OPERATING THE TEMPERATURE CONTROLLER FOR SIDE BENDING

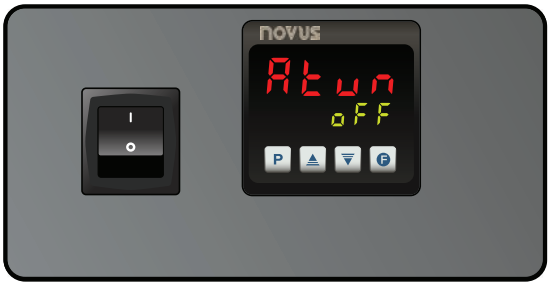
Set the temperature unit

The Temperature Controller can display either Celsius or Fahrenheit. Confirm the temperature unit before setting the bending temperature range. You will only need to change this once, the controller will remember your settings.

Plug in the power cord. Turn on the red switch at the back of the controller, then the black switch on the front. The two switches are a safety feature, both must be switched on for the controller to operate. The screen should display “r2.01 Std”.



Press and hold down the **P** button (Parameters). You will first see “Atun” displayed. Continue to hold the **P** button.



When you see the screen display “type”, release the **P** button.



Press and release the **P** button to toggle through the menu until you see “unit” displayed in red. The green text will read **°F** for Fahrenheit or **°C** for Celsius. Press the up or down arrow buttons to change to your desired unit. Once changed press and release **P** to continue through the menu.



Set the temperature range

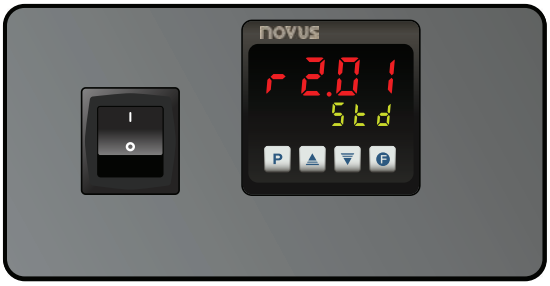
We recommend bending at 300 degrees, which is also the highest recommended setting for the Temperature Controller. Most woods bend well at this temperature, if you are bending softer or lighter colored woods test on scrap at a lower temperature.

CAUTION

DO NOT set the temperature with the Heating Blanket or thermocouple plugged in.

DO NOT turn on the Temperature Controller with the Heating Blanket plugged in unless it is in the sandwich and ready to bend. This can damage your Heating Blanket.

During bending, you can raise or lower the temperature of the blanket within your set range by using the up and down arrow buttons. We recommend setting the temperature range 10 - 20 to between your highest and lowest temperature. For example, if your maximum temperature is 300 degrees, your minimum temperature should be 280 - 290 degrees.



Turn on the controller. The screen should read “r2.01 Std”.

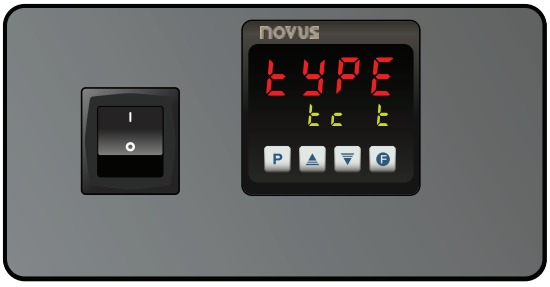
The screen will automatically switch to display the temperatures. The green number shows the current set temperature for the Heating Blanket, the red number is the current temperature measured by the thermocouple probe. The red number will appear as dashed lines when the thermocouple is not plugged in.



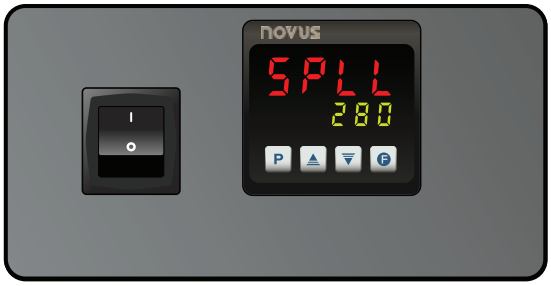
Press and hold down the **P** button. The screen will display “Atun” in red, continue holding.



Next the screen will display “type.” Release the **P** button.



To set the minimum temperature, press and release the **P** button until you see "SPLL" (Set Point Low Limit). Then use the up and down arrow buttons to set the desired minimum temperature.



