


| | | |
|--|-------------------------|---|
| 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

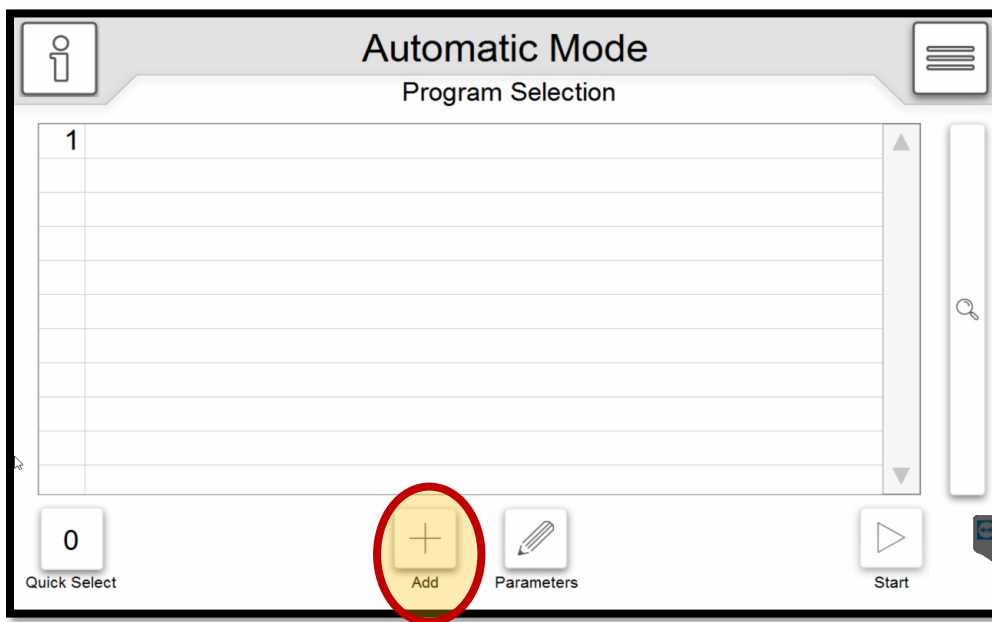
- Check the procedure or video how to select language correctly
- Check Correct Thermocouple is installed and selected in the settings

Procedure

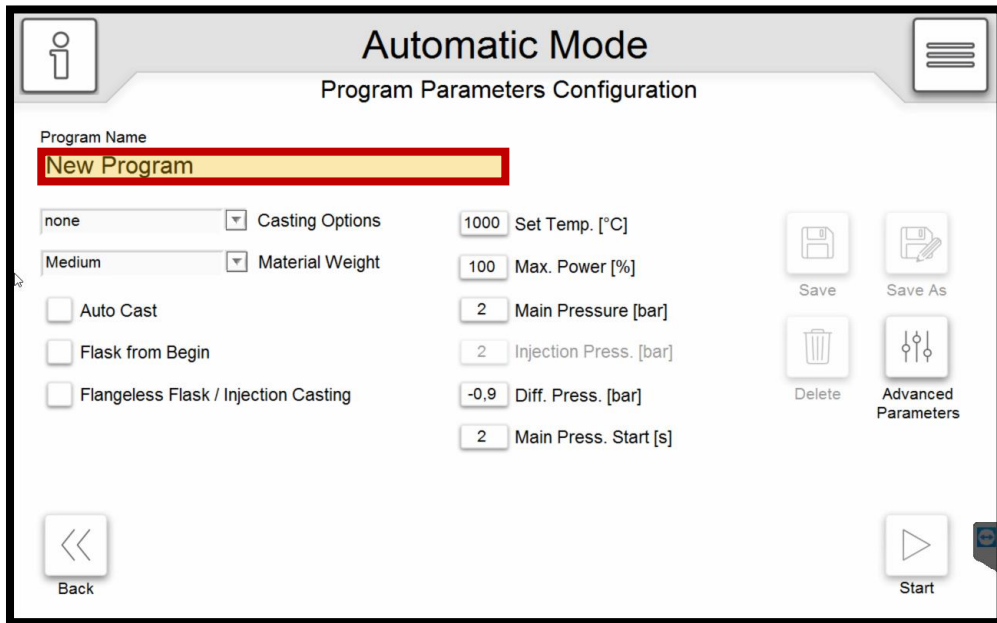
- Switch ON the machine
- Wait until the software bootup is completed



