PACKAGING plus+ ST6



DIP-STYLE SHRINK TANK OPERATION & PARTS MANUAL

VC999 PACKAGING SYSTEMS

419 E. 11TH AVE. NORTH KANSAS CITY, MO 64116 USA
+1 800-728-2999 SALES@VC999.COM

ST6
Shrink Tank Machine

1. Power requirement:

   Voltage: Look at the nameplate

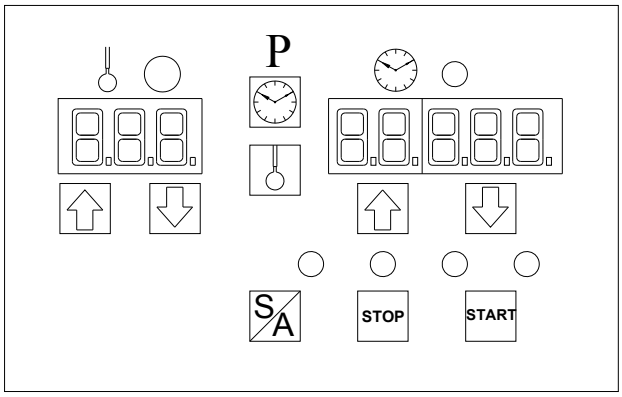
   Current: Look at the nameplate

   Frequency: 50/60Hz

   Phase: 3Ø

1. Maker sure the power is correct and the normal rated power is sufficient, so you could connect the power to the machine.
2. Fill the water to the maximum level（please refer the line between the arrow marks at two sides of machine's body）
3. Function description of the pushbuttons on the panel

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4.1 : INCREASING KEY

4.2 : REDUCING KEY

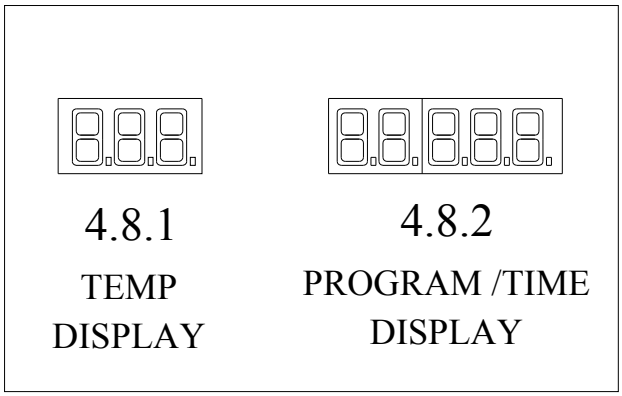
4.3 : PROGRAM / TIME DISPLAY

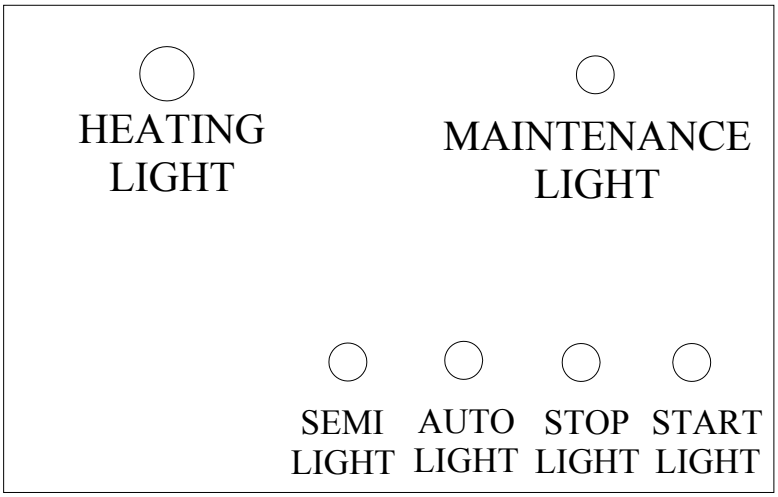
4.4 : TEMP. SETTING KEY

4.5 : S/A SEMI / AUTO KEY
(TO PRESS IT WHEN MACHINE RUNS IN AUTO MODE)

4.6 : STOP SEMI MODE : STOP KEY

4.7 : START START KEY





4.8: Description of the Display

4.8.1: Temperature Display

4.8.1.1: Description of Temp. Display:

(1) ts: Temp. Setting: It is preset 85℃

(2) td: Temp. Difference setting: it is preset 1℃

(3) AH: High Temp. Alarm setting: it is preset 99℃

(4) AL: Low Temp. Alarm setting: it is preset 40℃

(5) Ht: High temp. Alarm Time Setting: it is preset 1minute.

