

# VETERAN

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## VTR Series

### VTR Models with the LS Control Instrument



**PCS**  
**COMPANY**

**Turn To The Industry Experts**

Model: \_\_\_\_\_

Serial Number : \_\_\_\_\_





**INSTRUCTION MANUAL**  
Veteran 'VTR' Series  
with 'LS' Control Instrument

COVERING

**INSTALLATION  
OPERATION  
MAINTENANCE**

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## **1.0 GENERAL**

- 1.1** Receiving Instructions
- 1.2** Introduction
- 1.3** Safety
- 1.4** Water Treatment
- 1.5** Components

## 1.1 RECEIVING INSTRUCTIONS

- A. Temperature control units are generally shipped skid mounted, boxed and wrapped in plastic prior to shipment.
- B. Unbox the unit before accepting delivery. Check for visible damage and document any evident damage on the delivery receipt or refuse the shipment. Shipping damage is the responsibility of the carrier.
- C. In order to expedite payment for damages, should they occur, follow proper procedures and keep detailed records. Take photographs of any suspected damage.

## 1.2 INTRODUCTION

- A. This manual covers temperature control units from 10 to 34 kW of heating capacity using the LS control instrument. The standard fluid operating temperature range for this temperature control unit is 32°F to 250°F for units. Consult the factory if you have questions about the operating range of your temperature control unit.
- B. The intent of this manual is to serve as a guide in the installation, operation and maintenance of your temperature control unit. Improper installation can lead to equipment damage and poor performance. Failure to follow the installation, operation and maintenance instructions may result in damage to the unit that is not covered under the limited warranty. This manual is for standard products. The information contained in this manual is intended to be general in nature. The information is typical only and may not represent the actual unit purchased.
- C. When calling for assistance from the Manufacturer's Service Department, it is important to know the model and serial number of the particular unit. The model number includes critical unit information which is helpful when troubleshooting operating difficulties. The serial number allows the service team to locate manufacturing and testing records which can have additional information relating to a particular unit.

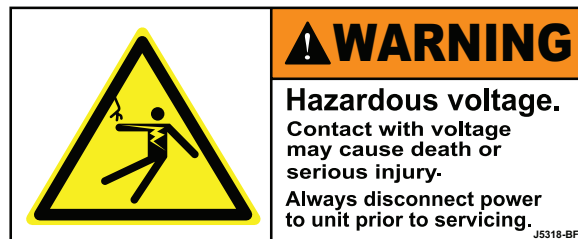
## 1.3 SAFETY

- A. It is important to become thoroughly familiar with this manual and the operating characteristics of the unit.
- B. It is the owner's responsibility to assure proper operator training, installation, operation, and maintenance of the unit.
- C. Observe all warning and safety placards applied to the unit. Failure to observe all warnings can result in serious injury or death to the operator and severe mechanical damage to the unit.

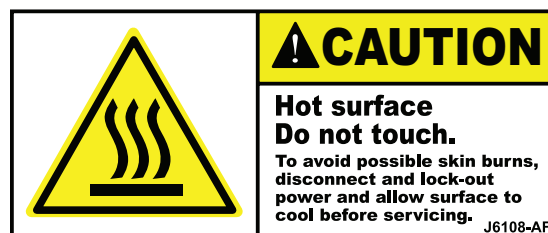


**WARNING:** This equipment contains hazardous voltages that can cause severe injury or death. Disconnect and lock out incoming power before installing or servicing the equipment.

- D. Observe all safety precautions during installation, startup and service of this equipment due to the presence of high voltage. Only qualified personnel should install, startup and service this equipment.
- E. When working on this equipment, observe precautions in literature and on tags, stickers and labels located on the equipment. Wear work gloves and safety glasses.
- F. Before installing and operating the unit, be aware of and follow any local laws and codes that apply to the installation.
- G. Samples of Warning Labels applied to typical temperature control units.
  - 1. Alerts users to the danger of high voltage.



- 2. Alerts the user to possible explosive danger.



- 3. Alerts the user to a hot surface danger due to high operating temperatures.



**WARNING: Improper water treatment will void unit warranty.**

## 1.4 WATER TREATMENT

- A. The fluid used in your temperature control unit will greatly effect its short and long-term operation. Lack of as well as improper water treatment can damage the temperature control unit by causing scale build-up, excessive corrosion and/or bacterial contamination. It is the equipment owner's responsibility to prevent damage caused by poor water quality. The services of a water treatment professional is recommended.
- B. The use of untreated or improperly treated water in a temperature control unit may result in scaling, erosion, corrosion, algae, bacteria or slime. The manufacturer recommends filtering the process water to prevent solids from plugging critical parts.
- C. It is recommended that the services of a qualified water treatment specialist be engaged to determine what water treatment is required.
- D. Advantage assumes no responsibility for equipment failures which result from untreated or improperly treated water.
- E. Do not use deionized water in this unit. Some customized units may be compatible with deionized water. Consult the factory before using deionized water.

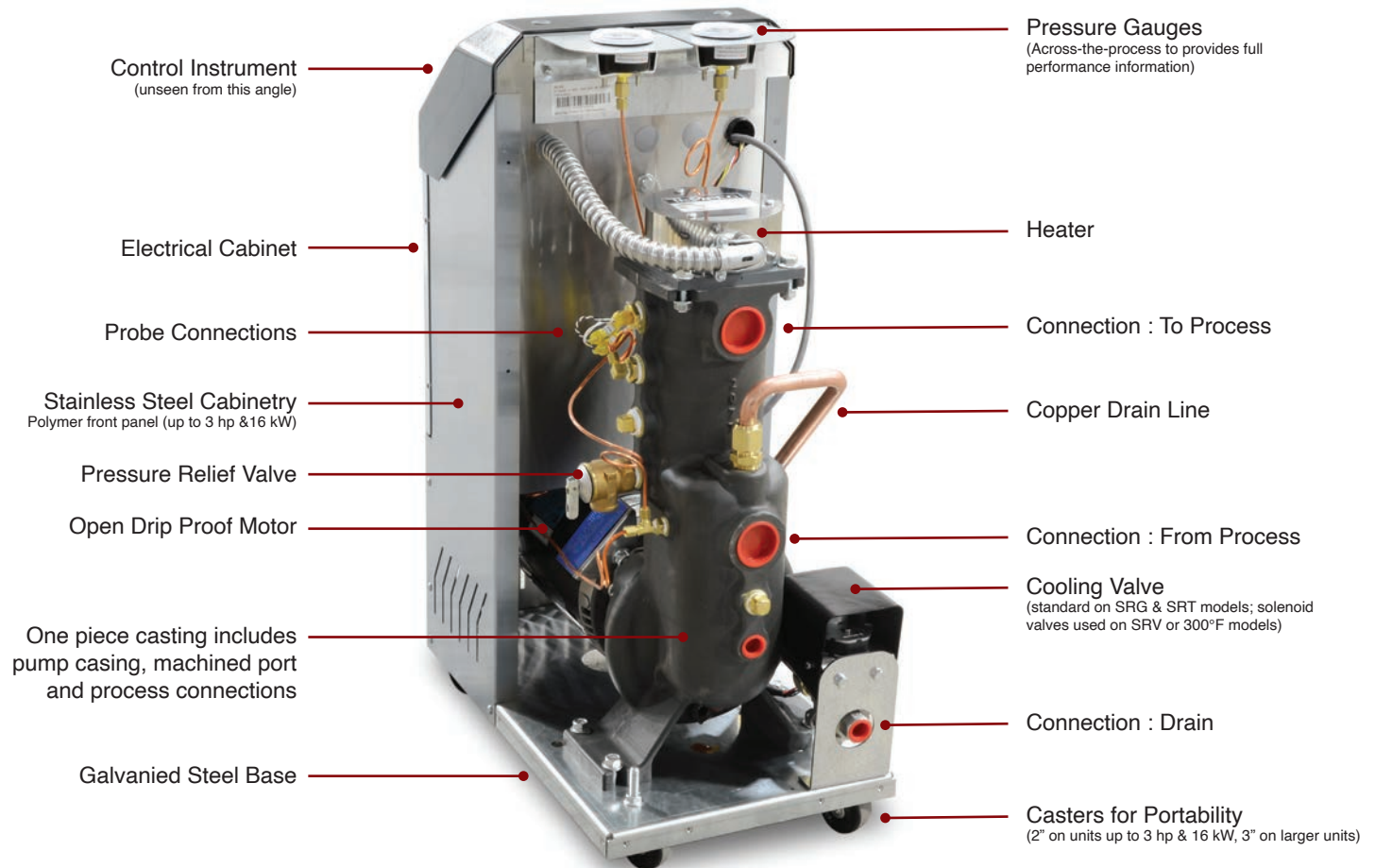
## 1.5 COMPONENTS

Cabinet style for units with:  
• 24 & 34 kW heaters  
• Up to 3 hp pumps  
Approximate dimensions:  
44" h x 16" w x 24" d

Cabinet style for units with:  
• 5 & 7½ hp pumps

Cabinet style for units with:  
• 16 kW & smaller heaters  
• 3 hp & smaller pumps  
Approximate dimensions:  
29 ½" h x 12 ½" w x 19" d





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## **2.0    INSTALLATION**

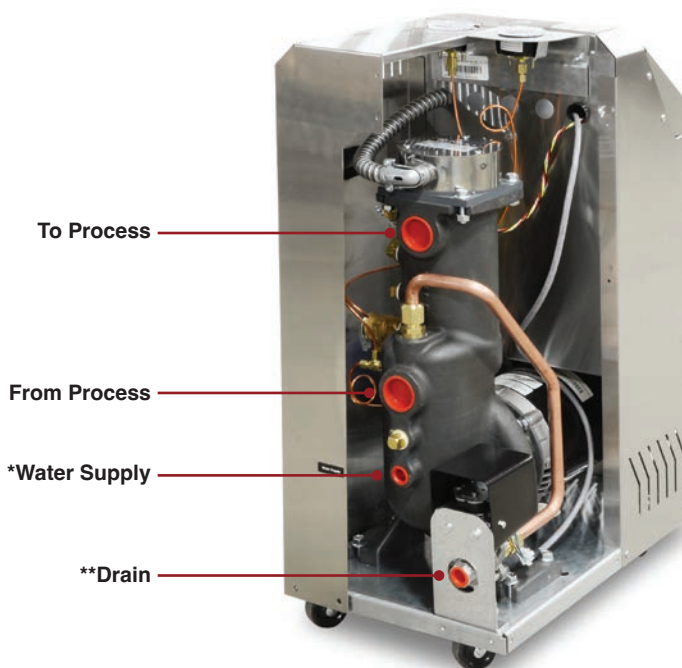
- 2.1**    General
- 2.2**    To and From Process Connections
- 2.3**    Water Supply Connection
- 2.4**    Drain Connection
- 2.5**    Electrical Connection

## 2.1 GENERAL

- A. Care should be taken to use materials (hose, rigid piping, valves or filters) rated for the temperature and pressure duty of your unit. Most units have a maximum operating temperature of 300°F or less and a maximum pressure of 150 PSI. The unit is most efficient when full size plumbing is run from the unit connections to and from the process. If necessary, reduce the plumbing size at your process, not at the unit.
- B. Be certain all process piping materials have the equivalent or larger diameter of the particular process connection.

**\*Connect Unit water supply to** plant's city water or well water source or tower water supply or chilled water supply.

**\*\*Connect Unit drain to** plant's open drain or tower water system return or chilled water system return.



## 2.2 TO AND FROM PROCESS CONNECTIONS

- A. Connect the unit's *To Process* port to the *Water In* port on the process manifold.
- B. Connect the unit's *From Process* port to the *Water Out* port on the process manifold.
- C. **Please note:** Process water piping circuitry should be designed to avoid an excessive use of elbows and/or lengths of pipe or hose. If hose is the material of choice, avoid tight twists or curls and excessive lengths.
- D. Valves and filters may be installed in the process water piping circuitry to facilitate service and maintenance, provided that such devices maintain the full inside diameter of the process connection. If installed, all such devices must be open and clean during unit operation.



**WARNING:** Check local codes to determine proper use of back flow prevention device in water supply line.

## 2.3 WATER SUPPLY CONNECTION

- A. Connect the unit's *Water Supply* port to the plant's city water, well water, tower water or chilled water supply.
- B. Water supply pressure requirements vary with operating temperatures. The chart below shows the required operating water supply pressures for various operating process temperatures. The required water supply pressure retains process water in a liquid state at temperatures over 180°F. Failure to maintain the required water supply pressure will cause premature failure of and increase maintenance in susceptible areas such as the shaft seal and heater.

| OPERATING TEMPERATURE |        |        |        |        |        |        |        |
|-----------------------|--------|--------|--------|--------|--------|--------|--------|
| 180°F                 | 190°F  | 200°F  | 210°F  | 220°F  | 230°F  | 240°F  | 250°F  |
| 20 PSI                | 25 PSI | 30 PSI | 35 PSI | 40 PSI | 45 PSI | 50 PSI | 55 PSI |
| WATER SUPPLY PRESSURE |        |        |        |        |        |        |        |

- C. The factory recommended minimum operating water supply pressure requirement is 20 PSI or shown the chart above based on operating temperature.
- D. Static water supply pressure can be determined at the unit's location by reading the unit's 0-160 PSI pressure gauges when the unit's pump motor is **OFF**.
- E. If water supply pressure as read on the unit's pressure gauges exceeds 75 PSI, a **pressure reducing valve** must be installed in the water supply line (refer to section 7.3 of this manual for installation information). The factory recommended 'regulated pressure out' is 55 PSI.



Typical pressure reducing valve installation (shown on S-925 model).

## 2.4 DRAIN CONNECTION:

- A. Connect the unit's **DRAIN** port to one of the following, determined by the water supply source:
  1. Open drain for well or city water supply.
  2. Tower water system return for tower system water supply.
  3. Chilled water system return for chilled water system supply.
- B. The factory recommends a minimum of 10 psi pressure differential between the water supply and drain line for proper cooling.

1. The amount of cooling provided by the unit depends on:
    - a. The cooling valve size
    - b. The pressure differential across the valve
    - c. The temperature difference between the unit set point and the cooling water temperature
    - d. The cooling valve position
  2. Consult factory when selecting the correct cooling valve for your application.
  3. In general the standard 3/8" solenoid cooling valve will provide approximately 24,000 Btu/hr (7 kW) of cooling per every 10°F difference between the cooling water temperature and the process set point based on 25 psi delta p across the cooling valve with 1/2" supply & return connections. Connecting the unit with 3/4" or 1" cooling water supply and return connections will increase the cooling capacity of the unit.
- C. For most applications, the drain line should not be valved. However, for installations with a pressurized drain system, it may be necessary to install a valve in the drain line. In such cases, the installed valve must be fully opened after installation and the valve handle removed to prevent operating the unit with a closed drain valve. The valve handle can be reattached to the valve body when it is necessary to close the valve.
- D. **CAUTION:** The unit must never be operated with a closed drain line valve. A closed drain line valve prevents adequate system cooling and will lead to unit overheating. Overheating of the unit may lead to unit damage and/or serious personal injury.