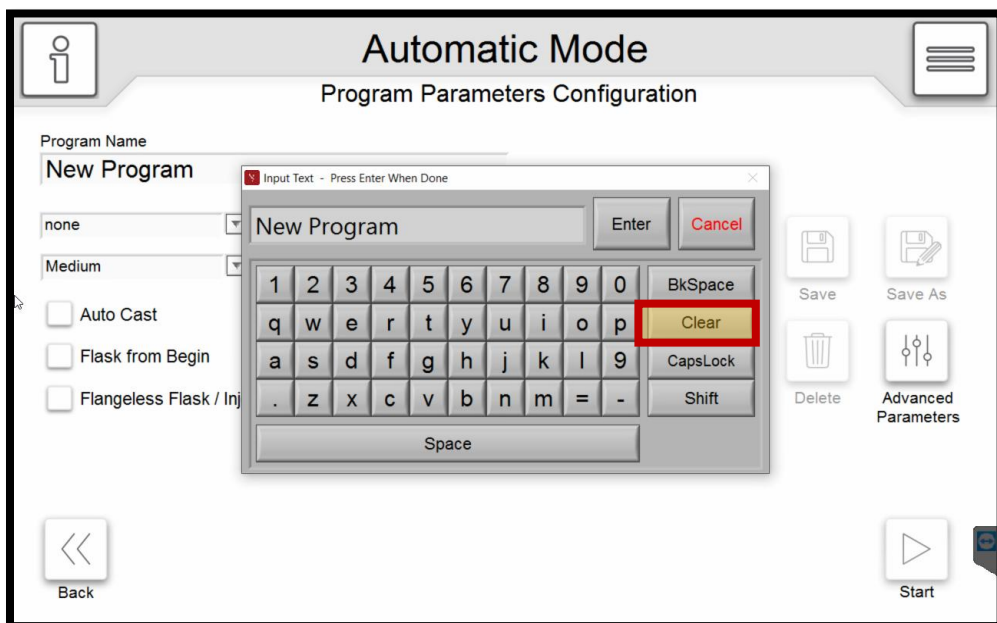
- Press  to create a new program in automatic mode



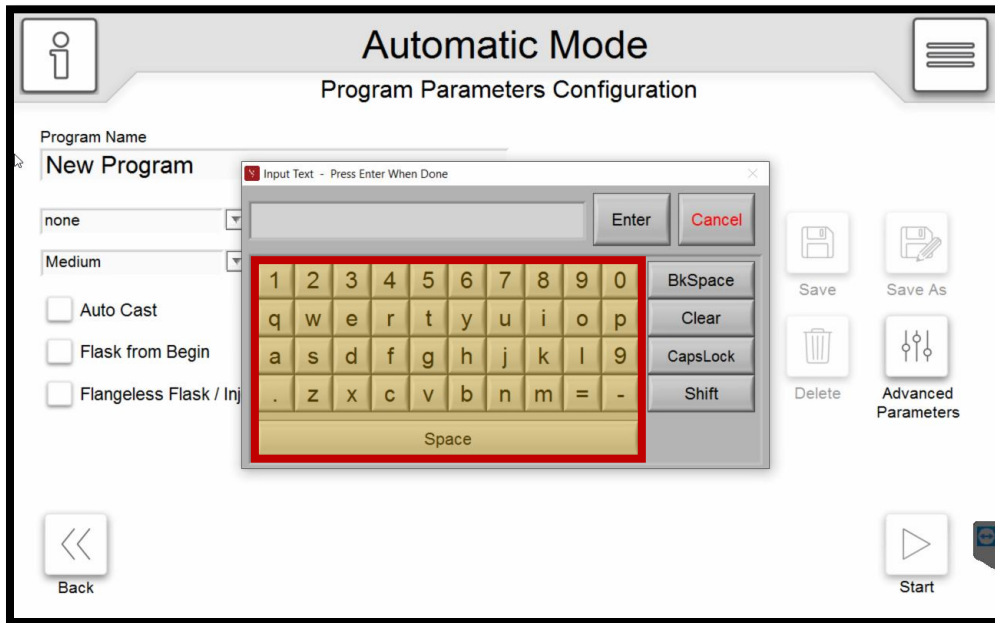
- Select **New Program** to change program name




