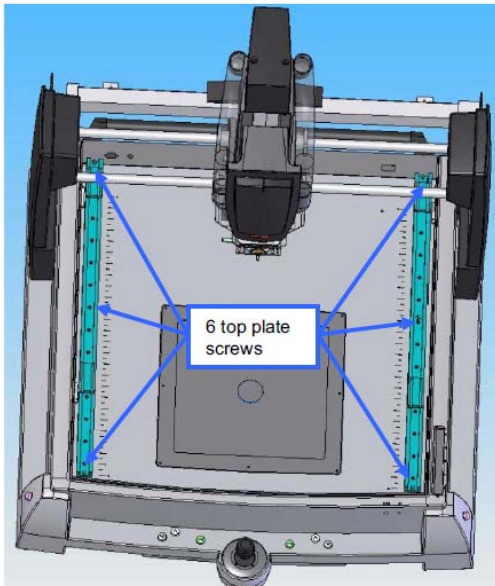


APR-5000-XL(S) TOP REFLOW PUMP

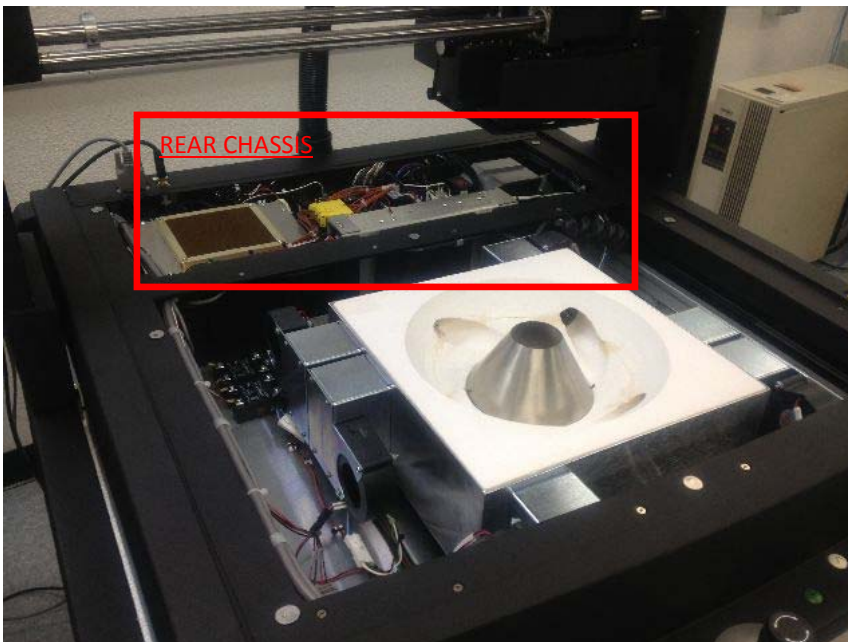
Tools: standard hex Allen key set

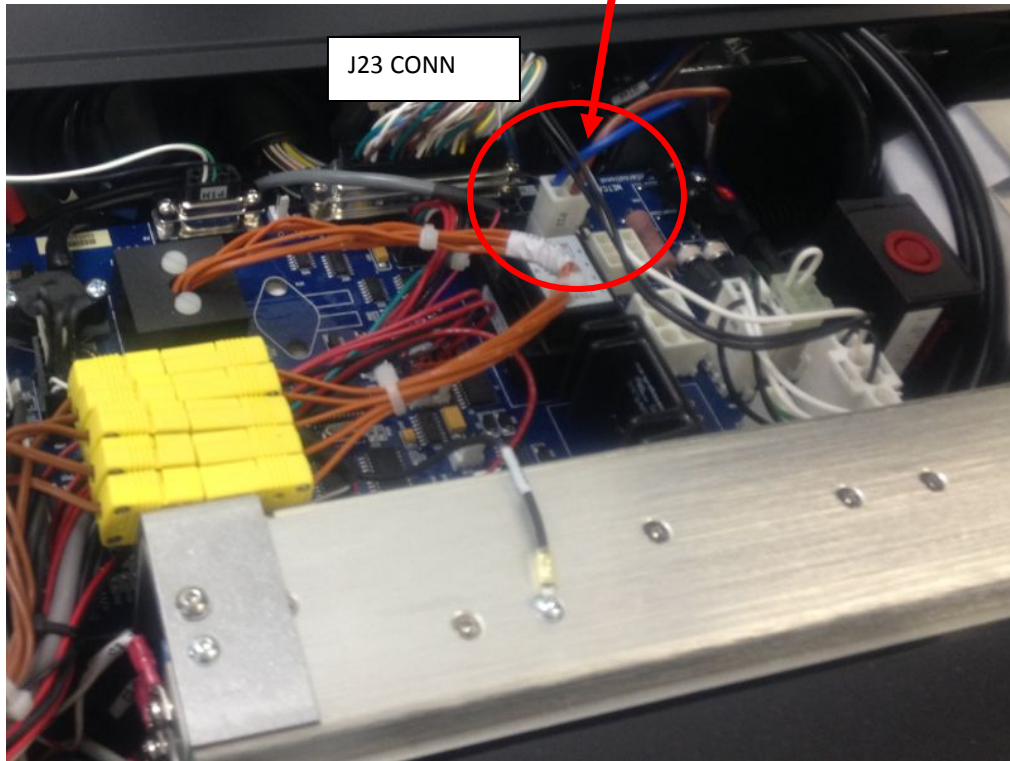
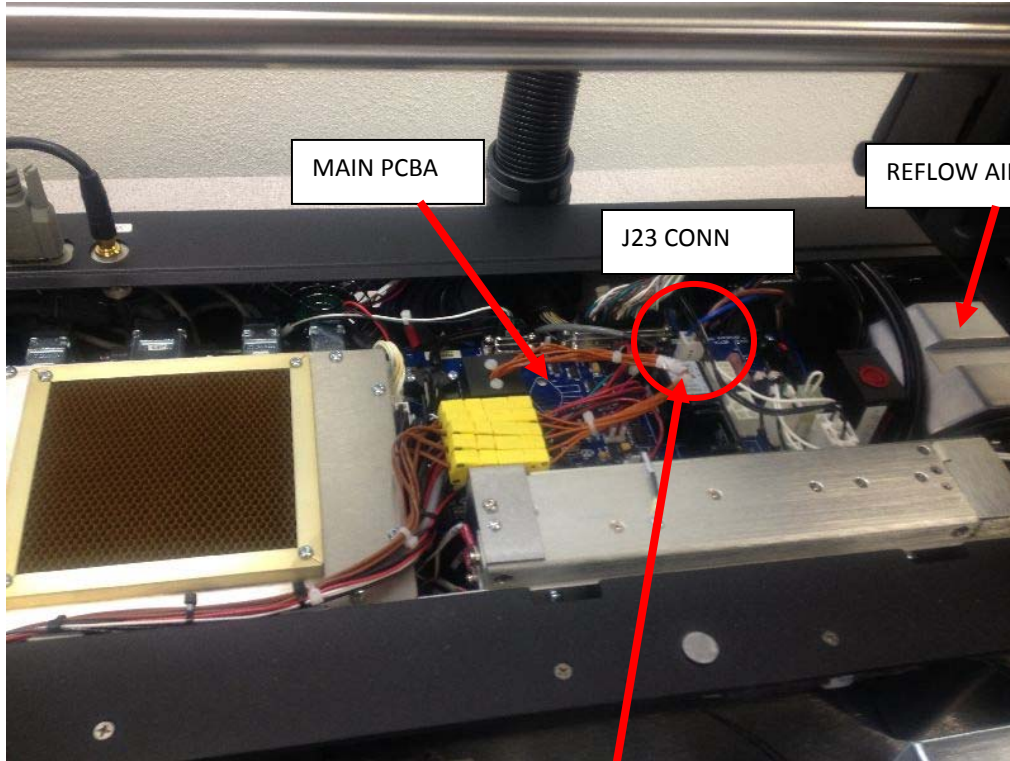
1. Machine is OFF
2. Remove TOP PLATE (3x screws front, middle, rear on left and right board holder rail guides (6x screws total); these screws will have larger head than the other rail screws
7/16" hex allen key