Typical drain valve installation  
(Shown on S-925 model).



**WARNING:** Never operation the Temperature Control Unit with a closed drain.

## 2.5 ELECTRICAL CONNECTION

### A. Standard Models

1. Electrical power supply requirements for standard units are identified on the equipment data tag. Verify that available voltage supply is the same as the unit's voltage requirements.

**WARNING: DO NOT CONNECT THE UNIT TO A VOLTAGE SUPPLY SOURCE NOT EQUAL TO THE UNIT'S VOLTAGE REQUIREMENTS AS SPECIFIED ON THE UNIT'S DATA PLATE.**



**WARNING:** Do not connect the unit to a voltage supply not equal to the unit's voltage requirements as specified on the unit's data plate. Use of incorrect voltage will void the unit's warranty and cause a significant hazard that may result in serious personal injury and unit damage.



**WARNING:** Electric Shock Hazard. High Voltage is present in the electrical cabinet. Disconnect power before servicing. Follow all facility lock-out tag-out procedures.

Use of incorrect voltage will void the unit's warranty and cause a significant hazard that may result in serious personal injury and/or unit damage.

2. For standard units with 10 and 16 KW heaters and up to 3 horsepower pumps, a four conductor cable, 10 foot in length, is provided for connection to an operator supplied fused disconnect.
3. For units with 24 and 34 KW heaters, the operator must provide a four conductor power cable and the fused disconnect.
4. The owner supplied fused disconnect must be sized and installed according to the unit's power supply requirements and local electrical codes.

#### **B. Models with Factory included Disconnect Switch and other Custom Features**

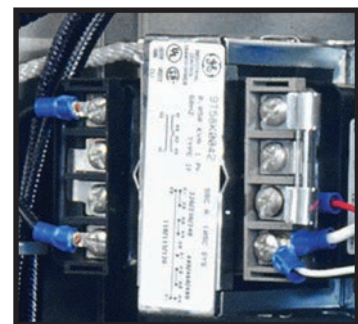
1. Some units may be customized and include a factory supplied power disconnect switch and/or higher specification electrical enclosure. Electrical power supply requirements are identified on the equipment data tag. Verify that available voltage supply is the same as the unit's voltage requirements.

**WARNING: DO NOT connect the unit to a voltage supply source not equal to the unit's voltage requirements as specified on the unit's data plate. Use of incorrect voltage will void the unit's warranty and cause a significant hazard that may result in damage to the unit or serious personal injury.**

2. Appropriate conduit and fittings should be selected which will maintain the integrity of the cabinet.
3. Supply a power conductor sized according to the unit's power supply requirements. Connect the power conductor to the unit's power supply entry terminal block.

#### **C. Control Circuit Wiring**

1. The unit's supplied control circuit is 110 volt, 1 phase, 60 cycle. The control circuit is supplied by the factory installed transformer. A control circuit fuse is provided.



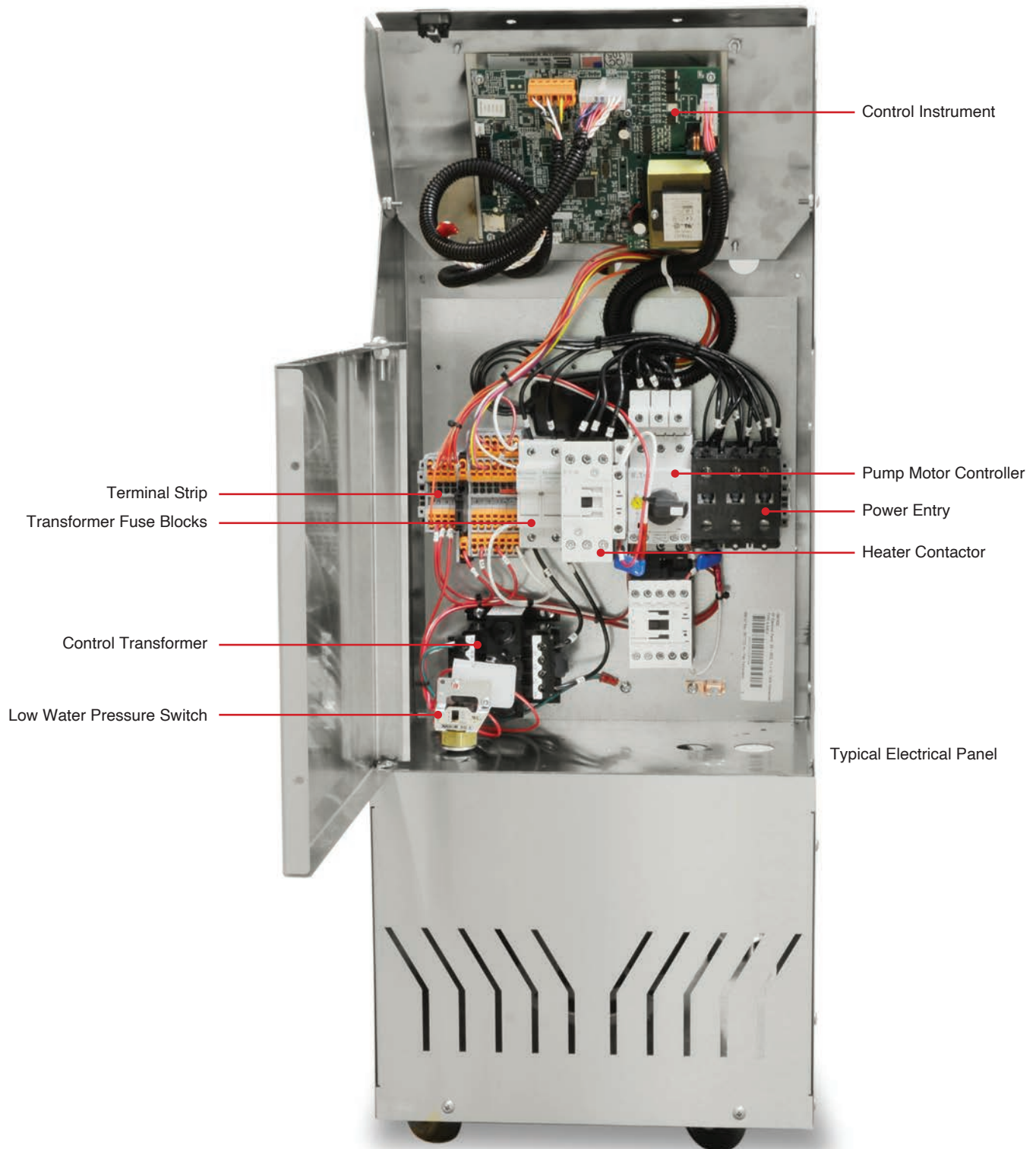
Typical control circuit transformer fuse

**D. General**

1. Make certain all ground connections to the unit are properly affixed. A proper connection to earth ground is required. A conduit ground is not a reliable conductor!
2. Make certain the power conductor, disconnecting means, and fusing are properly sized according to the unit's power supply requirements.
3. Make certain all electrical connections are tightly affixed. Any loose wiring connections must be tighten before engaging the power supply.
4. Make certain no moisture or standing water is present inside the electrical cabinet.



**WARNING:** Check that all electrical connections are tight before starting.  
Disconnect power before servicing. Follow all facility lock-out tag-out procedures.



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### **3.0 OPERATIONS**

- 3.1** General
- 3.2** Machine Start Up and Operation
- 3.3** Instrument Operation
- 3.4** Shut Down / Disconnect

### 3.1 GENERAL

- A. Failure to follow the factory required operation procedures may adversely affect the unit's ability to adequately control process temperature and may create a hazardous operating condition which may result in unit damage or serious operator injury.
- B. The Operations segment of this manual is outlined below:



**WARNING:** Follow all Factory operations procedures. Failure to do so may create a hazardous operating condition which may result in serious operator injury and/or unit damage.

- 3.2 **Machine start-up/operations procedure** - follow this segment to start the unit after the initial installation or to restart the unit after reinstallation to the same or different process. This section includes information on system fill, electric motor phasing (pump rotation) and process flow adjustments.
- 3.3 **Instrument Operation** - follow this segment to start up and operate the instrument. This section includes information on automatic and manual venting, setpoint selection and adjustment, and feature explanations.
- 3.4 **Shut down procedure** - follow this segment to shut down the unit. This segment includes information on system cool down, shut down, electrical power supply precautions, and disconnection from the system.

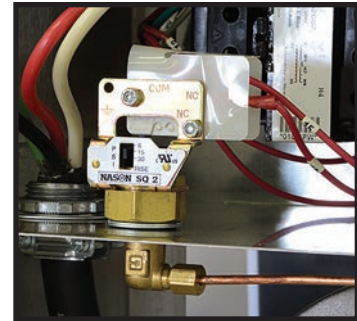
### 3.2 MACHINE START UP AND OPERATION

#### A. System Fill

- 1. Engage the water supply source by opening the water supply valve (customer installed) at the unit's location. If a valve is not installed, engage the water supply source at the plant's water supply central control point.
- 2. Once the water supply source is open, the unit will fill automatically. Allow a few moments for the unit to completely fill. The operator can determine the unit is properly filled when the *To Process* pressure gauge and the *From Process* pressure gauge stabilize at equal or closely similar pressure.
- 3. The operator must check for any water leakage in the unit's mechanical system, the process, and throughout the plant's water supply system. If a water leak is observed, the operator must disengage the water supply system, relieve all pressure, and repair the leak. The operator must verify the leak is repaired by refilling the system as outlined in this procedure.
- 4. During system fill, air is often trapped in the water system. Air is purged automatically via the cooling valve during initial pump start-up. All air must be purged before the unit is engaged for process temperature control. .

Entrained air in the system will adversely affect the unit's ability to control process temperature and can cause heater failure when the heating elements are exposed to this air.

5. Adequate water fill and pressure must be supplied to the unit for efficient and safe operation. To ensure sufficient water fill, an electrical panel mounted pressure switch is supplied with the unit. A capillary line feeds the pressure switch. If the water supply pressure is not adequate the unit can not be operated. This prevents operation with inadequate water fill and pressure. If the unit is operated without adequate water fill and pressure, the unit may be susceptible to overheating and could result in unit damage and/or serious injury to operating personnel.



Typical Panel mounted pressure switch

## B. Electric Motor Phasing (Pump Rotation)

1. The operator must determine the electric motor is phased correctly. This is done by visually inspecting the rotation of the motor shaft as outlined below. Incorrect phasing of the unit results in poor operation and eventual damage.
  - a. Supply electrical power to the unit by engaging the unit's disconnect switch. Once the correct voltage is supplied to the unit, the *Power* light on the display will illuminate.
  - b. Remove the thermoformed cover panel and open the hinged electrical cabinet panel cover. **Note that the electrical power is engaged at this point and caution must be observed while the electrical supply is engaged and the cabinet panel is open.**



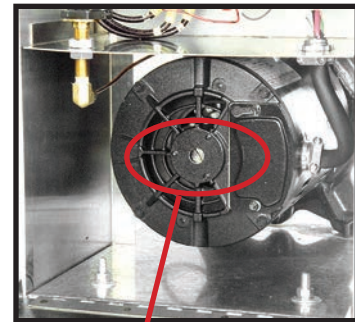
**WARNING:** *Electrical power is engaged and caution should be employed while the cabinet is open.*

- c. Locate the electric motor and identify the motor shaft inside the electric motor housing. The motor shaft can be seen through the vent slots in the motor housing or by removing the shaft cover.
  - d. Toggle the *On / Off* switch. This will cycle the motor "on" and then "off".
  - e. Observe the motor shaft as it slows to a stop to identify the rotation. Correct rotation is "clockwise", when viewed from the rear of the motor. Incorrect rotation is "counter-clockwise" when viewed from the rear of the motor. If the shaft does not rotate when the unit is started, the operator must identify the cause as outlined in this manual's troubleshooting and repair section.
  - f. If the unit is phased correctly, continue with the start up procedure at step C. If the unit is phased incorrect, continue with step 2.
2. To correct unit phase:
  - a. Disengage the electrical power supply to the unit at the unit's disconnect

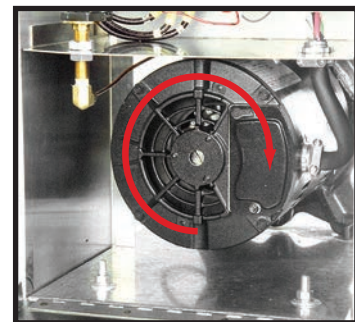
switch. Follow proper lockout procedures before proceeding.

- b. Once the electrical power supply is disengaged, reverse any two power leads of the power cord at the fused disconnect terminals.
- c. **Note: The operator must reverse the power leads at the disconnect only and *not* at the power entry terminals on the unit's electrical panel.** The unit's internal electrical system wiring is phased correctly at the factory and must not be altered in the field.

3. To visually verify pump rotation, start the unit and observe the pressure gauges. The To Process pressure will indicate 35-50 PSI more than the From Process pressure. In this state, the pump rotation is correct (clockwise). If this is not evident the unit is not correctly phased and should be corrected as outlined in step 2.



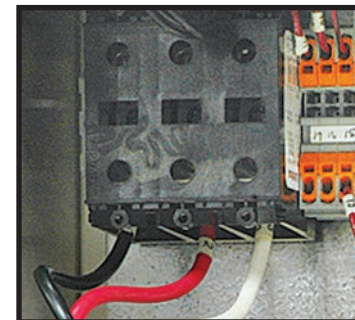
Remove shaft cover to view the motor shaft.



Correct rotation is clockwise when viewed from the rear of the motor.

### C. Process Flow Adjustments

1. The operator must determine and set proper water flow rate for the most efficient and trouble free operation.
  - a. Water flow rate through the process is determined by the pressure losses in the process loop. Generally, higher flow rates result in turbulent flow achieving maximum temperature control and lower maintenance.
  - b. If the flow rate exceeds the motor HP capacity, the electric motor will draw excessive amps. This is a result of the process loop's ability to flow water at a greater rate than can be provided by the pump. This will eventually result in tripping the thermal motor overload relay (overload relays open) and the unit will shut down and illuminate the *Safety* and *Alarm* lights on the display.
2. If an excessive flow situation is encountered and the motor overload circuit has tripped, the operator must manually reset the overload relay before operations can continue. This is done by opening the electrical panel cover and identifying the overload relay.



**DO NOT** reverse power leads at the unit's power entry.



**WARNING:** To correct phase ... switch power leads at the disconnect switch only.

Some older models have overload relay where a red button that pops out if the overloads are tripped. Simply push the button in until the overloads are reset.

Other overload relays have a switch. This switch will be positioned with the indicator pointing up when in normal operation. The indicator will be pointing to the left when the overloads are tripped. To reset, simply turn the switch to where the indicator points up.



