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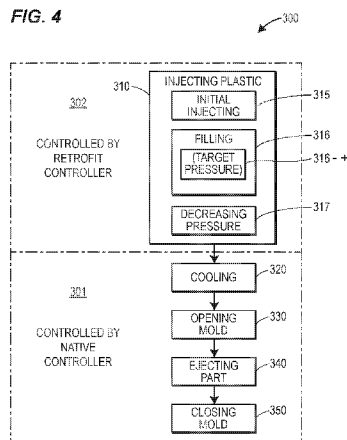
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(54) **Title:** INJECTION MOLDING CONTROLLER INTERFACE WITH USER-ADJUSTABLE VARIABLES

FIG. 4



(57) **Abstract:** An injection molding machine uses a native controller and a retrofit controller to effectively control its operation. The controllers may determine and/or receive information regarding the machine's maximum load capacity, and may also determine a current operational load value of the machine. The retrofit controller may cause the machine to operate at any number of combinations of settings of operational parameters which result in the machine operating at or below the maximum load value by adjusting any number of machine parameters associated with the injection molding machine based on feedback sensors measuring real-time operating conditions of the machine.

## INJECTION MOLDING CONTROLLER INTERFACE WITH USER-ADJUSTABLE VARIABLES

### 5 FIELD OF THE INVENTION

The present application generally relates to injection molding and, more specifically, to approaches for retrofitting an injection molding machine with a secondary controller to control operation thereof, which can reduce the energy required to form a molded article.

### 10 BACKGROUND OF THE INVENTION

Injection molding is a technology commonly used for high-volume manufacturing of parts constructed of thermoplastic materials. During repetitive injection molding processes, a thermoplastic resin, typically in the form of small pellets or beads, is introduced into an injection molding machine which melts the pellets under heat and pressure. The molten material is then  
15 forcefully injected into a mold cavity having a particular desired cavity shape. The injected plastic is held under pressure in the mold cavity and subsequently is cooled and removed as a solidified part having a shape closely resembling the cavity shape of the mold. A single mold may have any number of individual cavities.

Conventional injection molding machines operate within manufacturer-provided  
20 constraints to ensure safety and operability of the machine. These machines are typically constrained by maximum load values which act to limit any number of operating parameters of the injection molding machine to ensure safe and effective operability and avoid damage to components of the injection molding machine. In the event that the manufacturer's safety margin level, as contrasted to the machine's actual maximum load value for a given set of  
25 operating and environmental conditions, is exceeded, the machine may overheat, trip to a failsafe setting, and/or trigger an alarm condition. The maximum load value may be represented graphically, and it may be dependent on any number of variables, such as, for example, equipment operating speeds, pressures, the type and viscosity of material(s) being molded, as well as environmental conditions. Because of the presence of maximum load values, the  
30 machine may be permanently configured to operate at or below particular variables regardless of whether the machine is operating above the maximum allowable load prescribed by the manufacturer.

Generally speaking, injection molding machines allow an operator to modify and/or manipulate the operating parameters thereof. As a merely illustrative, non-limiting example, if an environmental factor such as a plant ambient temperature causes the injection molding machine to work harder to generate parts, the machine's operating load value over a given period of time will increase. This increase in the operational load value may eventually cause the machine to approach or exceed the maximum load value which may result in temporary or permanent machine failure. Prior to exceeding or even reaching this maximum load value, the machine may be pre-programmed to generate an alarm which prompts a machine operator to adjust operating variables as required to lower the operating load on the machine, or may trigger the machine to reduce or even cease molding operations altogether, *i.e.* trip to a safety mode.

By relying on the machine operator to adjust operating parameters of the machine, adjustments may not be made as frequently as optimal. For example, if the injection molding machine is operating overnight with a limited number of operators on duty, there may be an extended period in which parameters are not altered. Further, an operator may not realize when the characteristics causing the machine's load value to change have subsided, and thus may keep the machine running in an operational mode which fails to fully utilize the injection molding machine's efficiency. Further still, different operators may employ different approaches to adjusting the machine, and some operators may be less inclined to adjust settings as frequently as others.

Machines may be configured to provide a safety margin below a maximum machine load based on a "worst-case scenario," that is, when any number of parameters are present that would dramatically impact operability of the machine. The restrictions applied to the machines (e.g., safety factors) may restrict the machine from operating within a certain percentage of the maximum machine load. As a result, in operating conditions that resemble the worst-case scenario (such as environments with high ambient temperatures and/or pressures, materials having abnormally high viscosities, thus impacting flow speeds and cooling times, and the like), the machine is limited to performing at a level that is less than its peak performance. Similarly, even in the presence of operating conditions which are considered favorable or preferred, due to the fact that the manufacturer's pre-programmed safety factors are set with worst-case scenarios in mind, and are often not easily overridden, it is often the case that conventional injection molding systems do not approach peak efficiency outputs, even in the most ideal of operating conditions.

Frequently, injection molding machines are configured by the manufacturer to fix the range of adjustability of certain operator-adjustable parameters in an injection molding operation, or even prevent any operator adjustment of certain parameters, based on operator adjustment of other parameters. For instance, if an operator sets up an injection molding machine to implement molding operating program that contemplates injecting a viscous molten thermoplastic material at particularly aggressive velocity in a given portion of each injection molding cycle, the machine may be pre-programmed to only permit the injection molding machine's electric, hydraulic, servo-hydraulic, or servo-driven screw to accelerate at a conservative rate of acceleration, and/or to operate at a conservative pressure, based on the manufacturer's built-in safety margin below the machine's actual load capacity.

### SUMMARY OF THE INVENTION

Embodiments within the scope of the present invention are directed to the use of multiple controllers (i.e., a native controller and a retrofit controller) to effectively control operation of an injection molding machine. The controllers may determine and/or receive information regarding the machine's maximum load capacity, and may also determine an instantaneous (or at least periodic) present load value on the machine. The retrofit controller of the present disclosure may cause the machine to operate at or near the maximum load value by adjusting any number of machine parameters, and dynamically adjust the range within which operator-adjustable parameters in an injection molding operation may be manipulated to facilitate, or at least permit, operation of the injection molding machine in a manner that exploits the machine's actual load capacity during the course of its operation, thereby increasing efficiency and output. In response to operator adjustment of various injection molding operating parameters, rather than constrain other operating parameters to tight ranges or preventing adjustment beyond conservative manufacturer-set safety margins, the controller of the present invention permits conventionally-fixed parameters to float in a manner that allows the injection molding machine to operate at, or near, its maximum load capacity at the new operating conditions (which may include both machine conditions and environmental conditions).

In many embodiments of the present disclosure, the retrofit controller is adapted to selectively operate the injection molding machine in a manner that allows the current load value to remain within a predetermined range below the maximum load value. By adjusting any number of operating parameters, the machine is capable of reacting to changing conditions, some of which may occur during the middle of a cycle, in a near-instantaneous manner, thus

effectively maximizing machine efficiency and producing the maximum number of parts possible over a given period of time. Additionally, because the retrofit controller is adapted to monitor the machine in real-time, an operator need not actively monitor and/or adjust the machine's parameters on the fly.

5           In these embodiments, one and/or both of the native and retrofit controllers may first enter into a learning mode, during which an initial or reference load value or curve is calculated. The initial load value is calculated based on a first set of parameters and/or operating variables, and represents an estimated maximum load value the injection molding machine can maintain while avoiding failure. One of the two controllers then calculates a modified load value by  
10       operating the injection molding machine based on a second set of operating variables. This second set of parameters may be values that are anywhere between approximately 0.1 to 50%, preferably 0.1 to 25%, more preferably 0.1 to 15%, even more preferably 0.1 to 10%, and most preferably 0.1 to 5%, including any integer or non-integer percentage within these ranges, away from the parameters used to calculate the initial load value. The load values may be calculated  
15       using a root-mean-square approach or any other suitable method.

          Using the initial and modified load values as well as the first and second set of operating parameters, a reference (or maximum) load curve for that particular injection molding system may be generated. For instance, a computer program associated with the controller may be provided that interpolates load values between the measured initial and modified load values for  
20       any operating conditions intermediate the first and second operating conditions, and extrapolates load values for operating conditions outside of the first and second operating conditions. Alternately, a reference or maximum load curve may be provided by the machine manufacturer or by the provider of the retrofit equipment, may be a theoretical value based on a predetermined maximum operating condition, and/or may be obtainable by other means.

25           The operating parameters may be any combination of adjustments to the injection molding machine, and may include environmental conditions, some of which may be within the control of the molder, such as ambient temperature in a temperature-adjustable manufacturing facility, but some may be outside of human control, such as barometric pressure. In some approaches, variations in operating parameters may include adjustments to a barrel temperature,  
30       a clamp closing speed, a clamp opening speed, a cooling time, an inject forward time, an overall cycle time, a pressure setpoint, a screw recovery speed, and a screw velocity. Other examples are possible and may be dependent on the particular injection molding machine in use.

