

# EWIKON

Valid for item numbers:

68152.202

68152.204

68152.208

68152.218

68152.301

68152.302

from software version 1.01.0

68162.202

68162.204

68162.208

68162.218

68162.271

68162.272

from software version 3.00.0

EWIKON 02/2025



Controller for electric valve gate systems  
with linear servo drives

## *motion CONTROL SD*

Operating manual



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## 1. General information



### NOTE!

Improper operation of the device may result in severe personal injury and considerable material damage! You must carefully read this operating manual and familiarise yourself with the safety installations before installing, commissioning or maintaining the device. Do not operate the device without having received appropriate training.

### 1.1 Information on this operating manual

This operating manual has been prepared in accordance with directive 2006/42/EC. It enables the safe and efficient operation of **motion CONTROL SD** controllers.

### 1.2 Manufacturer

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### 1.3 Formal information on this operating manual

Person in charge of documentation: Horst Balzer

Version: 1.03.0, date: 11/02/2025

Language: German (original operating manual); English

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## 1.4 Conventions

### 1.4.1 Instructions and system responses

Operating steps that have to be carried out by the operator are displayed as a numbered list. The sequence of the steps has to be adhered to.

Example:

1. Operating step 1
2. Operating step 2

### 1.4.2 Enumerations

Enumerations without mandatory sequence are displayed as a list with bullet points.

Example:

- Point 1
- Point 2

### 1.4.3 Abbreviations

The following terms and abbreviations are used in the operating manual:

Abbreviation	Meaning
PPE	Personal protective equipment
PE	Protective earth conductor
EU	European Union
SD	Servo drive
LSR	Liquid Silicone Rubber
LCD	Liquid cristal display
TFT	Thin-film transistor
FTP	File transfer protocol

Chart 1: Terms and abbreviations

## 2. Safety instructions

The **motion CONTROL SD** controller complies with the Low Voltage Directive 2014/35/EU and the EMC Directive 2014/30/EU and has been designed, manufactured and tested for safety in accordance with the currently applicable safety regulations and laws and the state of the art. If the **motion CONTROL SD** controller is used in a manner not specified by EWIKON, the function of the protective devices of the device may be impaired.

The **motion CONTROL SD** controller is delivered in perfect technical condition.

However, hazards can arise from **motion CONTROL SD** controllers if they are:

- operated by personnel who have not been properly trained.
- used improperly or not as intended.
- not in perfect condition from a safety point of view.

### 2.1 Safety instructions and symbols used

The safety instructions are introduced with signal words and are marked by symbols. They draw attention to dangerous situations that may arise during installation, operation and maintenance work. Safety instructions must be observed to avoid accidents, personal injury and damage to material.

#### Warnings

- protect against possible personal injury and damage to material if observed.
- classify the extent of the hazard by means of the signal word.
- indicate the danger of personal injury by means of the hazard sign.
- indicate the type and source of the hazard.
- indicate the risk and the possible consequences.
- indicate measures to avoid hazards and prohibit certain types of behaviour.



**WARNING!** = Signal word

#### Source of hazard

Possible consequences, if ignored

- Measures / prohibitions

The hazard sign marks warnings which warn against personal injuries.

#### Source of hazard

The source of hazard indicates the cause of hazard.

#### Possible consequences, if ignored

If the warnings are ignored, possible consequences will be e. g. crushing, burnings or other severe injuries.

#### Measures / Prohibitions

“Measures / Prohibitions” lists actions that are to be carried out to prevent a hazard (e. g. stop a drive) or that are prohibited in order to prevent a hazard.



2.1.1 Signal words for hazard classification



**HAZARD**

Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.



**WARNING!**

Indicates a potentially hazardous situation which, if not avoided, will result in death or serious injury.



**CAUTION**











Indicates a potentially hazardous situation which, if not avoided, will result in minor injury or material damage.



**NOTE**

Indicates useful additional information and tips to promote trouble-free operation and to prevent material damage.

2.1.2 Explanation of pictograms

	Read operating manual		Caution! Risk of electrocution
	Caution! Hot surface		Caution! Oxidising agents
	Caution! Suspended load		Caution! Risk of hand injuries / crushing
	Caution! Explosive atmosphere		Caution! Risk of hand and cut injuries
	Caution! Systems under pressure		Caution! Moving forklift traffic hazard

## 2.2 Intended use

EWIKON controllers are designed exclusively for the intended use described here.

Any other use contrary to the intended use is excluded and may lead to personal injury and damage to material. In this case, the warranty expires.

The **motion CONTROL SD** controller is to be used exclusively for controlling the valve pin movement of EWIKON valve gate hot and cold runner systems installed in a closed injection mould.

Intended use requires that all notes and information in these operating manual are read, understood and observed.

To ensure safe operation of the **motion CONTROL SD** controller, the specified maintenance and inspection intervals must be observed.



### Use of the **motion CONTROL SD** controller

Only use the **motion CONTROL SD** controller for its intended purpose and in perfect condition in terms of safety! This is the only way to ensure the operational safety of the **motion CONTROL SD** controller.

## 2.3 Improper use

Any use not specified under or going beyond the intended use is considered improper use.

## 2.4 Qualification of staff

The staff must have the appropriate qualifications for assembly, maintenance and repair.

Any lack of knowledge on the part of the staff must be eliminated through training and instruction.

### 2.4.1 Requirements on specialised staff

Improper use of EWIKON controllers can lead to personal injury and damage to material. All work must be carried out by specialised staff only.

Only trained specialised staff is allowed to connect and operate EWIKON controllers. Specialised staff has technical training, proven knowledge and experience in handling e.g. injection moulding equipment or electrical systems, as well as knowledge of the relevant safety regulations and is able to independently recognise possible dangers and avoid them by taking suitable protective measures.

## 2.5 Personal Protective Equipment (PPE)

Wear the necessary protective equipment when working on or near the machine. Special instructions for personal protective equipment in the working area must be observed.

### 2.5.1 Symbols of the personal protective equipment

Always wear the following when carrying out any work:



**Protective clothes:** To protect your body wear tight-fitting clothes with low resistance to tearing, without protruding parts and with long sleeves and long trousers. Do not wear rings, chains or any other jewelry.



**Safety shoes:** To protect yourself against electric shocks, melt splashes, heavy, falling objects and slips and falls on slippery surfaces.

Always wear the following when carrying out special work:



**Safety glasses:** To protect your eyes against scattering debris, heat and melt splashes.



**Ear protection:** To protect your ears against loud ambient noises.



**Face mask:** To protect your face against scattering debris, heat and melt splashes.



**Protective helmet:** To protect your head against falling objects and sharp edges.



**Protective gloves (heat resistant):** To protect your hands against extreme heat, abrasions, punctures and more severe injuries.



**Heat resistant apron:** To protect your body against extreme heat.

## 2.6 Hazards and safety measures in connection with hot runner systems

In principle, the operator of the system is subject to the legal obligations for occupational safety. In addition to the safety instructions in this manual, the safety, accident prevention and environmental protection regulations applicable to the system's area of use must be observed. The operator must clearly define responsibilities and ensure that all staff operating the system has read and understood these instructions. Information about hazards must be provided regularly. Protective equipment must be provided for the staff. Maintenance intervals must be observed.



### Risk of physical injuries by high pressure or unexpected material leakage

- Unexpected material leakage may result in burns. There is a risk of serious injuries or death and/or damage to the hot runner.
- There is also a risk of burns, if water gets onto or into the hot runner. If the water reaches dangerously high temperatures, the metal housing may burst and cause serious injuries due to emerging water vapour or melting resins.



### Safety measures

- Make sure the hot runner system heats up evenly. Particularly for large manifolds it may be necessary to switch on nozzle and sprue bush heaters at the same time, but later than the manifold heaters.
- Make sure the nozzle tips and/or the gates are not blocked by solidified resin that has a higher melting point and that there is no humidity on the hot runner system, e.g. caused by a leaky temperature control circuit.



### Risk of burns

- Hot surfaces  
Many components of the hot runner systems get very hot and may cause severe skin burns when being touched.
- Hot material (plastic melt)  
Never touch material leaking from the nozzle/the mould/the hot runner or the material inlet. Even material that seems to be cooled down already may still be hot inside the core and cause burns.

### Safety measures

- Please make sure you wear your personal protective equipment (PPE) when working near or on a hot runner system. Pay special attention to warnings indicating hot surfaces. All components have to be cooled down to ambient temperature before you start working. Exceptions to these rules are explicitly mentioned.

**Risk of electric shocks**

- Danger to life by electric shock. Touching live surfaces may result in severe or even lethal injuries.
- Always keep water away from live components and the hot runner. There is a risk of short circuits!

**Safety measures**

- Electrical systems have to be disconnected from the mains and secured against being switched on again before any work is carried out. Only authorised electricians are allowed to carry out any work on electrical systems.
- All components have to be connected to a suitable power source according to the wiring diagrams and in compliance with the applicable local regulations. Injection moulding machine and hot runner systems have to be grounded.

**Risk of physical injuries by suspended / heavy load**

- Only trained staff is authorised to operate lifting devices and forklift trucks. Proceed slowly and with care. Prevent uncontrolled swinging of the load (e. g. the manifold).

**Safety measures**

- Lifting devices and forklift trucks have to be designed in such a way that they bear the weight and the size of the hot runner system/manifold. Make sure you use the marked lifting points.

**Risk of physical injuries by pressurized connecting lines (compressed air, hydraulic oil, water etc.)**

- All supply lines to the hot runner and/or the hot runner system or the hot half have to be long enough to prevent any stress when the mould halves part. They must not be affected by moving parts of the mould or of the machine. Prevent the hoses from rubbing over the edges of the mould as they may be damaged because this will create the risk of a spontaneous leakage of pressurized process media (pressurised air, hydraulic oil, water).

**Safety measures**

- Make sure you have depressurized all supply lines before carrying out any work. Only skilled personnel is allowed to carry out work on the supply lines. Please wear your personal protective equipment (PPE).

**Risk of physical injuries by sharp edges and corners**

- Sharp edges and corners pose a risk of injury, possibly resulting in skin abrasions and cut injuries.

**Safety measures**

- Make sure you wear protective gloves when working near sharp edges and corners. Proceed with care.
- Make sure the system is clean and free of burrs!

**Risk of physical injury by crushing of extremities**

- There is risk of injury when lifting heavy loads during assembly. Your hands or other parts of the body may be crushed.

**Safety measures**

- Make sure you wear protective gloves to prevent injuries while working close to heavy loads.
- Keep all parts of your body away from danger areas while setting down heavy loads during assembly.

## 2.7 Hazards and safety measures in connection with cold runner systems

The company operating the system must comply with the statutory obligations on occupational safety. In addition to the safety instructions of this manual the safety, accident prevention and environment protection provisions applicable for the system's range of use must be adhered to. The operating company must clearly define responsibilities and make sure that all staff operating the system has read and understood this manual. The company also has to inform about hazards at regular intervals. Personal protective equipment has to be made available to the staff. Maintenance intervals have to be respected.



### Risk of physical injuries by high pressure or unexpected material leakage

- Unexpected material leakage may result in burns. There is a risk of serious injuries or death and/or damage to the cold runner.
- There is also a risk of burns, if water gets onto heated surfaces. If the water reaches dangerously high temperatures, the metal housing may burst and cause serious injuries due to emerging water vapour or crosslinked silicone.



### Safety measures

- Make sure the nozzle tips and/or the gates are not blocked by crosslinked silicone and that there is no humidity on the cold runner system, e.g. caused by a leaky temperature control circuit before heating up the heated separator plate.



### Risk of burns

- Hot surfaces  
Partitions of the cold runner system get very hot and may cause severe skin burns when being touched.
- Hot silicone finished part  
The freshly cross-linked finished part must in no way be touched immediately after the end of the injection moulding process. It can be very hot and cause burns.

### Safety measures

- Please make sure you wear your personal protective equipment (PPE) when working near or on a cold runner system. Pay special attention to warnings indicating hot surfaces. All components have to be cooled down to ambient temperature before you start working. Exceptions to these rules are explicitly mentioned.



### Risk of electric shocks

- Danger to life by electric shock.  
Touching live surfaces may result in severe or even lethal injuries.
- Always keep water away from live components and the cold runner. There is a risk of short circuits!

### Safety measures

- Electrical systems have to be disconnected from the mains and secured against being switched on again before any work is carried out. Only authorised electricians are allowed to carry out any work on electrical systems.
- All components have to be connected to a suitable power source according to the wiring diagrams and in compliance with the applicable local regulations. Injection moulding machine and cold runner systems have to be grounded.



### Risk of physical injuries by suspended/heavy load

- Only trained staff is authorised to operate lifting devices and forklift trucks. Proceed slowly and with care. Prevent uncontrolled swinging of the load (e. g. the manifold).

### Safety measures

- Lifting devices and forklift trucks have to be designed in such a way that they bear the weight and the size of the cold runner system/manifold. Make sure to use the marked lifting points.



### Risk of physical injuries by pressurized connecting lines (compressed air, hydraulic oil, water etc.)

- All supply lines to the cold runner and/or the cold runner system or the cold half have to be long enough to prevent any stress when the mould halves part. They must not be affected by moving parts of the mould or of the machine. Prevent the hoses from rubbing over the edges of the mould as they may be damaged because this will create the risk of a spontaneous leakage of pressurized process media (pressurised air, hydraulic oil, water).

#### Safety measures

- Make sure you have depressurized all supply lines before carrying out any work. Only skilled personnel is allowed to carry out work on the supply lines. Please wear your personal protective equipment (PPE).



### Risk of physical injuries by sharp edges and corners

- Sharp edges and corners pose a risk of injury, possibly resulting in skin abrasions and cut injuries.

