

Primocure II

Release 2.0

Operator & Spare Parts Manual

Release 2.0

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Trusted Partner for Your Product Decorating Needs

Trans Tech 475 North Gary Avenue, Carol Stream, IL 60188

Tel +1 (630) 752 4000 Fax +1 (630) 752 4467

Email sales@itwtranstech.com

www.itwtranstech.com www.itwids.com

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Primocure II

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1. Technical Specifications

Power requirements	19A 220VAC single phase
Heater panel	3600 watt
Air supply	100 CFM
Conveyor length	6 feet
Curing section	24" x 18" x 6"
Belt speed	0 - 12 fpm
Maximum Part Size	12" wide x 6" tall
Exit chute - adjustable angle	
Casters - 4	

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2. Primocure II Operating Procedures

2.1. Start Up

The Primocure II should be pre-heated for approximately 5 - 10 minutes. Higher curing temperatures require more pre-heating time.

The heat control is a digital temperature controller (refer to page 6 for setting procedure). The belt speed control has settings ranging from 0 - 100. The tables below give actual results relating to the settings (Note: the belt speed control response is not linear).

Since the cure is a result of several variables, (i.e.: substrate type, heat element height, end panel heights, heat control setting and belt speed) it is always necessary to conduct thorough tests to ensure that proper curing is being achieved.

Belt Speed	Approximate Time in Process
20	3 min. 15 sec.
30	54 sec.
40	31 sec.
50	21 sec.
60	16 sec.
70	13 sec.
80	10 sec.
90	9 sec.
100	7 sec.

Adjust the heating elements via the two star shaped knobs on the top of the heating chamber as close to the parts to cure as possible without touching or creating hot spots.

Adjust the heating chamber covers to the lowest possible position above the parts to cure while still allowing them to enter and exit the heating chamber.

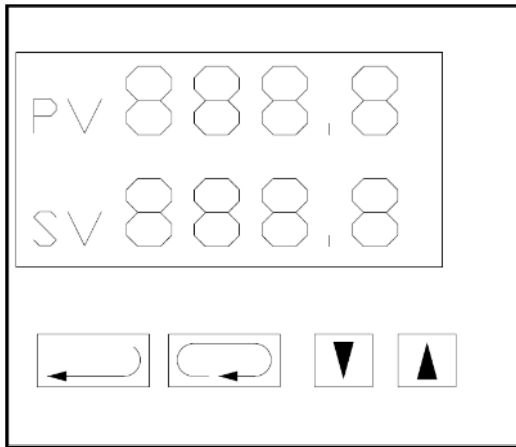
Position parts to cure on the belt as centered as possible or with printed ink portion of parts to cure as centered as possible.



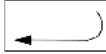
2.2. Shut Down Procedure

About 5 minutes before shutting off the Primocure II, turn off the heat while allowing the belt to run. This will keep the belt from being damaged by overexposure to heat.

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2.3. Setting the Temperature Set point



- Press   to change the Set Value (SV)
- SV will flash as you press the arrows
- When SV number has reached the desired set point press the 

2.4. Auto Tune Procedure

Use this procedure to run the unit with the least amount of temperature variation at the desired temperature set point. Load the unit with parts to cure as similar to production method as possible to simulate the actual production heat load.

Turn on the Main Power switch.

Turn on the Heat switch.

Set the process heat to 350 degrees once the controller has booted up.

Push and hold the Index key (circular symbol) then push the Enter key.

- The display changes to some parameter in the Regulation Mode.

Release both keys.

Push the Index key until "AT" (auto-tune) is displayed.

Push the Up Arrow key to change the "Off" to "On".

Push Enter. Push Enter.

-display is now back to standard set point/actual temperature display. The "AT" led should now be flashing. This indicates that the Auto-tune program is in process.

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Wait 10-15 minutes for the unit to complete the process, which is indicated by the “AT” led no longer flashing.

The unit should be operating near the set point.

