PRODUCT MANUAL

Lynx™ Surface- Analog Input Module with 24 V Power Supply

IA1-S-VI-24

Training and Technology for Injection Molding

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MAINTENANCE

TROUBLESHOOTING

RELATED PRODUCTS

INTRODUCTION

Read, understand, and comply with all following instructions. This guide must be kept available for reference at all times.

DISCLAIMER

Inasmuch as RJG, Inc. has no control over the use to which others may put this material, it does not guarantee that the same results as those described herein will be obtained. Nor does RJG, Inc. guarantee the effectiveness or safety of any possible or suggested design for articles of manufacture as illustrated herein by any photographs, technical drawings, and the like. Each user of the material or design or both should make his own tests to determine the suitability of the material or any material for the design as well as the suitability of the material, process, and/or design for his own particular use. Statements concerning possible or suggested uses of the material or designs described herein are not to be construed as constituting a license under any RJG, Inc. patent covering such use or as recommendations for use of such material or designs in the infringement of any patent.

PRIVACY

ALERTS

The following three alert types are used as needed to further clarify or highlight information presented in the manual:

DEFINITION *A definition or clarification of a term or terms used in the text.*

NOTES *A note provides additional information about a discussion topic.*

CAUTION *A caution is used to make the operator aware of conditions that can cause damage to equipment and/or injury to personnel.*

NOTES

PRODUCT DESCRIPTION

The Lynx™ surface-mount analog input module IA1-S-VI-24 is a surface-mounted module that is wired to the molding machine in order to collect 0–10 V DC or 4–20 mA signals from analog measurement devices, providing information such as injection pressure, plastic pressure, screw position, and temperature. In addition the module can supply a 24 V power source to some sensors.

APPLICATIONS

PROCESS MONITORING AND CONTROL

The IA1-S-VI-24 gathers 0–10 V/4–20 mA signals from molding machine analog inputs for the eDART. The eDART performs computations using the signals from the injection molding machine or other measurement devices for various process parameters during a typical cycle.

OPERATION

The IA1-S-VI-24 supplies the eDART or CoPilot system with injection pressure, stroke position/velocity, or dew point signals from the machine's output card.

In addition, the IA1-S-VI-24 is compatible with other measurement devices that supply a 0–10 V/4–20 mA signal for process monitoring, including: air flow, barrel temperature, coolant flow rate, coolant pressure, coolant temperature, delta pressure, dryer temperature, ejector pin (indirect) pressure, hydraulic pressure, line temperature, melt pressure, mold deflection, mold temperature, power consumption, revolution rate, and vacuum.

INJECTION PRESSURE

The IA1-S-VI-24 is often used to acquire an injection pressure signal from electric injection molding machines. The surface-mount analog input module cable C-IA1/LX-4M is wired to the machine output card which provides the signal; the C-IA1/LX-4M is connected to the IA1-S-VI-24, which collects the signal for use with the eDART or CoPilot system. In the software, the module is configured to read the voltages as pressures.

SCREW POSITION/VELOCITY

The IA1-S-VI-24 is often used to acquire an screw position/velocity signal from electric injection molding machines. The surface-mount analog input module cable C-IA1/LX-4M is wired to the machine output card which provides the signal; the C-IA1/LX-4M is connected to the IA1-S-VI-24, which collects the signal for use with the eDART. In the eDART or CoPilot system software, the module is configured to read the voltages as position/velocity.

