

Production Starting Guide

Starting the production with Cavity Eye Smart Moulding Control supervision.

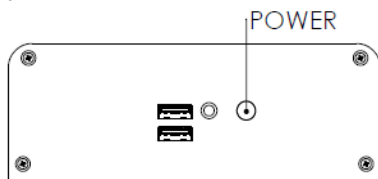
Applicable model: SMC8, SMC16, SMC32, SMC64

1. The content of the system

Part name
SMP plug
SCP 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.




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 the 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: 67890.

4. Check Smart Plugs

- Open Device Manager .
- Check if the system registrates all the connected Smart Plugs.
- In case of not seeing a Plug you connected:
 - Exit the software
 - Disconnect and reconnect the plug. Check if the plug receives power
 - Start the software again

5. Enter IMM ID

The SMC system automatically reads the injection molding machine ID (IMMID) from the SCS16 socket. When first starting the software, or if the SMC system is transferred to another injection molding machine, you have to add a new IMMID and set it as default. Measure mode cannot 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, type it in the New IMMID field, and then click Add IMMID button to add the new ID to the list. Set the new ID you created as the default by clicking the Set as default button.



6. 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.
- You can switch among the connected SMPs' data by clicking drop-down menu on the top left corner.



7. 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.



7/A Set new reference

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





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

7/B Select an existing reference


- The software loads the last used reference or the default reference if it was set.
- For select another existing reference, navigate to Log Monitor .
- Go in to the Reference Manager .
- 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).

8. Set the selector signal

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

9. Turn on Measure Mode

- Click on Measure Mode button  on the upper right corner.
- After the Measure mode is activated the Cavity Eye system automatically performs a reference-based evaluation of each shot and outputs the selector signal. During the Measured Mode is activated, no production setting is available. To change any settings, you must turn off the Measurement Mode first.