#### Safety measures

- Make sure you wear protective gloves when working near sharp edges and corners. Proceed with care.
- Make sure the system is clean and free of burrs.



### Risk of physical injuries by crushing of extremities

- There is a risk of injury when lifting heavy loads during assembly operations, possibly resulting in crushing of hand or other parts of the body.

#### Safety measures

- Wear protective gloves to prevent injuries while working around heavy loads.
- Make sure all body parts are kept away from the hazardous area while setting down heavy loads.

## 2.8 Electrical equipment



**HAZARD!**

### Residual voltage after activation

Risk of death by electric shock and severe injuries caused by live components.

- Check for zero potential before performing any work!

Any work on electrical equipment must be carried out by qualified electricians. Always apply the 5 safety rules when working with electrical components:

- Disconnect from the mains
- Secure against reconnection (by activating the repair switch and installing a safety lock at the same time, if necessary)
- Verify that the installation is dead
- Carry out grounding and short circuiting
- Provide protection against adjacent live parts

Maintenance work must be carried out by qualified and trained staff or maintenance staff in accordance with DIN EN 61010-2-201. Never use the **motion CONTROL SD** controller with faulty or inoperable electrical connections. In case of energy supply disruptions immediately switch off the **motion CONTROL SD** controller. The maintenance & inspection schedules regarding electrical components given by the manufacturers have to be adhered to. Check for damage to the insulation at regular intervals.

## 2.9 Spare and wear parts, auxiliary material

The use of non-OEM spare and wear parts as well as auxiliary material may pose risks. Only use original parts or parts approved by EWIKON Heißkanalsysteme GmbH.

## 2.10 Limitation of liability

All information and instructions given in this manual have been compiled in consideration of the applicable standards and regulations, state of the art as well as our know-how and experience.

EWIKON does not assume liability for any damage caused by:

- Non-observance of this manual
- Improper use
- Use of unskilled staff
- Unauthorised retrofitting or technical modifications
- Use of non-approved spare parts

The technical service provided verbally, in writing or on the basis of tests represents our best knowledge but is not binding and does not release you from carrying out additional tests on the products supplied by us regarding their suitability for the intended use.

The use of the products is beyond our control. Therefore, it is your own responsibility to ensure that the products meet your specific requirements. Nevertheless, should an issue of liability arise, all damage shall be limited to the value of the products supplied by EWIKON and used by you.

We guarantee the perfect quality of our products in accordance with our general terms and conditions of sale and payment as well as the extended warranty conditions.

These are available on our homepage [www.ewikon.com](http://www.ewikon.com).

The statutory provisions prevailing at the time of conclusion of the contract shall apply.

We reserve the right to make technical changes within the scope of improving the properties of use and further development.

## 2.11 Warranty terms

For warranty conditions of hot and cold runner systems and components please refer to the terms and conditions of EWIKON.

## 2.12 Standards and directives

EWIKON hot and cold runner systems conform to the following European directives:

- Machinery Directive 2006/42/EC
- Low Voltage Directive 2014/35/EU
- EN ISO 12100:2010 Safety of machinery - General principles for design - Risk assessment and risk reduction
- DIN EN 60204-1:2019-06 Safety of machinery - Electrical equipment of machines - Part 1: General requirements

EWIKON controllers conform to the following European directives:

- Low Voltage Directive 2014/35/EU
- EMC Directive 2014/30/EU
- DIN EN 61010-1: 2020-03 Safety requirements for electrical equipment for measurement, control, and laboratory use - part 1: General requirements
- DIN EN 61010-2-201: 2019-04 Safety requirements for electrical equipment for measurement, control and laboratory use - part 2-201: Particular requirements for control equipment





### 3. Technical Data

#### 3.1 motion CONTROL SD for single drives

##### 3.1.1 Mechanical data

###### 3.1.1.1 Main dimensions / Dimensions of the motion CONTROL SD controller

Size	Description	Qty. / size (approx.)	Unit
2-zone controller Item no. 68152.202 / 68162.202	Dimensions (H x B x T)	190 x 355 x 400	mm
	Weight	approx. 9,5	kg
4-zone controller Item no. 68152.204 / 68162.204	Dimensions (H x B x T)	190 x 355 x 400	mm
	Weight	approx. 9,9	kg
8-zone controller Item no. 68152.208 / 68152.218 68162.208 / 68162.218	Dimensions (H x B x T)	460 x 220 x 550	mm
	Weight	approx. 21	kg

Chart 2: Main dimensions / Dimensions of the motion CONTROL SD controller for single drives

##### 3.1.2 Electrical data

###### 3.1.2.1 Connections / Connector pin assignment

Description	Qty. / size (approx.)	Unit
Voltage AC (+10 % / -15 %)	230	V
Frequency	50/60	Hz
Power	max. 540 2-zone / 4-zone controller	W
	max. 1020 8-zone controller	
Protection class	IP20	

Chart 3: Electrical data

#### 3.2 motion CONTROL SD for synchronous plate systems

##### 3.2.1 Mechanical data

###### 3.2.1.1 Main dimensions / Dimensions of the motion CONTROL SD controller

Size	Description	Qty. / size (approx.)	Unit
1-zone controller Item no. 68152.301	Dimensions (H x B x T)	460 x 220 x 550	mm
	Weight	approx. 17	kg
2-zone controller Item no. 68152.302	Dimensions (H x B x T)	460 x 220 x 550	mm
	Weight	approx. 21	kg

Chart 4: Main dimensions / Dimensions of the motion CONTROL SD controller for single drives

##### 3.2.2 Electrical data

###### 3.2.2.1 Connections / Connector pin assignment

Description	Qty./size (approx.)	Unit
Voltage AC (+10 % / -15 %)	230/400	V
Frequency	50/60	Hz
Power (item no. 68152.301 / 68152.302)	max. 3600 / 7200	W
Protection class	IP20	

Chart 5: Electrical data

## 3.3 motion CONTROL SD for pro EDGE VG

### 3.3.1 Mechanical data

#### 3.3.1.1 Main dimensions / Dimensions of the motion CONTROL SD controller

Size	Description	Qty. / size (approx.)	Unit
1-zone controller / 2-zone controller Item no. 68162.271 / 68162.272	Dimensions (H x B x T)	190 x 355 x 400	mm
	Weight	approx. 9.5 / 9.8	kg

Chart 6: Main dimensions / Dimensions of the motion CONTROL SD controller for pro EDGE VG

### 3.3.2 Electrical data

#### 3.3.2.1 Connections / Connector pin assignment

Description	Qty. / size (approx.)	Unit
Voltage AC (+10 % / -15 %)	230 / 400	V
Frequency	50/60	Hz
Power	max. 1020	W
Protection class	IP20	

Chart 7: Electrical data

## 3.4 Operating conditions

Operating conditions	Size (approx.)	Unit
Ambient temperature (operation)	+5 to +40	°C
Ambient temperature (storage)	-40 to +70	°C
Relative humidity for operation (up to 31 °C)	max. 80 (linearly decreasing to max. 50 % at 40 °C)	%
Pollution degree	2	

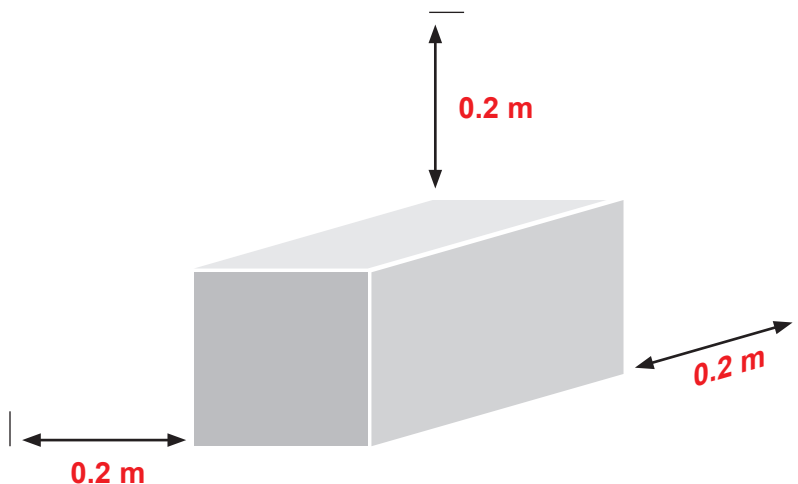
Chart 8: Operating conditions

## 3.5 Placing the controller

Place the controller on a stable, flat, non-combustible working surface. The display should be at eye level with the user to facilitate reading of the display and operation of the device.

The device includes a built-in fan on the rear side as well as ventilation slots on the underside, protected by a filter. Make sure that the air flow through these openings is not obstructed.

Keep a minimum distance of 0.2 m in all directions around the device to other equipment and parts of buildings.





## 4. Functional description of the *motion CONTROL SD* controller

### 4.1 Versions of the *motion CONTROL SD* controller



Picture 1: 2- or 4-zone controller (item no. 68152.202/204)

### 4.2 Required accessories (connection cables)

#### 4.2.1 *motion CONTROL SD* for single drives

Qty	Item no.	Description	Remark
1	60070.050-V06	Signal cable M23, 17-pin, Pin, 6 m	1 pc per controller
1	63050.130(-V06)	Hybrid motor cable SpeedTec 4G0, 75 mm <sup>2</sup> , 3 m (6 m)	1 pc per drive

Chart 9: Connecting cables required for the *motion CONTROL SD* controller for single drives(not included in delivery)

#### 4.2.2 *motion CONTROL SD* for synchronous plate systems

Qty	Item no.	Description	Remark
1	60070.050-V06	Signal cable M23, 17-pin, Pin, 6 m	1 pc per controller
1	63050.110-V03/V06	Motor connection cable M23 servo drive unit 3/6 m	1 pc per drive
1	63050.120-V03/V06	Resolver cable M23 servo drive unit 3/6 m	1 pc per drive

Chart 10: Connecting cables required for the *motion CONTROL SD* controller for synchronous plate systems (not included in delivery)

#### 4.2.3 *motion CONTROL SD* for *pro EDGE VG*

Qty	Item no.	Description	Remark
1	60070.050-V06	Signal cable M23, 17-pin, Pin, 6 m	1 pc per controller
1	63050.110-V03/V06	Motor connection cable M23 servo drive unit 3/6 m	1 pc per drive
1	63050.120-V03/V06	Resolver cable M23 servo drive unit 3/6 m	1 pc per drive

Chart 11: Connecting cables required for the *motion CONTROL SD* controller for *pro EDGE VG* (not included in delivery)

### 4.3 Function

The **motion CONTROL SD** controller enables precise control of the opening and closing movement for electric valve gate systems, especially for sequential gating. Depending on the version up to eight drives can be connected to one **motion CONTROL SD** controller. Only linear actuators (servo motors with integrated spindle) qualified by EWIKON can be used as drives.



#### Application range of the **motion CONTROL SD** controller

This EWIKON control system can be used to operate electrically operated valve gate systems from EWIKON Heißkanalsysteme GmbH in dry rooms in the industrial sector.

## 5. Operating instructions

### 5.1 Safety instructions



#### WARNING!

#### Residual voltage after activation

Risk of electric shock due to live parts and risk of severe injuries due to moving parts



- Ensure zero potential before performing any work on or inside the **motion CONTROL SD** controller
- Set the power switch to OFF and disconnect the mains plug
- Wait for 5 minutes until the condensers for the DC link voltage are discharged.
- Connection, repair and maintenance work may only be carried out by qualified specialised staff!



#### Checks and protective measures before startup

The connected drives and hot or cold runner components can get hot  
There is crush hazard due to moving parts (e. g. pistons, cylinders)

- The installation must be checked in accordance with EN 60204-1 or recognised standards of good practice before starting up the valve gate system.
- Appropriate precautions must be taken for startup and operation.

## 5.2 Operating requirements

### 5.2.1 Technical requirements

An input signal for „release“ sent from the injection moulding machine or the temperature controller is necessary to prevent the system from being operated when it is cold or when the safety door is open.

At least one trigger signal from the injection moulding machine is required to control the drive(s). It triggers the stroke movement of the drive via the control unit. The „start injection“ signal is preferably used to open the valve pins, alternatively the „start build-up of clamping force“ or „close mould“ signal can be used. Closing of the valve pins usually takes place at „end of holding pressure“.

When a signal is applied (+24 V), the drive moves and causes the valve pins to open and to remain in this position. When the signal is cancelled (0 V), the valve pins close again. If the trigger signal is not made available by the controls of the injection moulding machine as described, an adjustment will have to be made. Further digital or analogue signals can be used to obtain e. g. complex motion profiles.

The **motion CONTROL SD** controllers are only designed for the drives listed below.

#### Drives for **motion CONTROL SD** for single drives:

Item no.	Description	Selection
22902	Drive for valve pin Ø 2,0 mm, stroke = 10 mm	SRV31-22900 ESM55
22903	Drive for valve pin Ø 3,0 mm, stroke = 10 mm	
22904	Drive for valve pin Ø 4,0 mm, stroke = 15 mm	

Chart 12: Drives that can be used with the **motion CONTROL SD** controller for single drives

#### Drives for **motion CONTROL SD** for synchronous plate systems:

Item no.	Description	Selection
13812	Linear actuator GSM20-0301-IFA-ER1-238XM	SRV40-13812 GSM20
13813	Linear actuator GSM30-0302-IFA-ER1-238XM	SRV41-13813 GSM30
13814	Linear actuator GSM40-0602-IFA-ER1-138XM	SRV43-13814 GSM40
13814-V01	Linear actuator GSM40-0602-IFA-BR1-238-30	SRV43-13814-V01 GSM40 DS
18255	Linear actuator MA406G-0R0R-132Z-0E0	SRV46-18255 MA406G
18253	Linear actuator MA506G-0R0R-132Z-0E0	SRV47-18253 MA506G
18266	Linear actuator MG633I-0R0R-032Z-0E0	SRV48-18266 MG633I

Chart 13: Drives that can be used with the **motion CONTROL SD** controller for synchronous plate systems

#### Drives for **motion CONTROL SD** for **pro EDGE VG**:

Item no.	Description	Selection
18449	Linear actuator MG404D-0R0S-132Z-0E0	SRV23-18449 MG404D

Chart 14: Drives that can be used with the **motion CONTROL SD** controller for **pro EDGE VG**



**DANGER!**

#### Insufficient protective conductor connection to injection moulding machine

Fatal electric shock or serious injuries due to live components.