Normal Operating Position



Tripped Position

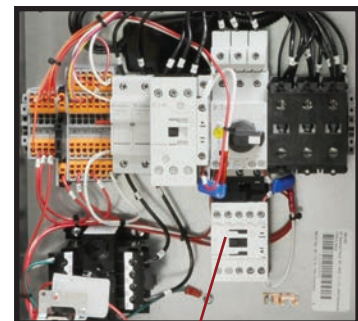
3. If a motor overload situation persists, the operator must adjust the flow rate to match the system pressure loss (reduce flow rate) to prevent continual tripping of the overload relay. This procedure is outlined here:

- a. Open electrical cabinet panel door. The panel cover is hinged and held open by a support cable. **Note that the electrical power is engaged at this point and caution must be observed while the cabinet panel is open.**



**WARNING:** Electrical power is engaged and caution should be employed while the cabinet is open.

- b. Identify the motor starter block. This block consists of the motor starter contactor and the overload relay.
- c. Place an amp meter on a single power lead coming from the overload relay.
- d. Locate the motor name plate on the pump motor housing. The full load amp rating for the motor is listed on the name plate.



Pump Motor Controller

- e. Engage the electrical power supply and start the unit.
- f. The amp meter will display the motor amps. Compare the actual motor amps as displayed on the amp meter to the full load amp rating as listed on the motor name plate.
- g. If the amp draw is excessive (higher than the listed name plate amp rating), a throttling valve must be installed in the “from process” water

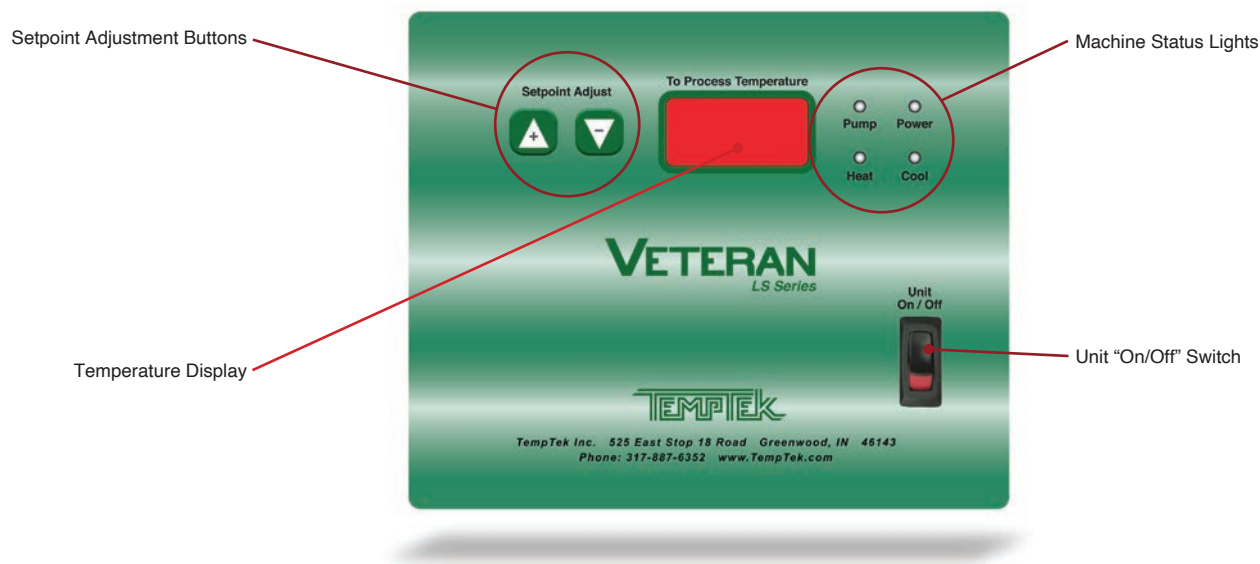
line. The throttling valve can be a gate valve or a ball valve.

- h. With the throttling valve installed, fully close the valve and then engage the pump motor. Slowly open the throttling valve and monitor the motor amps as displayed on the amp meter until the actual motor amps equal the listed full load amp rating of the motor. The process flow is now correctly adjusted. The valve should remain in this position during operation.



6. **LOW PROCESS FLOW:** The minimum recommended process flow rate is 10 GPM. Process restrictions may limit the flow to less than 10 GPM. We recommend the addition of bypass lines to raise the flow rate to 10 GPM. The best place to add bypass lines are on the extra ports on the molding machine manifold. If extra ports are not available, add a tee in the *To Process* and *From Process* lines, install a bypass line between the two tees with a throttling valve. Adjust the valve for a minimum of 10 GPM.

### 3.3 INSTRUMENT



**Note:** The standard temperature range for LS control instrument is approximately 32°F above the cooling water supply temperature to 250°F.

**A. INSTRUMENT START-UP**

1. When the correct electrical power and adequate water supply pressure are supplied to the unit, it is possible to start the unit for temperature control duty.
2. When the power is engaged to the unit, the instrument will momentarily illuminate all indicating lights and digits on the display. After a short delay, the controller software version number is displayed. At this time, the operator can verify that all lights and digits are functioning properly. If the operator determines an indicating light or digit does not illuminate, the controller must be removed and sent to the factory for repair.
3. Also, the instrument will immediately check the status of the sensor probe, the high temperature safety switch, and the water supply pressure switch for acceptable operating conditions. If all systems are found to be 'ok', the unit will begin operations. If a system is not found to be 'ok', the instrument will not start and will illuminate *no FLO* in the temperature display window.
4. Conditions that will prevent the unit from starting process temperature control operations are:
  - a. **Water supply pressure inadequate** (pressure switch is open). The unit is prevented from operating without adequate water supply pressure by an electrical panel mounted pressure switch. Sufficient water supply pressure must be present to close the switch and consent the safety circuit.
  - b. **Motor overload switch opened.** The electric motor is protected from excessive flow by a set of thermal overload relays. These relays will open (trip) and prevent operation. If open, the overload relay must be reset before operations can continue. An excessive flow condition must be corrected immediately.
  - c. **High temperature limit switch open.** The unit is prevented from operations with temperatures exceeding 256°F by a "high temperature limit switch". This switch is installed in the *To Process* temperature sensor. If this switch is open (due to a high temperature condition), the control circuit is not consented and the unit cannot be started. If a high temperature condition exists, the unit must first "cool down" (reduce water temperature) before the "high temperature limit switch" will automatically reset to allow operation.
  - d. **Temperature sensor.** Failure of the *To Process* temperature sensor will be indicated in the *Temperature* window by a "--- ---". Check the sensor cable and connector for loose wires or moisture. If no problems are found, replace the sensor.

## B. INSTRUMENT OPERATION

1. Process temperature control operation is started by toggling the unit's *On / Off* rocker switch to the "on" position.
2. When the *On / Off* rocker switch is toggled "on", the instrument will immediately display the process temperature as indicated by the temperature sensor.
3. If temperature is less than 100°F, the PVT™ cooling valve will open for 45 seconds. This is automatic and purges entrained air from the process system to the drain. Automatic venting is indicated by a *Air Prg* display in the *Temperature* window. If the automatic vent cycle does not vent all entrained air (evidenced by a "rattling" sound in the unit and fluctuating pressure gauges), manually vent the system by depressing and holding the *Up Arrow* and *Down Arrow* push buttons. Release the buttons to conclude the manual vent sequence. If the *To Process* temperature exceeds 100°F, the instrument will bypass the automatic vent cycle and step immediately to process temperature control operation.
4. To display the setpoint temperature, briefly touch the *Up Arrow* or *Down Arrow* push buttons. To change the setpoint, hold the *Up Arrow* or *Down Arrow* push buttons until the preferred setpoint temperature is indicated in the *Temperature* window. Setpoint temperatures can be adjusted anytime.

## C. INSTRUMENT CONTROLS

1. **UNIT ON/OFF SWITCH:** This rocker switch engages/disengages electrical supply to the pump, heater and PVT™ cooling valve (figure 3.3A).
2. **UP ARROW:** Depress briefly to display the setpoint temperature. Depress and hold to increase the setpoint temperature. If pressed momentarily the setpoint value is incremented by one degree. If held down longer the setpoint will increase slowly at first and then faster. The setpoint control range is 32° to 250°F (0° - 121°C).
3. **DOWN ARROW:** Depress briefly to display the setpoint temperature. Depress and hold to decrease the setpoint temperature. If pressed momentarily the setpoint value is incremented by one degree. If held down longer the setpoint will increase slowly at first and then faster. The setpoint control range is 32° to 250°F (0° - 121°C).

## D. STATUS INDICATING LIGHTS

1. **POWER ON:** Illuminates when power is applied to the unit.
2. **PUMP:** Illuminates when the unit's *On / Off* rocker switch is turned "on" and the motor pump is operating. Even with the *On / Off* rocker switch "on", the *Pump* light will not illuminate if a safety fault condition exists.

3. **HEAT:** Illuminates when the heater is on to increase process water temperature.
4. **COOL:** Illuminates when the PVT™ valve is open. Opening the valve will discharge process water to the drain. Opening the valve also allows cooling water flow from the water supply source to enter the circulating system and mix with the heated process water to reduce process temperature.

### 3.4 SHUT DOWN - DISCONNECT

#### A. UNIT SHUT DOWN

1. Decrease the setpoint temperature lower than 85°F and allow the unit to cool to the temperature. A pump seal cooling feature can be selected from the features menu to automatically cool the unit once the stop button is pressed.
2. Press the stop button.
3. Relieve residual static pressure before disconnecting or servicing the unit.
4. Follow all lock-out tag-out requirements.

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## **4.0 TROUBLESHOOTING**

- 4.1** Unit will not start (Display is not Illuminated)
- 4.2** Unit will not start (Display Illuminated)
- 4.3** Unit Stops
- 4.4** Unit Overheats
- 4.5** Unit Underheats
- 4.6** Pressure Relief Valve Leaks

#### 4.1 UNIT WILL NOT START (POWER LIGHT IS NOT ILLUMINATED)

- A. One or more fuses at the main disconnect device are open (blown). Determine continuity at each fuse. If continuity is not determined, replace the fuse. Then determine cause of blown fuse.
- B. Control circuit transformer fuse is open (blown). Determine continuity at the control circuit transformer fuse. If continuity is not determined, replace the fuse.

#### 4.2 UNIT WILL NOT START (POWER LIGHT IS ILLUMINATED)

- A. **Power supply is ON.** The operator can determine that electrical power supply to the unit is “on” by an illuminated *Power* light on the display. Even with the main power supply on, the unit is prevented from operating by one of the following conditions:
  - 1. ***Water supply pressure inadequate.*** (pressure switch is open). The unit is prevented from operation without adequate water supply pressure by the electrical panel mounted pressure switch. Sufficient water supply pressure must be present to close the switch.
  - 2. ***Motor overload switch opened.*** The electric motor is protected from overload conditions by a set of thermal overload relays. These relays will open (trip). If the overload relay is open, it must be reset before operation can continue. An excessive flow condition must be isolated and corrected immediately.
  - 3. ***High temperature limit switch open.*** The unit is prevented from operations at temperatures exceeding 256°F by a “high temperature limit switch”. This switch is installed in the *To Process* temperature sensor. If this switch is open (due to a high temperature condition), the unit cannot be started and must “cool down” before the “high temperature limit switch” will automatically reset.

#### 4.3 UNIT STOPS

- A. The operator should determine the main power supply to the unit is **ON** by an illuminated *Power* light on the display. With the main power supply “on”, the unit will be prevented from starting by the following conditions:
  - 1. ***Water supply pressure inadequate.*** (pressure switch is open). The unit is prevented from operation without adequate water supply pressure by the electrical panel mounted pressure switch. Sufficient water supply pressure must be present to close the switch.
  - 2. ***Motor overload switch opened.*** The electric motor is protected from overload conditions by a set of thermal overload relays. These relays will open (trip). If the overload relay is open, it must be reset before operation can continue. An excessive flow condition must be isolated and corrected immediately.
  - 3. ***High temperature limit switch open.*** The unit is prevented from operations at temperatures exceeding 256°F by a “high temperature limit switch”. This switch is installed in the *To Process* temperature sensor. If this switch is open (due to a high temperature condition), the unit cannot be started and must “cool down” before the “high temperature limit switch” will automatically reset.

- B.** The operator should check the *Power* light on the display. The operator should check the following conditions:
1. One or more fuses at the main disconnect device are open (blown). Determine continuity at each fuse. If continuity is not determined, replace the fuse. Then determine cause of blown fuse.
  2. Control circuit transformer fuse is open (blown). Determine continuity at the control circuit transformer fuse. If continuity is not determined, replace the fuse.

## 4.4 UNIT OVERHEATS

- A.** This is evidenced by *To Process* temperatures consistently above the selected setpoint temperature. Overheating is also evidenced by a *To Process* temperature that continues to escalate above the setpoint temperature with no apparent cooling action, even though the *Cool* light is on. Extreme overheating is evidenced by *To Process* temperatures over 256°F. The operator should check for the following conditions:
1. **Inadequate water supply pressure.** The unit must be supplied with adequate water flow to provide cooling when required. The minimum pressure differential between the water supply and drain to achieve full cooling capacity is 10 PSI. The minimum water supply pressure is 20 PSI. A drop in water supply pressure operation will cause the pump to stop and a safety fault to be displayed.
  2. **PVT™ valve defective.** The instrument opens and closes the PVT™ cooling valve as prescribed by the current process load. If the valve becomes clogged with process water debris or scaled with mineral deposits, its operation is hindered or fully prevented and adequate process water discharge to drain is prevented. The operator must service the PVT™ valve and remove any loose debris. Massive debris or scale deposits may necessitate replacement of the internal PVT™ valve components. The procedure for servicing the valve is outlined in Section 5.3 of this manual.
  3. **Drain line obstruction.** The operator must determine if the drain line is obstructed by the following conditions. Section 2.4 outlines the parameters of correct drain line installation.
    - a. **Closed drain line valve.** An installed but partially or fully closed valve in the drain line prevents full discharge to drain and contributes to an overheating condition. The operator should determine the drain line is open.
    - b. **High drain back pressure.** Pressurized plant drain lines will prevent flow to drain if the differential between the water supply pressure and the drain line pressure is inadequate. The factory recommended minimum differential is 20 psi. If the differential is less than the factory recommendation, plant service personnel should take measures to reduce drain line pressure.
  4. **Instrument defective.** The instrument is designed and manufactured exclusively by Advantage. The instrument is life-tested and found to be field reliable. However, in the case where the instrument is determined to be defective, the operator must remove the assembly according

to instructions outlined in this manual and return the assembly to the factory. The instrument is not a field serviceable component.

## 4.5 UNIT UNDERHEATS

- A. This is evidence by operations with *To Process* temperatures consistently below the selected setpoint temperature.
1. **Process water leakage.** When the instrument engages the heater to elevate process temperature, the input of heat into the process can be offset by a defective PVT™ valve. If the PVT™ valve is defective, it may pass a larger than required stream to drain, thus providing unwanted cooling. A defective PVT™ valve should be repaired immediately.
  2. **Heater element failure.** A failed heater element will not input adequate heat into the process to elevate the process water temperature. The operator must check the amps at the heater contactor with the contactor energized. Zero amps at the contactor indicate a failed heater or burnt wire connections. The operator should remove the failed heater and replace with a new heater according to the procedure outlined in section 5.2.
  3. **Unit capacity too low.** This occurs when the process requires more heat than the unit is capable of producing. The only option in such cases is to install a unit with an adequate heater KW rating for the load.
  4. **Instrument defective.** The instrument is designed and manufactured exclusively by Advantage. The instrument is life-tested and found to be field reliable. However, in the case where the instrument is determined to be defective, the operator must remove the assembly according to instructions outlined in this manual and return the assembly to the factory. The instrument is not a field serviceable component.

