



# **CONTINUOUS BELT IR BELT FURNACE**

## **TP Solar Model TPS-618 Owner's Manual**

Revision 0



MODEL: TPS-618

SERIAL NUMBER: 2016286

FACTORY ORDER NUMBER: 16-005

### **Infrared Furnace Setup, Operation, Theory & Troubleshooting Guide**

This Owner's Manual contains product information specific to the newly installed equipment and software. In addition, this manual contains information regarding features and options which may or may not be included in your furnace system.

# Continuous Belt IR Furnace

Owner's Manual

Rev. 0

Model: TPS-618

Serial Number: 2016286

Part No. 16-005 - 676-110000-01 CD

Part No. 16-005 - 676-110000-02 Loose Leaf

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## TABLE OF REVISIONS

Rev	Sections	Description	Date
0	All	Initial Release	1/20/2017

## INTRODUCTION

This manual covers the TP Solar infrared high quality controlled atmosphere infrared belt furnace designed for industrial production and laboratory infrared thermal processing.

Achieving high performance and high yields is attainable with careful adjustment of the temperature and gas flow controls provided on the furnace. Infrared furnaces are highly responsive to critical temperature settings. With lamps as the primary heat source, the equipment is literally heating with the speed of light. The unique gas management system provides an extremely even distribution and well-regulated flow of gas throughout the process chambers. Understanding how to control both the heat and gas flow is essential to the effective operation of the furnace. When the interaction and performance of the control elements are well managed the tool can achieve its potential. For many, our furnaces become regarded more than just an effective tool; they are viewed as a fine instrument that can produce results over a variety of thermal processing situations.

There are many features in your equipment to help assure your success in achieving your goals. Many “firsts” involving the application of near infrared heating include: the first high temperature furnace capable of operating at 1000°C with extremely tight temperature control; the first thick film furnace; the first controlled atmosphere furnace capable of <5 ppm O<sub>2</sub>; and the first hydrogen furnace.

## WHAT IS IN THIS MANUAL

This manual explains furnace equipment installation and setup, operation and troubleshooting of the TP Solar TPS-618 model IR furnace. Some equipment described in this manual is optional or may not apply to your model as configured. The manual also covers aspects of infrared processing theory and techniques to assist you in achieving highly repeatable and reliable thermal processes.

Study this manual carefully. Experience has shown that clients who thoughtfully master the contents of this manual can become expert in understanding the process system capabilities of our infrared furnaces. In doing so, many are able to push the initial process performance envelope and thus achieve higher degrees in both process reliability and throughput than previously anticipated.

*Note that throughout this Owner’s Manual the equipment is generally referred to as a furnace. A dryer is a furnace with only the top lamp elements installed or operated.*

## FORMATTING CONVENTIONS

This manual uses the following formatting conventions.



**DANGER: This signifies a potential threat to human safety.**

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**Warning: This signifies a potential threat to equipment damage or product loss.**

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Note: This signifies an important fact that could affect process control.

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*Examples are shown in italic text.*

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**Bold** text words or phrases embedded in this document, are terms with definitions in the glossary.

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**Underlined** text is used for pop-up windows, button descriptions & selector button/box choices.

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Cross-references to “Section Titles” are bound with quotes.

---

(Optional ) accessories will be shown in parenthesis with a checkbox. If supplied, please check the box as appropriate.

## ABOUT LCI

LCI Furnaces specializes in the application and sales of high quality near infrared (0.5-5.5  $\mu\text{m}$ ) wavelength continuous belt dryers, ovens and furnaces worldwide. If needed, LCI can aid in the selection new equipment and features or rebuild of an existing furnace to meet the special and challenging needs our partners require. Should you have a furnace operating question, contact LCI Furnaces or FurnacePros Technical Support. LCI furnaces represents TP Solar for new furnace equipment sales.

### LCI Websites

New Furnaces: [www.LCIfurnaces.com](http://www.LCIfurnaces.com)  
Rebuilt RTC Furnace Support: [www.FurnacePros.com](http://www.FurnacePros.com)

### Contact:

Phone: (714) 935-0302  
e-mail: [Info@LCIfurnaces.com](mailto:Info@LCIfurnaces.com)

## ABOUT TP Solar

TP Solar, Inc. was founded by furnace experts who pioneered IR furnaces and set the industry standards for the PV industry in the early 1980s. TP Solar is committed to delivering the greatest total value to make its customers more productive, more competitive and more profitable. They accomplish this goal by having the most technically talented product application people, the most customer focused support personnel, and by continuously improving our business processes. For questions about the furnace described in this manual, contact TP Solar or your sales representative.

