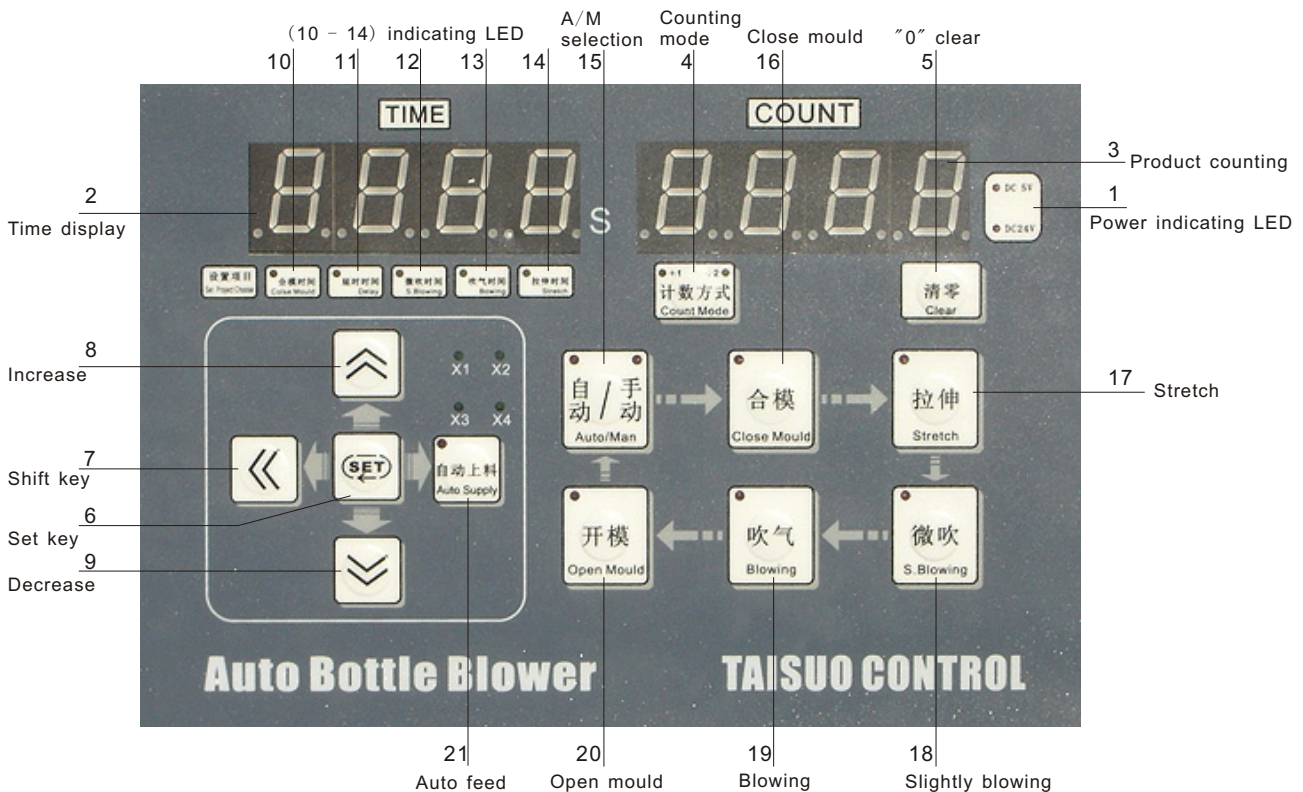


ABB-800 PLC instruction manual

Before operating this instrument, please read this manual carefully and fully understand its contents.