DEW POINT

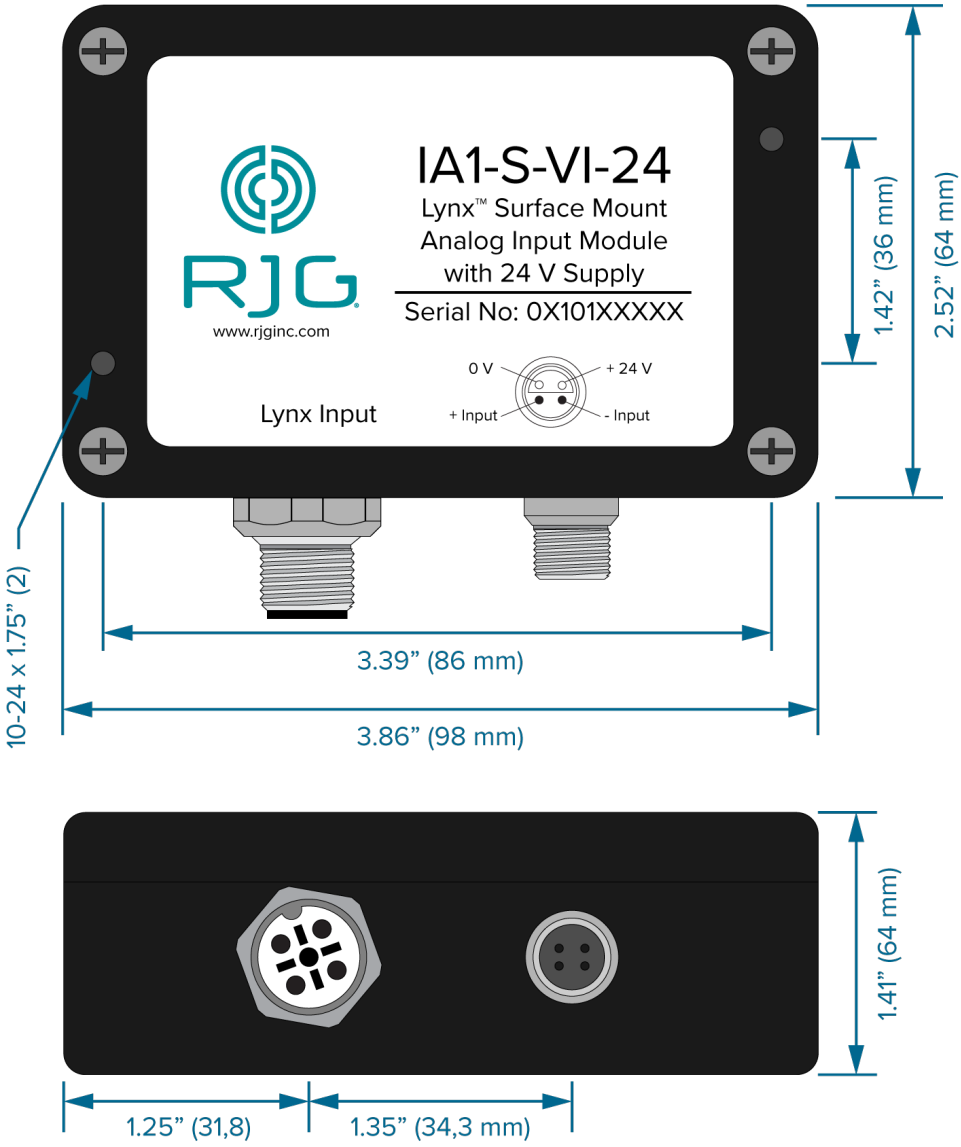
The IA1-S-VI-24 can be used to acquire a dew point measurement from the Vaisala DRYCAP® Transmitters DMT142 or DMT143. The DMT142 or DMT143 is connected to the IA1-M-V using a cable (included with DMT142 or DMT143 purchase from RJG), which collects the signal for use with the eDART or CoPilot system. In the software, the module is configured to read the voltages as dew point.

OTHER SUPPORTED SENSOR TYPES

The IA1-S-VI-24 also supports the additional following sensor types:

- Ejector Pin (indirect)
- Hydraulic Pressure
- Mold Temperature
- Barrel Temperature
- Coolant Temperature
- Coolant Flow Rate
- Delta Pressure
- Revolution Rate
- Mold Deflection
- Power Used
- Dryer Temperature
- Air Flow
- Melt Pressure
- Line Temperature
- Vacuum

DIMENSIONS



CABLE LENGTH

The C-IA1/LX-4M is 13 ft. (4 m) long.

