上海智覺光電有限公司

Operation manual

Administrator
2014/7/18 Friday

1. Machine

The mold guard machine parts are:

Camera   LED light
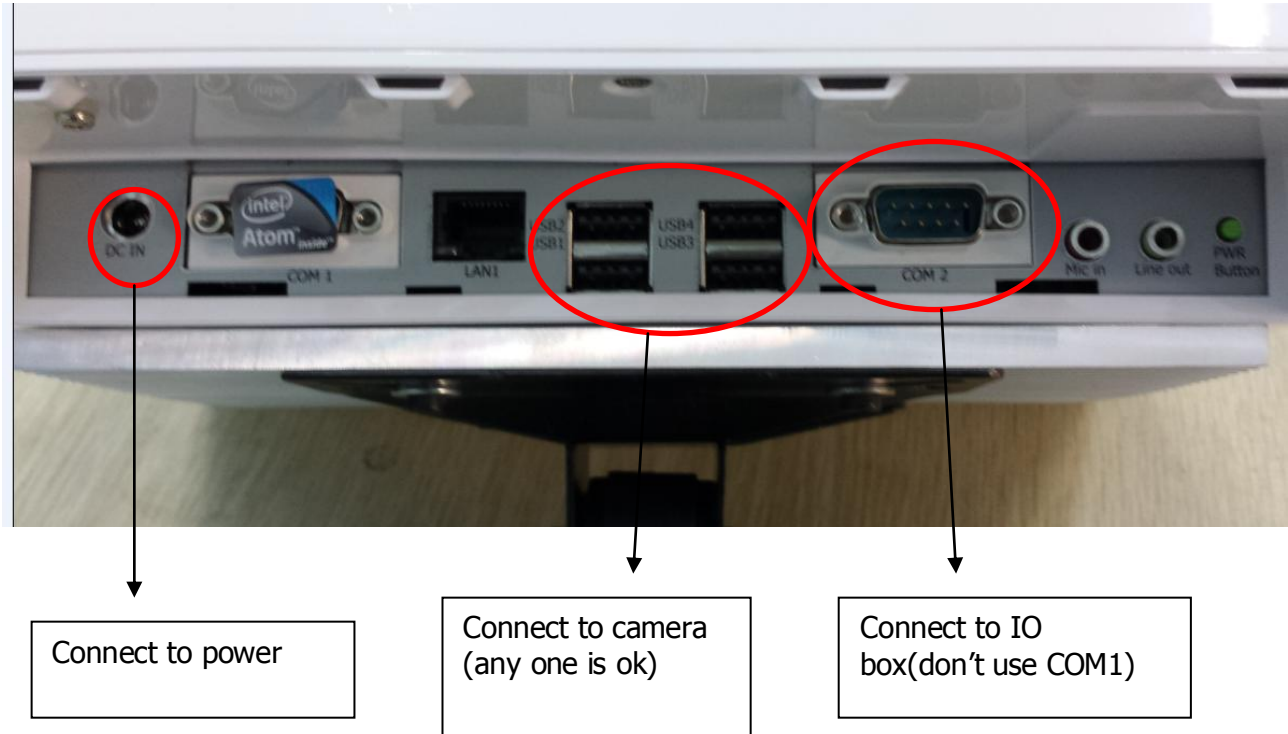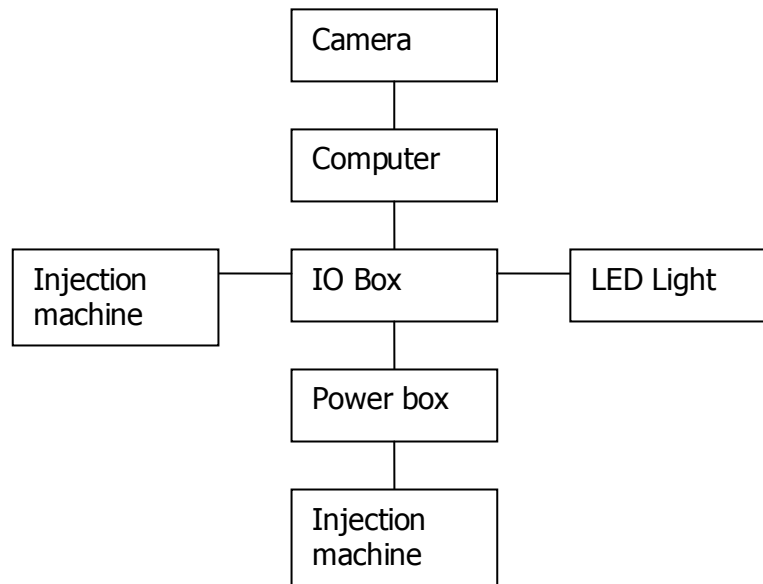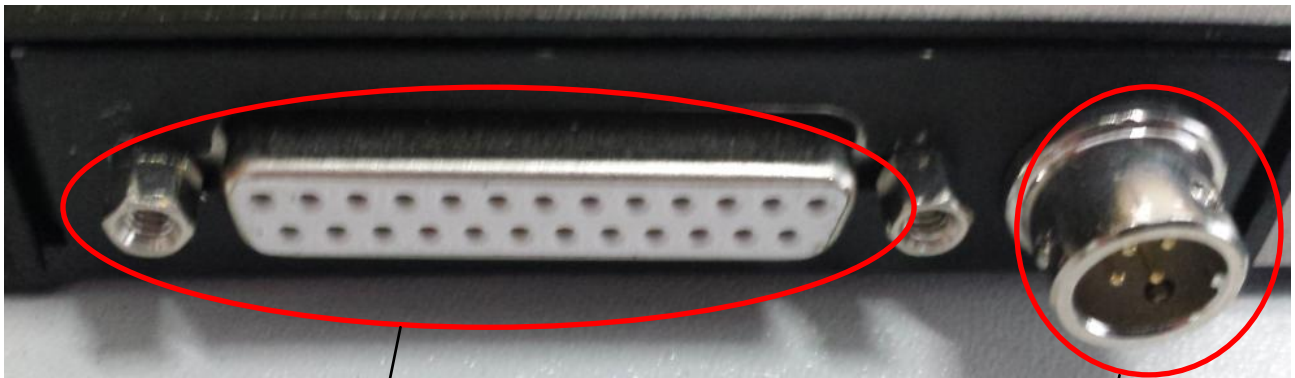