## WHERE TO GET HELP

### TP Solar Corporate Offices & Factory

Address: 16310 Downey Avenue, Paramount, CA 90723 USA  
Phone: (562) 808-2171  
Fax: (562) 529-2483

### TP Solar Technical Support, Parts & Service

Department: Aftermarket  
Phone: (562) 808-2171  
e-mail: [sales@tpsolar.com](mailto:sales@tpsolar.com)

### Website

Furnace Equipment: [www.TPSolar.com](http://www.TPSolar.com)

## EQUIPMENT LIST

Verify that the following equipment was received.

Qty	Unit	Description	Part Number
(1)	ea	TPS-618 Furnace	16-005-TPS-618
(1)	ea	Belt, High Temp, Balanced Weave (Heavy Duty)	Nichrome-V

In addition verify that you received the following, shipped separately.

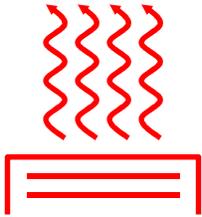
Qty	Unit	Description	Part Number
(1)	ea	Manual, Owner's, 3-Ring Bound	16-005-676-110000-02
(1)	ea	CD Media, Owner's Manual, P/N 16-005-676-110000-01	16-005-676-110000-01
(1)	set	CD Media, TPSI Furnace software, backup	
(1)	ea	CD Media, Reinstallation, Windows operating system	
(1)	set	CD, Drivers and Utilities	

## GENERAL SAFETY GUIDELINES

The following set of guidelines is intended to create awareness of potential health and safety hazards.

### Normal Good Laboratory Practice

Normal good laboratory practices apply to the operation of IR furnaces. Do not use the space above the furnace as storage. Do not block the cabinet doors preventing the cooling of the electronic equipment inside. Do not operate with side covers off as this will prevent normal cooling of the electronic equipment thus voiding the warranty. Tuck electrical cords out of the way. Do not store flammables in the vicinity of the furnace and especially while operating the furnace with an oxygen atmosphere.



**HIGH TEMPERATURES.** In general, the operation of any furnace may expose operators or maintenance technicians to the risk of burns. After being processed in an infrared furnace, customer product may still be dangerous to handle. Each owner is responsible for providing a safe work environment and proper training in the handling of material being processed in a furnace.



**ELECTRICAL SHOCK HAZARD.** IR furnaces operate at high voltages. Operation with side covers off constitutes a safety hazard. Ensure that main power is off while side covers are removed.

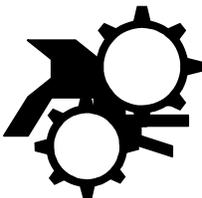
Electrical shock hazards exist for those technicians who service the furnace. High voltages are required to operate the furnace and precautions must be taken to reduce the exposure to these elements. Again, it is the responsibility of the furnace owner to assure that only properly trained service technicians, familiar with high voltage operations be allowed to service the equipment



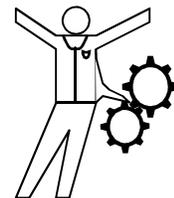
**EXPLOSION** Explosive dangers may exist in the high temperature process environment of the furnace. If the furnace operates with process gas containing hydrogen, measures must be taken to avoid the dangers of explosion. Furthermore, improper gas flow balance may draw oxygen rich air into the furnace, mixing with effluent gases and material from products, also creating a hazardous environment.



**HAZARDOUS MATERIALS.** Persons performing maintenance tasks such as replacement of lamps may become exposed to silica fiber compounds. Such tasks should be performed by qualified persons wearing gloves, eye protection and a facemask to prevent inhalation of particulates.



**ROTATING EQUIPMENT.** Roller dangers exist when working around the conveyor belt of the furnace. Care should be taken not to place hands or garments on or near the belt drive mechanisms when the conveyor system is operating as roller crush may occur. Operators should avoid walking near the open ends of the conveyor belt. Those who must be near the moving parts should wear close fitting clothing.