CABLE LENGTH

NOTES

INSTALLATION

INSTALLATION OVERVIEW

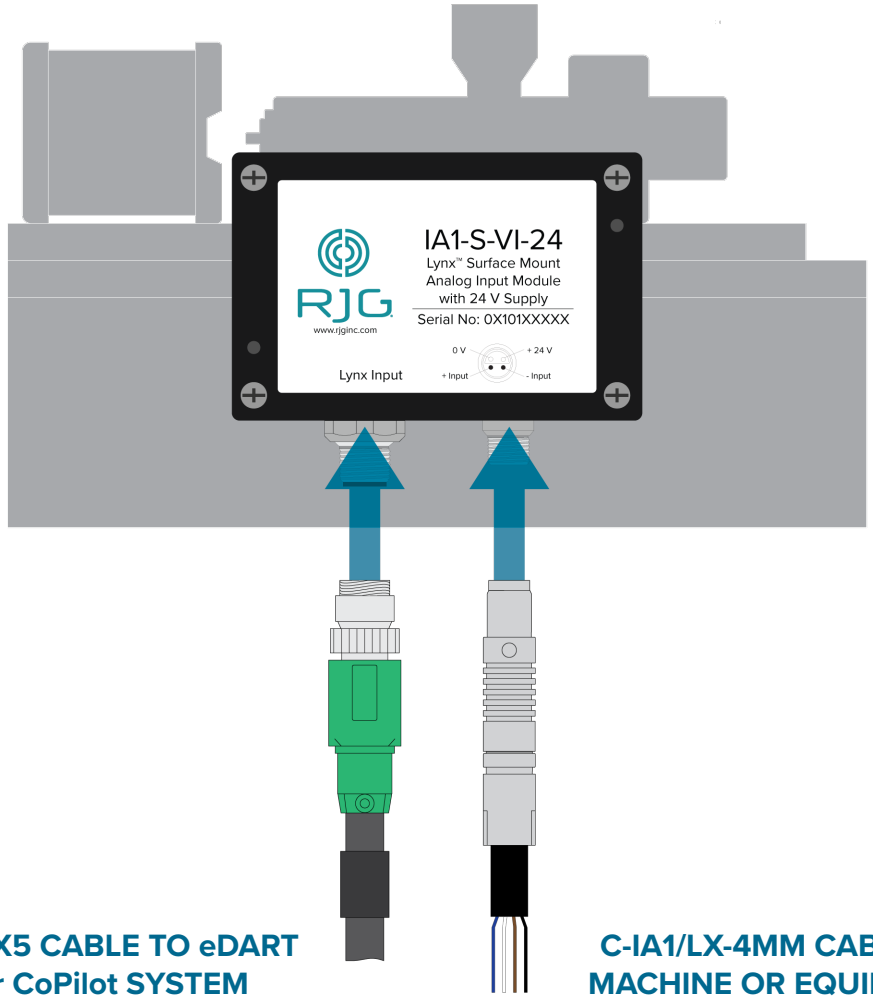
The surface-mount analog input module is mounted to a solid surface, such as the machine or mold.

IA1-S-VI-24

The surface-mount analog input module cable C-IA1/LX-4M is wired directly to the machine (to an output card) on one end—or to some other 0–10 V/4–20 mA measurement device—and connected to the IA1-S-VI-24 on the other using the four-pin connector.

eDART OR COPILOT SYSTEM CONNECTION

The surface-mount analog input module is connected to the eDART or CoPilot system using a CE-LX5 Lynx cable.



CE-LX5 CABLE TO eDART or CoPilot SYSTEM

C-IA1/LX-4MM CABLE TO MACHINE OR EQUIPMENT

INSTALLATION SPECIFICATIONS

The instructions that follow are a general guide; actual steps necessary to install this product will vary based on injection molding machine manufacturer, model, and options.

The required machine signals can often be obtained from the machine's output card.

REQUIREMENTS

CAUTION *Before beginning IA1-S-VI-24 installation, disconnect and lockout/tag-out any and all power to the molding machine. Failure to comply will result in personal injury or death, and damage or destruction of equipment.*

