

## Calibrating the Chromalox Heat Control on the H20 Laminator

Unlike most of the Ledco Laminators that use a standard thermocouple, The H20 uses an infrared sensor to read the surface temperature of the hot rolls. This requires calibration of the heat control to maintain the proper temperature. The procedure involves putting the control into programming mode and then using an external temperature sensor to read the actual temperature of the roll. This value is then inputted into the control and saved. The procedure is as follows:

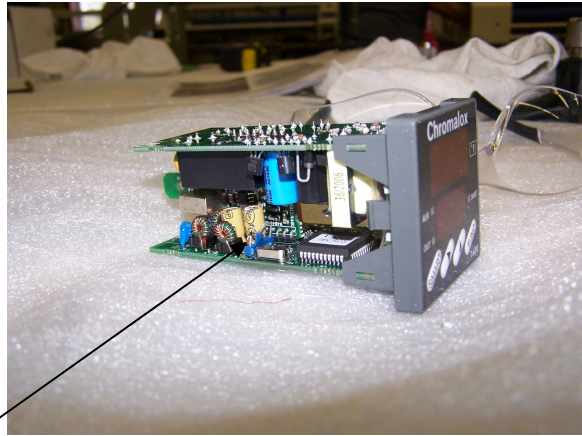
1. Remove the control from the housing and unlock the programming pin (Figure 1)
2. Reinstall the control and turn on machine
3. Press the **function button** to scroll through the menu until P-1 appears. Set the value to 10 using the **up/down arrow keys**. Scroll through the settings until CNF appears and then shut the power off to the machine.
4. Pull the control out of the housing and reset the programming pin
5. Put the control back into the housing and turn the machine back on.
6. Set the temperature to 200 degrees using the **up/down arrow keys** and let the heat stabilize. It is recommended that the rolls be in the up position and turning slowly to distribute the heat evenly. Let the machine heat up for at least 20 minutes so the temperature stabilizes.
7. Using an external temperature probe, check the temperature of the roll. It is recommended that the temperature be measured as close to the sensor as possible. The sensor is located 1/3<sup>rd</sup> of the way in from left side of the roller in the back.  
Note the difference and turn off the machine
8. Pull the control out of the housing and unlock the programming pin.
9. Reinstall the control and power up the machine.
10. Using the **function key**, scroll through the functions to P9. Enter the difference between the readout temperature and the actual temperature using the **up/down arrow keys**. Note: this could be a negative as well as a positive difference. For instance:

*If the readout says 200 degrees and the actual temperature is 180 degrees, enter +20*

*If the readout says 200 degrees and the actual temperature is 250 degrees, enter -50*

11. After the difference is entered, scroll with the **function key** to CNF and turn off power
12. Remove the control from the housing and reset programming pin
13. Reinstall the control, set the temperature to 200 degrees, let the machine stabilize as performed earlier and check temperature. Repeat steps 7 thru 13 if there is more than a 3 degree difference.

**Figure 1**



Programming pin