## SAFETY EQUIPMENT

### EMO Buttons



Each infrared furnace is fitted with at least four SEMI S2 compliant Emergency Stop or Emergency Machine Off buttons (EMO's), two located at each end of the furnace. Each Emergency Machine Off button is attached directly to a switch that automatically shuts down all furnace electrical systems. In many cases, process gas flow will remain on after power is shut off.

Locate and insure their proper function prior to regular furnace operation.

### High Voltage Protection

The furnace is equipped with a three-phase disconnect switch located on the rear side near the furnace entrance. The 3-phase disconnect switch must be in the OFF position before the panel can be removed for service access.

The furnace is equipped with electrical drawers that are secured by drawer locks to discourage operation of the furnace with high voltage exposed to operators. Within the drawers, clear plastic (Lexan™) shields further isolate individuals from exposure to electrical equipment where dangerous voltages are present. Each of the drawers located on the front of the furnace closest to the furnace entrance is safeguarded by lock to limit access to the high voltage areas.

Removal of top access covers requires a tool (removal of 2 screws per panel). When a top cover is removed near the furnace heating chamber, the user may be exposed to hot surfaces, but the electrical lamp terminals containing high voltage are enclosed by an inside cover. Further in order to access lamps and lamp wires, the plenum covers must be removed. The furnace should be disconnected from its power source before the furnace sections with lamps are accessed by maintenance or testing personnel.



**DANGER: Removing access panels or unlocking and opening the drawers while the furnace is operating increases maintenance personnel exposure to electrical hazards. The user must ensure that all drawers are closed and locked before the furnace is returned to normal operation following any inspection or adjustment.**

### Other Protection

In the cooling section of the furnace, fan guards provide protection from rotating parts. Line voltage 120 Vac electricals are protected by insulated wire. Service and maintenance should exercise caution when accessing this section of the furnace while the furnace is connected to its power source.

### Safety with Forming Gas, FG (Nitrogen/Hydrogen Premix)

The three-gas, dual mode option provides for separate manifolds to allow users to select one or two of three connected gases for the process gas at the same time. Use of Forming gas (FG) is generally safe provided the concentration of hydrogen in the mixture is lower than the lower flammable limit of hydrogen. Hydrogen is flammable in concentrations of 4-74% in air; explosive range is 18-59% in air. Dual and Tri-gas furnaces are equipped with an audible alarm to indicate low nitrogen and/or forming gas supply pressure.



**DANGER: Combustible gas should NOT be connected to this furnace. Forming gas or other gas mixtures which have a combustible gas component can be safely introduced into furnace provided the delivered concentration is below its lower flammable limit (LFL) in air.**

# LIMITED WARRANTY

BUYER: <u>GE Fuel Cells LLC</u>	PROJECT: <u>16-005</u>
PRODUCT: <u>TF-618 IR Furnace</u>	SHIPMENT DATE: <u>11/22/2016</u>
SERIAL NUMBER: <u>2016268</u>	STARTUP DATE: <u>01/19/2017</u>

EQUIPMENT	WARRANTY PERIOD
✓ IR Continuous Belt Furnaces & Dryers	Checkout/Startup by Seller: Twelve (12) months from date of initial startup, in no event exceeding fifteen (15) months from date of shipment.
Refurbished Equipment, Cooling systems & Controls Upgrades	Checkout/Statup by others: Twelve (12) months from date of shipment. Furnace Warranty Expires: <b>01/20/2018</b> .
✓ Aftermarket Parts & Consumables	Sixty (60) days from date of shipment.

**TP Solar, INC. (SELLER) warrants that during the Warranty Period the original SELLER supplied Equipment shall conform to its specifications and be free from defects in material and workmanship. This warranty is only applicable to the original system and components under normal use and service, and excludes damage due to misuse, chemical attack, wear and tear from abrasion or corrosion. Consumables such as filters, fuses, lamps, and thermocouples shall be expressly excluded from this warranty, except to the extent SELLER is notified a failure of any consumable item within the first 60 days from shipment of the furnace from SELLER.**

During the Warranty Period SELLER will at its option, repair or replace the defective part provided (1) BUYER promptly notifies SELLER of any claimed defect, (2) BUYER receives return authorization and returns the product to SELLER for inspection, and (3) the Product is determined by SELLER to be defective and the remedy the responsibility of SELLER. Minor deviations from the specifications shall not constitute defects or non-conformance.