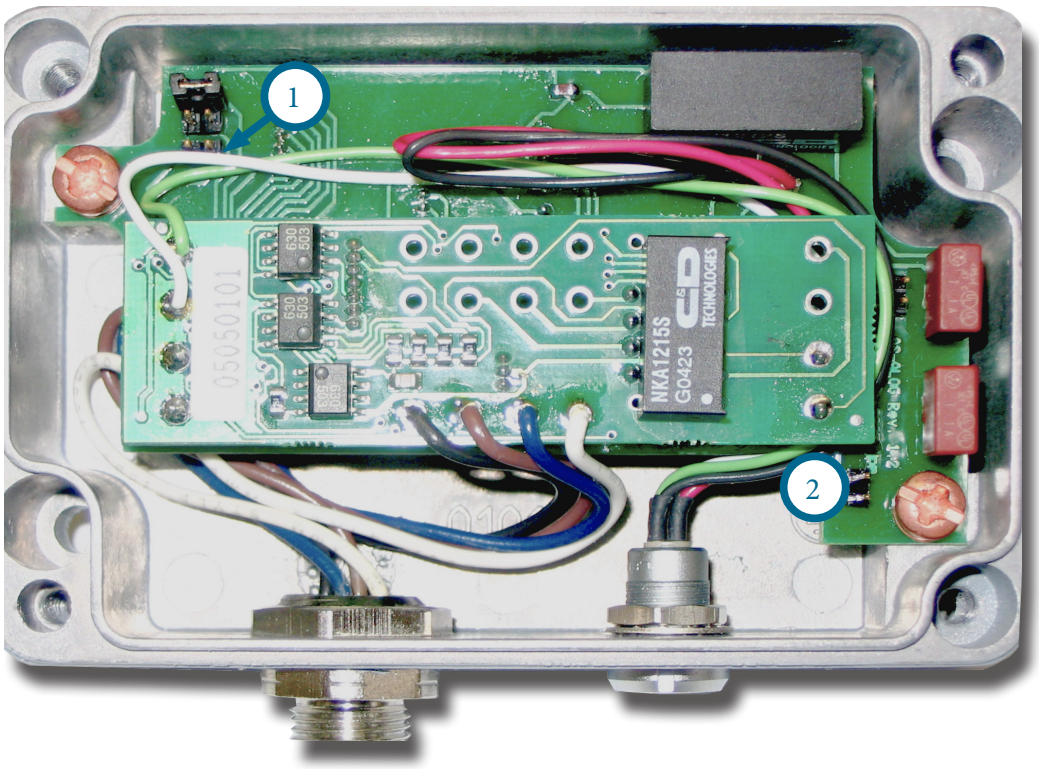
SWITCHING 0–10 V INPUT TO 4–20 MA INPUT

The Lynx surface-mount analog input module is shipped configured for 0–10 V operation. To configure the module for 4–20 mA operation, perform the following steps:

NOTES *Remove all cables from the module, and remove module from mounting location if already mounted.*

1. Remove Lid.
   - Remove four (4) M4 x 20 screws from module; remove lid from module.
2. Locate the jumper locations JP1(1 below) and JP2 (2 below).
3. Install 4–20mA Jumpers.
   - Install jumpers into jumper locations JP1 and JP2. The jumpers required are taped to the lid.

CAUTION *Do not remove or install any other jumpers. Failure to comply will result in personal injury or death, and damage or destruction of equipment.*



MOUNTING

Mount the IA1-S-VI-24 module to a solid surface—such as the molding machine or mold—using the supplied 10-24 x 1.75" socket head cap screws (2).

ⓘ NOTES *Modules and connecting cables must be located away from any static sources, such as feeder tubes and material hoppers.*

WIRING

The C-IA1/LX-4M cable has colored-coded wires to simplify installation. Refer to the table below for the correct wire/signal combinations for installation.

INPUT	FUNCTION	COLOR
0–10 V	+ Signal	Blue
0 V DC Common	– Signal	White
+ 24 V	24 V Power	Black
+ 0 V	Sensor Power Common	Brown

Attach the 0 V DC (white) wire to the common terminal of the injection molding machine 0–10 V I/O card. Attach the 0–10 V (blue) wire to the signal of the machine.

If the associated sensor requires power from the IA1-S-VI-24, attach the 0 V DC (brown) wire to the common terminal of the sensor; attach the 24 V DC (black) wire to the sensor to supply it with power.

If a 4–20 mA sensor is used, refer to "Switching 0–10 V Input to 4–20 mA Input" on page 6 to appropriately alter the signal to work with the IA1-S-VI-24.

