Identifier Service SH	**Service Document**	schultheiss
How to do Vacuum Test in VPC		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 66/100/Pure	All version	Since Release

Problem

How to check leakage of Vacuum in Melting and Flask chambers

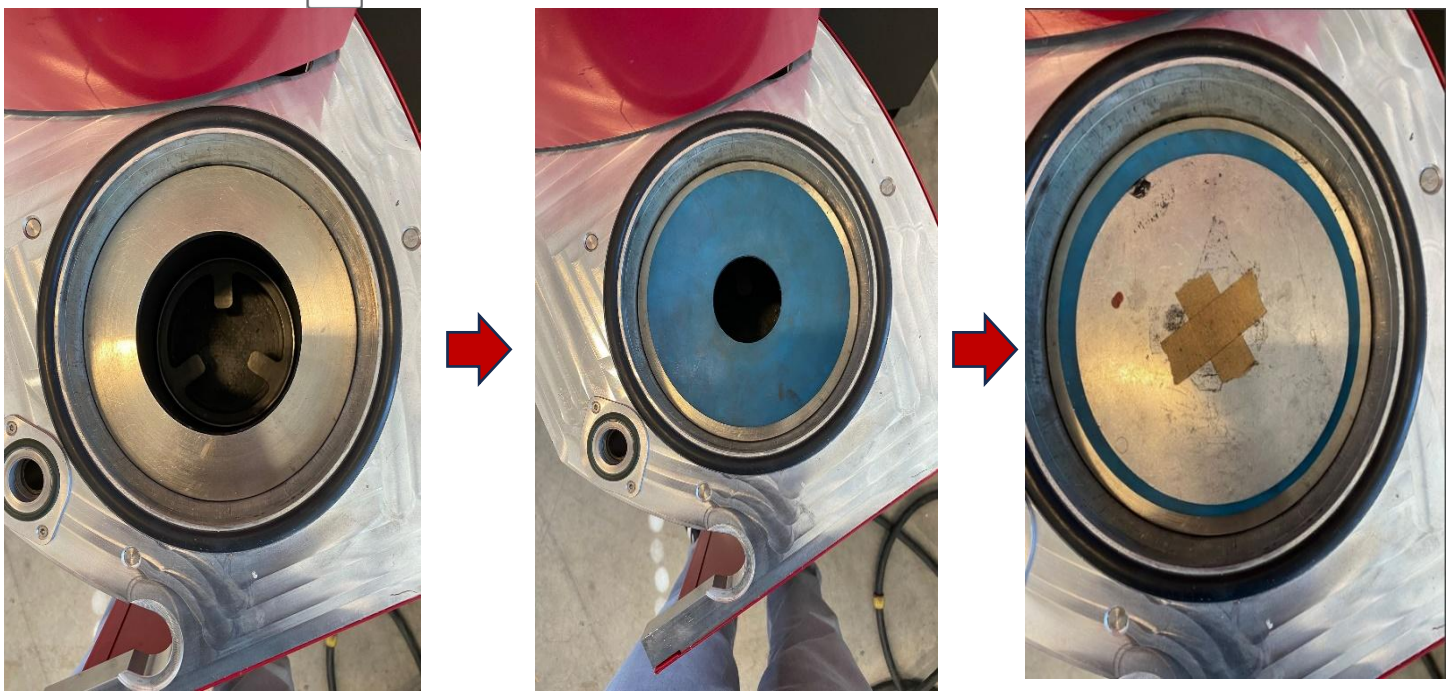
Prerequisites

Test Plate – FD000209