No parts shall be received by SELLER without SELLER prior written authorization. If SELLER determines that the warranty does not apply, BUYER will be responsible for any repair or replacement costs and all associated freight charges.

BUYER shall bear the cost of return of any materials, components and equipment to SELLER. SELLER shall bear the cost of non-expedited shipping to BUYER of parts and materials replaced under this warranty. When a SELLER representative visits BUYER's facility for warranty work, BUYER shall only reimburse related normal and customary travel and lodging expenses.

Unless otherwise specifically authorized in advance, payment of charges incurred by others shall not be borne by SELLER. In any event, approved charges shall be limited to the cost SELLER would have reasonably incurred had the equipment been returned to its plant for correction. SELLER will not accept any back charges for field corrections made without its prior written approval and instructions.

These warranties will not apply if the equipment or any components thereof have been subject to:

- (1) operation, maintenance, overhaul, installation, storage or use which is improper or not in accordance with SELLER's instructions;
- (2) any alteration modification, or repair by anyone other than SELLER or its authorized representative;
- (3) any accident, misuse, neglect, or negligence after shipment; or
- (4) damage due to uncontrollable external events or acts of God.

SELLER's LIABILITY IS LIMITED TO THE REPAIR OR REPLACEMENT OF THE EQUIPMENT FOUND TO BE DEFECTIVE AT SUCH LOCATION AS MAY BE DETERMINED IN THE SOLE DISCRETION OF SELLER. ALL WORK UNDER THIS WARRANTY SHALL BE PERFORMED DURING NORMAL WORKING HOURS. ALL REPLACEMENT PARTS, WHETHER NEW OR REMANUFACTURED, ASSUME AS THEIR WARRANTY PERIOD ONLY THE REMAINING TIME PERIOD OF THIS WARRANTY.

All payments must be made according to the agreement terms to activate this warranty. Warranties will commence for the remainder of the original Warranty Period upon late receipt of any balance due SELLER.

**LIMITATION OF LIABILITY.** In no event will SELLER's liability to BUYER for any and all claims, including property damage and personal injury claims, allegedly resulting from breach of contract, tort, or any other theory of liability exceed the amount of the contract purchase price paid to SELLER. THE EXPRESS WARRANTIES MADE HEREIN ARE EXCLUSIVE AND ALL OTHER WARRANTIES, EXPRESS, STATUTORY OR IMPLIED, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE DISCLAIMED. IN NO EVENT SHALL TP SOLAR, INC BE LIABLE FOR ANY CONSEQUENTIAL DAMAGES (SUCH AS SPECIAL OR INDIRECT) NOR FOR ANY LOSS OF PRODUCTION OR OTHER LOSSES arising out of, resulting from, or in any way connected with its work, the performance of the Equipment, any failure of the Equipment or any breach of the agreement.



# CONTENTS

<b>INTRODUCTION</b>	<b>iii</b>
<b>ABOUT LCI</b>	<b>iv</b>
<b>Contact:</b>	<b>iv</b>
<b>ABOUT TP Solar</b>	<b>iv</b>
<b>EQUIPMENT LIST</b>	<b>iv</b>
<b>GENERAL SAFETY GUIDELINES</b>	<b>v</b>
<b>WARRANTY</b>	<b>vii</b>
<b>CONTENTS</b>	<b>ix</b>
<b>Section 1</b>	<b>1</b>
<b>FURNACE EQUIPMENT</b>	<b>1</b>
1.1 Furnace Description	1
1.2 Furnace Views	2
1.3 Furnace Elements	4
1.4 Control System	9
1.5 Auxiliary Equipment	12
1.6 Optional Equipment	15
<b>Section 2</b>	<b>2-1</b>
<b>INSTALLATION</b>	<b>2-1</b>
2.1 Unpacking the Equipment	2-1
2.2 Location & Initial Installation Work	2-1
2.3 Providing Power	2-7
2.4 Providing Process Gas	2-12
2.5 Exhaust Requirements	2-14
2.6 Water and Drain Connections	2-16
2.7 Emergency Machine Off (EMO)	2-17
2.8 Interlocks	2-17
<b>Section 3</b>	<b>3-1</b>
<b>EQUIPMENT OPERATION</b>	<b>3-1</b>
3.1 Power Controls and Indicators	3-1
3.2 Software – Main screens	3-6
3.3 Starting the Furnace	3-16
3.4 Normal Furnace Operation	3-18
3.5 Furnace Shut Down	3-19
3.6 Modifying Control Strategies	3-23

