

# **Elimia Industrial**

Thank you very much for purchasing an Elimia Phase Converter. We sincerely hope that our products provide outstanding service for years to come.

Our company believes in the philosophy of “never stop improving”. We encourage our customers to provide input, opinions and suggestions on our products.

## Phase converter installation instructions:

Your converter should be located indoors at a location dry and easily accessible. You will need to provide suitable wiring and fusing from your existing main service or subpanel. Refer to your schematic for minimal wire fusing sizes. If fed from a circuit breaker the breaker will need to be a double pole type. Your wiring should be protected in conduit as required by national and local electrical codes. If your feed power is located more than 50 feet from the phase converter panel you should up size your feeder wire by one size or more to reduce voltage drop in the fed wiring.

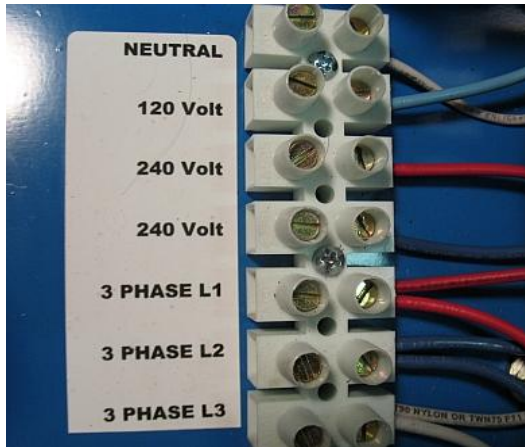
If your nominal 240 VAC feeder wiring is NOT a 4 conductor cable you will need to provide a separate 120 VAC wire to operate the converter controls. If using a 4 conductor cable (2 hot wires, insulated neutral and ground) that is all that will be needed. The schematic can help you determine what is easiest for you. If you do run a separate 120 VAC wire it will need to be properly fused and include a hot, neutral and ground. Jumping off an existing 120 VAC circuit is acceptable.



*The start stop switches are equipped with quick release adapters. These allow you to easily disconnect the pushbuttons from the actuators. Slide the red tabs to release the switches from the panel cover.*

New models of Elimia converters use a single point terminal block for all power connections. In other cases a terminal block or lugs will be provided and marked for this connection. In the picture below the terminal block is labeled and ready for the input power. Don't skimp on wire size! Using wiring that is undersized results in voltage drop. Voltage drop can greatly affect the operation of your converter and your three phase equipment. Nominal main power is 220 – 240 VAC. If your main's power is on the low end of nominal you should limit voltage drops as much as possible.

Some converters have been provided with fusing for your machine wiring. Please note that this fusing is intended to protect the wiring to your machine, not the machine itself. It should not be used as a replacement for protection required or already built in to your machine. Please refer to the schematic for sizing wire and fuses, in some cases the fusing provided from the factory may need to be changed based on wire size and load.



*All connections are made on the terminal block as labeled. If you ran a 4-wire cable for main power: hot, hot; neutral and ground, you should install a jumper wire from the 120V connection to one of the 240V connections. Installing the jumper means you will NOT need to provide separate 120V wiring. The 240V connections are for the main power coming from your double pole circuit breaker or fuse. Connections L1, L2 and L3 are three phase power out to your machine or subpanel. Make sure to twist or solder tin your wires before connecting.*

If you are running more than one machine from your phase converter, a subpanel should be installed. A subpanel can split your loads up and provide proper fusing for each machine's feeder wires. Elimia offers circuit breaker and fused subpanels and can provide help in determining wire size and protection.

Don't forget to properly ground your control panel. Grounding is required for your protection and can save your life. There will be either a terminal block provided for ground wire connection OR a loose wire may be provided for grounding to your input power with a wire nut or crimp connector.

If you are unsure about the installation please consult a professional electrician.

We are also available for support. Call 256-528-7120 during regular business hours and we can help with your concerns. If we are unavailable or after hours please call 256-490-0388.

## Phase converter operation:

Elimia converters now use a single "start/stop" switch for operation. The switch is located on the front cover and incorporates a LED run indicator light as well. Before you test your converter you should double check all added wiring and connections. Inspect the on-board connections and verify nothing shook loose during shipping. Make sure components are still firmly mounted and secure and that they're no wire unconnected. Don't forget to provide an adequate ground and connection.

### Dual Motor Converters:

For dual motor converters unit #1 or motor #1 is the primary motor. There will be two sets of start/stop switches on dual motor units. Dual motor converters can be operated with either motor #1 active OR with both motor #1 AND motor #2 active. Do not attempt to operate only motor #2. When running in dual mode (both motors running) wait 3 seconds before powering up motor #2. Always power motor #1 prior to activating motor #2. When powering down dual units, always power #2 down prior to motor #1.

### Wireless Remote Control Units:

Converters equipped with optional wireless remote starting you should first test the manual starting means. Remote control converters are equipped with two means to start and stop the converter. Once the manual start is verified you can test the wireless starting capabilities. You should be able to start and stop your converter with the remote for up to 200 feet, depending on obstacles.

