


Identifier  Service SH	<b>Service Document</b>	
<b>I-S-40-01 How to Create program in VPC 40</b>		Römerstr. 21 D – 71296 Heimsheim Tel.: + 49(0)7033-309878-41 <a href="mailto:service@schultheiss-gmbh.de">service@schultheiss-gmbh.de</a> <a href="http://www.schultheiss-gmbh.de">http://www.schultheiss-gmbh.de</a>

Apply for:

Machine Type	Version	Year
VPC 40	Since Release	

## Problem

How to Create program in VPC 40



## Prerequisites

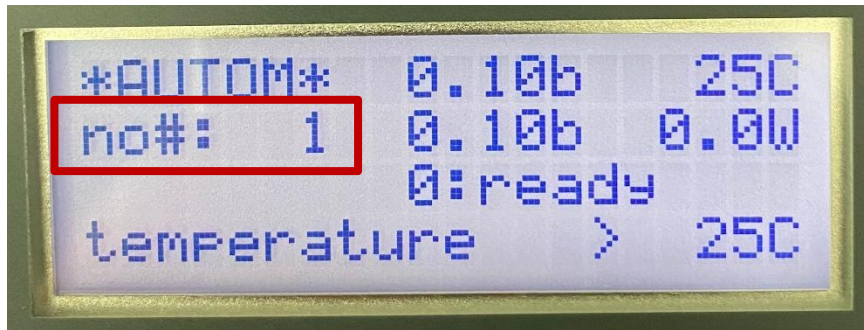
The following are the maximum and minimum limits of the parameters needed to be aware of.



Parameters	Possible values
Temperature	0 to 1450°C *
diff-pressure	0.0 to -0.9 bar
main pressure	0.0 to 2.0 bar
main-pr. Start	0.0 to 9.9 sec
start cast autom	0 or 1
flask in fr.start	0 or 1
vibrate start	0.0 to 9.9 sec
degassing time	0.0 to 99 sec
mixing time	0.0 to 99 sec
power max	0.0 to 100%

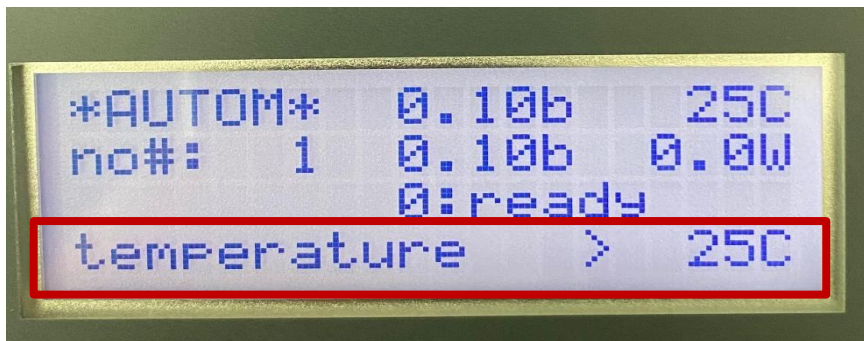
\*Based on the type of thermocouple








## Procedure

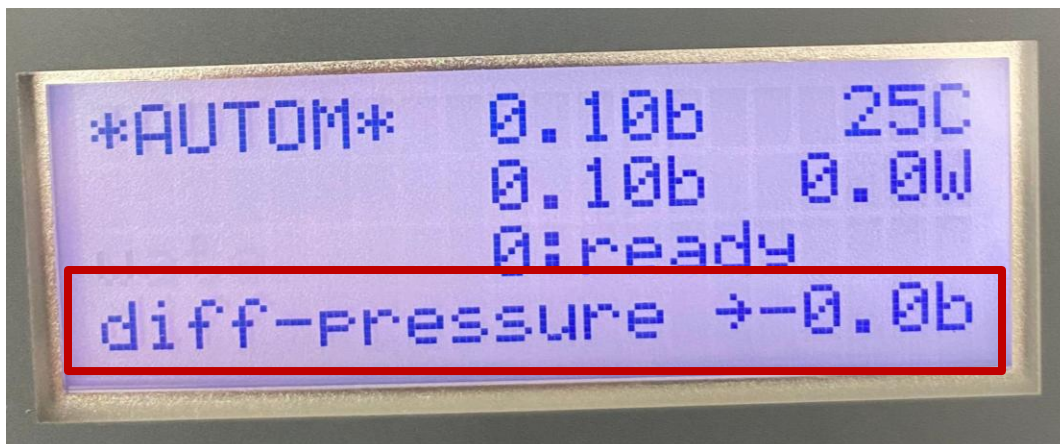
- Turn On the machine and wait until the self-testing is completed.
- Press  'M' to enter the Automatic Program mode
- The arrow indicates which program # is selected. This can be changed by Press Enter and then Up and Down key to select the program # and then confirm it by pressing  'E'.