3.7 PID Zone Tuning	3-33
3.8 Real-time and Historical Trends	3-34
3.9 Alarm Status (All Access Levels)	3-37
3.10 Element Monitoring System	3-39
3.11 Over Temperature Alarm	3-40
3.12 View Alternate Programs	3-40
3.13 Exit Program in Windows	3-40

<b>Section 4</b>	<b>4-1</b>
<b>SERVICE &amp; MAINTENANCE</b>	<b>4-1</b>

4.1 Service and Maintenance Access	4-1
4.2 Electrical Panels	4-5
4.3 Routine Maintenance	4-9
4.4 Other Preventive Maintenance	4-9
4.5 TROUBLESHOOTING	4-16
4.6 Controller Troubleshooting	4-22
4.7 Computer Troubleshooting	4-30
4.8 Element Failure Indication	4-36
4.9 Troubleshooting Process Problems	4-39
4.10 SERVICE	4-41
4.11 Control System Installation and Setup	4-49
4.12 Calibration	4-53
4.13 Over Temperature Alarm Setpoints	4-56
4.14 Remote Access	4-58

<b>Section 5</b>	<b>5-1</b>
<b>SPECIFICATIONS</b>	<b>5-1</b>

5.1 Equipment Specifications	5-3
5.2 Serial Nameplate	5-6
5.3 Power & Current	5-7
5.4 Oxygen Analyzer Setup	5-8
5.5 Oxygen Analyzer Specifications	5-9
5.6 Oxygen Analyzer Certification	5-12
5.7 I/O Channel Assignments	5-13
5.8 IR Sintering System Requirements	5-14

<b>Section 6</b>	<b>6-1</b>
<b>DRAWINGS &amp; SCHEMATICS</b>	<b>6-1</b>

6.1 Furnace Arrangement	6-3
6.2 Chamber Arrangement	6-5

# Contents

---

6.3	Supply Gas Switching .....	6-7
6.4	Oxygen Sampling System .....	6-9
6.5	Safety Enclosure.....	6-11
6.6	Frame Wiring.....	6-13
6.7	Element Wiring .....	6-15
6.8	Edge Heat.....	6-17

## Section 7 **7-1**

### **MSDS** **7-1**

7.1	M0090 Fiberfrax® QF Cements .....	7-2
7.2	M0042 Fiberfrax® Duraboard® .....	7-8
7.3	M0001 Fiberfrax® Refractory Ceramic Fiber	7-14
7.4	M0055 Fiberfrax® High Purity Papers .....	7-20
7.5	Kaowool® Insulation MSDS 203 .....	7-26
7.6	MSDS 0732 RTV Silicone 732 .....	7-31
7.7	MSDS MagnaForm Boards .....	7-33

## Section 8 **8-1**

### **PROCESS ENGINEERING** **8-1**

8.1	IR Furnace Process .....	8-1
8.2	Furnace Construction.....	8-3
8.3	Heating Chamber Design .....	8-4
8.4	PID Tuning Concepts .....	8-6
8.5	Gas Flow .....	8-8

## Section 9 **9-1**

### **THERMAL PROCESSING THEORY** **9-1**

9.1	Infrared Waves.....	9-1
9.2	Infrared Heating.....	9-2
9.3	Thermal Process.....	9-3
9.4	Temperature Profiling.....	9-3

## Section 10 **10-1**

### **APPENDIX** **10-1**

10.1	EC900 Oxygen Analyzer .....	10-3
10.2	SMEMA Standard .....	10-3
10.3	TEC 876 Uninterruptible Power Supply ....	10-3
10.4	Glossary.....	10-1

