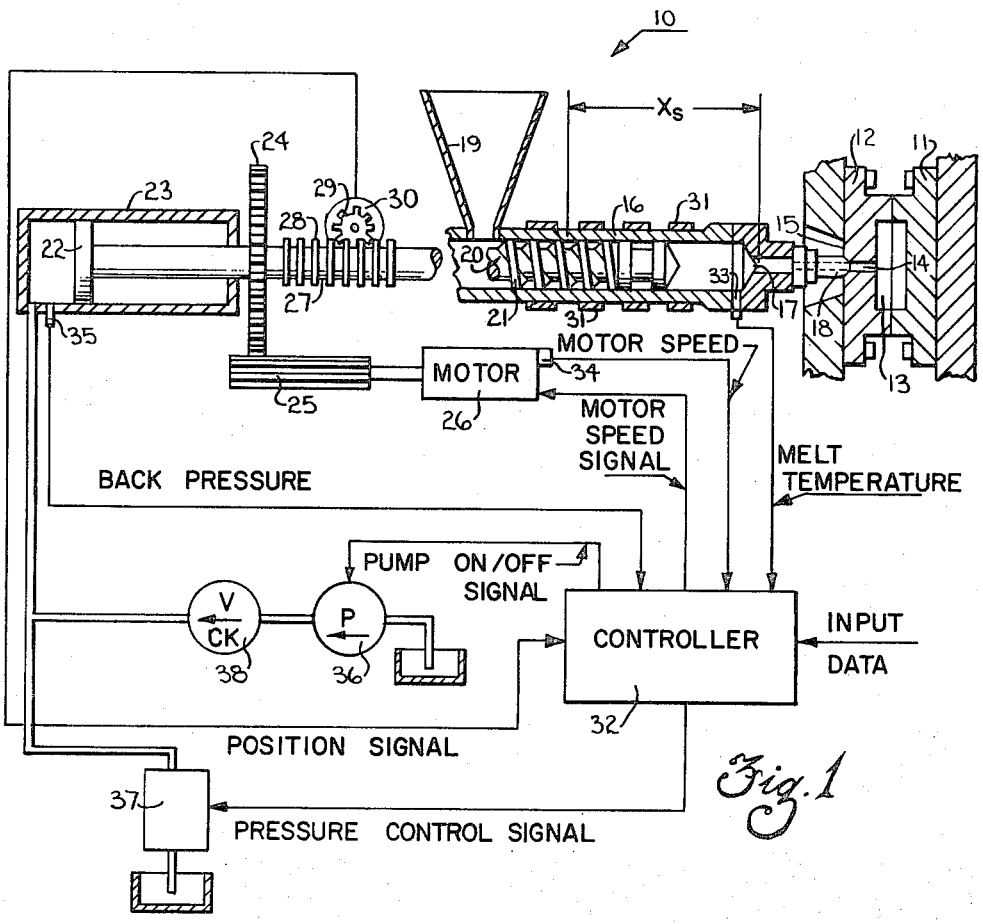
10
X_s
19
24
23
29
30
28
22
27
35
16
31
20
21
31
33
15
17
18
12
11
14
13
MOTOR SPEED
MOTOR
34
25
26
MOTOR SPEED SIGNAL
MELT TEMPERATURE
BACK PRESSURE
PUMP ON/OFF SIGNAL
V
CK
P
38
36
CONTROLLER
INPUT DATA
32
POSITION SIGNAL
37
PRESSURE CONTROL SIGNAL

Fig. 1

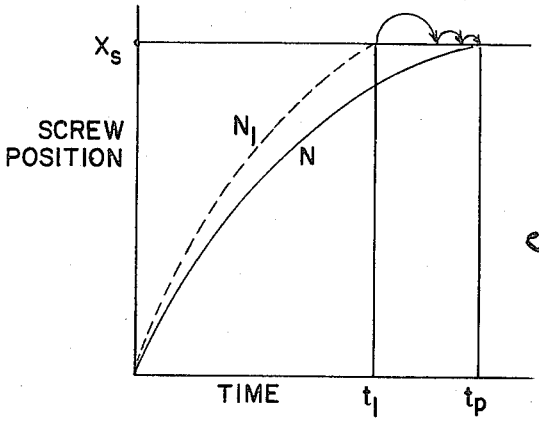
X_s
SCREW POSITION
N_1
N
TIME
t_1
t_p

Fig. 2