Computer   IO box
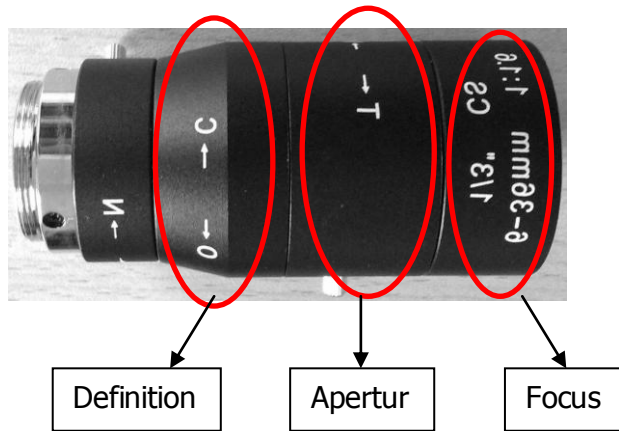

Power Box

Connection as below:

```
                    ┌─────────┐
                    │ Camera  │
                    └────┬────┘
                         │
                    ┌────┴─────┐
                    │ Computer │
                    └────┬─────┘
                         │
┌───────────┐      ┌────┴────┐      ┌──────────┐
│ Injection │──────│ IO Box  │──────│ LED Light│
│ machine   │      └────┬────┘      └──────────┘
└───────────┘           │
                  ┌──────┴─────┐
                  │ Power box  │
                  └──────┬─────┘
                         │
                  ┌──────┴─────┐
                  │ Injection  │
                  │ machine    │
                  └────────────┘
```


Connect to power

Connect to camera (any one is ok)

Connect to IO box(don't use COM1)

Connect to injection machine (signal cable)

Connect to power box

Connect to LED light

Connect to computer

2 Camera setting

| Definition	Apertur	Focus

- First, adjust "Apertur" to get a proper brightness.

- Second, adjust "Focus" to get a proper picture size, best size is 2/3 of the screen.

- Third, adjust "Definition" to make the picture clear.

- Finally, tight all the screw.

3、Software setting

The mold guard has two step detection, first step is "plastic detection", it is to check whether the products remain on the fixed side; the second step is "mold detection", it is to check whether the products remain on the moved side.

The setting is the same, we set "mold detection" for example:

