

FIG.1

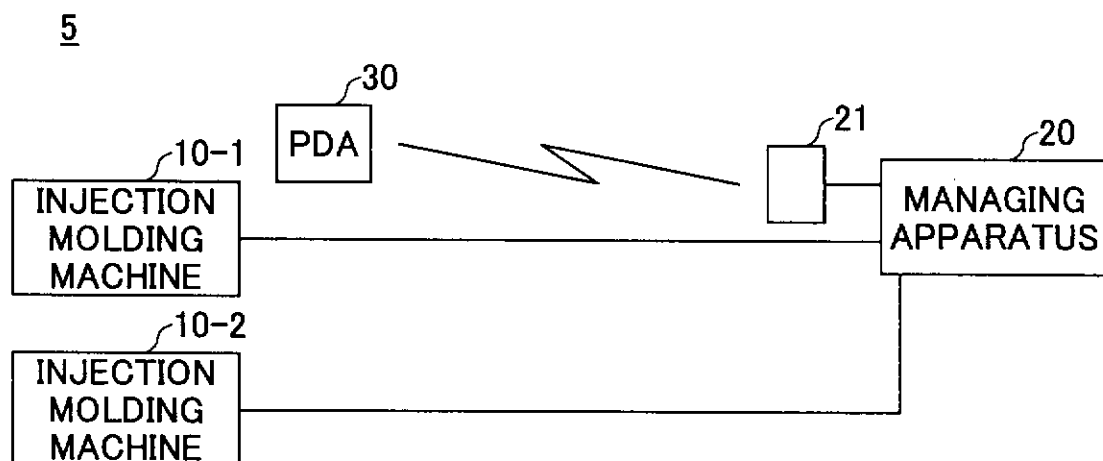


FIG.2

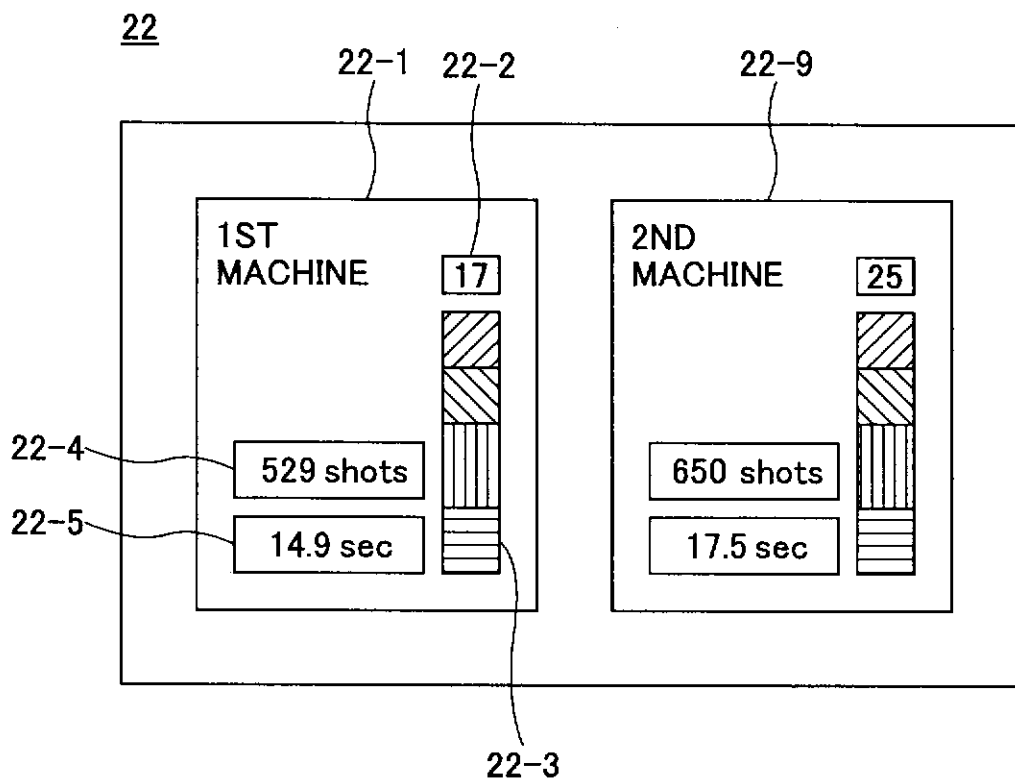


FIG.3

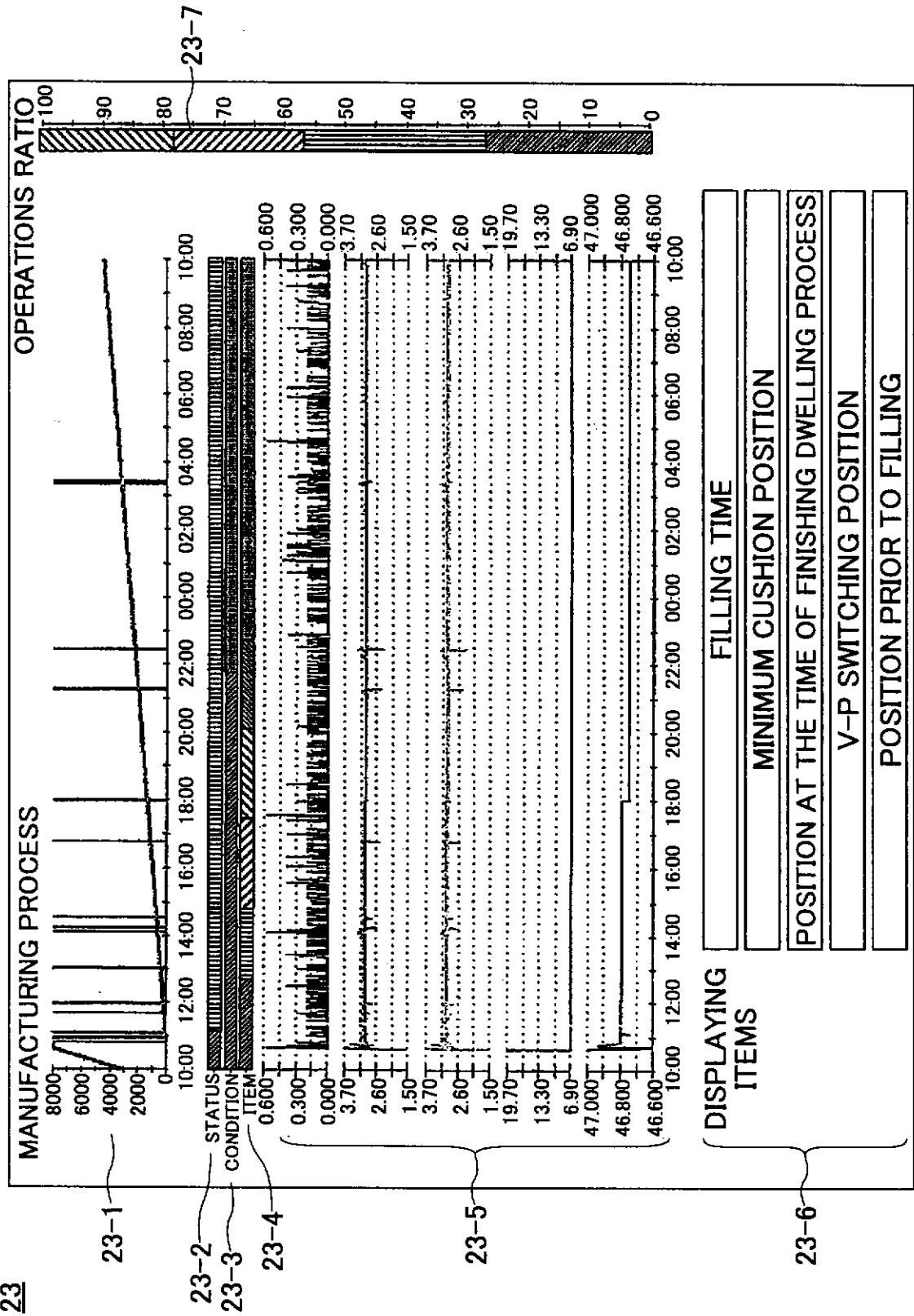


FIG.4

24

1ST MACHINE			
ITEMS	BEFORE CHANGED	AFTER CHANGED	DATE AND TIME
METERING FINISHING POSITION	46.25	46.20	2003/06/05 14:15:20
CYCLE MONITOR MODE	0	1	2003/06/05 10:20:15
MOLD PROTECTION MONITOR MODE	0	1	2003/06/05 10:20:15
MAXIMUM CUSHION MONITOR MODE	0	1	2003/06/05 10:20:15
MINIMUM CUSHION MONITOR MODE	0	1	2003/06/05 10:20:15