(6) Lt: Low temp. Alarm Time Setting: it is preset 5 minutes.

(7) tA: Temp. Adjustment: it is preset 0□

4.8.2: Program and Time Display:

The left display is for program and the right display for time (unit: second)

4.8.2.1: Description of Program display:

Program:

(1) 01: the platform stops at top position time in Auto mode.

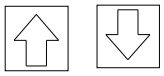
(2) 02: the platform stops at bottom position time in Auto mode.

(3) 03: the platform stops at the bottom position time in Semi mode.

5. Operation description of the PC Board

5.1: Temp. setting  :press the key  in 3 sec.，temp. display shows ts，then press the key  once again (to release it once press immediately), the display showed the set temp., then you could adjust the keys  and  to input the needed temp.

5.2: Time setting key  : 5 partitions display，the 2 left partitions display is for program and the 3 right partitions display are for time (unit: second)

Operation：Press the key  in 3 seconds，the display twinkles one time, and you could adjust the keys of  for input the needed time. To press the key of  for changing the program. (to release it once press immediately)

5.3：After 30 seconds of the temp. and program time setting, it would keep into the memory of the program automatically.

6. When you finish the work and would like to clean the tank, please turn off the power (No.2) and take off the platform fixing screw(No.1-1、1-2), take off the platform from the machine. **(Please watch out the water inside the tank is boiling hot)**
7. Please do not touch the heaters (No.5-1、5-2、5-3) when cleaning. After washing please drain off the water from the water out hole (No.8) at behind the machine.
8. After drain off the water, please put the platform (No.1) to the machine for the next working.

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Error Codes
AH : temperature max
AL : temperature min
Ht : temperature max duration
Lt : temperature min duration
E1H : thermocouple broken or current temperature above AH
E1L : thermocouple broken or current temperature below AL
EAH : if E1H keep displaying without reset til duration time of Ht.
EAL : if E1L keep displaying without reset til duration time of Lt.
EOL : cycle time alarm

Example : I set AH at 80 , AL at 50 , Ht at 3 , Lt at 2 ,

If current temperature 85 , then screen will display E1H , if E1H keep displaying more than 3 mins , the screen will then display EAH
If current temperature 45 , then screen will display E1L , if E1L keep displaying more than 2 mins , then screen will then display EAL

How to clear the EOL when the cycle time is reached to the setting time.

For example: it set 1002 cycles on this PC Board. So the machine would stop when it runs to 1002 cycles and the display would appear EOL.

1. EOL is on the left display.
   It means the Motors needs to be changed the Lubricating Oil, since the machine runs to 1002 cycles that we set on the PC Board.



2. To Press the Increasing Key to clear the original setting time.
   The right display would appear CLr.
   Then the machine could work again.



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3. If you would like to change the cycle times. Pls do the following:

To press the Time Setting Key 4 times and then to press the Increasing Key on the left and right display to reset the times for changing the lubricant oil.

After finishing the cycles time setting, pls put the Time Pressing Key again to complete the set up.



4.