### Operation:

Without the load connected, test your converter. When you push the start switch the indicator light should immediately come on and the idler motor should run. You may hear a rumble or a growl for a split second and at the end of this growl you may be able to hear a clip or clap. That is the starting circuit engaging the start capacitors

and then disengaging. The starting is done with an electronic device. The starting time is set at the factory and should not be adjusted.

Now your converter should be up and running smoothly. If your converter is a TEFC (totally enclosed fan cooled) motor you will notice mainly wind noise from the external motor cooling fan. There should be very little noise from the motor or converter box. If you hear a loud hum, rattle or continuing growl, push the stop switch immediately! Capacitors can explode and cause injury. If this condition occurs contact Elimia for service or instructions. **Never operate or power up the converter or control panel with the cover removed!**

Now that your converter is up and running let it run a few minutes. Then push the stop switch. The converter should immediately shutdown and coast to a stop. Once the shaft is stopped turning push the start switch again and power the idler back on. Repeat this several times and listen for any unusual sounds. **Do NOT start the converter until the shaft has completely stopped turning.** The starting system is designed for a 0 RPM start. With the converter off touch the motor housing. It should only be slightly warmer than ambient temperature. If the motor is so hot that you can't touch it verify that the fan on the motor is intact and turning with the motor. If no obvious problem exists consult the factory for more information. For motor types ODP (without ribbing) you may here a little rattle or squeak during operation. ODP motors have an open design and can occasionally suck up debris. Don't be alarmed, from time to time blow out the motor with air pressure. It is also possible that during manufacturing your converter picked up metal shavings while the shaft was being cut off. These small metal flakes usually work themselves out within a few minutes of operation. If the problem continues consult the factory.

Your converter has been designed for flexibility. Some converters may be equipped with a load matching system. This system allows the owner to adjust the converter panel to various load sizing and still maintain peak performance. Converters without this feature are design for optimum performance ¼ to ½ loaded. Meaning, a 5 HP converter is designed for match voltages with a medium 1 – 3 HP load. That doesn't mean you can't run a smaller or larger load it just means that the voltages your equipment will get from the converter will be slightly different referencing L1/L2/L3. The difference will not be enough to affect operation of most equipment but the difference could affect some voltage sensitive equipment such as CNC drives.

To determine the voltage balance of your machine you should take voltage readings between the phase legs.

Example of typical readings are as follows:

L1 to L2 should be within a few tenths of a volt of nominal input power.

Nominal input on 240V connections= 235 VAC

L1 – L2 = 235 VAC

L2 – L3 = 240 VAC

L1 – L3 = 245 VAC

Please note that actual readings will vary...

If you measure the three phase voltages reference to ground the typical readings are as follows:

L1 – Ground = 115 VAC

L2 – Ground = 115 VAC

L3 – Ground = 225 VAC

**The L3 line is the generated phase and should never be used for 120 VAC power. If your equipment has any electronics or 120 VAC loads you should verify from where the machine gets the 120 VAC power. Only use L1 or L2 for 120 VAC loads!**

Once your machine is wired to the factory supplied fuse block or connections it is time to verify operation. **The converter should ALWAYS be started prior to your machine being started.** If your converter is started under load (your machine already on) it could burn out a relay and or damage the start capacitor(s). We will not replace equipment/parts that exhibit this damage. Also, always kill power to your machine prior to the converter being switched off. Not doing so can damage the converter or blow fuses.

Now that you have verified your converter is running correctly you can power up your 3 phase equipment (machine). With the converter running, power-up your 3 phase machine. Your equipment should sound normal, there should not be any extra humming or growling from your machines motor. If your machine failed to start and only hums, first verify your wiring. Make sure that all three wires are connected to L1/L2/L3 appropriately. Next, verify your machines motor ratings and voltages. Make sure your machine’s motor is not wired for 440 VAC operation. Consult factory for more information. If your equipment’s motor is turning backwards you will need to inspect your wiring and reverse any two connections on L1/L2/L3 or the take off point from your converter.

With your machine running normal operate it as usual. As long as the converter is not overloaded you will not notice the converter change in sound or motor speed. You may be able to notice that the converter runs slightly quieter with your machine on. This is normal. The converter should run quieter when the optimum load (your machine) is on. This is because the capacitance is balanced for a load.

Please note: Elimia Industrial is not responsible for any damages contributed from misapplication of its products. It is your responsibility to verify our products meet the specifications for your equipment and application.