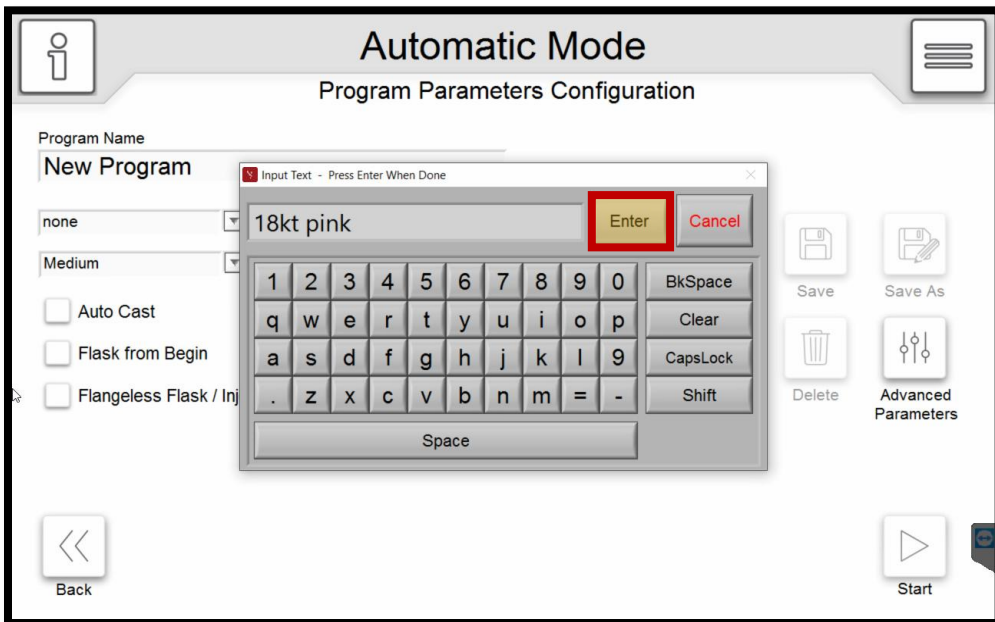
- Click **Clear** to clear name bar



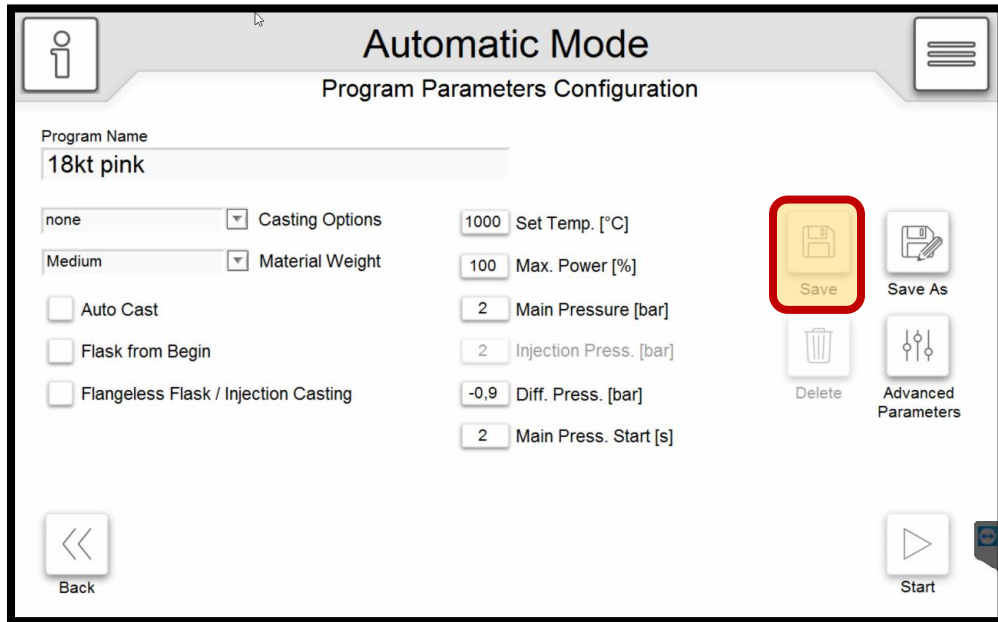
- Use On-Screen Keyboard to Enter desired program name



