TEMPCO Model PCM10024 Portable Control Console
Instruction Manual

SPECIFICATIONS
Control Zones: 1
Temperature Controller: Model TEC-9100, 1/16 DIN PID Time Proportioning
Sensor Input: ANSI Type “J” Thermocouple
Power Cord Input: 120 VAC, 50-60 Hz
Heater Output: 120 VAC — 16 amps maximum (1,920 watts maximum)
Output Device: Mechanical Relay
Main Power Switch: Located on front panel
Main Power Fuse: Buss ABC-20-R (located on back panel)
Control Power Fuse: Buss ABC-1 (located on back panel)

WARNINGS
1. Dangerous voltage capable of causing injury or death is present within this console. Power to all
   equipment must be disconnected before installation or beginning any troubleshooting procedures.
   Heater output wiring and component replacement
   must be made by qualified personnel only.

2. To minimize the possibility of fire or shock, do not expose this console to rain or excessive moisture.

3. Do not use this console in areas where hazardous conditions exist such as excessive shock,
   vibration, dirt, corrosive gases, oil or where explosive gases or vapors are present.

WIRING (For safety, disconnect all power sources prior to wiring)
1. Attach the leads from your type “J” thermocouple to the black mini-plug provided. Take care to
   note the correct polarity. For a type “J” thermocouple, the white lead is (+) positive and the red lead
   is (-) negative.

2. The heater output current is sourced directly through the 120V line cord. The rear console output
   receptacle provides live controlled power for direct connection to your heater(s). Connect one lead
   from your heater to one prong of the Hubbell plug (not ground). Connect the other lead from your heater
   to the other prong. Connect heater ground (if applicable) to the ground connection (G) on the plug.
OPERATION

1. Verify the power switch is in the off position. Plug in your thermocouple and heater load. Plug the provided 120 V line cord from the console into a 20 Amp, Grounded 120 VAC outlet. Switch on the PCM10024.

2. Set your desired temperature setpoint by using the up and down arrow buttons on the TEC-9100 temperature controller.

3. Refer to the Instruction Manual provided for complete operation and auto-tuning of the TEC-9100 temperature controller.

4. The standard PCM console is set to control electric heaters and cycle the heaters on and off to maintain an accurate temperature. The TEC-9100 controller can easily be changed to “on-off” action which eliminates this cycling, such as for the control of solenoid valves. To accomplish this, go to the “Pb” setting and lower that to zero. Then go to the “HYST” setting and the number you enter there will become the hysteresis (deadband) setting.

SPARE/REPLACEMENT PARTS

<table>
<thead>
<tr>
<th>Tempco Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>EHD-124-213</td>
<td>Fuse (1), rated 20 amps, 250V, ¼” x 1¼”, fast acting, BUSS ABC-20-R. Used for main power (located inside rear panel mounted fuseholder)</td>
</tr>
<tr>
<td>EHD-124-276</td>
<td>Fuse (1), rated 1 amp, 250V, ¼” x 1¼”, fast acting, BUSS ABC-1. Used for TEC-9100 Controller (located inside rear panel mounted fuseholder)</td>
</tr>
<tr>
<td>EHD-102-140</td>
<td>Power output plug (1), Hubbell HBL5366C or equivalent, 20A 125V Straight-Blade, 2-pole, 3 wire grounding, NEMA 5-20P</td>
</tr>
<tr>
<td>TCA-101-105</td>
<td>Type “J” thermocouple mini plug (1), black</td>
</tr>
</tbody>
</table>
1–5 Menu Overview

- **User Menu**: Use the [ ] button to enter the user menu.
  - Select parameters: SP2, SP3, INPT, UNI, DP, PB, T1, TD, CYC1, ADDR
  - Select SETUP Menu (see page 6)

- **Setup Menu**
  - Manual Mode
    - **HEAT** H___
    - **COOL** C___
  - Auto-tuning Mode (see page 7)
  - Calibration Mode

- **User Menu**
  - 5 sec.
  - 6.2 sec.
  - 7.4 sec.
  - 8.6 sec.
  - 9.8 sec.

- **Manual Mode**
  - Release and press for 3 seconds to start auto-tuning mode.
  - Press for 5 seconds to start manual control.

- **Auto-tuning Mode**
  - Press for 5 seconds to perform calibration.

- **Calibration Mode**
  - Press for 5 seconds to perform calibration.