Upon the machine entering an operational mode, the retrofit controller selectively operates the machine based on any number of operating parameters described herein. By adjusting the various operating parameters, an operational load value of the machine may be maintained below the reference load curve. During operation of the machine, one or both of the  
5 controllers are adapted to actively (e.g., periodically) monitor the load values to ensure the operational load on the machine remains below values of the reference curve. The retrofit controller is further adapted to adjust the operating variables as needed to ensure the operating load value remains below the reference load values.

In many of these examples, the retrofit controller may selectively control how closely the  
10 operational load is kept to the reference load curve by adjusting the operating parameters described herein. For example, depending on the particular application, the operational load may be held to within approximately 0.1-50% of the maximum load value, or any integer or non-integer value for percentage in that range, or any range formed by any of those integer values, such as 0.1-30% or from 0.1-25%, 0.1-10%, or 0.1-5%.

The retrofit controller can be any type of controller, such as an electro-mechanical  
15 controller, a circuit board, a programmable logic controller, an industrial computer, or any other type of controller as described herein or as known in the art. The retrofit controller may be set, configured, and/or programmed with logic, commands, and/or executable program instructions according to the embodiments provided herein or as known in the art.

The retrofit controller is adapted to establish signal communication between the retrofit  
20 controller and the injection molding machine such that the retrofit controller at least partially controls operation of the machine. Thus, the retrofit controller may connect one or more outputs from any number of sensors (e.g., pressure sensors, temperature sensors, position sensors, and the like) disposed on or near the machine to one or more inputs of the retrofit controller.  
25 Connecting the retrofit controller may also include disconnecting one or more of the existing sensor outputs from the native controller and connecting those existing sensor outputs to the retrofit controller, or adding more outputs to one or more of the existing sensors and connecting those added outputs to the retrofit controller, or combinations of these. Connecting the retrofit controller can involve one or more existing sensors already in place on the molding machine, or  
30 moving one or more existing sensors to new locations on the molding machine, or installing one or more new sensors on the molding machine, or combinations of these. The signal communication can be any kind of signal (e.g. hydraulic, pneumatic, mechanical, analog electrical, digital electrical, optical, etc.) described herein or known in the art. In some

embodiments, the retrofit controller can replace the native controller and replace all of its functions. In other embodiments of retrofitting, the retrofit controller can be added as an addition to the native controller and replace less than all of its functions. In alternative embodiments, a native controller can be reconfigured to become a retrofit controller, as described herein.

Any or all of the embodiments described in this Summary section can be performed in any way disclosed herein or known in the art, and can be used and/or combined in any workable combination, including any alternative embodiments.

## BRIEF DESCRIPTION OF THE DRAWINGS

While the specification concludes with claims particularly pointing out and distinctly claiming the subject matter that is regarded as the present invention, it is believed that the invention will be more fully understood from the following description taken in conjunction with the accompanying drawings. Some of the figures may have been simplified by the omission of selected elements for the purpose of more clearly showing other elements. Such omissions of elements in some figures are not necessarily indicative of the presence or absence of particular elements in any of the exemplary embodiments, except as may be explicitly delineated in the corresponding written description. None of the drawings are necessarily to scale.

FIG. 1 illustrates an exemplary machine loading profile in which an injection molding machine's screw velocity is plotted as a function of pressure in accordance with various embodiments of the present disclosure;

FIG. 2 illustrates an elevation view of an exemplary injection molding machine having a retrofit controller coupled thereto in accordance with various embodiments of the present disclosure;

FIG. 3 illustrates portions of a control mechanism having a native and a retrofit controller in accordance with various embodiments of the present disclosure;

FIG. 4 illustrates a retrofit injection mold cycle as programmed to the control mechanism to control the injection molding process in accordance with various embodiments of the present disclosure;

FIG. 5 illustrates an exemplary screenshot of a controller providing periodically updated operating values of a number of parameters in accordance with various embodiments of the present disclosure; and

FIGS. 6A and 6B illustrate exemplary schematics of control processes of electric and hydraulic injection molding machine in accordance with various embodiments of the present disclosure.

## DETAILED DESCRIPTION OF THE INVENTION

Turning now to the drawings, an injection molding process is herein described. Injection molding machines have a generally nonlinear reference or maximum loading curve 10 as illustrated in FIG. 1. This curve 10 may be viewed as a graphical representation of an effect that any number of parameters (such as, for example, velocity as a function of operating pressure) may have on the machine. Generally speaking, operators run these machines at operating load values (which may fluctuate over time) that are at a point well below the reference load curve to avoid tripping the injection molding machine manufacturer's pre-programmed alarms and/or failure modes. As FIG. 1 illustrates, injection molding machines (also referred to herein simply as "machines") typically have absolute maximum operating values which may not be exceeded so as to limit potential machine failure.

Machine manufacturers utilize safety buffers which act to restrict parameters from exceeding particular values that are lower than that which would cause the machine to operate to its absolute maximum operating load capacity. As illustrated by FIG. 1, points P-1 and V-1 represent specified manufacturing maximum values that may not be exceeded. These values are programmed into a native controller that at least partially controls operation of the machine. As a result of these restrictive values, the normal available operating range 12 (as depicted by the slashed shaded area in FIG. 1) is available for use by the operator, meaning the operating parameters may fall somewhere in this area.

However, the machine may still be operated using parameters that are greater than the manufacturer's designated maximums without causing damage to the injection molding machine. In the examples provided herein, operating parameters such as the maximum pressure are selectively increased (while remaining below the machine's specified absolute maximum operating velocity value) in order to increase the available operating range 14 (depicted by area having circles in FIG. 1). Similarly, the maximum velocity may be selectively increased (while remaining below the machine's specified absolute maximum operating velocity value) in order to increase the available operating range 16 (as depicted by the area having crosses in FIG. 1). Any number of parameters may be adjusted in this way to increase the allowable operating

range of the machine. Ultimately, the entire area under the maximum load curve (up to the machine's specified absolute maximum operating parameter values) may be used.

To enable operating parameter values beyond the manufacturer's preprogrammed maximums, a retrofit controller is used to intercept and alter and/or generate new control signals that are sent to the injection molding machine. The retrofit controller may include software that communicates with the native controller to "trick" the native controller into believing operating parameters are still within the manufacturer's maximum allowed values while in reality, different control signals are being sent to the machine. In some examples, the retrofit controller may suspend or intercept control signals originating from the native controller and generate new signals to send to the machine. Other examples are possible, and further discussion of the retrofit controller is provided herein.

While any number of approaches may be used to form parts, the injection molding machine described herein is merely exemplary and is not intended to limit the applicability of inventive concepts in any way. The approaches described herein may be suitable for electric presses, servo-hydraulic presses, and other known machines. As illustrated in FIG. 2, the retrofitted injection molding machine 100 includes an injection unit 102 and a clamping system 104. The injection unit 102 includes a hopper 106 adapted to accept material in the form of pellets 108 or any other suitable form. In many of these examples, the pellets 108 may be a polymer or polymer-based material. Other examples are possible.

The hopper 106 feeds the pellets 108 into a heated barrel 110 of the injection unit 102. Upon being fed into the heated barrel 110, the pellets 108 may be driven to the end of the heated barrel 110 by a reciprocating screw 112. The heating of the heated barrel 110 and the compression of the pellets 108 by the reciprocating screw 112 causes the pellets 108 to melt, thereby forming a molten plastic material 114. The molten plastic material 114 is typically processed at a temperature selected within a range of about 130°C to about 410°C.

The reciprocating screw 112 advances forward and forces the molten plastic material 114 toward a nozzle 116 to form a shot of plastic material which will ultimately be injected into a mold cavity 122 of a mold 118 via one or more gates 120 which direct the flow of the molten plastic material 114 to the mold cavity 122. In other embodiments, the nozzle 116 may be separated from one or more gates 120 by a feed system (not illustrated). The mold cavity 122 is formed between the first and second mold sides 125, 127 of the mold 118 and the first and second mold sides 125, 127 are held together under pressure via a press or clamping unit 124.

The press or clamping unit 124 applies a predetermined clamping force during the molding process which is greater than the force exerted by the injection pressure acting to separate the two mold halves 125, 127, thereby holding together the first and second mold sides 125, 127 while the molten plastic material 114 is injected into the mold cavity 122. To support these clamping forces, the clamping system 104 may include a mold frame and a mold base, in addition to any other number of components.

Once the shot of molten plastic material 114 is injected into the mold cavity 122, the reciprocating screw 112 halts forward movement. The molten plastic material 114 takes the form of the mold cavity 122 and cools inside the mold 118 until the plastic material 114 solidifies. Upon solidifying, the press 124 releases the first and second mold sides 115, 117, which are then separated from one another. The finished part may then be ejected from the mold 118. The mold 118 may include any number of mold cavities 122 to increase overall production rates. The shapes and/or designs of the cavities may be identical, similar, an/or different from each other.

The retrofitted injection molding machine 100 also includes a native controller 130 which is communicatively coupled with the machine 100 via connection 132. The connection 132 may be any type of wired and/or wireless communications protocol adapted to transmit and/or receive electronic signals. In these examples, the native controller 130 is in signal communication with at least one sensor, such as, for example, sensor 128 located in the nozzle 116 and/or a sensor 129 located proximate an end of the mold cavity 122. It is understood that any number of additional sensors may be placed at desired locations of the machine 100.

