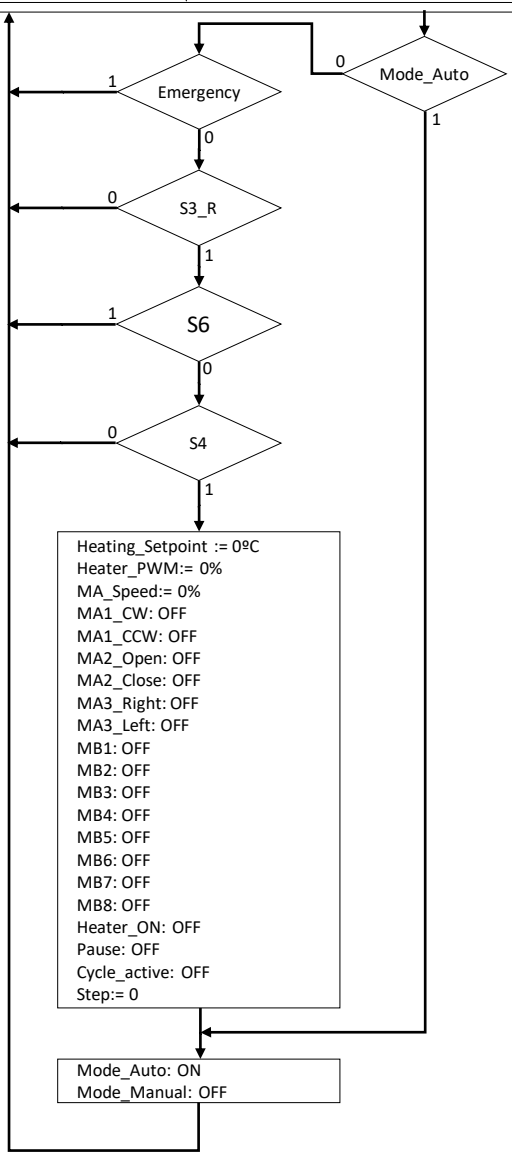


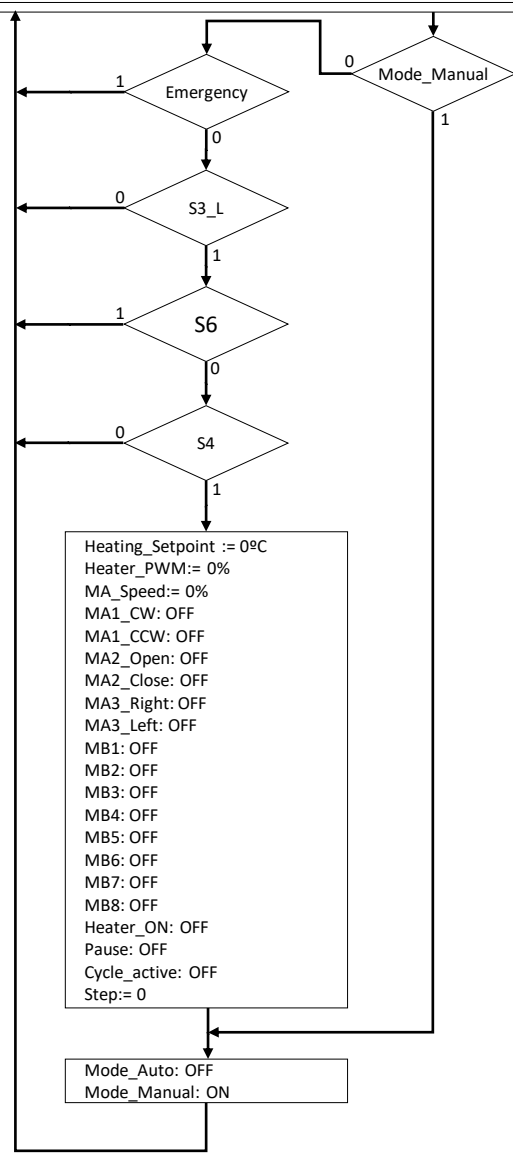
**Note:**  
Switches, Push buttons or other devices **Actuated/True = state "1"** on the function diagram  
Switches, Push buttons or other devices **Not Actuated/Not true = state "0"** on the function diagram