I. Description of front panel



1. Power supply: +5V and +24V power supply indicating lamp
 2. Running time displaying window. All kinds of time is displayed in this window. Range 00.00-99.99.
 3. Product counting displaying window. Counting the finished products numbers.
 4. Counting modes: pressing 3 seconds to select the different counting modes. There are two modes according to the mould, one product/time; two products/time.
 5. Counting number clear to "0". Pressing 3 seconds.
 6. Set key. Press this key to enter setting mode. After setting, press again to store the value.
 7. Shift key. Press this key to shift on the digits which you are going to change.
 8. Increasing key. To increase the setting values.
 9. Decreasing key. To decrease the setting values.
 10. Close mould time indicating LED: press "SET" key(6), when this LED is light, then you can set the time of closing mould.
 11. Delay time indicating LED: press "SET" key(6), when this LED is light, then you can set the delay time.
 12. Slightly blowing time indicating LED: press "SET" key(6), when this LED is light, then you can set time of slightly blowing.
 13. Blowing time indicating LED: press "SET" key(6), when this LED is light, then you can set the time of blowing.
 14. Stretching time indicating LED: press "SET" key(6), when this LED is light, then you can set the stretching time.
 15. A/M selection key. Select the Automatic or Manual mode.
 16. Close mould key. It's active only in Manual mode, open or close the closing mould valve.
 17. Stretching key. It's active only in Manual mode, start or stop the stretching valve.
 18. Slightly blowing key. It's active only in Manual mode, start the slightly blowing valve.
 19. Blowing key. It's active only in Manual mode, start the blowing valve.
 20. Open mould key. It's active only in Manual mode, open or close the open mould valve.
 21. Auto feeding key. Start or stop the function of auto feeding raw material to the machine.
- Indicating lamp: X1 start signal; X2 stop signal; X3 mould closing ok; X4 stretching ok

II. Setting function

A) How to set the time of each parameter:

press "SET" key to enter the setting mode, at then, the decimal point would be blinking in the time displaying window, then you can set the time value with the shift key; increasing key and the decreasing key. When you push "SET" again, then go to next parameter, and at the same time, store the previous value. The indicating LED is indicating which parameter you are standing on.

B) How to quit the setting mode:

After your setting of stretching time, the controller will quit the setting mode automatically.

Or, when there is no pushing keys with 20 seconds, then the controller will quit the setting mode automatically.

III. Auto feeding function

Press the "Auto supply" key (21) to start or stop the auto feeding fuction. When the function is active, the feeding would be stopped when the raw material is full.

IV. Auto/Manual selection function

The default mode is Auto mode at power on. Press the A/M key to switch the Auto/Manual mode.

V. Product counting

Under the normal running status, the product counting display window(3) shows the quantity of the processed products.

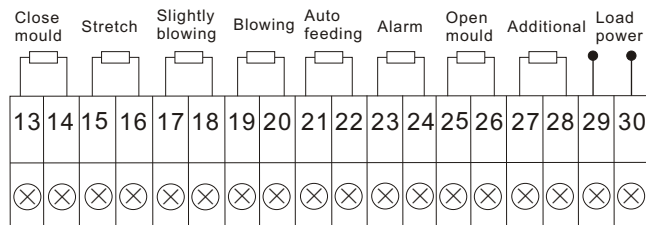
Counting methods can be divided into two different methods: one product/time; two products/time, you can choose the methods through pressing the "count mode" key(4) 3 seconds. To clear the displaying window, press the "clear" key(5) 3 seconds.

When the controller power off suddenly, we offer the memory function of the quantity which counted before. When you power on the controller next time, the quantity is still there.

VI. Wire connection

⊗ 1	External signal
⊗ 2	Feeding signal
⊗ 3	Stretching signal
⊗ 4	Close mould signal
⊗ 5	Stop signal
⊗ 6	Start signal
⊗ 7	+24V DC
⊗ 8	+24V DC
⊗ 9	GND/COM
⊗ 10	GND/COM
⊗ 11	L 110-240VAC
⊗ 12	N 110-240VAC

Model	ABB-800
Supply	110-240VAC 50/60HZ
Amb. temp.	50°C max.



VII. Description of the codes

Code	Description
STOP	Stop status
Err1	Close mould is not ok
Err2	Stretching is not ok

VIII. Attentions

- * If the indicating LED +5V or +24V is not light, please stop the controller to avoid mis-operating.
- * To avoid mis-operating, only the special worker can use it.
- * Do not touch any sensor signal when the controller is running under auto mode.
- * When the controller receives the external signal, it will be protection mode and stop the next working cycle until the external signal disappear.

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