2.5. Parameters

The Heater Control uses parameters to customize it to be used in the Primocure II unit. These never have to be altered and are referenced for replacement controllers only.

The Heater Controller has the following parameters changed from factory stock to Trans Tech values:

HtS – 1.0

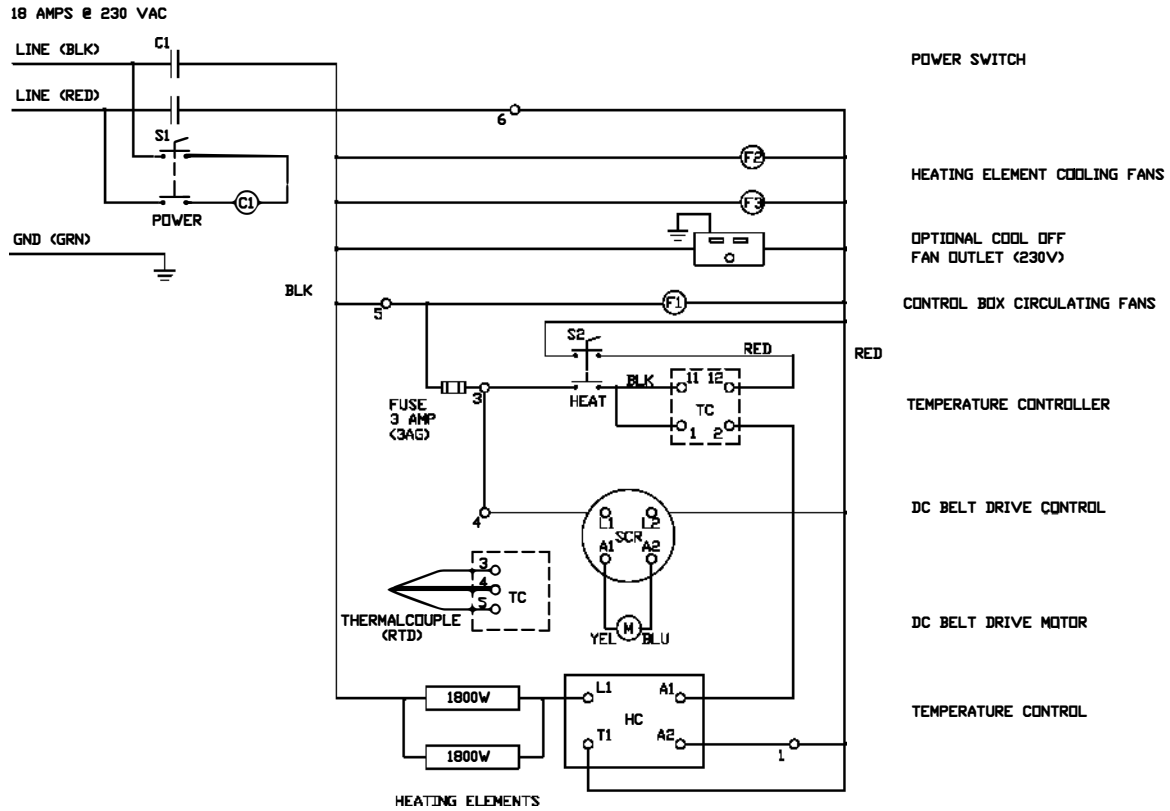
CnPt – JPt1

tPUn – F

Running the Auto Tune process will set the P, I, and D values appropriate for the unit.