Power ON

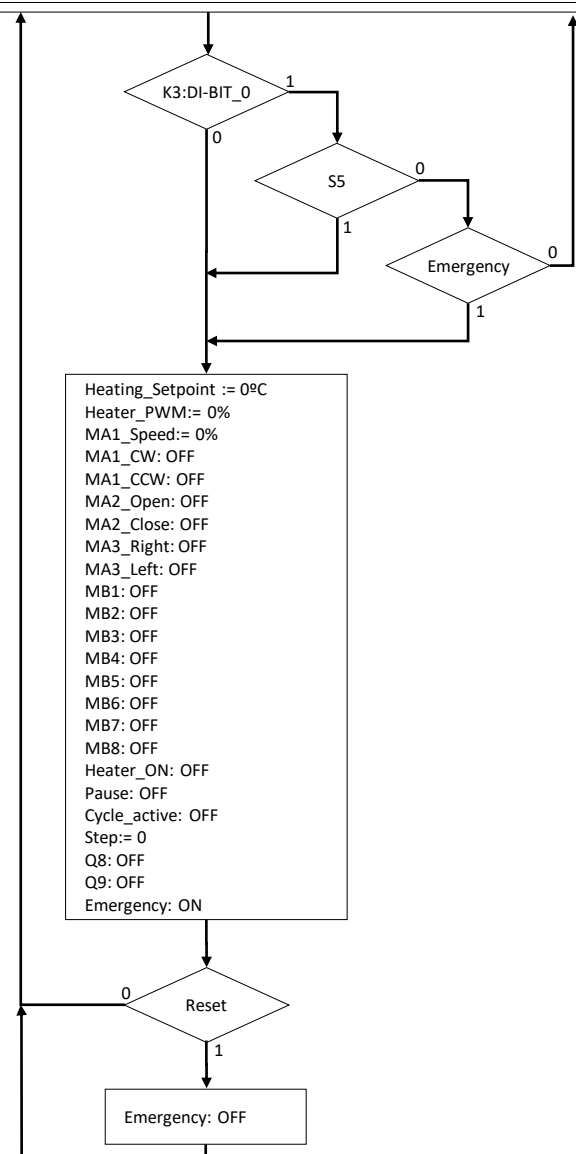
All actuators : OFF



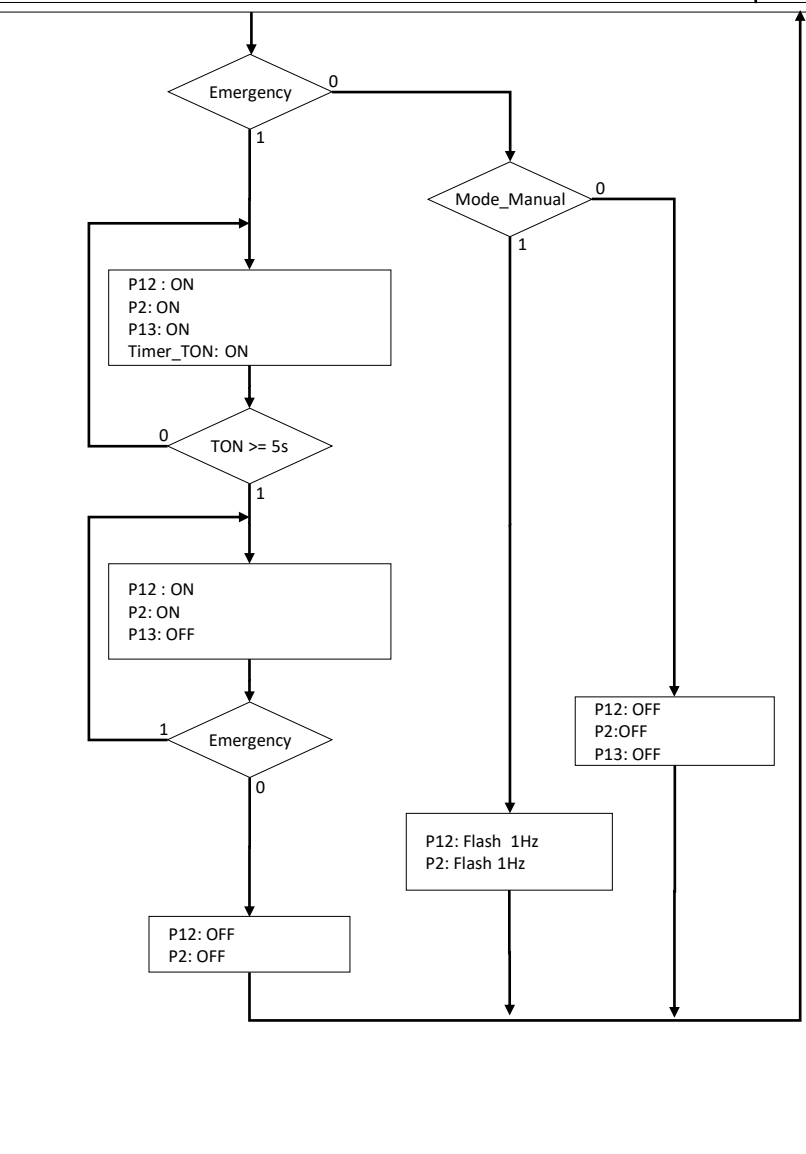
Mode\_Auto

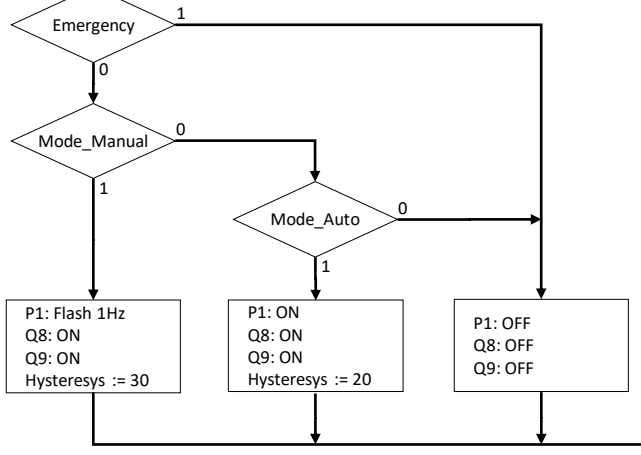
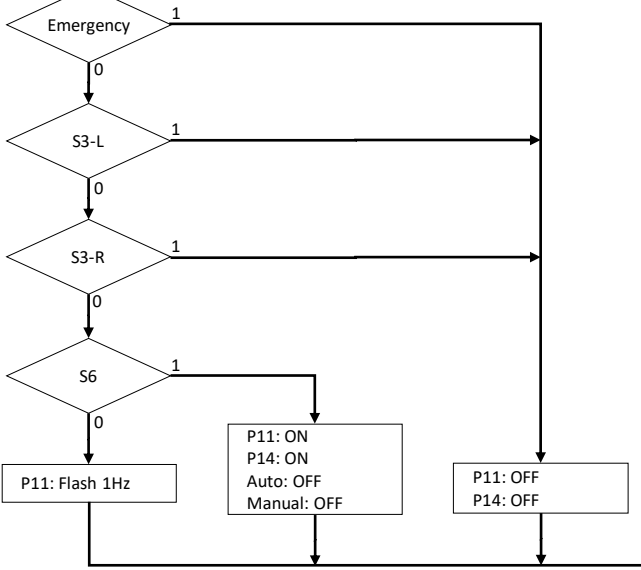


Mode\_Manual

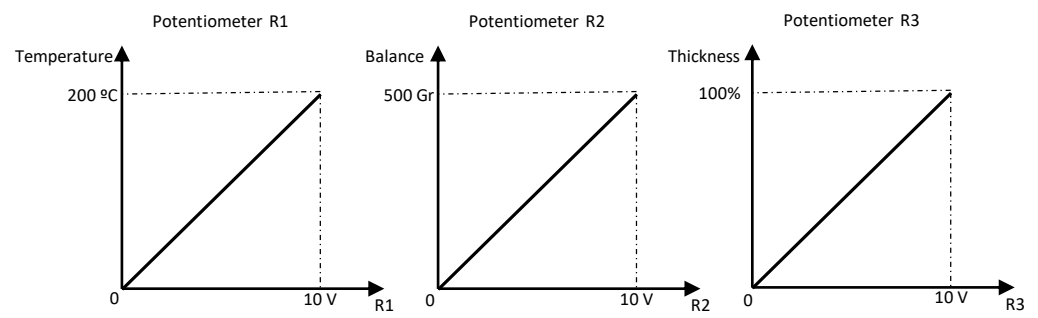
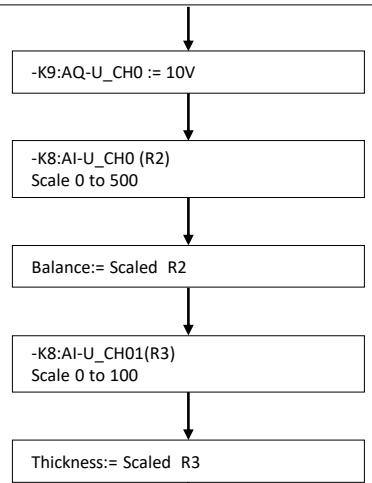
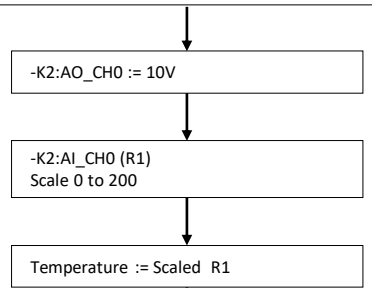
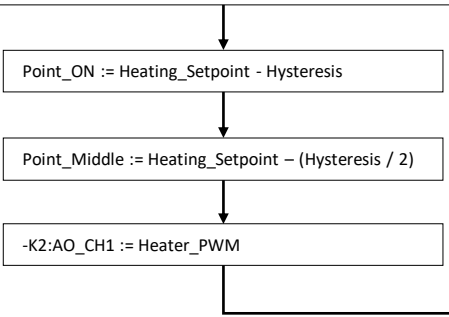


