

EQ Temperature Setting and Warm Up Troubleshooting

To bring up the temperature screen, in the space of 1 second perform the following steps:

- Press and hold the "ESC" button.
- Press the "up" arrow button
- Release both buttons at the same time

Once the Temperature Setting screen is visible you should be able to raise or lower the temperature setting with the "up" arrow or "down" arrow only. Within a few seconds the screen will return to the default "Equalizer" screen. Remember that each time you access the Temperature Setting screen you are changing the temperature setting from its previous value.

HOW TO change the Temperature:

- The Equalizer has 10 temperature settings, 10 being the hottest and 1 the coldest.
- Turn on the machine and allow it to get to running temperature.
- During the Warm-Up mode, the Screen will display the countdown timer.
- Once the Running Temperature has been reached the Run Screen will appear.
- To navigate from the Run Screen to the Temperature Set Screen press and hold ESC, then press the UP arrow or the DOWN arrow.
- This will adjust the operating temperature by 1 level. The machine is factory set at a temperature level of 5.

Guidelines:

- Once you have found the temperature setting that works best for you, it is unlikely that you will have to adjust it very often.
- Once a change to the temperature has been made, allow the glue 10 to 15 minutes to reach the new temperature, and then run a test board before changing the temperature again.
- **Do not attempt** temperature adjustment while in the *Warm-up Cycle*

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In the event your Equalizer is not warming up, you will need to determine where the problem may be:

On your LOGO display the screen should be showing "Warming Up"

Press the DOWN arrow key and you should have a flashing Time/Date display. When you have that, press the RIGHT arrow key twice and you should have a display that looks something like this:

Q:
O 1 2 3 4 5 6 7 8 etc...
2

The first number on the O line, the 1 – is it 'highlighted'? (as opposed to how the other numbers are displayed)

If YES, then check the output voltage on Q1,2 . It should be 120V.

If Q1,2 voltage is 120V, then it's most likely your heating element.
If Q1,2 is not showing 120V then check Q1,1. That should ALWAYS show 120V output

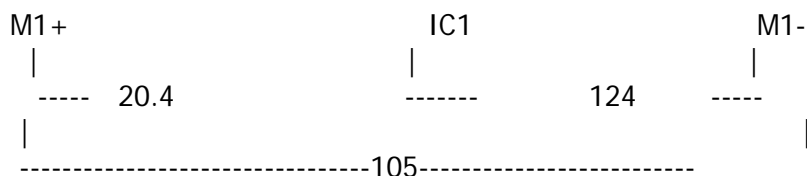
If Q1,1 does show 120V then your PLC is bad and needs to be replaced
If Q1,1 does NOT show 120V, then it's a wiring issue, check to make sure the wires are connected and not loose or detached.

If NO, then check the Thermistor (see diagram that I will attempt to draw below)

If the thermistor is OK, then we don't know what the problem is exactly...
If the thermistor is 15% off or more, then replace thermistor

To check thermistor values:

Machine = Off



Enclosed is the EQ Wiring Diagram, select the correct one for your machine by referring to the serial number

Manuals and Diagnostic documents can be found on our website:
www.castleusa.com/support.html

WIRING DIAGRAM APPLIES ONLY TO TLE EQ S/N 63548 and EARLIER

The diagram illustrates the electrical connections for a Siemens LOGO! 12/24 RC control unit. The unit is divided into four main sections: DC 12/24V INPUT 8xDC, DC 12/24V INPUT 4xDC, DC 12/24V INPUT 4xDC, and AC 120/230V INPUT/OUTPUT.

Key Components and Connections:

- Power Input:** AC 120/230V is connected to the L1, N, and G terminals. The output is DC 24V/1.3A.
- DC Input:** DC 12/24V is connected to the L+ and M terminals. The output is DC 24V/1.3A.
- Relay Outputs:** The unit features four relay outputs (Q1, Q2, Q3, Q4) rated at 4x RELAY/10A. These are connected to the Glue Level, Glue Feed, and Guillotine switches.
- Safety Switches:** The Guillotine Switch and Glue Pot Switch are connected to the unit's output terminals. The Guillotine Switch is connected to the L+ and M terminals, and the Glue Pot Switch is connected to the L+ and M terminals.
- Wiring Color Coding:**
 - Red: Main power and output lines.
 - Blue: Grounding and safety lines.
 - Orange: Input and output lines.
 - Yellow: Control and signal lines.
 - Black: Common ground and return lines.

The diagram includes detailed terminal block connections and a legend for the switches and components. The unit is labeled with its model number, 6ED1 052-1MD00-0BA3, and the manufacturer, SIEMENS.

CIRCUIT DIAGRAM APPLIES ONLY TO
CASTLE EQ S/N 63549 AND LATER