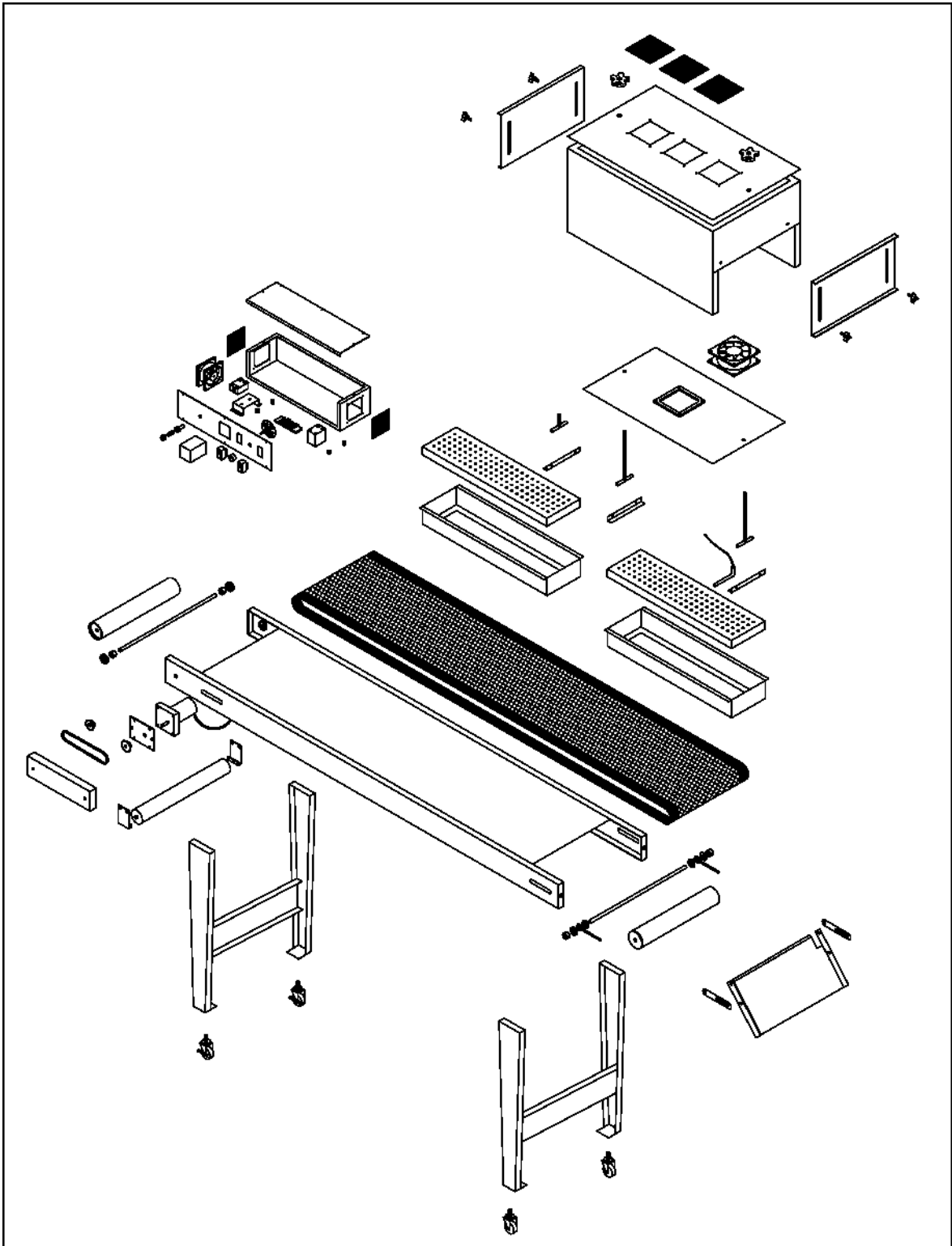
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3. Electrical Schematic