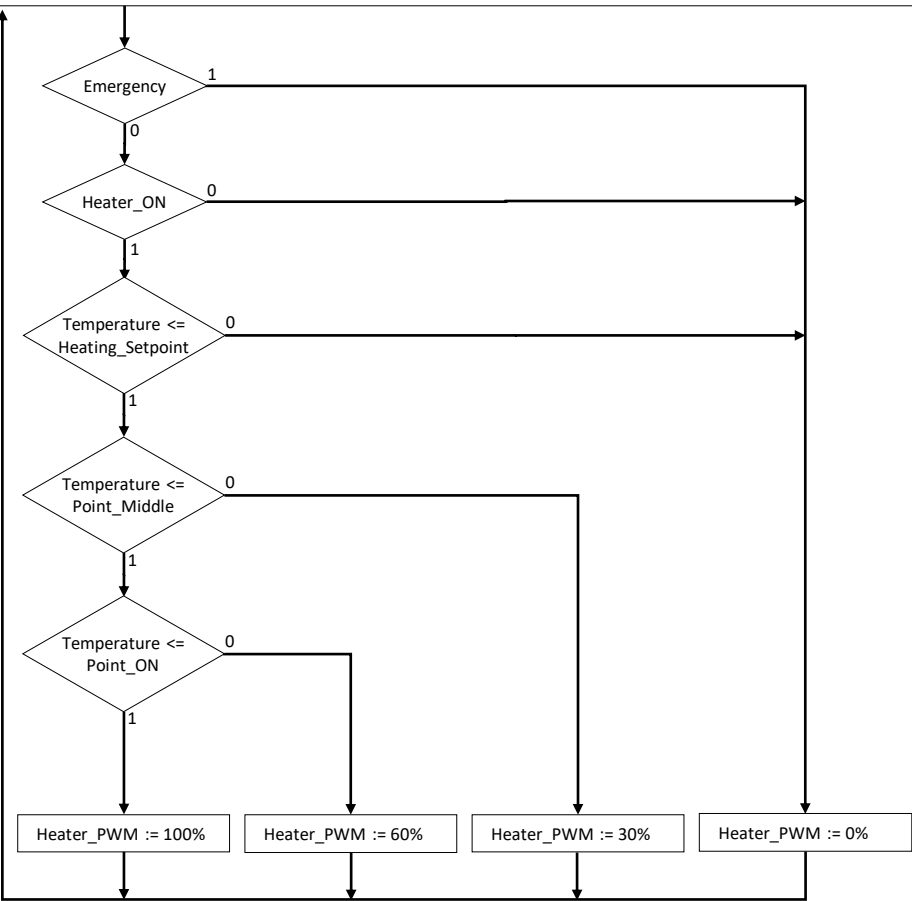
Emergency\_STOP / Reset





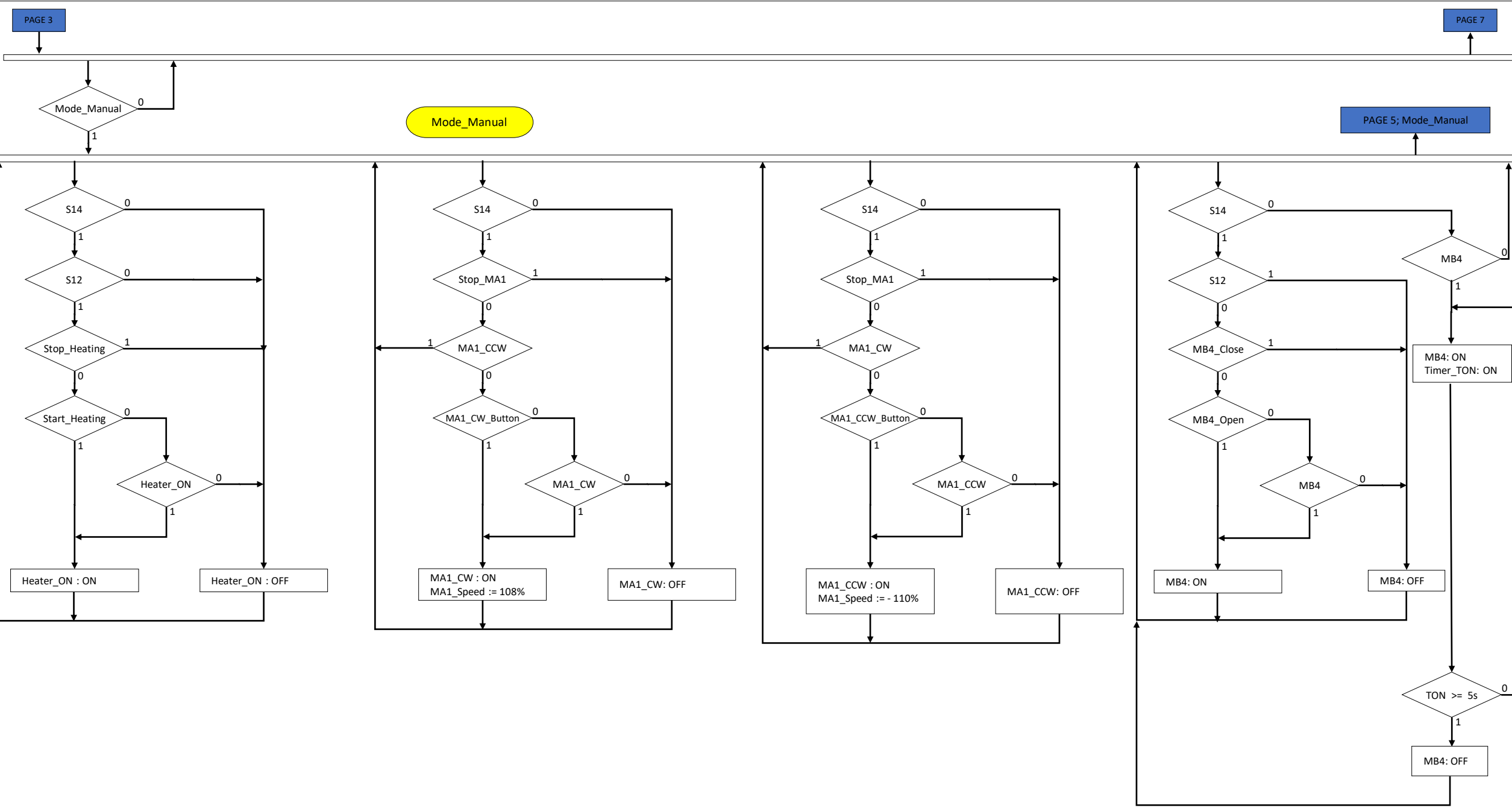
Maintenance\_Mode

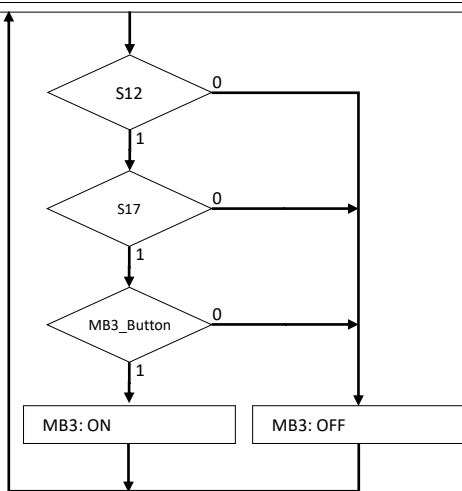
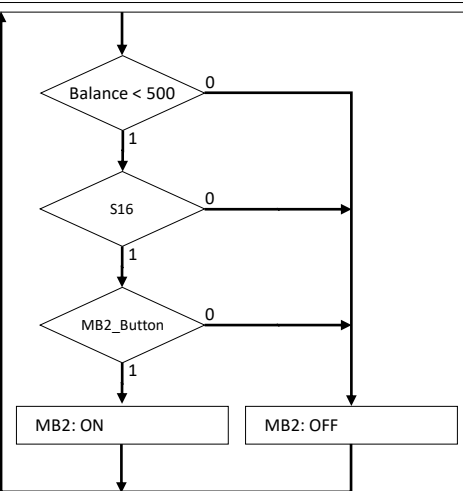
