

Fiche de programme

Moulo: 39 Tabouret à Pastilles 40 N

Machine: 450/1

Matlère:

Dosage: 900Cm³ LP.Inj: Br

SOLIDIFIC: 20...S DECOMPAP: 30...Cm³

Palier 1: 8...%DOS Vitesse1: 55...%VM

VITES.Vis: 180T/min DECOMPAV: 0...Cm³

Palier2: 8...%DOS Vitesse2: 55...%VM

CONT.PRESS: 2...Bar CDEH.M: 0...%DOS

Palier3: 8...%DOS Vitesse3: 55...%VM

VIT.PURGE: 20...%VM

Palier4: 6...%DOS Vitesse4: 2...%VM

Temps M1: 2.5 S Pression M1: 40 Bar

RET.INJ/VER:.....S

Temps M2: 0...S Pression M2: 0...Bar

Temps M3: 0...S Pression M3: 0...Bar

Pass. P-INJE: 10 Pression CDE: 0...Bar

Zone	Consigne	Ecart
Zone 1	210	[-] 20 [+] 20 R
Zone 2	210	[-] 20 [+] 20 R
Zone 3	250	[-] 20 [+] 20 R
Zone 4	250	[-] 20 [+] 20 R
Nez	30	[-] ... [+] ... R
Buse	30	[-] ... [+] ... R
M1	0	[-] ... [+] ... R

Zone	RE/DO	ECAR A/R	VEIL: A/B	SC: V/C	COEF
Zone1	1 0	1 0	1 0	1 0	25
Zone2	1 0	1 0	1 0	1 0	25
Zone3	1 0	1 0	1 0	1 0	25
Zone4	1 0	1 0	1 0	1 0	25
NEZ	0 1	0 1	1 0	1 0	25
BUSE	0 1	0 1	1 0	1 0	25
M1	0 1	0 1	0 0	0 0	10

Veille A [0.] 0...% Veille B [0.] 0...%

Cycle: 90...S HORMAC.A: ...S
Entre Cycle: 0...S HORMAC.B: ...S

EJ.Pneumat.2 Retard: 2.8...S
EJ.Pneumat.2 Durée: 3...S
EJ.Pneumat.3 Retard: 3.8...S
EJ.Pneumat.3 Durée: 4.5...S
EJ.Pneumat.4 Retard: 2.2...S
EJ.Pneumat.4 Durée: 0.9...S

EJECT.HYD: EJECT.PNE
Retard: 0...S Retard: ...S
Sortie: 0...S Durée: ...S
Rentrée: 0...S Maint.Verrou: ...S
Retard.Visl: ...S
Retard.Recul C.INJ: 30...S

Eject.Pneumatique2: [1]
Eject.Pneumatique3: [1]
Eject.Pneumatique4: [0]
Blocage contre P: []
Masquage T Cyc: []

Cycle Auto: [1] Cycle Semi Auto: [0]
Relance Cycle: [0] OUV/INCI D.SS.EJ: [0]
Eject.Hydrau: OUV/INCI D.AV.EJ: [0]
MARCHE: [1]
TEMPOR: [0]
PULSE: [0]
PASS.PIECE N1: [1]
EJECT.PNEUMAT: [0]
INJ.TEMPO/VER: []
BOISSEAU OUVERT: []

F.VERROU: 400...T

C.ouverture: 69mm
C.ouvert L1: 20mm VIT.LENT1: 15...%VM
C.ouvert L2: 20mm VIT.LENT2: 15...%VM
OUVERT.PART: 0mm VIT.RAPID: 50...%VM
CDE.EJECT: 400...mm

C.FERMETURE L1: 40mm VIT.LENT1: 20...%V
C.FERMETURE L2: 20mm VIT.LENT2: 20...%V
VIT.RAPID: 45...%V
C.SECURITE: 20mm PRES.SECU: 30...Bar
FERM.PART: 0mm NUM.H.M: 1...