

VISIONS 3000

STARTUP GROUPS

LINUX 2.52



Start-up Groups



You can configure Manifold Startup Groups from the **setup dialog**.

To edit Manifold Startup Groups, you must first be logged in as the supervisor

Supervisor

test.efi



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Accessing Startup Groups

From the home screen or the main run-screen, in monitor-mode or run-mode, press the setup button, then the "General Settings" icon, then "More", then select the "Startup Groups" icon.



This takes you to the Startup Groups Page.

This is an important setting which affects how the controller starts heating up the tool.

This setting only affects manifolds.

When Startup Groups are active, the manifolds are heated first, in groups. This is called the **startup sequencer**.

The Startup Group Page allows you to define how many groups are in the sequence and which zones belong to which group. You enable the startup sequencer in the General Setup page.

Startup Sequence Without Pre-Heat

Manifolds are heated beginning with Startup group 1. Once all the zones in Group 1 reach setpoint, Startup Group 2 is "released".

When all manifolds in the final group have reached setpoint, the cavities are released and the controller begins normal operation.

Startup Sequence With Pre-Heat

When used in conjunction with Manifold Pre-Heat, the startup sequence is more complicated.

The manifolds are started group by group and controlled at the pre-heat temperature.

Once all zones in the last group reach pre-heat temperature, the cavities are released, but the manifolds start again with Group 1.

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|---------------------------|-------------------|-------------------|-------------------|-------------------|-------------------|
| Manifold Start-up Group 1 | | | | | |
| 101 'Sprue' | 102 'Manifold-1' | 103 'Manifold-2' | 104 'Manifold-3' | 105 'Manifold-4' | 106 'Manifold-5' |
| 107 'Manifold-6' | 108 'Manifold-7' | 109 'Manifold-8' | 110 'Manifold-9' | 111 'Manifold-10' | 112 'Manifold-11' |
| 113 'Manifold-12' | 114 'Manifold-13' | 115 'Manifold-14' | 116 'Manifold-15' | 117 'Manifold-16' | 118 'Manifold-17' |
| 119 'Manifold-18' | 120 'Manifold-19' | 121 'Manifold-20' | 122 'Manifold-21' | 123 'Manifold-22' | 124 'Manifold-23' |
| 125 'Manifold-24' | 126 'Manifold-25' | 127 'Manifold-26' | 128 'Manifold-27' | | |



Place a zone into a new group using this button.



Use this button to place multiple zones into groups.

Only Supervisors can change startup groups.

Changes made to startup groups affect the current setup.

Manifolds are heated in group order (i.e.: Group-1 is heated first).

| | | | | | |
|---------------------------|-------------------|-------------------|-------------------|-------------------|-------------------|
| Manifold Start-up Group 1 | | | | | |
| 101 'Sprue' | | | | | |
| Manifold Start-up Group 2 | | | | | |
| 102 'Manifold-1' | 103 'Manifold-2' | 104 'Manifold-3' | 105 'Manifold-4' | 106 'Manifold-5' | 107 'Manifold-6' |
| 108 'Manifold-7' | 109 'Manifold-8' | 110 'Manifold-9' | 111 'Manifold-10' | 112 'Manifold-11' | 113 'Manifold-12' |
| Manifold Start-up Group 3 | | | | | |
| 114 'Manifold-13' | 115 'Manifold-14' | 116 'Manifold-15' | 117 'Manifold-16' | 118 'Manifold-17' | 119 'Manifold-18' |
| 120 'Manifold-19' | 121 'Manifold-20' | 122 'Manifold-21' | 123 'Manifold-22' | 124 'Manifold-23' | 125 'Manifold-24' |
| Manifold Start-up Group 4 | | | | | |
| 126 'Manifold-25' | 127 'Manifold-26' | 128 'Manifold-27' | | | |



Enabling the Startup Sequencer

Once you have defined the startup groups, you must enable the startup sequencer. This setting is in the General Set-up page.

Only Supervisors can change this setting.



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