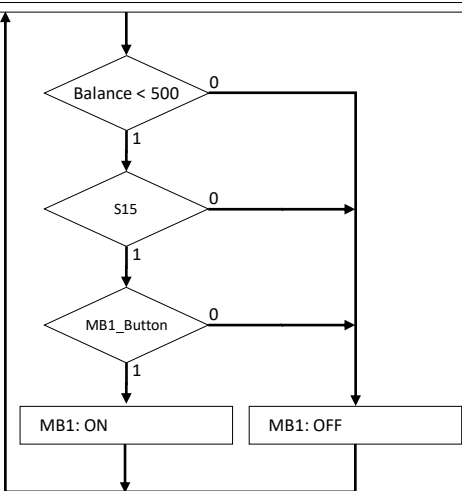
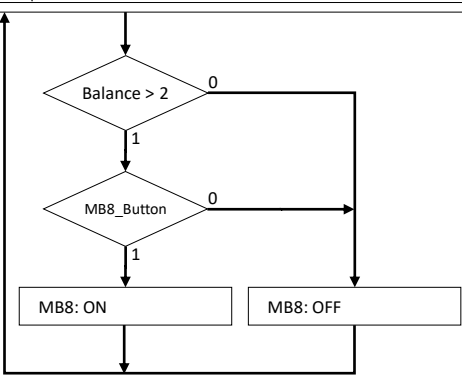
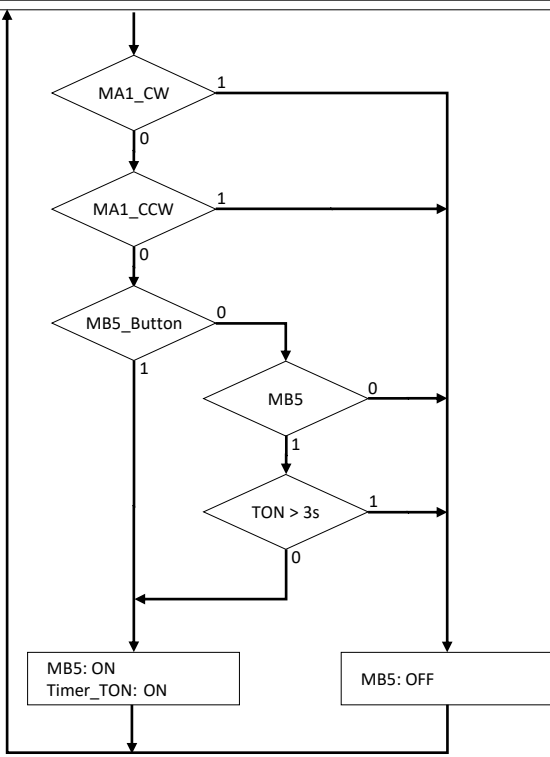
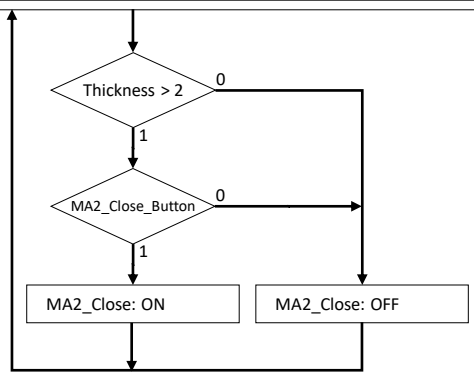
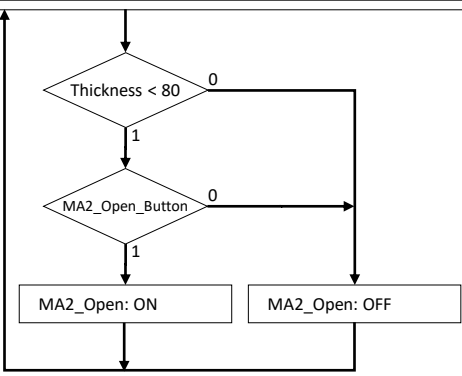


