

## **Automatic Zero Calibration (AUTOCAL)**

Owing to the automatic zero calibration (AUTOCAL) function, there is no need to adjust the zero point manually on the controller. The AUTOCAL function matches the controller to the current and voltage signals that are present in the system.

You can activate this function by selecting step 7 in the Settings menu and then pressing “ENTER” key. The initial temperature (ambient temperature) of the heatsealing bar should be set-up with the proper ambient temperature (0-40 °C) using the “UP” and “DOWN” keys. (We use 20°C as the zero point).

The automatic calibration process takes around 10 seconds. The heatsealing band is not heated until the calibration process has finished. The message “Calibration – please wait” appears on the display while the AUTOCAL function is executing and a counter counts down to 0.

**You should always wait for the heatsealing band and the bar cool down (to ambient temperature) before activating the ‘AUTOCAL’ function.**

If your ambient room temperature is 20° C and you AUTOCAL when the bands are warmer than ambient, you have changed the ZERO point. If your ambient temperature is higher or lower than the 20°C, you must set the initial temperature (AUTOCAL to: XX °C).

The AUTOCAL function is usually only used when changing heatseal bands. Doing an AUTOCAL when the improper ambient temperature or when the heatseal bands are warm will give a false 0 (zero) point and move the scale for the temperature.

Since the controller uses resistance to determine the power to create the temperature desired and does not have a thermocouple to read the actual temperature, the proper AUTOCAL procedures are imperative for the best sealing conditions.