## FIGURES

Figure 1-1 TF-618 IR Furnace Front Elevation .....	1	Figure 1-37 Screen showing Product Tracking settings.....	22
Figure 1-2 TF-618 IR Furnace Rear Elevation from Entrance .....	2	Figure 1-38 Sample Port Chamber Penetration...	24
Figure 1-3 TF-618 Entrance Elevation .....	2	Figure 2-1 Name Plate .....	2-1
Figure 1-4 Exit View .....	2	Figure 2-2 Shipping Brackets.....	2-2
Figure 1-5 Front, Panels Off.....	3	Figure 2-3 Leveling Feet .....	2-3
Figure 1-6 Rear, Panels Off .....	3	Figure 2-4 Foot and Wheel.....	2-3
Figure 1-7 Process Sections .....	4	Figure 2-5 Location of Support Brackets.....	2-3
Figure 1-8 4-Zone TF Furnace Internals.....	5	Figure 2-6 Chamber Support Brackets .....	2-3
Figure 1-9 Water Flowmeters.....	7	Figure 2-7 Belt Path .....	2-4
Figure 1-10 Cooling Controls .....	7	Figure 2-8 Belt Orientation .....	2-4
Figure 1-11 Furnace Computer.....	9	Figure 2-9 Belt Splice .....	2-4
Figure 1-12 PLC Rack.....	9	Figure 2-10 Lower Access Panel .....	2-5
Figure 1-13 PLC Drawer .....	9	Figure 2-11 Belt Weight in guide with packing...	2-5
Figure 1-14 PAC-S1 Controller .....	10	Figure 2-12 Belt Weight in Place.....	2-5
Figure 1-15 PAC-EB2 I/O Brain .....	10	Figure 2-13 Proper Alignment of Belt Weight in guide .....	2-5
Figure 1-16 Ethernet Switch (R) and Controller (L)	10	Figure 2-14 Belt weight in Tank on UCD system	2-6
Figure 1-17 Furnace network .....	11	Figure 2-15 Standard Front Entry Power Port and Elapsed Time Meter.....	2-7
Figure 1-18 Pressure Switch.....	12	Figure 2-16 Typical safety interlock disconnect switch location (option) .....	2-7
Figure 1-19 Direction of Belt Travel .....	12	Figure 2-17 Elapsed Time Meter and Nameplate	2-7
Figure 1-20 Transport Drive Motor.....	13	Figure 2-18 Circuit breaker top mounted enclosure location (option not included).....	2-7
Figure 1-21 Factory UPS .....	13	Figure 2-19 Circuit Breaker panel .....	2-8
Figure 1-22 UPS, Rear View .....	13	Figure 2-20 Circuit breaker.....	2-8
Figure 1-23 3-Phase Circuit Breaker.....	15	Figure 2-21 Interlock Disconnect switch .....	2-8
Figure 1-24 3-Phase Circuit Breaker-Panel OFF..	15	Figure 2-22 Interlock disconnect switch enclosure	2-8
Figure 1-25 LA-309 Unload station with 600.....	16	Figure 2-23 Enclosure, .....	2-8
Figure 1-26 CDA - Single Gas mode .....	17	Figure 2-24 Disconnect switch .....	2-8
Figure 1-27 N <sub>2</sub> – Single Gas mode .....	17	Figure 2-25 Ethernet and USB Ports (Entrance)	2-9
Figure 1-28 N <sub>2</sub> /FG - Dual Gas mode.....	17	Figure 2-26 Factory Standard UPS.....	2-10
Figure 1-29 Light Tower .....	18	Figure 2-27 N <sub>2</sub> , CDA Connection .....	2-13
Figure 1-30 MM510 Moisture Analyzer .....	18	Figure 2-28 H <sub>2</sub> & N <sub>2</sub> Connections .....	2-13
Figure 1-31 EC913 Oxygen analyzer.....	19	Figure 2-29 Supply Gas Mixing System.....	2-13
Figure 1-32 Oxygen analyzer next to OSS sample system.....	19	Figure 2-30 Exhaust Connection.....	2-14
Figure 1-33 O <sub>2</sub> ppmv and popup on Process screen .....	20	Figure 2-31 Exhaust Connection Detail .....	2-14
Figure 1-34 Sampling Recipe popup .....	20	Figure 2-32 Cabinet Exhaust Example .....	2-15
Figure 1-35 SHEMA Sensor .....	22	Figure 2-33 Cabinet Exhaust Examples.....	2-15
Figure 1-36 SHEMA Sensor .....	22	Figure 2-34 Typical Hydrogen Furnace Process Gas Exhaust Connection .....	2-15

