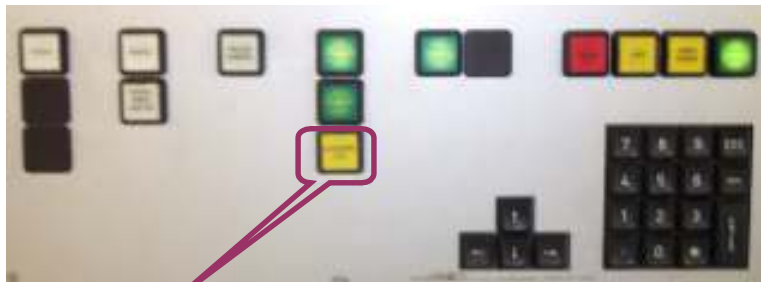


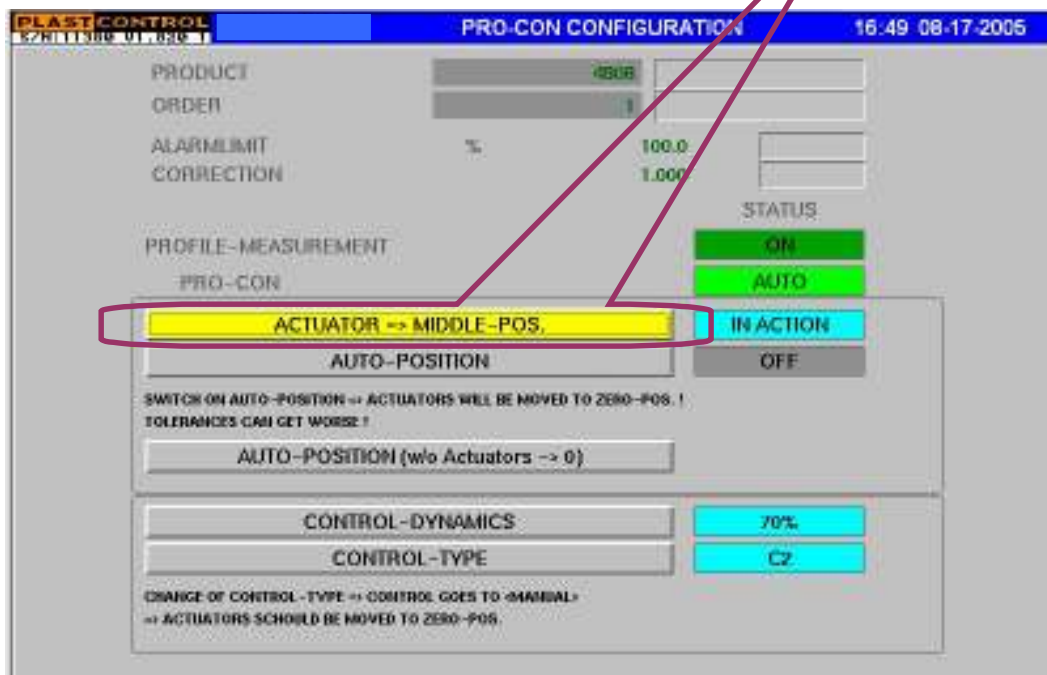
PLAST CONTROL PROCON START UP INSTRUCTIONS

The purpose of this document is to optimize the Plast Control gauge control system known as Procon to achieve the best possible results.

Start up of a new product



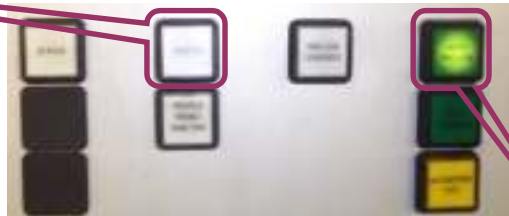
- 1.1) Select “Actuators to the 0 position” button which will bring you to the PRO-CON CONFIGURATION screen. Cursor up/down to highlight the ACTUATOR → MIDDLE POS. and press enter. This will move all the elements to the middle position. This could take one to two minutes.