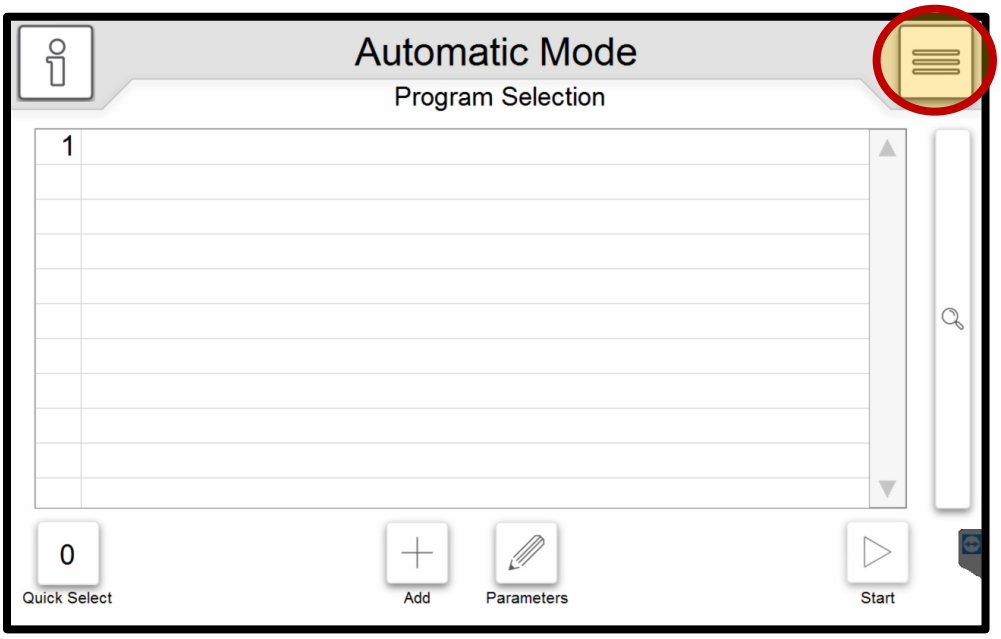
Silicon Gasket – HV001519

Procedure

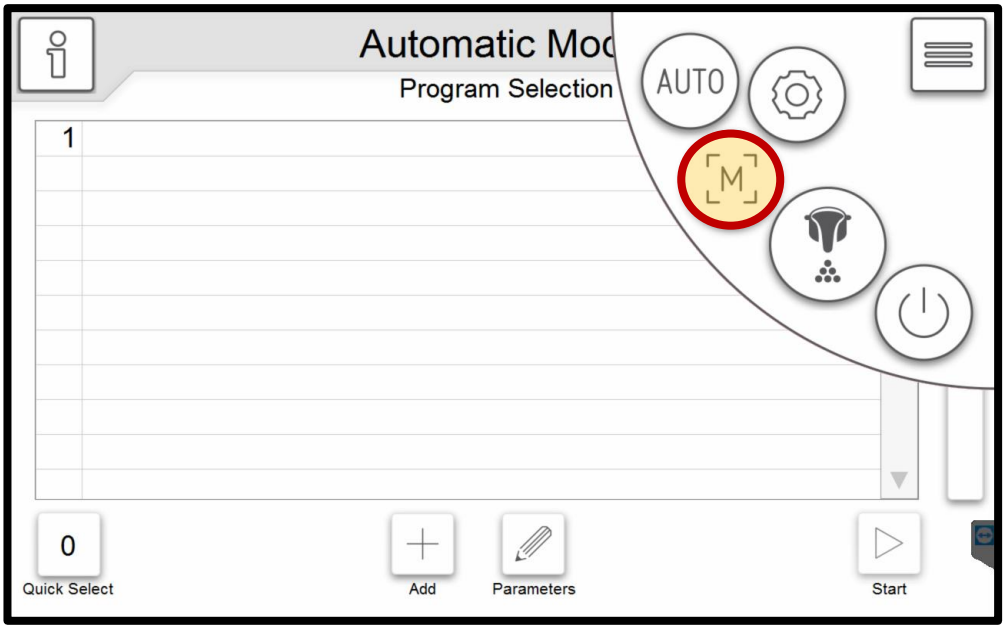
- Open the flask chamber and put the Blue Gasket (**HV001519**) on top put the metal test plate (**FD000209**)
- The test plate has a hole in the center. Cover the hole with a paper tape, that will be the top side
- Close the chambers