## 4.6 PRESSURE RELIEF VALVE LEAKS

- A. The unit has a 150 psi pressure relief valve mounted in the cooling cylinder. If the valve is found to be leaking, the operator should check the following:
- B. **Water supply pressure exceeds 75 psi.** The unit is designed to operate with water supply **NOT** exceeding 75 psi. See section 2.3 paragraph B for specific water supply pressure requirements at corresponding setpoint temperatures. If the plant water supply pressure exceeds 75 psi, the pressure relief valve may leak. Static water supply pressure can be determined at the unit's location by reading the unit's 0-160 PSI pressure gauges when the unit's motor pump is off. If the water supply pressure at the unit's location exceeds 75 PSI, a pressure reducing valve must be installed in the water supply line. The factory recommended 'regulated pressure out' is 55 PSI. Refer to section 7.3 for regulator installation drawing.
- C. **Back flow prevention device in water supply line.** If a back flow prevention device (check valve, pressure regulator, closed valve) is installed in the water supply line, increased pressures from thermal expansion are unable to move into the water supply line. This will increase the unit's internal pressure causing the pressure relief valve to leak. Refer to section 7.3 for regulator installation drawing.

- D. Valve contamination.** The pressure relief valve may become contaminated with water debris causing the valve not to close properly. If this is the case, flushing the valve for a moment will cleanse the seat and allow it to work properly. If flushing the valve does not remedy the leaking, the valve must be replaced.
- E. Extreme internal system pressure.** If the internal pressure in the unit is elevated, the pressure relief valve will leak as a safety measure to dissipate excessive pressure. If this is the case, the operator must determine why the system internal pressure is excessive and correct the condition.

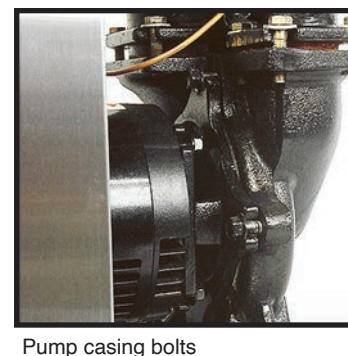
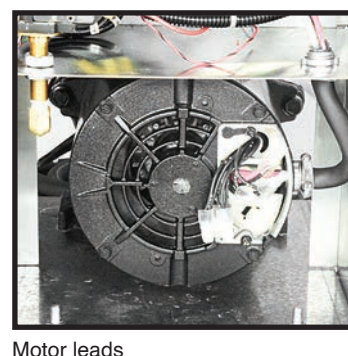
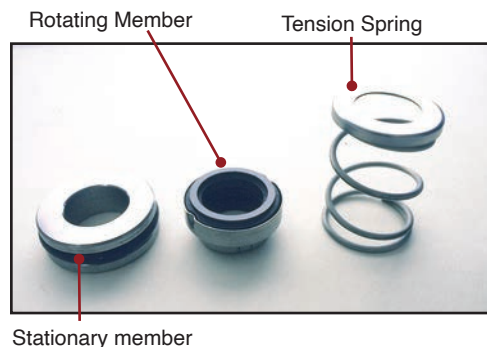
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## **5.0 SERVICE/MAINTENANCE**

- 5.1** Pump Seal Replacement
- 5.2** Heater Replacement
- 5.3** Cooling Valve Service
- 5.4** Voltage Change
- 5.5** Sensor Probe Service
- 5.6** Pressure Switch Service
- 5.7** Electronic Instrument Repair Policy & Procedure
- 5.8** Celsius Temperature Display
- 5.9** Heater Contactor and Pump Motor Starter

## 5.1 PUMP SEAL REPLACEMENT

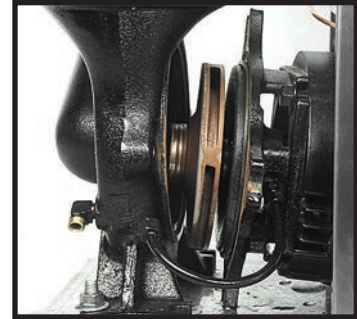
- A.** The pump seal is a carbon/ceramic shaft seal assembly including a stationary member, rotating member and tension spring.
- B.** The life cycle of the pump seal is determined by hours of use, operating temperature and water quality. Poor water quality is the primary reason for premature pump seal failure.
- C.** The operator should follow this procedure to replace the pump seal:
  1. Disengage process operations and relieve all system pressure.
  2. Disengage main power supply. Verify the *Power* light on the display is “off”.
  3. Remove the lift-off access panel and set aside.
  4. Remove the necessary panels to gain access to the pump motor.
  5. Drain machine by removing the pump casing drain plug.
  6. Remove the three motor wire leads from the motor wiring terminals. The operator should “map” the wire terminal locations to ensure correct rewiring. The power cord should be removed from the motor housing.
  7. Locate and remove the 4 pump casing bolts. These bolts secure the motor and motor adapter to the pump casing.
  8. Separate the motor and adapter from the pump casing to expose the pump impeller. Remove the motor and adapter from the unit and place on a workbench to continue the procedure.
  9. Locate and remove the dust cap from the motor to expose slotted motor shaft.



The motor shaft is free to rotate, but must be secured to remove the impeller. To secure the motor shaft, insert a flat bladed screw driver in slot to hold the shaft stationary.

10. Locate and remove impeller locking screw. Using a socket and ratchet, the impeller retaining screw can be removed. Once removed, the impeller can be “unthreaded” from the motor shaft to expose the pump seal assembly.
11. Remove all seal parts. Note seal component arrangement to facilitate reassembly.
12. Clean the motor shaft and lubricate with a mild soap solution. **Note: Oil must never be used as a lubricant as it will damage the rubber parts of the seal assembly.**
13. Install new stationary seal member in pump casing cavity. Be certain the stationary seal member is fully squared and seated in cavity.
14. Slide the rotating member onto the lubricated pump shaft. Be certain not to damage or tear the rubber bellows assembly.
15. Place the spring onto the rotating member.
16. Align the tension spring and rotating member before reinstalling the impeller. Be certain the spring and rotating member are aligned before the impeller is fully tightened and the impeller retaining screw is reinstalled.
17. Clean the pump casing, cavities, impeller and O-ring before reassembly.
18. Mate the motor and adapter to the pump casing. Reinstall the 4 pump casing bolts.
19. Reconnect the motor power cord and leads.
20. Replace the thermoformed front panel and the lift-off cover.

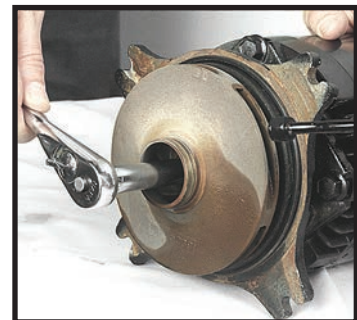
- D. When this procedure is complete, the operator may restart the unit. In many cases, a new pump seal will experience a small amount of leakage for a short



Impeller



Motor shaft



Removing impeller locking screw with ratchet



Seal components

time. This is normal. After a few moments, the new seal will take seat and the leak will stop.



Seal components

Figure 5.1I



Stationary member

Figure 5.1J



Rotating member

Figure 5.1K



Aligning impeller and spring

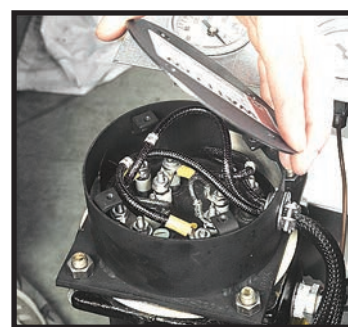
Figure 5.1L

## 5.2 HEATER REPLACEMENT

- A. The heater is a flange mounted assembly and inserted into the cast cylinder tank and secured by 4 bolts.
- B. The operator can determine if the heater requires replacement when the heater draws “0” amps or when a continuity check of each heater element is negative.
- C. Generally, heaters fail due to low water flow, low water pressure, air in the system or defective heating elements.
- D. The operator should follow this procedure to replace the heater:
  1. Disengage operations and be certain all system pressure is relieved and the unit’s pressure gauges read “0”.
  2. Disengage main power supply. Verify the *Power* light on the display is “off”.
  3. Remove the lift-off access panel and set aside
  4. Drain machine. The machine can be drained by removing the pump casing drain plug.
  5. Remove heater’s junction box cover to locate wiring connections. The operator should note the wiring connections to ensure correct reinstallation.
  6. Disconnect the three power leads from the heater terminals. Remove the power cord from the junction box.
  7. Remove the 4 heater mounting bolts.
  8. Remove heater.
  9. Before the new heater is installed, the mating surface of the cast tank should be cleaned. Once cleaned, place the new heater gasket onto the tank mating surface. Coat the mating surface with a high temperature gasket sealant.
  10. Set new heater into tank. Aligning the bolt pattern of the heater and tank flanges.



Heater



Heater junction wires



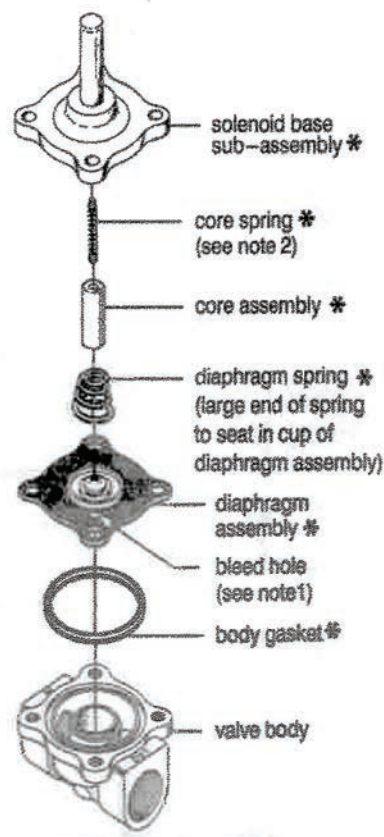
Heater mounting bolts

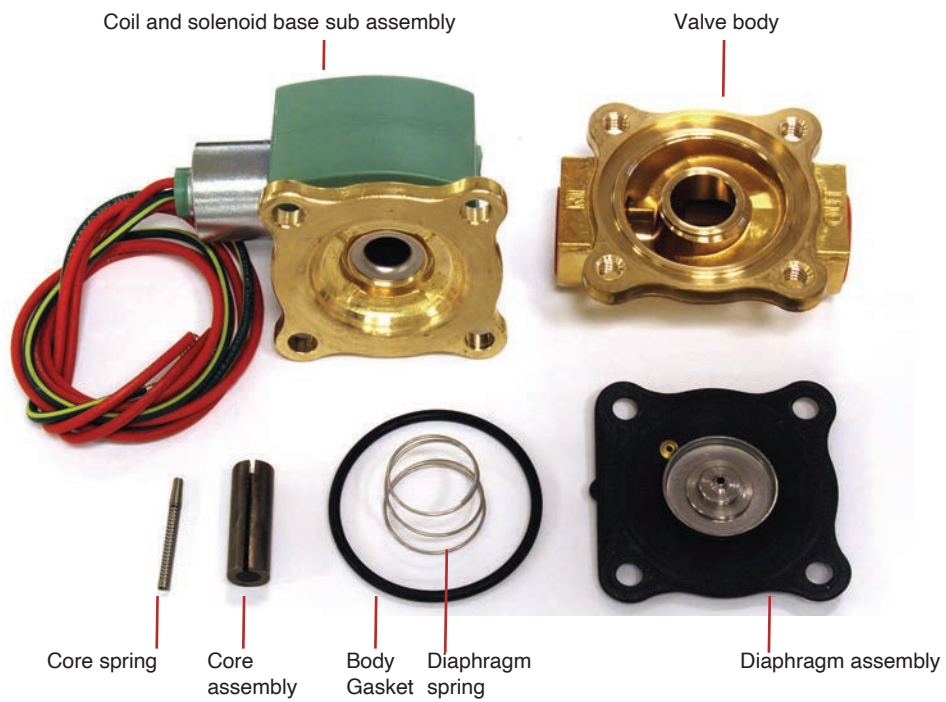


Remove heater

## 5.3 COOLING VALVE SERVICE

- A. The unit uses the PVT™ (Pulsed Valved Technology) solenoid valve (figure 5.3A) as the cooling valve. The solenoid valve is controlled by the instrument.
- B. Generally, the PVT™ valve require service for a failed coil or more often it will not fully close because debris from poor make-up water quality is in the valve mechanism.
- C. To service the solenoid valve follow the procedure below.
  1. Disengage process operations according to the procedure outlined in **section 3.4**. Be certain process fluid pressure is relieved (coolant pressure gauge reads “0”) and water system flow is shut off.
  2. Disengage main power supply. The operator must follow all lockout/tagout procedures.
  3. Remove or open any access cover panel and set aside to gain access to the make-up solenoid valve.
  4. The solenoid valve can be disassemble by removing the 4 retaining screws.
  5. Keeping all electrical connections intact, lift the coil and top solenoid base assembly and set aside.
  6. **Note the arrangement of the core spring and core assembly, diaphragm spring and diaphragm assembly.** (See diagram.)





## 5.4 VOLTAGE CHANGE

- A. Some units can undergo a field voltage conversion by qualified technicians. Consult with the Advantage Service Department to determine if your unit can be converted. Have your Serial Number ready and call 317-887-0729.

- B. Typical Conversions for 1/2 to 7.5 horsepower motors and 10 to 16 kW heaters:

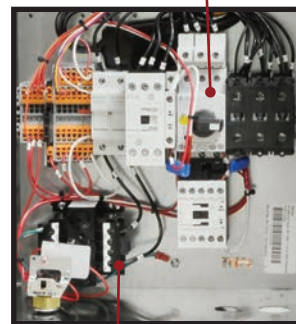
1. 240/3/60 to 480/3/60
2. 480/3/60 to 240/3/60
3. 480/3/60 to 208/3/60

Consult factory for other power conversions.

- C. For a field voltage changeover, the following items will require replacement or rewiring:

1. Heater (rewiring)
2. Motor (rewiring)
3. Transformer (rewiring)
4. Motor starter and overload block (replace)
5. Replace unit data tag with tag stating new voltage and amp rating.

