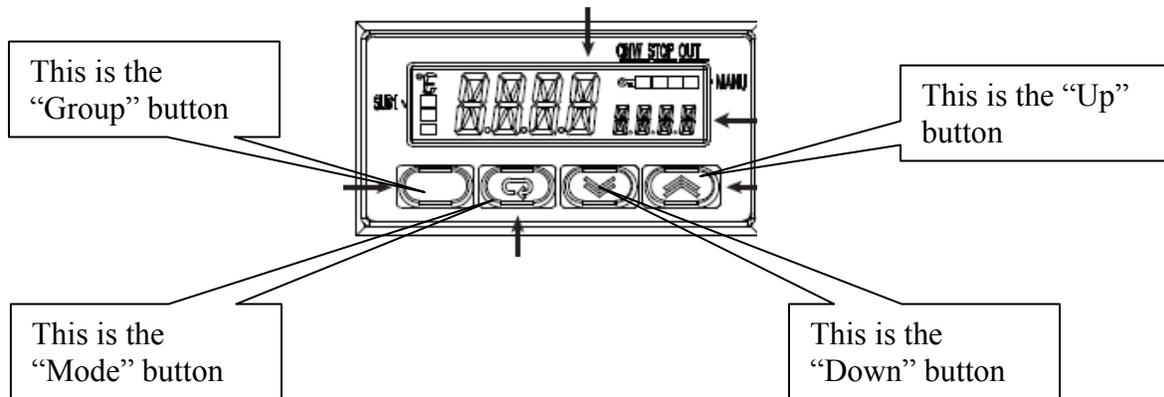


How to set the Temperature:

Example: 80 Degrees = F 80 or 200 Degrees = F200 etc.

The “Up” and “Down” buttons on the right of the display set the temperature (See the display below). If the temperature is flashing then the heater control is in tuning mode. There is an alarm on the heater that when the actual temperature falls outside a given range then it sends a fault to the control panel that stops the machine. Wait for the temperature to come back into range and reset the fault and restart the machine. If you change the temperature setting greater than 50° F or 25° C you may need to run an Auto Tune. See instructions below.

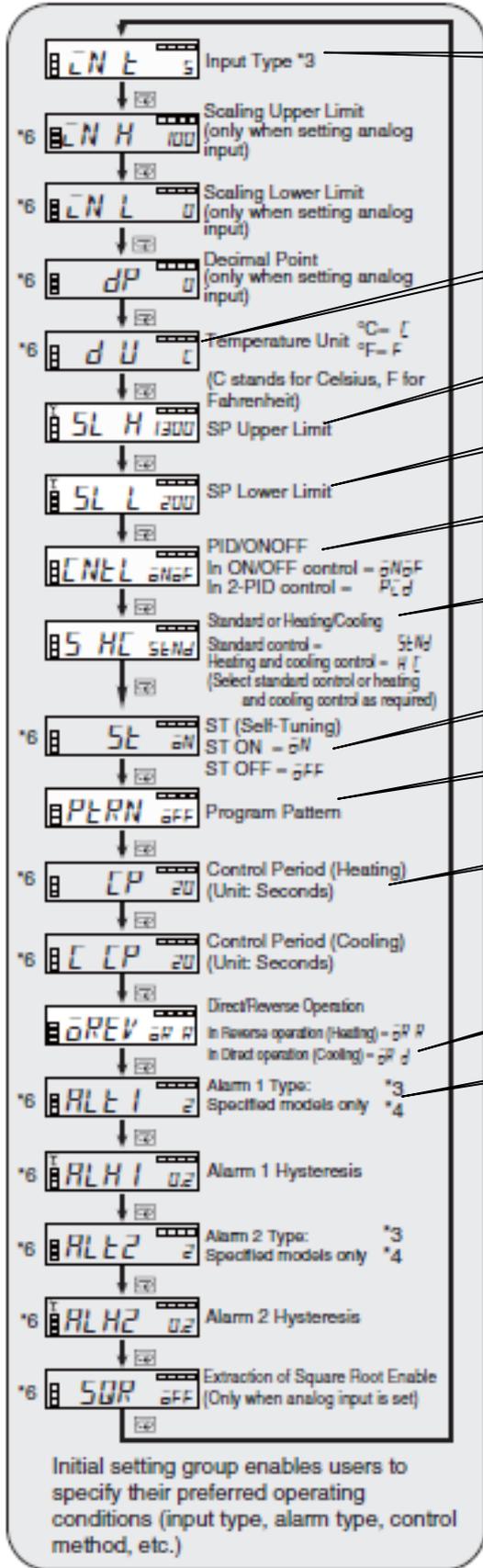
The green digital display indicates the target temperature. The red digital display indicates the actual temperature. It takes about several minutes for the heater to reach the preset temperature. **CAUTION:** It takes about 2 hours for the heater to cool off after the machine has been shut down. The faster the machine is running the higher the temperature that you want for consistently good seals.