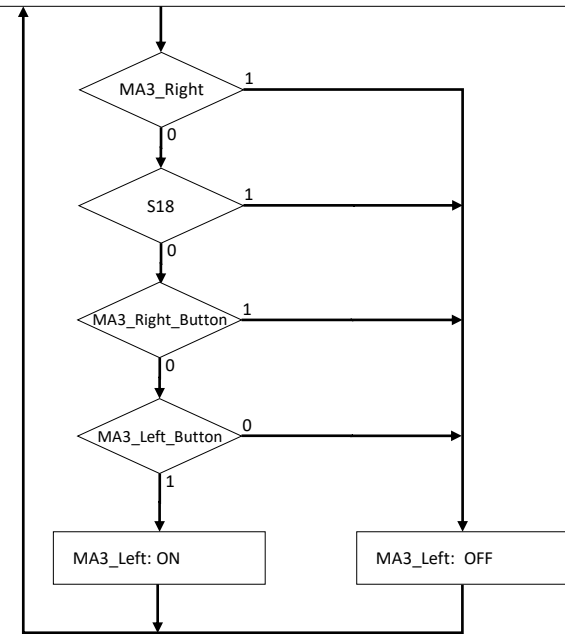
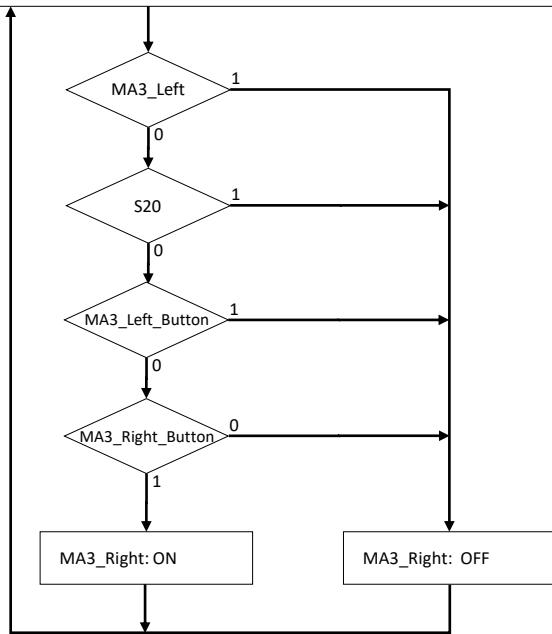
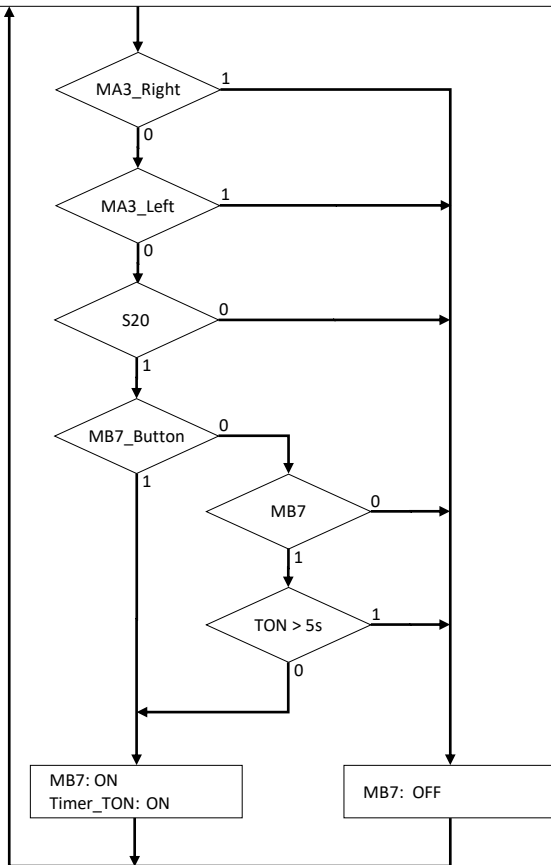
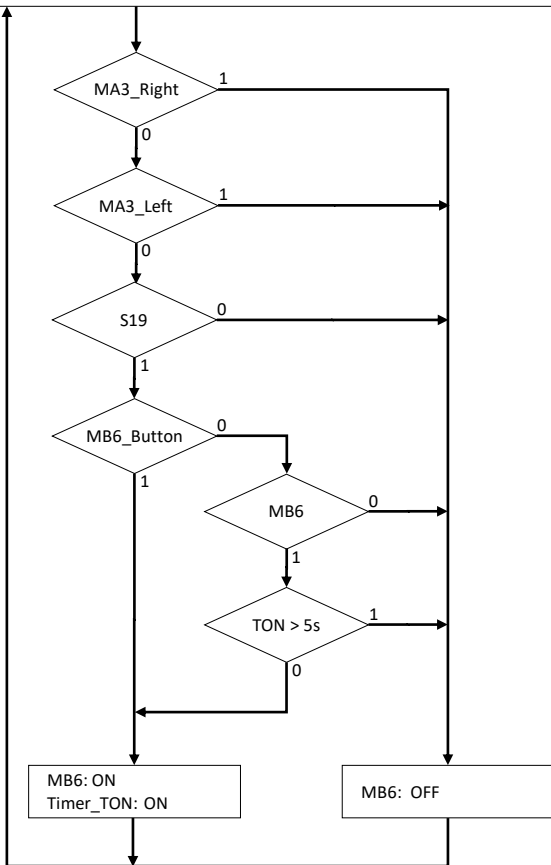