ⓘ NOTES *Note the signals which are wired to the machine for future software setup and use.*

CONNECTIONS

Connect the C-IA1/LX-4M cable to the IA1-S-V-24 module. Connect a CE-LX5 Lynx cable to the IA1-S-V-24 module and eDART or CoPilot system.

eDART SYSTEM SOFTWARE SETUP

Each sensor type must be fully-defined in the software for the IA1-S-VI-24 and eDART system to provide accurate data. Always read and perform the following instructions to set up the IA1-S-VI-24 module in the eDART system software.

eDART SYSTEM VERSION 9.XX

1. Select the Sensor Type “0 - 10V Input” in Sensor Locations and Scaling.
2. With the motor or machine (depending on the sensor type) off/in standby, measure and record the voltage—the voltage should be displayed in the “Value” column.
3. Measure and record the actual voltage at maximum—the voltage should be displayed in the “Value” column. Record the machine value for the measurement at this time, as well.

   For example, if using the IA1-S-VI-24 to acquire injection pressure from the machine, record the machine’s injection pressure displayed on the controller.
4. Subtract the low voltage value recorded in step 2 from the high voltage value recorded in step 3.
5. Select the Setup button in Sensor Locations and Scaling.
6. Select the sensor model number from the drop-down menu; if not listed choose “Other”.
7. Select the sensor type from the drop-down menu.
8. Enter the machine value recorded in step 3 into the Sensor Full Scale field, and select the appropriate units of measurement.
9. Enter the change in voltage found in step 4 in the “when signal shifts by” field.
10. Select Accept to save the entered information.

eDART SYSTEM VERSION 10.XX

1. Drag and drop the input from the Available Sensor list in Machine Setup/ INPUTs to the desired position.
2. Click the “i” on the analog input to open the Analog Input Scaling window.
3. With the motor or machine (depending on the sensor type) off/in standby, measure and record the voltage.
4. Measure and record the actual voltage at maximum; record the machine value for the measurement at this time, as well.

For example, if using the IA1-S-VI-24 to acquire injection pressure from the machine, record the machine’s injection pressure displayed on the controller.

5. Enter the machine value recorded in step 4 into the Maximum field, and select the appropriate units of measurement.
6. Enter the maximum voltage recorded in step 4 into the Voltage at Maximum Pressure field.
7. Enter the voltage recorded in step 3 into the Voltage at 0 field.
8. Select Save to save the entered information.

COPILOT SYSTEM SOFTWARE SETUP

Each sensor type must be fully-defined in the software for the IA1-S-VI-24 and CoPilot system to provide accurate data. Refer to the **CoPilot™ System Software User Guide** to set up the IA1-S-VI-24 module in the CoPilot system software, available online for download at www.rjginc.com.

MATH EQUATIONS FOR ANALOG INPUTS

Alternately, the following math equations may be used to determine injection pressure, screw position, and velocity maximum voltages if voltages for hold pressure, position shot size, or velocity setting are known:

1. Injection Pressure

$$\frac{\text{Volts}}{\text{Hold Pressure Setting}} \times \text{MAX Pressure} = \text{Volts at MAX Pressure}$$

2. Screw Position

$$\frac{\text{Volts}}{\text{Position Shot Size}} + \left(\text{De-comp} \times \text{MAX Pressure}\right) = \text{Volts at MAX Position}$$

3. Velocity

$$\frac{\text{Volts}}{\text{Velocity Setting}} \times \text{MAX Velocity} = \text{Volts at MAX Velocity}$$

NOTES

MAINTENANCE

The surface-mount analog input module requires little to no maintenance provided that all installation instructions are followed.

CLEANING

REGULAR CLEANING

Cables must be installed in areas free from oil, dirt, grime, and grease.

