

Identifier Service SH	Service Document	
I-S-PU-01 How to create a program in VPC Pure		Römerstr. 21 D – 71296 Heimsheim Tel.: + 49(0)7033-309878-41 service@schultheiss-gmbh.de http://www.schultheiss-gmbh.de

Apply for:

Machine Type	Version	Year
VPC Pure/66/100	all	Since release

Problem

How to create a program in VPC Pure

Prerequisites

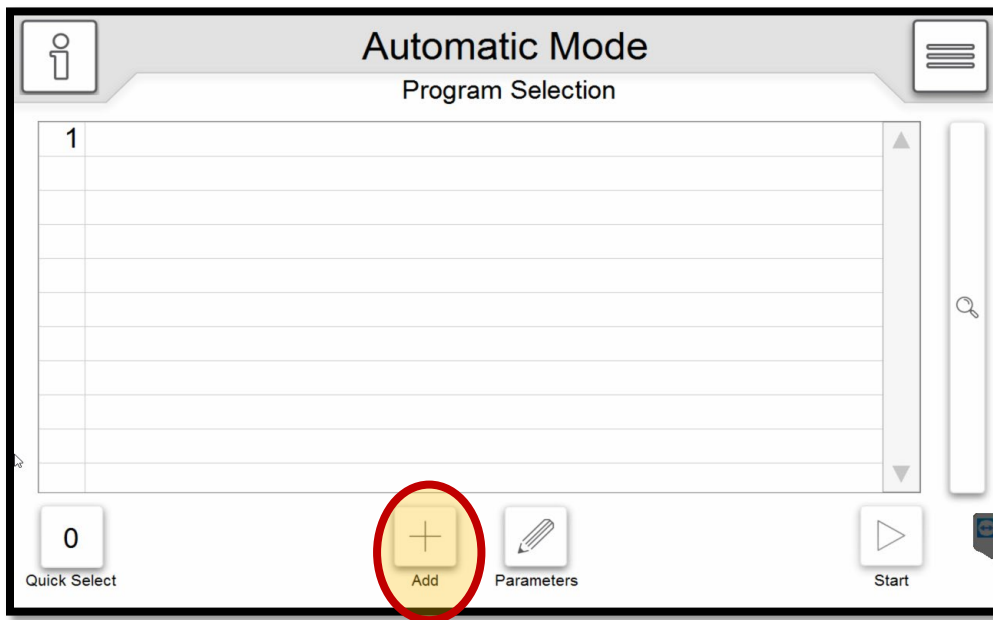
- Check the procedure or video how to select language correctly
- Check Correct Thermocouple is installed and selected in the settings

Procedure

- Switch ON the machine
- Wait until the software bootup is completed



- Press  to create a new program in automatic mode



- Select **New Program** to change program name

Automatic Mode
Program Parameters Configuration

Program Name
New Program

none Casting Options 1000 Set Temp. [°C]
Medium Material Weight 100 Max. Power [%]
☐ Auto Cast 2 Main Pressure [bar]
☐ Flask from Begin 2 Injection Press. [bar]
☐ Flangeless Flask / Injection Casting -0.9 Diff. Press. [bar]
2 Main Press. Start [s]