- When starting up the system the operator has to make sure that all electrically operated system components are connected to the protective conductor system of the injection moulding machine or are safeguarded by equivalent safety measures before he applies any electric voltage.
- Before switching on a drive system it has to be made sure that the housing is properly connected to ground potential (PE bar). The earth connections must be installed, even if the drive system is connected only for testing purposes or for a short period!

## 6. Assembly

The purpose of the following notes is to support the assembly staff during the assembly of the *motion CONTROL SD* controller. Additionally, the assembly staff has to have the knowledge required to connect a *motion CONTROL SD* controller.

### 6.1 Safety instructions



#### WARNING!

PPE

#### Cut injuries due to sharp edges and risk of getting jammed

Cut injuries to body and extremities, mainly to the hands  
Jamming of fingers or hand

- Wear your PPE and take care.



#### Control of live components before installation

Physical injuries such as an electric shock.

- The electrical equipment of the *motion CONTROL SD* controller should be checked, especially those areas which will no longer be accessible after installation.
- Please check if cables are kinked or squeezed and if cable insulations are undamaged.

#### Connected voltage supply during assembly

Risk of electric shock due to live parts

- The *motion CONTROL SD* controller and all connected components have to be disconnected from the voltage source during installation.

### 6.2 Checks before installation

The *motion CONTROL SD* controller is subject to comprehensive testing by the manufacturer before delivery. For safety reasons (transport or storage damage or damage to the device when preparing installation) we recommend that you check the *motion CONTROL SD* controller for damage just before installing it.

### 6.3 Installation

#### 6.3.1 motion CONTROL SD controller for single drives – Connections and connector assignment

Depending on the model, not all or more connections are available.



Picture 2: Connections on the front side (housing for 2- or 4-zone controller)



Picture 3: Connections on the front side (housing for 8-zone controller)



Picture 4: Connections on the rear side (housing for 2- or 4-zone controller)



Picture 5: Connections on the rear side (housing for 8-zone controller)



No.	Description	Function
1	Emergency Stop	Emergency stop of all drives
2	USB socket	USB socket to connect a USB memory stick for data exchange
3	Device fan	Cooling of the internal electronic modules
4	RJ 45	Ethernet connection for PC monitoring, diagnostics or OPC UA connection
5	Signal I/O	Digital signal input/output +24 V DC (17-pin)
6	Mains switch	Switch for power supply
7	Drive 1	Motor/resolver connection first drive
8	Drive 2	Motor/resolver connection second drive
9	Drive 3	Motor/resolver connection third drive
10	Drive 4	Motor/resolver connection fourth drive
11	Drive 5	Motor/resolver connection fifth drive
12	Drive 6	Motor/resolver connection sixth drive
13	Drive 7	Motor/resolver connection seventh drive
14	Drive 8	Motor/resolver connection eighth drive
15	Powerlink Out	Connection for extension unit, data interface
16	Power Supply	Connection for extension unit, power supply
17	Fuse	Device input fuse F6.3 A, 6.3 x 32 mm (placed under the top cover for 8-zone housing)
18	Mains connection	Mains cable, operating voltage 230 V +10/-15%, 50-60 Hz
19	Protective earth connection	Connection for earth potential (PE rail)

Chart 15: Connections of the *motion CONTROL SD* controller for single drives

**6.3.2 motion CONTROL SD controller for synchronous plate systems – Connections and connector assignment**

Depending on the model, not all or more connections are available.



Picture 6: Connections on the front side



Picture 7: Connections on the rear side

No.	Description	Function
1	Emergency Stop	Emergency stop of all drives
2	USB socket	USB socket to connect a USB memory stick for data exchange
3	Device fan	Cooling of the internal electronic modules
4	RJ 45	Ethernet connection for PC monitoring, diagnostics or OPC UA connection
5	Signal I/O	Digital signal input/output +24 V DC (17-pin)
6	Mains switch	Switch for power supply
7	Resolver 1	Connecting socket for the resolver of the first drive unit
8	Resolver 2	Connecting socket for the resolver of the second drive unit
9	Drive 1	Connecting socket for the motor cable of the first drive unit
10	Drive 2	Connecting socket for the motor cable of the second drive unit
11	Mains connection	Mains cable, operating voltage 230/400 V +10/-15%, 50-60 Hz
12	Protective earth connection	Connection for earth potential (PE rail)

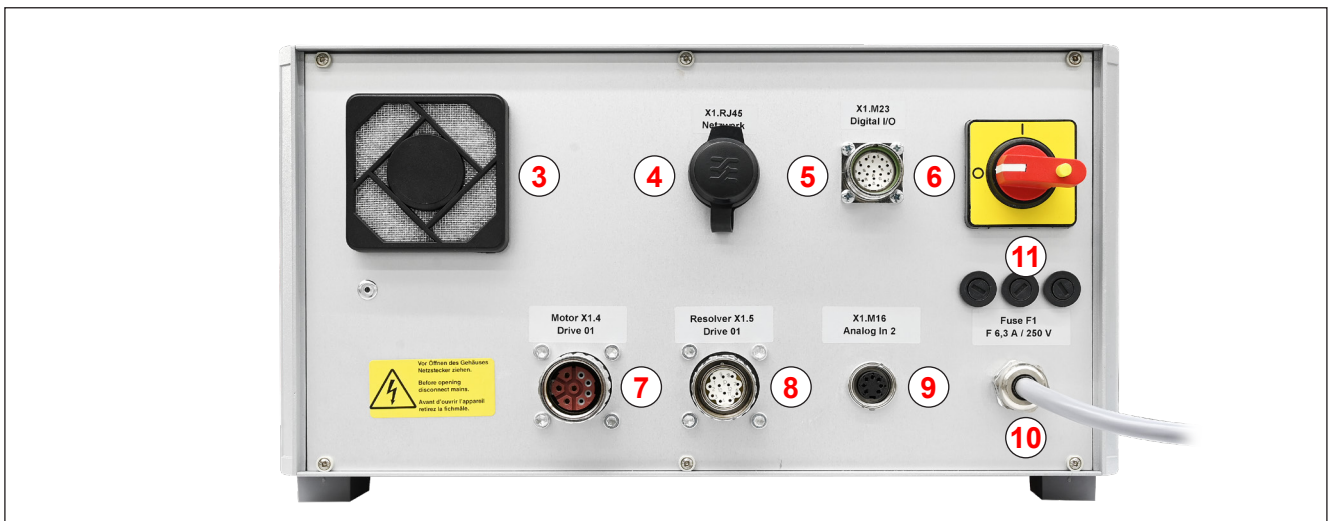
Chart 16: Connections of the *motion CONTROL SD* controller for synchronous plate systems

### 6.3.3 motion CONTROL SD controller for pro EDGE VG – Connections and connector assignment

Depending on the model, not all or more connections are available.



Picture 8: Connections on the front side



Picture 9: Connections on the rear side

No.	Description	Function
1	Emergency Stop	Emergency stop for drive unit
2	USB socket	USB socket to connect a USB memory stick for data exchange
3	Device fan	Cooling of the internal electronic modules
4	RJ 45	Ethernet connection for PC monitoring, diagnostics or OPC UA connection
5	Signal I/O	Digital signal input/output +24 V DC (17-pin)
6	Mains switch	Switch for power supply
7	Drive	Connecting socket for the motor cable of the drive unit
8	Resolver	Connecting socket for the resolver of the drive unit
9	Analog In 2 (Option)	Analogue signal input 0 - 10 V DC
10	Mains connection	Mains cable, operating voltage 230/400 V +10/-15%, 50-60 Hz
11	Fuse	3 x Device input fuse F6.3 A, 6.3 x 32 mm

Chart 17: Connections of the *motion CONTROL SD* controller for *pro EDGE VG*

### 6.3.4 Connecting the *motion CONTROL SD* controller to the injection moulding machine

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#### CAUTION!

##### Insulation of unused cores

Failure to do so may result in damage to the device.

- All unused cores have to be insulated.
- 

#### Standard connections

##### Digital input

To provide the trigger signals, a connection to the machine's control system is established using the signal cable (item no. 60070.050(-V06), must be ordered separately). Two different versions are possible here:

1. Injection moulding machine provides output signal 24 V DC:  
The output signal (+24 V DC) is connected to contact 1 (wire 1), the machine ground (GND) is connected to contact 10 (wire 10).
2. Injection moulding machine provides potential-free normally open contacts:  
A potential-free normally open contact of the injection moulding machine control is connected to contact 9 (wire 9) and contact 1 (wire 1) of the valve gate controller.

In any case, the signal „enable movement“ must be connected to the seventh signal input, as the servo motors will only move if the signal is present. This prevents damage to the valve pins in case of an improperly warmed up hot or cold runner system or movement when any safety door is open. The signal must be provided by the injection moulding machine in combination with the temperature controller.

## Analogue input 1 and 2 (option AI)

If an analogue input is used for control, in order to use information about screw position, screw volume or cavity pressure for valve pin control, there is the following possibility for connection.

- Connect a signal where the analogue value is in linear relation to the screw position directly to the input (contact / wire 15), 0-10 V and ground (contact / wire 16).

The input must be adapted in the control to the conditions of the injection moulding machine (see chapter „7.2.5.4 Analog IN“).

## Digital output

It is highly recommended to connect the digital signal output of the controller to the injection moulding machine to detect when the control is „ready“ for the next cycle or when there is an error. Each signal output provides +24 V DC and can be loaded with 0.1 A. Potential-free version (option RY) on request.

The connection of the other signals is described in „Chart 18: Contact assignment of the 17-pin trigger connection (5)“

## General overview of the trigger connection

Some applications require more than the standard signal, e.g. if the mould is equipped with pressure or temperature sensors or complex movement profiles have to be run.

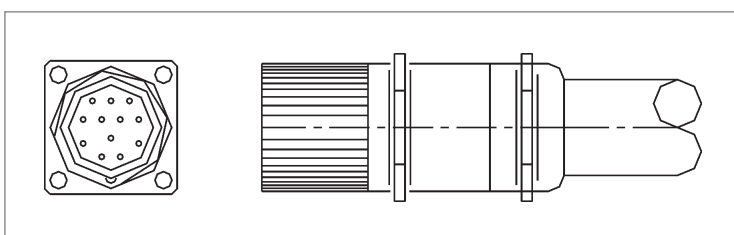
If, in addition to the „READY“ signal, confirmation for the „OPEN“ position of at least one valve pin or all valve pins is required for controlling the filling sequences, these are also provided via the signal cable.

The complete assignment of the trigger line with the standard settings for use can be found in the following table:

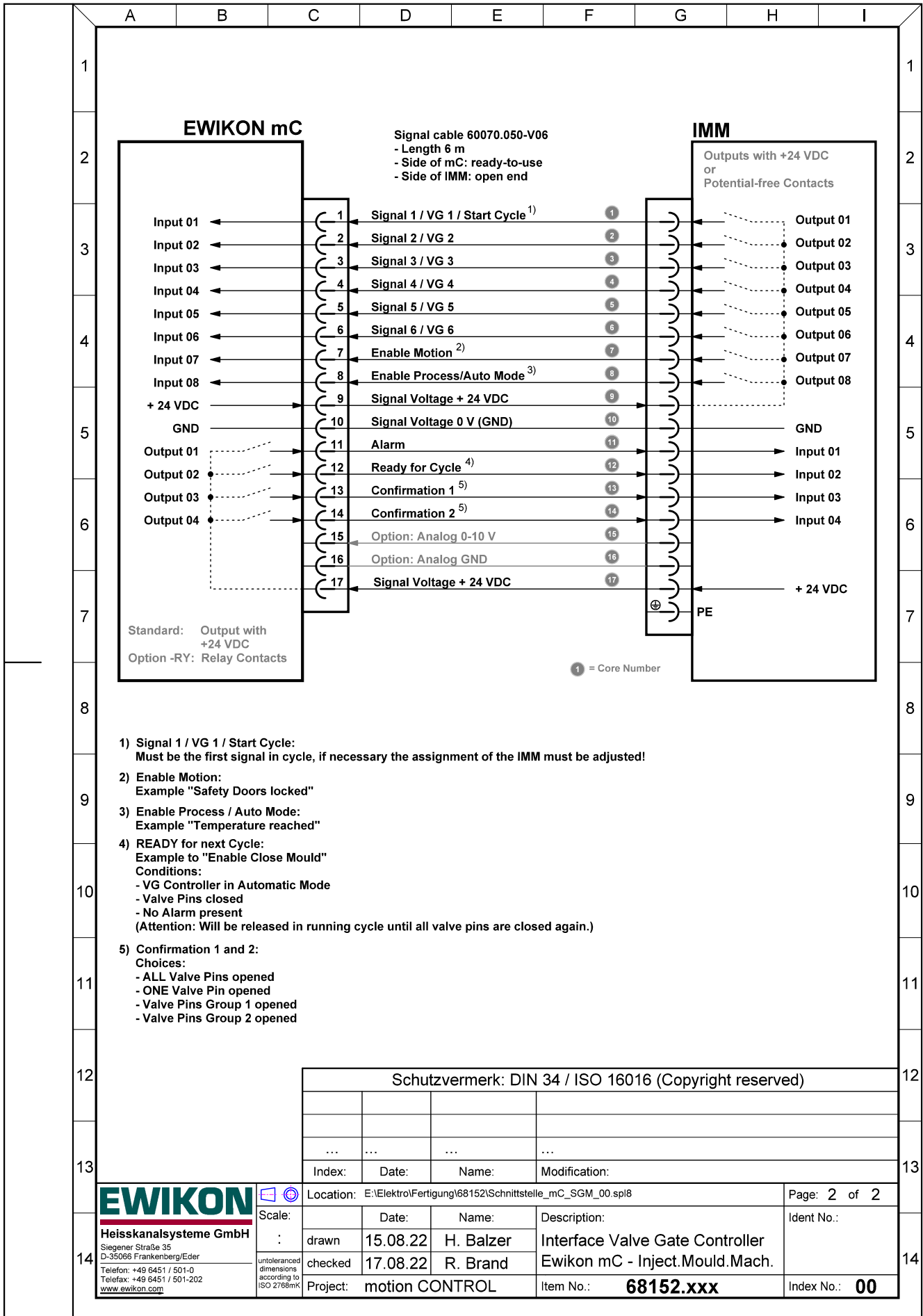
Contact / Core	Description	Use
1 / black 1	S 1 (+24 V)	Signal 1 input, start cycle
2 / black 2	S 2 (+24 V)	Signal 2 input
3 / black 3	S 3 (+24 V)	Signal 3 input
4 / black 4	S 4 (+24 V)	Signal 4 input
5 / black 5	S 5 (+24 V)	Signal 5 input
6 / black 6	S 6 (+24 V)	Signal 6 input
7 / black 7	S 7 (+24 V)	Signal 7 input, enable movement
8 / black 8	S 8 (+24 V)	Signal 8 input, enable process
9 / black 9	+24 V DC	Signal voltage +24 V
10 / black 10	GND	Ground
11 / black 11	Out 1(+24 V)	„Alarm“ output
12 / black 12	Out 2(+24 V)	„Ready for cycle“ output
13 / black 13	Out 3(+24 V)	„all OPEN“ output
14 / black 14	Out 4(+24 V)	„min. 1 OPEN“ output
15 / black 15	ANA 1	Analogue input (0-10 V) (Opt.AI)
16 / black 16	ANA 1 GND	Ground Analogue input (Opt.AI)
17 / black 17	EX. 24 V DC	External signal voltage

