



VIP UNIVERSAL X-PRESS FURNACE

Pressable Ceramic Firing Programs # 0 through 19

Quick Start Guide

Introduction

This guide provides brief setup and user instructions to quickly allow the operator to start using the Pressable Ceramic Firing Programs # 0 through 19 for VIP Universal X-Press Furnace operation. For more detailed information, refer to the Instruction Manual supplied with the furnace.

WARNING: Connect the VIP Furnace to an individual branch circuit. The overall circuit power rating must be 15 amps minimum for the 120-volt model and 10 amps minimum for the 230-volt model. No other devices shall be connected to the circuit powering the VIP Furnace.

Set Up

1. Install cooling tray, if necessary.
2. Connect vacuum pump.
3. Connect compressed air line.
4. Connect input power line cord.
5. Turn on power. Observe that the door opens (lowers).
6. Place firing block with ring insert in place on to door platform.

Important: Run the muffle conditioning program whenever furnace has been off, cooled down and then turned on.

Muffle Conditioning

Run muffle conditioning program # 400 **two times** as follows:

1. Press the **PROGRAM SELECT** key.
2. Enter digits **4 0 0** and press the **ENTER/REVIEW** key.
3. Press the **START** key.

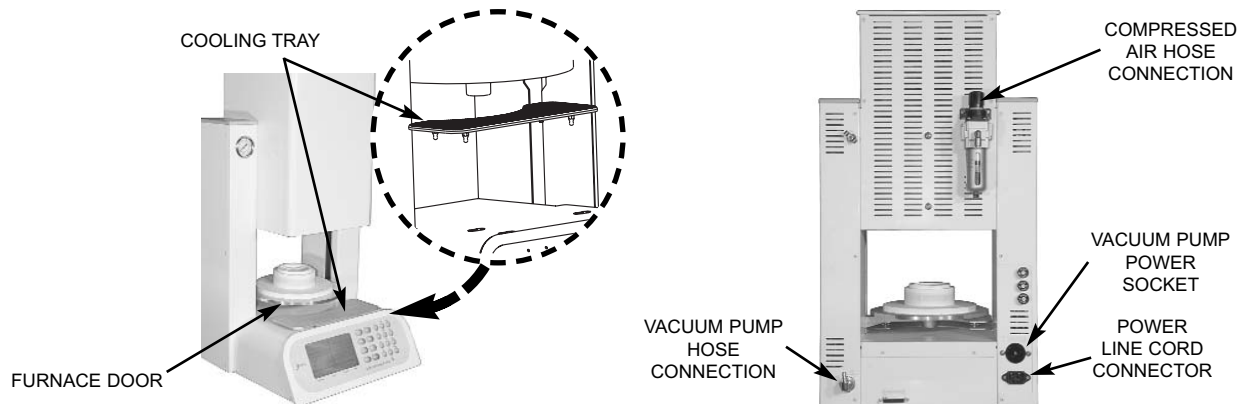


Figure 1. VIP Furnace Setup



Figure 2. VIP Furnace Controls and Indicators Location

Programming Pressable Ceramic Firing Programs # 0 through 19

1. Enter information for pressable programs (#0 - 19) via front-panel keyboard shown by Figure 2.
2. Press **EDIT** and observe that the message **NAME** appears on the status display.
3. Enter desired NAME of program by using alpha/numeric key pad (i.e. PRESS 3 INGOT).
4. After typing the desired NAME, press **ENTER** and notice the square status indicator advances to the next parameter (ie. PREDRY TIME).
5. Select time in minutes and seconds for PREDRY TIME (if any) followed by **ENTER/REVIEW**.
6. Select LOW TEMP (starting temp) followed by **ENTER/REVIEW**.
7. Continue to select all remaining individual press program parameters as applicable and press the **EDIT** key when done.

Notes:

1. For normal pressing we suggest selecting 0:00 for RE-PRESS TIME.
2. Revise the factory default idle temperature setting of 1000°F (538°C) as desired. To change, refer to SET IDLE TEMPERATURE Program #700, page 25 of the Instruction Manual.
3. Operational preferences can be selected from the SPECIAL PROGRAMS. Refer to the Instruction Manual, pages 21 through 27, as necessary.

Pre - Press and Starting to Press

1. Set the pressure regulator on the furnace rear panel for the desired amount of air pressure. The actual regulated air pressure setting is shown by the Press Gauge located on the front of the furnace.
2. Select desired Press program (0 to 19) by pressing the **PROGRAM SELECT** key, entering the digits of program number and pressing the **ENTER/REVIEW** key.
3. Press the **START** key one time. The furnace closes the door and heats up to the low temperature setting. When this temperature setting is reached, the furnace door opens and a message to press the **START** key again is displayed along with a continuous beep. This indicates that the furnace is ready to perform press. The continuous beeping can be silenced by pressing any key.
4. Remove hot ring from burnout furnace, place desired ingots carefully into the ring followed by the plunger.
5. Place hot ring (with ingots and plunger) on to the ring insert of firing block.

Note: When plunger begins to press, the distance as it moves is shown on the front panel display.

6. While the press START key again message is displayed, press the **START** key and the selected Press program will begin.