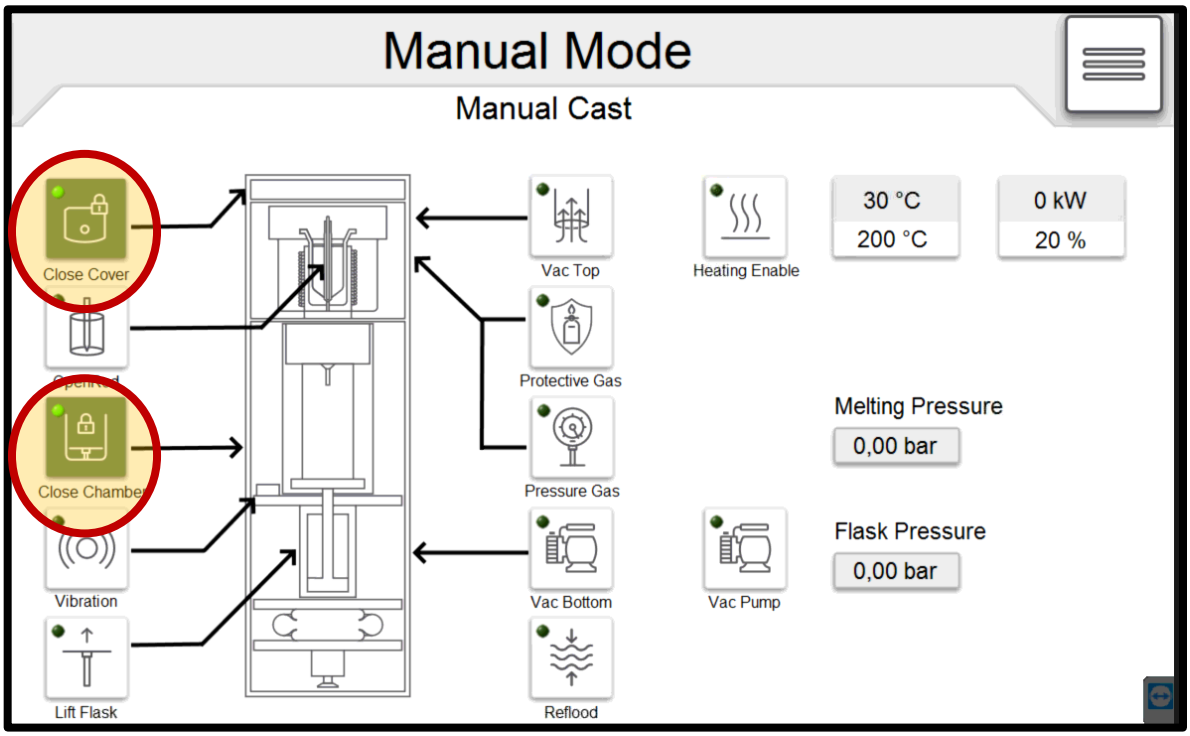
- Press to open Menu



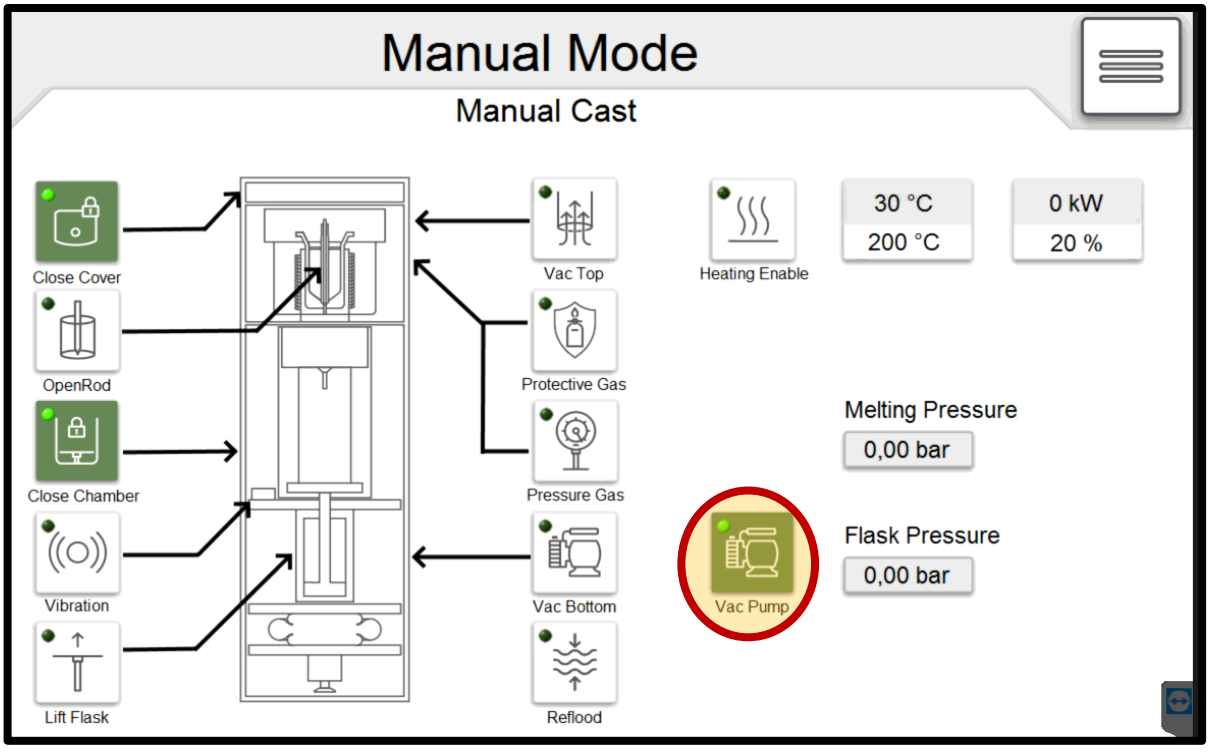