**Signal inputs 7 + 8 are not selectable for trigger signals, but are reserved for movement enabling and process enabling.**

Chart 18: Contact assignment of the 17-pin trigger connection (5)



Picture 10: 17-pin trigger connector (5)

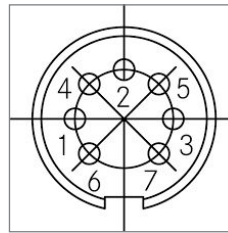


Picture 11: Interface valve gate EWIKON mC - injection moulding machine

## Analogue input 2 (Option AI)

Connect a signal for which the analogue value is in linear relation to the measured value directly to the input (contact 2), 0-10 V and ground (contact 3).

Contact	Use
1	free
2	Analogue input 2 (0-10 V)
3	Ground Analogue input 2
4	free
5	free
6	+24 V DC
7	GND DC



Picture 12:  
Analogue input 2

Chart 19: Contact assignment Analogue In 2

If further options are to be used, please contact EWIKON.

### 6.3.5 Connecting the *motion CONTROL SD* controller to the mould



#### CAUTION!

##### Only plug in currentless

Damage to the output modules may occur.

- Connection or disconnection of the drives may only be carried out when the controller is switched off. The drives are also supplied with power during standstill in order to generate the necessary retention forces.

##### Only switch on when the mould is heated up

Non-observance may result in damage to the tool.

- The servo control must not be switched on until the hot runner system or the cold runner mould has reached its set temperature and the plastic has completely melted (hot runner system). Before plugging in the mains plug or connecting the mains cable, it is essential to ensure that the supply voltage matches the data on the servo control's type plate.

The **motion CONTROL SD controller for single drives** is connected to the drives via the orange hybrid connection cable, item no. 63050.130 (3 m) or 63050.130-V06 (6 m). Other lengths are available on request. The hybrid connection cable is specially designed for this application due to its shielded construction and is ready to plug in at both ends.

Both the power supply and the temperature monitoring of the drive as well as the position feedback of the encoder system are carried out via the cable and the associated plug system.

The **motion CONTROL SD controllers for synchronous plate systems and pro EDGE VG** are connected via the orange motor connecting cable, item no. 63050.110-V03/V06 (3/6 m). The ready-to-use shielded cable is especially designed to suit this application. The position detection of the drive unit has to be connected to the **motion CONTROL SD** controller via the green resolver cable. Please use the cable 63050.120-V03/V06 (3/6 m) for this purpose.

## 6.4 Checks after assembly

- Check all connections for tight fit and correct assignment.
- Please use the „I/O Test“ menu to check whether the injection moulding machine is sending the required trigger signals.

## 7. Start up



### WARNING!

#### Insufficient protective conductor connection, Risk of injury due to moving parts

Risk of electric shock due to live parts

- When starting up the system the operator has to make sure that all electrically operated system components are connected to the protective conductor system of the injection moulding machine or are safeguarded by equivalent safety measures before applying any electric voltage. When applying electric voltage to systems or system components beyond their intended use the operator has to make sure that a sufficient protective conductor connection has been made or equivalent protective measures for each component have been taken.

Risk of severe injuries due to moving parts


- Keep hands away from the operating area of the drives during operation, otherwise cut injuries, bone fractures or crushing injuries of fingers and hands are possible. To prevent injuries disconnect the controller from the power supply (disconnect mains plug!) before carrying out any necessary work.

### 7.1 Basic settings and operation



Picture 13: Front view of the *motion CONTROL SD* controller

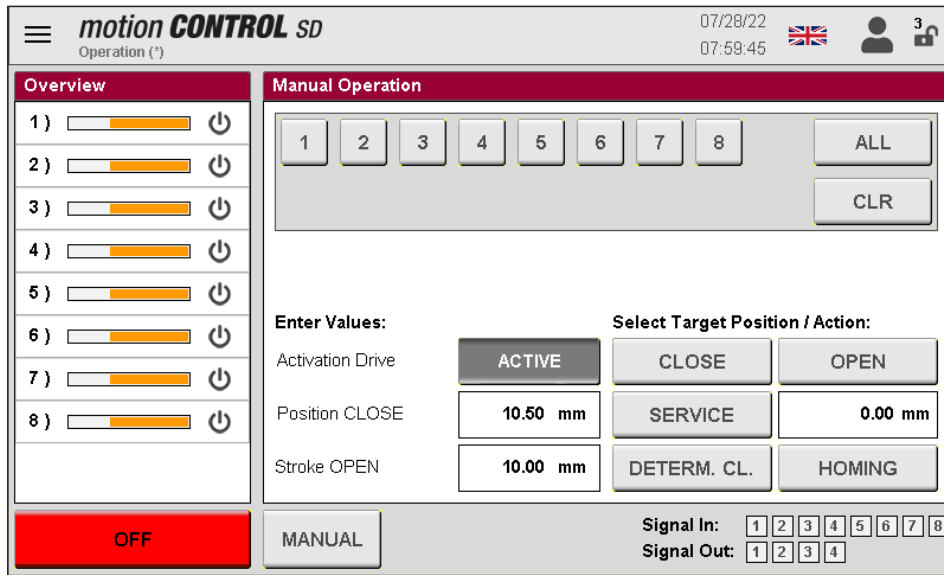
The *motion CONTROL SD* controller for the control of electrically operated valve gate systems by means of servo actuators is equipped with a colour touch-screen display via which all settings can be made.

After starting the system, the start page is displayed in manual mode, which provides access to operation via various icons. All other setting options can be reached via the menu button. 



## 7.2 Description of the menus

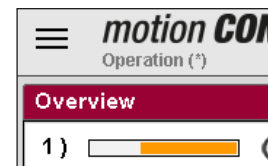
### 7.2.1 Start page



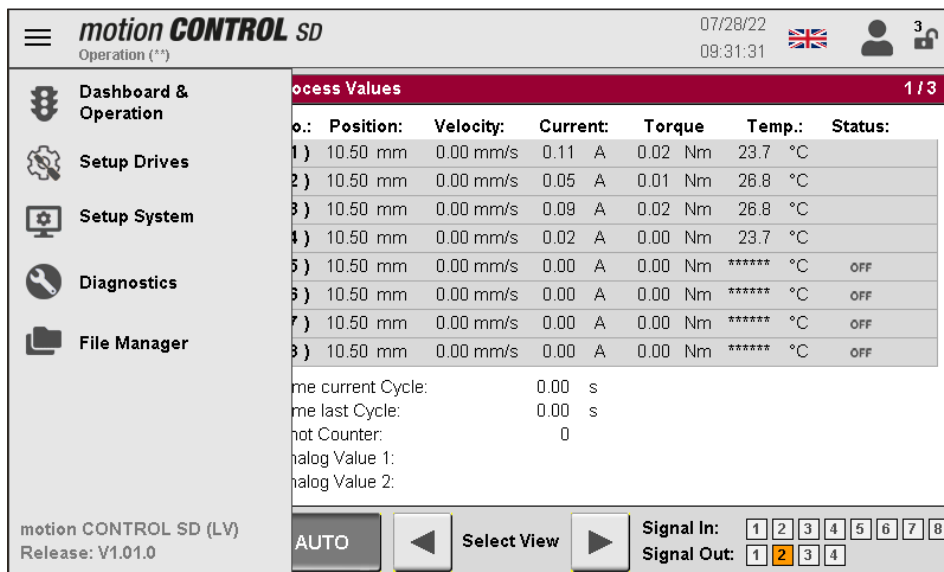
Picture 14: Start page of the *motion CONTROL SD* controller



The button in the lower right corner outside the screen (picture above) calls up the „I/O test“ function (see chapter „7.2.6.3 I/O Test“).



The menu selection is made via the hamburger menu at the top left.



Picture 15: Process values with menu open

#### Menu selection:

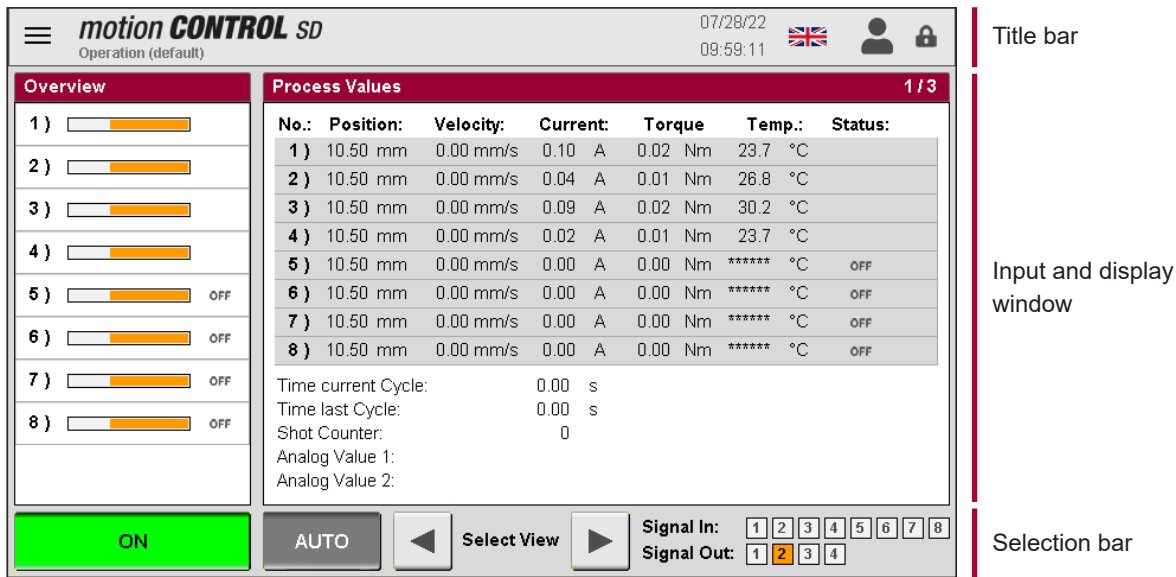
- Dashboard & Operation
- Setup Drives
- Setup System
- Diagnostics
- File Manager

The menu options are opened by touching the corresponding symbol on the screen.

**The unit can also be operated remotely via a separate operating terminal (PC, laptop or tablet with VNC client) by means of a VNC connection.**

The individual menus are described on the following pages.

7.2.2 Screen layout



Picture 16: Screen layout of the *motion CONTROL SD* controller

Title bar

Menu selection                      Area for additional information                      Language selection (DE / EN / IT / PL)



Name of the currently selected menu, the selected recipe file in brackets (\*, = Changes to settings have not yet been saved)

Date and time / Touch function „Screenshot“

Log-in: Opens a window for entering the password in order to access a higher operating level. The operating level is indicated by an open lock with the number of the access level next to it.


Possible additional information in the title bar

	Process/temperature enable is not available.
	Process release for manual operation only.
	Process/temperature release is provided.
	Release signal is no longer present, the elapsing timer signals the time until the process release is reset.
	Ongoing output of requested data.
	Ongoing storage process on the internal drive or an available USB stick.

	The screen symbol flashes when a screenshot is taken and saved. The current display is saved as a file on the internal drive and an available USB stick.
	A USB stick is available and has been correctly recognised.
	There is a warning or malfunction. Touch function: Opens the current alarms.

