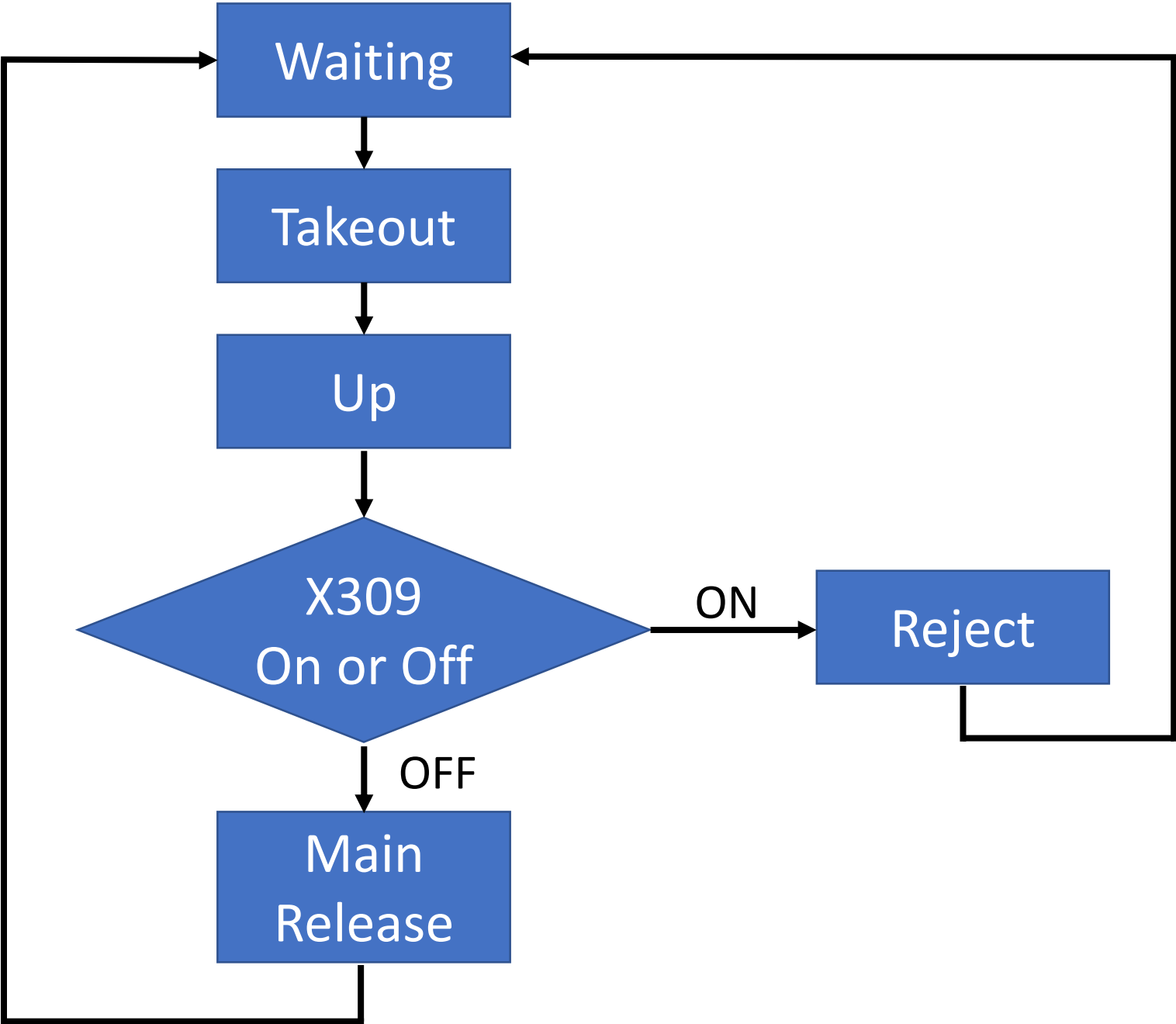
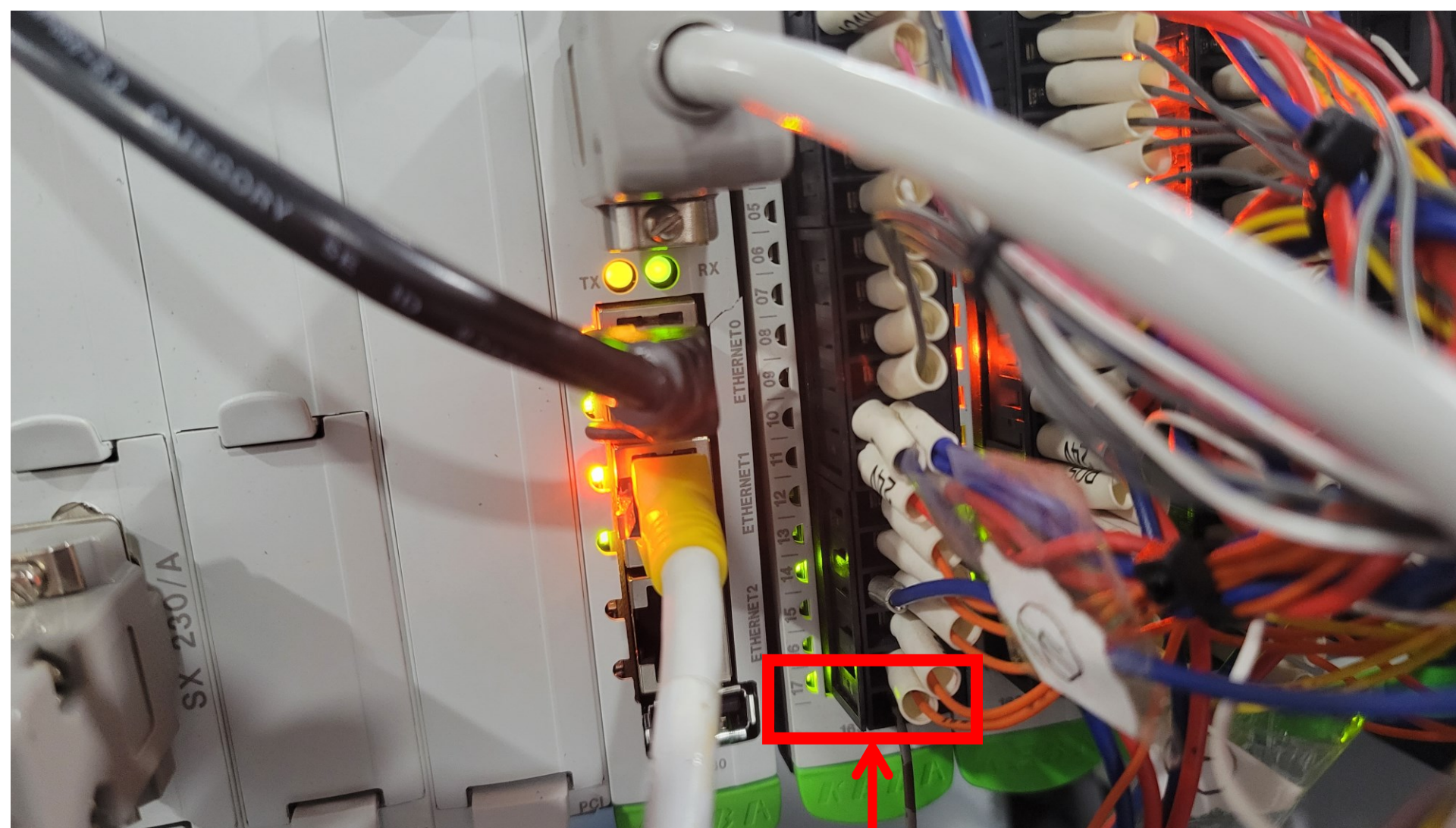