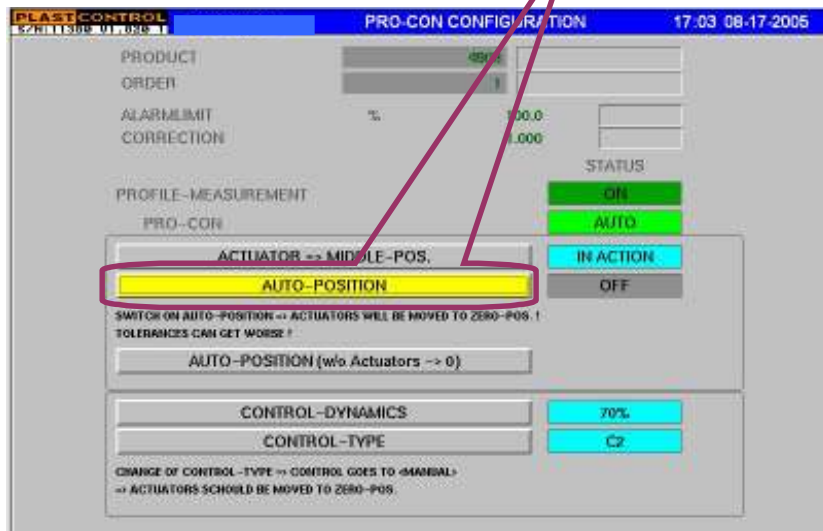
- 1.2) Ensure that the Control type on this page is set to C2 and the Control Dynamics are set to 70%. This will ensure quick reduction in tolerances in the first part of the program.



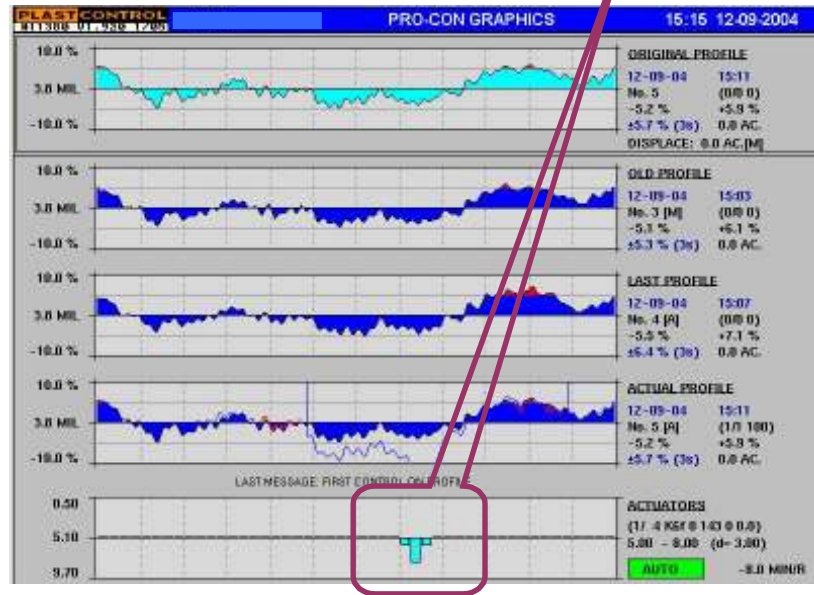
- 1.3) Pull the bubble and select "Profile Measurement" after the line is stable. Select the "Profile" button and adjust the die bolts to achieve the best results.



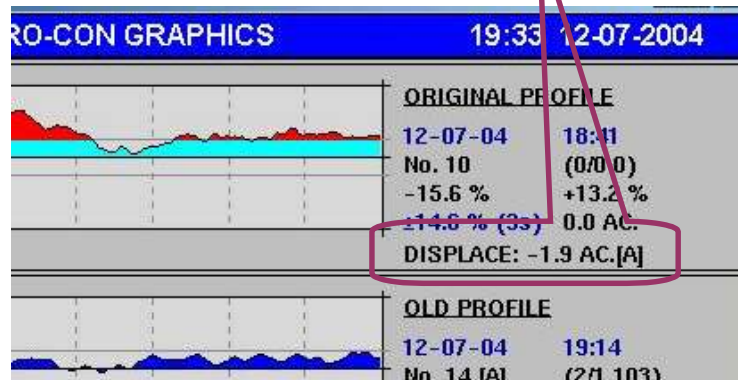
- 1.4) Wait for at least two consecutive profiles to be the similar and select the "Auto Position" button. This will bring you to the PRO-CON CONFIGURATION screen. Use the up/down buttons to scroll to the AUTO-POSITION and when highlighted in yellow press the enter key



- 1.5) This will eventually show a bump out of three elements in an inverted pyramid shape on the Procon Graphics page once enter is pressed.



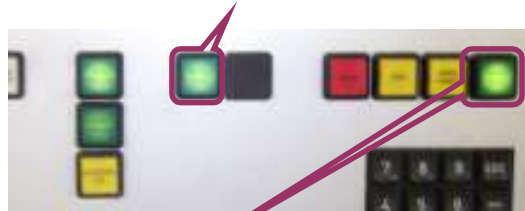
- 1.6) The system will calculate the twist in the line between the air ring and the measurement device displaying this calculation in the upper right hand corner with the letter(A) signifying a good calculation. The letter (E) means the calculation was faulty and should be tried again. The letter (M) means that the operator went right to gauge control without doing an Auto Position or the operator entered a displacement value.