## Selection bar (in the „Dashboard & Operation“ menu)

Selection of the operating mode „AUTO“ / „MANUAL“



Power supply drives „ON“ / „OFF“

In automatic mode, selection of the view by using the arrow keys

- Process values in a table
- Diagram with comparative values of up to 8 drives plus optional analogue signals
- Diagram with details (position, speed, current, torque) of a drive plus optional analogue signals

Information about the digital input and output status

Signal inputs (Signal In):

- Input 1 is the main trigger for starting a cycle.
- Inputs 2-6 can be used freely to trigger various events.
- Inputs 7 and 8 cannot be selected for triggering, but are reserved for movement and process release.

Signal outputs (Signal Out):

- Output 1 indicates an alarm in the *motion CONTROL SD* system to the injection moulding machine.
- Output 2 is configurable in the menu „Setup System & Device; General“ if required (by default to „READY for next Cycle“) and is usually used to enable the machine.
- Output 3 is configurable in the menu „Setup System & Device; General“ if required (by default set to „All valve pins OPEN“).
- Output 4 is configurable in the menu „Setup System & Device; General“ if required (by default set to „One valve pin OPEN“).

Active input or output signals are indicated by an orange flash of the square assigned to them.






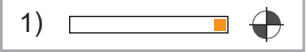





In the other menus, the display of the selection bar changes; here, the desired submenu for display or input is called up via the adapted buttons.

### 7.2.3 Operation

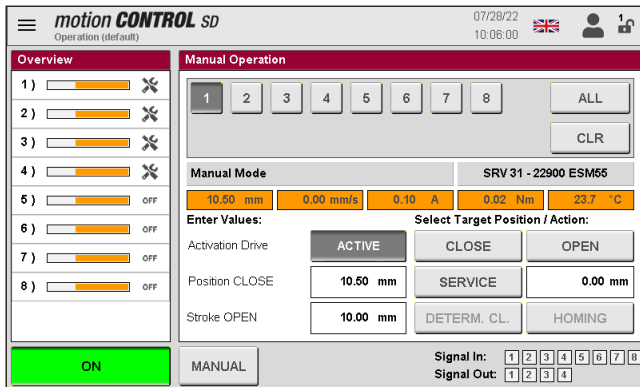
In the „Overview“ window, the actual position of each drive is displayed via orange bars, the display is scaled to the maximum stroke of the selected drive.

- Bar on the right = needle in rear position (OPEN)
- Bar left = needle in forward position (CLOSED)

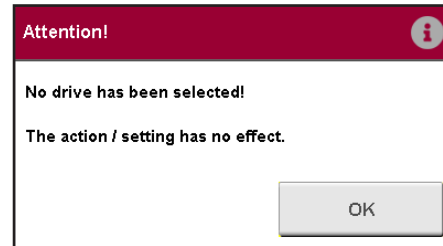
**Symbols used in the process display and their meaning:**

1)  = Drive inactive (switched off)	1)  = Reference run forward
1)  = Drive on standby	1)  = Reference run to the back
1)  = Initialisation	1)  = Not referenced (flashing)
1)  = Regular operation	1)  = Drive has a warning
1)  = Drive moves into parking position	1)  = Alarm
1)  = Drive in manual operation	

### 7.2.3.1 Manual operation



Picture 17: View „Manual Operation“



If no drive is selected,  
the above window appears

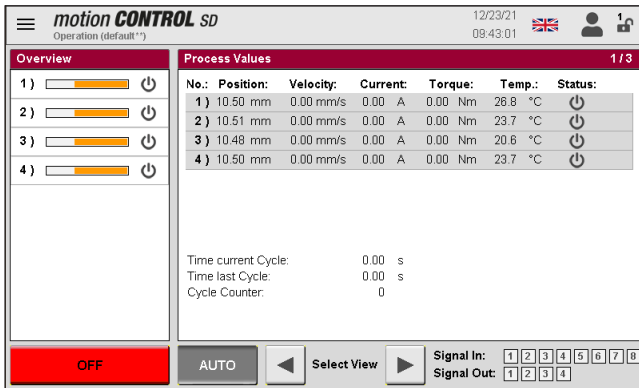
View when the „Manual“ operating mode is selected. The desired drive is selected via the numbered buttons in the input and display window. Alternatively, all drives can be selected („ALL“) or the selection can be deleted („CLR“).

All drives can be switched **<ACTIVE>** or **<INACTIVE>**. The current values of the drive when the system is switched on are shown in the orange fields.

Further information and buttons:

<b>Value for Position CLOSED</b>	Desired position „CLOSED“ of the valve pin (gate closed)
<b>Stroke OPEN</b>	Desired stroke of the valve pin
<b>CLOSE button</b>	The selected drive moves to the set position „CLOSED“
<b>OPEN button</b>	The selected drive moves to the set position „OPEN“
<b>SERVICE button</b>	The selected drive moves to the set position „SERVICE“
<b>Input field for a freely definable position</b>	The selected drive moves to the entered position when the numerical value has been confirmed.
<b>HOMING button</b>	The selected drive performs a reference run (zero point determination of the measuring system).
<b>DETERMINE CLOSE (DETERM. CL.) button</b>	The selected drive first performs a reference run (rear stop) and then determines the front mechanical stop. This position is then set as the value for "Position CLOSED". This function is only carried out for drives for which one of the COOLSHOT function types has been selected.

### 7.2.3.2 Automatic operation



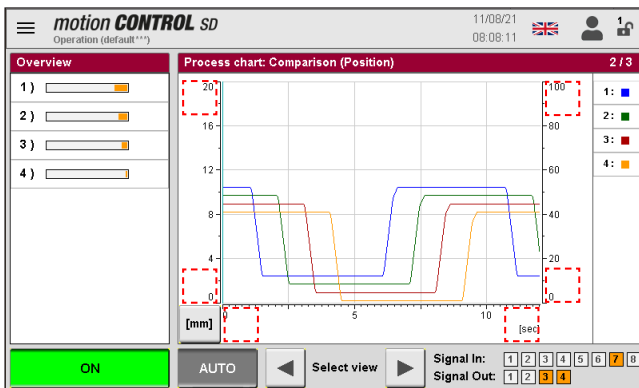
Picture 18: View „Process Values“

View when the operating mode „AUTO“ is selected. In the „Process Values“ window, the most important values of the drives are displayed in a table:

- Position
- Speed during movement
- Current (when the control is switched on, low currents are always shown here; these are needed to keep the drive in position)
- Torque
- Temperature of the drive
- Status of the drive

#### Process diagrams:

By using the arrow keys in the selection bar, one can switch between the views „Process Values“, „Process Chart: Comparison“ and „Process Chart: Details Drive no.xx“. The scaling of the 4 axes (2x analogue, position / current / torque and time) can be adjusted by touching the upper / lower end of the scale (6 hidden buttons ). Furthermore, graphs can be hidden for the next recording for a better overview.



Picture 19: View „Process Chart: Comparison (Position)“

In the view „Process Chart: Comparison“, the values of the drives are displayed in different colours.

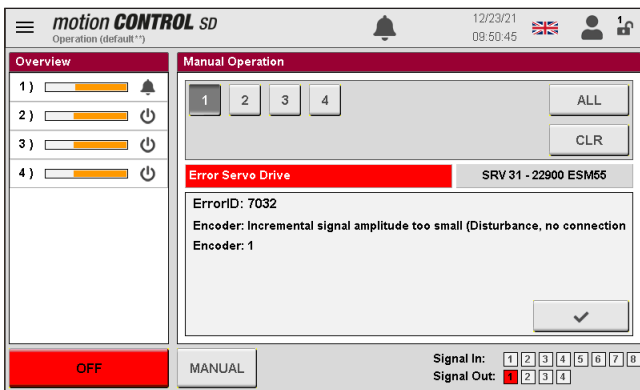
Here it is possible to switch between the values for position, speed, motor current and torque of the drives in order to compare the graphs and values with each other.

The toggle button simultaneously displays the unit of the physical quantity in the lower left corner.

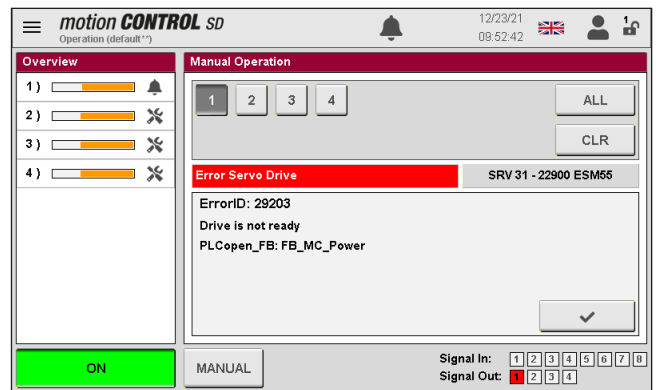
In the detailed view, the position profile, the speed, the current, the torque and the measured value at the analogue inputs of the **motion CONTROL SD** controller are displayed separately for one drive. By touching the bar of the respective drive in the overview, the view is switched between the drives.

Recording starts automatically with each cycle start (signal 1 = 24 V) of the **motion CONTROL SD** controller and ends when the end of the time scale is reached.

### 7.2.3.3 Error messages of the servo controller



Picture 20: Servo controller error message; no connection to the drive



Picture 21: Servo controller error message; positioning error

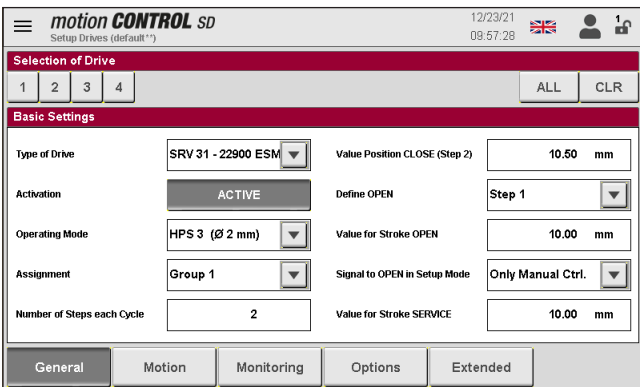
In „Manual“ mode, error messages from the servo controller are displayed in the individual view with error ID and description. The errors must be acknowledged via the confirmation button (grey tick) when the drive is switched on. As a rule, 2 - 3 related error messages occur. The drive can then be switched inactive and reactivated after the cause of the fault has been eliminated. It is recommended to carry out a reference run of the drive.

### 7.2.4 Configuration of drives

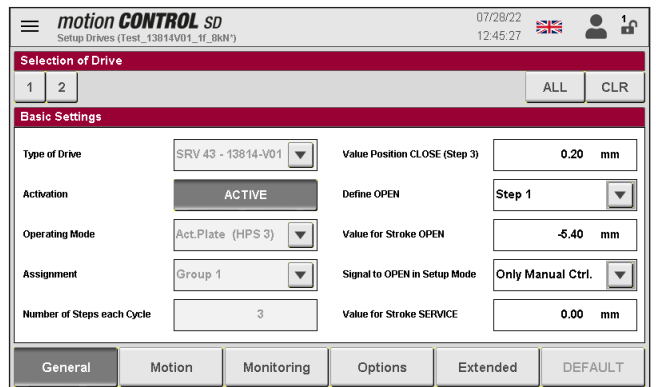
In the selection bar it is possible to navigate through the settings. In the „Selection of drives“ bar, all drives whose settings are to be changed are selected. „All“ is also possible. In this case, changes made are applied to all drives.

Changes to most settings are only possible after entering a higher access level (see chapter „7.2.5.2 Display & View“).

#### 7.2.4.1 General (basic settings)



Picture 22: View „Configuration of drives – Basic Settings“ / *motion CONTROL SD* for single drives“



Picture 23: View „Configuration of drives – Basic Settings“ / *motion CONTROL SD* for synchronous plate systems“

**ATTENTION:** The settings for „Type of Drive“, „Operating Mode“, „Assignment“, and „Number of Steps each Cycle“ can only be made when the motors are switched off. Some selection options can only be set in the individual selection, others only in the „All“ selection (field greyed out = not available).

