Flash cnt. 0.033 sec Flow front OFF mm Filling time 1.00 sec Filling

	4th	3rd	2nd	1st		V-P	—	4th	3rd	2nd	1st	stg	
Time	OFF	OFF	OFF	1.00	sec	STANDARD	Pos.	0.00	OFF	OFF	OFF	OFF	mm
Pres.	0.0	0.0	0.0	0.0	MPa	Flash pattern	Vel.	0.0	0.0	0.0	0.0	0.0	mm/s
Retract vel.	OFF				mm/s		Pres.	0.0					MPa