

PLASTIC THERMOFORMING SYSTEMS

THE SHUMAN CO
CHARLOTTE NC

DOUBLE HEATER
SEQUENCE #1 - 14

DATE _____ JOB NUMBER _____ P.O. NUMBER _____

CUSTOMER _____

DESCRIPTION OF JOB _____

MOLD NUMBER _____

MATERIAL

TYPE _____ THICKNESS _____ SIZE _____

COLOR _____ SUPPLIER _____

DELIVERY DATE _____

PLATEN LIMIT SWITCH SETTINGS

UPPER

LOWER

UP LIMIT _____ DOWN LIMIT _____ UP LIMIT _____ DOWN LIMIT _____

VACUUM PRESSURE

UPPER PLATEN _____ LOWER PLATEN _____

TIMER AND COUNTER ACCESS MODULE SETTINGS

<u>TIMER/COUNTER NO.</u>	<u>FUNCTION</u>	<u>PRESET/CURRENT VALUE</u>
1	HEAT TIMER	_____
2	VACUUM TIMER, UPPER	_____
3	VACUUM TIMER, LOWER	_____
4	AIR TIMER, UPPER	_____
5	AIR TIMER, LOWER	_____
6	DELAY TIMER	_____
7	FAN TIMER	_____
8	SPARE/DELAY	_____
9	TIME FOR LOWER PLATEN TO BUMP DOWN (.3 SEC)	_____
10	BUMP DOWN DELAY (2.0 SEC)	_____
11	TIME FOR LOWER PLATEN TO BUMP UP (.1 SEC)	_____
12	BUMP UP DELAY (2.0 SEC)	_____
13	COUNT FOR BUMP (3)	_____
14	ZONE RESET (ALWAYS 13.2)	_____
15	ZONE RESET (ALWAYS .1)	_____