⚠️ Entering these modes will break the control loop and change some of the previously set data. Make sure that the system is able to accept these modes.

*1: This flow chart shows a complete listing of all parameters. For actual application the number of available parameters depends on setup conditions and could be less than that shown in the flow chart.

*2: You can select up to 8 parameters to be placed in the user menu by using SEL1–SEL8 located at the bottom of setup menu.

*3: Release [ ], press [ ] again for at least 2 but no more than 3 seconds, then release to access the calibration menu.

The user menu shown in the flow chart corresponds to the default setting for SELECT parameters SEL1 to SEL8. SP3 will be hidden if NONE is selected for ALFN. SP2 will be hidden if the alarm function is not selected for OUT2. An unused parameter will be hidden even if it is selected by the SEL parameters.
### Parameter Descriptions (TEC-9100 Temperature Controller)

<table>
<thead>
<tr>
<th>Parameter Notation</th>
<th>Parameter Description (Refer to Page)</th>
<th>Range</th>
<th>Default Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>SPI SPI1</td>
<td>Set point for output 1</td>
<td>Low: SPI1L High: SPI1H</td>
<td>77.0°F</td>
</tr>
<tr>
<td>LoCB LOCK</td>
<td>Select parameters to be locked out</td>
<td>0</td>
<td></td>
</tr>
<tr>
<td>unPE INPT</td>
<td>Input sensor selection</td>
<td>0</td>
<td></td>
</tr>
<tr>
<td>unB UNIT</td>
<td>Input unit selection</td>
<td>1</td>
<td></td>
</tr>
<tr>
<td>dP DP</td>
<td>Decimal point selection</td>
<td>0</td>
<td></td>
</tr>
<tr>
<td>SHF SHIF</td>
<td>PV shift (offset) value</td>
<td>Low: -200.0°C High: 200.0°C</td>
<td>0.0</td>
</tr>
<tr>
<td>rFlt FILT</td>
<td>Filter damping time constant of PV</td>
<td>2</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Parameter Notation</th>
<th>Parameter Description (Refer to Page)</th>
<th>Range</th>
<th>Default Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pb BI</td>
<td>Proportional band value</td>
<td>Low: 0 High: 500.0°C (900.0°F)</td>
<td>10.0°C (18.0°F)</td>
</tr>
<tr>
<td>Ti TI</td>
<td>Integral time value</td>
<td>Low: 0 High: 1000 sec</td>
<td>100</td>
</tr>
<tr>
<td>TD TD</td>
<td>Derivative time value</td>
<td>Low: 0 High: 360.0 sec</td>
<td>25.0</td>
</tr>
<tr>
<td>oal OUT1</td>
<td>Output 1 function</td>
<td>0</td>
<td></td>
</tr>
<tr>
<td>oLY OITY</td>
<td>Output 1 signal type</td>
<td>0</td>
<td></td>
</tr>
<tr>
<td>oFz O1FT</td>
<td>Output 1 failure transfer mode (Page 6)</td>
<td>Select BPSLS (bumpless transfer) or 0.0 - 100% to continue output 1 control function as the unit fails, or select OFF (0) or ON (1) for OFF-ON control.</td>
<td>0</td>
</tr>
<tr>
<td>oHY OHY</td>
<td>Output 1 ON-OFF hysteresis (Page 5)</td>
<td>Low: 0.1 High: 50.0°C (90°F)</td>
<td>0.1°C (0.2°F)</td>
</tr>
<tr>
<td>rCYC1 CYC2</td>
<td>Output 1 cycle time</td>
<td>Low: 0 High: 90.0 sec</td>
<td>18.0</td>
</tr>
<tr>
<td>rFST OFST</td>
<td>Offset value for P control</td>
<td>Low: 0 High: 100.0%</td>
<td>25.0</td>
</tr>
<tr>
<td>rRtP RAMP</td>
<td>Ramp function selection (Page 5)</td>
<td>0</td>
<td></td>
</tr>
<tr>
<td>rr RR</td>
<td>Ramp rate (Page 5)</td>
<td>Low: 0 High: 500.0°C (900.0°F)</td>
<td>0.0</td>
</tr>
</tbody>
</table>

*Controller Parameter Descriptions that are not applicable are not shown in the above table.*
Control Outputs

Heat only ON-OFF control: Select REVR for OUT1. Set PB (proportional band) to 0. O1HY is used to adjust dead band for ON-OFF control. The output 1 hysteresis (O1HY) is enabled in case PB=0. The heat only on-off control function is shown in the following diagram:

![Image of Heat Only ON-OFF Control](image)

Figure 3.2 Heat Only ON-OFF Control

The ON-OFF control may introduce excessive process oscillation even if hysteresis is minimized. If ON-OFF control is set (i.e., PB=0), TI, TD, CYC1, OFST, CYC2, CPB, and DB will be hidden and have no function in the system. The auto-tuning and bumpless transfer functions will be disabled as well.