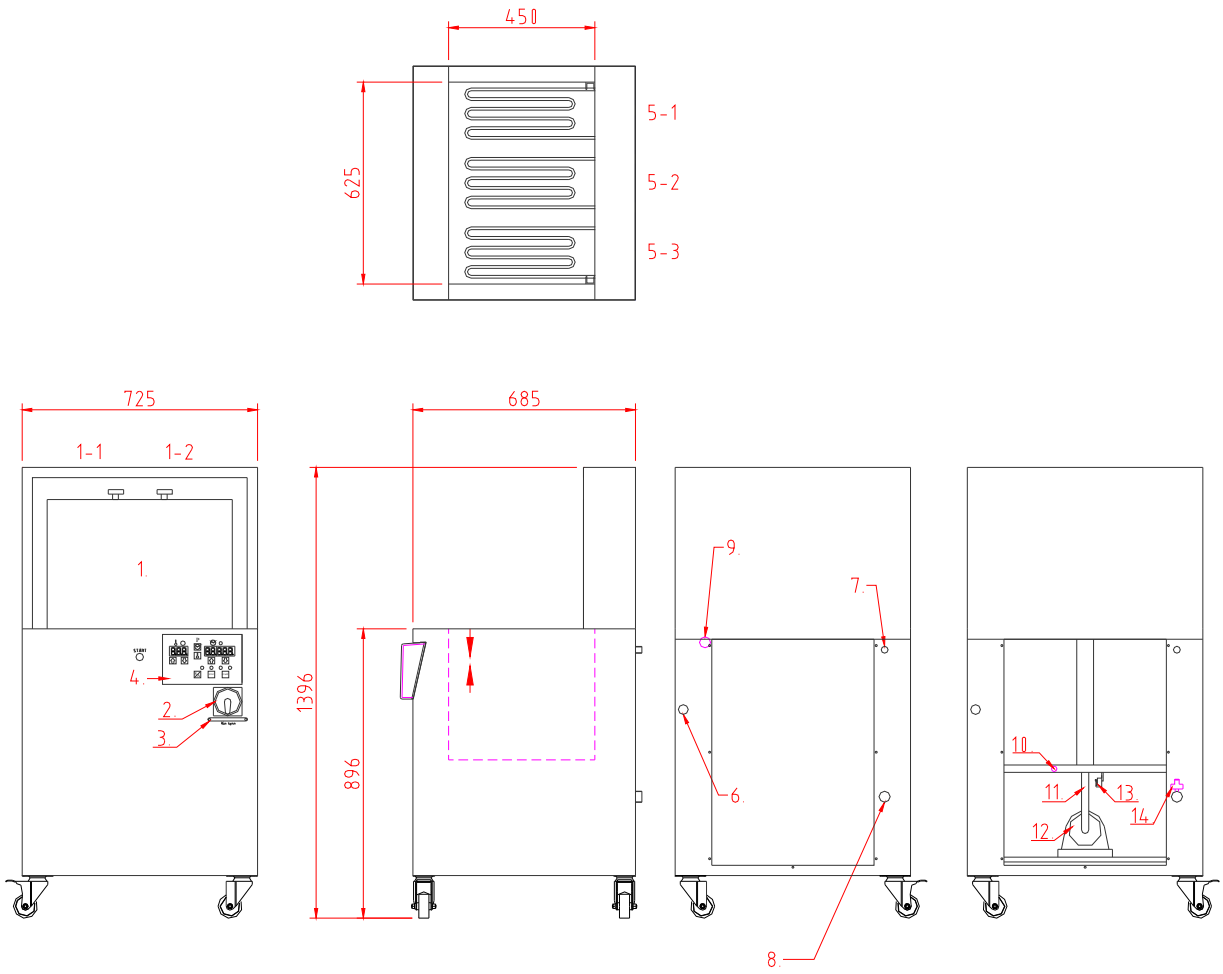
For example this display means the cycle time is 3,201,002.
In fact you could set the cycle time very big numbers, so the machine would be not stopped when operation often.



Pls press this Temp. setting key for the number dot moves forward to the next number when the right number is 9.

for example the display is 2.9 and increase the top pressing key to the number is 9.9 and moves the dot to the next position to 1.99 and then 9.99 and then 1.999…etc.

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1.PLATFORM
1-1.PLATFORM DISMANTLE SCREW
1-2.PLATFORM DISMANTLE SCREW
2.MAIN SWITCH
3.MAIN SWITCH PROTECT HANDLE
4.CONTROL PANEL
5-1.HEATER
5-2.HEATER
5-3.HEATER

6.POWER LINE
7.WATER IN
8.WATER OUT
9.WATER OVERFLOW
10.TEMP SENSER
11.LIFT AND DOWN AXLE
12.MOTOR
13.LIMIT SWITCH
14.PRESSURE SWITCH