The native controller 140 can be disposed in a number of positions with respect to the injection molding machine 100. As examples, the native controller 140 can be integral with the machine 100, contained in an enclosure that is mounted on the machine, contained in a separate enclosure that is positioned adjacent or proximate to the machine, or can be positioned remote from the machine. In some embodiments, the native controller can partially or fully control functions of the machine via wired and/or wired signal communications as known and/or commonly used in the art.

The sensor 128 may be any type of sensor adapted to measure (either directly or indirectly) one or more characteristics of the molten plastic material 114 located in the nozzle 116. The sensor 128 may measure any characteristics of the molten plastic material 114 that is known in the art, such as, for example, pressure, temperature, viscosity, flow rate, and the like, or any one or more of any number of additional characteristics which are indicative of these.

The sensor 128 may or may not be in direct contact with the molten plastic material 114. In some examples, the sensor 128 may be adapted to measure any number of characteristics of the injection molding machine 100 near the nozzle 116 and not just those characteristics pertaining to the molten plastic material 114.

5           The sensor 128 generates a signal which is transmitted to an input of the native controller 140. If the sensor 128 is not located within the nozzle 116, the native controller 140 can be set, configured, and/or programmed with logic, commands, and/or executable program instructions to provide appropriate correction factors to estimate or calculate values for the measured characteristic in the nozzle 116.

10           The sensor 129 may be any type of sensor adapted to measure (either directly or indirectly) one or more characteristics of the molten plastic material 114 to detect its presence and/or condition in the mold cavity 122. In various embodiments, the sensor 129 may be located at or near an end-of-fill position in the mold cavity 122. The sensor 129 may measure any number of characteristics of the molten plastic material 114 and/or the mold cavity 122 that is  
15           known in the art, such as pressure, temperature, viscosity, flow rate, etc. or one or more of any other characteristics that are indicative of any of these. The sensor 129 may or may not be in direct contact with the molten plastic material 114.

          The sensor 129 generates a signal which is transmitted to an input of the native controller 140. If the sensor 129 is not located at the end-of fill position in the mold cavity 122, the native  
20           controller 140 can be set, configured, and/or programmed with logic, commands, and/or executable program instructions to provide appropriate correction factors to estimate or calculate values for the measured characteristic at the end-of-fill position. It is understood that any number of additional sensors may be used to sense and/or measure operating parameters.

          The native controller 140 is also in signal communication with the screw control 126. In  
25           these embodiments, the native controller 140 generates a signal which is transmitted from an output of the native controller 140 to the screw control 126. The native controller 140 can control any number of characteristics of the machine, such as, for example, injection pressures (by controlling the screw control 126 to advance the screw 112 at a rate which maintains a desired melt pressure of the molten plastic material 114 in the nozzle 116), barrel temperatures,  
30           clamp closing and/or opening speeds, cooling time, inject forward time, overall cycle time, pressure setpoints, screw recovery speed, and screw velocity. Other examples are possible.

          The signal or signals from the native controller 140 may generally be used to control operation of the molding process such that variations in material viscosity, mold temperatures,

melt temperatures, and other variations influencing filling rate are taken into account by the native controller 140. Adjustments may be made by the native controller 140 in real time or in near-real time (that is, with a minimal delay between sensors 128, 129 sensing values and changes being made to the process), or corrections can be made in subsequent cycles.

5 Furthermore, several signals derived from any number of individual cycles may be used as a basis for making adjustments to the molding process. The native controller 140 may be connected to the sensors 128, 129, the screw control 126, and or any other components in the machine 100 via any type of signal communication known in the art.

As illustrated schematically in FIGS. 2 and 3, the retrofit controller 150 is generally

10 similar to the native controller 140. The retrofit controller 150 is electrically coupled to the native controller 140 via any number of methods such that the retrofit controller 150 and the native controller 140 are in signal communication. The retrofit controller 150 is adapted to control operation of the injection molding machine 100 directly and/or by controlling the output of the native controller 140.

15 The native controller 140 includes software 141 adapted to control its operation, any number of hardware elements 142 (such as, for example, a memory module and/or processors), any number of inputs 143, any number of outputs 144, and any number of connections 145. The software 141 may be loaded directly onto a memory module of the native controller 140 in the form of a non-transitory computer readable medium, or may alternatively be located remotely

20 from the native controller 140 and be in communication with the native controller 140 via any number of controlling approaches. The software 141 includes logic, commands, and/or executable program instructions which may contain logic and/or commands for controlling the injection molding machine 100 according to an original mold cycle. The software 141 provided by manufacturers includes preprogrammed maximum safe operating values of any number of

25 parameters which are designed to limit the risk of machine damage and/or failure. The software 141 may or may not include an operating system, an operating environment, an application environment, and/or a user interface.

The hardware 142 uses the inputs 143 to receive signals, data, and information from the injection molding machine being controlled by the native controller 140. The hardware 142 uses

30 the outputs 144 to send signals, data, and/or other information to the injection molding machine. The connection 145 represents a pathway through which signals, data, and information can be transmitted between the native controller 140 and its injection molding machine 100. In various embodiments this pathway may be a physical connection or a non-physical communication link

that works analogous to a physical connection, direct or indirect, configured in any way described herein or known in the art. In various embodiments, the native controller 140 can be configured in any additional or alternate way known in the art.

5 The retrofit controller 150 includes components that are similar to those of the native controller 140, such as a software 151 adapted to control its operation, any number of hardware elements 152 (such as, for example, a memory module and/or processors), any number of inputs 153, any number of outputs 154, and any number of connections 155. The software 151 may be loaded directly onto a memory module of the native controller 150, or may alternatively be located remotely from the native controller 150 and be in communication with the native  
10 controller 150 via any number of controlling approaches. The software 151 includes logic, commands, and/or executable program instructions which may contain logic and/or commands for controlling the injection molding machine 100 according to a retrofit mold cycle. Unlike the original mold cycle, in the retrofit mold cycle, the maximum allowable operating parameters are no longer fixed to permanent values and may be variable so long as the total overall loading of  
15 the injection molding machine 100 remains below a maximum value.

The connection 145 is illustrated as being in common with a connection 155, wherein the common connection represents a pathway through which signals, data, and information can be transmitted: a) between the retrofit controller 150, the native controller 140 and the injection molding machine 100, b) between the retrofit controller 150 and the injection molding machine  
20 100, and c) between the retrofit controller 150 and the native controller 140. In various embodiments these pathways may be physical connections or non-physical communication links that work analogous to physical connections, direct or indirect, configured in any way described herein or known in the art. In various embodiments, the native controller 140 and the retrofit controller 150 can be configured in any additional or alternate way known in the art.

25 FIG. 3 illustrates connecting a particular output 144 from the native controller 140, which is used as a particular input 153 to the retrofit controller 150. In various embodiments disclosed herein, the retrofitting of the injection molding machine 100 includes establishing signal communication between: a) an inject forward output 156 from outputs 144 of the native controller 140, and b) one of the inputs 153 of the retrofit controller 150. The native controller  
30 140 can be set, configured, and/or programmed with logic, commands, and/or executable program instructions such that the inject forward output 156 signals when the plastic injecting should (and/or should not) occur during a mold cycle of the molding machine 100.

As an example, the native controller 140 can turn “on” the inject forward output 156 when the plastic injecting should occur, and can turn “off” the inject forward output 156 when the plastic injecting should not occur. The retrofit controller 150 can use the state of the inject forward output 156 as a condition for injecting plastic in the retrofit mold cycle. This signal communication allows the native controller 140 to hand-off control of the plastic injection to the retrofit controller 150 for the plastic injecting portion and/or any other portion of the retrofit mold cycle. In various embodiments, the function of the inject forward output 156 can be accomplished by the native controller 140 sending to the retrofit controller 150 one or more additional or alternate signals, data, and/or information, which are equivalent to an inject forward output 156, using any known approaches in the art.

FIG. 3 further illustrates moving a particular output from the native controller 140 to the retrofit controller 150. In various embodiments disclosed herein, the retrofitting includes: a) disconnecting signal communication between an injection control output 147 of the native controller 140 and a control input of an injection unit of the molding machine 100 (signal illustrated by a phantom line), and b) establishing signal communication between an injection control output 157 of the retrofit controller 150 and the control input of the injection unit of the molding machine 100 (signal illustrated by a solid line). The retrofit controller 150 can be set, configured, and/or programmed with logic, commands, and/or executable program instructions such that the injection control output 157 signals the injection unit regarding the rate at which injecting should occur during plastic injecting of a retrofit mold cycle of the molding machine.