<b>Type of Drive</b>	The drive to be controlled is selected here using the item number. The possible selection depends on the controller
<b>Activation</b>	Specifies whether the drive should participate in the movement profile or not
<b>Operating Mode</b>	Selection of the drive's operating mode, depending on the selected drive type. This adjusts the default settings for the operation of the application (see table below):

### motion CONTROL SD for single drives

Operating mode	Default settings
<b>HPS 3 (Ø 1.5 mm)</b> HPS III systems with valve pin diameter 1.5 / 1.7 mm	Value Position CLOSE: 10.5 mm Value for Stroke OPEN: 10.0 mm Torque limitation: 0.28 Nm / approx. 520 N Function Drive OFF: Directly OFF
<b>HPS 3 (Ø 2 mm)</b> HPS III systems with valve pin diameter 2.0 / 2.2 mm	Value Position CLOSE: 10.5 mm Value for Stroke OPEN: 10.0 mm Torque limitation: 0.46 Nm / approx. 860 N Function Drive OFF: Directly OFF
<b>HPS 3 (Ø 3 mm)</b> HPS III systems with valve pin diameter 3.0 / 3.2 mm	Value Position CLOSE: 10.5 mm Value for Stroke OPEN: 10.0 mm Torque limitation: 0.92 Nm / approx. 1720 N Function Drive OFF: Directly OFF
<b>HPS 3 (Ø 4 mm)</b> HPS III systems with valve pin diameter 4.0 / 4.2 mm	Value Position CLOSE: 15.5 mm Value for Stroke OPEN: 15.0 mm Torque limitation: 1.38 Nm / approx. 2580 N Function Drive OFF: Directly OFF
<b>COOLSHOT (LSR)</b> COOLSHOT systems for Liquid Silicone processing	Value Position CLOSE: 10.5 mm Value for Stroke OPEN: 3.0 mm Torque limitation: 0.46 Nm / approx. 860 N Function Drive OFF: Move to SERVICE position, then OFF
<b>COOLSHOT (HTV)</b> COOLSHOT systems for Solid Silicone processing	Value Position CLOSE: 10.5 mm Value for Stroke OPEN: 5.0 mm Torque limitation: 0.92 Nm / approx. 1720 N Function Drive OFF: Move to SERVICE position, then OFF

### motion CONTROL SD for synchronous plate systems

Operating mode	Default settings
<b>Act. Plate (HPS 3)</b> Synchronous plate system for hot runner with HPS III standard nozzles	Value Position CLOSE: 6.5 mm Value for Stroke OPEN: 6.0 mm Torque limitation: motorabhängig Function Drive OFF: Directly OFF
<b>Act. Plate (MH 100)</b> Synchronous plate system for hot runner with MH100 nozzles	Value Position CLOSE: 7.5 mm Value for Stroke OPEN: 3.0 mm Torque limitation: motorabhängig Function Drive OFF: Directly OFF
<b>Act. Plate (MH 200)</b> Synchronous plate system for hot runner with MH200 nozzles	Value Position CLOSE: 10.5 mm Value for Stroke OPEN: 5.0 mm Torque limitation: motorabhängig Function Drive OFF: Directly OFF

### motion CONTROL SD for pro EDGE VG

Operating mode	Default settings
<b>pro EDGE VG</b> pro EDGE VG side valve gate systems	Value Position CLOSE: 2.6 mm Value for Stroke OPEN: 2.5 mm Torque limitation: 2.5 Nm / ca. 2920 N Function Drive OFF: Directly OFF



<b>Assignment</b>	Here, for hot runner systems with 2 components or combined systems hot runner/cold runner, each drive can be assigned to one of the two groups
<b>Number of Steps each Cycle</b>	Number of movements per cycle (2-6)
<b>Value Position CLOSED (assignment of steps)</b>	Setting the „CLOSED“ position [mm] (gate closed)
<b>Define OPEN</b>	Determines which step in the movement sequence is the „OPEN“ position (gate open). This is required for manual operation
<b>Value for Stroke OPEN</b>	Defining stroke [mm] for valve pin movement to „OPEN“ position
<b>Signal to OPEN in Setup mode</b>	Determines whether in manual operation the valve pins are actuated only via the button or also via signals from the injection moulding machine
<b>Value for Stroke SERVICE</b>	Defining stroke [mm] for valve pin movement to „MAINTENANCE“ position

### 7.2.4.2 Motion (Motion profile setting)

Position	Velocity	Trigger	Level	Value	Delay	Offset CO	Velocity CO	
1	0.50 mm	20.0 mm/s	signal 1	24V	0.0 mm	0.00 s	0.00 mm	5.0 mm/s
2	10.50 mm	20.0 mm/s	signal 2	24V	0.0 mm	0.00 s	1.00 mm	5.0 mm/s
3	10.50 mm	20.0 mm/s	signal 3	24V	0.0 mm	0.00 s	0.00 mm	5.0 mm/s
4	10.50 mm	20.0 mm/s	signal 4	24V	0.0 mm	0.00 s	0.00 mm	5.0 mm/s
5	10.50 mm	20.0 mm/s	signal 5	24V	0.0 mm	0.00 s	0.00 mm	5.0 mm/s
6	10.50 mm	20.0 mm/s	signal 1	0V	0.0 mm	0.00 s	0.00 mm	5.0 mm/s

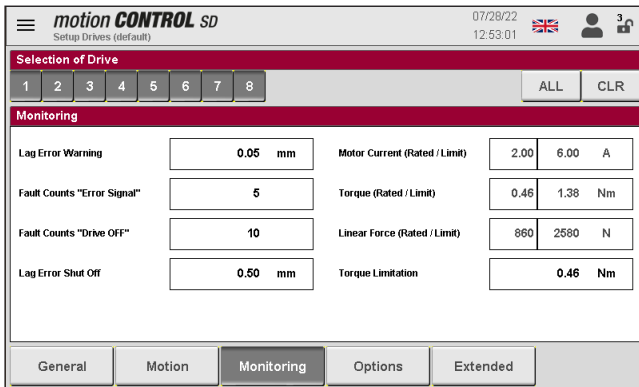
Picture 24: View „Configuration of drives – Motion Profile“

The settings for the trigger events can be entered here. The number of steps displayed depends on the setting „Selection of steps per cycle“.

The following parameters can be set or selected for each step:

<b>Position</b>	Numerical value of the target position in mm. In the example, step 1 is not adjustable (= position „OPEN“), as this value is calculated via the set stroke (see chapter „7.2.4.1 General (basic settings)“)
<b>Velocity</b>	Speed at which the target position is to be reached
<b>Trigger</b>	Trigger source for this step, digital or an optional analogue signal
<b>Level / Value</b>	Depending on the selected trigger source, either the signal level „24 V“, „0 V“ or the comparison value applies
<b>Delay</b>	A delay time can be added to each trigger event, resulting in a time-delayed reaction of the drives
<b>Offset CO / Velocity CO</b>	In addition, a switch-over point can be defined from which the speed is reduced to the set value. This can be used, for example, to reduce wear caused by rapid valve pin movement in the gate area. (access level 2 required)

### 7.2.4.3 Monitoring



Picture 25: View „Configuration of drives – Monitoring“

**Attention! All settings on this page are only possible when the drives are switched off!**

#### Lag Error Warning

Maximum deviation from ACTUAL / NOMINAL during the movement until a warning is issued.

#### Fault Counts „Error Signal“

Number of lag errors in a row after which an error is reported to the injection moulding machine

#### Fault Counts „Drive OFF“

Number of lag errors in a row after which a drive is switched off to avoid damage.

#### Lag Error Shut Off

Maximum deviation from ACTUAL / NOMINAL during the movement that causes a direct shutdown of the drive.

#### Motor Current

Nominal current and maximum value of the selected drive

#### Torque

Nominal torque and maximum value of the selected drive

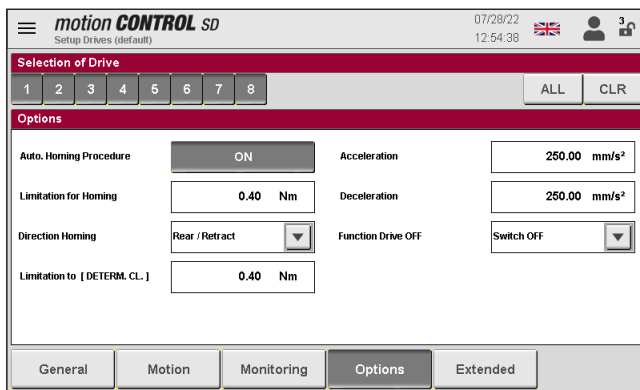
#### Linear Force

Nominal force and maximum value of the selected drive

#### Torque Limitation

The power of the drive can be limited by this value to avoid damage to the drive or the mechanics

### 7.2.4.4 Options (Optional settings)

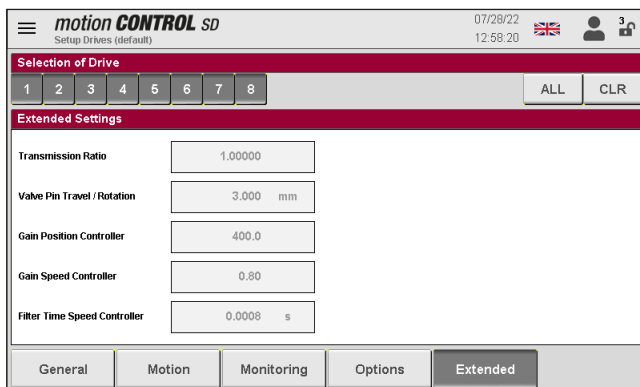


Picture 26: View „Configuration of drives – Options“

**Attention! All settings on this page are only possible when the drives are switched off!**

<b>Automatic Homing Procedure</b>	Determines whether the drives perform a reference run every time the unit is switched on (required if, for example, displacements in position can occur when the unit is switched off). <ON/OFF>
<b>Limit value for Homing</b>	Value that must be exceeded to recognise the mechanical rear stop
<b>Direction Homing</b>	Determines in which direction the reference run is carried out.
<b>Limit value for „DETERMINE CLOSE“</b>	Limit value that must be exceeded to identify the front mechanical stop (only for COOLSHOT systems).
<b>Acceleration</b>	Value at which the drive reaches its setpoint speed [mm/s <sup>2</sup> ]
<b>Deceleration</b>	Value at which the drive comes to a standstill [mm/s <sup>2</sup> ]. These values depend on the selected drive.
<b>Function Drive OFF</b>	Selectable „directly off“ or „move to service position and then off“

### 7.2.4.5 Extended (Extended settings)



Picture 27: View „Configuration of drives – Extended Settings“

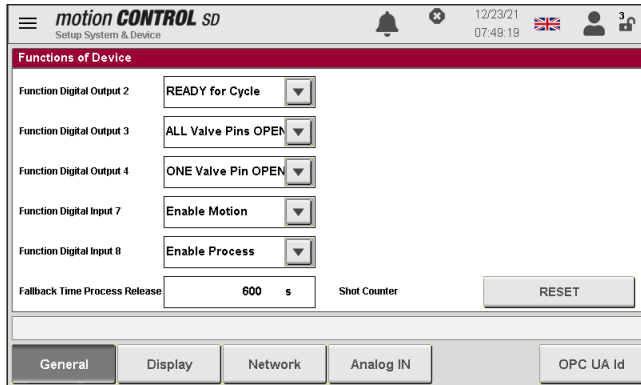
**Changes to these settings can have a serious effect on the driving behaviour of the drive and the actuated mechanics and may therefore only be carried out by EWIKON specialised personnel.**

## 7.2.5 Setup System & Device

In the selection bar it is possible to navigate through the settings.

Changes to most settings are only possible after entering a higher access level (see chapter „7.2.5.2 Display & View“).

### 7.2.5.1 General



Picture 28: View „Setup System & Device – Functions of Device“

#### Function Digital Output 2, 3 and 4

Selection of the function of the digital outputs for adaptation to the process:

- „Ready for Cycle“ condition: Unit is in automatic mode, all active valve pins are closed and there is no error
- „All Valve Pins OPEN“ condition: all active valve pins open
- „min. 1 Valve Pin OPEN“ condition: at least 1 valve pin open
- „Group 1/2 OPEN“ condition: all active valve pins of the selected group open

#### Function Digital Input 7

- **„No use“**. The input is not used by the controller, the enable for the movement of the drives is always set
- **„Enable movement“**. Movement of the drives is only possible if a +24 V DC signal is present at input 7. Without the enable, e.g. safety door closed and hot runner system or cold runner mould at temperature, the drives can no longer be operated. Any movements that are still active are completed to prevent undefined intermediate positions. After that, any further movement is blocked

#### Function Digital Input 8

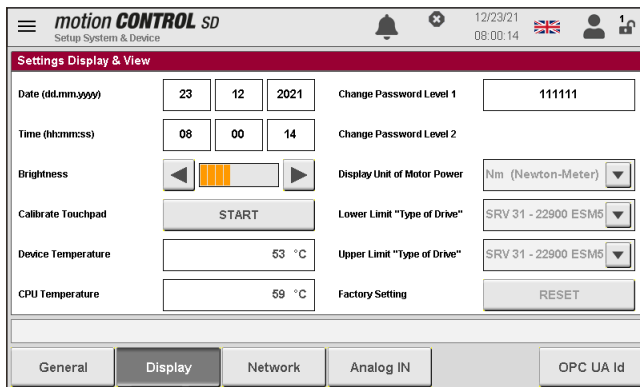
- **„No use“**. The input is not used by the controller, the release for the production process is always set.
- **„Enable process“**. The input is used here to indicate to the controller the readiness of the system, e.g. „Heating ON“ or „Temperature reached“, for the production process. If there is no process enable, the movement of the drives can only be enabled for manual operation. At least access level 1 is required for this. After resetting the access level (5 minutes without entry on the display), the drive enable for manual operation is also reset. If enable is present (+24 V DC at input 8), the operator must still manually confirm readiness for production, after which the controller is enabled for all operating modes (automatic / manual). If the process enable is reset during operation, the set fallback time still remains during which the drives can continue to be moved. If the enable signal is set again during this time, production can continue without interruption. Otherwise, the drives are moved to the SERVICE or CLOSED position after the time has elapsed (depending on the setting for „Drives OFF function“) and further operation is blocked.

**Fallback Time Process Release** Input in seconds for disengaging time

#### Shot Counter

Pressing the „RESET“ button resets the shot counter to zero

### 7.2.5.2 Display & View



Picture 29: View „Setup System & Device – Display & View“

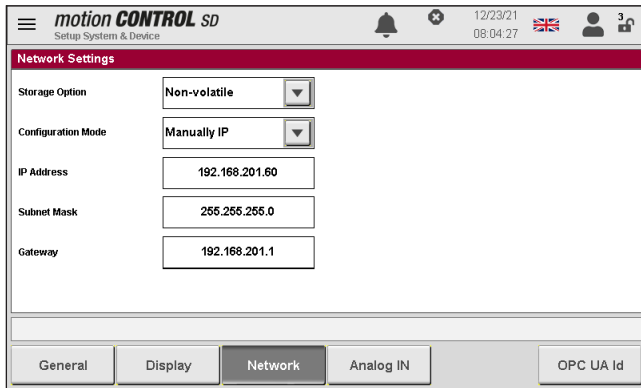
In diesem Menü können folgende Einstellungen vorgenommen werden:

<b>Date</b>	Setting the date
<b>Time</b>	Setting the time
<b>Brightness</b>	Setting the display brightness
<b>Calibrate Touchpad</b>	If the touch screen no longer responds correctly to inputs, there is the possibility of calibration
<b>Device Temperature</b>	Display of the device temperature
<b>CPU Temperature</b>	Display of the CPU temperature
<b>Change Keyword</b>	Change of passwords for level 1+2. They are always activated in the corresponding level.
<b>Display Unit Motor Power</b>	Switching between torque and linear force
<b>Lower Limit „Type of Drive“</b>	For the selection list „Type of Drive“ (depending on controller) in the menu „Configuration of Drives - General“, a lower limit can be set here to limit the selection
<b>Upper Limit „Type of Drive“</b>	Sets the upper limit for the „Type of Drive“ selection list (depending on controller).
<b>Factory Setting</b>	Pressing the „RESET“ button resets the control unit to the delivery status at the next start, saved recipes are not lost.