Heat only P (or PD) control: Select REVR for OUT1, set TI to 0. OFST is used to adjust the control offset (manual reset). 

O1HY is hidden if PB is not equal to 0.

Ramp

The ramping function is performed during power up as well as any time the set point is changed. If MINR or HRR is chosen for RAMP, the unit will perform the ramping function. The ramp rate is programmed by adjusting RR. The ramping function is disabled as soon as failure mode, manual control mode, auto-tuning mode or calibration mode is entered.

Example without dwell timer

Select MINR for RAMP, select °C for UNIT, select 1-DP for DP, set RR=10.0. SV is set to 200°C initially, and changed to 100°C 30 minutes after power-up. The starting temperature is 30°C. After power-up, the process runs like the curve shown below:

![Image of RAMP Function](image)

Figure 3.5 RAMP Function

OFST function: OFST is measured by % with a range of 0–100.0%. In the steady state (i.e., process has been stabilized), if the process value is lower than the set point by a definite value, say 5°C, while 20°C is used for PB, that is lower by 25%, then increase OFST 25%, and vice-versa. After adjusting OFST value, the process value will be varied and eventually coincide with set point.

Refer to section 3-12 “manual tuning” for the adjustment of PB and TD. Manual reset (adjust OFST) is not practical because the load may change from time to time and OFST may need to be adjusted repeatedly. PID control can avoid this situation.

Heat only PID control: If REVR is selected for OUT1, PB and TI should not be zero. Perform auto-tuning for the new process, or set PB, TI, and TD with historical values. See section 3-11 for auto-tuning operation. If the control result is still unsatisfactory, then use manual tuning to improve control. See section 3-12 for manual tuning. The unit contains a very advanced PID and Fuzzy Logic algorithm to create a very small overshoot and very quick response to the process if it is properly tuned.

Cool only control: ON-OFF control, P (PD) control, and PID control can be used for cool control. Set OUT1 to DIRT (direct action). The other functions for cool only ON-OFF control, cool only P (PD) control, and cool only PID control are the same as for heat only control except that the output variable (and action) for cool control is inverse to heat control.

NOTE: ON-OFF control may result in excessive overshoot and undershoot problems in the process. P (or PD) control will result in a deviation of process value from the set point. It is recommended to use PID control for heat-cool control to produce a stable and zero offset process value.

Note: When the ramp function is used, the lower display will show the current ramping value. The ramping value is an artificially determined setpoint created and updated by the control to match the ramp rate set by the user. However, it will revert to show the set point value as soon as the up or down key is touched for adjustment. The ramping value is initiated to process value either on power-up or when RR and/or the set point are changed. Setting RR to zero means no ramp function.
PV Shift

In certain applications it is desirable to shift the controller display value (PV) from its actual value. This can easily be accomplished by using the PV shift function.

The SHIF function will alter PV only.

Example: A process is equipped with a heater, a sensor, and a subject to be warmed up. Due to the design and position of the components in the system, the sensor could not be placed any closer to the part. Thermal gradient (differing temperatures) is common and necessary to an extent in any thermal system for heat to be transferred from one point to another. If the difference between the sensor and the subject is 35°C, and the desired temperature at the subject to be heated is 200°C, the temperature at the sensor should be 235°C. You should enter -35°C to subtract 35°C from the actual process display. This in turn will cause the controller to energize the load and bring the process display up to the set point value.

Failure Transfer

The controller will enter failure mode if one of the following conditions occurs:

1. **SBER** occurs due to input sensor break or input current below 1mA if 4–20 mA is selected or input voltage below 0.25V if 1–5V is selected.
2. **ADER** occurs due to the A-D converter of the controller failing.

Output 1 and output 2 will perform the failure transfer function as the controller enters failure mode.

