


Identifier Service SH	<b>Service Document</b>	
<b>T-M-40-01 How to do Vacuum Test 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>

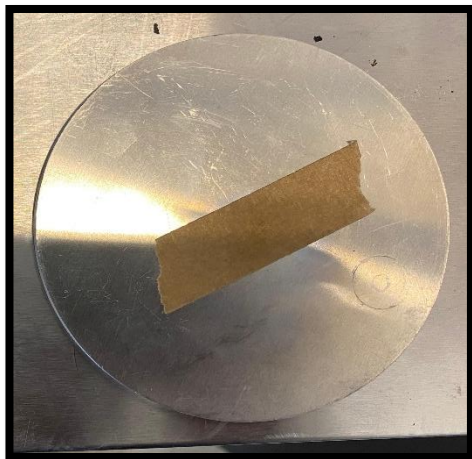
Apply for:

Machine Type	Version	Year
VPC 40	All	Since Release

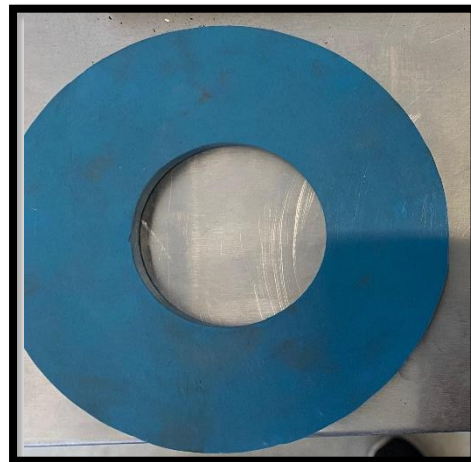
## Problem

How to do Vacuum Test

## Prerequisites



Test Plate ø105mm KF002351



Silicon Gasket

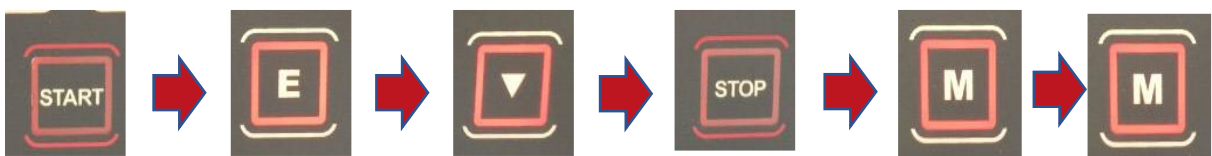
- Test plate has holes on both sides, Cover the hole on one side with sticky tape

## Procedure

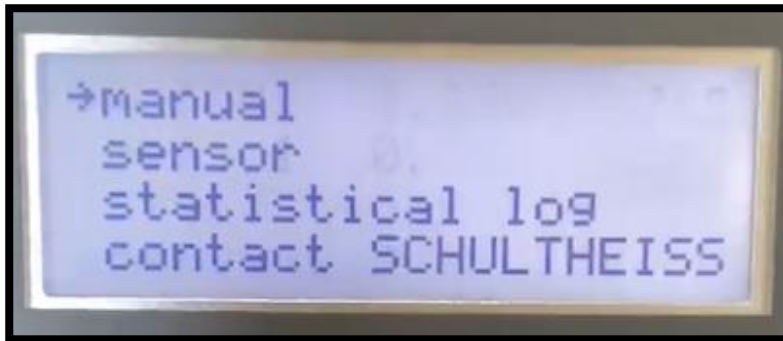
- Put the Test Plate and silicon in the chamber





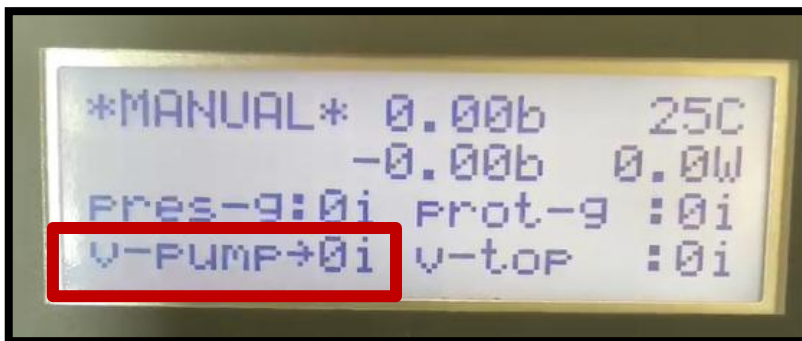
- Close and Lock the chamber
- Switch ON the machine
- Wait until the Self-test is completed
- Enter the following sequence to enter in Manual mode




