**HPS-C-SLOT+ Start Up Procedure**

1. Dry out mold 3–4 times, apply full tonnage, close mold on stacked molds.
2. Turn “On” main disconnect.
3. Press “Up” or “Down” to select Zone 1.
4. Select Zone 1.
5. Enter automatic set point.
6. Press enter to confirm.
7. Repeat for other zones or modules.

**Basic Operation / Advanced Setup / Troubleshooting**

1. Press “Up” and “Select” together (Power “On”)
2. Select Zone(s)
3. Press “1”, “2”, or “1 & 2” together to select “both”
4. Press enter to confirm
5. Enter “0” for automatic or open loop control
6. Press enter to confirm
7. Repeat for other zones or modules
8. Zones are closed or holding set point when zone selected.

**How to Enter a Set Point**

- Press “Up” or “Down” together to turn power “On”.
- Press “Up” or “Down” together to turn power “Off”.

**How to Select Automatic or Manual**

- Press “Up” or “Down” together to select “Auto” / “Manual”.
- Press “Up” or “Down” together to turn automatic on / off.

**Standard Controller Enclosure Wiring**

- Female DB9 remote computer interface.
- Female DB25 enclosure link connector on network module.
- Contact is closed when any zone is in alarm for 16 seconds.
- Fused at 5 amps.
- Male insert on enclosure.

**H44 Input/Output Connectors**

- Standard input / output.
- All zones go to standby mode.
- If standby set point is “1”, module will be inhibited.
- Configures in Advanced Setup.
- Make insert on enclosure.

**Optional Network Module Wiring**

- Female DB25 enclosure link connector on network module.
- Complimentary monitoring software including Gammavision, Mold Monitor, Mold Doctor and Field Calibrator.
- Female DB9 remote computer interface on enclosure.

**EWIKON Field Calibrator**

- Female DB9 remote computer interface on enclosure.
- EWIKON Complimentary monitoring software including Gammavision, Mold Monitor, Mold Doctor and Field Calibrator.

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**Technical Information Subject to Alteration**

- EWIKON 11/2014
- Item no. 13972E
HPS-C-SLOT+ Start Up Procedure

1. Dry cycle mold 3–4 times, apply full tonnage (determine any pinched wires in subsequent operation).
2. Turn “On” main disconnect.
3. Select Zone 1. Enter automatic set point. Press “Enter”.
4. Repeat for other zones or modules.
5. Select Zone 1. Enter temperature set point. Press “Enter”.
6. Repeat for other zones or modules.
7. Select Zone 1. Enter automatic set point. Press “Enter”.
8. Select Zone 2.
9. Repeat for other zones or modules.
10. Press “Up” and “Select” to select “both”.

How to Enter a Set Point

- Press “Up” or “Down” to set temperature (Press “Up” or “Down” together to set temperature). Press enter to confirm.

How to Select Automatic or Manual

- Press “1”, “2”, or “1 & 2” together to select “both”.
- Press “1”, “2”, or “0” to select automatic or manual.

How to Turn the Power “On” & “Off”

- Press “1”, “2”, or “1 & 2” together to turn power “Off”.

Standard Controller Enclosure Wiring

- Earth conductor wired to housing.
- Power Thermocouple.
- Type K Thermocouple.
- Load Fused at 5 amps.
- Normally open contact. Contact is closed when any zone is in alarm for 16 seconds.
- Share input, output and communications.

Optional Network Module Wiring

- Mold Monitor, Mold Doctor and Mold Thermocouple.
- Female DB9 remote computer link connector on network module.
- Male DB25 enclosure link connector on network module.
- Female DB9 encoder link connection on controller enclosure.

Remote Computer & Enclosure Link Connections

- Standby input
- Earth conductor wired to housing.
- 22 – 265 V AC/VDC must be supplied.
- 24 or 120 V AC/VDC input to activate.