To set the maximum temperature, press the **P** button again and you will see "SPHL" (Set Point High Limit). Use the up and down arrow buttons to set the desired maximum.

Maximum temperature: Do not exceed 300 degrees as you can scorch the wood and Bending Forms.



Press and release the **P** button once each time until you see the dashed red lines and green temperature number again.

The unit will remember the last temperature range set when turned back on. Always check the green temperature before plugging in the blanket.

When finished programming the Temperature Controller and after bending, always turn off both the front and rear power switches.

CAUTION

The Temperature Controller **DOES NOT** automatically shut off. You must turn it off with **both** front and rear power switches.

Whenever the heat is on and bending sides **DO NOT walk away**. It is easy to forget or get distracted.

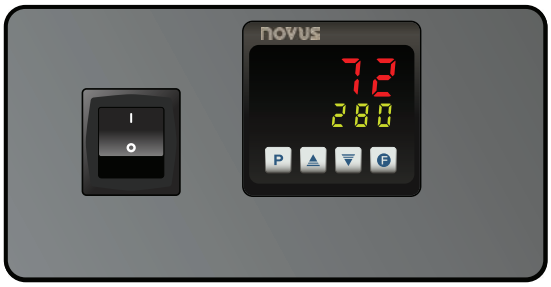
You can burn your sides **or worse**...

Overheating or "cooking" your sides can also case-harden them, making them brittle and more prone to cracking.

Set the temperature control timer

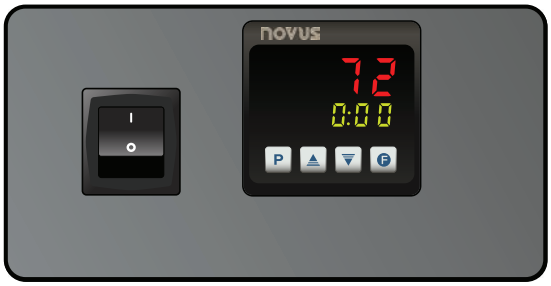
The timer in the Temperature Controller starts when your Heating Blanket reaches the low set temperature (SPLL). It will then count down from the timer's set time and shut the Heat Blanket off when it reaches zero.

After first turning on your controller with the thermocouple plugged in, you will see a red readout and a green readout.



After a few seconds, the red will show the thermocouple temperature reading, and the green will show the low temperature set point for your Heating Blanket.

Press the **P** button once, the red readout will remain on, while the green readout switches to a minutes-and-seconds timer.



Press the **P** button once more to change the red readout to t1 (for timer), and the green readout will show the preset 10:00 (ten minutes and zero seconds). Press the up and down arrow buttons to change the timer setting. We recommend NOT going above 15:00 (fifteen minutes and zero seconds).



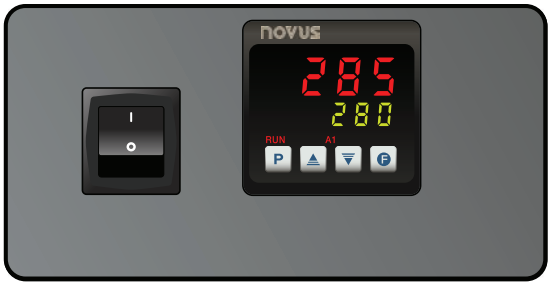
At this time, load your "sandwich" (side covered in parchment paper, Heating Blanket, and steel straps) into the Side Bending Machine.

Press **P** again to change the red readout to “run” and the green to “no”. At this point, there is no power to the Heating Blanket. Press the “down” arrow once to change the green readout to “yes”. In the bottom left corner, in smaller letters, you’ll see the words “RUN”. This turns on the Heating Blanket and will start the timer countdown when it reaches the low set point.



Press **P** again to return the red readout to the current temperature, and the green readout to the low set temperature.

Finally, press **P** once again to see the current temperature of the Heating Blanket on the red readout. When the set temperature is reached, “A1” will light up red in the bottom left center of the controller. This tells you the timer circuit has started.



The green readout will now show the timer counting down. (It will need to fully cycle before you can reset.) When the timer reaches 00:00, the Heating Blanket turns off, and the sides and blanket will start to cool down.



CAUTION

Manually turn off **both** power switches and **unplug** the Heating Blanket when the timer reaches zero and the bend is complete.

This is an extra safety measure while the side and machine cool to room temperature. **Never** leave the immediate area of the Side Bending Machine while the Heating Blanket is on!