- Select  to enter in **Manual Mode**



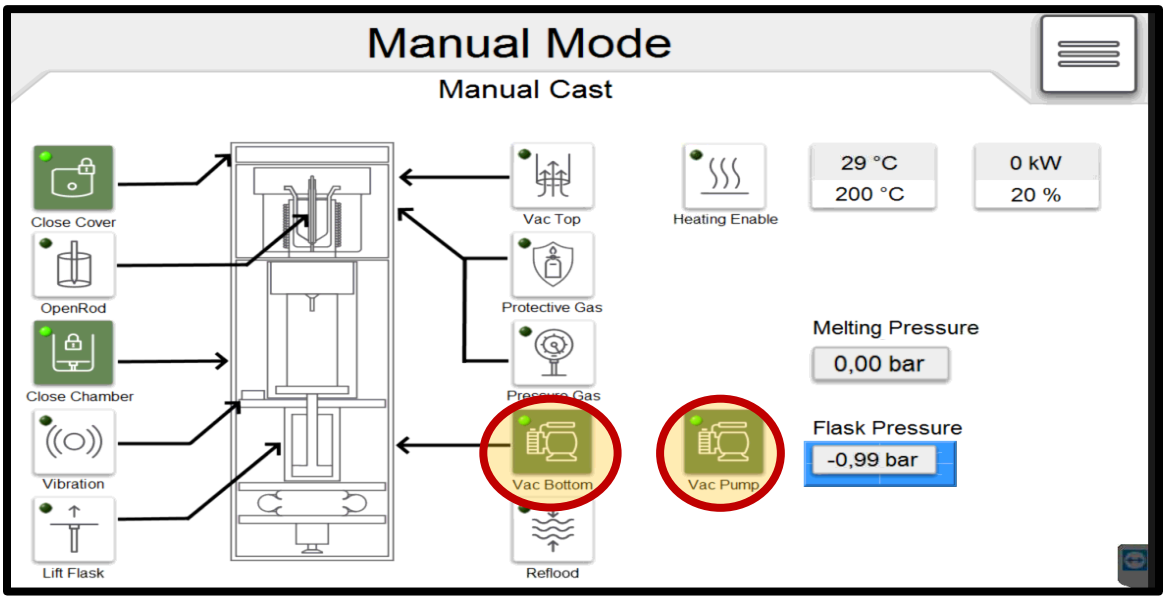
- Lock the chambers in Software