CAUTION: top plate is heavy in weight, lift and remove carefully

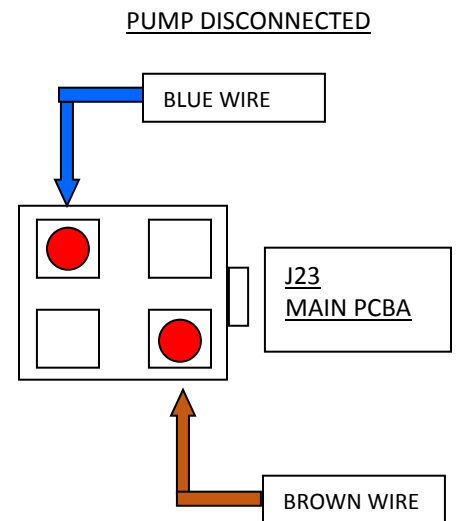
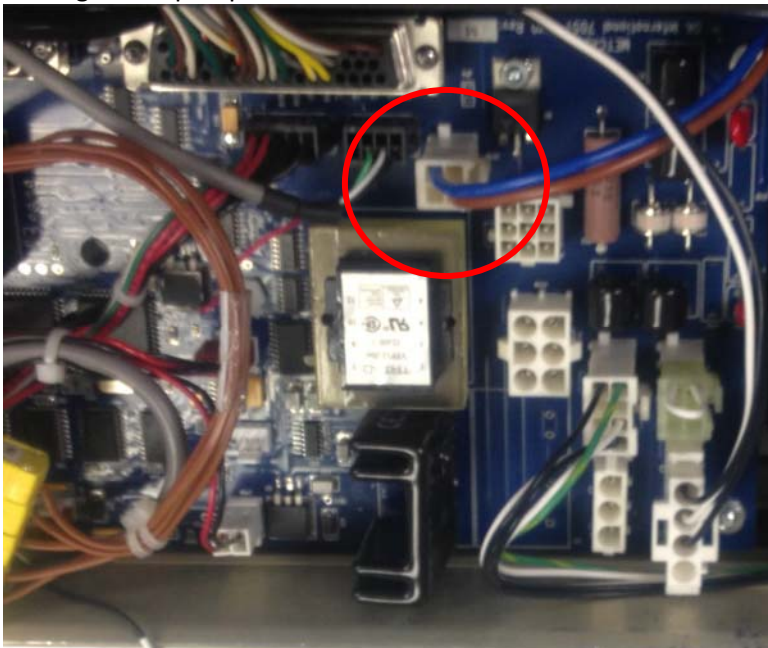


3. Locate top reflow air pump and main pcba J connector in rear chassis

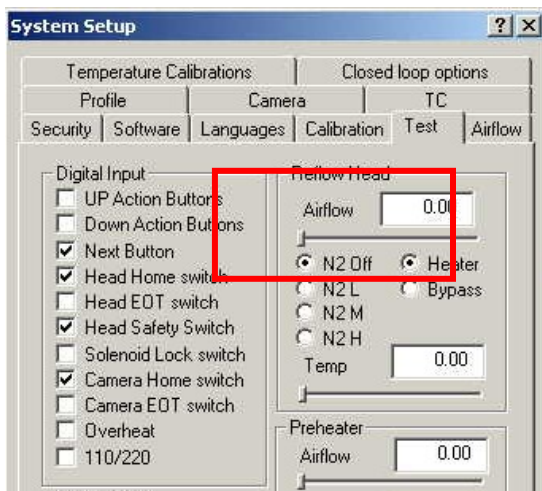




4. DISCONNECT J23 from main pcba
5. Check reference ohms across the 2-wires on connector side leading to the pump
RECORD OHM VALUE
FOR REFERENCE ONLY: 'typical' ohms (sample only) \approx 103-104 ohms
6. Turn machine ON
IMPORTANT: there will be live voltage present when machine is on and top cover removed
Please observe all pre-cautions! Only come into contact with what is noted in the procedure!
7. Open the software in admin mode (enter OK admin username and password)
8. Go to System setup and TEST tab
9. **IMPORTANT:** J23 is a 4-pin/socket connection BUT only a 2-wire AC connection leading from main pcba to pump. Make sure to test the correct points as the next steps will be to test for live AC voltage across the correct 2-pins/sockets for the connection on main pcba
Use multimeter set to AC voltage to check across the 'live' pins that correspond to the 2x wires leading to the pump on the other side of the connection



10. In TEST tab, right side under REFLOW HEAD adjust the Airflow slider to 1/4 'on' (value=25)
Record AC voltage seen across 2x 'live' pins on main pcba J23 connection
11. In TEST tab, right side under REFLOW HEAD adjust the Airflow slider to 1/2 'on' (value=50)
Record AC voltage seen across 2x 'live' pins on main pcba J23 connection
12. In TEST tab, on the right side under REFLOW HEAD adjust the Airflow slider all the way to the right or 100% 'on' (value=100)
Record AC voltage seen across 2x 'live' pins on main pcba J23 connection



IMPORTANT NOTE: the sample values in table are 'reference only' from one sample machine

| <u>AIRFLOW SETTING</u> | <u>J23 VOLTAGE 'SAMPLE'</u> | <u>J23 VOLTAGE MEAS.</u> | <u>COMMENT</u> | | |
|----------------------------------|------------------------------------|---------------------------------|-----------------------|--|--|
| <u>1/4 (value = 25)</u> | 39-40 VAC | | PUMP DISCONNECTED | | |
| <u>1/2 (value = 50)</u> | 118-120 VAC | | PUMP DISCONNECTED | | |
| <u>Full (value = 100)</u> | 200-202 VAC | | PUMP DISCONNECTED | | |