RJG, Inc. recommends the following cleaners:

- Microcare MCC-CCC Contact Cleaner C
- Microcare MCC-SPR SuprClean™
- Miller-Stephenson MS-730L Contact Re-Nu®

FUSE REPLACEMENT

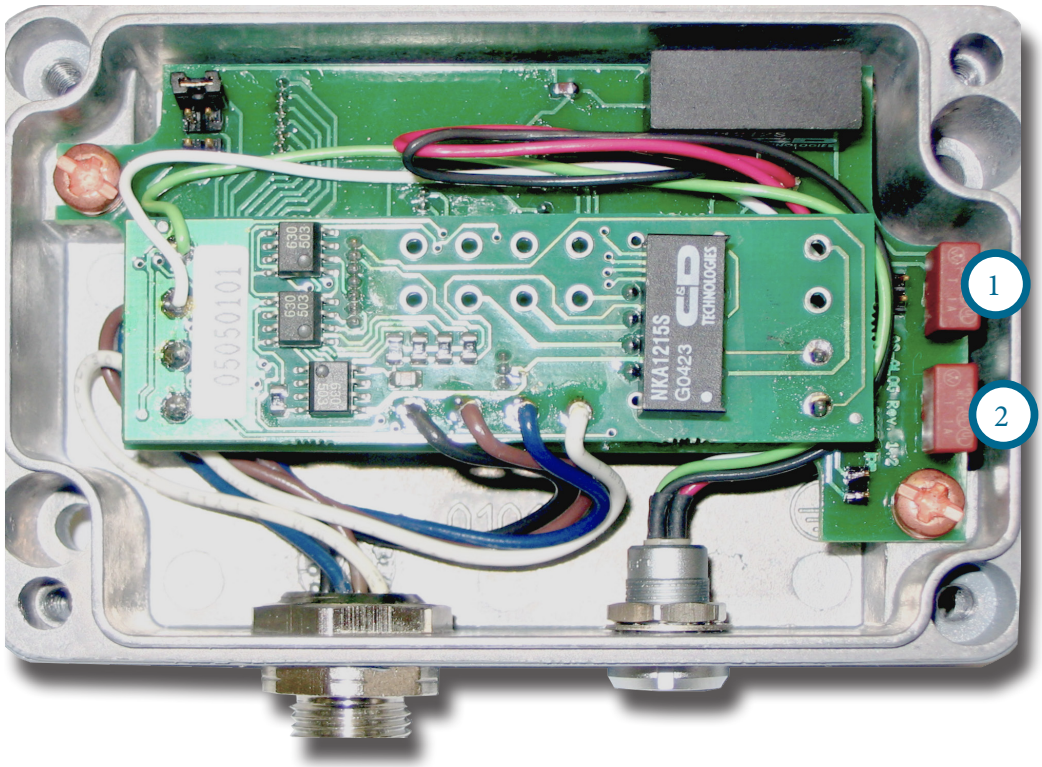
The 24 V output supply is fused—a spare fuse is provided on the board inside the IA1-S-VI-24 module enclosure.

Fuse part number: Wickman 3950160044

ⓘ NOTES *Remove all cables from the module, and remove module from mounting location if already mounted.*

1. **Remove Lid.**
   - Remove four (4) M4 x 20 screws from module; remove lid from module.
2. **Remove the used 24 V fuse (1 below) and discard.**
3. **Insert new 24 V fuse.**

   A spare 24 V fuse (2 below) is included inside the module.
4. **Reinstall Lid.**
   - Install lid using four (4) M4 x 20 screws.



WARRANTY

RJG, INC. STANDARD WARRANTY

RJG, Inc. is confident in the quality and robustness of the surface-mount analog input module, and so are offering a one-year warranty. RJG's products are guaranteed against defects in material and workmanship for one year from the original date of purchase. The warranty is void if it is determined that the adapter was subjected to abuse or neglect beyond the normal wear and tear of field use, or in the event the adapter box has been opened by the customer.

PRODUCT DISCLAIMER

RJG, Inc. is not responsible for the improper installation of this equipment, or any other equipment RJG manufactures.

Proper RJG equipment installation does not interfere with original equipment safety features of the machine. Safety mechanisms on all machines should never be removed.

TROUBLESHOOTING

COMMON INSTALLATION ERRORS

NEGATIVE SCALING FOR STROKE

Problem: Negative value was entered in stroke scaling.

Solution: The analog input module cannot see negative voltages. The wiring must have the positive (+) terminal on the analog input above the negative (-) terminal.

The eDART determines the stroke direction using the Screw Run signal. It will invert the signal automatically if necessary to get a positive volume and stroke curves, and to analyze flow of material.