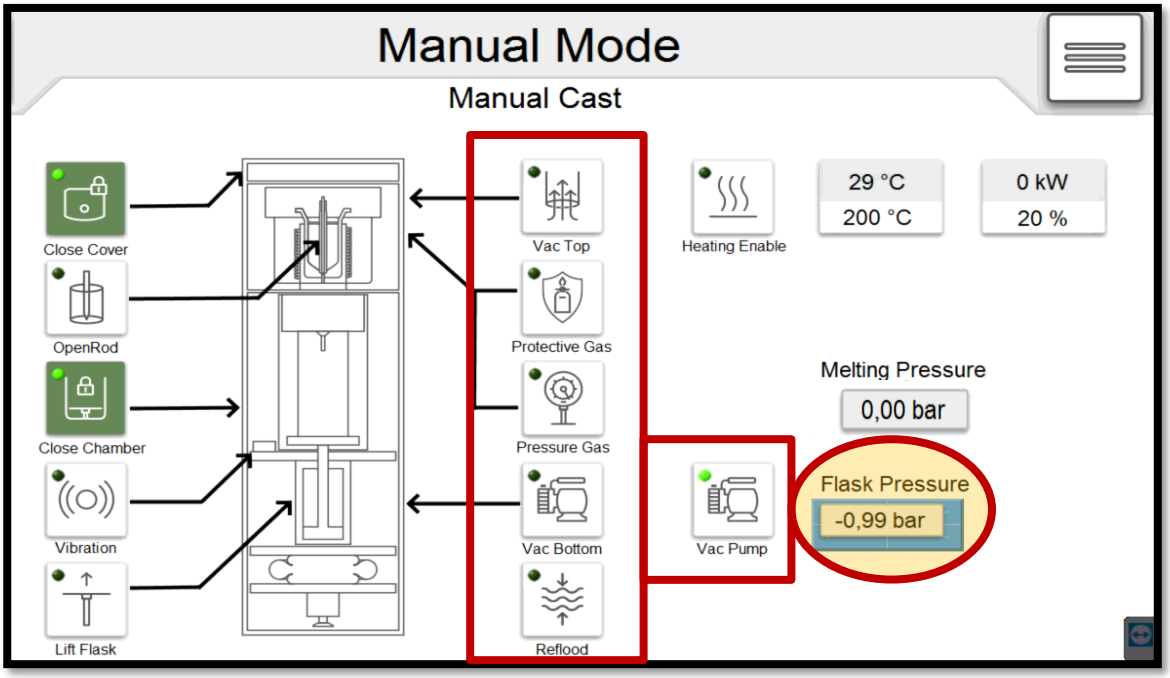
- **Tap on Vacuum Pump** Icon to start the pump