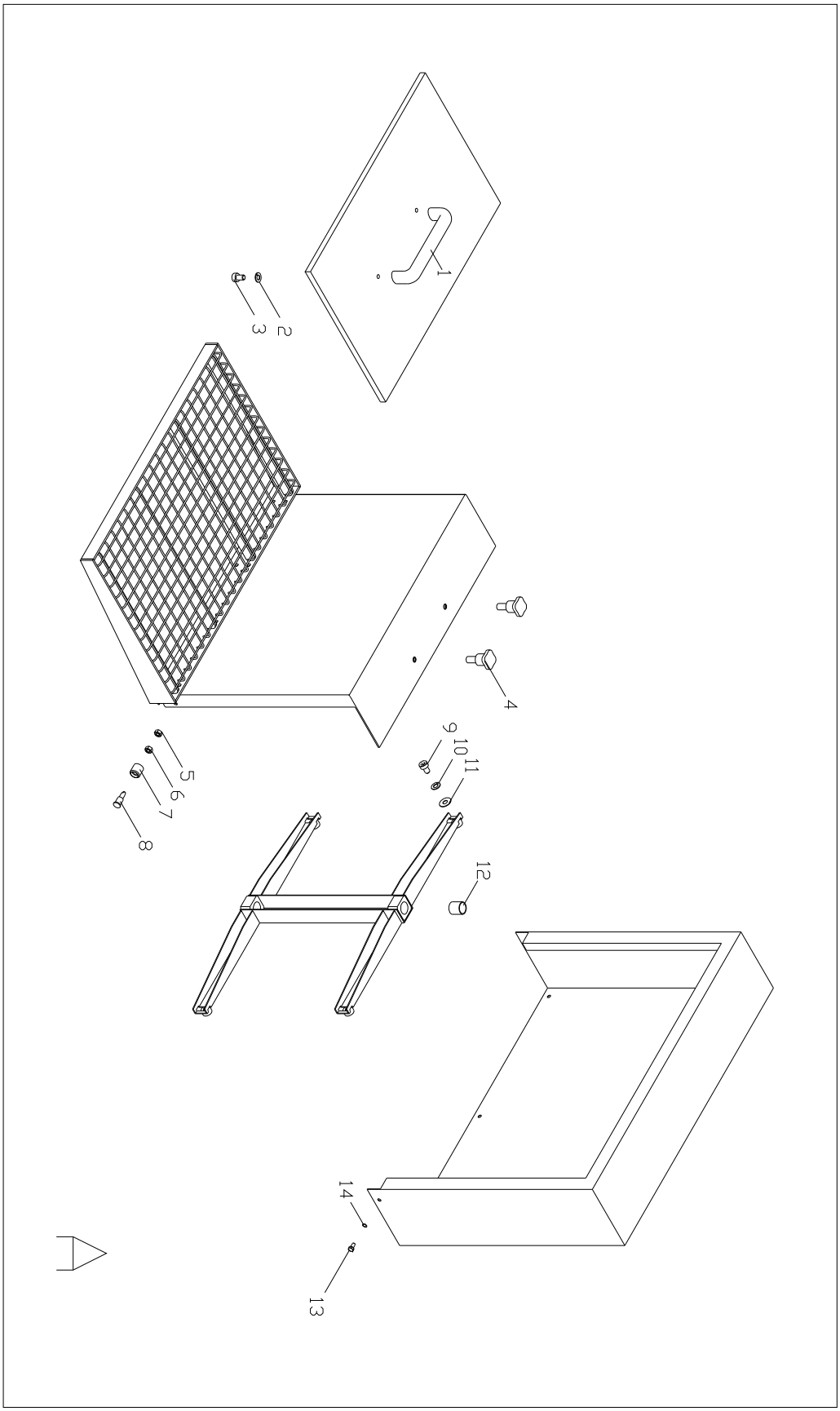
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ST6 – A

Spare Parts List

NO.	Description	Part Number
1	Handle	XVT464470
2	Spring Washer	XVT72931
3	Hex. Screw	XVT76760
4	Knob	XVT73757
5	Hex. Nut	XVT77271
6	Hex. Nut	XVT77271
7	Roller	XVT73756
8	Shaft	XVT77273
9	Inner Hex. Screw	XVT70988
10	Spring Washer	XVT460653
11	Flat Washer	XVT460654
12	Insert Bearing	XVT73758
13	Hex. Screw	XVT77274
14	Spring Washer	XVT70985

