

COPILOT® SYSTEM RELEASE NOTES

Build No. v9.4.0



Overview

The CoPilot® system now features Optional Inputs, enabling the use of only mold closed or mold clamped in lieu of machine sequence signals, and a bug fix for summary graph values.

New Features

Optional Inputs

Optional Inputs enable the configuration of a machine without injection forward (IF), first stage (FS/1st), second stage (SS/2nd), or screw run (SR) sequence signals as long as a mold closed or mold clamped (MC) signal is assigned. Injection pressure (INJ) can also be configured when only using MC, but also does not have to be assigned.

When using optional inputs, the following summary variables to used to detect and sort short shots and flash are available:

- Peak Cavity Pressure (including Average Range and Balance peak)
- Cavity Pressure Cycle Integral
- Cycle Time
- Part Out Time
- Cushion
- Fill Pressure (only when INJ is configured)
- Peak Integral (Fill and Pack Integral)
- Pack Rate and Cooling Rate
- Peak, Minimum, and Average Temperatures
- Temperature Rise
- Peak Mold Deflection
- Average Flow Rate

Template Match will operate without machine sequence signals, even with missing summary variables.

If no sequence signals or INJ are assigned, some functionality and data will not be available:

- Sorting will work *only on the end of mold clamped* timing
- Valve gate control will not operate.
- V→P outputs cannot be configured and will not operate.
- Processes with alarms set on unavailable variables will not operate; a new process must be created.
- MAX (process assistance) will not operate.

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Bug Fixes

Summary Variables Automatically Added to Summary Graph

When a user added a stroke variable for volume or length, or injection pressure or transfer length, the corresponding variable was automatically added to the Summary Graph without user input, and when it was removed, it would reappear after the user navigated away from and back to the Summary Graph.