


Identifier  Service SH	<h1>Service Document</h1>	
<h2>How to solve S3 - Degassing Error</h2>		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>

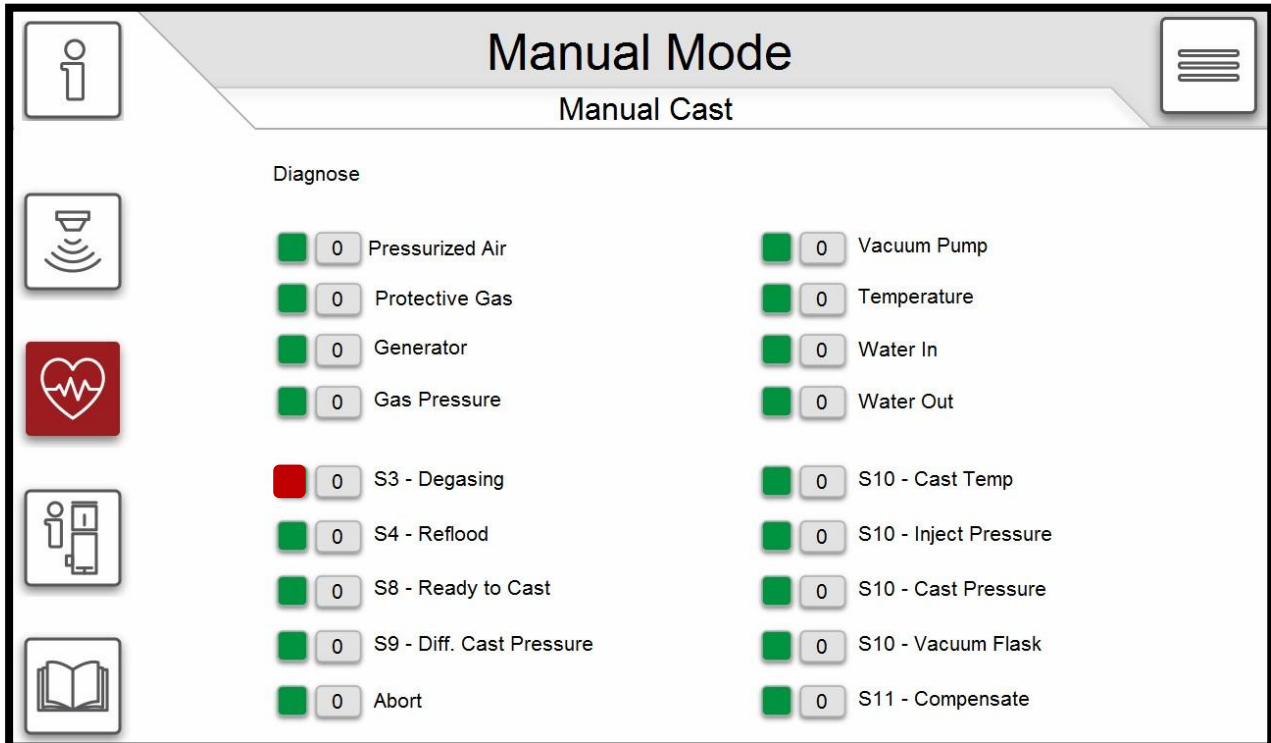
Apply for:

Machine Type	Version	Year
VPC66/100/Pure	All	Since Release

## Problem

**S3 - Degassing Error** occurs when the vacuum in both chambers does not reach -0.99bars at step 3 in Automatic mode

S3 Error will appear in the **Diagnose** Menu



**Manual Mode**  
Manual Cast

Diagnose

<input checked="" type="checkbox"/> 0 Pressurized Air	<input checked="" type="checkbox"/> 0 Vacuum Pump
<input checked="" type="checkbox"/> 0 Protective Gas	<input checked="" type="checkbox"/> 0 Temperature
<input checked="" type="checkbox"/> 0 Generator	<input checked="" type="checkbox"/> 0 Water In
<input checked="" type="checkbox"/> 0 Gas Pressure	<input checked="" type="checkbox"/> 0 Water Out
<input checked="" type="checkbox"/> 0 S3 - Degassing	<input checked="" type="checkbox"/> 0 S10 - Cast Temp
<input checked="" type="checkbox"/> 0 S4 - Reflood	<input checked="" type="checkbox"/> 0 S10 - Inject Pressure
<input checked="" type="checkbox"/> 0 S8 - Ready to Cast	<input checked="" type="checkbox"/> 0 S10 - Cast Pressure
<input checked="" type="checkbox"/> 0 S9 - Diff. Cast Pressure	<input checked="" type="checkbox"/> 0 S10 - Vacuum Flask
<input checked="" type="checkbox"/> 0 Abort	<input checked="" type="checkbox"/> 0 S11 - Compensate

# Warning and Hazards



## Procedure

- Checking the Filters

If the vacuum is not being created, the reason could be the vacuum pump or machine filter is full of dirt and needs to be cleaned