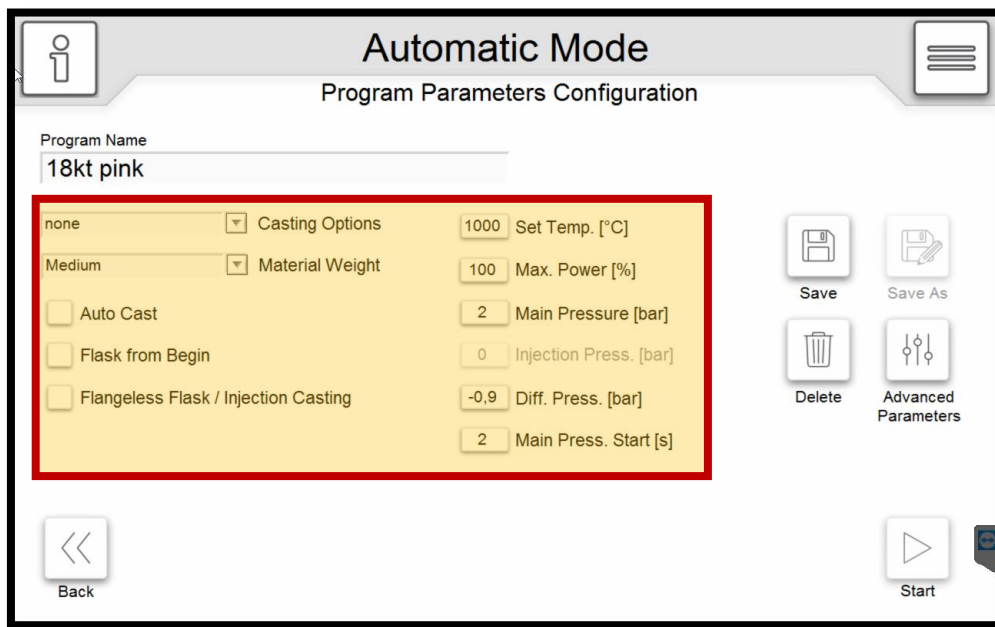
- Press  to take over the new program name e.g. 18kt Pint



- Click  to save a new program




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




| 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
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 -0,7 Diff. Press. [bar]