Note: All symmetric inputs must be supplied for grounding. For grounding, earth conductor must be connected to a local earth conductor. Earth conductor may be connected to the metal enclosure or the metal housing. Only earth conductors will be connected as an earth conductor and not as a fun power conductor.
HPS-C-SLOT+ Start Up Procedure

1. Dry cycle mold 4 – 6 times, apply full surface contact (start any pinched wires in sequence of operation);
2. Turn “On” main disconnect
3. Select Zone(s) “On” (and “Enter”)
4. Press “Select” to move to Zone(s) “Off”
5. Select Zone(s) “Off” (and “Enter”) Press “Select” to move to Zone(s) “On”
6. Repeat for other zones or modules
7. Zones will read a low temperature alarm
8. Select “Off” for automatic or closed loop control
9. Zone(s) “On” or “both” to turn power “Off”
10. Zone(s) “Off” to turn power “On”

How to Enter a Set Point

1. Enter Manual % Output Set Point
2. Enter Automatic Temperature Set Point
3. Press “Enter to confirm
4. Select zone(s)

How to Select Automatic or Manual

1. Select zone(s) “O” – “O”
2. Select zone(s) “O” – “M”
3. Select zone(s) “M” – “M”
4. Select zone(s) “M” – “O”

How to Turn the Power “On & Off”

1. Zone(s) “On” or “both” to turn power “On”
2. Zone(s) “Off” to turn power “Off”

Standard Controller Enclosure Wiring

- Field Calibrator
- Mold Monitor, Mold Doctor and other sensors

Optional Network Module Wiring

- Female DBG enclosure link connector on standard enclosure
- Connect two enclosures to one network module
- Share input, output and communication

Remote Computer & Enclosure Link Connections

- Female DBG enclosure link connection on one network module
- Configure in Advance Setup
- Alert output (potentially hazardous signal)
- Normally open contact
- Configure to sound alarm in alarm for 16 seconds
- Flash at 5 times

Standard Controller Enclosure Wiring

- Female DBG enclosure link connection on one network module
- Configure in Advance Setup
- Make sure enclosure is properly grounded

Remote Computer & Enclosure Link Connections

- Female DBG enclosure link connection on one network module
- Configure in Advance Setup
- Alert output (potentially hazardous signal)
- Normally open contact
- Configure to sound alarm in alarm for 16 seconds
- Flash at 5 times
**Advanced Setup Guide - Level 2 Security to Change**

**Why Standby? How to Activate Alternate Standby Inputs**

<table>
<thead>
<tr>
<th>Temperature deviation alarm set point (individual zone)</th>
<th>0 – 999 ºF/537 ºC (100 ºF/55 ºC)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Alarm - disables output to the heater, except for the zone set point (individual zone)</td>
<td>0 – 30 and -31 ultra fast low mass tuning. P = auto selection tune performed (setup number)</td>
</tr>
<tr>
<td>Alarm - disables output to the heater, except for the zone set point (individual zone)</td>
<td>- 17 to -10 fast manifold tuning with increasing lag. -27 to -20 very fast tuning with increasing lag.</td>
</tr>
</tbody>
</table>
Advanced Setup Guide - Level 2 Security to Change

To place security on the HPS-C-SLOT+ you must activate security by "On" in the power. Many customers require security code level 1. You must be in level 2 to change. Refresh procedure available, call EWIKON.

Advanced Setup Guide - Level 2 Security to Change

Explanation

Temperature override default set at 0ºF (0 ºC).
If this temperature is exceeded for 10 minutes the temperature override default 10ºF (5.6 ºC) = disabled.

Setting set point (individual). All zones turned "On" when shut down last, stay "On" (162ºF / 72ºC).

Standalone switch on enclosure. Sprue – low alarm (5) Sprue – critical over temperature (6) Sprue – high alarm (7) Thermocouple (T/C) open (8) Thermocouple (T/C) shorted (9) Thermocouple (T/C) reversed (10)

Select zone(s) to boost
All zones will boost (120ºF / 55ºC)

Input to alarm controller

Thermocouple (T/C) open (0) Thermocouple (T/C) shorted (1) Thermocouple (T/C) reversed (2)

Power Flex=5 is active (1) Power Flex=5 is set to default value (2)

Temperature controller software version (3) Fan (4) Tip 1 – in alarm (5) Tip 2 – normal operation (6) Tip 3 – manual (7) Tip 4 – high alarm temperature (8) Zone(s) (9) Zone(s) boostable (10) Zone(s) “On” (11) Zone(s) “Off” (12) Alarm status (13) Fan status (14) Communications port (15) Power input cable (16) Power output cable (17) Main disconnect (circuit breaker) (18) Thermocouple input connector (19) Thermocouple output connector (20)

Thermocouple input connector

Thermocouple (T/C) open (0) Thermocouple (T/C) shorted (1) Thermocouple (T/C) reversed (2)

Critical over temperature – The temperature of the zones exceed the critical temperature (100ºF / 38 ºC) = disabled. Critical over temperature alarm is "On" automatically. To clear the alarm, select alarm status and press enter.

