

QUICK GUIDE for gravimetric pump system „GR-50“ 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 package with hose and put it on holder. Insert hose in peristaltic pump head or connect it with progressive cavity pump respectively and connect it with extruder.
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**". If necessary repeat procedure until a reasonable value > 10 g is displayed in the lowest line "SampleWgt(gr)".
5. **Enter dosage (%):** Select "**LDR %**" (let down ratio) via arrow keys, enter dosage and confirm with "**ENTER**".
6. **Enter shot weight (g):** Change to "**Shot Size (gr)**", enter the shot weight and confirm with "**ENTER**".
7. **Start:** Press "**START**".
8. **Stop:** Press "**STOP**".

Note:

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