Mode\_Manual

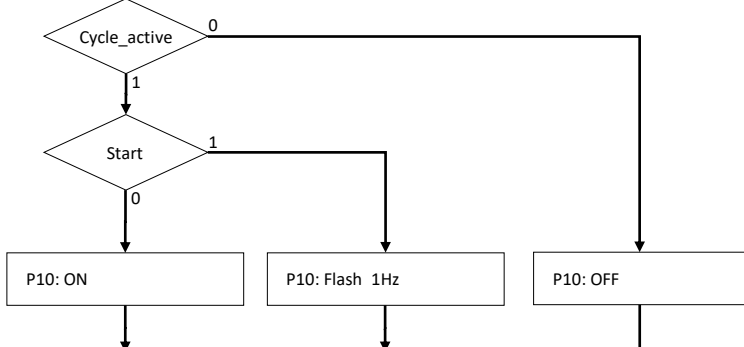
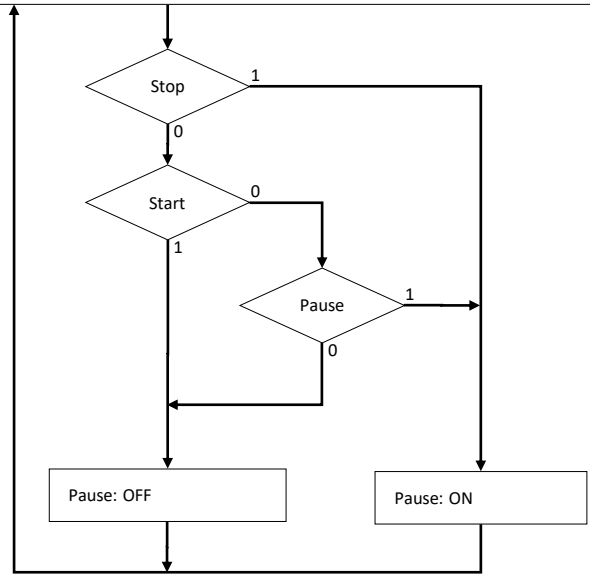
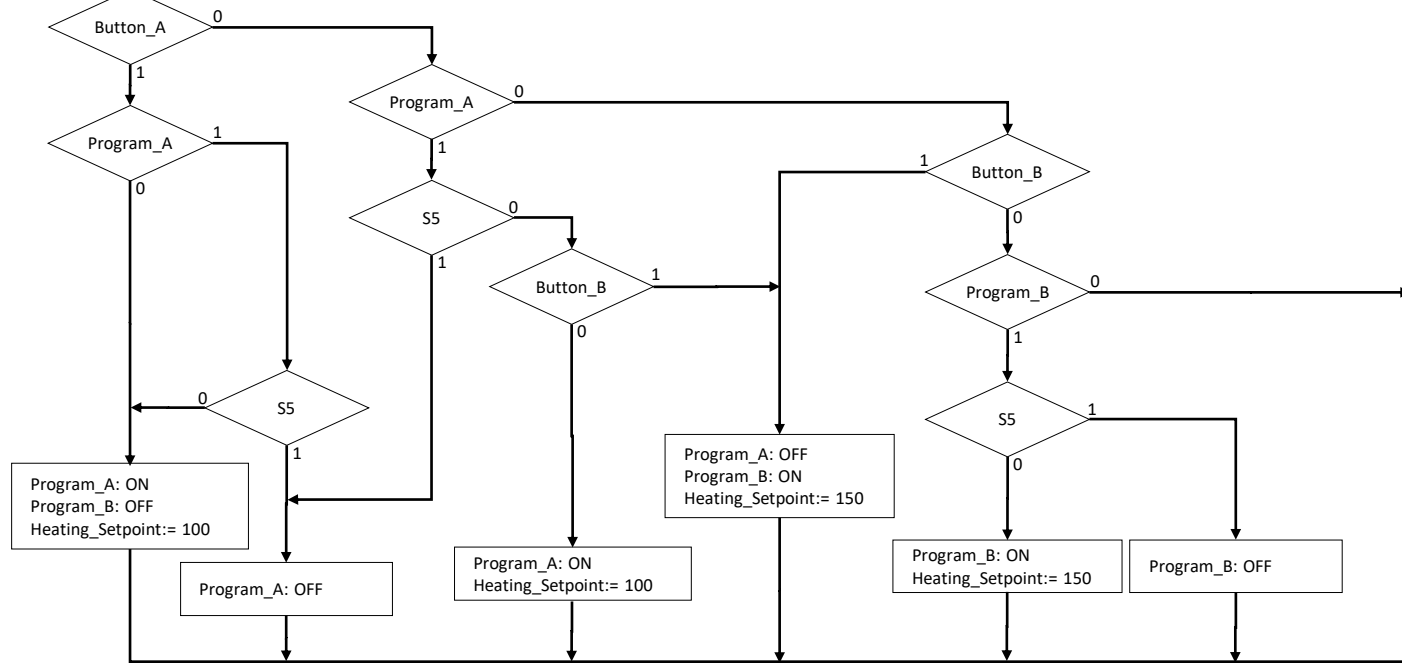
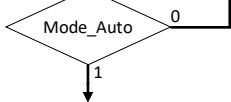
PAGE 5; Mode\_Manual