If there is no machine sequence module input for Screw Run positive numbers for full scale must still be used; set the screw direction correctly in “Sequence Settings”. The stroke signal should ascend positively while the material is being injected into the mold; the zero of the screw (screw bottom) must also be set.

FALSE CYCLE START ON PRESS POWER-UP

Problem: Job on eDART is started before machine is powered on.

Solution: Always power the eDART on after the machine is powered on.

Analog signals tend have a spike or a sudden “lurch” from zero to a specific position voltage. Often the eDART will interpret the forward jump of the stroke signal as the cycle start. Sumitomo machines are particularly prone to this false trigger problem because a calibration cycle is performed at each power-up.

INCORRECT INJECTION PRESSURE SCALING

Problem: Injection pressure scaling is incorrect.

Solution: The eDART system and Lynx sensors eliminate the need for the manual scaling steps if injection pressure (for electric machines) comes from either a nozzle pressure sensor or an electrical signal from the machine. However, if signals from another source are used, then scaling must be manual input in the eDART.

The electrical signal for pressure is usually 0–10 V ,with a “low” voltage (not always zero) being no pressure and a “high” voltage (not always 10 V) being the highest pressure. Compare the machines reported hold pressure to the eDART-reported pressure to determine whether a scaling adjustment is necessary.

CUSTOMER SUPPORT

Contact RJG's Customer Support team by phone or email.