As an example, the retrofit controller 150 can generate the injection control output 157 as an analog control voltage, which scales from a particular low value (representing a minimum injection rate) to a particular high value (representing a maximum injection rate). The injection unit can use the state of the inject control output 157 as the input for controlling the rate of injecting plastic in the retrofit mold cycle. The rate of injecting, in turn, directly affects operating values such as the injection pressure of the molten plastic in the machine 100. As a result, the injection control output 157 can effectively be used to control injection pressures in the retrofitted injection molding machine 100, according to any of the embodiments disclosed herein. This signal communication also allows the retrofit controller 150 to replace control of the plastic injection by the native controller 140 in the retrofit mold cycle. In various embodiments, the function of the injection control output 157 can be accomplished by the retrofit controller 150 generating one or more additional or alternate signals, data, and/or information, which are equivalent to an injection control output, and sending such to one or

more additional or alternate machine components, which partially or fully control operating parameters of the machine 100 in any way known in the art. For example, in one alternative embodiment, the retrofit controller 150 may at least partially control injection pressures of the machine 100 by controlling a rate of melt flow through the nozzle 116. In various embodiments, the retrofitting can also include rerouting the disconnected injection control output 147 to one of the inputs 153 of the retrofit controller 150. Other examples are possible.

The injection molding machine 100 may also include a disable switch 158, which can be provided with the retrofitting, as described herein. The disable switch 158 can allow a user of the retrofitted injection molding machine to select a mode of injection molding that disables the retrofit controller 150 such that the machine 100 and the native controller 140 mold production versions (i.e. parts made using production conditions on the molding machine 100, wherein the parts have acceptable part quality) of the plastic part according to the original mold cycle. In various embodiments disclosed herein, the retrofitting process includes establishing signal communication between: a) a user-controlled output 159 from the disable switch 158, and b) one of the inputs 153 of the retrofit controller 150. The retrofit controller 150 can be set, configured, and/or programmed with logic, commands, and/or executable program instructions such that when the user-controlled output 159 provides a particular signal, the retrofit controller 150 does not control plastic injecting during a mold cycle of the molding machine 100.

As an example, when the user-controlled output 159 is turned “on,” the injecting function of the retrofit controller 150 is disabled and does not control the plastic injecting, and when the user-controlled output 159 is turned “off,” the injecting function of the retrofit controller 150 is not disabled and does control the plastic injecting. The retrofit controller 150 can also be set, configured, and/or programmed with logic, commands, and/or executable program instructions such that when the injecting function of the retrofit controller 150 is disabled, the retrofit controller 150 can receive the control output 147 from the native controller 140 (as described above) and pass that received signal to the control input of the injection unit of the molding machine 100. As a result, when the injecting function of the retrofit controller 150 is disabled, the native controller 140 can effectively control the plastic injecting (with the passed through signal) and the retrofitted molding machine 100 can still operate, although using an original mold cycle which is likely to be relatively less efficient than the retrofit mold cycle. In various embodiments, the function of the disable switch 158 and the user-controlled output 159 can be accomplished by one or more additional or alternate user input devices and/or signals, data, and/or information which are equivalent, in any workable way known in the art.

FIG. 4 provides an illustration of a retrofit injection mold cycle 300 as programmed on the native controller 140 and the retrofit controller 150 of FIGS. 2 and 3, for controlling the retrofitted injection molding machine 100. The retrofit mold cycle 300 includes an operating sequence of injecting molten plastic 310, according to control 302 by the retrofit controller 150, and subsequently performing other functions according to control 301 by the native controller 140. The injecting of the molten plastic 310 includes an initial injecting portion 315, a filling portion 316, which includes using a target pressure 316-t, and a decreasing pressure portion 317. The native controller 140 and retrofit controller 150 can use various signal communications, as described herein and known in the art, to share control of the retrofitted injection molding machine 100 during the retrofit mold cycle. The injecting of the molten plastic 310 can be partially or fully performed in any way described herein for a retrofit mold cycle. The other functions of the cycle include cooling the plastic 320, opening the mold 330, ejecting the part from the mold 340, and closing the mold 350. Any number of additional functions may be performed by either the retrofit controller 150 and/or the native controller 140.

In order to run the retrofit injection mold cycle, machine load values must be determined and/or calculated for the injection loading machine 100, preferably in real time, continuously, semi-continuously, periodically, or at at least one or a plurality of locations during the course of an injection molding cycle.

In some embodiments, maximum and/or reference load values for the machine 100 are provided by the manufacturer and/or are readily obtainable.

In other examples, the maximum load may be calculated by causing the injection molding machine 100 to enter a learning mode during which an initial load value is calculated based on operating the machine 100 according to a first defined set of parameters. Accordingly, this first set of parameters would be interpreted as a “maximum loading” value. A modified load value is then calculated by operating the machine 100 according to a second defined set of parameters. In some examples, the loading may be increased by a specified percentage to reach an absolute maximum loading of the machine. By modifying the parameters to the second defined set, a relative weighting of what each factor contributes to the overall loading of the machine can be determined. As an example, by increasing the cooling time by a specified percentage, the amount the machine loading changes can be calculated. The second set of parameters can be experimentally determined to understand the maximum amount of change that is allowable before a noticeable degradation in part quality is observed. As a result, in some

embodiments, a suitable operating range for each parameter is determined and thereafter used to form satisfactory parts.

This second defined set of parameters can differ from the first defined set of parameters, preferably by at least approximately 5-35% in order to allow the reference load curve to be optimally interpolated and extrapolated. The retrofit controller 150 and/or the native controller 140 then generates and stores a reference load curve that is based on the first and second operating parameters via extrapolation and/or any other suitable method. For example, the parameters may be determined via an iterative, "closed-loop" process known in the art. In these examples, limits and operating instructions must be established and provided so the controller can "learn" how far the parameters may be changed to maintain safe operation of the injection molding machine. In further embodiments, dependent variables may be added where modifying any number of variables may result in other variables automatically changing to stay within the established limits.

In some examples, it may be necessary to identify operating speed, torque settings, estimated load values, the particular machine geometry (e.g., screw pitch or other details), and the type of plastic being used. Other variables may also need to be identified. It is understood that the reference load curve may be calculated via any other suitable method known in the art such as by experientially monitoring system performance at a peak period of time and storing and using these values as maximums. In other approaches, the maximum load value may be a theoretical value based on the motor and/or drive specifications for a given injection molding machine.

Upon determining and/or establishing a reference or maximum load curve, the learning mode is complete, and the injection molding machine 100 is placed in an operational mode wherein it is operated in a manner that does not exceed the maximum load value at any point but may approach the maximum load value to obtain peak efficiency. Alternately, the learning mode may remain open and the reference or maximum load curve could continually or periodically be regenerated based on new reference load data. If the operational load value were to exceed the maximum load value, the machine 100 may overheat, risk damage to one or more of its components, and/or fail. The machine 100 may be adapted to accept a user input designating how close an operational load must be to the maximum load allowable by the machine. In some embodiments, a user may wish to operate the machine 100 within approximately 50% and approximately 100% of the maximum load at all times, without exceeding the maximum load at any time. In preferred embodiments, the machine may be configured to operate at any numerical

value between approximately 60-99% of the machine's maximum load. If the operational load falls outside of this range, the retrofit controller 150 is adapted to selectively control operation of the machine to cause the operational load to be within this range, with a pre-programmed hierarchy of operational parameter adjustments to be made to bring the IM machine back within the desired range. In some examples, sensors 128, 129 and/or any other devices may determine values associated with the machine's 100 operation and transmit these data to the native controller 140 and/or the retrofit controller 150. The current operating values are then compared to the reference load curve to determine whether the machine is operating within the desired range.

In some embodiments, any or all of the initial load value, the modified load value, and/or the current operational load value are calculated using a root-mean-square (or RMS) calculation in which the operating current and/or voltage values are periodically measured to determine a mean value. Power consumption can be measured using any number of approaches known in the art such as, for example, by using current/voltage probes. To measure power consumption, RMS voltage and RMS current are calculated and multiplied together. The power consumption may also be calculated using the following formula:  $POWER = \sqrt{I_0^2 + I_1^2 + I_2^2 + \dots + I_n^2} \times \sqrt{V_0^2 + V_1^2 + V_2^2 + \dots + V_n^2}$  where  $I_n$  and  $V_n$  represent scans of the processor. If these values are calculated at a high enough rate, a machine's power loading may be provided. This calculation is then reset or repeated with each given shot or segment of control of interest (for example, the injection phase, the hold phase, the recovery phase, etc.). In other examples, a machine capacity load calculation or any other calculation known in the art may be used to determine the machine's load.

An exemplary operating screen or display 500 of the native controller 140 and/or the retrofit controller 150 is illustrated in FIG. 5. The native controller 140 and/or the retrofit controller 150 may sense, determine, calculate, and/or display information relating to operation of the machine 100 in a graphical manner to allow an operator to identify how the machine 100 is currently operating. The native controller 140 and/or the retrofit controller 150 may also store historical data for the operator to review at a later date and to perform any number of analytical calculations. The display 500 may provide energy consumption metrics for different phases of the injection molding cycle, and may sum this information to provide a total load value.