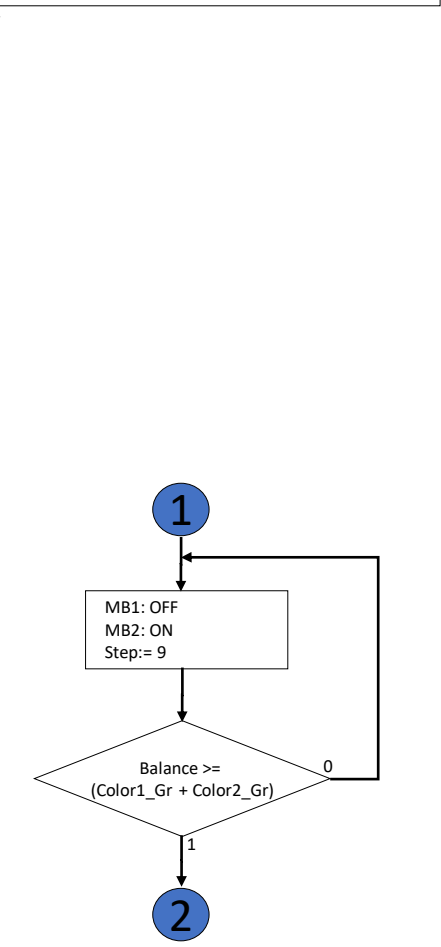
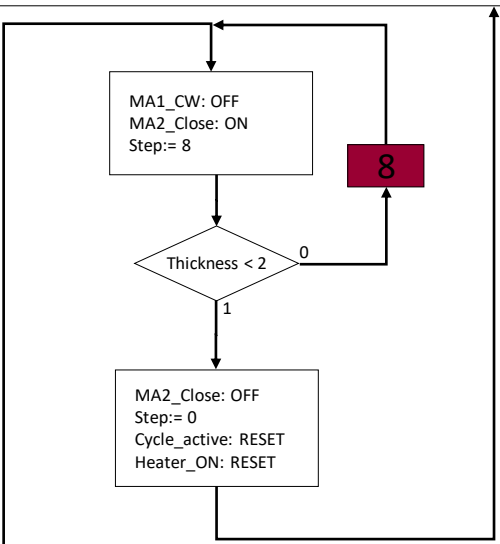
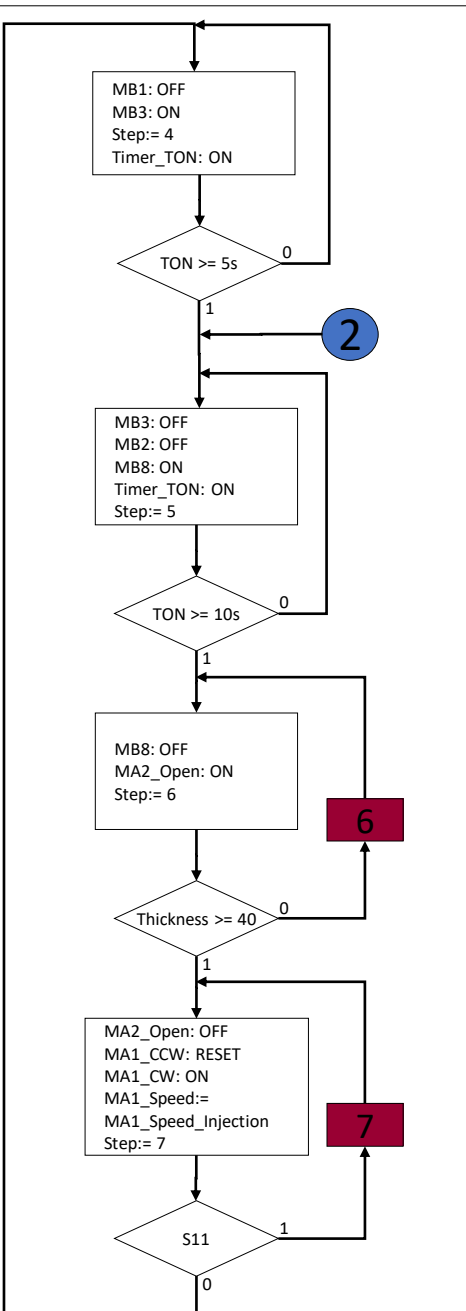
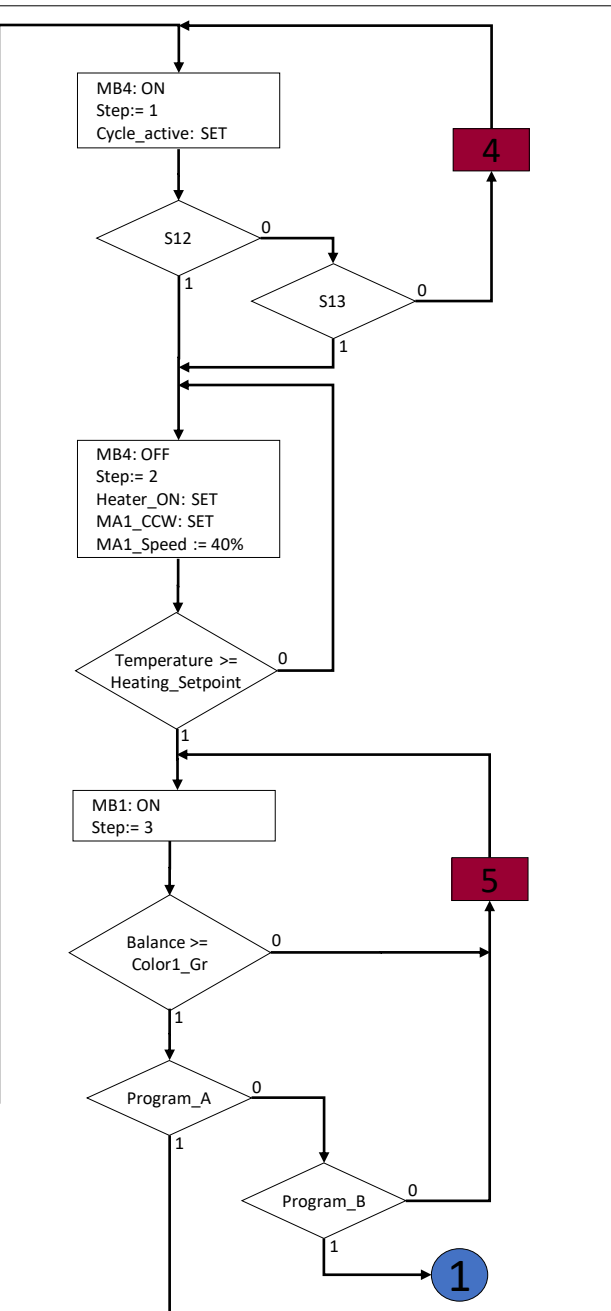
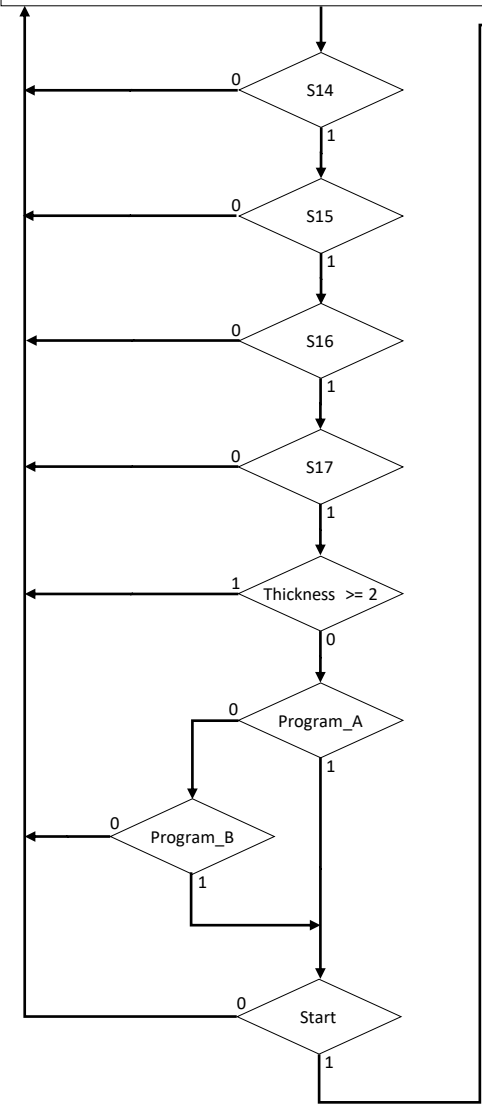


