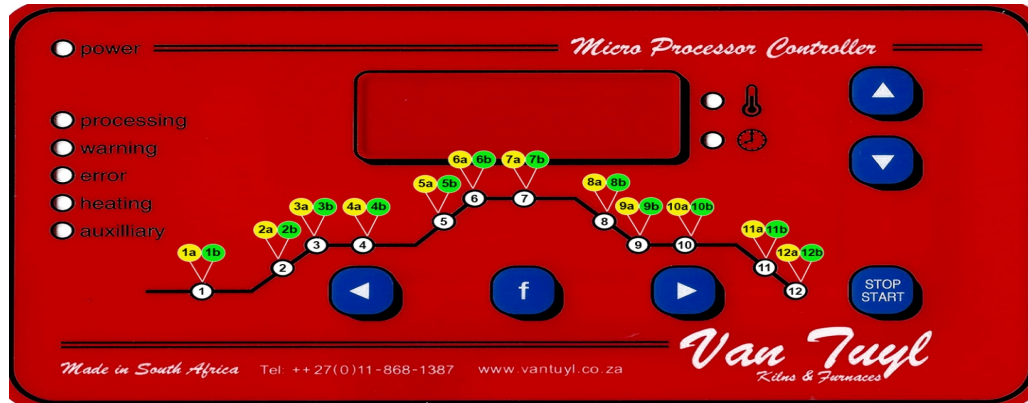


## SETTING PROGRAMMES FOR THE VT-36 CONTROLLER

- The VT-36 Programmable Controller has the flexibility to be able to run multiple sets of steps in a programme with a number of UP-Ramp sets and DOWN-Ramp sets.
- The Controllers' standard default setting is set to run on 8 Steps ( Cycle A ). This allows the user to run 2x UP-Ramps sets and 2x DOWN-Ramp sets.
- You can change the Controller to 16 Steps ( Cycle A&B ) in the Global Parameters. This will allow the user to run a maximum of either 4x UP-Ramp sets, and 2x DOWN-Ramp sets OR 2x UP-Ramp sets and 4x DOWN-Ramp sets.

Fig 1.



**Cycle A**

**Cycle B**

Client Programme Data

3 UP ramps only

| Program - Cycle A |                            |                  |                 |                    |
|-------------------|----------------------------|------------------|-----------------|--------------------|
|                   | Type                       | Controller Input | Detail          | Comments           |
| 1a                | Delay                      | -- --            |                 | No Delay           |
| 2a                | 1st Ramp Up                | 0040             | Deg C / Hour    |                    |
| 3a                | 1st Set Temperature        | 0200             | Deg C           |                    |
| 4a                | 1st Soak                   | -- --            | Hours & Minutes |                    |
| 5a                | 2nd Ramp Up                | 0060             | Deg C / Hour    |                    |
| 6a                | 2nd Set Temperature        | 0600             | Deg C           |                    |
| 7a                | 2nd Soak                   | -- --            | Hours & Minutes |                    |
| 8a                | 1st Ramp (down)            | -- --            | Deg C / Hour    | No data to reflect |
| 9a                | 1st Set Temperature (down) | -- --            | Deg C           | No data to reflect |
| 10a               | 1st Soak (down)            | -- --            | Hours & Minutes | No data to reflect |
| 11a               | 2nd Ramp (down)            | -- --            | Deg C / Hour    | No data to reflect |
| 12a               | 2nd Set Temperature (down) | -- --            | Deg C           | No data to reflect |

| Program - Cycle B |   |                  |                 |                    |
|-------------------|---|------------------|-----------------|--------------------|
|                   | Type                                    | Controller Input | Detail          | Comments           |
| 1b                | Not Available on Cycle B                |                  |                 |                    |
| 2b                | 3rd Ramp Up                             | 0100             | Deg C / Hour    |                    |
| 3b                | 3rd Set Temperature                     | 1000             | Deg C           |                    |
| 4b                | 3rd Soak                                | -- --            | Hours & Minutes |                    |
| 5b                | 4th Ramp Up                             | -- --            | Deg C / Hour    |                    |
| 6b                | 4th Set Temperature                     | -- --            | Deg C           |                    |
| 7b                | 4th Soak                                | -- --            | Hours & Minutes |                    |
| 8b                | 1st Ramp (down)                         | -- --            | Deg C / Hour    | No data to reflect |
| 9b                | 1st Set Temperature (down) for 16 Steps | -- --            | Deg C           | No data to reflect |
| 10b               | 1st Soak (down) for 16 Steps            | -- --            | Hours & Minutes | No data to reflect |
| 11b               | 2nd Ramp (down) for 16 Steps            | -- --            | Deg C / Hour    | No data to reflect |
| 12b               | 2nd Set Temperature (down) for 16 Steps | -- --            | Deg C           | No data to reflect |

Programme Data entering:

### ENTERING DATA FOR A 16-STEP PROGRAMME (BOTH CYCLE A & B)

- 1 Ensure no programme is running.
- 2 Select the programme you wish to set.
- 3 Return to the default screen (Kiln temperature should be on the display).
- 4 Hold down the "f" key for 5 seconds. The display will change to P-01. You are now in the Global Parameter Setting (page 7 in your manual).
- 5 Use the UP arrow key to select "P-15" (This is the parameter to change from 8 to 16 steps)
- 6 Press the RIGHT arrow key once. You will see "0001" on the display.
- 7 Change "0001" to "0002" by using the UP arrow key.
- 8 Press the "f" key twice to return to the default screen.
- 9 You have now set your controller to run 16 steps (2 Cycles)
- 10 Enter your programme data as per your table above (fig 1).

**Note :** When you are entering data in CYCLE B you will see a red dot on the bottom right corner of the controller display. This indicates that you are in CYCLE B.