- Press  'Down', to go to Set Temperature
- Press  'E' to make changes in the temperature the arrow tail will change meaning so that it can be edited







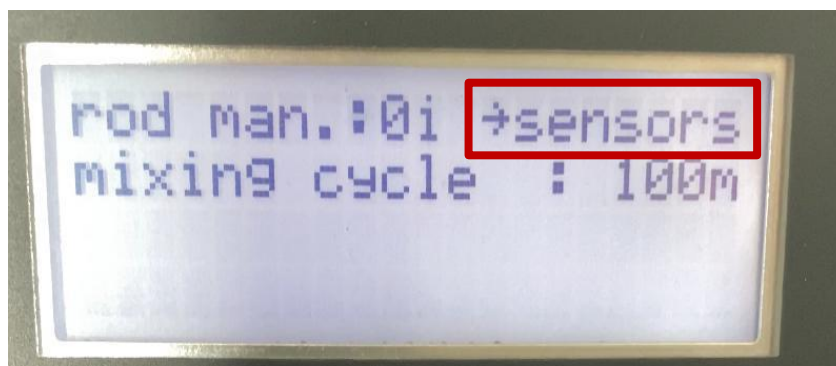
- To reach the desired temperature the value, Press **Up**  and **Down**. 
- Press **E**  to save the temperature.
- Press **'Down'**  to go to **Differential Pressure**
- Press **'E'**  to make changes in the Differential Pressure.
- To reach the desired value, Press **Up**  and **Down**  **Down**  
(Suggestion: start with mid value i.e. -0.5b and then experiment)



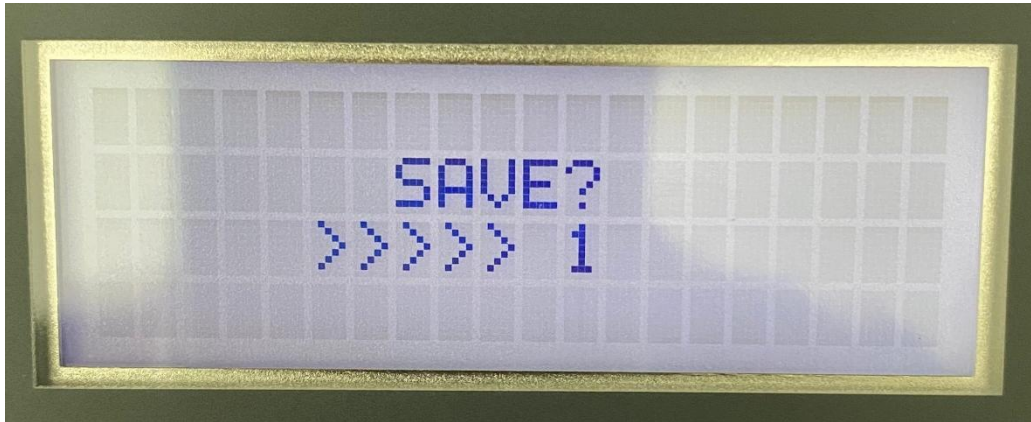
- Similarly follow the screen and adjust the parameters as per the table

Parameters	Possible values
Temperature	0 to 1450°C *
diff-pressure	0.0 to -0.9 bar
main pressure	0.0 to 2.0 bar
main-pr. Start	0.0 to 9.9 sec
start cast autom	0 or 1
flask in fr.start	0 or 1
vibrate start	0.0 to 9.9 sec
degassing time	0 to 99 sec
mixing time	0 to 99 sec
power max	0 to 100%

- Press  'E' to make changes in the Differential Pressure.
- To reach the desired value, Press  **Up** and  **Down**
- After setting all the parameters, scroll down to Sensor menu, Press 



- To save the program change the value from **0 to 1**



- Press  'E' to confirm

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

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