**Output 1 failure transfer**, if activated, will perform:

1. If output 1 is configured as proportional control (PB≠0), and BPLS is selected for O1FT, then output 1 will perform bumpless transfer. Thereafter, the previous averaging value of MV1 will be used for controlling output 1.
2. If output 1 is configured as proportional control (PB≠0), and a value of 0 to 100.0% is set for O1FT, then output 1 will perform failure transfer. Thereafter, the value of O1FT will be used for controlling output 1.
3. If output 1 is configured as ON-OFF control (PB=0), then output 1 will be driven OFF if OFF is set for O1FT and will be driven ON if ON is set for O1FT.

Manual Control

Operation

To enable manual control, the LOCK parameter should be set to NONE, then press for 6.2 seconds; (hand control) will appear on the display. Press for 5 seconds, then the MAN indicator will begin to flash and the lower display will show . The controller is now in manual control mode. indicates output control variable for output 1, and indicates control variable for output 2. Now you can use the up and down keys to adjust the percentage values for the heating or cooling output.

The controller performs open loop control as long as it stays in manual control mode.

Exit Manual Control

Pressing the key will cause the controller to revert to its normal display mode.
Auto-tuning

⚠️ The auto-tuning process is performed near the set point. The process will oscillate around the set point during the tuning process. Set the set point at a lower value if overshooting beyond the normal process value is likely to cause damage.

**Auto-tuning is applied in cases of:**
- **Initial setup for a new process**
- **The set point is changed substantially from the previous auto-tuning value**
- **The control result is unsatisfactory**

**Operation:**

1. The system has been installed normally.
2. Set the correct values for the setup menu of the unit, but don’t set a zero value for PB and TI, or the auto-tuning program will be disabled. The LOCK parameter should be set at NONE.
3. Set the set point to a normal operating value, or a lower value if overshooting beyond the normal process value is likely to cause damage.
4. Press [Hold until SET] appears on the display.
5. Then press [Hold for at least 5 seconds. The AT indicator will begin to flash and the auto-tuning procedure begins.

**NOTE:** The ramping function, if used, will be disabled when auto-tuning is taking place.

Auto-tuning mode is disabled as soon as either failure mode or manual control mode is entered.

**Procedures:**

Auto-tuning can be applied either as the process is warming up (cold start), or when the process has been in a steady state (warm start). After the auto-tuning procedures are completed, the AT indicator will cease to flash and the unit will revert to PID control using its new PID values. The PID values obtained are stored in the nonvolatile memory.

**Auto-Tuning Error**

If auto-tuning fails an ATER message will appear on the upper display in the following cases:
- If PB exceeds 9000 (9000 PU, 900.0°F or 500.0°C),
- if TI exceeds 1000 seconds,
- if the set point is changed during the auto-tuning procedure.

**Solutions to Auto-Tuning Error**

1. Try auto-tuning once again.
2. Don’t change the set point value during the auto-tuning procedure.
3. Don’t set a zero value for PB and TI.
4. Use manual tuning instead of auto-tuning (see section 3-12).
5. Touch RESET key to reset message.

**Manual Tuning**

In certain applications auto-tuning may be inadequate for the control requirements. You can try manual tuning for these applications.

If the control performance using auto-tuning is still unsatisfactory, the following rules can be applied for further adjustment of PID values:

<table>
<thead>
<tr>
<th>ADJUSTMENT SEQUENCE</th>
<th>SYMPTOM</th>
<th>SOLUTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>(1) Proportional Band (PB)</td>
<td>Slow Response</td>
<td>Decrease PB</td>
</tr>
<tr>
<td>(2) Integral Time (TI)</td>
<td>High overshoot or Oscillations</td>
<td>Increase PB</td>
</tr>
<tr>
<td>(3) Derivative Time (TD)</td>
<td>Instability or Oscillations</td>
<td>Increase TI</td>
</tr>
</tbody>
</table>

**Table 3.2 PID Adjustment Guide**

![Figure 3.9 Effects of PID Adjustment](image)

