

OPERATING PROCEDURE FOR HONDA SC

1. Turn on 480 volt disconnect
2. Turn on control panel power.
3. For manual operation press "MANUAL MODE" this lets operator move doors, turn on fans, run conveyor ect. individually.
4. For automatic operation press "AUTO MODE" for Temper oven, Quench tank and Age oven. on Panelview Plus 600.
5. Open doors manually if not open already. Go to "AUTO" mode and press "OVEN ON" button on Panelview 600 for Temper, Age oven and CIRCULATION PUMP and HEATER CONTACTOR on Quench tank. Wait for all fans to start. Wait for "PURGE" light to go off and turn "BURNERS" to the on position. Burner #1 and Burner #2 indicators should go on.
6. DO NOT put a load on at this time. Oven must go through a 1 hr. warm up cycle to get to temperature. Use "LOAD PART BYPASS" until the first cycle indexes into oven.
7. Press "START SYSTEM" on Panelview 600.
8. After the chain indexes a part basket may be placed on the load station to be ready for the next 1 hr. cycle time. Amber flashing light means you have 10 minutes to put part basket on load station other wise an alarm will sound and will have to press "START SYSTEM" again to keep the cycle going.
9. This process will go for 4 hours then yellow light flashes doors open and parts basket rolls onto Quench tank then to "quench" for 5 minutes
10. Elevator raises and parts basket is set on Age oven chain. Here it will drip dry for 5 minutes, then will index into Age oven.
11. After a 2 hr. soak in Age oven load will index into cooling fan chamber for 1 hr. then to unload station to be taken off. Amber light will flash 10 minutes before the cycle is done and must be unloaded or alarm will sound and operator will have to press "SYSTEM RESTART" to continue cycle.

STEADY GREEN LIGHT= UNIT IN OPERATION

YELLOW FLASHING W/SOUND= EQUIPMENT MOVEMENT

RED FLASHING= AN ALARM CONDITION

FLASHING AMBER= TAKE LOAD OFF OF LOAD, UNLOAD STATION

CHAINS ON BOTH TEMPER OVENS MUST BE LUBED ONCE A WEEK OR WHEN AMPERAGE ON INDEXING VFD'S REACH FLA OF MOTOR WITH FUCHS SPC 100 SPRAY COAT DRY FILM LUBRICANT WITH GRAPHITE OR SIMILAR.