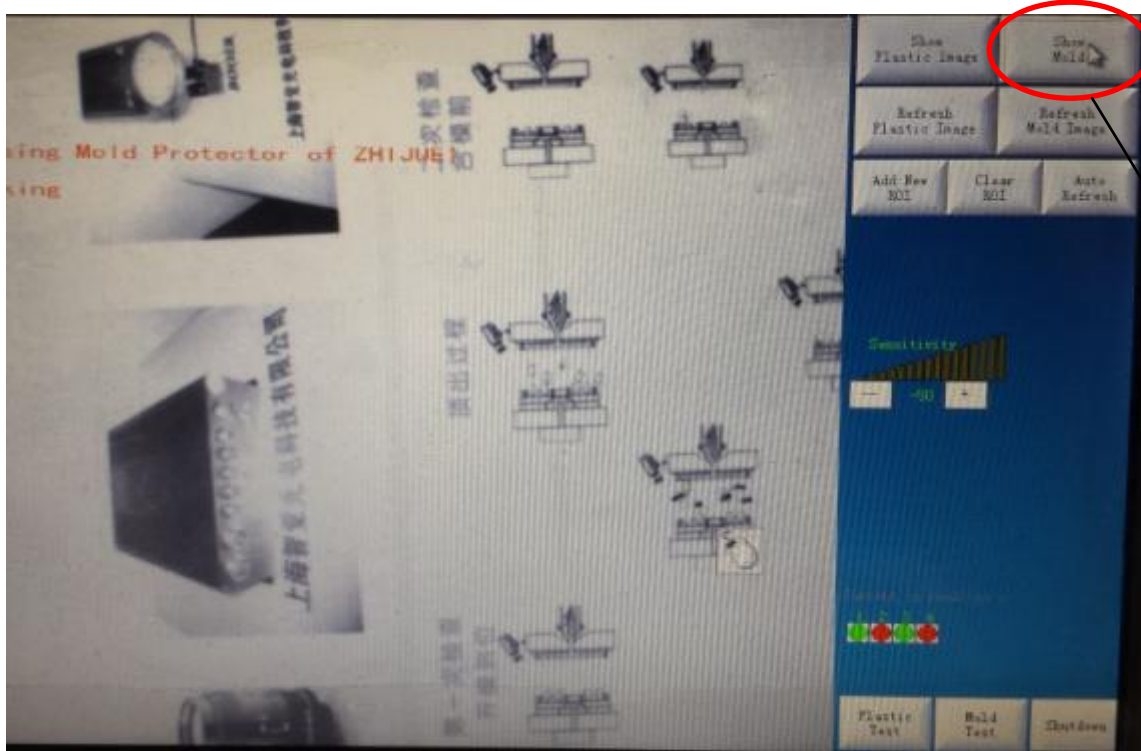(1) Take mold (cavity) standard picture.
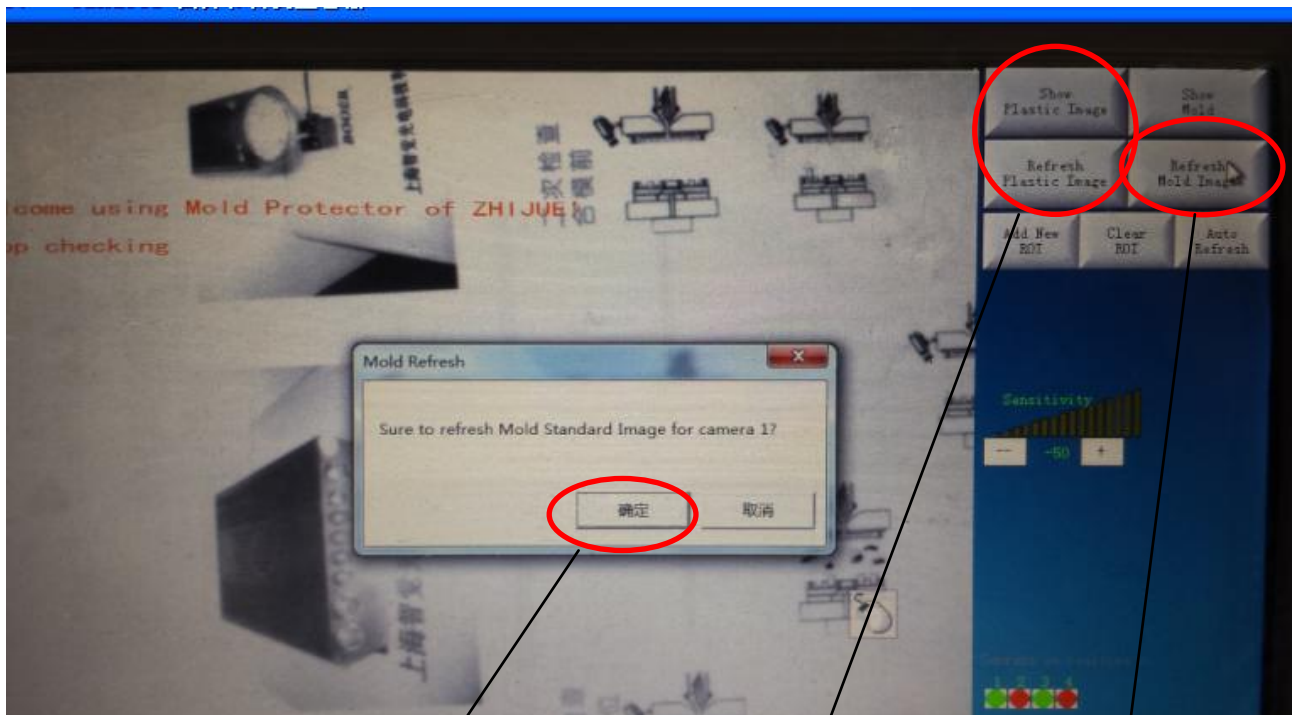
Then press "YES" to get the mold standard picture

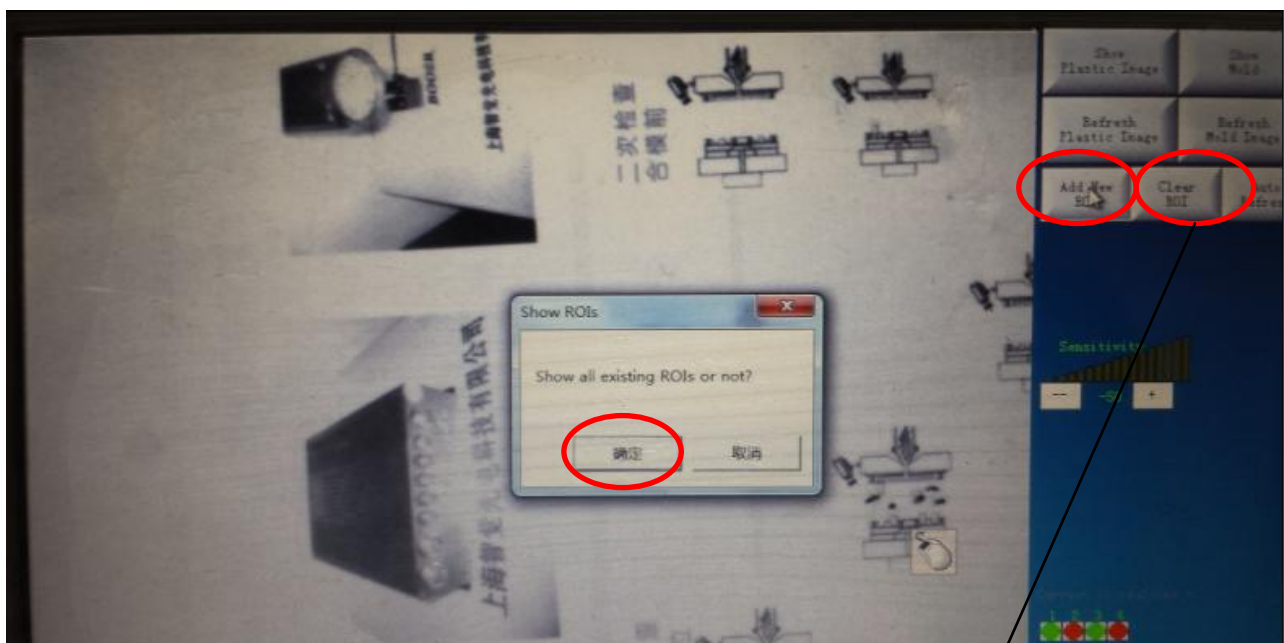These two button for "Plastic check", if your product stick to the fixed side, you can use it