2 Main Press. Start [s]






Save Save As







Delete Advanced Parameters

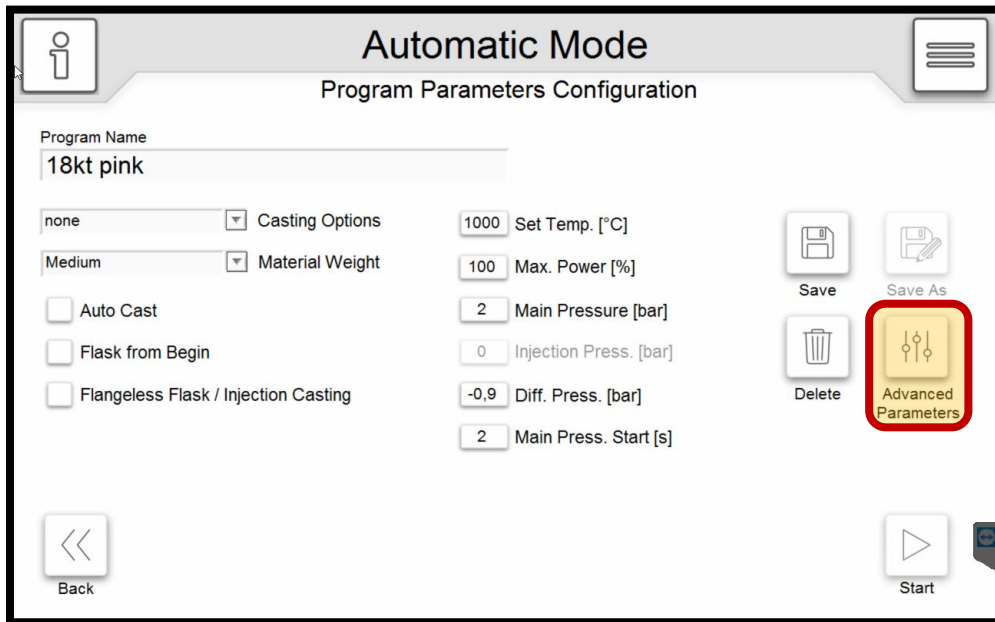


Back

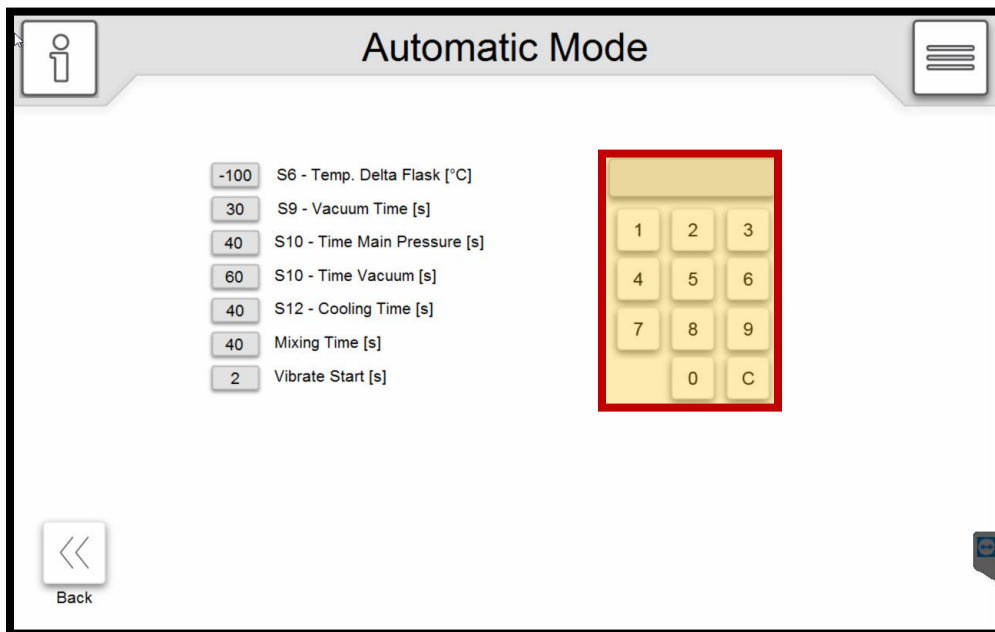


Start

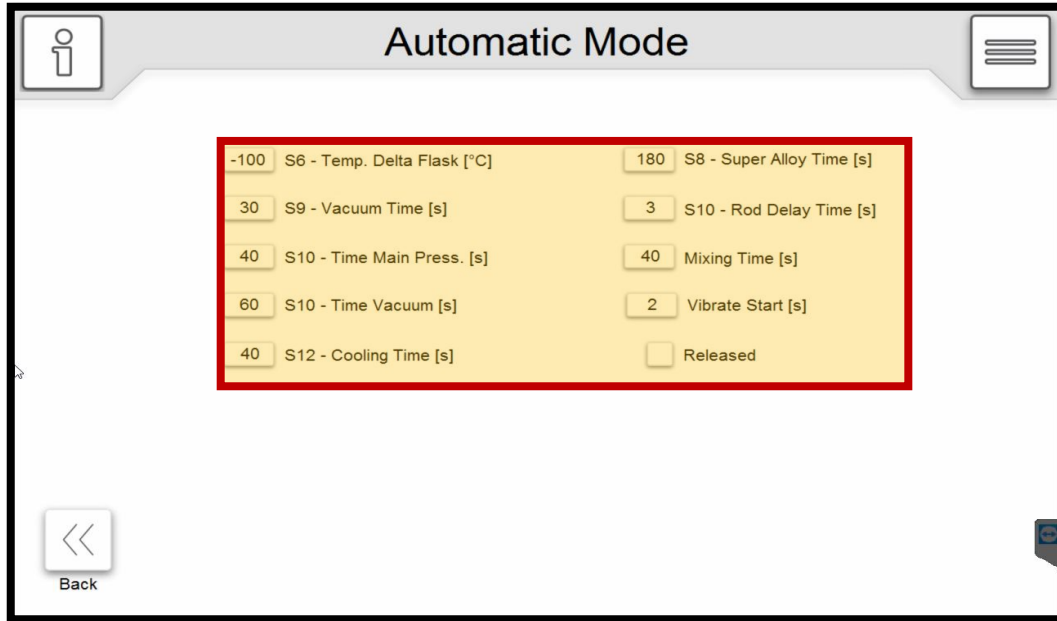
- Click  to enter advanced parameter
Advanced Parameters




- Use On-Screen Keypad to enter advanced parameter code "1234"