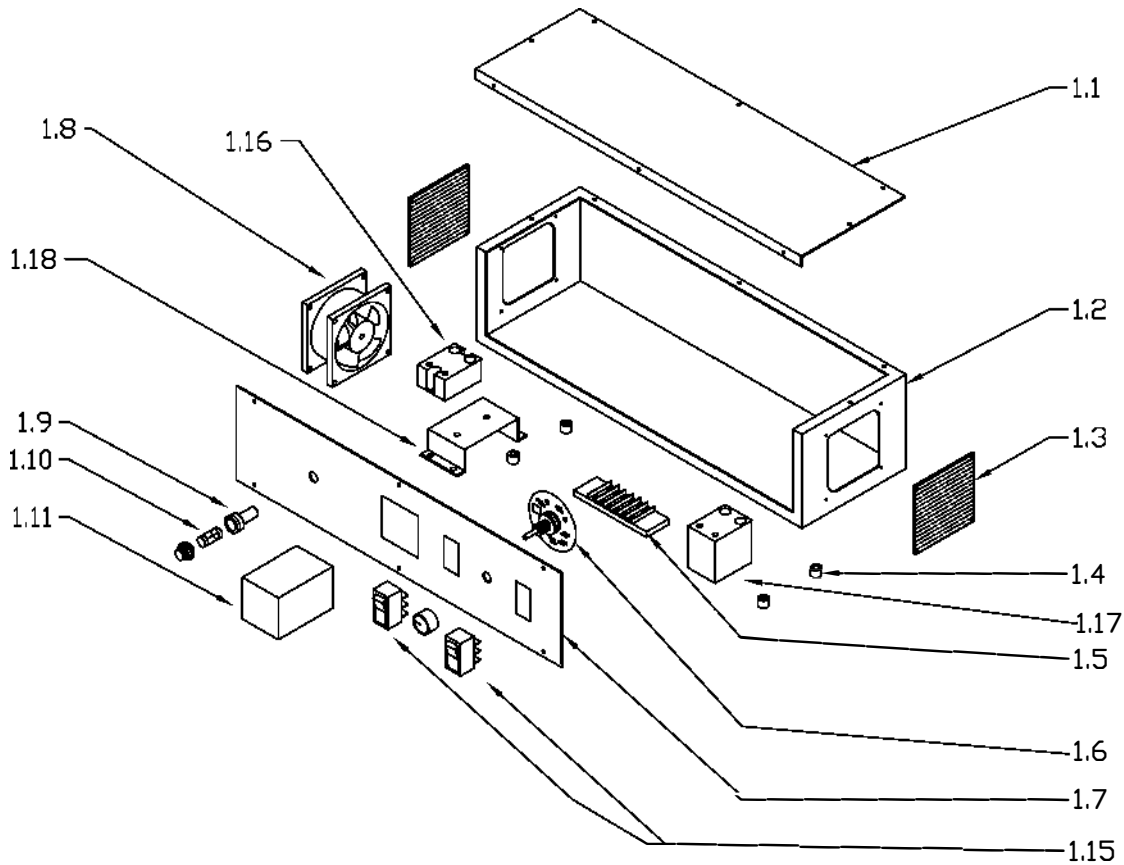
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4. Spare Parts



