

Production Starting Guide

Starting the production with Cavity Eye Smart Moulding Control supervision.

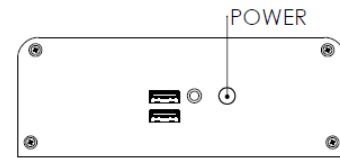
Applicable model: SMC8, SMC16, SMC32, SMC64.

1. What does an SMC system consist?

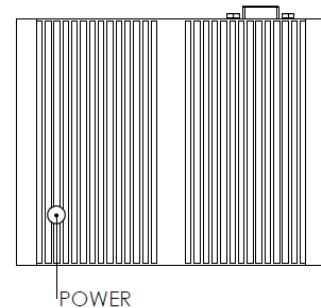
Part name
SMP8 plug
SCP412 plug
Local database (PC Unit)
Touchscreen
PoE Switch
UTP cable with bayonet lock
UTP cable 300 mm
Monitor cable (USB Mini-B – USB-A)
USB Interface – Data saving
Power Adapter 19V to PC
Power Adapter 48V to Switch
Mounting accessories (Monitor holder, screws, DIN rail etc.)

2. Power on

- Plug the power supplies into the 230 V/50 Hz source. Check that the power LED light up on the PC and the SWITCH.
- The system starts automatically. If not, then you have to turn the PC on manually.





The older models have the power button on the top.





When the system started, the LED will turn blue on the power button.

3. Starting Cavity Eye

- When the system is running, you can start the Cavity Eye software by clicking on the  icon on the desktop.
- You have to log in to the software to be able to use it. Click on the blinking log in button  and enter your password. The default password for *engineer* user is: **67890**

4. Enter IMM ID

When first starting the software, you have to add a new IMMID and set it as default. Measure mode can not be started until an IMMID is added.

- Navigate to the Settings menu  and open additional settings .
- In IMMID list select the appropriate machine ID and set it as default. If it is not in the list, click Add IMMID button and add a new ID to the list.

5. Start data acquisition



- Launch the data-acquisition by clicking on *START* button on the right side.
- After starting the data-acquisition you will see the Process Monitor, which shows the real-time pressure data by individual SMPs.

- c. You can switch among the connected SMPs' data by clicking drop-down menu on the top left corner.



6. Set reference

When first using the mould with Cavity eye system, you have to set a reference for the production and separation. If the mould was already operating with the Cavity Eye system, you can select an existing reference.



6/A. Set new reference

- a. Navigate to Trigger Monitor  on the right side.
- b. Go in to the Trigger settings .
- c. Set the delta time in Trigger tab.
- d. Set the number of averaged cycles in Averaging tab.
- e. Wait for a suitable cycle and set it to reference.





- f. Navigate to Analysis Monitor  on the right side.
- g. Go in to the Analysis settings .
- h. Set the upper and lower pressure and time tolerance.

6/B. Select an existing reference

- a. The software loads the last used reference or the default reference if it was set.
- b. For select another existing reference, navigate to Log Monitor .
- c. Go in to the Reference Manager .
- d. You can see all previous references and set a default reference with the *Set as Default* button. (The Cavity Eye will always load the reference set as default at the start.)


7. Set the selector signal

- a. Navigate to Analysis Monitor  on the right side.
- b. Go in to the Selector settings .

- c. Set the selector signal length in the percentage of cycle time

The Cavity Eye emits selector signal in case of good parts by default. The Cavity Eye software start evaluating good or bad part and giving output signal - corresponding with the part's evaluation - right after the Delta time passes.

8. Turn on Measure Mode

- a. Click on Measure Mode button  on the upper right corner.

Cavity Eye Hungary Kft.
Szellő str. 1.
6000 Kecskemét
Hungary
Tel: +36 76 951 966
info@cavityeye.com
www.cavityeye.com



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INTELLIGENCE IN MOLDING