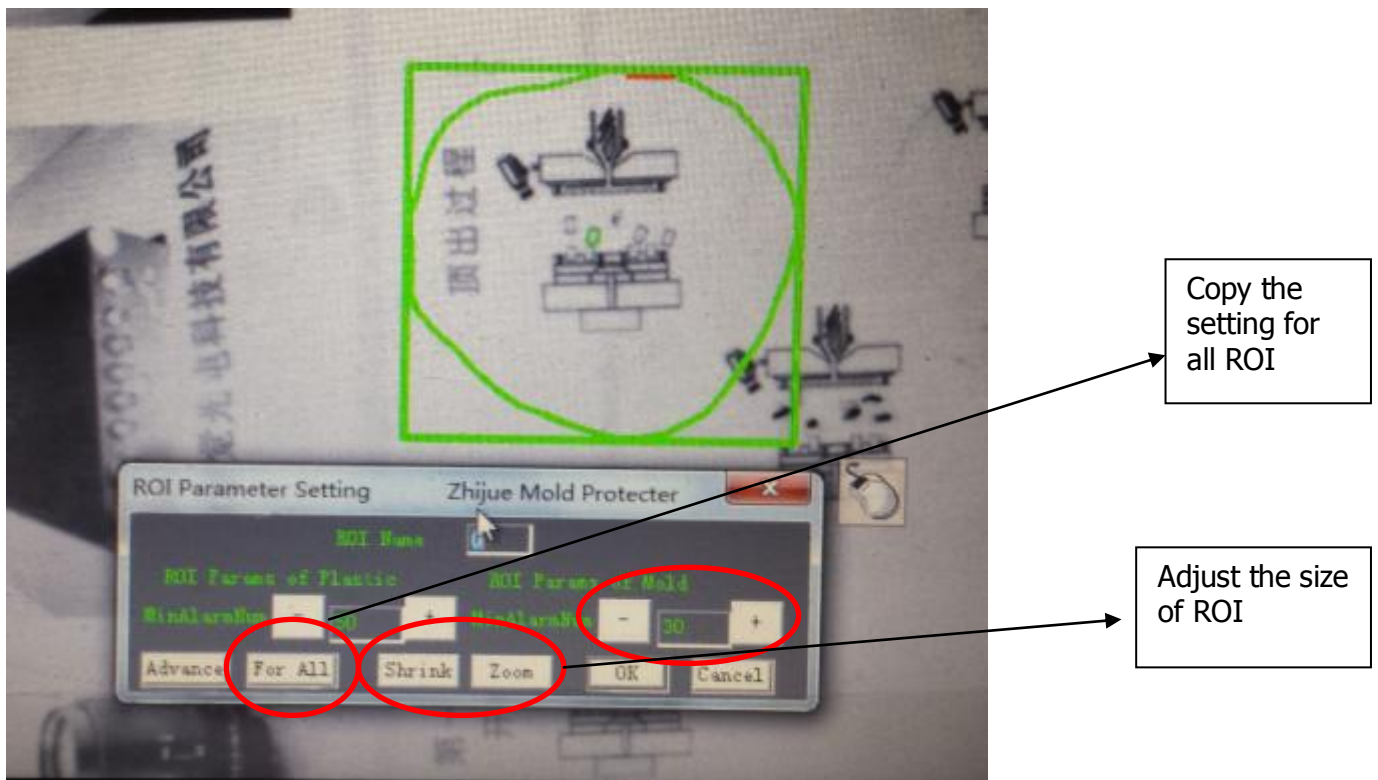Press "refresh mold image"

(2)Show mold standard picture

Press "show mold" to show the standard picture on the screen.

(3)Add new ROI(region of interest)

Clear ROI means click to clear all ROI you draw

Copy the setting for all ROI

Adjust the size of ROI

Draw the ROI for the cavity, and set the "min alarm num" for sensitive.

Sensitivy setting: the bigger number means more accurate, normally set to the center number