# REJECT PARTS



# WORK FLOW





This is X309 Signal port. (GND)  
It is the bottom port of the leftmost PLC card.)



Set up Reject Position

Signals		new2		Main	
Output	Input	Inter.	Vacuum		
#IMM Signal				#Interlock	
<input type="radio"/> X300:MoldCloseDone		<input checked="" type="checkbox"/> MoldClose			
<input checked="" type="radio"/> X301:MoldOpenDone		<input checked="" type="checkbox"/> MoldOpen			
<input checked="" type="radio"/> X302:SafetyDoor		<input checked="" type="checkbox"/> EjectorFwd			
<input checked="" type="radio"/> X303:FullAuto		<input checked="" type="checkbox"/> EjectorBack			
<input type="radio"/> X304:EjectorBac...		<input checked="" type="checkbox"/> CoreFwd			
<input type="radio"/> X305:EjectorFwdDon		<input checked="" type="checkbox"/> CoreBack			
<input type="radio"/> X306:CoreFwdDone		<input type="checkbox"/> Core2Fwd			
<input type="radio"/> X307:CoreBackDone		<input type="checkbox"/> Core2Back			
<input type="radio"/> X308:MoldOpening		<input type="checkbox"/> Buzzer			
<input type="radio"/> X309:RejectPart		<input type="checkbox"/> ConveyorOn			
<input type="radio"/> X310:Core2FwdDone		<input type="checkbox"/> TakeOutComplete			
<input type="radio"/> X311:Core2BackDone		<input checked="" type="checkbox"/> RobotEMO			

Check Interlock <Reject Part> signal.

If signal is ON, ☒ X309:RejectPart

the robot release the part at "Reject position"

If the robot uses  
*Order Point Off* mode,

Please download  
[SecondPositionDown.tip](#) file  
from our website.

This file needs to be placed in the Robot PLC.





**Take out SD card from  
the robot PLC**



**Connect it to the PC**

Before moving on to the next step,  
**PLEASE BACK UP** the data  
into your PC or another SD card.