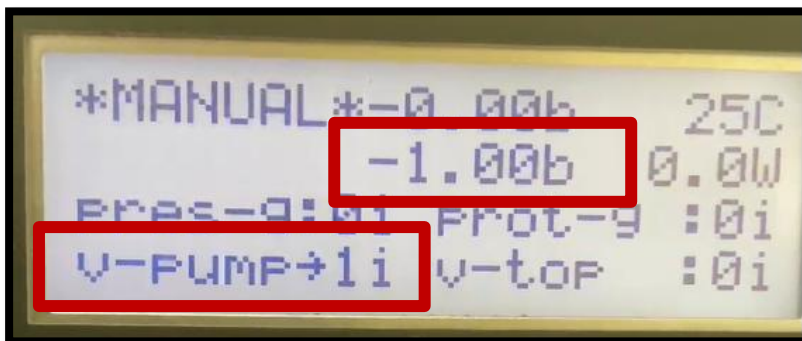
- The following screen should pop up. If not, then repeat the steps from the beginning.



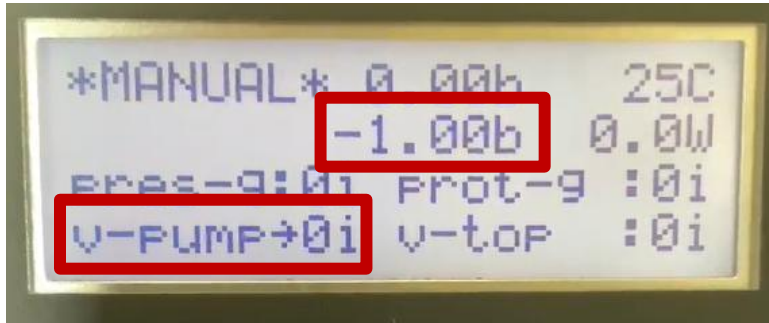
- Press  E to enter Manual mode
- Press  Down and go to V-pump





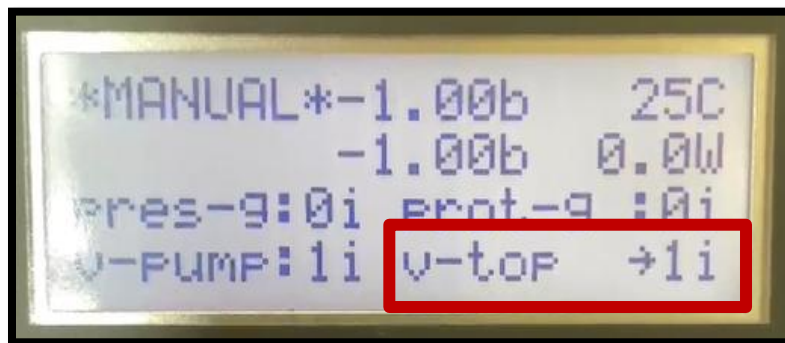
- Press  E to activate the vacuum pump and then the flask chamber will be vacuumed and reach -1.00bar



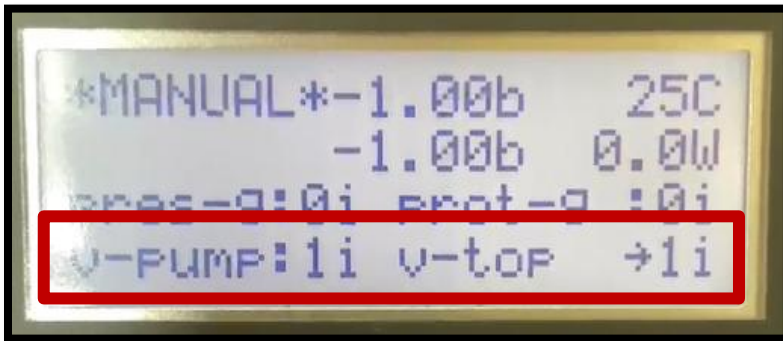
- Once reached, press  E to stop the vacuum pump