,
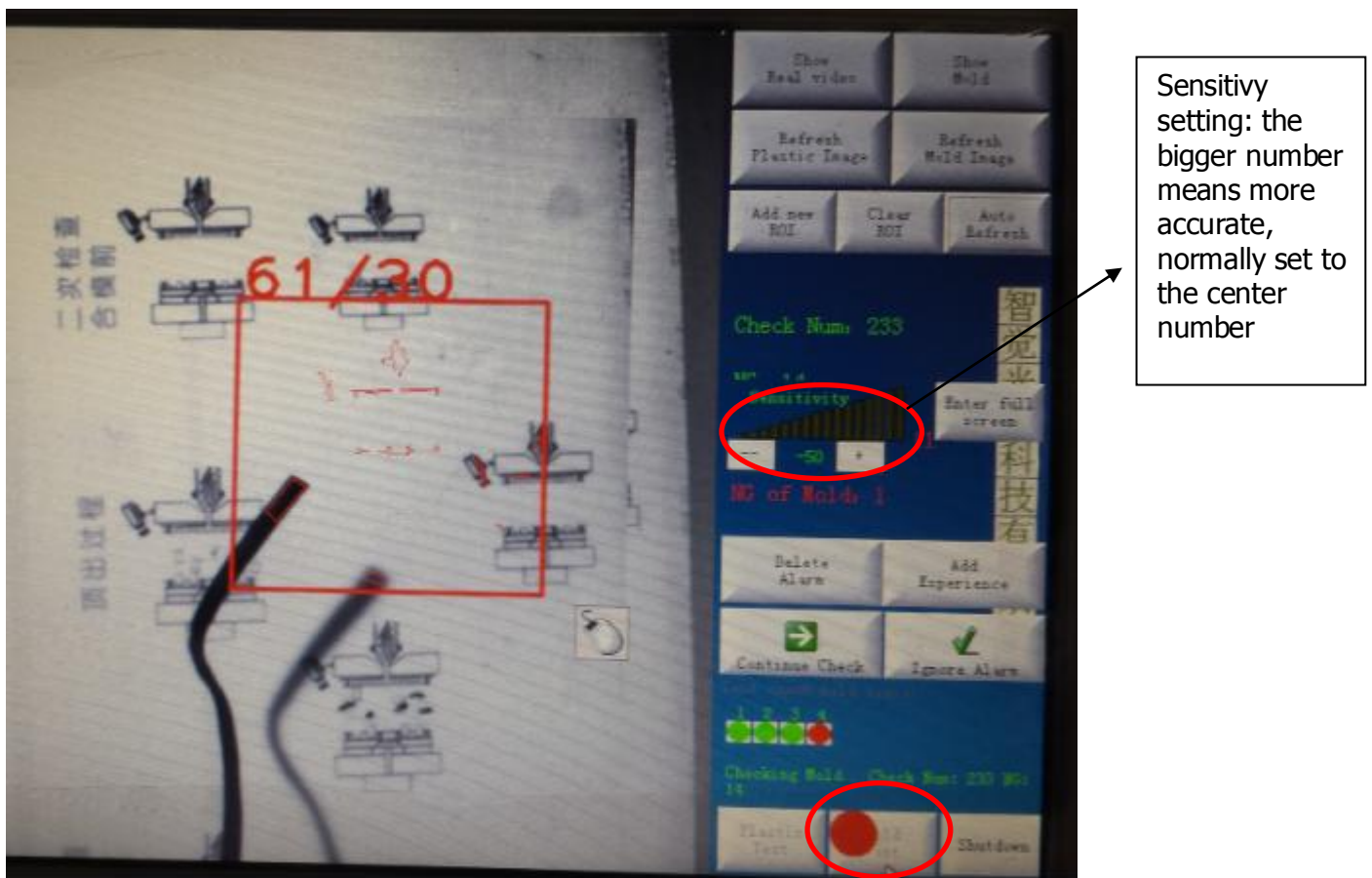
If you don't know how much is the best setting, put something into the cavity and press "mold test". You can see something like 61/30, 30 is the sensitive

