

PID controller Temperature Autotune

1. Turn the HEAT switch from REM to OFF.



2. Press the scroll and down arrow key together for five seconds. The display should be changed to setup.



3. Press the scroll key, slow down after 25 presses and look for the '**SPMD**' parameter

- **SPMD** will be in '**PV2**', and this is remote operation
- Use the arrow keys to change **SPMD** to '**SP1.2**' – Local mode.

4. Press the up and down arrow keys together for two seconds to save setting, and the display will return back to normal.
5. Set the temperature to the one you use most often, so that heater PID settings will be most effective at reaching and maintaining that temperature.
6. Press scroll and the down arrow key together for 3 seconds - SET will display.
7. Press scroll and the down arrow together again - HAND will display.
8. Press scroll and the down arrow together again - A_t will display.
9. Press the scroll button only for ~ 5 seconds. The main display will return and the temperature reading will start blinking. This indicates the Tempco controller is in AUTOTUNE mode.
10. Immediately turn the HEAT switch to ON. Autotuning is now in progress.

NOTE: The temperature will rise and fall as the controller performs the autotune. When the autotune is complete the temperature will stop blinking. This may take a while, but total time depends mostly on how high a temperature you tune at, and the wattage of the heater.

11. Once Autotune is completed, turn the HEAT switch from ON to OFF.
12. Press the scroll and down arrow key together for five seconds. The display will change to setup.
13. Press the scroll key and look for **SPMD**, and the **SPMD** parameter will be at **SP1.2**

14. Press the up or down arrow key until the value **PV2** is displayed.
15. Press the up and down arrow keys together for two seconds to save setting, and the display will return back to normal.