Motor Starter and Overload Block

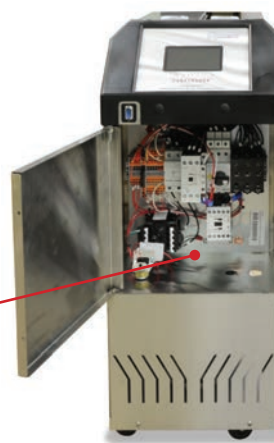


Transformer

- D. The qualified technician should follow this procedure to complete a field voltage changeover:

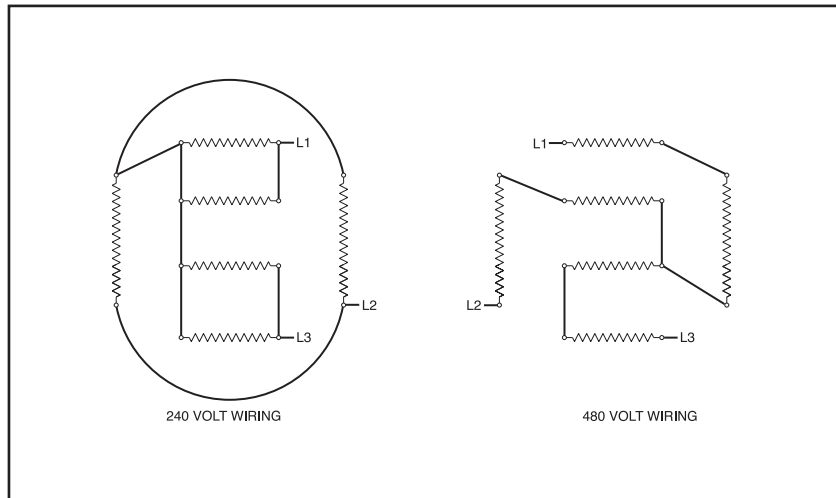
1. Disengage operations and verify all system pressure is relieved and the unit's pressure gauges read "0".
2. Disengage main power supply. **Follow proper lock-out procedures.** The operator must verify the *Power* light on the display is "off".
3. Gain access to the electrical panel.

Typical electrical panel.



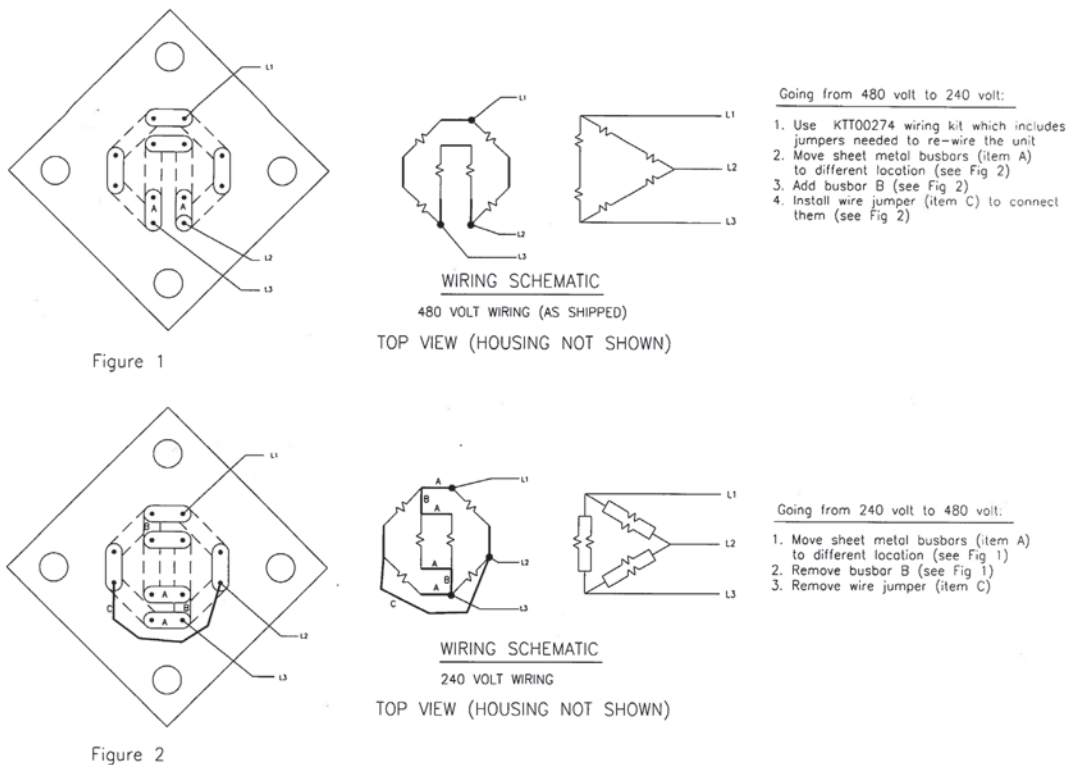
4. Rewire the heater to the new voltage. Schematics for heater brands used in typical temperature control units are shown below.

### Wiring Schematic for Watlow Brand Heaters : 10 kw & 16 kW

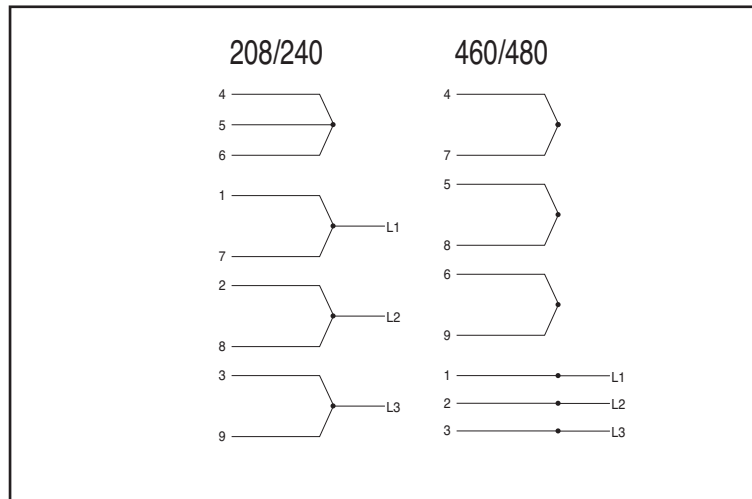


Wiring schematics for 240 and 480 volt heaters Revised 4/11

### Wiring Schematic for Tempco Brand Heaters : 10 kw & 16 kW



5. Remove the thermoformed front panel and open the electrical cabinet panel door. Unplug the instrument connectors to fully extend the hinged panel.
6. Rewire the pump motor for the new voltage. Most Sentra pump motors are dual voltage. The drawing schematic below shows the wiring schematic for 240 and 480 voltages.



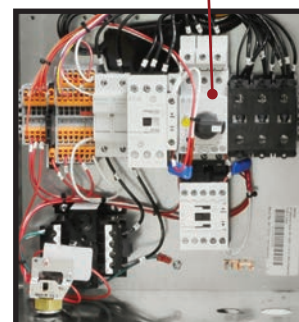
Wiring schematics for 240 and 480 volt pump motors

7. Rewire the transformer to the proper voltages as shown by the schematic on the transformer.
8. Replace the motor starter and overload block. Adjust the overload block settings for the current draw at the new voltage.
9. Once a voltage change is complete, be certain the unit is properly connected to the new voltage supply, as outlined in **section 2.5** of this manual. Restart unit operations according to **section 3** of this manual.



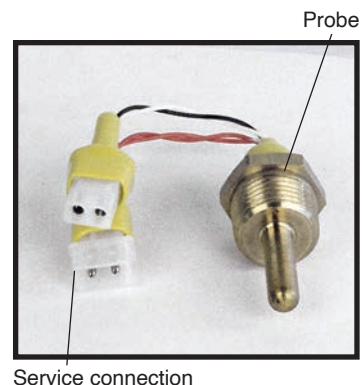
Typical Transformer

Motor Starter and Overload Block



## 5.5 SENSOR PROBE SERVICE

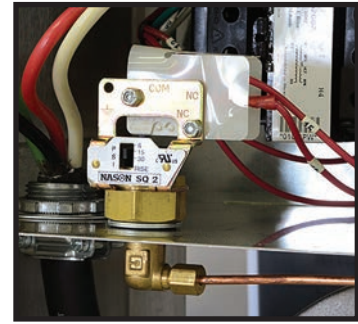
- A.** The temperature probe is a temperature transducer. The transducer is embedded into a bulb well, which is threaded into the tank. The transducer converts the temperature of the water into a proportional current output, which the microprocessor controller reads, displays, and bases its controlling functions. The gain is automatically calibrated within the controller electronics, the zero adjustment potentiometer is located on the CPU.



- B.** Sensor probe errors are indicated by three dashed line on the temperature display (- - -). When a sensor probe error is displayed, take the following steps to correct:
- 1. RECONNECTION.** If the service connection becomes saturated with water simply unplug the connection, shake out the water and replug. If this was the problem, the yellow Alert icon will disappear. If not, continue with replacement.
  - 2. REPLACEMENT.** All factory supplied replacement probes are complete with the service connection. The unit uses two sensor probes. The “high temperature limit” safety switch is a part of the to process probe. To replace follow the procedure as outlined below:
    - a.** Stop process operations as described in section 3.4 of this manual.
    - b.** Determine that all process pressure is relieved and the unit’s pressure gauges read “0” pressure.
    - c.** Drain the unit by removing the pump casing drain plug. The unit can be drained below the sensor probe mount if preferred.
    - d.** Disconnect the sensor probe service plug.
    - e.** Using a crescent wrench, remove the sensor probe from the cylinder. To install a new sensor probe continue as follows:
    - f.** The new sensor probe threads should be lined with teflon tape and coated with leak preventative sealant. Using a crescent wrench, thread the new sensor into the machined boss of the cylinder.
    - g.** Reconnect the service connection. Restart the unit as outlined in section 3 of this manual.

## 5.6 PRESSURE SWITCH SERVICE

- A. The unit is protected from low pressure operations by a pressure switch. This switch is mounted at the bottom of the electrical cabinet.
- B. The switch will close and consent the control circuit when sufficient water supply pressure is presented. The switch is factory set to 20 psi.
- C. If insufficient water supply pressure is present, the switch will open and prevent operations.
- D. In cases where sufficient water supply pressure is present as indicated by the unit's pressure gauges and the pump is "off", and if the pressure switch fails to close, the pressure switch may be defective. To replace the pressure switch, follow the steps outlined:
  - 1. Shut down unit operations according to section 3.4 in this manual. Be certain proper lock-out procedures are followed. Also, be certain system pressure is eliminated and the unit's pressure gauges read "0" pressure.
  - 2. Drain unit by removing the pump casing drain plug.
  - 3. A capillary runs from the cooling cylinder to the pressure switch. Remove the capillary connection.
  - 4. The brass elbow mounted on the pressure switch must be removed.
  - 5. Remove the electrical connections to the pressure switch.
  - 6. The pressure switch is mounted onto the electrical cabinet with two 1/2" nuts in series. Remove the nuts to remove the pressure switch. A new pressure switch from the factory should be installed by continuing with step 7.
  - 7. Thread one 1/2" nut onto the pressure switch and then place the pressure switch through the panel in the original mounting hole. Thread the second 1/2" nut from the bottom of the pressure switch. Tighten to lock the pressure switch in place.
  - 8. Install the brass elbow fitting. Teflon tape and leak preventative paste should be used to prevent water leakage. Install the capillary tube and resume operations.



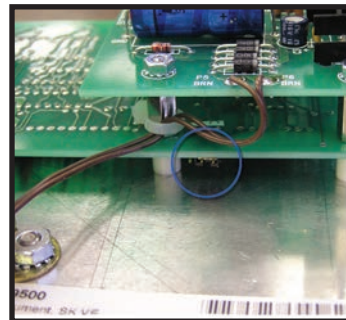
Pressure switch

## **5.7 ELECTRONIC INSTRUMENT REPAIR POLICY AND PROCEDURE**

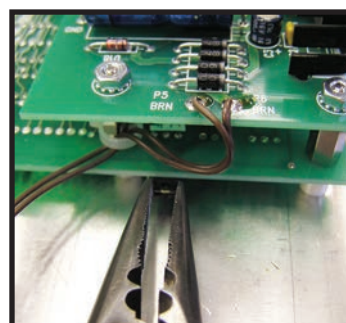
- A.** All control instruments used in Advantage temperature control units are covered by the machine's warranty. Proprietary 'tailor made' instrument are manufactured specifically for Advantage.
- B. IN WARRANTY SERVICE INCIDENT**
1. Call the factory for diagnostic assistance.
  2. If a control instrument is determined to be at fault, a new or reconditioned instrument will be sent as a replacement.
  3. Return the defective instrument freight pre-paid for full credit. If the defective instrument is not returned you will need to pay for it.
- C. OUT OF WARRANTY SERVICE INCIDENT**
1. Call the factory for diagnostic assistance.
  2. If a control instrument is determined to be at fault, there are 3 options.
    - a. Purchase a new instrument as a replacement.
    - b. Send your instrument back for repair, freight prepaid. For a nominal fee, your instrument will be repaired and returned.
    - c. Purchase a new instrument and repair the old one as a back up.
  3. If you are sending your instrument back for repair, call the Service Department for more information. Do not disassemble the instrument.
- D. Other Information:**
1. Call the factory for current repair charges.
  2. Repair warranty: 1 year.
  3. Ship to Advantage Engineering, 525 East Stop 18 Road, Greenwood, IN 46143. Attention: Repairs (317-887-0729). Include in the shipping box: Part, purchase order, contact name, phone number, and symptom (if available).

## 5.8 CELSIUS TEMPERATURE DISPLAY

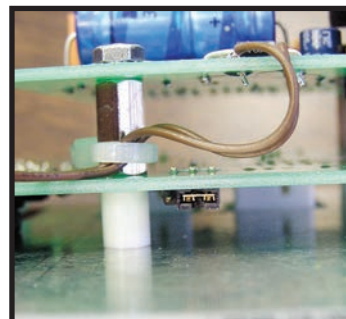
- A. The following procedure changes the Temperature display units from Fahrenheit to Celsius. Fahrenheit display is standard.
- B. Note that there is no indication for Fahrenheit or Celsius temperature display.
- C. To change to Celsius temperature display, do the following:
  1. Disengage process operations and relieve all system pressure.
  2. Disengage main power supply. Verify the *Power* light on the display is “off”. Follow standard lock out procedures.
  3. Remove the thermoformed front panel and set aside. The panel is attached to the stainless steel cabinet by 4 small screws.
  4. Open the hinged electrical cabinet panel cover. The panel is opened by removing four small screws.
  5. Locate the instrument. A jumper bar controls the Temperature display. The jumper bar is located on the larger circuit board.
  6. Using non conductive pliers, remove the jumper from the Fahrenheit position (standard) to the Celsius position.
  7. After securing the electrical panel cover and replacing the thermoformed front panel, resume operations. The change will take effect once power is resupplied to the unit.



Jumper location.