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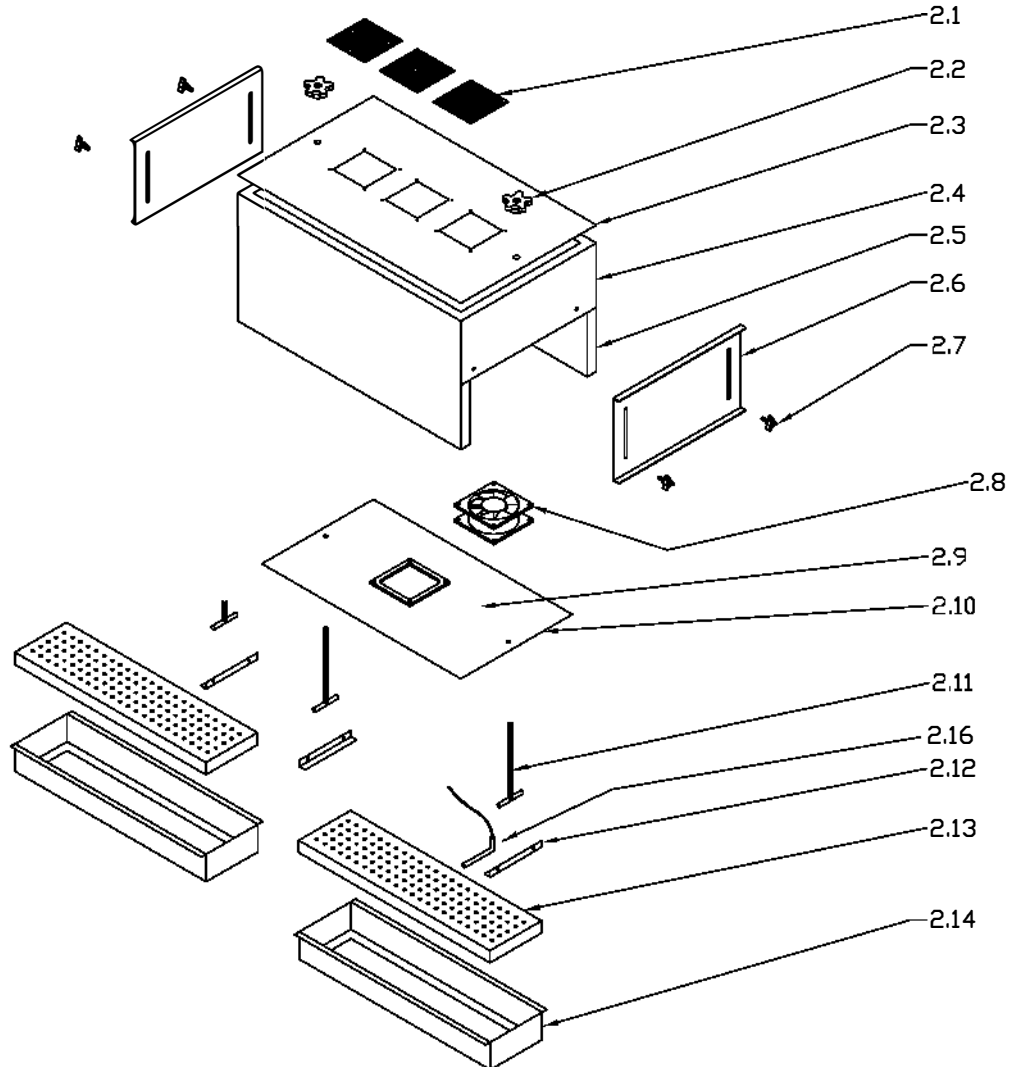
4.1. Controls



Item	Part Number	Description
1.1	90100517	Top cover
1.2	90100518	Enclosure, Control
1.3	31100237	Filter
1.4	90100519	Stand Off
1.5	90100520	Terminal Strip
1.6	91100003	Belt Speed Controller, 220V (includes knob)
1.7	90100525	Front Panel
1.8	31100333	Fan, 3", 230vac
1.9	90100522	Fuse Holder
1.10	90100523	Fuse
1.11	9261-82-001	Temperature Controller, Digital, Programmed
1.15	90100525	Power and Heat switch
1.16	342-05-017	Solid State Relay for Heaters
1.17	31100334	Heater Power Contactor
1.18	31100336	Heatsink, for Solid State Relay