FIG.5

25

1ST MACHINE		
ITEMS	TIME OF OCCURRENCE OF ABNORMALITY	TIME OF LIFTING OF ABNORMALITY
[ABNORMALITY] MOLD PROTECTION	2003/06/01 10:20:15	2003/06/02 14:15:10
[INTER ROCK] SAFETY DOOR OPEN	2003/06/01 10:20:15	2003/06/02 14:15:10
[INTER ROCK] NOT FINISHED MOLD CLAMPING ADJUSTMENT	2003/06/01 10:20:15	2003/06/02 14:15:10

FIG.6

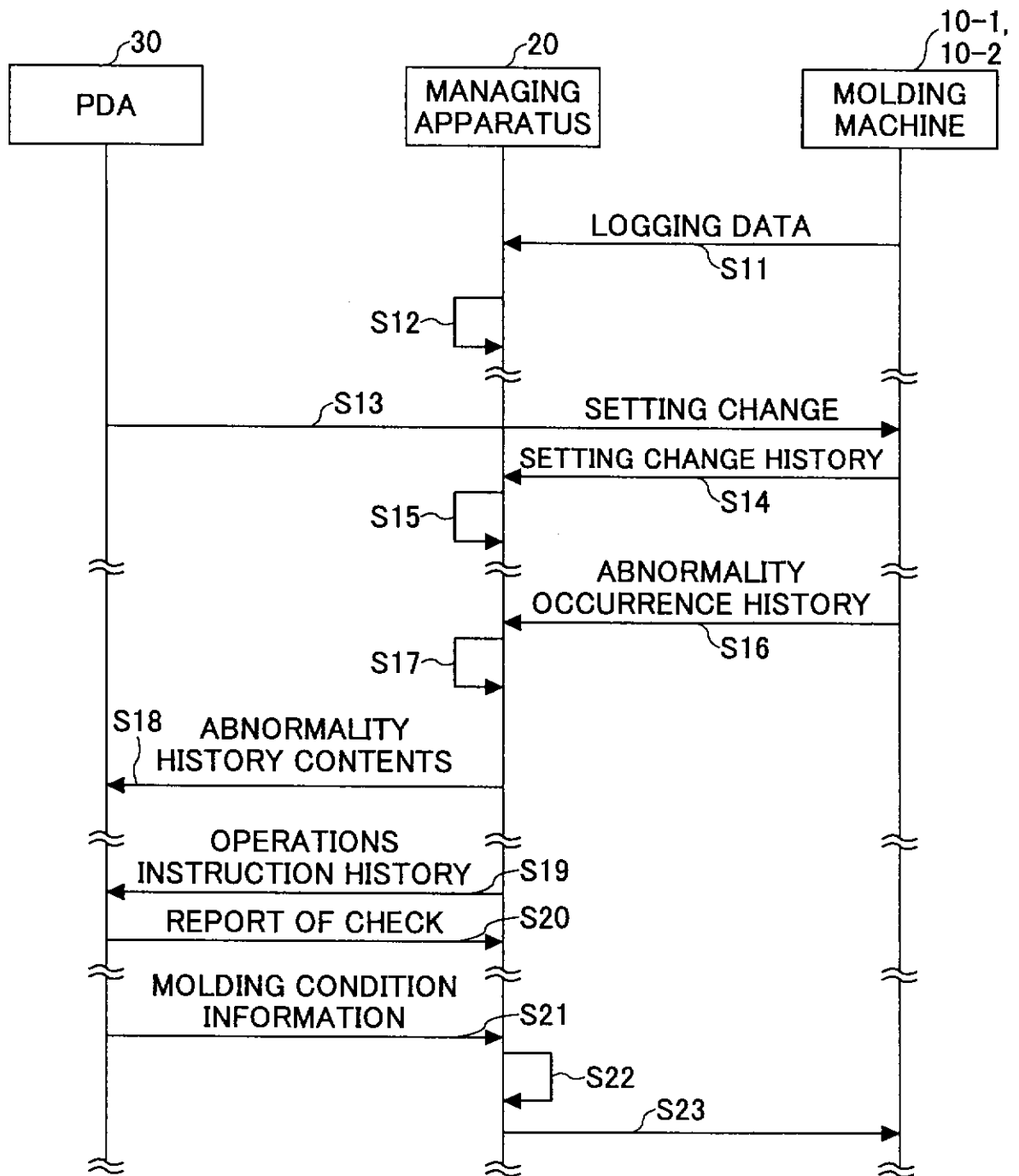


FIG. 7

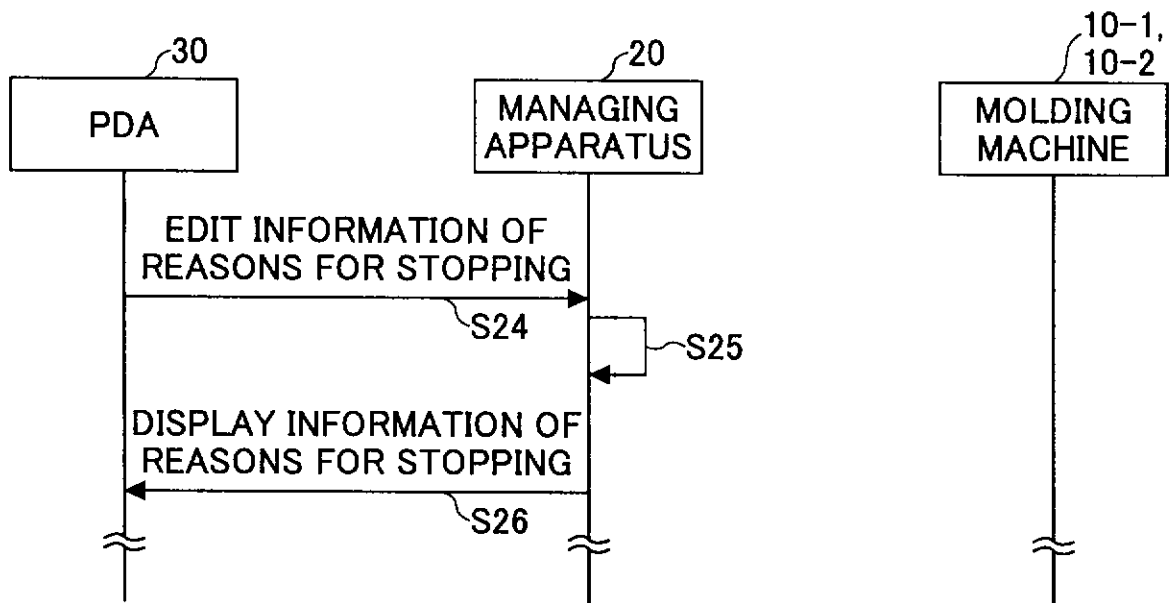


FIG.8

60

61 61 62

▲ ▼ EDIT

1ST MACHINE			
MOLDING CONDITION		INITIAL	
STATUS	ABNORMALITY OCCURS	TIME OF STOPPING	000:01:15
OCCURRENCE TIME		03/05 11:06:09	
RESTART TIME		03/05 11:07:24	
ABNORMALITY		[A000]CYCLE	
SUPPLEMENT		MOLD PROTECTION ABNORMALITY	
PERIPHERAL APPARATUS		MOLD	
REASON		PIN IS BROKEN	
OPERATOR		x x x x	
MEMO		REPAIRABLE	

FIG.9

70

		MANUFACTURING INSTRUCTION	
OPERATOR		x x x x	
1ST MACHINE		MOLDING MACHINE	
▲ ▼		EDIT	RETURN
PRODUCT		FLOWERPOT	
MOLDING CONDITION		FLOWERPOT AB	
MOLD		FLOWERPOT 001	
MATERIAL		PP	
ESTIMATED MANUFACTURED NUMBER		1000	

FIG.10

80

OPERATOR x x x x	
81	1ST MACHINE ▼
82	SELECT MENU

FIG.11

85

86

REGISTER

OPERATOR x x x x

1ST MACHINE			
MOLDING CONDITION		INITIAL	
STATUS	ABNORMALITY OCCURS	TIME OF STOPPING	000:01:15
OCCURRENCE TIME		03/05 11:06:09	
RESTART TIME		03/05 11:07:24	
ABNORMALITY		[A000]CYCLE	
SUPPLEMENT		MOLD PROTECTION ABNORMALITY	▼
PERIPHERAL APPARATUS		MOLD	▼
REASON		PIN IS BROKEN	▼
MEMO		REPAIRABLE	