**Figure 3.9 shows the effects of PID adjustment on process response.**
## Table A.1 Error Codes and Corrective Actions

<table>
<thead>
<tr>
<th>Error Code</th>
<th>Display Symbol</th>
<th>Error Description</th>
<th>Corrective Action</th>
</tr>
</thead>
<tbody>
<tr>
<td>4</td>
<td><strong>Er 04</strong></td>
<td>Illegal setup values being used; Before COOL is used for OUT2, DIRT (cooling action) has already been used for OUT1, or PID mode is not used for OUT1 (that is, PB=0 and/or TI=0)</td>
<td>Check and correct setup values of OUT2, PB, TI and OUT1. If OUT2 is required for cooling control, the control should use PID mode (PB≠0, TI≠0) and OUT1 should use reverse mode (heating action). Otherwise, don’t use OUT2 for cooling control.</td>
</tr>
<tr>
<td>10</td>
<td><strong>Er 10</strong></td>
<td>Communication error: bad function code</td>
<td>Correct the communication software to meet the protocol requirements.</td>
</tr>
<tr>
<td>11</td>
<td><strong>Er 11</strong></td>
<td>Communication error: register address out of range</td>
<td>Don’t issue an over-range register address to the slave.</td>
</tr>
<tr>
<td>14</td>
<td><strong>Er 14</strong></td>
<td>Communication error: attempt to write a read-only data or a protected data</td>
<td>Don’t write a read-only data or a protected data to the slave.</td>
</tr>
<tr>
<td>15</td>
<td><strong>Er 15</strong></td>
<td>Communication error: write a value which is out of range to a register</td>
<td>Don’t write an over-range data to the slave register.</td>
</tr>
</tbody>
</table>
| 26         | **R Err**      | Fail to perform auto-tuning function                                              | 1. The PID values obtained after auto-tuning procedure are out of range. Retry auto-tuning.  
                                        2. Don’t change set point value during auto-tuning procedure.  
                                        4. Don’t set a zero value for PB.  
                                        5. Don’t set a zero value for TI.  
                                        6. Press RESET key                   |
| 29         | **E E PE**     | EEPROM can’t be written correctly                                                 | **Return to factory for repair.**                                              |
| 30         | **C J Er**     | Cold junction compensation for thermocouple malfunction                           | **Return to factory for repair.**                                              |
| 39         | **S b Er**     | Input sensor break, or input current below 1 mA if 4-20 mA is selected, or input voltage below 0.25V if 1-5V is selected | Replace input sensor.                                                          |
| 40         | **R d Er**     | A to D converter or related component(s) malfunction                             | **Return to factory for repair.**                                              |
WARRANTY
Tempco Electric Heater Corporation is pleased to offer suggestions on the use of its products. However, Tempco makes no warranties or representations of any sort regarding the fitness for use, or the application of its products by the Purchaser. The selection, application, or use of Tempco products is the Purchaser's responsibility. No claims will be allowed for any damages or losses, whether direct, indirect, incidental, special, or consequential. Specifications are subject to change without notice. In addition, Tempco reserves the right to make changes—without notification to the Purchaser—to materials or processing that do not affect compliance with any applicable specification. TEC Temperature Controllers are warranted to be free from defects in material and workmanship for two (2) years after delivery to the first purchaser for use. Tempco’s sole responsibility under this warranty, at Tempco’s option, is limited to replacement or repair, free of charge, or refund of purchase price within the warranty period specified. This warranty does not apply to damage resulting from transportation, alteration, misuse, or abuse.

RETURNS
No product returns can be accepted without a completed Return Material Authorization (RMA) form.

TECHNICAL SUPPORT
Technical questions and troubleshooting help is available from Tempco. When calling or writing please give as much background information on the application or process as possible.
E-mail: techsupport@tempco.com
Phone: 630-350-2252
800-323-6859
Custom Manufacturer Since 1972
ELECTRIC HEATING ELEMENTS • TEMPERATURE CONTROLS • SENSORS • PROCESS HEATING SYSTEMS

HEAT THINGS UP!
With Thousands of Design Variations
We Make Everything You Need.

Band Heaters          Cartridge Heaters
Cast-In Heaters        Coil & Cable Heaters
Radiant Heaters        Strip Heaters
Flexible Heaters       Tubular Heaters
Process Heaters        Instrumentation
Temperature Control    Temperature Sensors

TEMPCO
ELECTRIC HEATER CORPORATION
607 N. Central Avenue Wood Dale, IL 60191-1452 USA
P: 630-350-2252  Toll Free: 800-323-6859
F: 630-350-0232  E: info@tempco.com
www.tempco.com

© Copyright 2020. All Rights Reserved