

# NORMAL DISPLAY



## ALARM DISPLAY



LEAK DETECTED, RED LED FLASHES, INTERLOCK RELAY WILL OPERATE AFTER 10 SECOND DELAY TIME. DISPLAY CYCLES THROUGH LEAK ALARM LOCATIONS. ALARMS ARE 'AUTO-RESET' AND WILL CLEAR WHEN THE LEAK LOCATION'S CLEAR. THE RELAY WILL RETURN TO NORMAL WHEN THE LAST LEAK LOCATION CLEARS

## LOW AIR PRESSURE ALARM DISPLAY

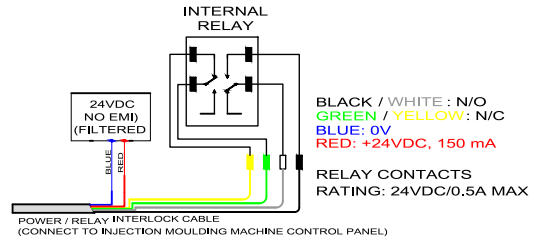


RED LED FLASHES, INTERLOCK RELAY WILL ACTIVATE AFTER 10 SECOND DELAY AND WILL RESET WHEN AIR SUPPLY IS RETURNED

## IMPORTANT INSTALLATION / OPERATION NOTES:

- 1) The DC Power Source must be interference free i.e no EMI or Switching Valves, Servo Motors etc. Use separate Power Supply or Power Supply from the Machine PLC.
- 2) The Internal Interlock Relay Contacts have a capacity to switch loads of 24Vdc with a maximum current of 0.5A.
- 3) Ensure neat workmanship and run the wiring and PU tubing within the machine enclosure if possible. Do not overtighten pneumatic connections.
- 4) Ensure that both ends of all Sensor Tubes are cut neatly and filed and cleared of any debris so as to provide a clear air passage and inner Sensor Tube diameter of 1mm.
- 5) Electrical Power should only be switched on after the Air Supply is energised. When using Modular Systems, the Manifolds should be mounted on the Mould Base before applying Electrical Power to allow the 'self teaching' function to work as all mould leak sensor installations will be somewhat different.

## ELECTRICAL CONNECTIONS



## MANIFOLD LED INDICATIONS

- POWER LED SHOULD BE CONTINUOUSLY LIT (NORMAL)
- ALARM LED SHOULD FLASH WHEN AN ALARM IS DISPLAYED

CORRECT INSTALLATION WILL MAKE A VERY RELIABLE LEAK DETECTION SYSTEM!  
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# AIRTECT Plastic Leak Alarm System

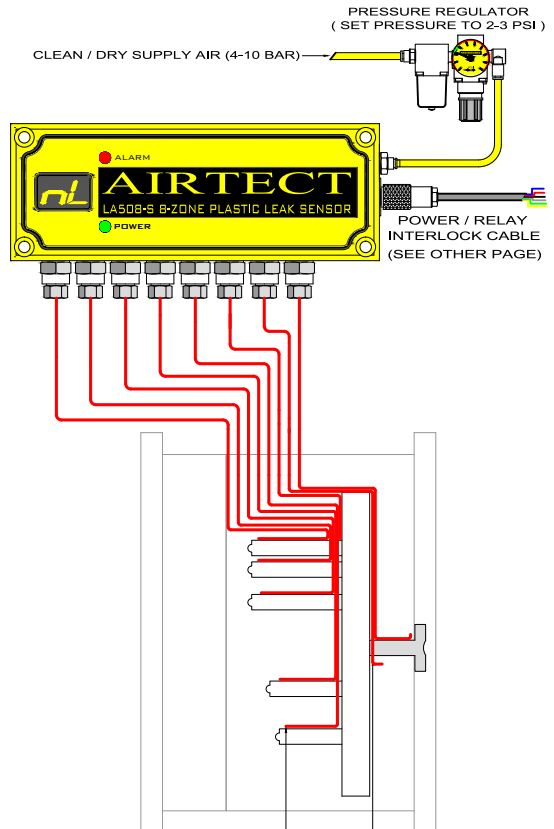
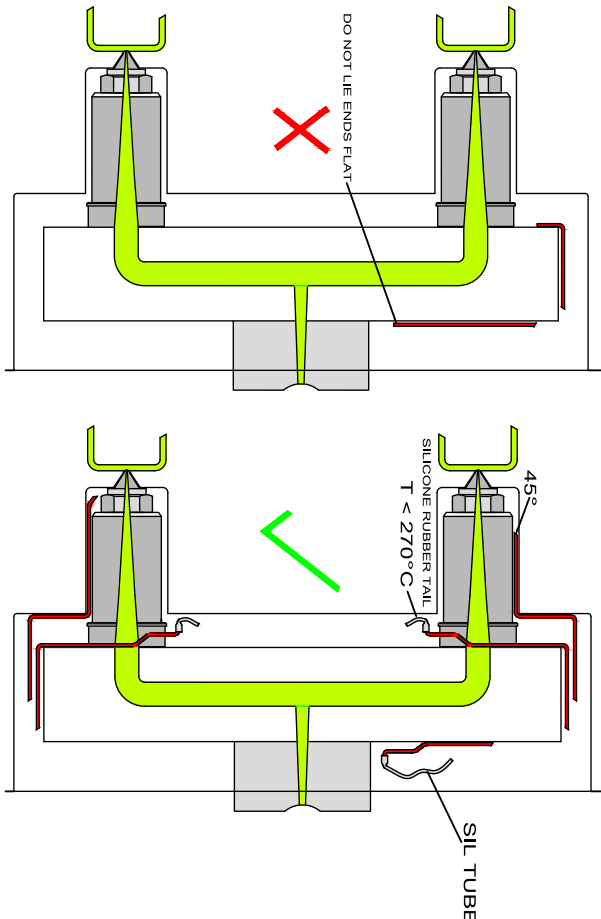


LA504S / LA508S / LA516S / LA524S

Installation Guide

V.1.0/121

EXAMPLE FOR LOCATION OF SENSOR TUBES AT NOZZLES AND MANIFOLD AREAS. USE SILICONE RUBBER TAILS IN AREAS <270°C AROUND HOT RUNNER MANIFOLD



INSTALL SENSOR TUBES AT LIKELY LEAK LOCATIONS (CHOOSE CAREFULLY BASED ON MOLD DESIGN AND / OR LEAK HISTORY) DO NOT LIE SENSOR TUBES FLAT ON MANIFOLD BUT TURN THE END UP FOR 10mm. USE SILICONE RUBBER TAILS IN AREAS <270°C AROUND HOT HOT RUNNER MANIFOLD. SEE OTHER DIAGRAM.