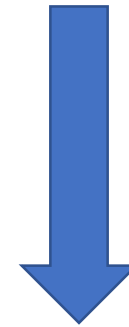


Name	Date modified
application	12/10/2020 3:55 PM
protocol	12/10/2020 3:55 PM
system	12/10/2020 3:55 PM
systemsettings	12/10/2020 3:55 PM
terminal	12/10/2020 3:55 PM
PmaData.bin	3/7/2018
ProcessData.csv	12/3/2020

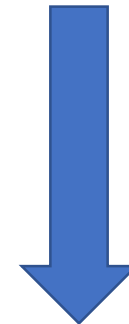
> application

Name	Date modified	Type
control	12/10/2020 3:55 PM	File folder
view	12/10/2020 3:55 PM	File folder

**<Application>**



**<Control>**



> application > control

Name

config

iecontrol

teachcontrol

text

**<teachcontrol>**



**You will see mold project file folders.  
Find **projectbase.tt** folder.**

**This folder is the basis for  
every new mold file you create.**

general222.tt

order\_reject\_test.tt

ordermulti.tt

projectbase.tt

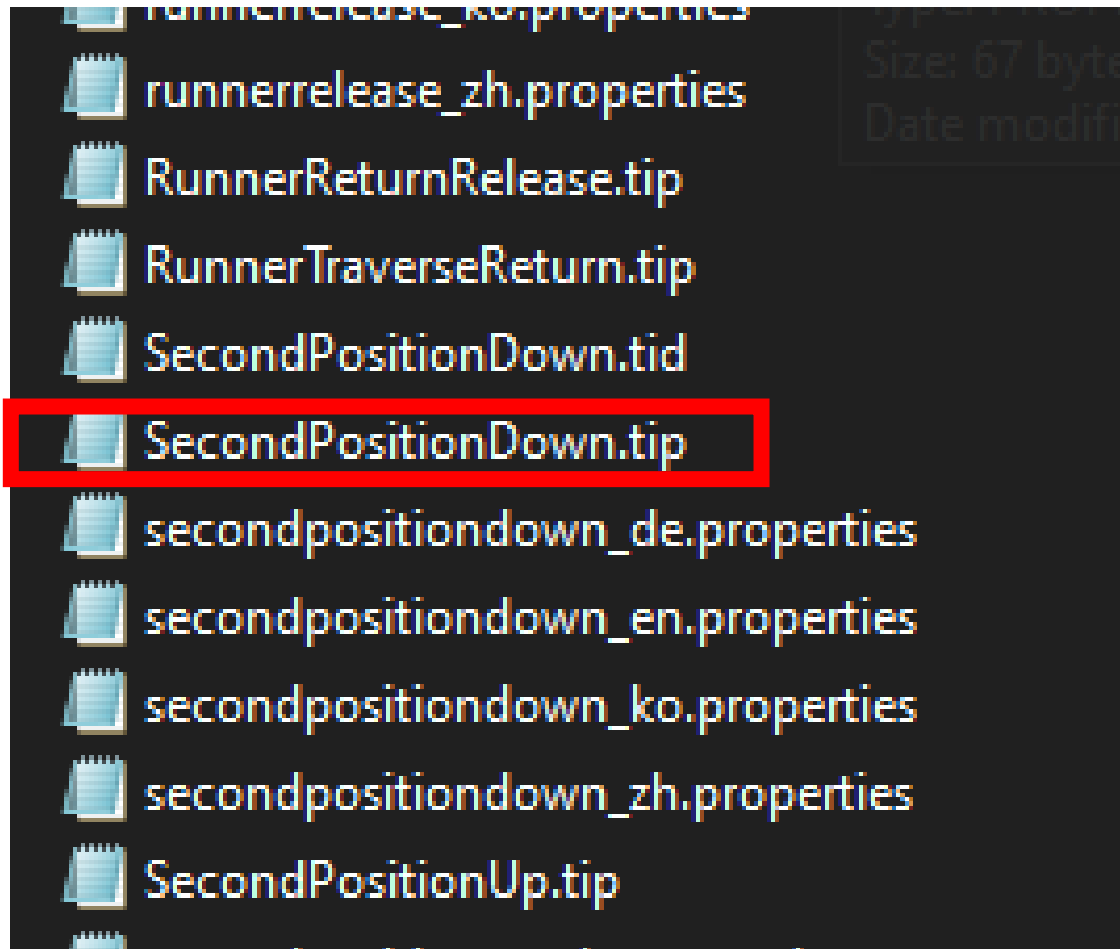
tbs105054\_han\_backup.tt

tempo2.tt

test.tt

ttt.tt

Vision\_MoveUntil.tt



**Replace  
“SecondPositionDown.tip  
with new file.**

- Insert back to the Robot PLC, and power ON the robot.
- Create a new mold file

Please let us know if you have any questions.