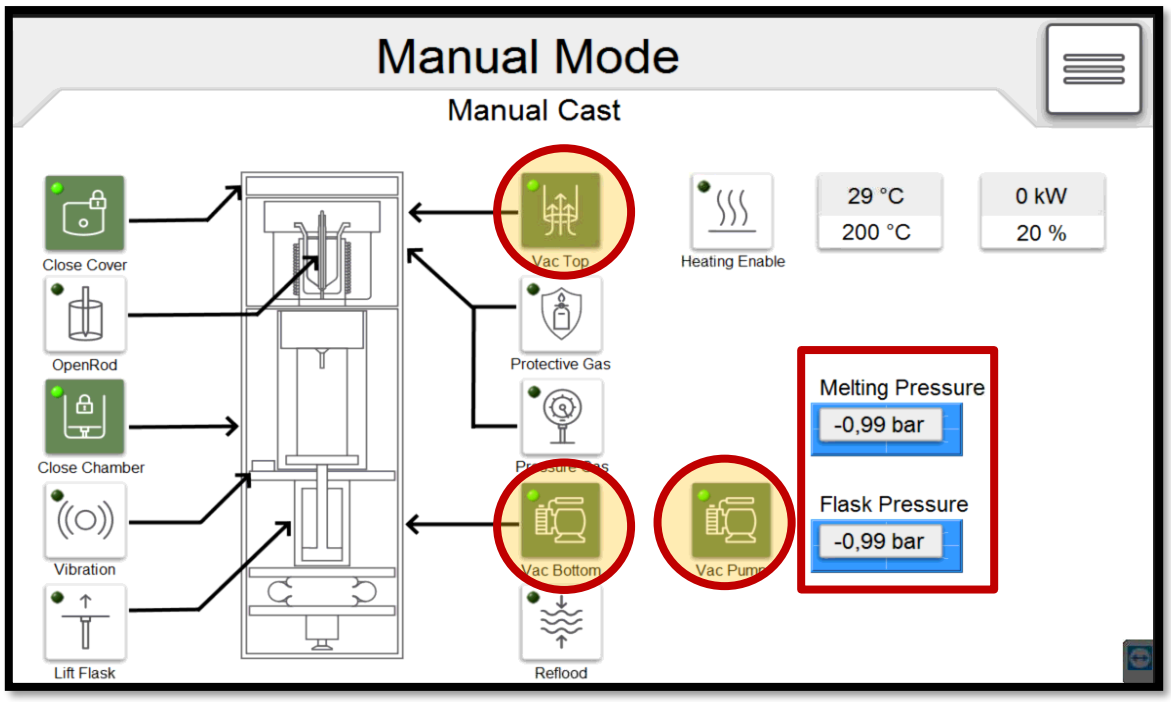
- **Tap on Vac. Bottom** to start vacuuming the flask chamber. The pressure of flask chamber will reach **-0.99bars**



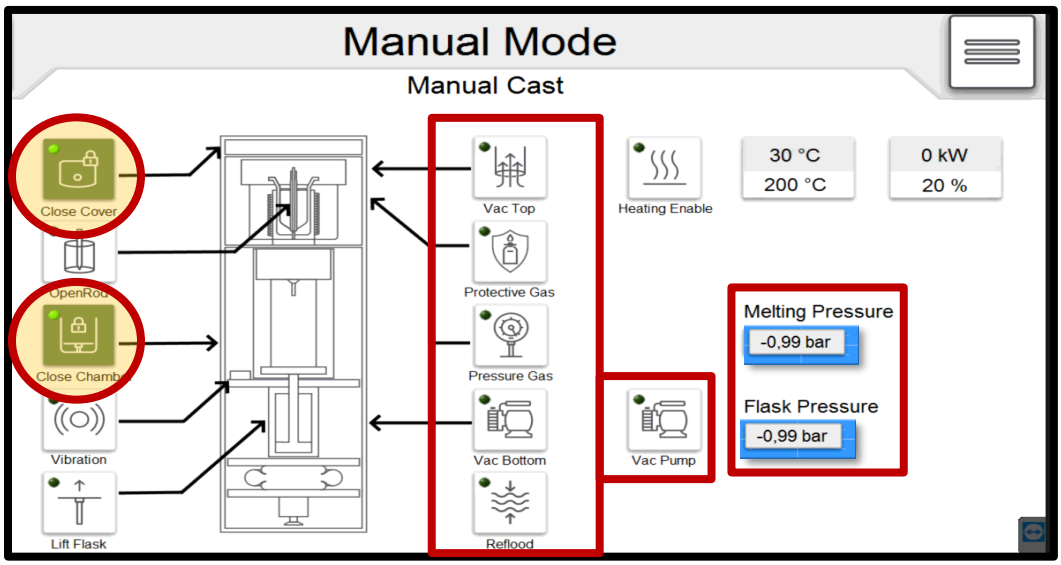
- **Tap on Vac. Bottom to close** the valve and **Tap on Vac. Pump** to turn off pump
- Now observe the pressure in flask chamber for 3 minutes. The value should be held stable
- ***Drop until -0.80bars in 3 minutes is acceptable***.



