

QUICK GUIDE for volumetric dosing system “Midexx-V” for injection molding

Connections:

- **Start signal** either as potential free open contact via signal cable (AUX Port/DB9 ↔ green & white wire) or 220 V power connection on right side
- 220 V **power connection** on back side

Start-up:

1. **Power supply:** Switch on by On/Off-toggle on backside.
2. **Color supply:** Connect color container with hose and put it on holder. Insert hose in peristaltic pump head or connect it with progressive cavity or gear pump respectively and connect it with hopper of molding machine.
3. **Pre-conveying of color:** Press „**FORWARD**“. If necessary repeat proceeding until the color has passed the pump head. By pressing "**STOP**" the process can be aborted.
4. **Calibration:** Press "**CALIBRATE**" followed by "**START**". → Pump conveys for 30 sec. Collect color into a cup and determine the mass of product. Repeat 2-3 times and form the arithmetic mean value.
5. **Enter calibration value:** Select "**SampleWgt(gr)**" via arrow keys, enter value and press "**ENTER**".
6. **Enter dosage (%):** Select "**LDR %**" (let down ratio) via arrow keys, enter dosage and confirm with "**ENTER**".
7. **Enter shot weight (g):** Change to "**Shot Size (gr)**", enter shot weight and confirm with "**ENTER**".
8. **Start:** Press "**START**".
9. **Stop:** Press "**STOP**".

Note:

- To prevent color drops after production the color can be conveyed back into the hose via pressing "**REVERSE**" permanently.