In some embodiments, the retrofit controller 150 may incorporate any number of approaches to providing periodic, accurate tracking and/or adjusting of machine parameters in real or near-real time. For example, the retrofit controller 150 may incorporate feedback control

components and/or systems which compare real-time sensed operating values with anticipated operating values and applying corrective action to compensate for the difference between the sensed values.

In some examples, the retrofit controller 150 may be a closed loop controller which provides feedback and trim control during the mold cycle. The feedback trim control provides modification to both steady-state response and control system dynamics. By altering the feedback signal of the control system (e.g., adding and/or subtracting a PID controlled trim signal), either the native controller 140 and/or the retrofit controller 150 may perform the desirable process. It is understood that any number of feedback controllers and/or systems known those having skill in the art may be used.

As a non-limiting example and as illustrated schematically by FIGS. 6A and 6B, the retrofit controller 150 may be adapted to include feedback control (e.g., a trim control process as illustrated by FIG. 6A) which can include a number of components coupled to the injection molding machine 600 via any number of electrical coupling approaches. The feedback control may be applied to any machine configuration, including electric, hydraulic, servo-hydraulic, servo-driven, and any other configurations. In addition to the components of the injection molding machine 600 previously described herein with regard to the preceding figures, the process may utilize any number of sensors 602 (e.g., a cavity sensor and a nozzle sensor), a load calculation module 604, a first pressure setpoint 606, a first summer 608, a first PID controller 610, a second summer 612, a second pressure setpoint 614 (which may be equal in value to that of the first pressure setpoint 606), a third summer 616, a second PID controller 618, and a valve or drive 620. It is understood that any number of additional components used in feedback control processes may also be used to provide control. Further, it is understood that the native controller may supply the retrofit controller with any number of sensed values not illustrated in FIGS. 6A and/or 6B.

As illustrated in FIG. 6A, the sensor and/or sensors 602 transmit a signal to the load calculation module 604 to determine the current operational load value. This value is transmitted to the first summer 608 which compares the value to the first pressure setpoint 606 and generates an error signal to be transmitted to the first PID controller 610. The first PID controller 610 then generates a load signal and transmits the signal to the second summer 612, which compares the signal to the current operational load value. The second summer 612 generates a voltage signal indicative of an operating pressure based on the received signals, and is compared to the second pressure setpoint 614 value at the third summer 616. Depending on

the machine, the system environment, and additional factors, the process may transmit signals at different voltage scales. For example, the signals may range between 4-20 mV, -10-10V, 0-10V, and any other suitable range. In some embodiments, the signal ranges may also vary based on the type of signal being measured (e.g., a temperature, pressure, and/or position measurement).

5 An error signal is again sent to the second PID controller, which generates a voltage signal representative of a valve position for the valve or drive 620. Upon receiving this signal, the valve 620 adjusts and transmits a pressure to the injection molding machine 600 for operation.

The process illustrated schematically in FIG. 6B depicts the use of a control loop in an exemplary standard (e.g., hydraulic) press and differs from the process in FIG. 6A in that a  
10 single control loop is used to determine and cause modifications to the system. In these machines, the feedback loop may be different from the control used in an electric process. Some considerations when controlling a hydraulic press include additional contributing factors on the load such as hydraulic pressure (including the pressure in hoses, valves, and other components), oil temperatures (where, in some examples, the hybrid press may shut down due to overloading),  
15 and a PID tuning rate. Other examples are possible.

In FIG. 6B, the sensor and/or sensors 602 transmit a signal to the load calculation module 604 to determine the current operational load value. This value is transmitted to the summer 608 which compares the value to the pressure setpoint 606 and generates an error signal to be transmitted to the PID controller 610. The PID controller then generates a voltage signal  
20 representative of a valve position for the valve or drive 620. Upon receiving this signal, the valve 620 adjusts and transmits a pressure to the injection molding machine 600 for operation. In some examples, the controller may adjust the dwell, cooling, and/or eject timing prior to adjusting valve pressure.

In some approaches, parameters of the injection molding machine 100 may be adjusted  
25 in any number of ways to effectuate a change to the current operational load. For example, changes may be made to a barrel temperature, a clamp closing speed, a clamp opening speed, a cooling time, an inject forward time, an overall cycle time, a pressure setpoint, a screw recovery speed, and/or a screw velocity to adjust the current operational load. It is understood that changing any and/or all of these parameters may have an effect on the operational load, thus  
30 there may be countless approaches to modifying these parameters to accomplish an increase or decrease in the operational load value.

For example, in some embodiments, by decreasing the barrel temperature, the machine's loading increases, as, for example, the lower barrel temperature may result in relatively higher

viscosity of the molten polymeric material to be injected into the mold cavity. By decreasing the clamp closing and opening speed, the operational load value will decrease. By decreasing the cooling (or dwell) time, the operational load value will increase. By decreasing the inject forward time (e.g., fill and pack times), the pressure setpoint, screw recovery speed, and screw velocity, the machine's loading values will decrease. By decreasing the overall cycle time, the machine's loading will increase. It is understood that for any of the above examples, increasing the parameter may result in an opposite effect on the machine's loading. Other examples of parameters which may be adjusted are possible. The software 151 of the retrofit controller 150 is adapted to selectively adjust any number of these parameters to increase or decrease the load value as desired to keep the current operational load within the desired range.

The dimensions and values disclosed herein are not to be understood as being strictly limited to the exact numerical values recited. Instead, unless otherwise specified, each such dimension is intended to mean both the recited value and a functionally equivalent range surrounding that value. For example, a dimension disclosed as "40 mm" is intended to mean "about 40 mm."

Every document cited herein, including any cross referenced or related patent or application and any patent application or patent to which this application claims priority or benefit thereof, is hereby incorporated herein by reference in its entirety unless expressly excluded or otherwise limited. The citation of any document is not an admission that it is prior art with respect to any invention disclosed or claimed herein or that it alone, or in any combination with any other reference or references, teaches, suggests or discloses any such invention. Further, to the extent that any meaning or definition of a term in this document conflicts with any meaning or definition of the same term in a document incorporated by reference, the meaning or definition assigned to that term in this document shall govern.

While particular embodiments of the present invention have been illustrated and described, it would be obvious to those skilled in the art that various other changes and modifications can be made without departing from the spirit and scope of the invention. It is therefore intended to cover in the appended claims all such changes and modifications that are within the scope of this invention.

## CLAIMS

What is claimed is:

1. A method of retrofitting an injection molding machine, the method comprising:
  - retrofitting an injection molding machine with a retrofit controller, the injection molding machine including a native controller adapted to control operation of the injection molding machine;
  - entering a learning mode of at least one of the native controller or the retrofit controller to calculate an initial load value of the injection molding machine based on a first set of operating parameters;
  - calculating a modified load value of the injection molding machine by operating the injection molding machine based on a second set of operating parameters;
  - generating a reference load curve based on at least the first set of operating parameters and the second set of operating parameters;
  - entering an operational mode of the retrofit controller; and
  - using the retrofit controller, selectively operating the injection molding machine such that an operational load value of the injection molding machine remains at or below the reference load curve.
2. The method of claim 1, wherein the retrofit controller comprises a closed loop controller adapted to permit the injection molding machine unit to operate within 50% of the reference load value.
3. The method of claim 1 or 2, further comprising establishing signal communication between an output of the retrofit controller and the injection molding machine such that the retrofit controller at least partially controls operation of the injection molding machine.
4. The method of any one of claims 1-3, wherein the first set of operating parameters and the second set of operating parameters comprise adjustments to at least one of barrel

temperature, clamp closing speed, clamp opening speed, cooling time, inject forward time, overall cycle time, pressure setpoint, screw recovery speed, and screw velocity.

5. The method of any one of claims 1-4, wherein the initial load value is calculated by sensing at least one of a nozzle pressure, injection pressure, screw velocity, and voltage over a predetermined per-cycle period of time and calculating a load value using the sensed data.

6. The method of any one of claims 1-4, wherein the modified load value is calculated by sensing at least one of a nozzle pressure, injection pressure, screw velocity, and voltage over a predetermined per-cycle period of time and calculating a load value using the sensed data.

7. The method of any one of claims 1-6, wherein the second set of operating parameters comprise a difference of approximately 0.1-50% from the first set of operating parameters.