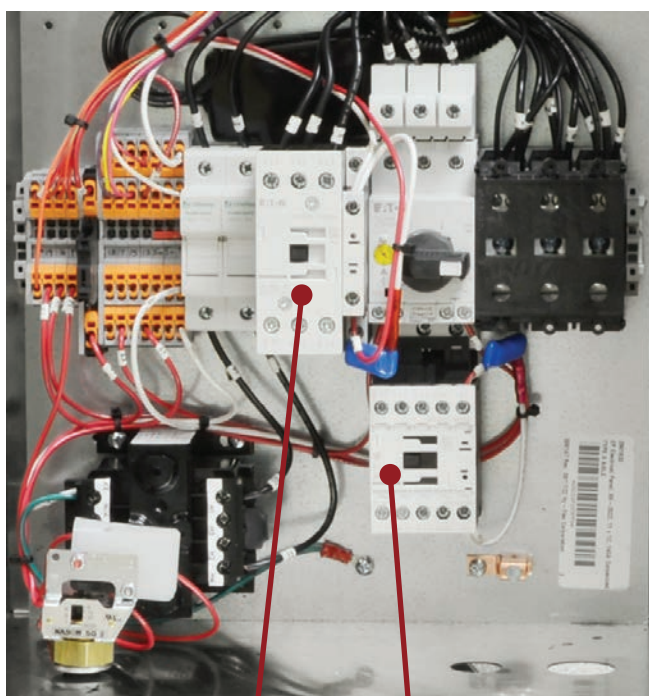
Changing jumper bar.



Jumper position for Celsius temperature display.

## 5.9 HEATER CONTACTOR & PUMP MOTOR STARTER

- A. The “standard” mechanical contactor for the heater will cycle proportionally to the amount of heat input required for the process and may cycle frequently.
- B. This is a “wear” item that must be routinely inspected and replaced when the contacts begin to indicate wear/pitting.
- C. Failure to maintain the contactor may result in overheating of the components and catastrophic electrical failure.
- D. The “standard” mechanical pump motor starter must also be routinely inspected and replaced when the contacts begin to indicate wear/pitting.



Typical electrical panel.

Typical Heater Contactor

Typical Pump Motor Starter



**WARNING:** Failure to maintain the contactor may result in overheating of the components and catastrophic electrical failure.

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## **6.0 COMPONENTS**

**6.1** Mechanical System

**6.2** Electrical System

## 6.1 MECHANICAL SYSTEM

- A. Pump Casing/Cooling Tank/Heater tank.** The pump casing/cooling/heater casting is an exclusive design (Standard 1/2-3 horsepower models). The pump casing is designed for high efficiency performance and houses the pump impeller. The integral heater tank houses the flange mounted immersion heater and the integral cooling tank provides a mixing chamber for return from process fluid and cooling water. The assembly is fastened to the unit base for support.
- 1. Pump adapter.** The pump adapter is the mating element between the pump casing the electric motor. The adapter is machined to accept the pump seal flush line. The stationary pump seal member is set in the seal cavity of the pump adapter.
  - 2. Electrical motor.** The electric motor is a dual voltage, 3 phase, ODP motor. The motor serves to turn the pump impeller creating process flow.
  - 3. Impeller.** The impeller is driven by the electric motor and rotates within the pump casing to create high flow rates.
  - 4. Pump Seal.** The pump seal prevents water leakage from the pump adapter. The seal is made up of three items: The stationary member (seated in the seal cavity), the rotating member (placed on the motor shaft) and the tension spring.
- B. HEATER.** The heater is a flanged immersion type heater mounted in the discharge housing of the pump. The heater elements have a stainless steel sheath. A mechanical contactor is engaged and disengaged by the control instrument to maintain the set point temperature. An optional solid state heater contactor is sometimes used in lieu of the mechanical contactor. The heater must remain submerged in water at all times.
- E. PRESSURE RELIEF VALVE.** The pressure relief valve is a 150 psi relief valve serving to discharge excessive unit pressure to atmosphere. The valve can be manually activated by lifting the actuating lever.
- F. COOLING VALVE.** The AVT™ valve modulating valve is a patented design using a motor/gearbox assembly to open in minute increments from 0 to 100% a custom ball valve assembly. The AVT™ valve is controlled by custom programming of the instrument and only available on unit with G & T control instruments. On units with the V, G300 & T300 a pulse metered solenoid valve is used. The cooling valve controls the flow of cooling water from the water supply source.
- G. PRESSURE GAUGES.** “To” and “from” process pressure gauges display the system pressure. “To process” pressure originates at the heat/pump discharge cylinder. “From process” pressure originates at the cooling cylinder. The gauges accurately display system pressures from 0 to 160 PSI.
- H. CASTERS.** The unit is mounted on 4 swivel ball bearing casters. The casters allow the unit to be portable and easily move from location to location.
- I. STAINLESS STEEL CABINETRY.** The stainless steel cabinetry prevents unsightly rust and metal decay. The electrical cabinet cover is hinged. The unit base is made of pressed steel with galvanized zinc coating. The rear access panels can be lifted off after removing the fasteners.

## 6.2 ELECTRICAL SYSTEM

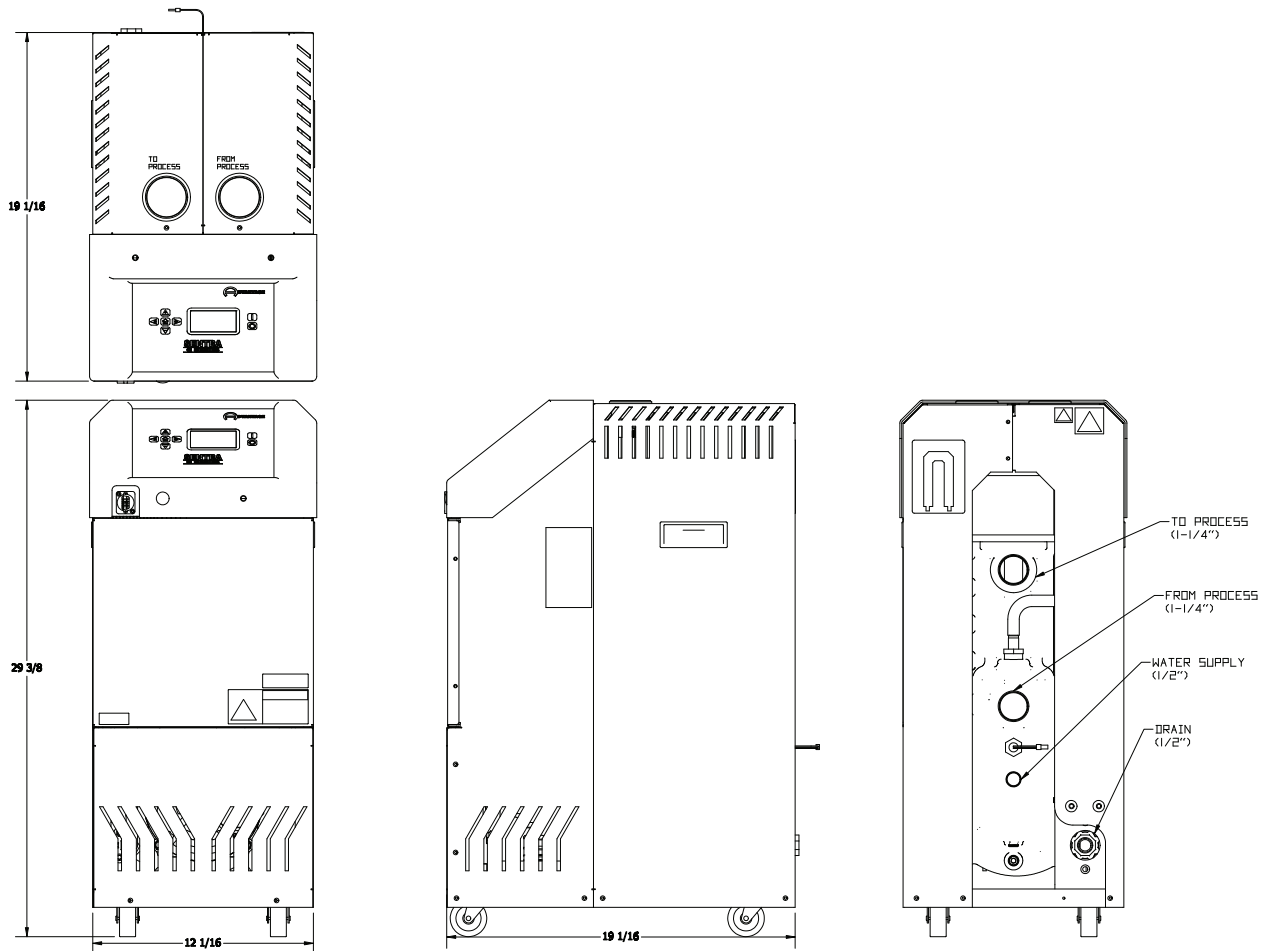
- A. INSTRUMENT.** The instrument is a custom designed and assembled microprocessor controller. The instrument is mounted to the electrical panel cover. The instrument controls the cycling of the heater, motor pump and AVT™ cooling valve. System and setpoint temperatures are displayed continually. System parameters are programmable..
- B. TRANSFORMER.** The transformer supplies 110 volts to the controlling instrument.
- C. PUMP MOTOR CONTROLLER.** The electrical motor is engaged when the motor starter contacts close, on command by the instrument. The electric motor is protected from excessive amperage by a set of thermal overload relays, which open when excessive amperage “heats” the overloads and the relay opens.
- D. HEATER CONTACTOR.** The standard heater contactor is a mechanical style contactor. On command from the instrument, the contactor will close and voltage will be supplied to the heater. The contactor use should be monitored and the contactor should be replaced as needed based on duty cycle. Some units are provided with a solid state contactor rather than the standard mechanical contactor.
- E. PRESSURE SWITCH.** The electric panel mounted pressure switch will close when sufficient pressure is supplied to the unit (20 psi). A closed pressure switch will consent the control circuit to the instrument controller to allow process operations.
- F. SENSOR PROBES.** The unit uses 1 sensor probe. The sensor and the “high temperature limit” safety switch” are housed in the same assembly and mounted in the heater/pump discharge tank. The “from process” probe is mounted in the suction tank.
- G. POWER CORD.** On standard models with 10kW and 16kW heaters and 1 - 3 HP pumps are supplied with a 3 conductor with 1 ground wire sized for the unit and 10’ in length. Standard models with 24kW and 34kW heaters are not supplied with a power cord and the customer must provide a 3 conductor with 1 ground wire sized for the unit.

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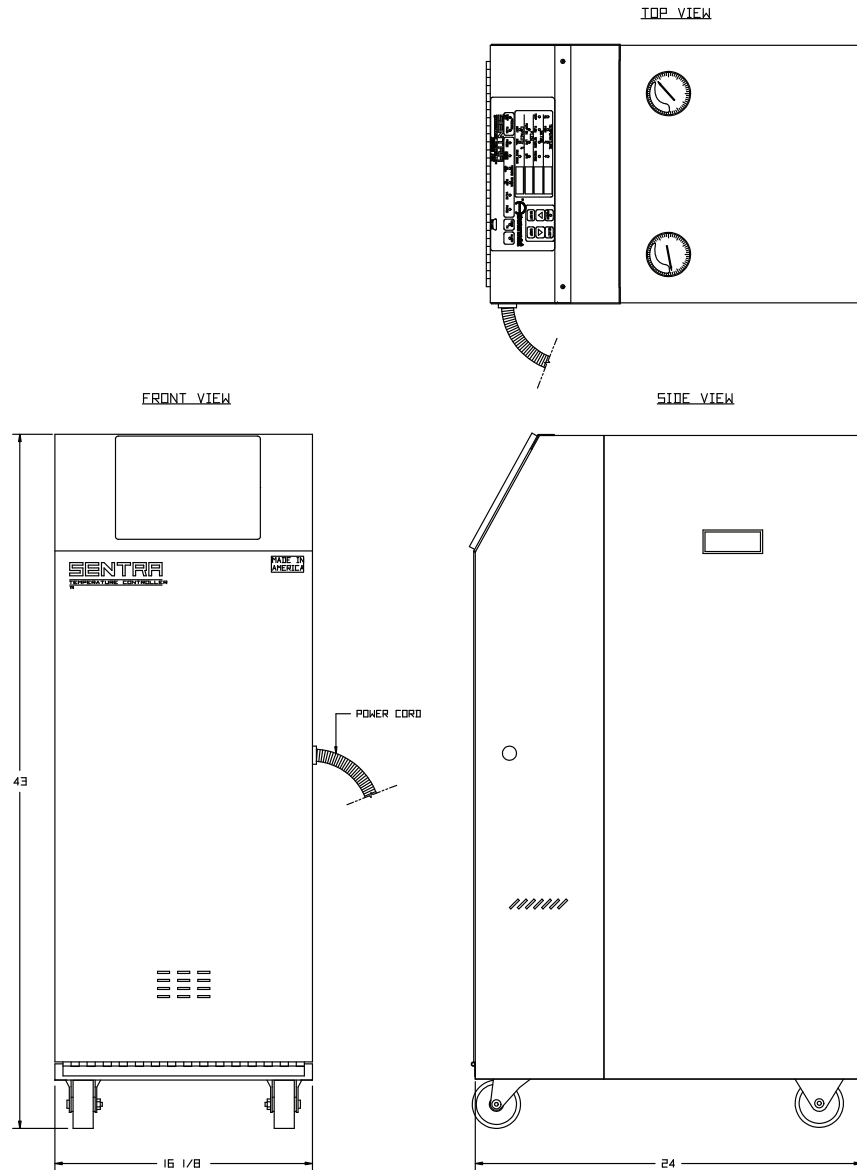
## **7.0 RELATED DRAWINGS**

- 7.1**     Physical : Cabinet Style for Units up to 16 kW Heaters and Pumps to 3 HP
- 7.2**     Physical : Cabinet Style for Units with 24 & 34 kW Heaters and Pumps to 3 HP
- 7.3**     Physical : Cabinet Style for Units with 5 & 7.5 HP Pumps
- 7.4**     Regulator / Bypass
- 7.5**     Dual Zone Dolly
- 7.6**     Stacking Rack