- 1.7) The system will then automatically put itself in AUTO gauge control and work on the profile.

Start up after making product changes such as mil change, line speed, rotation speed and blend recipe

- 2.1) Turn the AUTO gauge control to MANUAL before making changes.



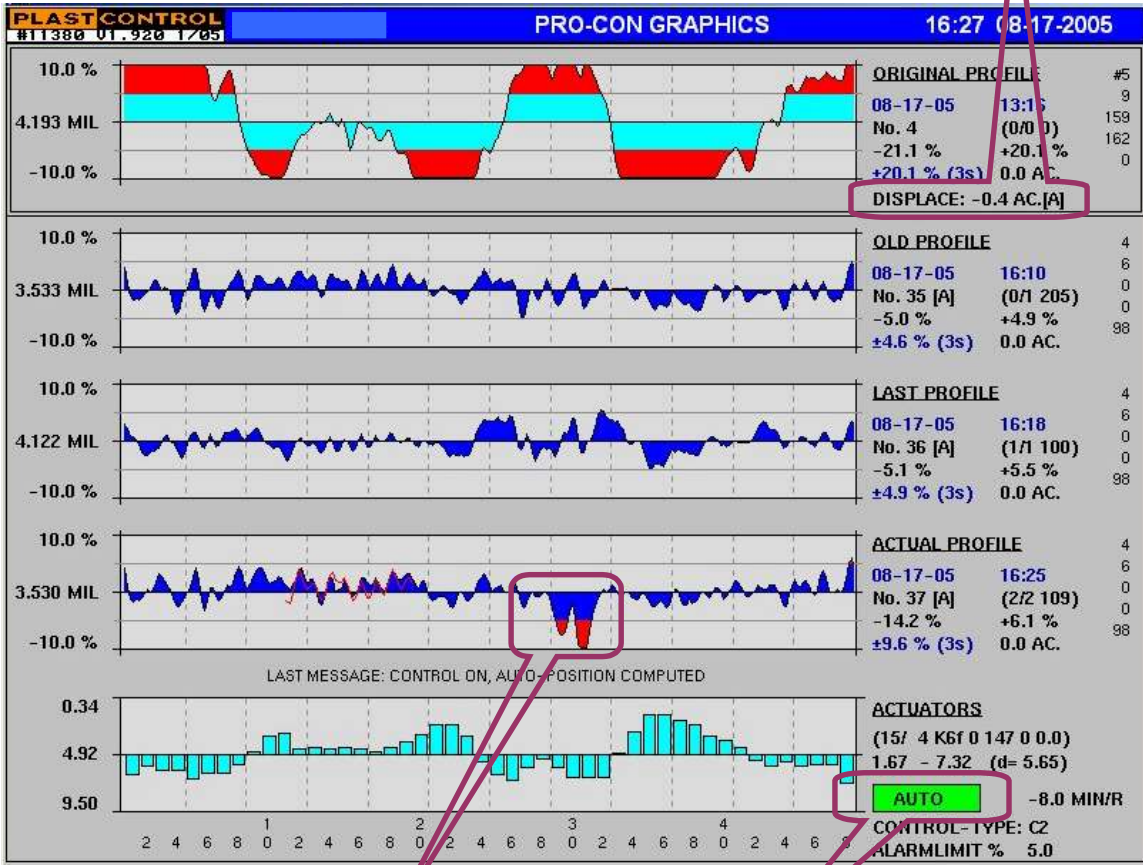
- 2.2) After the line is stable select the “Target Entry” button and ensure that Control type C2 is selected with the Control Dynamics set to 70%.



- 2.3) Using the up/down arrow keys select the “Auto Position Without Elements to Zero”. This feature is not in earlier PRO-CON systems but can be upgrade. Press enter and the system will keep the elements at their last position and perform a twist calculation. It is important to note that you will not see the bump out of the elements as it calculates this displacement but you will see in the profile display a large change in the area where the actuators where moved. During the AUTO POSITION test the DISPLACEMENT value on the PRO-CON display will show 0.0 and below the actuator location the message **AUTO-POSITION** will be displayed.



2.4) You can tell if a successful Auto Position has been calculated by looking at the upper right hand corner of the Profile Graphics page. Refer to section 1.6 for details.



Results of the auto position bump test. At the end of the auto position test the system automatically returns to the auto gauge control mode.