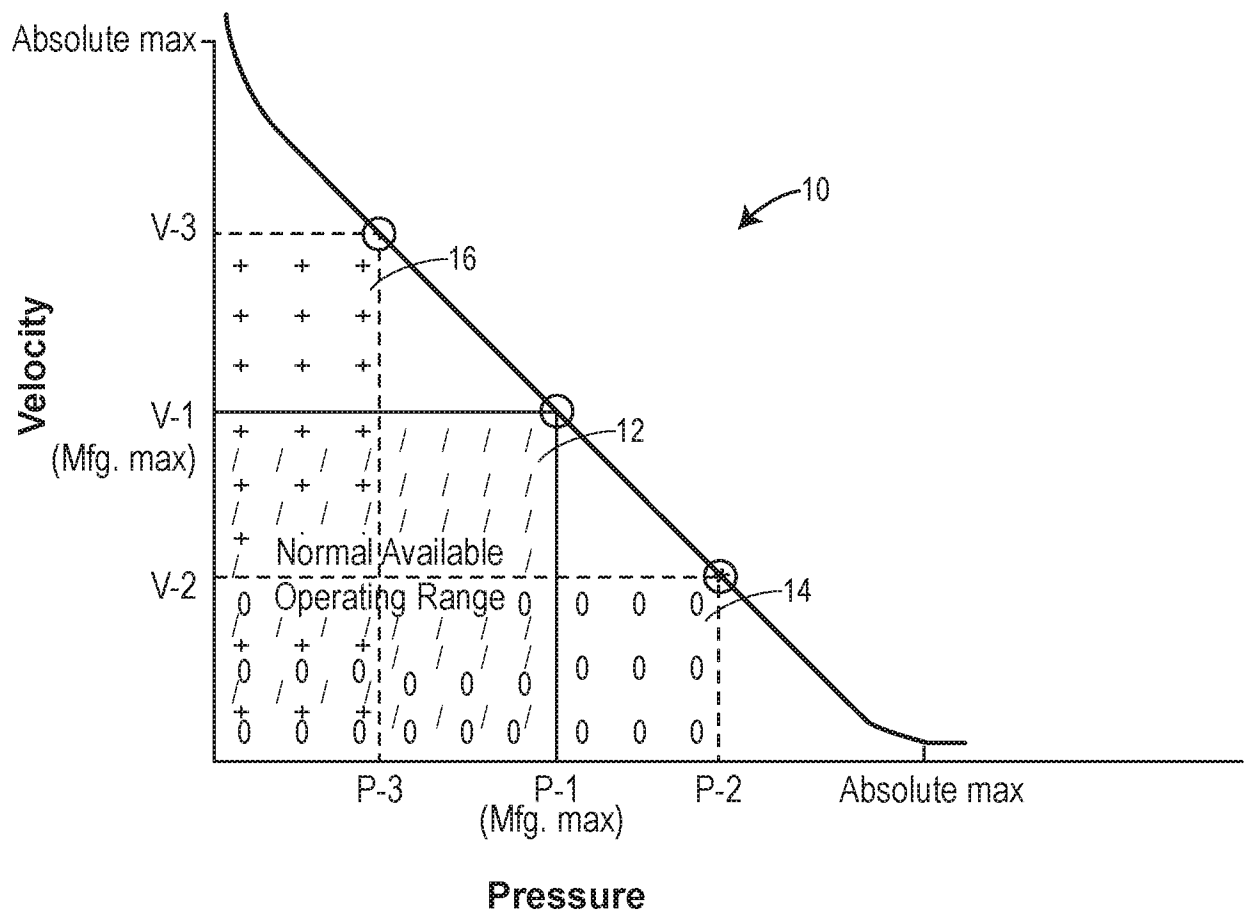
8. The method of any one of claims 1-6, wherein selectively operating the injection molding machine comprises selectively adjusting at least one of barrel temperature, clamp closing speed, clamp opening speed, cooling time, inject forward time, overall cycle time, pressure setpoint, screw recovery speed, and screw velocity.

9. The method of any one of claims 1-8, wherein the reference load curve provides an estimated maximum load value the injection molding machine can maintain while avoiding failure.

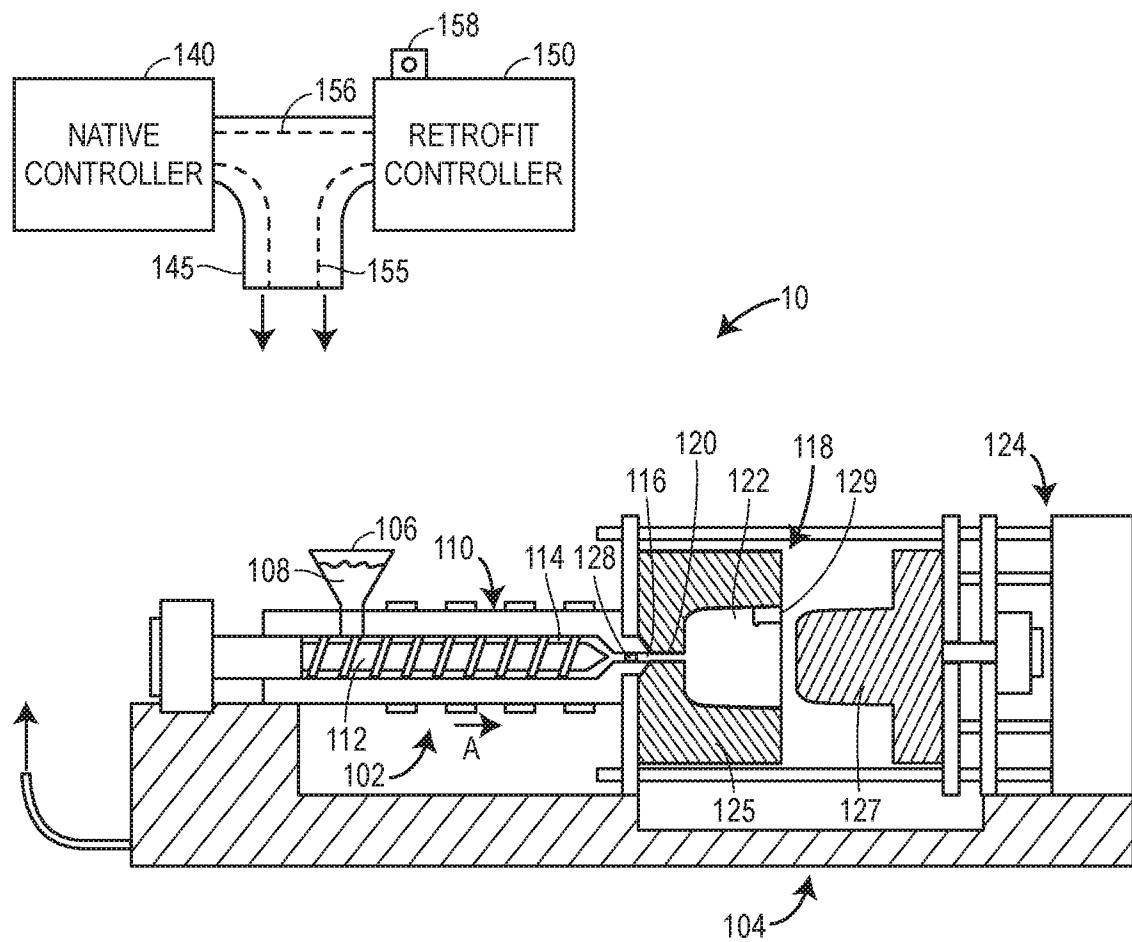
10. The method of any one of claims 1-9, further comprising periodically monitoring an operating load of the injection molding machine to ensure the operating load is within a determined range of the reference load curve.

11. The method of any of one claims 1-10, wherein at least one of the initial load value, the modified load value, and the operational load value is calculated by at least one a root-mean-square load calculation and a maximum machine capacity load calculation.

12. The method of claim 11, wherein a total machine load value is used to calculate the maximum machine capacity load calculation.