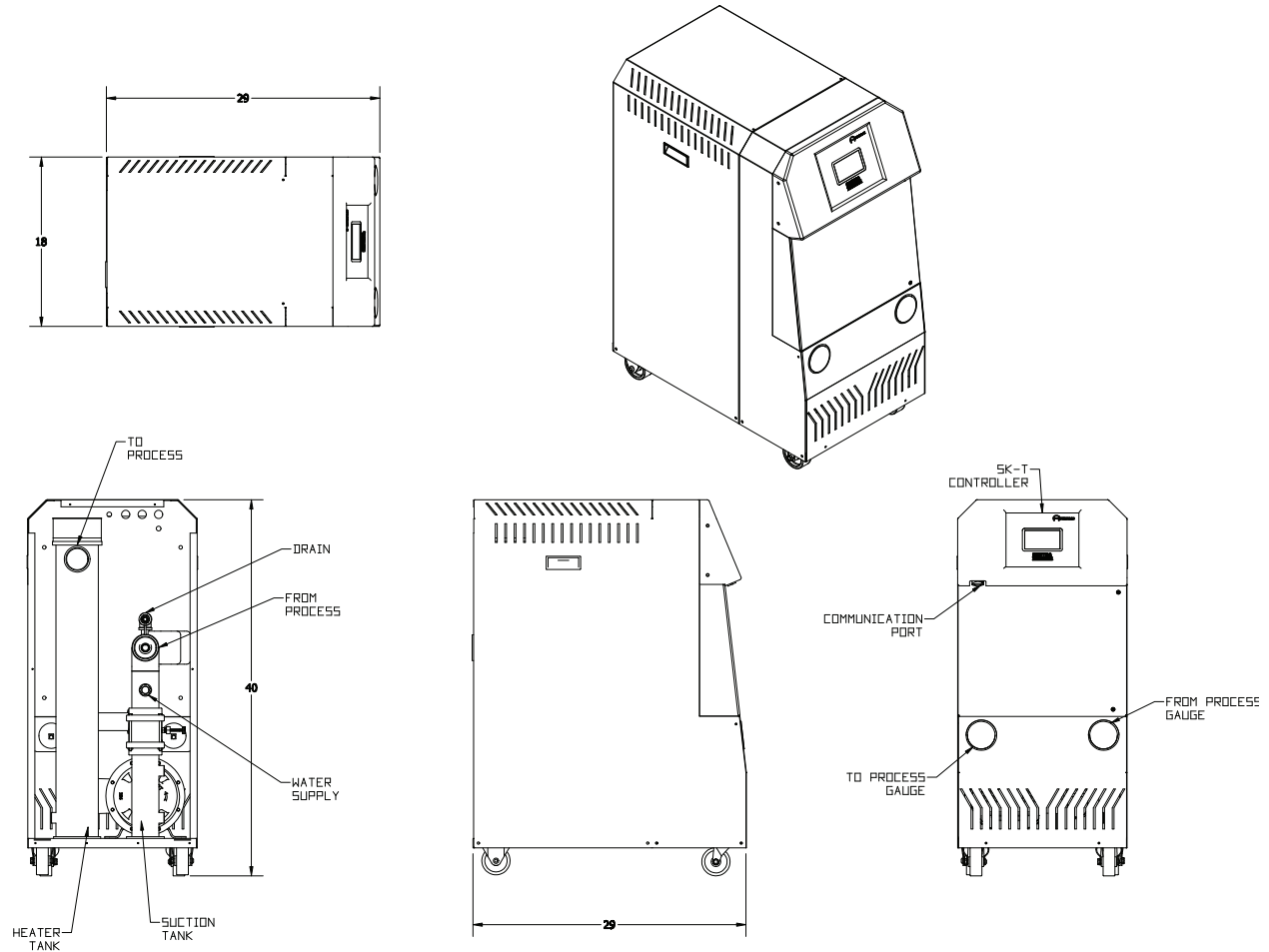
## 7.1 PHYSICAL : Cabinet Style for Units up to 16 kW Heaters and Pumps to 3 HP



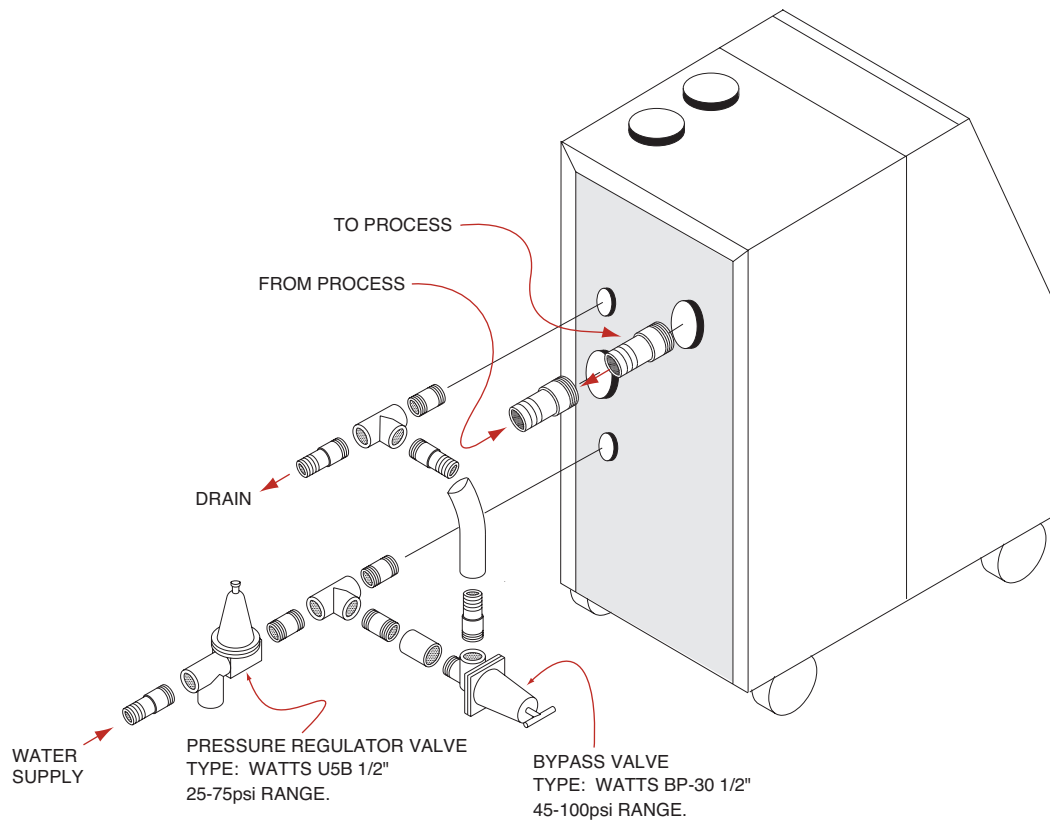
## 7.2 PHYSICAL : Cabinet Style for Units with: 24 & 34 kW Heaters and Pumps to 3 HP



### 7.3 PHYSICAL : Cabinet Style for Units with : 5 & 7½ HP Pumps



## 7.4 REGULATOR/BYPASS INSTALLATION



## 7.5 DUAL ZONE DOLLY



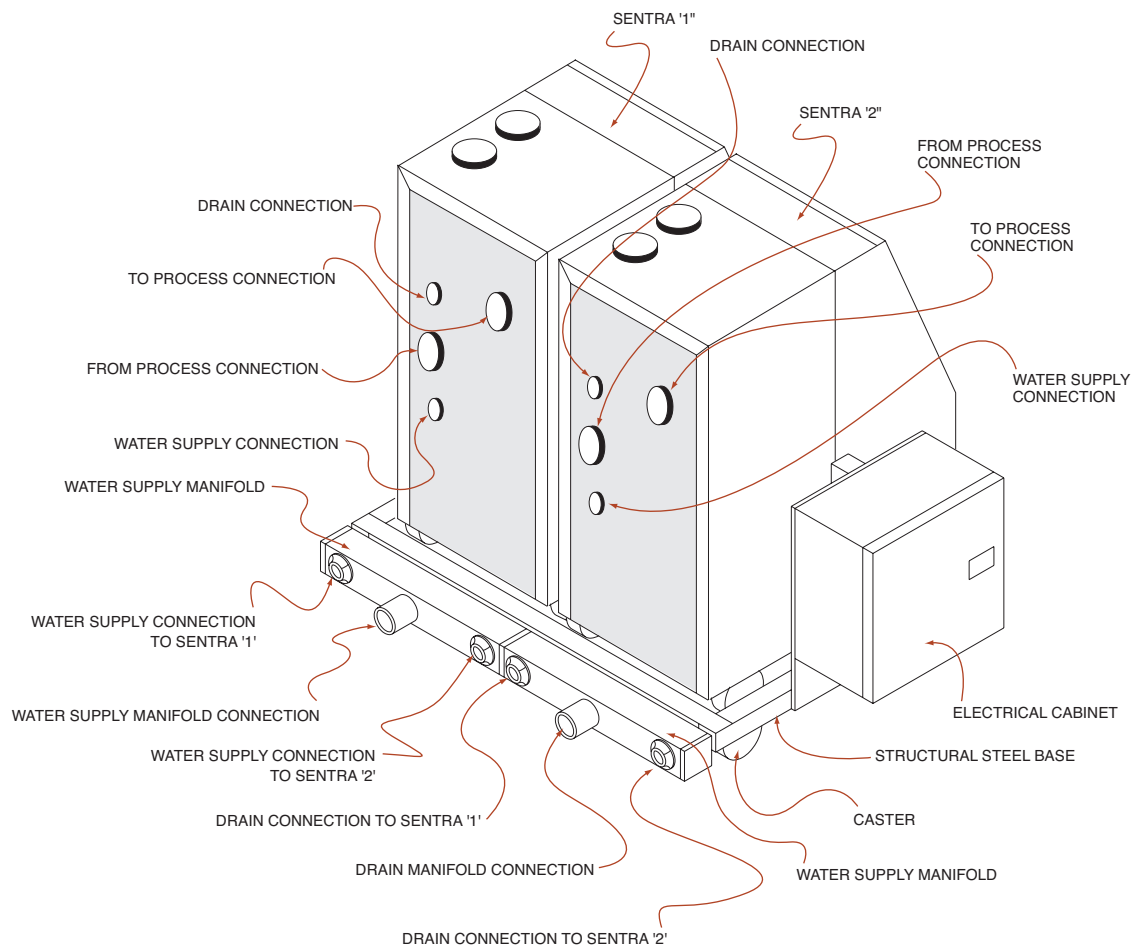
Molders often need to run different temperatures on each mold half to produce the best quality part.

Advantage can provide a dual zone dolly that holds two standard single zone temperature control units to meet this need.

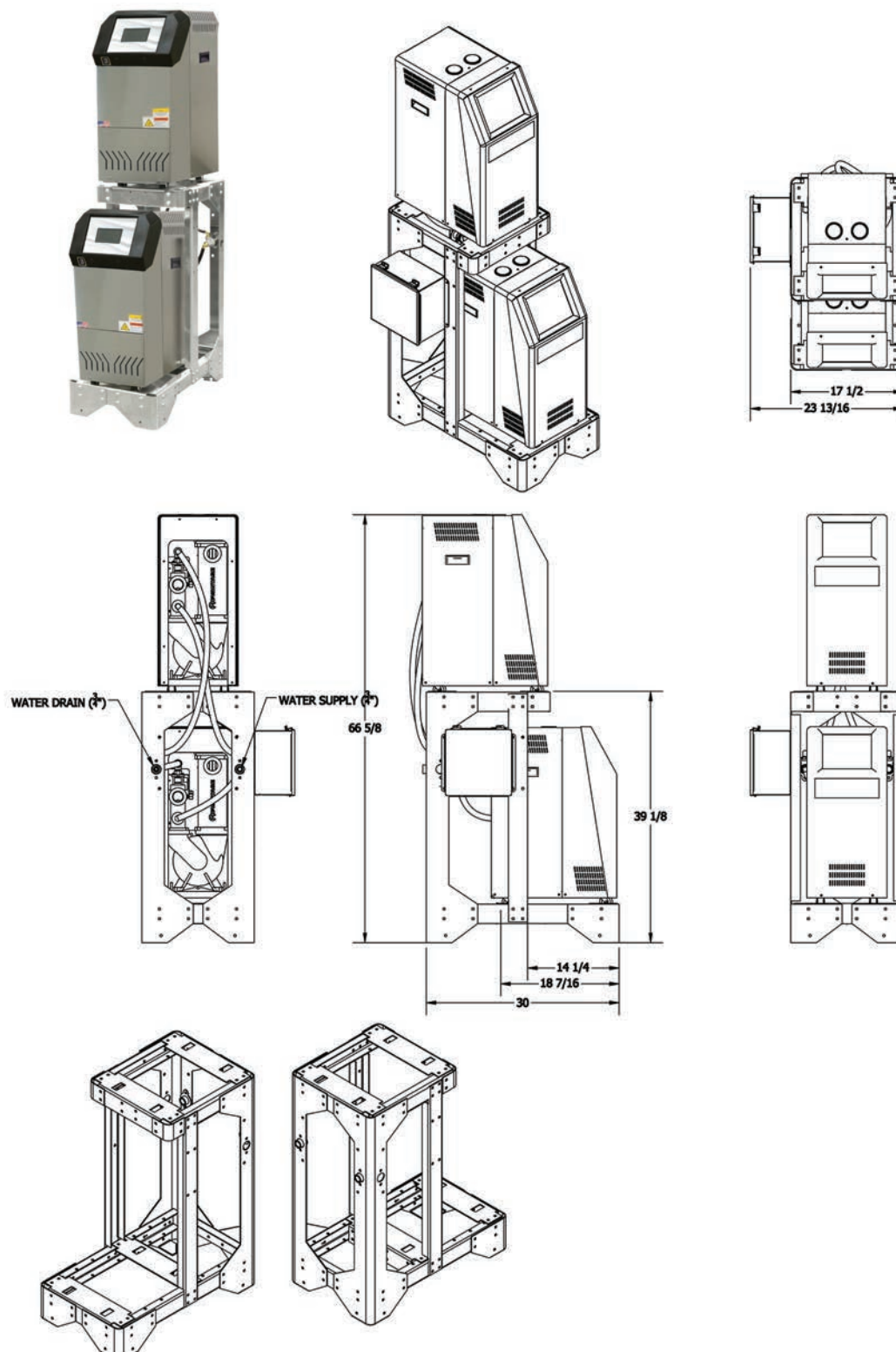
The dual zone dolly provides the convenience of a dual zone configuration while providing the economic first cost and ease of maintenance associated with independent single zone units.

Options:

- Single cooling water supply and drain connection
- Single power supply connections



## 7.6 STACKING RACK



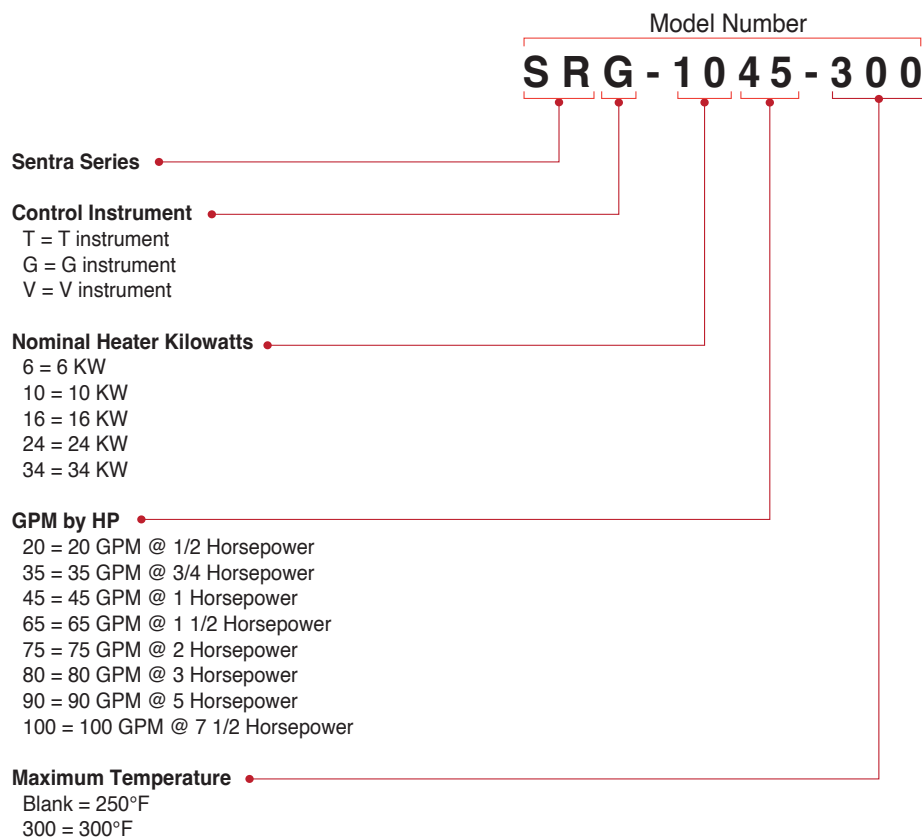
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## **8.0 APPENDIX**

- 8.1** Model # and Suffix Coding
- 8.2** Interpretation of Process Pressure Gauges
- 8.3** Mold Purge Operation
- 8.4** Parts : #119 Pump

## 8.1 MODEL NUMBER & SUFFIX CODING

The data tag on your Sentra Temperature Control Unit provides general information about the unit. Compare the information below with your data tag for more information about your unit. Some data tags may have other or different information. If you need specific information about the configuration of your unit contact the factory with the serial number from your unit.