Save Save As
Delete Advanced Parameters

Back Start

- Click **Clear** to clear name bar

Automatic Mode
Program Parameters Configuration

Program Name
New Program

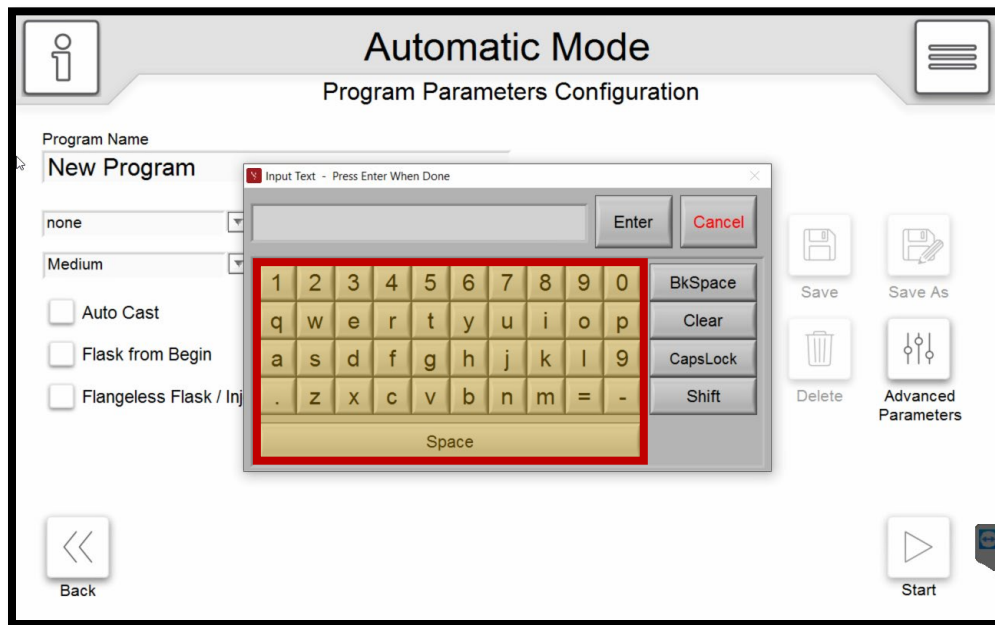
none Casting Options 1000 Set Temp. [°C]
Medium Material Weight 100 Max. Power [%]
☐ Auto Cast 2 Main Pressure [bar]
☐ Flask from Begin 2 Injection Press. [bar]
☐ Flangeless Flask / Inj -0.9 Diff. Press. [bar]
2 Main Press. Start [s]

Save Save As
Delete Advanced Parameters

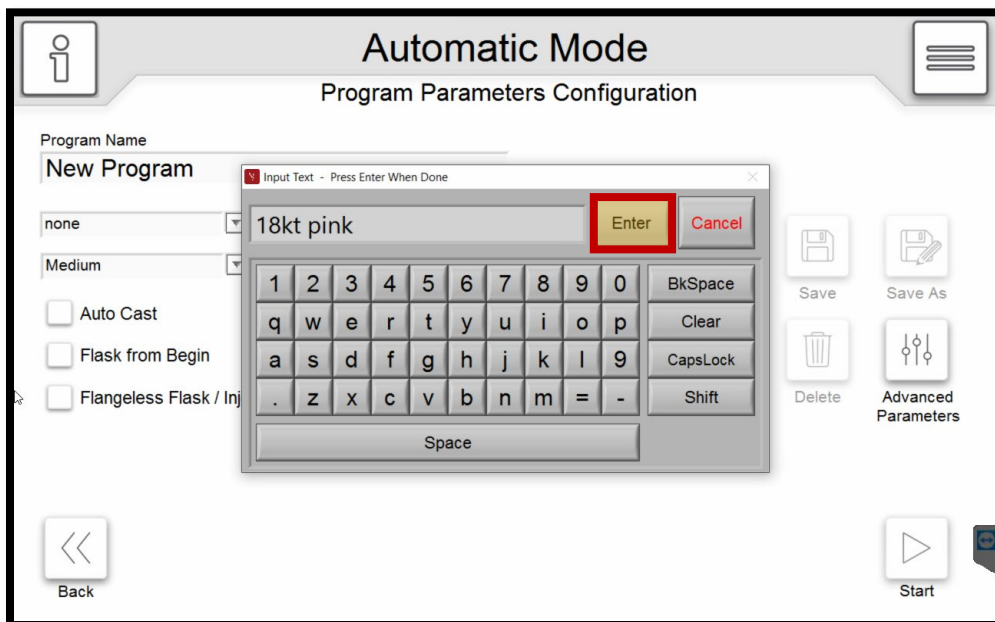
Back Start

Input Text - Press Enter When Done
New Program
Enter Cancel
1 2 3 4 5 6 7 8 9 0 BkSpace
q w e r t y u i o p Clear
a s d f g h j k l ; ' CapsLock
. z x c v b n m = - Shift
Space