**FIG. 1**



**FIG. 2**

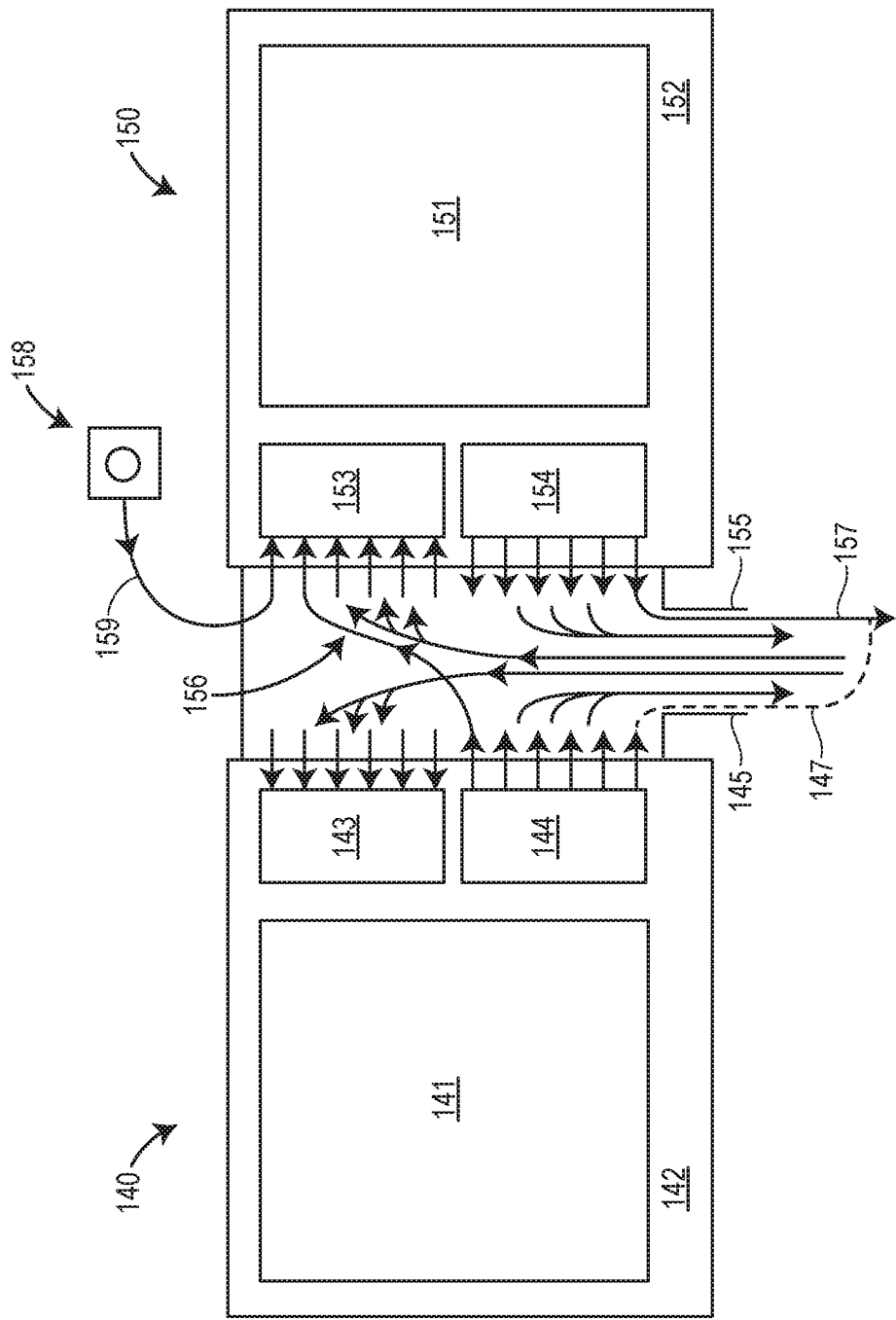
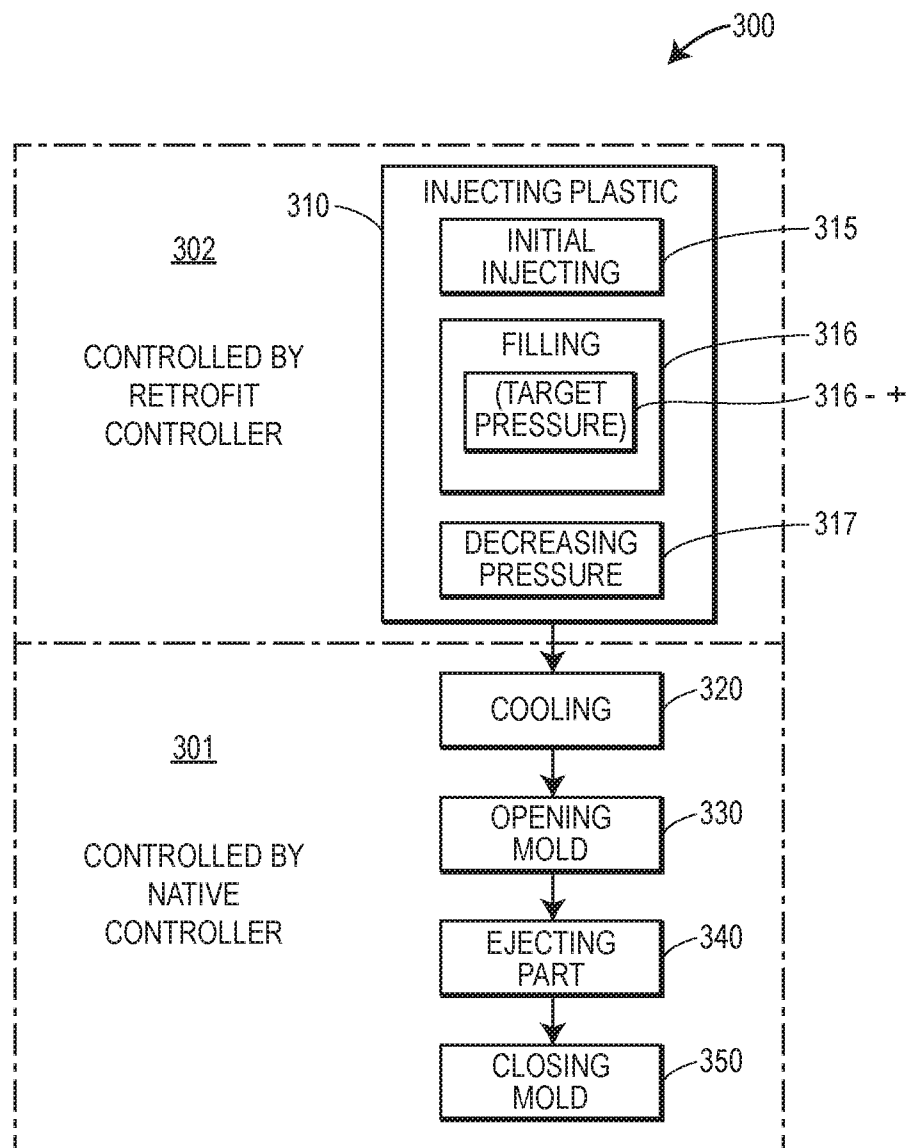


