

THE SHUMAN CO.
KOREA DOUBLE HEATER

TIMER LIST	VALUE
13 CYCLE TYPE IN AUTOMATIC	0=LOWER PLATEN UP ONLY 1=UPPER PLATEN DOWN ONLY 2=BOTH PLATENS
36 CYCLE FOR HEAT	0=NORMAL ON 1=NORMAL ON ONLY WHEN CARRIAGE IN IN THE OVEN 2=100% ON ALLWAYS
54 IF 0 THEN HEAT ZONES WILL START .1 SECOND APART IF 1 THEN ALL THE UPPER ZONE WILL START THEN ALL THE LOWER ZONES WILL START. THE TIME ON IS CONTROLLED BY THE TIME IN EACH ZONE.	

41 MEMORY STORE AND RECALL

SET TIMER 41 TO VALVE (1,2,OR 3) TO STORE OR (10,11,OR 12) TO RECALL FROM STORAGE. THE CURRENT SET OF TIMERS WILL BE STORED OR WRITEN OVER.

PRESS START IN MANUAL MODE TO MAKE IT WORK.

THE MEMORY ADDRESS TO SAVE THESE TIMERS VALVES ARE CALLED BINS, LIKE PARTS BINS FOR PRESET VALUES OF TIMERS.

--TO--	--FROM--
1 = STORE IN BIN 1	10 = FROM BIN 1
2 = STORE IN BIN 2	11 = FROM BIN 2
3 = STORE IN BIN 3	12 = FROM BIN 3

*** CYCLE IN AUTOMATIC ***

SHEET TEMPATURE IS MADE STARTING;

1 SOAK TIME _____ IN 0.0 SECONDS
THIS CAN BE 0 SECONDS

WHEN CARRIAGE COMES OUT IT STARTS THESE EVENTS IN ORDER

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{IF TIMER 13 IS 0 OR 2 THEN THE NEXT SET OF TIMERS WORK IN
{ORDER;
|2 LOWER PLATEN UP DELAY _____ IN 0.0 SECONDS
|38 DELAY FOR LOWER VACUUM ON _____
|5 LOWER VACUUM ON _____
|7 LOWER AIR EJECT ON _____
|39 DELAY FOR LOWER PLATEN DOWN _____
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{IF TIMER 13 IS 1 OR 2 THEN THE NEXT SET OF TIMERS WORK IN
{ORDER;
|3 UPPER PLATEN DOWN DELAY _____ IN 0.0 SECONDS
|37 DELAY FOR UPPER VACUUM ON _____
|4 UPPER VACUUM ON _____
|6 UPPER AIR EJECT ON _____
|40 DELAY FOR UPPER PLATEN UP _____
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