- Use On-Screen Keyboard to Enter desired program name



- Press  to take over the new program name e.g. 18kt Pint



- Click  to save a new program

Automatic Mode
Program Parameters Configuration

Program Name
18kt pink

none	▼ Casting Options	1000	Set Temp. [°C]
Medium	▼ Material Weight	100	Max. Power [%]
☐ Auto Cast		2	Main Pressure [bar]
☐ Flask from Begin		2	Injection Press. [bar]
☐ Flangeless Flask / Injection Casting		-0.9	Diff. Press. [bar]
		2	Main Press. Start [s]

Save As (highlighted)

Delete Advanced Parameters

Back Start

- Change desired program parameter. Similarly follow the screen and adjust the parameters as per the table

Automatic Mode
Program Parameters Configuration

Program Name
18kt pink

none	▼ Casting Options	1000	Set Temp. [°C]
Medium	▼ Material Weight	100	Max. Power [%]
☐ Auto Cast		2	Main Pressure [bar]
☐ Flask from Begin		0	Injection Press. [bar]
☐ Flangeless Flask / Injection Casting		-0.9	Diff. Press. [bar]
		2	Main Press. Start [s]

Save Save As

Delete Advanced Parameters

Back Start

Parameters	Possible values
Auto cast	Yes / NO
Flask from begin	Yes / NO
Flangeless Flask / Injection Casting	Yes / NO
Set Temperature °C	0 to 1450° *
Max Power (%)	0.0 to 100
Main pressure (bar)	0.0 to 4.0
Injection Pressure (bar)	0.0 to -0.7
Diff pressure (bar)	0.0 to -0.9
Main Press. Start (seconds)	0.0 to 10
Mixing time (seconds)	0.0 to 30

*Based on the type of thermocouple

Automatic Mode

Program Parameters Configuration

Program Name

none

▼

Casting Options

1050

Set Temp. [°C]

Medium

▼

Material Weight

100

Max. Power [%]

☒ Auto Cast

1,5

Main Pressure [bar]

☐ Flask from Begin

-0,2

Injection Press. [bar]

☒ Flangeless Flask / Injection Casting

-0,7

Diff. Press. [bar]

2

Main Press. Start [s]