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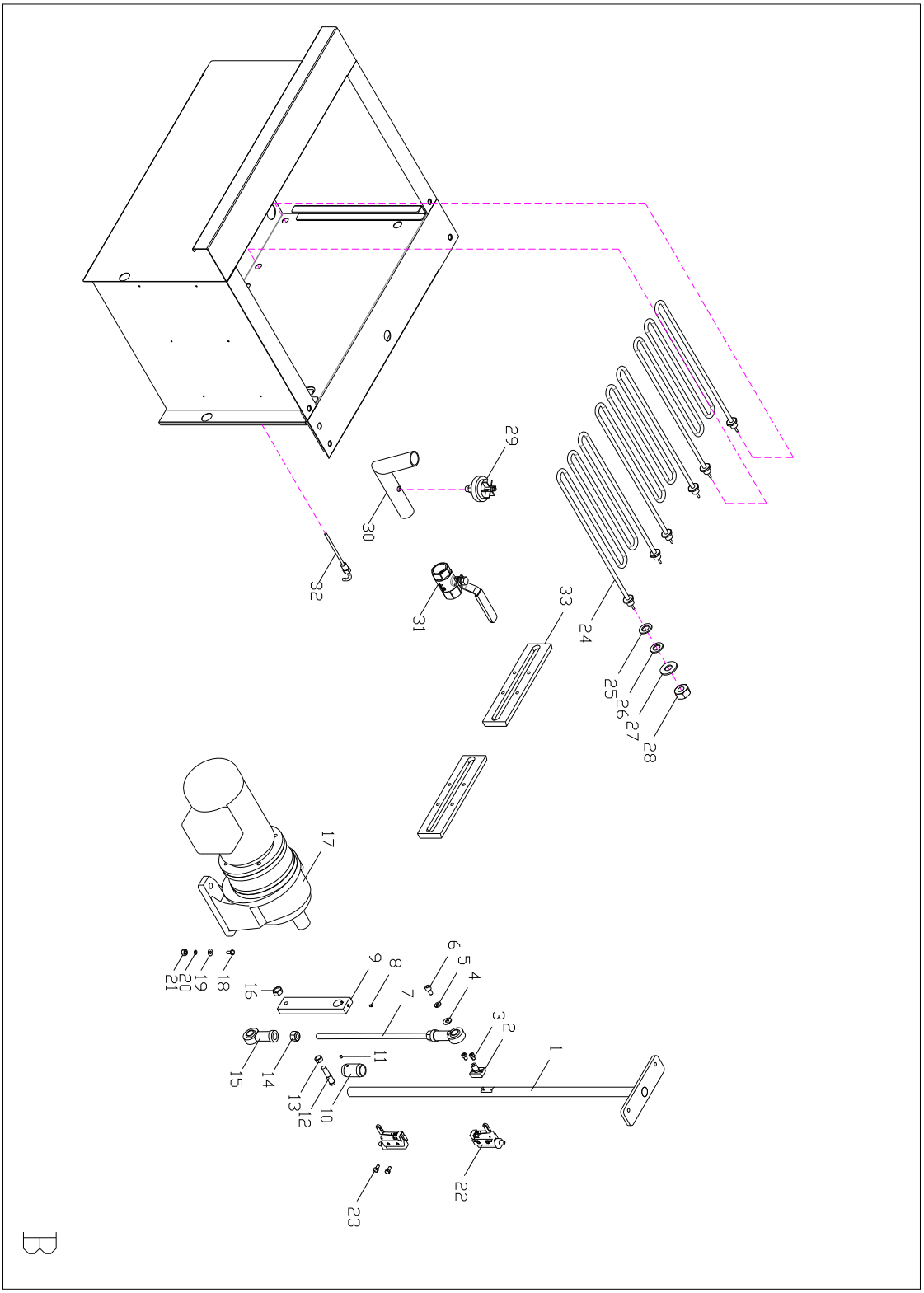
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ST6 – B Spare

Parts List

NO.	Description	Part Number	NO.	Description	Part Number
1	Lifting Shaft	XVT77300	25	Rock Wool	XVT77310
2	Connecting Block	XVT77301	26	Rock Wool	XVT77310
3	Inner Hex. Screw	XVT77275	27	Flat Washer	XVT77311
4	Flat Washer	XVT77276	28	Hex. Nut	XVT77312
5	Spring Washer	XVT70985	29	Pressure Switch	XVT467706
6	Inner Hex. Screw	XVT77277	30	Water pipe	XVT99099
7	Shaft	XVT77302	31	Ball valve	XVT92230
8	Hex. S-headless Bolt	XVT77303	32	Temperature staff	XVT84936
9	Crank	XVT77304	33	Bakelite plate Block	XVT88527
10	Limit Switch	XVT77305			
11	Hex. S-headless Bolt	XVT77303			
12	Fixing Screw	XVT77306			
13	Sleeve	XVT77307			
14	Hex. Nut	XVT70831			
15	Bearing RBH-12	XVT467707			
16	Hex. Nut	XVT71285			
17	Reducer	XV467710			
18	Hex. Screw	XVT77309			
19	Flat Washer	XVT460651			
20	Spring Washer	XVT72931			
21	Hex. Nut	XVT467850			
22	Limit Switch	XVT467705			
23	Round Head Screw	XVT77278			
24	Heater	XVT467708			