Mode\_Auto

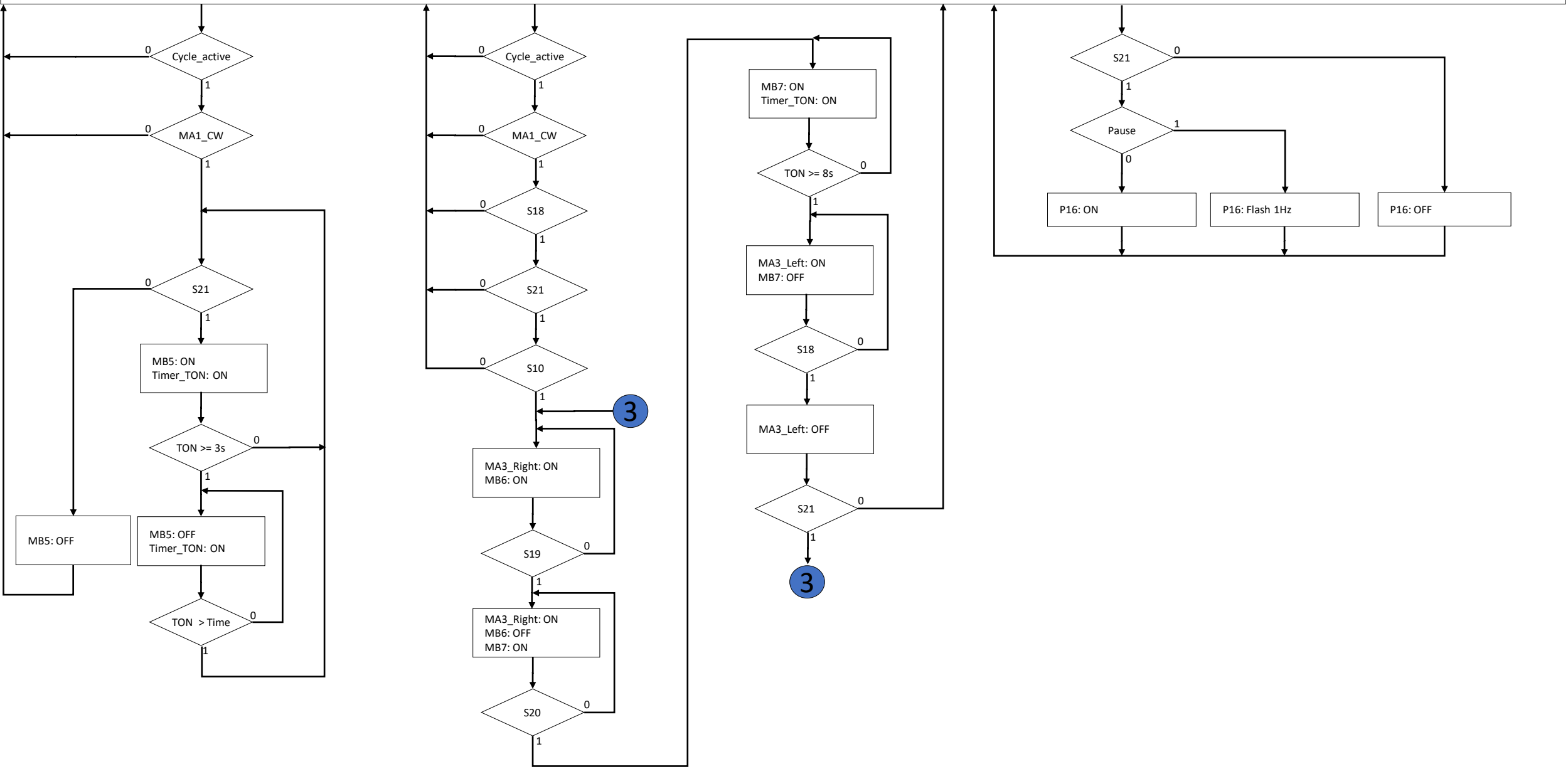


```

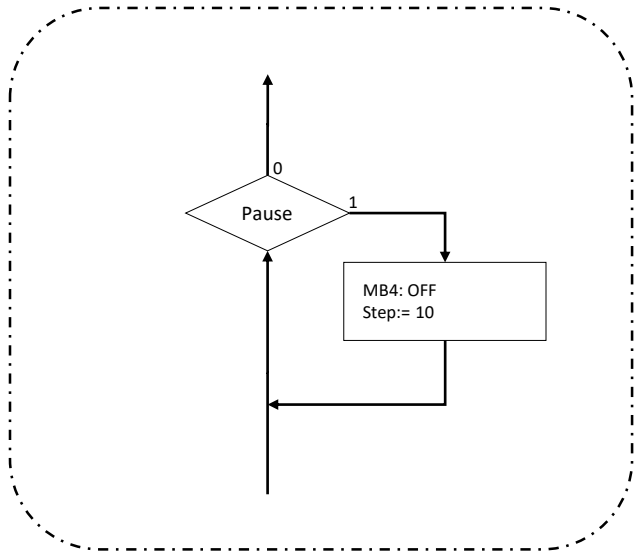
    MA1_Speed_Injection := 20 + [(Thickness * 80) / 100]
    Time := (Thickness * 2) / 10
  
```



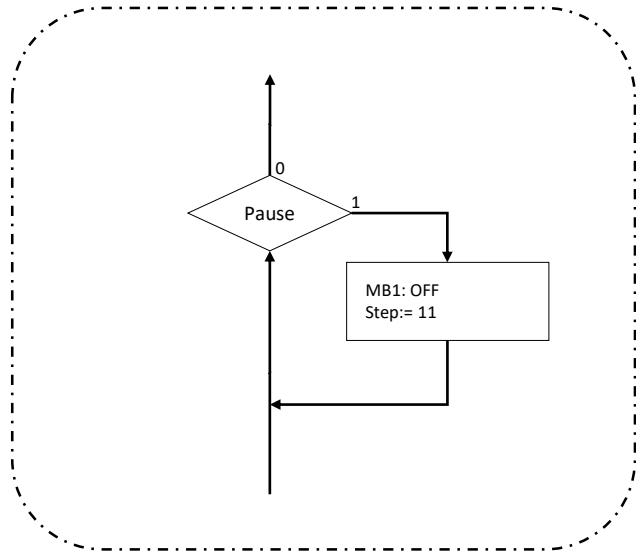




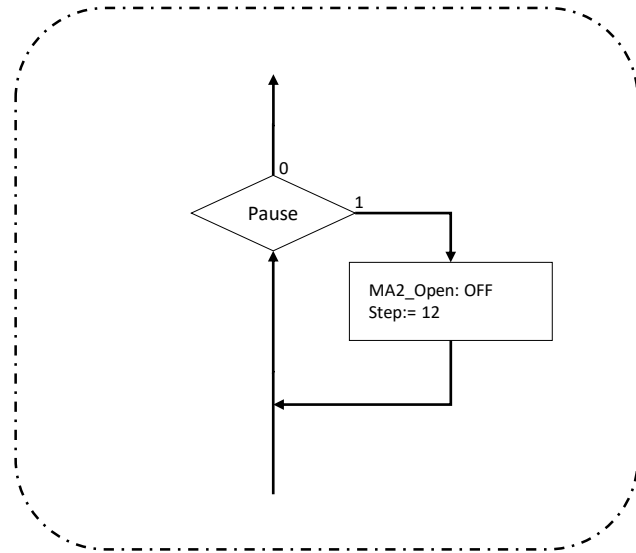
4



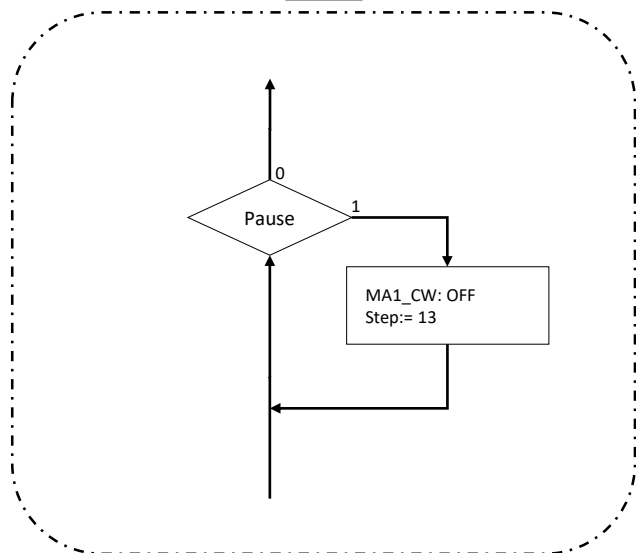
5



6



7



8

