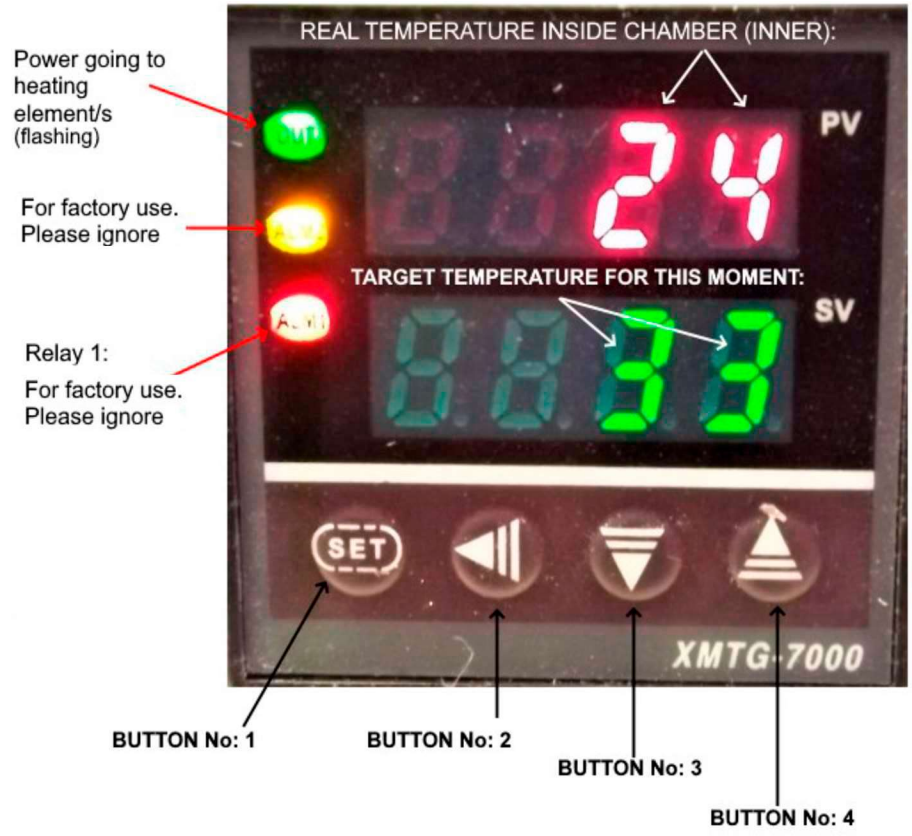
XMTG-7000 PROGRAMMABLE TEMPERATURE CONTROLLER

USEFUL TIPS FOR BEGINNERS

This programmable temperature controller is usually pre-set by the manufacturer for chamber drying purposes (unless the customer asked for a different program). If you want to re-program it, please refer to the instructions below:

FIGURE 1. MAIN XMTG-7000 PROGRAMMABLE CONTROLLER INFORMATION.



1. "SET" – setting /confirmation button. To be used for setting all the controller parameters.

2. "Left Arrow" or "A/M"- segment selector (to choose any of the four segments).

3. "Arrow Down" - value decrement (to lower the temperature).

4. "Arrow Up" - value increment (to increase the temperature).

PLEASE NOTE: The controller only 'remembers' one (last) program at any given time.

IMPORTANT!

If your kiln does not start the program when you try starting it, it may mean your **Temperature Starting Point** for the first C-01 segment (on the SV line) is **higher than** the real temperature (on PV line). **The Starting Point (C-01) should always be lower than temperature inside the chamber/inner.** This is why the manufacturer pre-set the starting point at C-01 = 0005 (5°C), as many people use their kilns outdoors or in cold workshops.

Example program and step-by step set up.

Ramp up from your room temperature to 450°C in 120 minutes (mins), hold this temperature for 4 mins, ramp up again to 945°C in 40 mins, hold for 20 mins, ramp down to 722°C in 60 mins. Hold this temperature for 25 mins and switch your program OFF to let the kiln cool down as quick as possible automatically:

1. Press and hold **Button 4** for 3 seconds until you see **green "STOP"** sign on the bottom line. This will allow you to disconnect the power supply from the kiln's heating element/s to avoid heating the objects you place inside the kiln during the re-programming process.

2. Press the "SET" button to see on TOP controller line "C-01" (First segment of the 32 segments in total. C = Celsius) and enter on the BOTTOM line starting temperature/point (usually = 5°C) - 0005.
Now press "SET" to save this parameter and move to the «r-01» ("r" = "T" = TIME segment - in minutes) to pre-set required TIME for reaching NEXT required temperature (450°C). To do this, input on the BOTTOM line (using buttons 2,3 and 4) "0120" (120 minutes) and press SET again to remember new settings and go to next step "C-02".
Now enter the required temperature "0450" on the bottom line and press "SET" again to go to "r-02" for pre-setting holding time = 0004 (4 minutes).
Press "SET" again to confirm holding temperature "0450" on segment "C-03".
Press "SET" again for pre-setting time (r-03 = 0040) for ramping up to 945°C and press SET again for pre-setting this required temperature (C-04 = 0945).
Press "SET" again hold this temperature for 20 mins (r-04 = 0020) and press "SET" again for confirming the soaking temperature (C-05 = 0945).
Press "SET" again for ramping down to 722°C in 60 minutes (r-05 = 0060) and press "SET" again to enter target temperature (C-06 = 0722).
Now enter holding time for this parameter (r-06 = 0025) and press "SET" again to confirm holding temperature (C-07 = 0722).
To stop your program and cool the kiln down automatically enter "0000" in "r-07" segment. Your program will finish automatically as soon as the last parameter is reached. That's it! Now you can use this controller for hundreds of different programs.

3. When re-programming is finished just click twice on the "SET" button again, leave the controller on for 20-30 seconds - it will remember all the parameters and go back to the main screen with "STOP" sign automatically.

4. To start a new program: press and hold **Button 3** for 3 seconds until you see the "Run" sign, or the starting point (0005) on the bottom line of controller. Otherwise, just can just re-start your kiln. Each time you turn your kiln ON the last program will start automatically.

5. Important for beginners: you will only have around 20-30 seconds to change the digits on **each segment**. Exceeding this time without changing any digit will lead to the controller returning to the main screen. If this happens, just re-start the re-programming process again by pressing and holding "SET" button again for 3 seconds. You can do it as many times as you need.

6. Quick tip: to quickly change the temperature or time please use **Button No:2** to change the digits on required segments from right to left (the required segment will starts flashing).