Thermocouple (T/C) shorted – The T/C is shorted to some point. Should be checked by each technician. Make sure that only wires in the cable set or the connectors/pins are not making contact.

Thermocouple reversed – The T/C is reversed, the connection is broken. Make sure that only wires in the cable set or the connectors/pins are not making contact.

Thermocouple – The T/C is broken, follow general troubleshooting.

General troubleshooting – Turn "Off" Main Disconnect

Check resistance from pin to pin. The T/C should read 3 – 5 ohms at room temperature. heater should be "On" (100ºF / 38 ºC). Check for open line. Thermocouple (T/C) open (8) = good. Some resistance is bad, heater shorted. Check the cable connections, wire connections, thermocouples, and the T/C.

Thermocouple reversed – The T/C is reversed, the connection is broken. Make sure that only wires in the cable set or the connectors/pins are not making contact.

Thermocouple open – the T/C connection is poor, follow general troubleshooting.

Thermocouple (T/C) shorted – The T/C is shorted to some point. Should be checked by each technician. Make sure that only wires in the cable set or the connectors/pins are not making contact.

Thermocouple (T/C) reversed – The T/C is reversed, the connection is broken. Make sure that only wires in the cable set or the connectors/pins are not making contact.

Thermocouple – The T/C is broken, follow general troubleshooting.

Open heater - The heater connection is broken, check all fuses (per module / 2 zone).

Thermocouple (T/C) open - the T/C connection is poor, follow general troubleshooting.

Thermocouple (T/C) shorted – The T/C is shorted to some point. Should be checked by each technician. Make sure that only wires in the cable set or the connectors/pins are not making contact.

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Thermocouple – The T/C is broken, follow general troubleshooting.
**Advanced Setup**

- **Power Priority™**
  - 0 = (off)
  - 1 – 4 = increased smoothing of power output
  - A = Power Priority™ is active (setup number)

- **Boost time set point**
  - The amount of time boost is active

- **Manual set point limit**
  - The maximum set point an operator can enter in manual on both zones

- **Automatic set point limit**
  - The maximum set point an operator can enter in automatic on both zones

- **Standby set point (individual)**
  - When standby is activated, all automatic zones selected will control to this set point

- **Network module distribution**
  - Applies to both zones on the module

- **Unlock advanced setup**
  - Reset advanced setup to default values – enter 321; press enter to confirm

**Why Standby?**

1. **Why Boost?**
   - Boost temporarily raises a zone(s) + % output, 20 ºF/11 ºC in 5 minutes – default. Change alarm timer amount. 0 = disabled

2. **How to Boost**
   - To cancel boost, select zone(s) to boost, and “enter”

3. **How to View All Zones Quickly**
   - Select zone(s) to boost, and “enter”

**General Troubleshooting**

- **Turn "Off" Main Disconnect**
  - If the problem is not explained, or you need spare parts please contact:

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**How to Activate**

- **Select zone(s) to put into standby**
  - “Enter”

- **Select zone(s) to boost**
  - “Enter”

- **Select zone(s) to boost**
  - “Enter”

- **Select zone(s) to boost**
  - “Enter”

- **Select zone(s) to boost**
  - “Enter”

- **Select zone(s) to boost**
  - “Enter”

**Alternate Standby Inputs**

- **Thermocouple probe**
  - The T/C is selected in the setup.

- **Thermocouple probe**
  - The probe is not selected in the setup.

**Thermocouple selected**

1. **Thermocouple jst/jk**
   - The T/C is selected in the setup.

2. **Thermocouple probe**
   - The probe is not selected in the setup.

**Thermocouple reversed**

1. **Thermocouple jst/jk**
   - The T/C is selected in the setup.

2. **Thermocouple probe**
   - The probe is not selected in the setup.

**Thermocouple probes**

1. **Thermocouple probe**
   - The T/C is selected in the setup.

2. **Thermocouple probe**
   - The probe is not selected in the setup.

**Power Priority™**

1. **Power Priority™**
   - 0 = (off)

2. **Power Priority™**
   - 1 – 4 = increased smoothing of power output

**Thermocouple probe**

1. **Thermocouple probe**
   - The probe is selected in the setup.

2. **Thermocouple probe**
   - The probe is not selected in the setup.

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