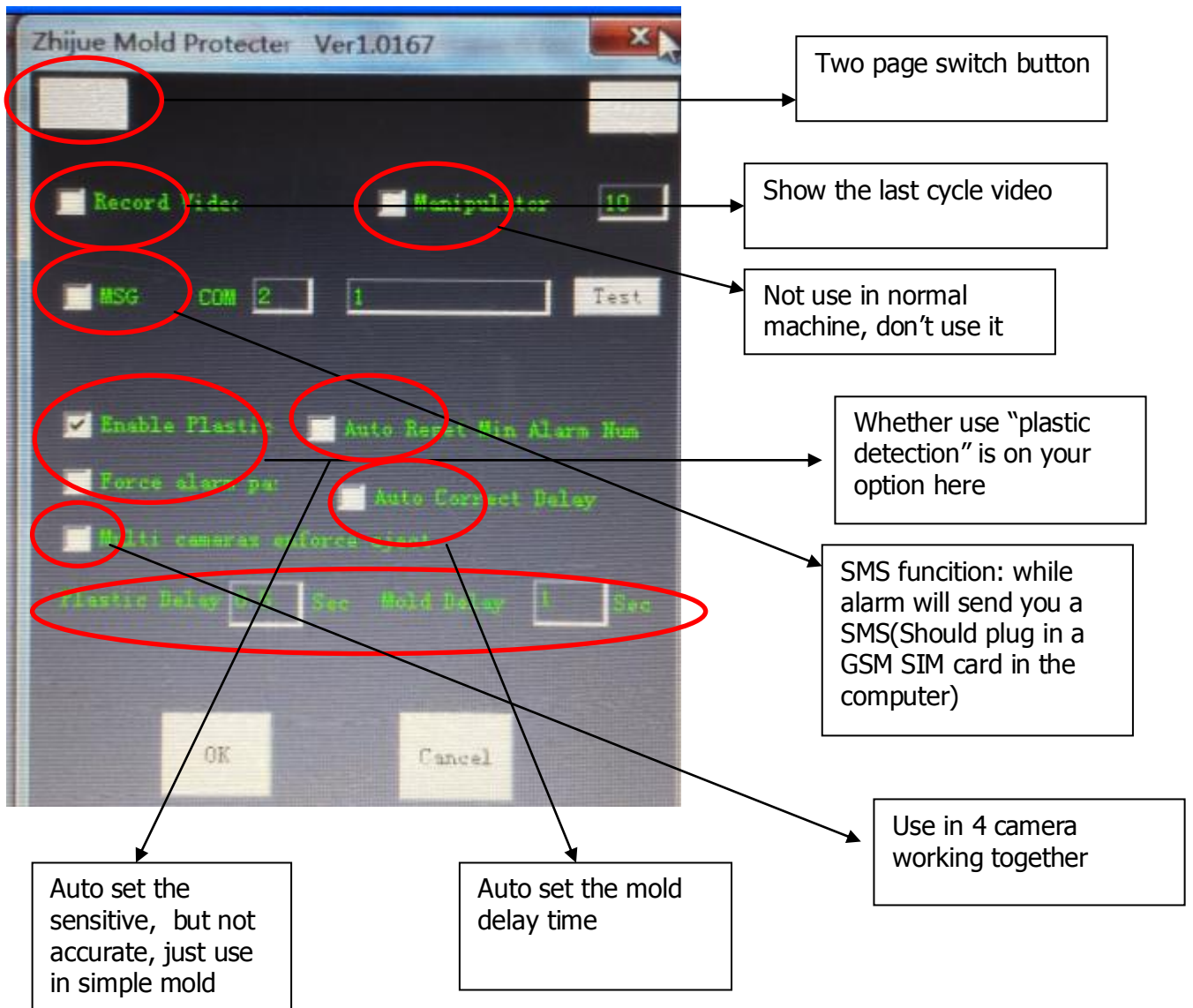you set, 61 is the size of the object. The sensitive must lower than the object, otherwise it will be ignore.
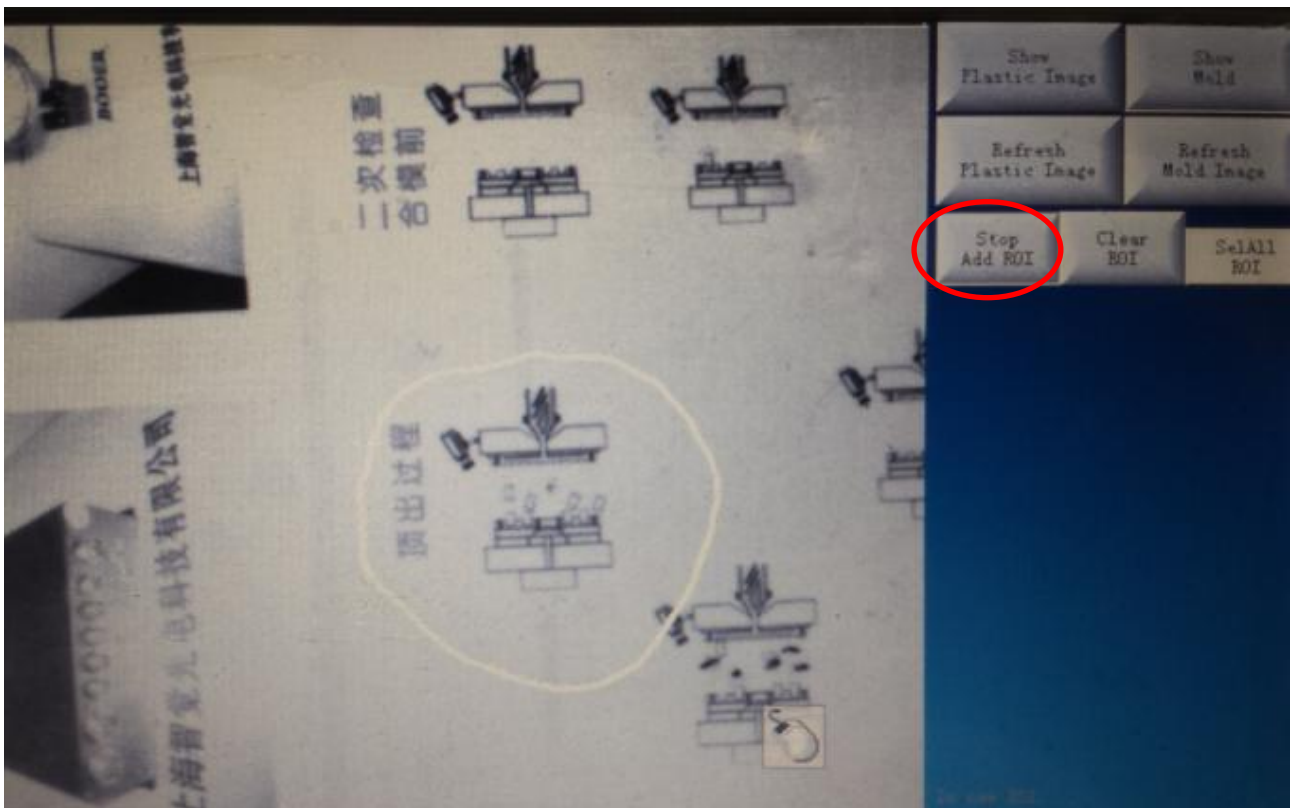
After finished, press "stop add ROI"

(4)Set the delay time for camera.

Press setting button.