FIG. 3

4/7

**FIG. 4**

500

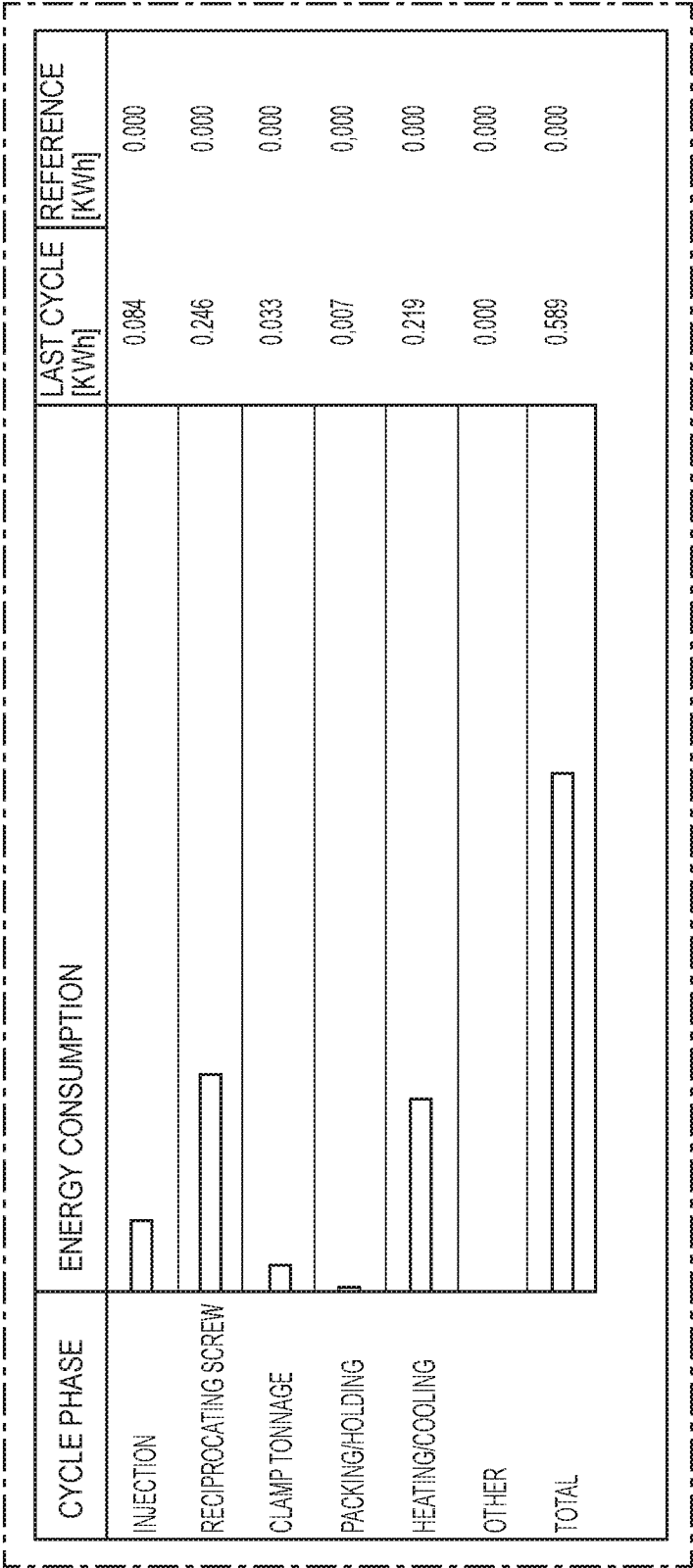


FIG. 5

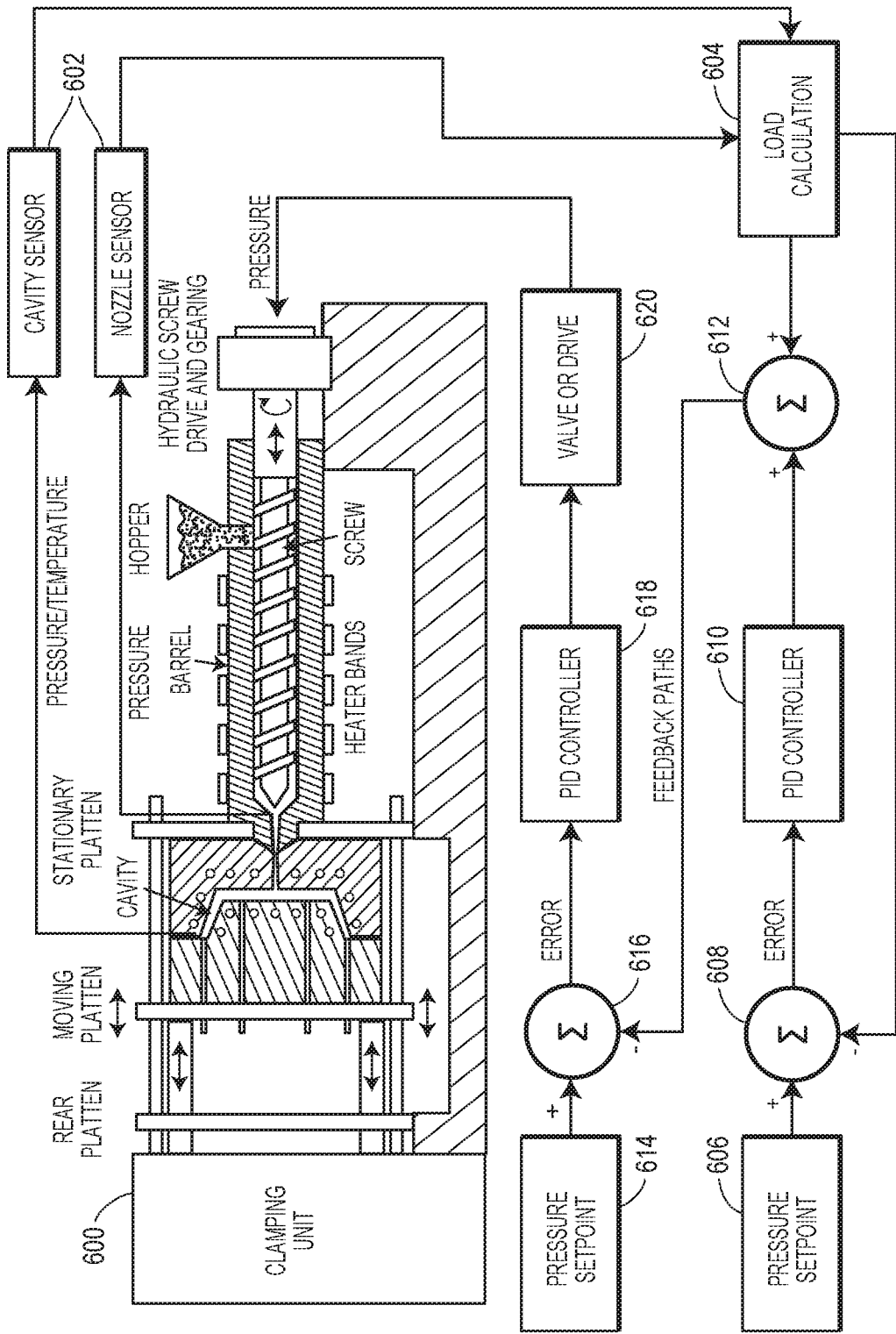


FIG. 6A

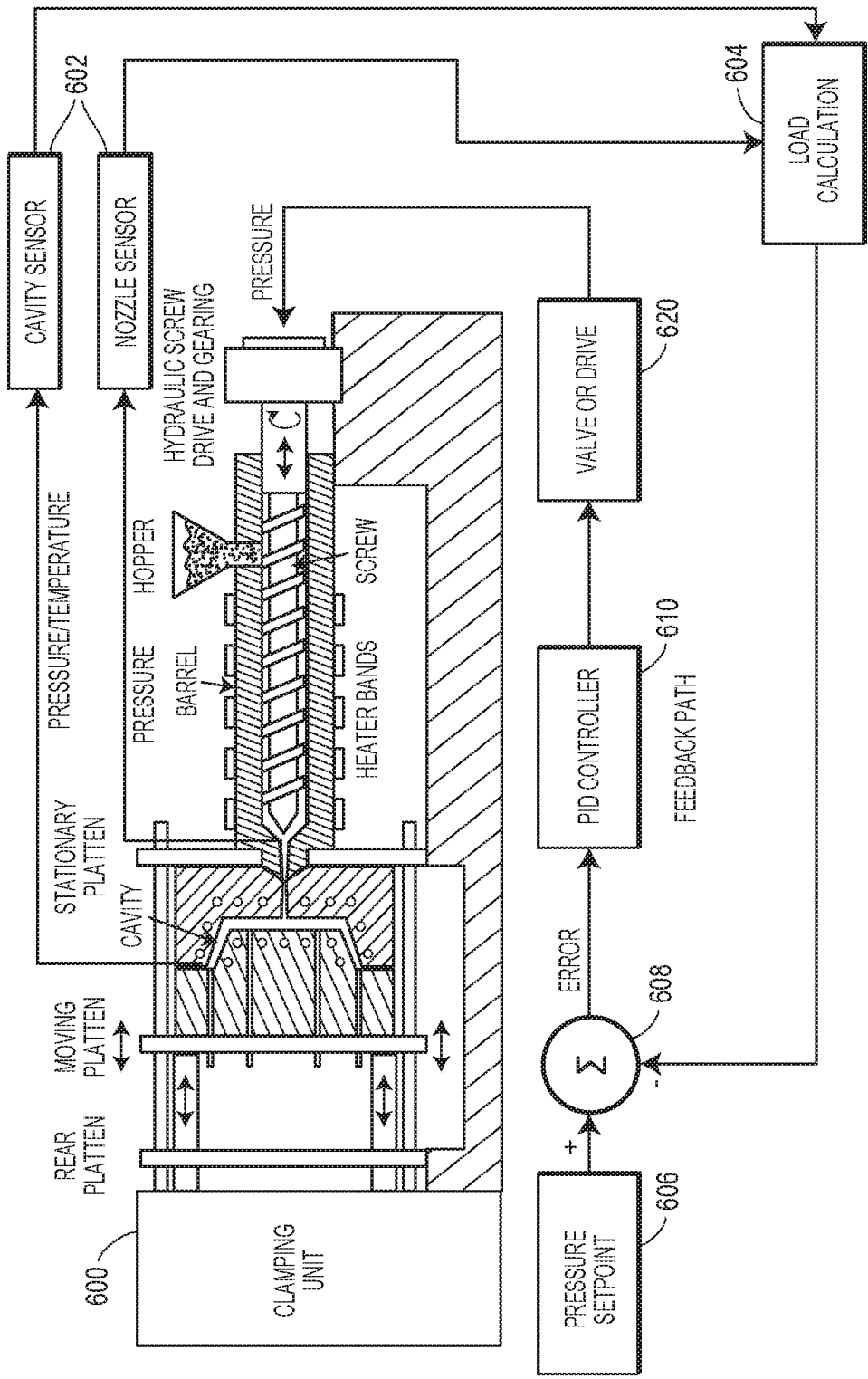


FIG. 6B

# INTERNATIONAL SEARCH REPORT

International application No

PCT/US2017/023387

## A. CLASSIFICATION OF SUBJECT MATTER

INV. B29C45/77 B29C45/76  
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

B29C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EP0-Internal, WPI Data

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

| Category* | Citation of document, with indication, where appropriate, of the relevant passages                                                                                                                                                          | Relevant to claim No. |
|-----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|
| A         | "PIGGY-BACK CONTROLLER",<br>IBM TECHNICAL DISCLOSURE BULLETIN,<br>INTERNATIONAL BUSINESS MACHINES CORP.<br>(THORNWOOD), US,<br>vol. 39, no. 4, 1 April 1996 (1996-04-01),<br>page 25, XP000587408,<br>ISSN: 0018-8689<br>the whole document | 1-12                  |
| A         | -----<br>EP 0 461 627 A1 (ALLEN BRADLEY CO [US])<br>18 December 1991 (1991-12-18)<br>page 3, line 47 - page 4, line 14<br>page 9, line 40 - line 54; figures 1,5<br>-----                                                                   | 1-12                  |

☐ Further documents are listed in the continuation of Box C.

☒ See patent family annex.

### \* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

31 May 2017

Date of mailing of the international search report

12/06/2017

Name and mailing address of the ISA/

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# INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2017/023387

| Patent document<br>cited in search report | Publication<br>date | Patent family<br>member(s) | Publication<br>date     |
|-------------------------------------------|---------------------|----------------------------|-------------------------|
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|                                           |                     | DE 69113128 D1             | 26-10-1995              |
|                                           |                     | DE 69113128 T2             | 09-05-1996              |
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