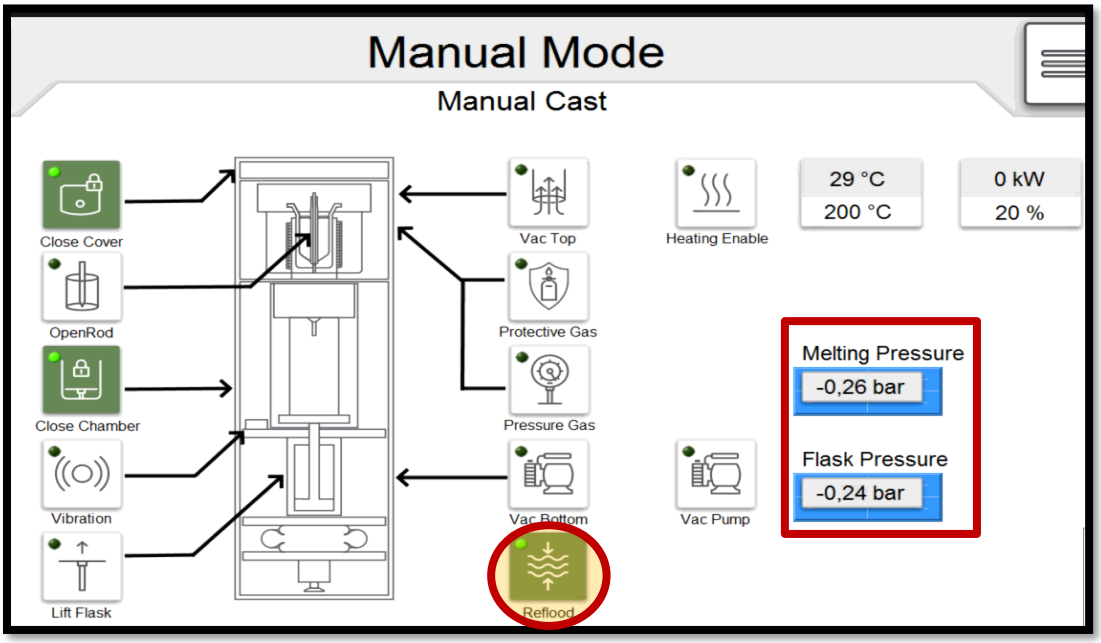
- Now checking the melting chamber
- **Turn ON the vacuum pump, Vac. Bottom and Tap on Vac. Top**
- The pressure in chambers will reach **-0.99bars.**



- Tap on **Vac. Bottom Vac Top** to close the valve and Tap on **Vac. Pump** to turn off pump
- Now observe the pressure in flask chamber for 3 minutes. The value should be held stable
- ***Drop until -0.80bars in 3 minutes is acceptable***



- Now **Tap Reflood** releases the vacuum in both chambers, and the pressure values will **be 0.00 bars**



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

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