### Troubleshooting:

Condition	Resolution
Phase Converter Idler Motor Did Not Start	<p>Check the obvious first: main power circuit breaker on; neutral connected etc...</p> <ol style="list-style-type: none"> <li>1) When you pushed the start switch did you hear any clicking inside the control panel? You should hear a clap and then within 1 second you hear another click or clap. If not do the following: Verify with a voltmeter that you have main power on the terminal block. Measure between the two connections labeled 240V. You should read about 230 – 245 Volts. If no problem found, measure between the 120V and neutral, you should see 115 – 123 Volts. If you did not hear clicking when then start switch was pushed most likely you have one of the two powers missing.</li> <li>2) When you pushed the start switch you heard clicking and clapping but nothing else happen... The motor made no noise and did not try to start. Inspect the wiring between the idler motor and control panel.</li> <li>3) When you pushed the start switch the idler motor tried to start but did not... <b>Very important, if the idler motor tried to start and failed to come up to speed the stop switch should be pressed immediately.</b> Possible causes are: starting capacitor failure, starting module failure, starting contactor failure, open wiring in start circuit, idler motor bearing failure or idler motor winding shorted. Before doing anything else try to start the phase converter again. If it does not start immediately (within 2 seconds) press the start button. If the converter does not start within 1 second, it is not going to start. Allowing the start system to remain engaged will destroy the motor or components. Try starting the converter a couple of times as cold motors and start capacitors can affect starting. If the phase converter still failed to start check the following: Incoming voltage is present and good; Idler motor shaft turns easily. With main power switched off, check the contactors for continuity. L1 – T1, L2 – T2 and L3 T3. The contactors have a tab button in the center for manual operation testing. You should see near zero resistance, when the contactor is manually pushed, across the contacts and open circuit when released. If not, contact the factory.</li> </ol>

	Next, visual inspect the start capacitors (black round), if they smell or have smoked residue around the top, consult factory.
Phase Converter Starts and Runs but 3 Phase Machine will not Start	<p>Check the obvious first: machine is set up for 480 Volt operation; machine is too large for phase converter...</p> <ol style="list-style-type: none"> <li>1) Typically, your phase converter idler motor HP should be 1.25% larger than your 3 phase load in HP or KW ratings. For some loads it may need to be 200% larger. Other factors should also be considered like: wire run distance; 3 phase load starting time; motor load RPMs etc... Voltage drop in wiring is one aspect that can be reduced. Always use wire of proper AWG size for your loads. Voltage drop in wiring is not usually noticeable until the 3 phase load is applied.</li> <li>2) If your 3 phase load did try to start and no other obvious solution exist check the wiring in the motor starter. If your motor starter uses direct 240V power for the contactor coil voltage you will need to verify the wiring. The L3 phase from Elimia converters is the generated phase. L3 should not be used for ANY 120V single phase loads AND should NOT be used for any 240V single phase loads in the machine starting circuit. It is now common in Asian produced machinery that they use L1 and L3 for the 240V contactor coil control voltage. If your 3 phase machine utilizes L3 you should move that connection to L2. This issue is very common especially if your equipment load is near the phase converter's capacity. If your machine's motor starter clicked and clapped while trying to start verify the coil voltage wiring in the motor starter. Consult factory for help if needed.</li> </ol>
My 3 phase load runs but is turning in reverse	<ol style="list-style-type: none"> <li>1) Likely, at least two of your three wire connections between your phase converter and load are swapped. Three phase motors can be reversed by swapping two connections of L1, L2 and L3. You should always verify the L1, L2 and L3 are connected correctly to avoid sending single phase power to electronic loads buried in your machine's wiring.</li> </ol>
My Start and Stop Switches have Reversed Functions	<ol style="list-style-type: none"> <li>1) The start stop switch has been reconnected upside down. Slide the red tab on the back of the switch connector, rotate 180 degrees and reconnect.</li> </ol>

### Things to remember:

Never operate or power the converter with the cover off

Do not engage the converter with a load (your equipment) already on

Never disengage the converter with a load left on

Never run the converter without proper fusing

Do not leave the converter running unattended

Do not reengage the converter until the converter motor has stopped turning

Do not use the L3 wiring for 120 Volt loads

*Please consult the factory if additional instructions are needed.*

*The design of this system is the sole property of Elimia Industrial and cannot be reproduced or copied in anyway, under penalty of law. Elimia Industrial is a licensed and insured company.*

## **Elimia Industrial**

2404 County Road 26  
Crossville, Al 35962  
256-528-7120

### ***Limited 10 year Warranty***

*Thank you for purchasing an Elimia Industrial phase converter. Elimia converters are built to last and we are confident you will receive excellent service from the converter for years to come! In the event of an unlikely system failure to any part of the converter we shall replace the failed part free of charge for up to 10 years. If a failed part cannot be identified, some or all of your system must be sent back to the factory for support. Warranty shall not cover shipping cost to or from our factory, fuses, motors and indicator lights. Additionally, Elimia Industrial shall not be liable for subsequent damages to equipment or real estate. We reserve the right to replaced part(s) with the same or compatible replacement(s). Your converter and warranty are identified by the model on the front of the control panel.*

*Again, we appreciate your business!*

*Ken Fowler, President, Elimia Industrial*

# **STOP!**

**Do not attempt to  
install your converter  
without reading this  
manual!**