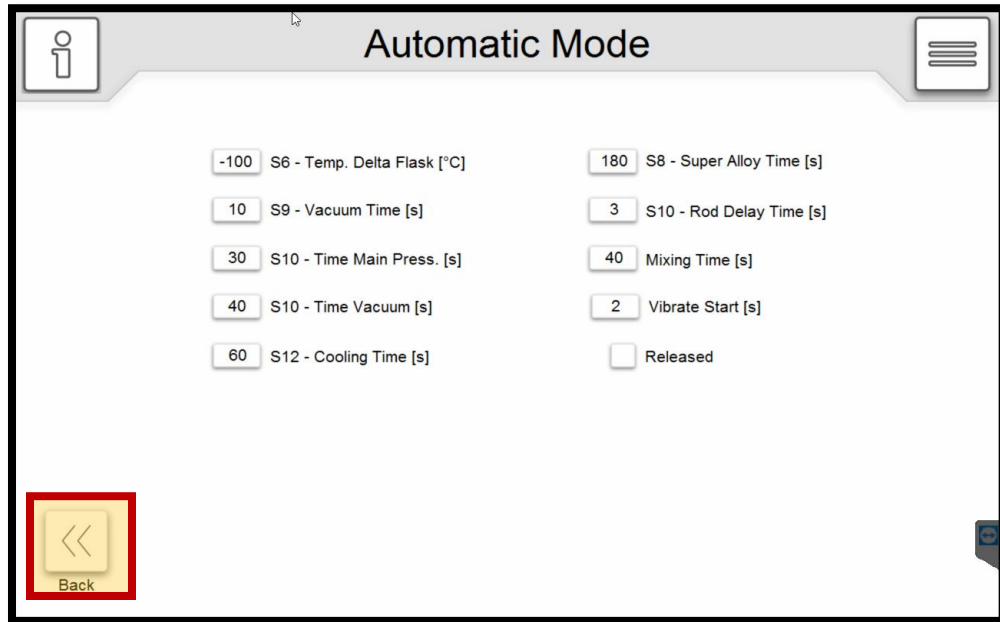



- Adjust the desired advanced parameter

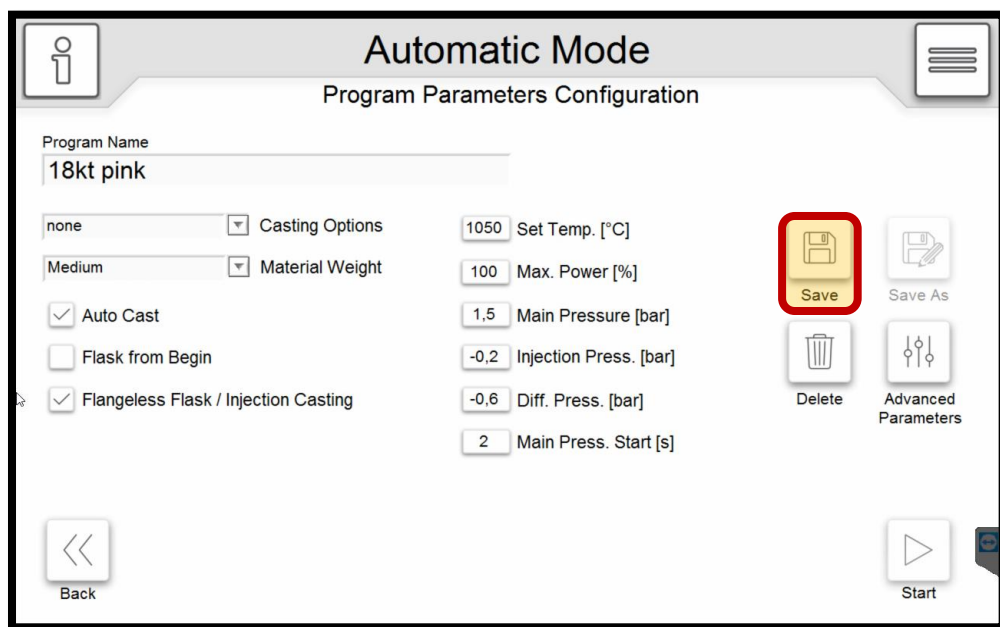



| Parameters | Explanation |
|------------------------------------|--|
| S6 – temp delta flask | How early from Set temperature should flask chamber open to put the flask in it. |
| S9 - Vacuum Time (seconds) | How long should vacuum values be held in casting preparation in Step 9 |