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4.2 Heater Box

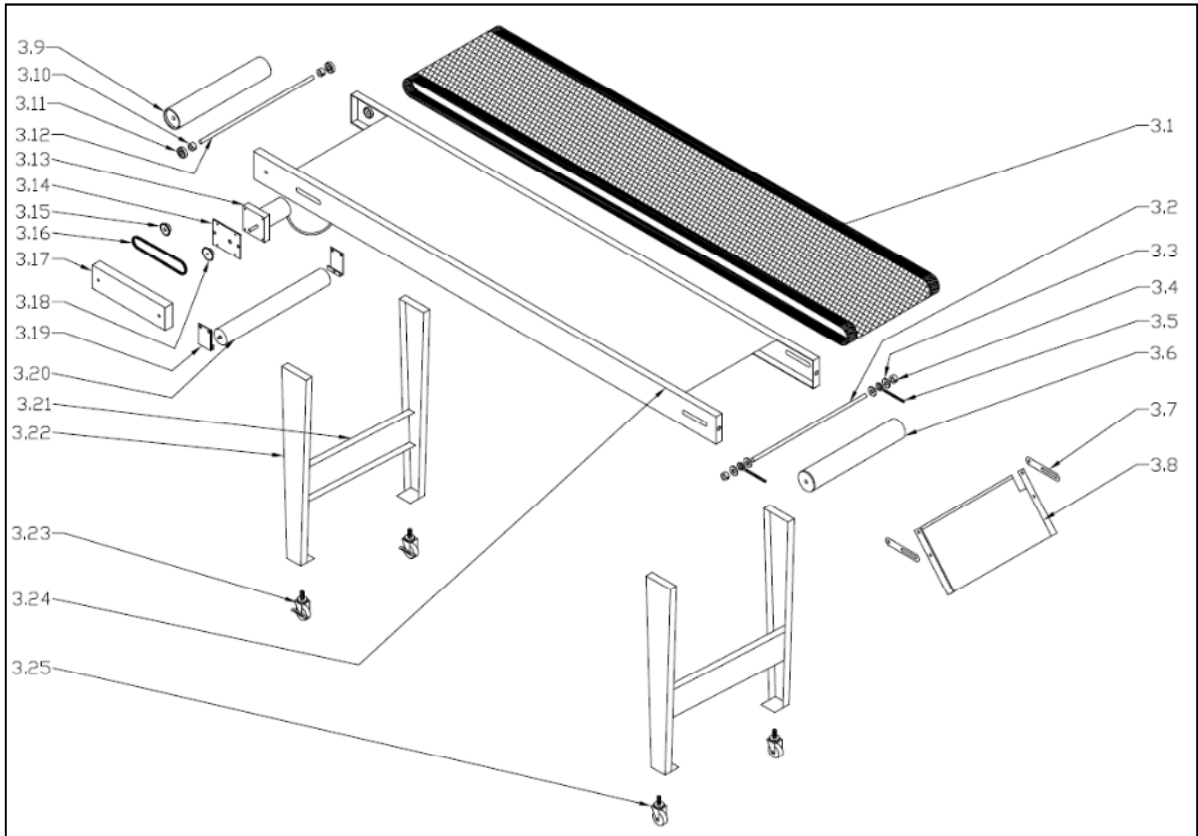


Item	Part Number	Description
2.1	90100032	Fan guard
2.2	90100526	Star knob
2.3	30100461	Top cover
2.4	90100527	End panel
2.5	90100528	Side panel
2.6	90100529	End gate
2.7	90100530	Star knob
2.8	31100335	Fan, 4", 230 vac

Item	Part Number	Description
2.9	90100531	Insulating spacer
2.10	90100545	Mounting plate
2.11	90100546	T bolt
2.12	90100547	Angle clip
2.13	31100329	Heating element
2.14	90100548	Box assembly
2.15	30100462	Decal set
2.16	31100331	Thermocouple, RTD

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4.3. Conveyor



Item	Part Number	Description
3.1	30100443	Belt
3.2	90100549	Shaft
3.3	90100550	Spacer Washer
3.4	90100551	Shaft collar
3.5	90100552	Eye Bolt
3.6	90100553	Roller assembly
3.7	90100554	Chute brace
3.8	90100555	Discharge chute
3.9	90100556	Roller assembly
3.10	90100551	Shaft collar
3.11	90100557	Bearing
3.12	90100549	Shaft
3.13	91100002	Gearmotor

Item	Part Number	Description
3.14	90100558	Mounting plate
3.15	90100559	Chain sprocket
3.16	90100560	Chain
3.17	90100561	Chain cover
3.18	90100562	Chain sprocket
3.19	90100563	Mounting bracket
3.20	90100564	Roller assembly
3.21	90100565	Leg brace
3.22	90100566	Leg
3.23	90100567	Caster, locking
3.24	90100568	Frame
3.25	90100569	Caster, non-locking

Note: Fasteners not shown are standard inch sizes that can be obtained from your local hardware supplier.