PSI POLYSOURCE
URETHANE FOAMS • ELASTOMERS & COATINGS • PROCESS EQUIPMENT SALES • SERVICE & RENTALS

BLOCK HEAT TROUBLESHOOTING – GLASCRAFT M-SERIES

A) If Block Heat Controller does not light-up, first check the following:

a. Supply power on? Supply light on? (200-240 VAC) ____
b. Over-temp/Over-pressure reset? ____
c. Safety shut-down re-set? ____
d. Emergency stop control re-set? ____
e. Confirm Block Heat breaker on? (24 VAC) ____
f. Test controller power supply voltage? ____

B) If Block Heat Controller does light-up, but no heat and displays an error, first check the following:

a. Display ERR-2 (check thermocouple) ____
b. Display ERR-4 (thermocouple unplugged) ____
c. Display ERR-7 (check controller program) ____

C) If Block Heat Controller does light-up and no error notes displayed, but still no heat, then check the following:

a. Controller set-point? (must be greater > "actual" display) ____
b. If controller "load on" light is not illuminated
   i. reconfirm section "a" above ____
   ii. Light gauge wire connection at SSR input tight & clean
   iii. test with an alternate controller ____
c. If Controller "load on" light is illuminated
   i. Confirm Block Heat breaker on? ____
   ii. Heavy gauge wire connections at SSR (solid state relay) output tight and clean? ____
   iii. Test controller voltage? ____
   iv. Block SSR (solid state relay) "load on" illuminated? ____
   (note: test for failed SSR via single jumper across output terminals & Block Heater should energize)
   v. Voltage at each heater element? (s/b 208-240 VAC) ____
   vi. If Voltage ok but no heat, then continuity test each heater element separately (s/b 46 ohms @ 74^0F) for 1000 watt rods ____

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