All settings remain saved in the device even after it is switched off.

The date and time continue to run via a gold foil capacitor. However, this can be completely discharged after a longer standstill of the controller. In this case, the date and time must be reset.

### 7.2.5.3 Network

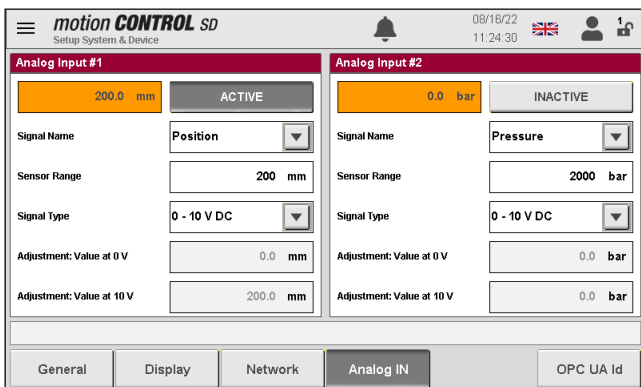


Picture 30: View „Setup System & Device – Network“

If the device is to be integrated into a network, the necessary network settings can be made here. Application examples are access via OPC UA or remote control of the device via VNC (only for 68152.XXX via port :5900) or web browser (only 68162.XXX via port :8085).

For devices of type 68162.XXX, the network parameters are set in a different way. Please contact EWIKON.

### 7.2.5.4 Analog IN



Picture 31: View „Setup System & Device – Analog IN“

Adjustment of analogue inputs 1 and 2 (optionally available) to the application. Each input must be switched „ACTIVE“ for use:

**Signal name (changes the unit of the analogue value)**

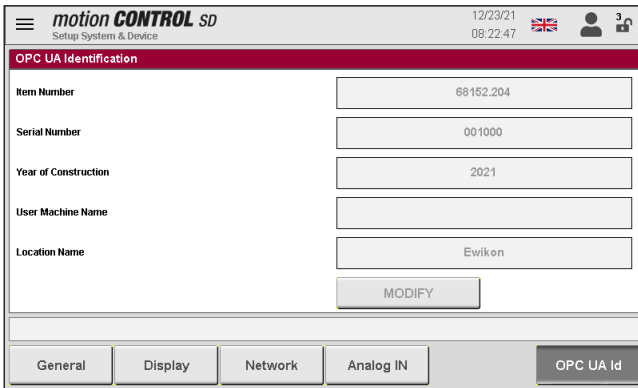
- „Position“ [mm]
- „Volume“ [ccm]
- „Pressure“ [bar]
- „Force“ [N]
- „Voltage“ [V]

**Sensor range** The measuring range of the sensors is entered as a numerical value

**Signal type (type of sensor):** Signal 0-10 V DC

**Adjustment** The settings may require an adjustment of the sensor. If necessary, the measured values of the controller can be scaled to the machine values. For this purpose, an adjustment is carried out at the beginning and end of the selected sensor measuring range. (Access level 2 required)

### 7.2.5.5 OPC UA Id

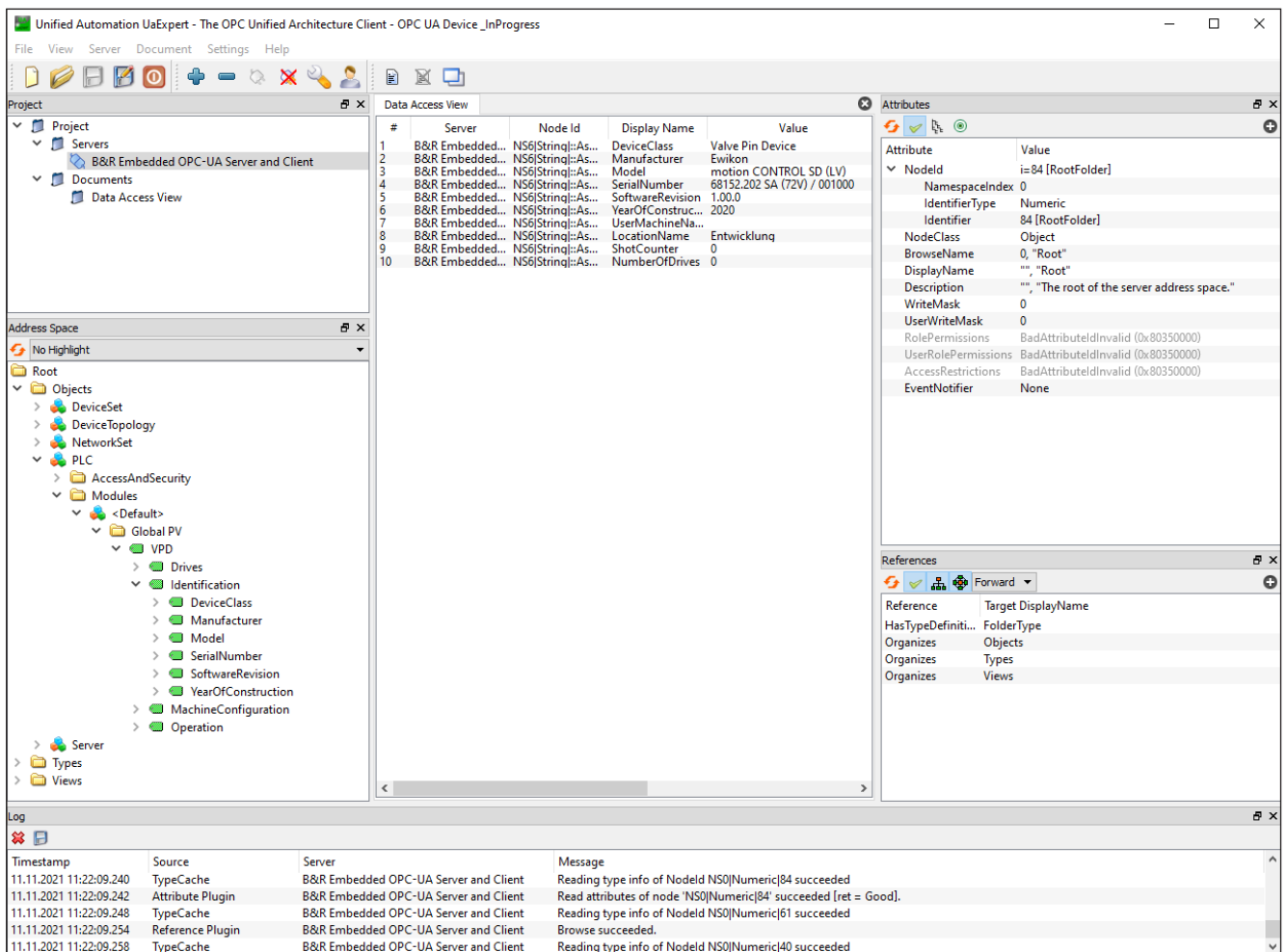


Picture 32: View „Setup System & Device – OPC UA Id“

The settings for item no., serial no. and year of manufacture can only be made by EWIKON and are set during production.

The device designation and the place of use can also be set by the customer via OPC UA access, e.g. via UA-Expert.

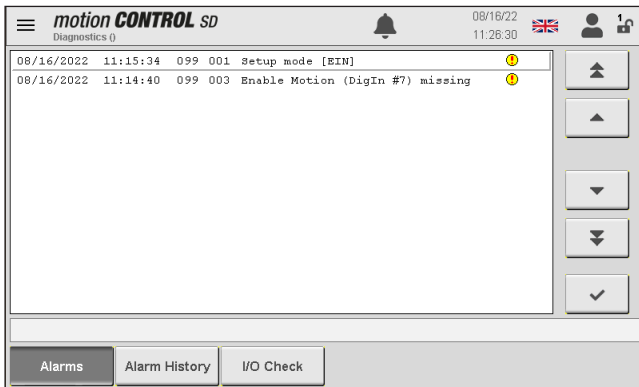
This information is used to identify the device when it is accessed via OPC UA. The data structure is shown in the following figure:



Picture 33: OPC UA data structure. Example for type 68152.XXX.

## 7.2.6 Diagnosis and troubleshooting

### 7.2.6.1 Alarms



Picture 34: View „Diagnosis and troubleshooting – Alarms“

Detailed view of the current alarms with date, time, output, alarm type and alarm text for more detailed analysis.

The arrow keys on the right edge can be used to scroll through the view.

Acknowledgement of an error is done via the confirmation button (grey tick).

### 7.2.6.2 Alarm history



Picture 35: View „Diagnosis and troubleshooting – Alarm history“

Output of the last 250 events of the alarm history.

#### Saving the list as a file on the device:

Press the printer symbol to the right of the list. It appears:

- Read alarm history of the application...
- Save to internal drive...
- Done!

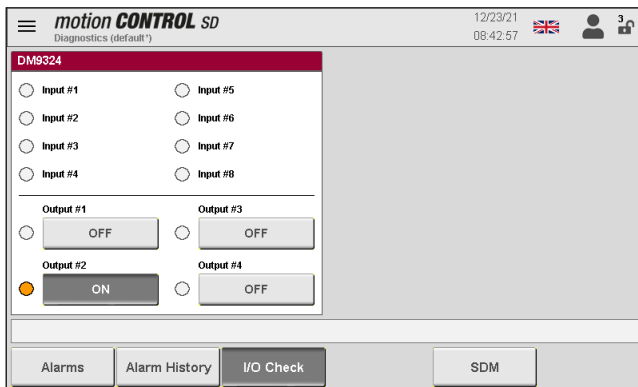
This process may take some time depending on the length of the list.

The file „Alarmlist.csv“ is created under (F:)/Alarms and can be evaluated with a chart program.

If a USB stick is connected, the alarm list is also copied to the stick in the corresponding directory. (see also chapter „7.2.7 File management“).



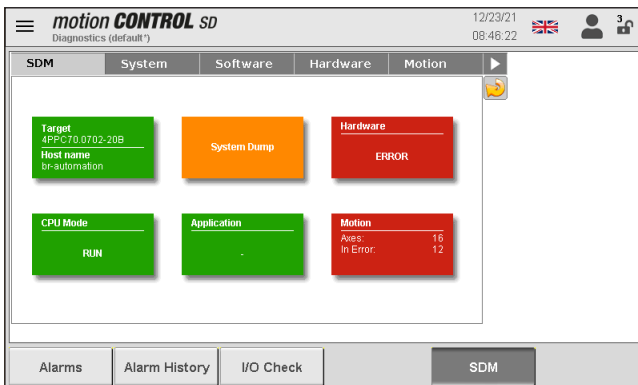
### 7.2.6.3 I/O Test



Picture 36: View „Diagnosis and troubleshooting – I/O-Test“

This menu allows to test the signal communication of the controller with the machine. Access level 2 is required to set the outputs.

### 7.2.6.4 System Diagnostics Manager (SDM)

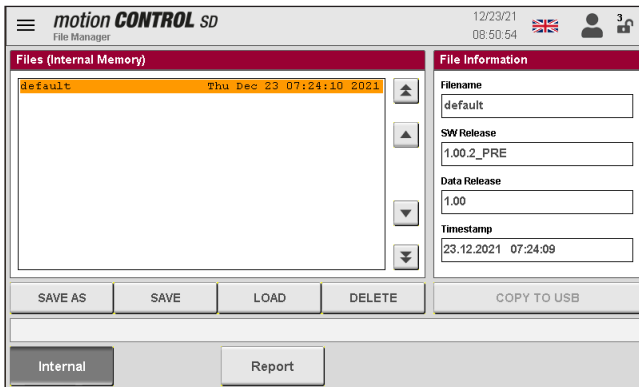


Picture 37: View „Diagnosis and troubleshooting – System Diagnostics Manager“

This menu is used by EWIKON for internal analyses during troubleshooting and is only released from access level 2.

## 7.2.7 File management

### 7.2.7.1 Internal



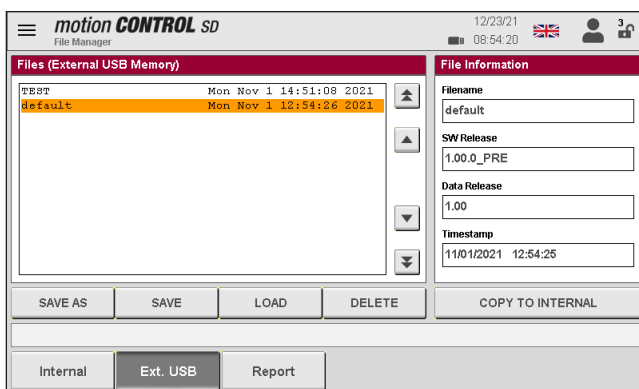
Picture 38: View „File management – Internal Memory“

This menu allows the settings for up to 50 different tools to be saved in the internal memory or loaded from there (drive (F:) in the device memory). The folder „Backup“ as well as alarm lists, screenshots and record files can be present on this drive.

