4 Channel 400 Point Modular Parison Controller
OVERVIEW

FEATURES & BENEFITS

HALF OF A CENTURY OF EXCELLENCE IN MOTION CONTROL

Moog control systems have been fitted by blow moulding machine manufacturers worldwide, and also as retrofit equipment by many thousands of end users. The system is user configurable for accumulator head and continuous extrusion machines running single or multiple parisons. In addition to features you have come to expect from the most established leader in this field, you will find that this new system includes advanced features like automatic calibration, alarm log, selectable interpolation methods and many more. This is the most advanced parison programmer on the market, and gives unsurpassed precise parison wall thickness control for optimising material usage and uniform distribution.

SYSTEM OVERVIEW

User Interface

- TFT color LCD, 640x480 pixel
- Rotary control knob for a rapid and accurate set-up of functions
- Limited number of keys for an easy navigation
- LEDs to monitor the main states of the machine
- Scalable structure of screen maps to optimize each map upon machine configuration (e.g. number of channels, closed-loop/open-loop, etc.)
- 3 access levels for data protection
- Removable memory for recipes (calibration and process data)

System Architecture

- Logos IEC61131-3 standard programming system for Windows, ST language based on the Moog Plastic Controller, 400 Series
- Modular structure (e.g. Fieldbus connectivity, Blow Pin management, etc.) for additional expansion modules

FEATURES

- 4 independent channels for:

  Head Parison Control (from 1 up to 4)
  - Parison profile programmable from 10 to 400 points
  - One single profile for all heads or independent profile
  - 5 interpolation modes (even in the same profile)
  - Up to 400 analog and digital markers (from 1 to 400)
  - Open-loop or closed-loop manual and automatic calibration
  - Handling of standard actuators and servoactuators with integrated electronics (hydraulic and electric)
  - Different molds on the same head can be used in successive turns (alternate parison mode)
  - Graphic feedback profile
  - 2 independent starts for special machines
  - Fixed or self-adjustable parison cycle time

Position Base Accumulator Heads

- Accumulator profile programmable from 10 to 400 points, selectable via software
- Open-loop and velocity closed-loop pushout control (in velocity closed-loop pushout mode you can set the pushout time).

Extruder Control

- Digital or analog extruder velocity control
- Parison length control can be used for continuous extrusion machines and accumulator position base
FUNCTIONALITY

- Users input data (numeric, profile, navigation) by rotary control knob for ease of operation
- Removable memory for recipes management
- LEDs indicating the configuration and the status of the machine
- Keys for direct command of purge, tooling

MAIN MENU PAGE

- User-friendly main menu
- Password level management

HEAD SETUP PAGE

Easy calibration, with the ability to select:
- Manual calibration in open-loop
- Manual calibration in closed-loop
- Automatic calibration in closed-loop

Easy head selection
Profile length correction
Choice of different actuators:
- Hydraulic/Electro-mechanical
- With or without feedback

HEAD OPERATION PAGE

Editor for parison axis that shows these profiles:
- Working
- Editing
- Feedback

- Manages Synchronism
- Manages analog and digital markers
- Shows the working current point
- It allows inserting master and interpolation without limitations
- Handles purges and tooling commands

INPUT/OUTPUT PAGE

Real time diagnostic of all digital and analogic I/O