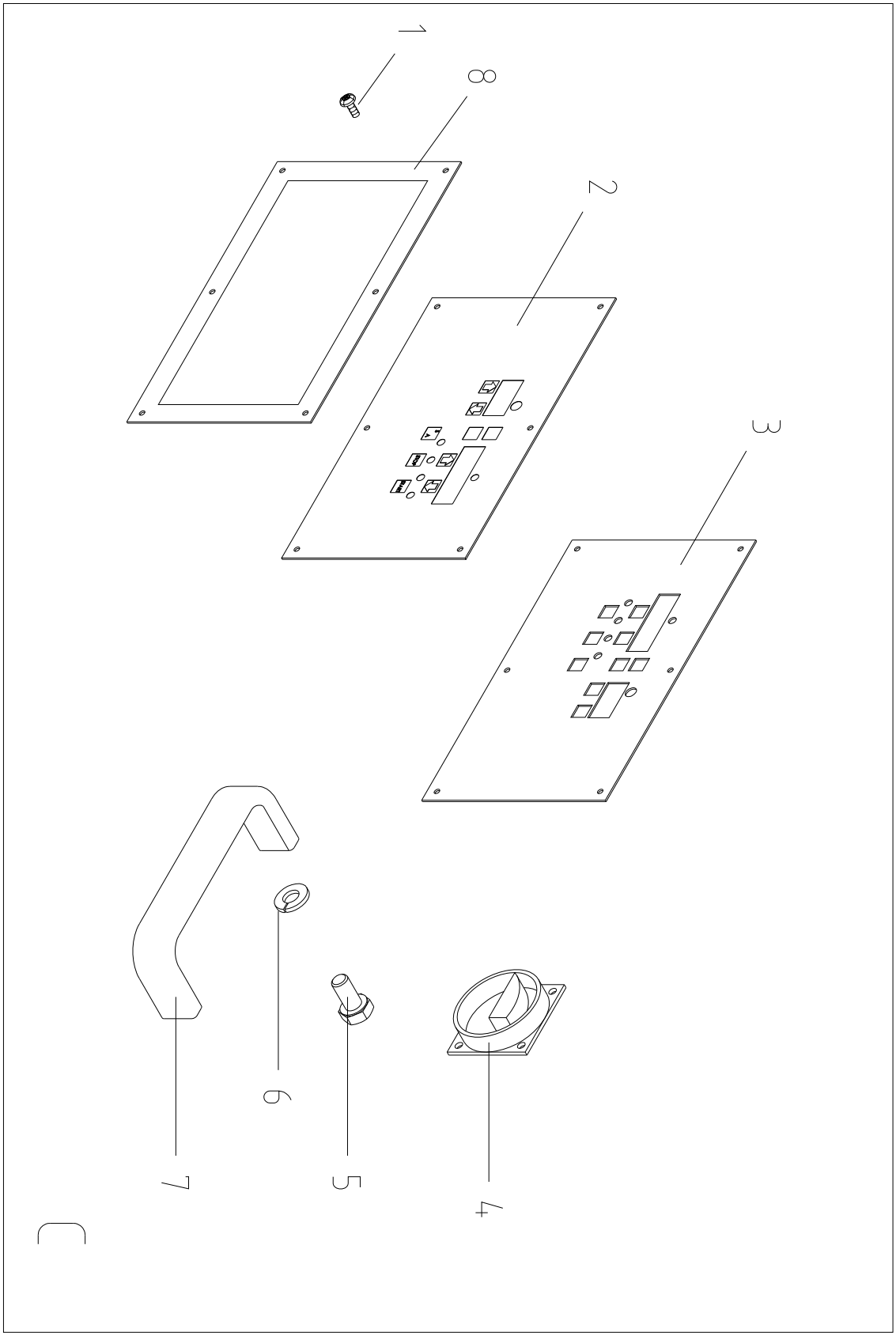
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ST6-C
Spare Parts List

