

Programming the Wabash P3H-15-CLX Heated Hydraulic Press

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1. General Information

- Notify Adams Microfab personnel before editing or adding programs to the Wabash Press so that the Recipe Chart can be updated accordingly.
- The press can store a maximum of 10 programs, with 12 segments per program.
- A segment or step will not complete until all setpoint parameters are met, regardless of if the set time has elapsed.
- A setpoint parameter will be met when the actual parameter is within a preset error limit.
 - The platen temperature error limit is 5 °C.
 - The force error limit is 30 lbs.
- There are two general types of program steps: “ramp” steps, in which temperature or force values are changed over a set time interval; and “hold” steps, in which these parameters are constant for a set time interval. In most programs, odd-numbered segments are “ramp” steps, and even-numbered segments are “hold” steps. However, two or more ramp steps may be made in succession, which disrupts this pattern.
- The **Time** values on the ramp steps control the rate of change for the force and temperature values for a particular ramp segment. However, the rate of change for the platen temperatures is limited by the heating and cooling circuits (a 0 or 1 second interval will create an as-fast-as-possible ramp step for heating or cooling).
- Crash cooling (0 sec. time interval) should only be used when the platen temperatures are less than 177 °C. Otherwise, a mix of air and water must be used (1 sec. time interval or greater.)
- When manually opening the platen cooling valves, the cooling system bypass solenoid will not close. In this case, unplug the solenoid valve from the back of the press to make the cooling system work properly.
- See the Recipe Chart on the side of the press for examples.

2. Building a Recipe

- a. Press **Security Setup (F8)** on the panelview touch screen.
- b. Press **Login (F1)** on the subsequent screen. Using the keypad, enter 951, then press the return (↵) button.
- c. Press **Main Menu (F10)** to return to the main screen.
- d. Press **Machine Setup (F1)**.
- e. Press **Recipe Build (F1)**.
- f. Press **Recipe ## (F1)** and enter the appropriate number on the keypad, then press the return (↵) button.
- g. Press **Segment ## (F2)** and enter the appropriate number on the keypad, then press the return (↵) button.
- h. Using the touchscreen, select **Time**, **Clamp Force**, and **Platen Temp** fields, and enter appropriate values using the keypad.
- i. Press **Accept Changes (F6)** to save the segment values.
- j. Repeat steps **f** through **h** for each required segment.
- k. Press **Main Menu (F10)** to return to the main screen.
- l. Press **Security Setup (F8)** on the panelview touch screen.
- m. Press **Logout (F2)** on the subsequent screen.