| S10 – Time Main 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 |

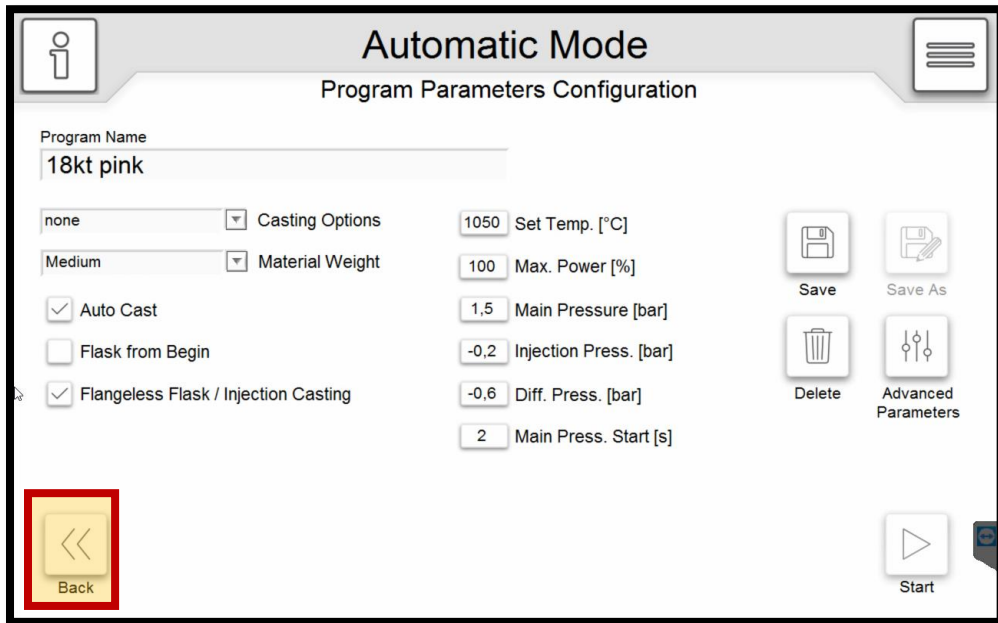
- Click  to get back to the program parameter



- Click  to save the program parameter



- Click  to go back to program selection in automatic mode



- 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.

E-Mail: service@schultheiss-gmbh.de

Schultheiss GmbH