<b>SAVE AS</b>	Saves new mould settings after entering the file name
<b>SAVE</b>	Applies changes by overwriting the selected old file
<b>LOAD</b>	Loads the settings of the selected file into memory for execution
<b>DELETE</b>	Deletes the selected recipe file
<b>Save / Load / Delete</b>	To save, load or delete (access level 1) saved settings, a file must be selected using the arrow keys (it appears with an orange background). The selected operation must be confirmed by acknowledging a confirmation prompt.
<b>COPY TO USB</b>	Copies the selected file to the external memory when a USB stick is connected (see chapter „7.2.7.2 External USB“).

Created mould files are stored in the folder „Backup“, at the same time a „filename.html“ is stored in the subfolder „Print“. This file makes it possible to view and print the saved values with a web browser if required. Successful saving is displayed in the info line.

### 7.2.7.2 External USB

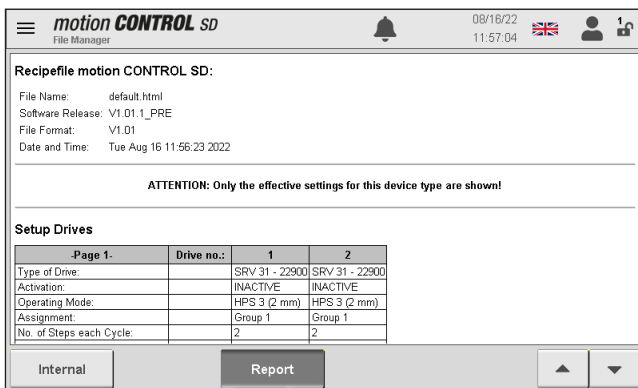


Picture 39: View „File management – External USB“

This menu enables data exchange with an external USB stick. It can only be selected when a stick has been connected to the device and the symbol in the title bar indicates availability.

When copying a file to the USB stick for the first time, the device creates the folder „Backup“ in the directory „motion CONTROL SD“ on the USB stick and saves the selected file there. The html file mentioned above under „Internal memory“ is also copied to the „Print“ subfolder.

## 7.2.7.3 Report



Picture 40: View „File management – Report“

The currently effective settings in the device are displayed here in an overview. Use the arrow keys to scroll through the menu.

To display saved recipes, the corresponding recipe file must be loaded.

**Attention, the current settings will be lost, they must be saved beforehand!**

Access to the system memory is also possible with an FTP client programme via the RJ45 connection in conjunction with an Ethernet cable on a computer network (please ask EWIKON for terminal settings and access data).

## 7.3 Help in case of malfunctions

### 7.3.1 Troubleshooting

Malfunction	Measure
Display remains dark / device cannot be switched on	<ul style="list-style-type: none"> <li>Check mains voltage and device fuse in the device</li> <li>Check 24 V DC power supply in the device</li> </ul>
Drive error	<ul style="list-style-type: none"> <li>Check if all connections are properly connected</li> <li>Check all settings (torque, speed, acceleration,...) for values suitable to the application</li> </ul>
Positioning error	<ul style="list-style-type: none"> <li>Check that the drive can move freely</li> </ul>
Emergency stop actuated, no release and no signal connection from and to the injection moulding machine	<ul style="list-style-type: none"> <li>Check the fuse in the PD2113 module as follows:               <ol style="list-style-type: none"> <li>Open the unit</li> <li>Pull out the fuse cover with the fuse on the right-hand side of the module with a screwdriver</li> <li>Slide the round fuse out of the guide and insert a new fuse (item no. 10516).</li> </ol> </li> </ul>

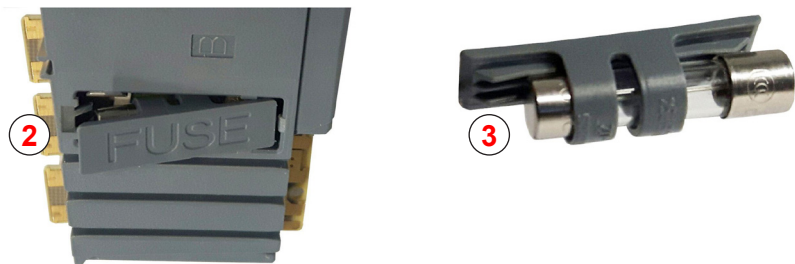


Chart 20: Malfunctions / Measures

### 7.3.2 Spare parts list

<b><i>motion CONTROL SD for single drives and pro EDGE VG</i></b>	
<b>Item no.</b>	<b>Description</b>
18305	Acopos micro drive module (orange), 2-zone for 68152.XXX
18300	Display PPC70 for 68152.XXX
18500 + 18501	CPU with 7" display and license for 68162.XXX
18503	Servo controller 1-zone, 5 A / 10 A, 24 - 48 V DC for 68162.202 / .204 / .208 / .218
18504	Servo controller 1-zone, 5 A / 10 A, 72 V DC for 68162.271 / 68162.272
18461	Switching power supply 72 V / 960 W
18311	Switching power supply 36 V / 480 W
18217	Fan
18218	Fan cover
18233	Filter mat 60 x 60 mm (fan cover)
18346	Filter pad (base)
18121	Fuse 6.3 A (F) 6.3 x 32 mm (unit fuse)
10516	Fuse 6.3 A (M) 5 x 20 mm (in module X20PD2113)
<b><i>motion CONTROL SD for synchronous plate systems</i></b>	
<b>Item no.</b>	<b>Description</b>
18301	Acopos P3 drive module, addressed
18343	Acopos P3 plug-in module, resolver interface
18300	Display PPC70
10668	Fan
18342	Mains filter
18346	Filter pad (bottom)
10516	Fuse 6.3 A (M) 5 x 20 mm (in module X20PD2113)

Chart 21: Spare parts list

### 7.3.3 EWIKON service departments

For service enquiries, please always have the article number and the current software version of the present device (OPC UA Id) as well as the order number (also that of the hot or cold runner system) ready!

- **Service Control Technology / Electronics**

Phone: (+49) 6451 501-0

Fax: (+49) 6451 501-693

E-mail: [elektro@ewikon.com](mailto:elektro@ewikon.com)

## 8. Quick Start Guide




### CAUTION!

Incorrect settings can lead to incorrect function or even damage to the mould or the drives!

The operation of the **motion CONTROL SD** controller is divided into several access levels.

- **Level 0 Operator** (start level)
- **Level 1 Fitter** (PIN: 111111)
- **Level 2 EWIKON** (PIN see envelope on the back of this manual)

To make settings, select the menu „Setup Drives“.

Use  to log in as a fitter.

#### Procedure for setting up a new system for the first time:

Make all necessary connections between the controller, the mould and the injection moulding machine according to these operating manual. Then switch on the controller and set it up according to the following list.

Setup Drives		
<b>General</b>	Basic settings	<ul style="list-style-type: none"> <li>• Select type of drive (chapter 5.2.1)</li> <li>• Select mode of operation (chapter 7.2.4.1)</li> <li>• Set steps per cycle</li> <li>• Set value of position CLOSED and STROKE</li> <li>• Activate all drives used in the mould</li> </ul>
<b>Motion</b>	Motion profile	<ul style="list-style-type: none"> <li>• Set positions and speeds</li> <li>• Set trigger signals according to application</li> <li>• Set deceleration and changeover points if required</li> </ul>
Setup System		
<b>General</b>	Function digital output Function digital input	<ul style="list-style-type: none"> <li>• If necessary, adapt to the application or machine.</li> </ul>
<b>Analog IN</b>	Input #1:	<ul style="list-style-type: none"> <li>• Configure analog input if necessary</li> </ul>
File Management		
<b>Internal</b>		<ul style="list-style-type: none"> <li>• If necessary, save the settings as a recipe</li> </ul>

1. Switch on the hot runner system or the cold runner mould and heat it up to the set temperature (also in advance).
2. Test the signal outputs of the machine for correct connection and function.
3. Switch on the power for the drives, they will now carry out their homing run.
4. System is ready for operation, observe the AUTO/MANUAL setting of the device!



### NOTE!

Further operation of the controller, setting up the valve pin movements for the application and adapting the functions to the injection moulding machine controller is carried out in accordance with the previous chapters 5-7. Before using the electric valve pin controller for the first time, it is therefore recommended to read through the operating manual completely in order to achieve optimum functionality.

## 9. Service and maintenance

### 9.1 Maintenance instructions



#### NOTE!

Omitted, incomplete and incorrectly performed maintenance and servicing work increases the wear of individual components of the **motion CONTROL SD** controllers.

- Maintenance and servicing work must be carried out completely and at the specified intervals in accordance with the maintenance schedule.
- Maintenance and servicing work on the units may only be carried out by qualified personnel with electrical engineering knowledge.

In order to ensure a long service life and trouble-free operation of the **motion CONTROL SD** controllers, proper care and maintenance are required in addition to correct operation. In addition to inspection and repair, maintenance is a preventive measure for the upkeep of the **motion CONTROL SD** controllers.

It is recommended that the maintenance work carried out is documented in writing.

### 9.2 Safety instructions for maintenance



#### DANGER!

##### Maintenance and repair with activated voltage supply

Risk of death by electric shock and severe injuries caused by live components.

- Disconnect the **motion CONTROL SD** controller and connected components from mains voltage before performing any work.

## 9.3 Maintenance work

Carry out the following maintenance work at regular intervals:

### 9.3.1 Changing the filter

The filter is positioned on the underside of the *motion CONTROL SD* controller; it has to be checked at regular intervals and replaced, if necessary, but at least once a year.

### 9.3.2 Cleaning the *motion CONTROL SD* controller



#### CAUTION!

##### Unintentional activation of buttons

When touching the touch screen or pushing buttons controller functions may be activated unintentionally.

- Cleaning of the *motion CONTROL SD* controller must only be carried out when the power is switched off.

Only use water with suitable additives. Clean the housing with a soft, humid cloth. Clean the inside with compressed air (low pressure) and a brush only.

Clean the touch screen with rinsing agents, a screen cleaner or alcohol (ethanol). Do not spray the cleaner directly onto the touch screen but onto the cloth and then wipe the screen.



#### NOTE!

Never use easily flammable or combusting substances, aggressive solvents, chemicals, scouring agents or steam cleaners.

### 9.3.3 Checking fan or fan grille

Fan and fan grille (on the rear side) have to be checked at regular intervals and cleaned, if necessary, but at least once a year.

## 9.4 Service and repair instructions

- Please always use replacement fuses of the same type.
- Only use original spare parts when replacing components (see chapter „7.3.2 Spare parts list“).



#### NOTE!

LCD- or TFT-type screens are sensible to the so-called burn-in effect which may occur, if static patterns are displayed over a longer period of time. These static patterns cause parasitic capacitances inside the LCD components preventing the liquid crystal molecules from returning to their original state.

**To reduce this effect we recommend that you switch off the *motion CONTROL SD* controller when not in use.**

## 10. Decommissioning

### 10.1 Returning the *motion CONTROL SD* controller

After end of its service life the device can be returned to the manufacturer for disposal.

### 10.2 Safety instructions for dismantling



#### DANGER!

##### Connected voltage supply

Risk of death by electric shock or severe injuries caused by live components

- Please make sure that you have disconnected the *motion CONTROL SD* controller from the voltage supply before dismantling it. At first remove the power cable to prevent any connection to the power supply, then all plug-in connections to mould or machine have to be removed from the device.

### 10.3 Disposal instructions



#### NOTE!

- All operating supplies are to be drained, collected and disposed of according to the local regulations
- Only trained staff is authorised to perform disassembly
- Disposed components must not be reused. EWIKON declines all responsibility for personal injury or material damage in connection with the reuse of the components
- After appropriate disassembly the components are to be recycled:
- Scrap metal material residues
- Recycle plastic elements and plastic residues
- Dispose of the other components sorted by material characteristics
- Electronic scrap and electronic components are subject to hazardous waste treatment; only specialised companies are authorised to dispose of them
- National regulations on disposal regarding an environmentally appropriate disposal of the disassembled *motion CONTROL SD* controller must be adhered to





We hereby confirm that the product described below conforms to the essential protection requirements of the following European Directives

**2014/35/EU “Low Voltage Directive”**

and

**2014/30/EU “EMC Directive”**

with respect to its design type. This requires that the product is used for its intended purpose and that the assembly and operating instructions are observed.

Alterations made to the product will void the declaration of conformity.

**Manufacturer:** EWIKON Heißkanalsysteme GmbH  
Siegener Straße 35  
35066 Frankenberg / Germany  
phone: +49 (0) 6451 / 501-0

**Product:** *motion CONTROL SD servo drive controller*  
for the operation of linear drives in hot and cold runner valve gate systems

**Type:** **68152.202 / 68162.202** ; *motion CONTROL SD* controller, 2-zone  
**68152.204 / 68162.204** ; *motion CONTROL SD* controller, 4-zone  
**68152.208 / 68162.208** ; *motion CONTROL SD* controller, 8-zone  
**68152.218 / 68162.218** ; *motion CONTROL SD* extension unit, 8-zone  
**68162.271** ; *motion CONTROL SD* controller, 1-zone  
**68162.272** ; *motion CONTROL SD* controller, 2-zone  
  
**68152.301** ; *motion CONTROL SD* controller, 1-zone  
**68152.302** ; *motion CONTROL SD* controller, 2-zone

**Applied harmonised standards:**

DIN EN 61010-1: 2020-03 “Safety requirements for electrical equipment for measurement, control, and laboratory use” - part 1: General requirements

DIN EN 61010-2-201: 2019-04 “Safety requirements for electrical equipment for measurement, control and laboratory use” - part 2-201: Particular requirements for control equipment

**Note:** It is necessary to use original connecting cables outside the device to meet the requirements!

The sole responsibility for issuing this declaration of conformity lies with the manufacturer.

Frankenberg, 11/02/2025



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