- Open the left panel of the machine



- The filter is at the bottom left side



- Remove the casing by turning it clockwise and clean it with vacuum cleaner



- Take out the filter and clean it with Vacuum cleaner



*Don't use pressurized Air, It will damage the filter*

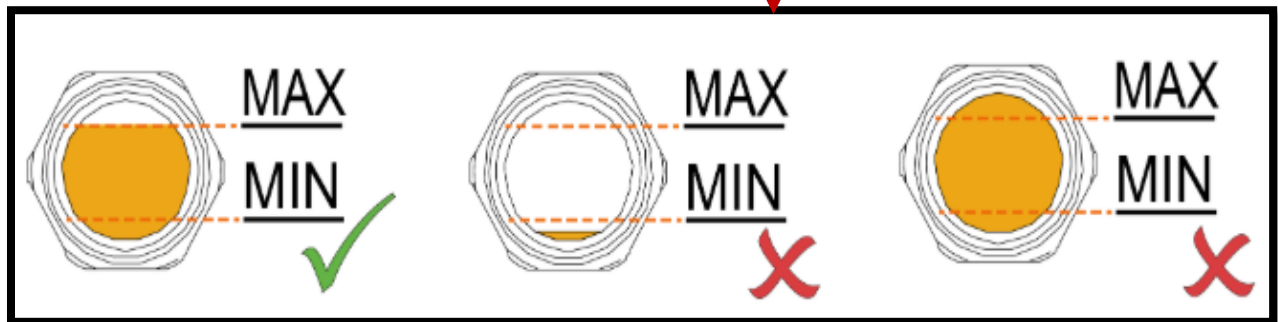
- Assemble it back correctly
- Open the filter chamber of the Pump, by unhooking the clips



- Take out the filter and clean it with Vacuum cleaner
- Don't use pressurized Air, It will damage the filter
- Assemble it back

## ○ Vacuum pump Oil

- Shut down the machine
- When the machine is stopped, wait 1 minute before checking the oil level
- Check the vacuum pump oil level
- It should be filled with more than half of the viewing glass
- If it is too dirty, replace the oil based on pump's operating manual

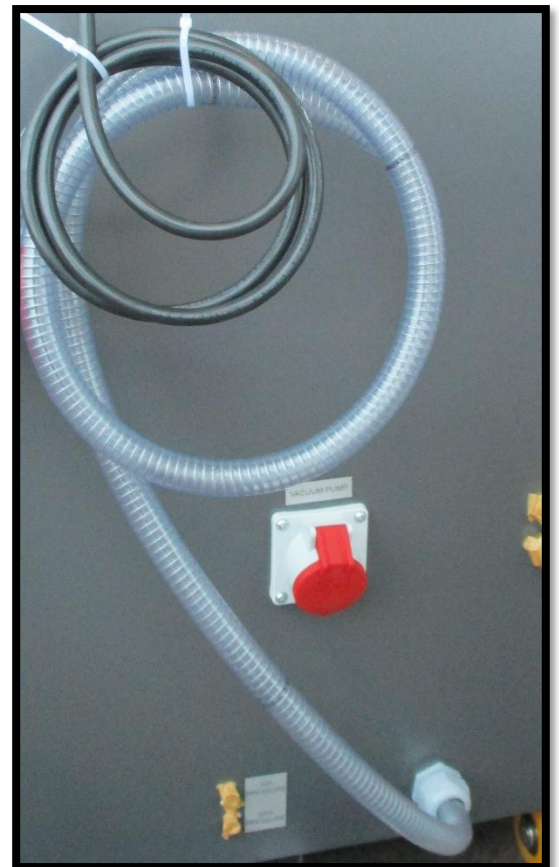


- Check vacuum spiral pipe

- Open the left Panel of the machine
- There will be a transparent tube with spiral metal embedded in it



- This tube is connected to the vacuum pump
- Inspect the tube for any cracks and deformation, report if found any
- Clean the tube with pressurized air to get rid of the accumulated dirt



## ○ Vacuum pump fan rotation

- Turn the Vacuum pump ON in manual mode
- Check the direction of the fan of the pump



- If it's turning in opposite direction of the Highlighted arrow, then **STOP** immediately, Contact Schultheiss Service or electrician to help you change the phase of electrical wires
- If the fan is turning in same direction, then move to next troubleshooting solution
- Check the video ' **How to connect and Check Vacuum Pump** '

## ○ Reset Pressure Sensors Job code

- Check video ' **How to Reset Pressure Sensors Job code**'
- After that do the vacuum test in Manual mode

## ○ Vacuum test in Manual mode

- Open the left panel of the machine
- Check the video on Homepage and follow the instructions ' **How to do vacuum test** '
- Start the Test and check if there is not any leakage from the tubes or somewhere inside the left side of the machine
- Report the results , If found different

## ○ Faulty or Choked Solenoid Valves

- If vacuum is not created in either chamber, then It could mean the valves are choked or not operating correctly
- Lastly the valves are choked and need to replace or cleaned
- Follow the document on how to clean the valves

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

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