



WIRING CONNECTIONS	
ZONE 1	ROW "A" TERMINALS 1 + 2
ZONE 2	ROW "A" TERMINALS 3 + 4
ZONE 3	ROW "A" TERMINALS 5 + 6
ZONE 4	ROW "A" TERMINALS 7 + 8
ZONE 5	ROW "B" TERMINALS 2 + 3
ZONE 6	ROW "B" TERMINALS 4 + 5
ZONE 7	ROW "B" TERMINALS 6 + 7
ZONE 8	ROW "C" TERMINALS 1 + 2
ZONE 9	ROW "C" TERMINALS 3 + 4
ZONE 10	ROW "C" TERMINALS 5 + 6
ZONE 11	ROW "C" TERMINALS 7 + 8
ZONE 12	ROW "A" + "C" TERMINALS 9
ROW "B" TERMINAL 8 IS NOT USED	

BEFORE POWER IS CONNECTED:

- USE OHM METER TO CHECK EACH HEATER POWER LEAD. RESISTANCE TO GROUND SHOULD BE GREATER THAN 20,000 OHMS.
- CHECK RESISTANCE BETWEEN HEATER POWER LEADS. (SEE CALCULATION BELOW)

BEFORE POWER IS CONNECTED:

- CHECK CONNECTIONS OF RED AND WHITE LEADS TO INSURE PROPER CONNECTION TO THE CORRECT TERMINAL.
- USE OHM METER TO MEASURE BETWEEN RED AND WHITE LEADS. RESISTANCE SHOULD BE LOW.
- MEASURE BETWEEN EACH HEATER POWER LEAD AND EACH THERMOCOUPLE LEAD. RESISTANCE SHOULD BE GREATER THAN 20,000 OHMS.

ZONE	WHT	RED	WHT	RED	WHT	RED
ZONE 1	1	6	1	9	1	13
ZONE 2	2	7	2	10	2	14
ZONE 3	3	8	3	11	3	15
ZONE 4	4	9	4	12	4	16
ZONE 5	5	10	5	13	5	17
ZONE 6			6	14	6	18
ZONE 7			7	15	7	19
ZONE 8			8	16	8	20
ZONE 9					9	21
ZONE 10					10	22
ZONE 11					11	23
ZONE 12					12	24

HEATER VOLTS MARKED ON HEATER **X** HEATER VOLTS MARKED ON HEATER **÷** HEATER WATTS MARKED ON HEATER **≈** MEASURED RESISTANCE OHMS

EXAMPLE: (240 VOLTS) X (240 VOLTS) ÷ 820 WATTS ≈ 70 OHMS

NOTE: ALL GROUNDS MUST BE CONNECTED TO MOLD TO INSURE OPERATOR SAFETY.



800-521-0546

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**STANDARD CONFIGURATION
TYPICAL MOLD CONNECTOR WIRING DIAGRAM**