Two page switch button

Show the last cycle video

Not use in normal machine, don't use it

Whether use "plastic detection" is on your option here

SMS funcition: while alarm will send you a SMS(Should plug in a GSM SIM card in the computer)

Use in 4 camera working together

Auto set the sensitive, but not accurate, just use in simple mold

Auto set the mold delay time
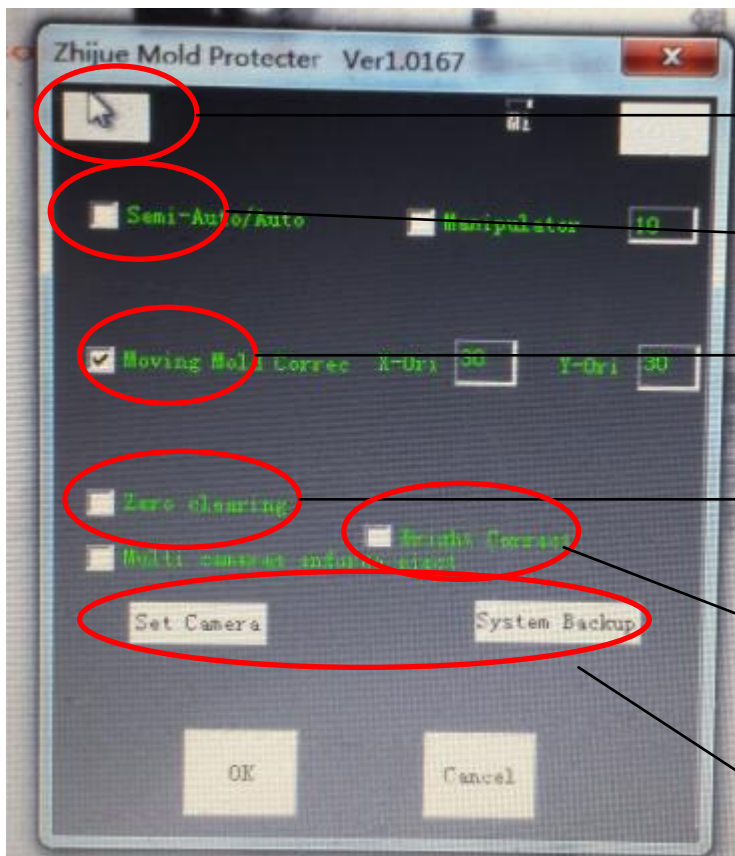
Set the delay time for camera, time is counted from mold open end.

Mold delay 1 sec means that after mold open end, camera wait 1 sec and take picture.

Zhijue Mold Protecter Ver1.0167

- Two page switch button
- Semi-Auto/Auto — Tick it will turn into semi-auto mode
- Moving Mold Correc X-Ori 50 Y-Ori 30 — Very important function, it will auto revise the picture different cause by mold open distance
- Zero clearing — Tick it will set the counting zero.
- Bright Correct — If sunlight shine to the mold, use this function to revise picture difference
- Set Camera / System Backup — Already set in china, don't use it

If your machine is working semi-auto, then time setting is different. Time counted from safe door close, not from mold open end. So in semi-auto mode, mold delay time you can set 0.
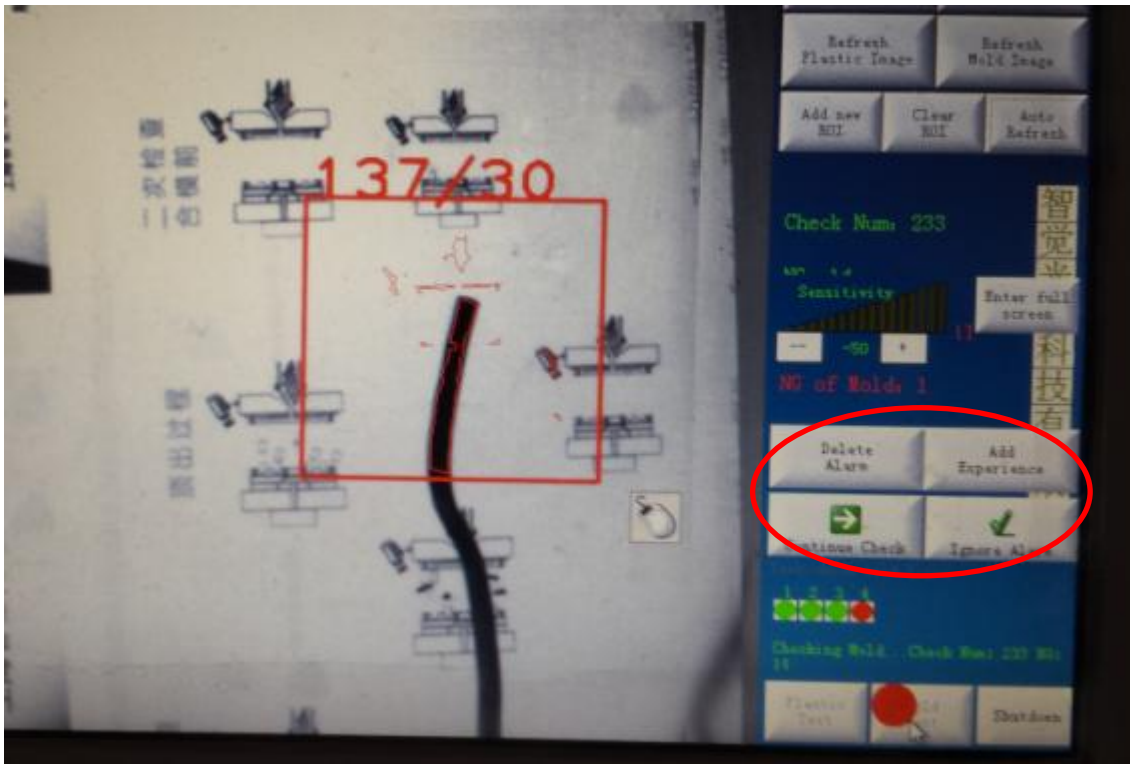
Other function don't use them.