Save

Save As

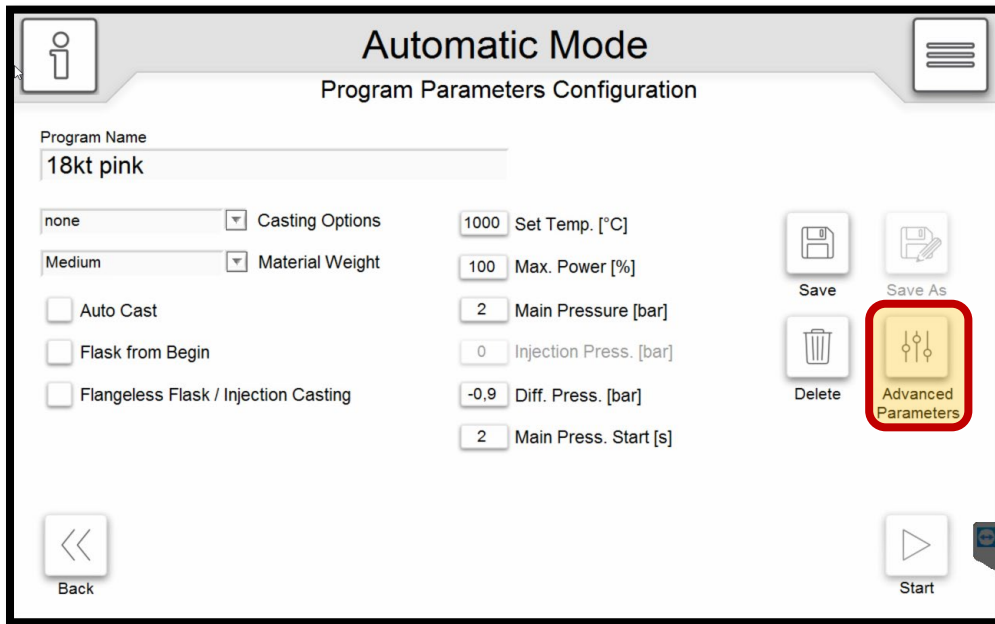
Delete

Advanced Parameters

Back

Start

- Click  to enter advanced parameter
Advanced Parameters



Automatic Mode
Program Parameters Configuration

Program Name
18kt pink

none Casting Options
Medium Material Weight

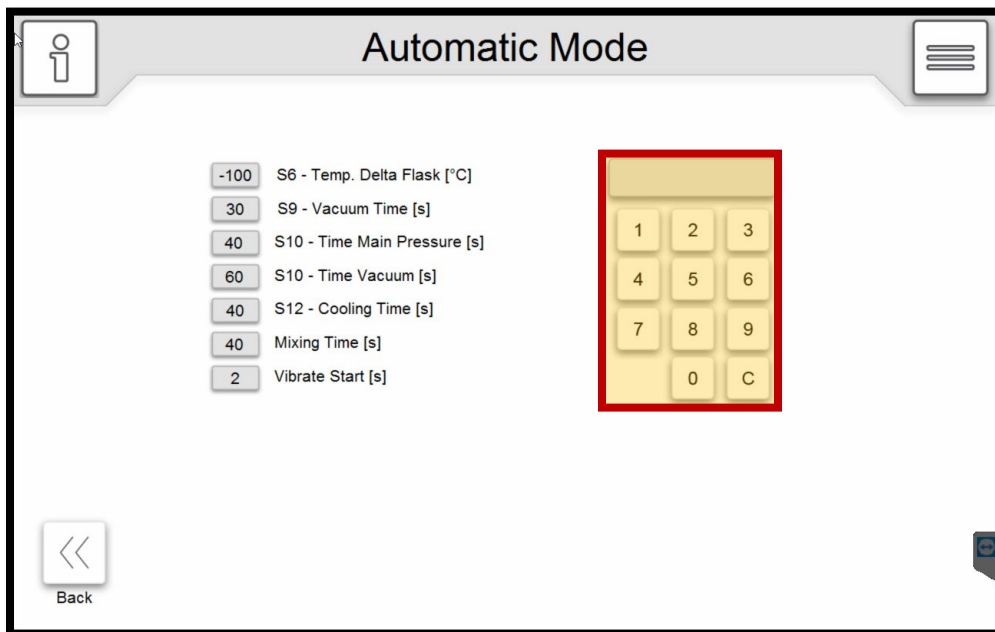
☐ Auto Cast
☐ Flask from Begin
☐ Flangeless Flask / Injection Casting

1000 Set Temp. [°C]
100 Max. Power [%]
2 Main Pressure [bar]
0 Injection Press. [bar]
-0.9 Diff. Press. [bar]
2 Main Press. Start [s]

Save Save As
Delete Advanced Parameters

Back Start

- Use On-Screen Keypad to enter advanced parameter code “1234”



Automatic Mode

-100 S6 - Temp. Delta Flask [°C]
30 S9 - Vacuum Time [s]
40 S10 - Time Main Pressure [s]
60 S10 - Time Vacuum [s]
40 S12 - Cooling Time [s]
40 Mixing Time [s]
2 Vibrate Start [s]