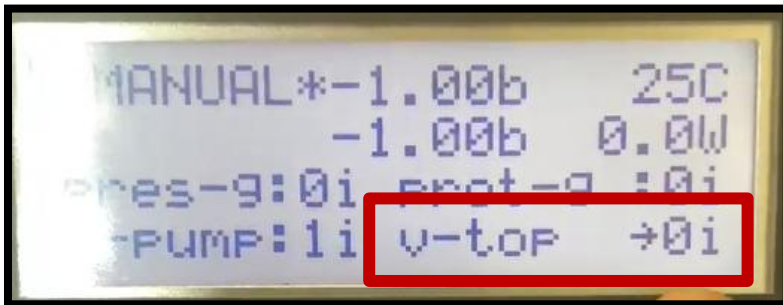
- If the vacuum is held for 3 minutes between (-0.90bar and -1.00bar) , this means the flask chamber has no leakage.
- Testing Vacuum in Melting Chamber
- Press  to run the Vacuum pump again
- Goto V top to vacuum the top chamber (melting chamber) and Press 



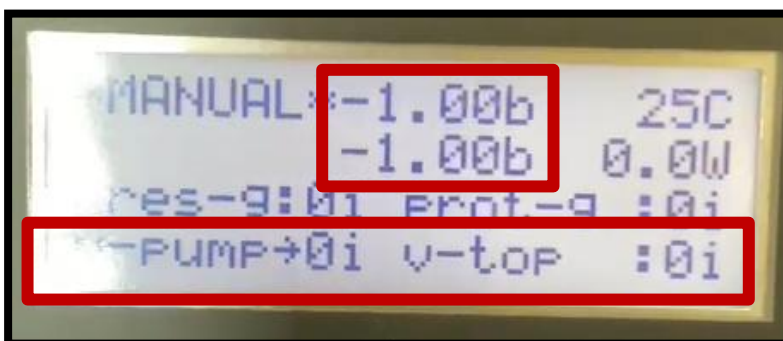
- The value in both chambers should reach -1.00bar



- Once reached, press  E to disable the V Top



- Goto V- pump press E to  turn off the Vacuum pump

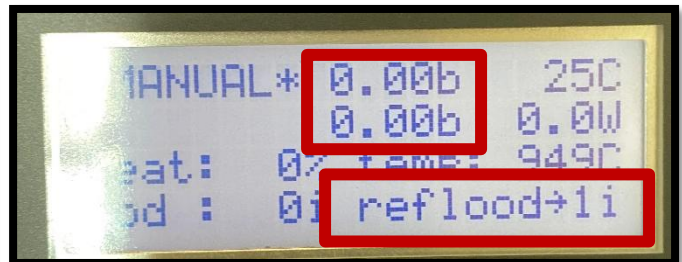
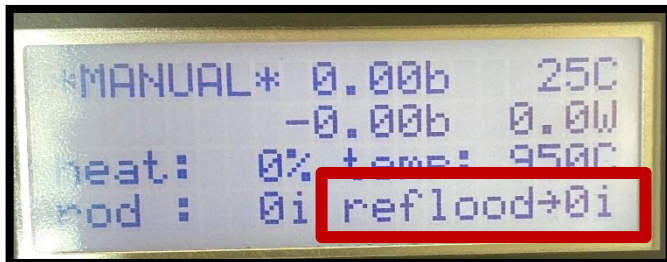


- If the vacuum is held for 3 minutes between (-0.90bar and -1.00bar) , this means the melting chamber has no leakage
- If there is no leakage, then go to Reflood on top of the screen

and activate it by pressing



the values will reset to 0.00



- If the values are not stable, then the system is not properly sealed. Need to check the sealings, vacuum tubes and valves
- Follow the instructions on the other document for troubleshooting

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

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