(5) Start working

Add means add another standard picture

Re-check means check again before mold close

4. Alarm handle

 When alarm happen, 4 button show in the screen.

"Delete alarm" means you don't need to check this area, and next if some other thing occur in this area, the system will ignore.

"Add experience" means add this picture as standard picture too, when false alarm happen, use this function.
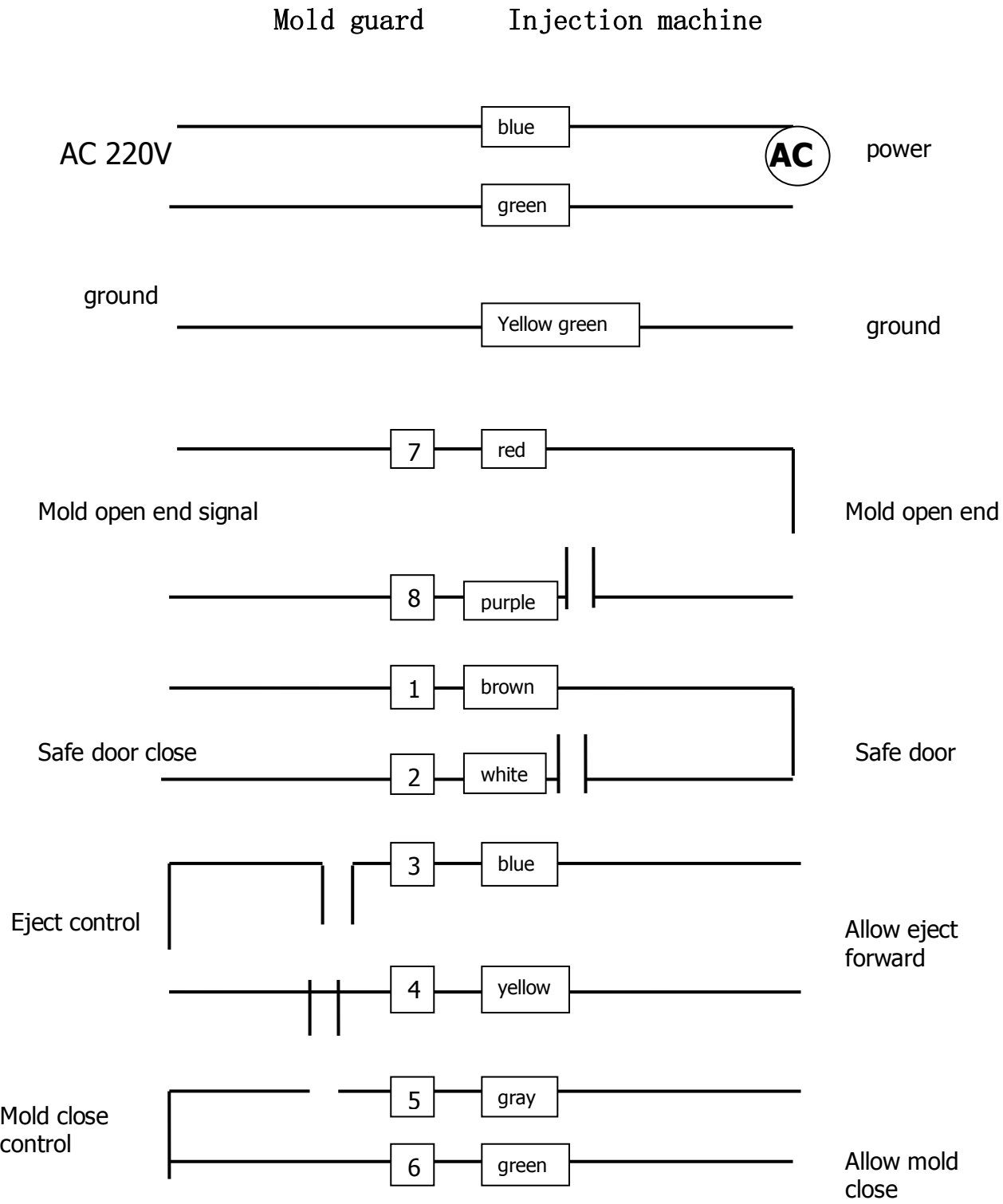
"Continue check" means check again.

"Ignore alarm" means you don't care this alarm, the mold will close after you press it.

Also you can see the 4 button in the host

Wiring diagram

Mold guard   Injection machine

AC 220V | blue | (AC)   power

| green |

ground | Yellow green | ground

| 7 | red |

Mold open end signal   Mold open end

| 8 | purple |

| 1 | brown |

Safe door close   Safe door

| 2 | white |

| 3 | blue |

Eject control   Allow eject forward

| 4 | yellow |

| 5 | gray |

Mold close control   Allow mold close

| 6 | green |

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Error Handle

Error: (1)The camera not working.

(2)Can not enter software.

(3)Detection speed slow down.

(3)Other error

Handle: (1)Re-start the computer, it will fix most problem.

(2) If problem still exist, first exit the software to the Windows desk. Then plug in the USB driver, it will renew the software automatically.

(3) If still not solve the problem, take the picture and send e-mail to zy88@s110.cn, we will help you.