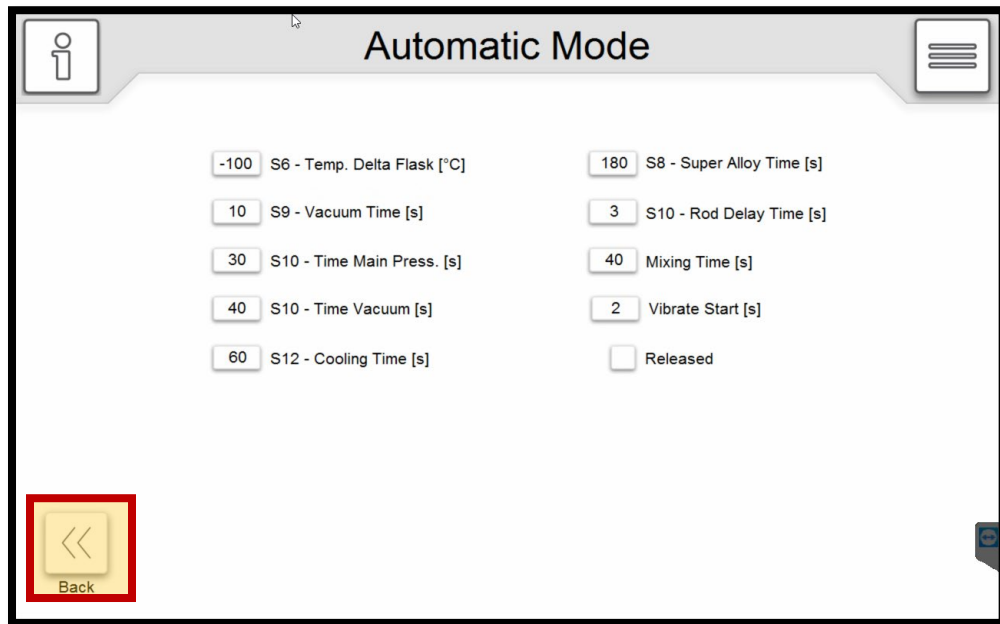
1 2 3
4 5 6
7 8 9
0 C

Back

- Adjust the desired advanced parameter

Parameters	Explanation
S6 – temp delta flask	How early from Set temperature should flask chamber open to put the flask in it.
S9 - Vacuum Time (seconds)	How long should vacuum values be held in casting preparation in Step 9
S10 – Time Main Pressure (seconds)	How long should main pressure be held during casting in Step 10
S10 - Vacuum Time (seconds)	How long should vacuum in chambers be held in casting in Step 10
Mixing time (seconds)	How long should the Set temperature be held to do the mixing
Vibrate Start (seconds)	When should the vibration start during casting at Step 10
S8 – Super alloy	Default
Stopper Rod Delay (seconds)	Default