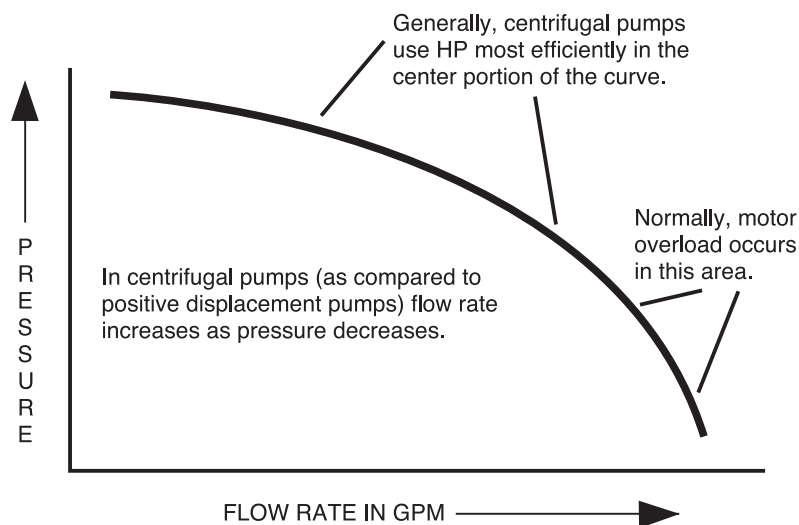


## 8.2 INTERPRETATION OF PROCESS PRESSURE GAUGES

- A. READ AVAILABLE WATER PRESSURE AT UNIT'S LOCATION.** When a temperature control unit is attached to the process with the water supply on and the pump off, both gauges will read the water supply pressure at the unit's location.
- B. READ PRESSURE DROP ACROSS PROCESS ( $\Delta P$ ).** With the pump on, the "to process" pressure gauge will rise to read the sum of the water supply pressure and pump generated pressure. The "from process" pressure gauge reads the effect of water supply pressure and pump suction pressure. The difference between the to and from process gauges is the pump generated circulating pressure... which is also equal to the pressure drop across the process.
- C. PUMP ROTATION INDICATION.** If the pump is running, and both gauges are "close" to same value, it is likely that the pump is rotating backward, or the pump is generating such a high flow that an overload condition will result.
- D. PUMP MOTOR OVERLOAD CONDITION.** If the  $\Delta P$  is low with the pump rotating correctly, then the flow rate is high, which probably will result in a motor overload. Refer to the representative pump curve below.
- E. WATER HAMMER (COMPETITIVE SOLENOID VALVE UNITS).** On competitive mold temperature controllers, when  $\Delta P$  gauges are supplied, the water hammer effect of on/off solenoid valves can be seen. When the solenoid valve is open, both to and from process pressure gauges will fall as the system depressurizes. When the valve closes, there will be a momentary spike that will be seen on both pressure gauges, then they will settle back to normal  $\Delta P$  values. This spike is called "water hammer".



Pressure gauges



### 8.3 OPERATION OF MOLD PURGE

- A. The mold purge system includes valves and piping that when activated and supplied with compressed air will expel process water from the mold or process to the central water return line or drain.
- B. Mold Purge is an optional feature and not included on all units. The function of the Mold Purge requires the purchase on the option.
- C. **The mold purge feature is used when the pump is turned off and has been cooled to below 85°F.**
- E. The operation of the mold purge is as follows (see illustration) :
  - 1. Stop the pump, maintain electrical power to unit.
  - 2. Close the water supply ball valve.
  - 3. Connect a regulated air supply to mold purge compressed air connection.  
  
Note: Air supply should be regulated approximately 10 PSI above drain line pressure.
  - 4. Mold Purge is activated by selecting the mold purge item from the Utilities menu. Mold purge is started immediately.  
  
If the pump is running, the follow message will be displayed.  
If the pump is not running, the mold purge will start.
  - 5. Press the Stop or Back button to disengage the purge cycle.
  - 6. When water is purged disconnect air supply. The unit can be disconnected at this time as most of the process fluid should be out of the process lines.

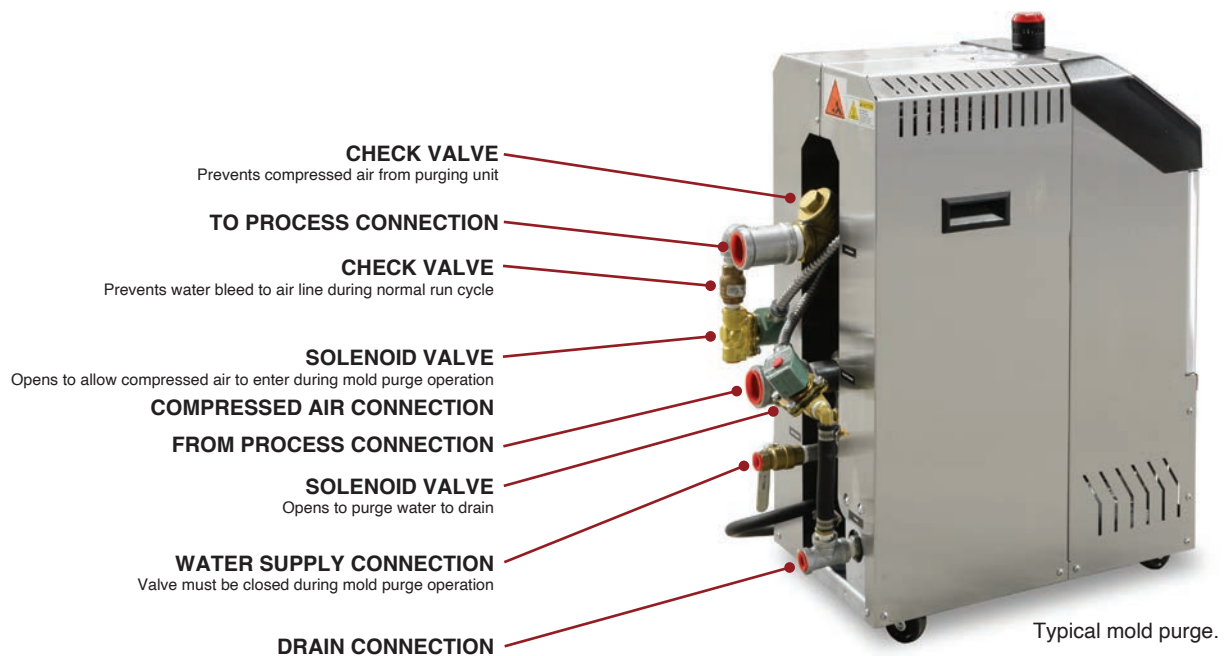
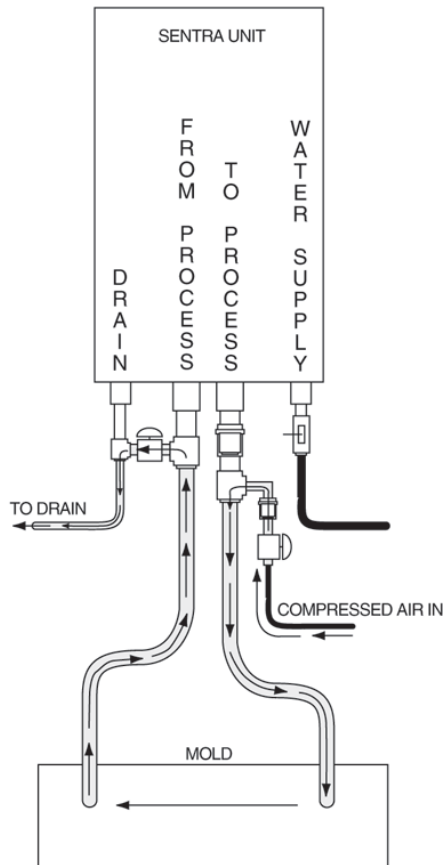


**ALERT:** The Purge cycle must be started and stopped. If not stopped, the Purge cycle will continue and will consume compressed air until stopped.



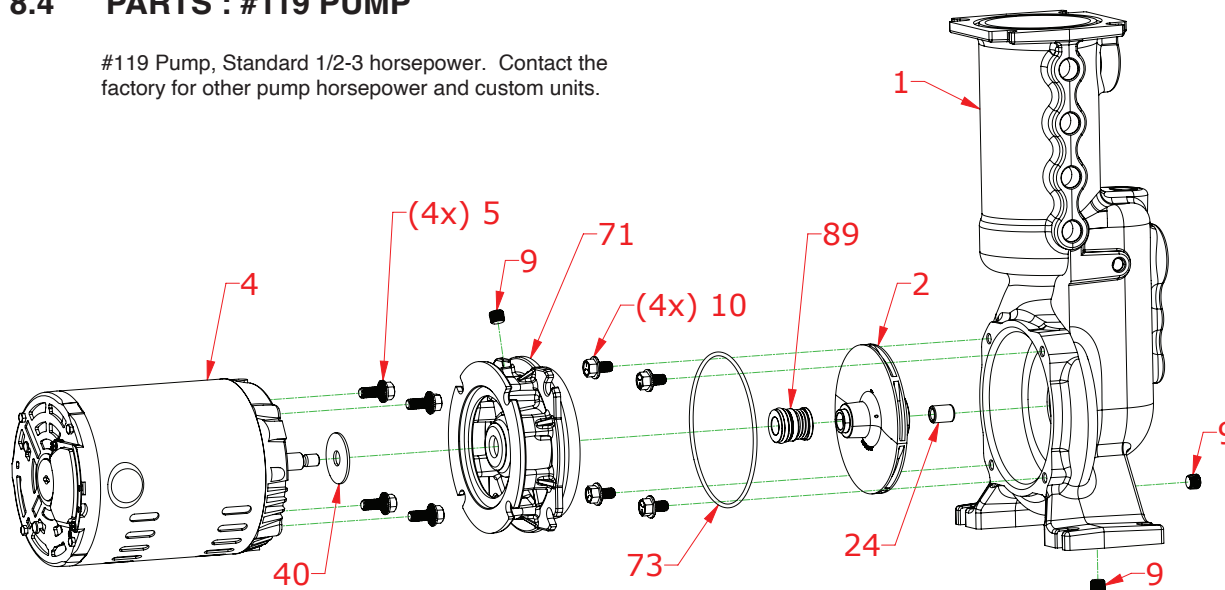
**WARNING:** Use caution when disconnecting process lines because residual pressure will remain in the lines. The remaining pressure will be equal to the compressed air pressure used for the purge process. Use caution because disconnecting process lines under pressure incorrectly may cause injury.

## AIR AND WATER MOVEMENT DURING MOLD PURGE OPERATION



## 8.4 PARTS : #119 PUMP

#119 Pump, Standard 1/2-3 horsepower. Contact the factory for other pump horsepower and custom units.



Model 119, 119S 0.5-3.0HP

| Key | Description                                       | Part #  | Reference #  |
|-----|---------------------------------------------------|---------|--------------|
| 1   | Case 119, Iron, 1.25x1.25 with Integral Tanks     | 771640  | 3301304X     |
|     | Case 119S, SS304, 1.25 x 1.25 with Integral Tanks | 771641  | 3301308X     |
| 2   | Impeller 503, Composite, 4.18", 0.5HP             | 4310560 | 3301381      |
|     | Impeller 503, Composite, 4.34", 0.75HP            | 4310561 | 3301382      |
|     | Impeller 503, Composite, 4.50", 1.0HP             | 4310562 | 3301383      |
|     | Impeller 503, Composite, 4.81", 1.5HP             | 4310563 | 3301384      |
|     | Impeller 503, Composite, 5.06", 2.0HP             | 4310564 | 3301385      |
|     | Impeller 503, Composite,, 5.31", 3.0HP            | 4310565 | 3301386      |
| 4   | Motor, J56 0.5HP, ODP, 3/60/208-230/460V          | 4713398 | 113.000.366W |
|     | Motor, J56 0.75HP, ODP, 3/60/208-230/460V         | 4713400 | 113.000.354W |
|     | Motor, J56 1.0HP, ODP, 3/60/208-230/460V          | 4713401 | 113.000.372W |
|     | Motor, J56 1.5HP, ODP, 3/60/208-230/460V          | 4713402 | 113.000.360W |
|     | Motor, J56 2.0HP, ODP, 3/60/208-230/460V          | 4713403 | 113.000.349W |
|     | Motor, J56 3.0HP, ODP, 3/60/208-230/460V          | 4713404 | 113.000.368W |
| 5   | Bolt, Hex, Adapter to motor, Zinc Steel           |         | 137.001.170  |
|     | Bolt, Hex, Adapter to motor, SS304                |         | 137.003.149  |
| 9   | Pipe Plug, Hex, Brass                             |         | 106.000.284  |
|     | Pipe Plug, Hex, SS304                             |         | 108.000.126  |
| 10  | Bolt, Hex, Adapter to case, Zinc Steel            |         | 137.003.070  |
|     | Bolt, Hex, Adapter to case, SS304                 |         | 137.003.150  |
| 24  | Lock Nut, Stainless                               | 5404005 | 110.000.190  |
| 40  | Flinger, Neoprene                                 | 7160000 | 104.000.171  |
| 71  | Adapter, Iron, J56, 5/8" Seal, with Brass plugs   | 470     | 3301001X     |
|     | Adapter, SS304, J56, 5/8" Seal, with SS plugs     | 471     | 3301135X     |
| 73  | Gasket, Case, Buna                                | 3444445 | 137.003.072  |
| 89  | Pump Seal Ceramic #50458 (for 250°F units)        | 6491000 |              |
|     | Pump Seal EPT 101-104 5/8" (for 300° units)       | 6495315 |              |



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