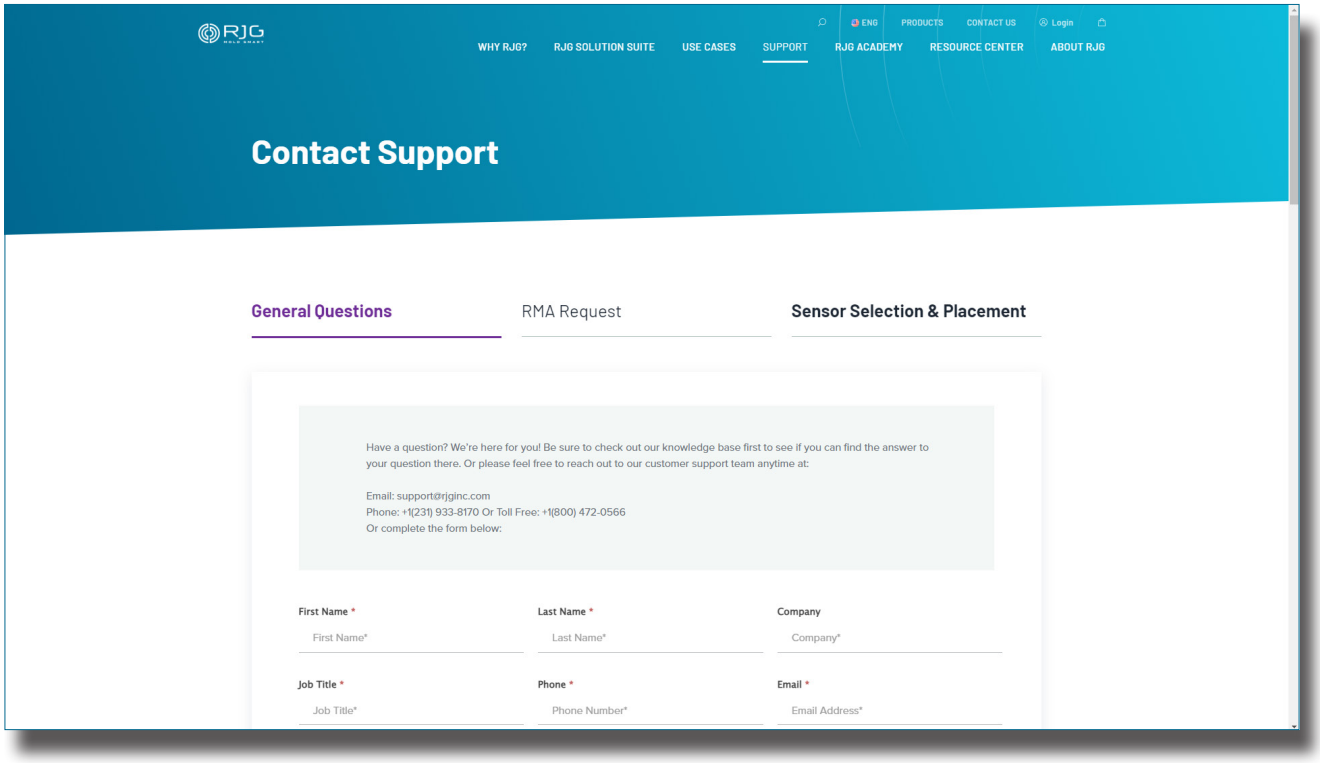
RJG, Inc. Customer Support

P: 800.472.0566 (Toll Free)

P: +1.231.933.8170

email: support@rjginc.com

www.rjginc.com/support



RELATED PRODUCTS

The surface-mount analog input module is compatible with other RJG, Inc. products for use with the eDART or CoPilot process control and monitoring systems.

COMPATIBLE PRODUCTS

SURFACE-MOUNT ANALOG INPUT MODULE CABLE C-IA1/LX-4M

The shielded analog input module cable C-IA1-M-3M (1 at right) cable is suited for the heat and stress found in injection molding environments. Designed specifically for use with RJG, Inc.'s analog input module IA1-M-V and the eDART or CoPilot System, the C-IA1-M-3M provides a connection from molding machines' output card and the RJG, Inc. C-IA1-M-3M.

LYNX CABLES CE-LX5

The Lynx sensor cable (2 at right) is a polypropylene-coated cable suited for the heat and stress found in injection molding environments. The cable is available in lengths 12–472" (0,3–12 m), and can be ordered with straight or 90° fittings. One CE-LX5 is required to interface the IA1-S-VI-24 with the eDART or CoPilot system.

SIMILAR PRODUCTS

The following products, similar to the IA1-S-VI-24, are compatible for use with the eDART or CoPilot process control and monitoring systems.

LYNX COMMUNICATIONS ADAPTER DIN/LX-D

The Lynx communications adapter DIN/LX-D (1 at right) is a shielded, DIN-rail-mounted module that interfaces other RJG, Inc. shielded machine interface modules with the eDART or CoPilot system when the ID7-M-SEQ is not used. This module is shielded to ensure high quality data even in rugged molding environments, and designed to be mounted on standard 35 mm DIN rails often found in machine panels.

1

LYNX SHIELDED ANALOG INPUT MODULE IA1-M-V

The Lynx shielded analog input module IA1-M-V (2 at right) is a shielded, DIN-rail-mounted module that interfaces the eDART or CoPilot system and injection molding machines in order to collect 0–10 V DC signals from analog measurement devices, providing information such as: injection pressure, plastic pressure, screw position, and temperature.

2

LOCATIONS / OFFICES

USA

RJG USA (HEADQUARTERS)
3111 Park Drive
Traverse City, MI 49686
P +01 231 947-3111
F +01 231 947-6403
sales@rjginc.com
www.rjginc.com

MEXICO

RJG MEXICO
Chihuahua, Mexico
P +52 614 4242281
sales@es.rjginc.com
es.rjginc.com

FRANCE

RJG FRANCE
Arnithod, France
P +33 384 442 992
sales@fr.rjginc.com
fr.rjginc.com

GERMANY

RJG GERMANY
Karlstein, Germany
P +49 (0) 6188 44696 11
sales@de.rjginc.com
de.rjginc.com

IRELAND/UK

RJG TECHNOLOGIES, LTD.
Peterborough, England
P +44(0)1733-232211
info@rjginc.co.uk
www.rjginc.co.uk

ITALY

NEXT INNOVATION SRL
Milano, Italy
P +39 335 178 4035
sales@it.rjginc.com
it.rjginc.com

SINGAPORE

RJG (S.E.A.) PTE LTD
Singapore, Republic of Singapore
P +65 6846 1518
sales@swg.rjginc.com
en.rjginc.com

CHINA

RJG CHINA
Chengdu, China
P +86 28 6201 6816
sales@cn.rjginc.com
zh.rjginc.com

KOREA

CAEPRO
Seoul, Korea
P +82 02-2113-1870
sales@ko.rjginc.com
www.caepro.co.kr