Temperature Controller - Main Settings

The main settings should have been pre-programmed for you at Our manufacturing facility. If you should have to replace the temperature controller following are the initial settings.

Press and Hold the “Group” button for 3 seconds. You will now be in the Initial Setting Group. Press the “Mode” button to cycle through the settings. Use the settings on the following page:



Input type: 8

Temp Unit: F

750°

0°

PID

StNd

oFF

oFF

20

GR R

1

Leave all other settings in this group as they are.

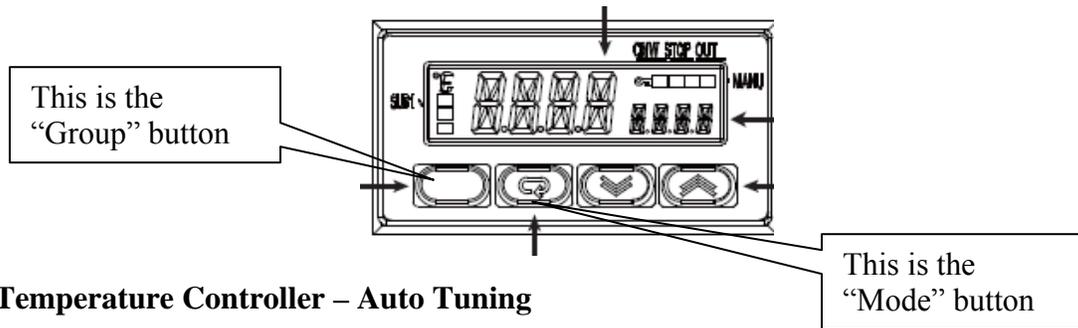
Temperature Controller – Upper and Lower Alarm Settings

There are upper and lower alarm deviations for the temperature. If the temperature gets too hot or too cold an alarm goes off and faults the machine the machine will not run until the temperature goes back into range. This prevents inconsistent sealing. There is an upper deviation and a lower deviation.

To set the deviations Press the “Mode” button twice to set the Upper deviation and press the “Mode” button a third time for the Lower deviation.

The value should be the number of degrees over or under the set point for the temperature.

(i.e. If you have the set point temperature at 400° and you have the alarm upper deviation set to 30 and the alarm lower deviation set to 25, then the machine will fault if the temperature rises above 430° or below 375°.)



Temperature Controller – Auto Tuning

If you change out the temperature controller, on the first running you will need to perform an Auto Tune. If you change the temperature set point greater than 50° F or 25° C, you will need to perform an Auto Tune.

Press the “Mode” button once. Then press the “Group” button once. Then press the “Mode” button once again.

Set the Auto Tune to “on”.

Press the “Group” button once to exit the menu and the temperature should now be flashing. The flashing temperature tells you that the machine is auto tuning.

You may want to Auto Tune the machine while it is dry cycling to emulate an operational state.

While Auto Tuning the machine will deviate greatly. You may need to temporarily change the alarm deviations to accommodate the fluctuation. Then reset them after the Auto Tune is complete.