NO.	Description	Part Number
1	Round Head Screw	XVT458060
2	Front Panel	XVT76117
3	PC Board	XVT76116
4	Main Switch	XVT73759
5	Hex. Screw	XVT75412
6	Spring Washer	XVT70985
7	Handle	XVT77313
8	Stainless Steel Plate	XVT469351

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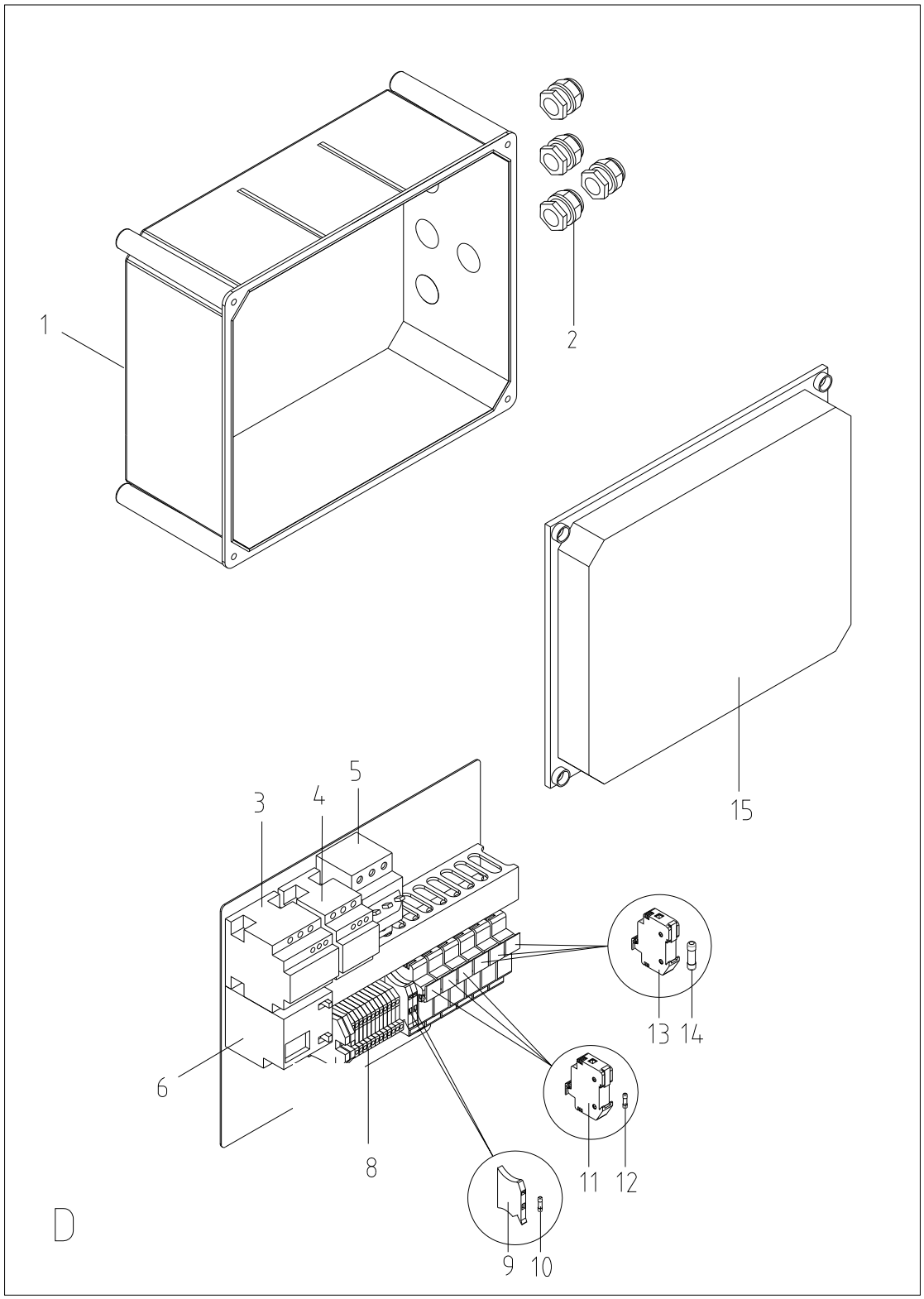
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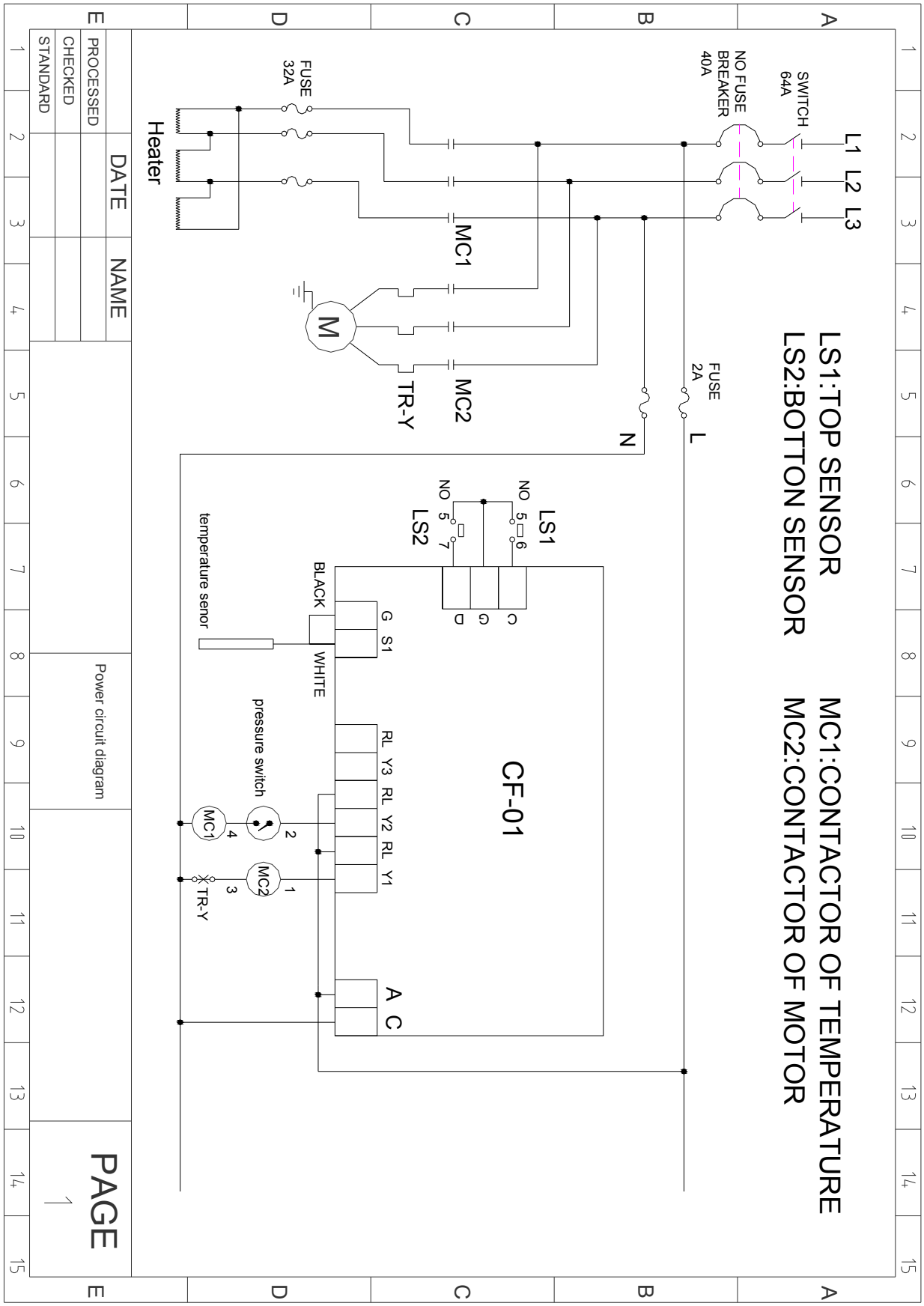
ST6 – D

Spare Parts List

	Description	Part Number
1	Control box	XVT464041
2	Gland	XVT466372
3	Contactor	XVT46480
4	Contactor	XVT468607
5	No fuse breaker	XVT71327
6	Overload Relay	XVT71328
7	Terminal block (green)	XVT99447
8	Terminal block	XVT70983
9	Fuse holder	XVT71015
10	Fuse 2A	XVT71287
11	Fuse holder 1P	XVT71329
12	Fuse 2A	XVT99449
13	Fuse holder 32A	XVT99448
14	Fuse 32A	XVT87260
15	Control box cover	XVT467521

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