- Click  to get back to the program parameter

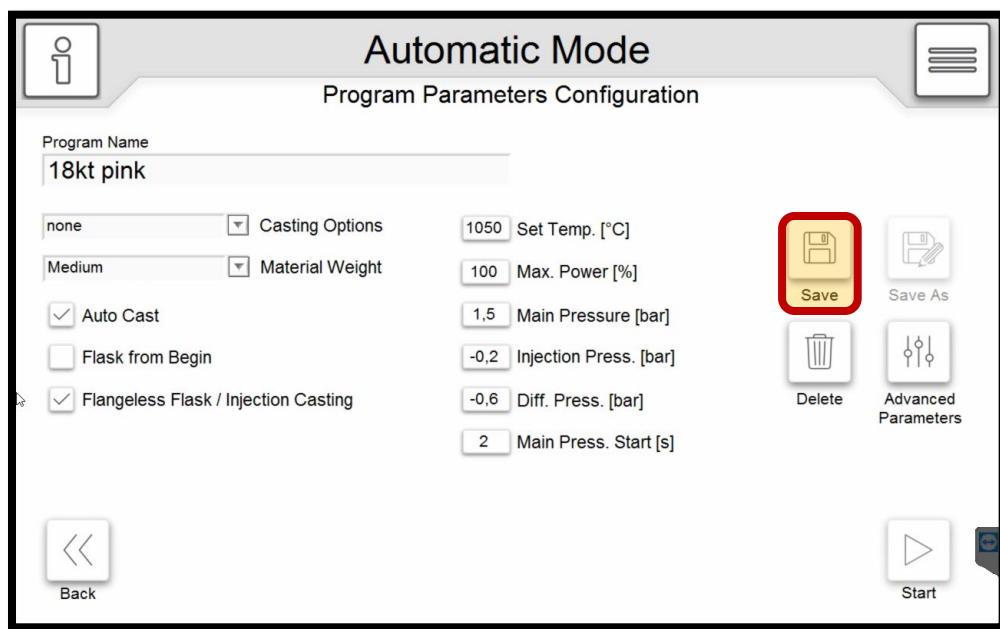


Automatic Mode

-100 S6 - Temp. Delta Flask [°C]	180 S8 - Super Alloy Time [s]
10 S9 - Vacuum Time [s]	3 S10 - Rod Delay Time [s]
30 S10 - Time Main Press. [s]	40 Mixing Time [s]
40 S10 - Time Vacuum [s]	2 Vibrate Start [s]
60 S12 - Cooling Time [s]	☐ Released

 Back

- Click  to save the program parameter



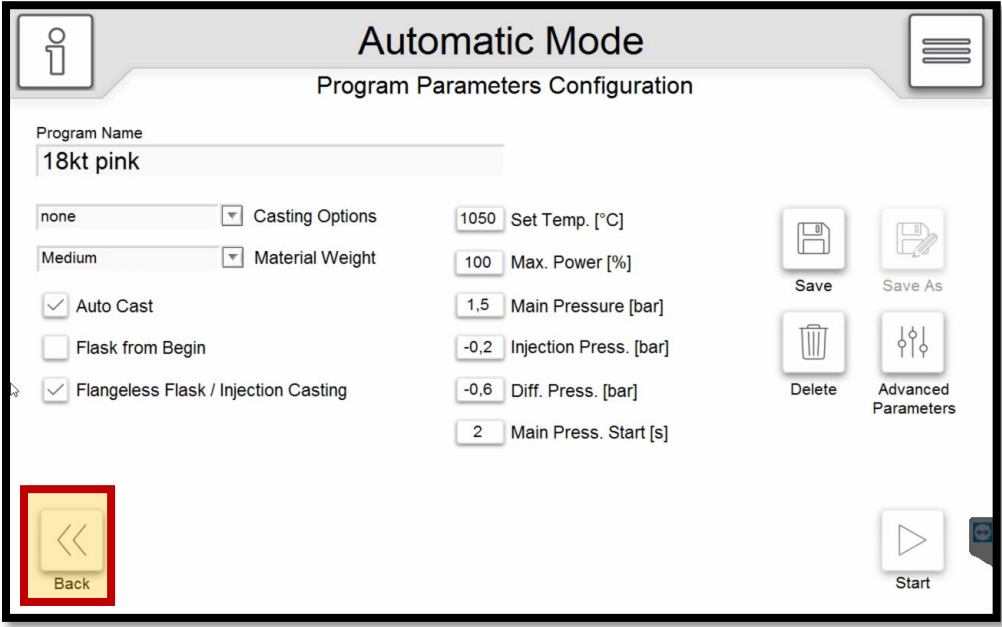
Automatic Mode
Program Parameters Configuration

Program Name
18kt pink

none Casting Options	1050 Set Temp. [°C]	 Save  Save As  Delete  Advanced Parameters
Medium Material Weight	100 Max. Power [%]	
☒ Auto Cast	1,5 Main Pressure [bar]	
☐ Flask from Begin	-0,2 Injection Press. [bar]	
☒ Flangeless Flask / Injection Casting	-0,6 Diff. Press. [bar]	
	2 Main Press. Start [s]	

 Back  Start

- Click  to go back to program selection in automatic mode



Automatic Mode

Program Parameters Configuration

Program Name
18kt pink

none Casting Options 1050 Set Temp. [°C]

Medium Material Weight 100 Max. Power [%]

☒ Auto Cast 1,5 Main Pressure [bar]

☐ Flask from Begin -0,2 Injection Press. [bar]

☒ Flangeless Flask / Injection Casting -0,6 Diff. Press. [bar]

2 Main Press. Start [s]

Save Save As

Delete Advanced Parameters

Back Start

- To run the selected program, Press the GREEN button under the display

In case the problem still exists, please feel free to contact us again.

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