# Contents

---

Figure 2-35 UCD Water Connections .....	2-16	Figure 3-37 Recipe N <sub>2</sub> Purge Editor .....	3-29
Figure 2-36 CAWC Water Supply .....	2-16	Figure 3-38 Recipe O <sub>2</sub> Sampling System Editor popup screen .....	3-29
Figure 2-37 EMO buttons at Entrance .....	2-17	Figure 3-39 Recipe Description & Zone Select	3-30
Figure 2-38 Front Interlock switch location .....	2-17	Figure 3-40 Recipe Zone Editor .....	3-30
Figure 3-1 Control Console keyboard & monitor	3-1	Figure 3-41 Recipe PID Editor .....	3-31
Figure 3-2 Control Console Furnace Power ON and OFF & Indicator Lights .....	3-1	Figure 3-42 Zone Character pop-up .....	3-31
Figure 3-3 Power Buttons .....	3-1	Figure 3-43 Recipe Top Bottom Power editor ..	3-31
Figure 3-4 Screen Menu bar .....	3-6	Figure 3-44 Gas Flow flow meter setpoint .....	3-32
Figure 3-5 Top Status bar .....	3-6	Figure 3-45 Gas Flow Screen .....	3-32
Figure 3-6 Log-On screen .....	3-8	Figure 3-46 Service Screen: Zone Tuning .....	3-33
Figure 3-7 Process screen .....	3-10	Figure 3-47 Service screen: Zone Tuning .....	3-33
Figure 3-8 Zone Temperature display .....	3-10	Figure 3-48 Trends graph .....	3-34
Figure 3-9 Zone Temperature setpoint .....	3-10	Figure 3-49 Trends Menu bar .....	3-35
Figure 3-10 Zone Temperature display .....	3-11	Figure 3-50 Change Vertical Scale .....	3-36
Figure 3-11 Belt Speed display .....	3-11	Figure 3-51 Load Historical Trend Data .....	3-36
Figure 3-12 Recipe Editing box .....	3-12	Figure 3-52 Alarm pop up screen .....	3-37
Figure 3-13 Get Recipe from Recipe screen .....	3-12	Figure 3-53 IPS Inlet Pressure Switch .....	3-38
Figure 3-14 Recipe Gas Flow Screen .....	3-13	Figure 3-54 Element Monitor screen .....	3-39
Figure 3-15 Service screen .....	3-14	Figure 3-55 EM Serial Test screen .....	3-39
Figure 3-16 Lamps screen .....	3-15	Figure 4-1 Front Access Panels .....	4-1
Figure 3-17 I/O Status pop-up .....	3-15	Figure 4-2 Front Access .....	4-1
Figure 3-18 Trends screen .....	3-15	Figure 4-3 Rear Access .....	4-2
Figure 3-19 Recipe Editing box .....	3-17	Figure 4-4 Rear Access Panels Off .....	4-2
Figure 3-20 Get Recipe from Recipe screen .....	3-17	Figure 4-5 Lower Access Panel Removal .....	4-3
Figure 3-21 Select Warmup .....	3-18	Figure 4-6 Lower Access Panel Installation .....	4-3
Figure 3-22 In Warmup .....	3-18	Figure 4-7 Hanging Lower Access Panel .....	4-4
Figure 3-23 Process Ready .....	3-18	Figure 4-8 Hanging Lower Access Panel .....	4-4
Figure 3-24 Process screen .....	3-23	Figure 4-9 Top Panel In Place .....	4-4
Figure 3-25 Zone Temperature & Power setpoints	3-23	Figure 4-10 Front with Access Panels removed	4-6
Figure 3-26 Zone Temperature & Power fields	3-24	Figure 4-11 Rear with Access Panels removed	4-6
Figure 3-27 Belt Speed fields .....	3-24	Figure 4-12 Entrance Panels .....	4-6
Figure 3-28 Edge Heater setpoints .....	3-24	Figure 4-13 Exit Enclosure Access Panels .....	4-6
Figure 3-29 N <sub>2</sub> Pre-Purge setpoint .....	3-24	Figure 4-14 Power Distribution and Safety panels	4-7
Figure 3-30 O <sub>2</sub> Sampling display and Port Select	3-25	Figure 4-15 MCC / UCD panel .....	4-7
Figure 3-31 O <sub>2</sub> Sampling display and Port Select	3-25	Figure 4-16 Motor and drive gears .....	4-8
Figure 3-32 UCD System pop-up .....	3-26	Figure 4-17 Computer and UPS (L) PLC panel (R)	4-8
Figure 3-33 UCD Cool Down .....	3-27	Figure 4-18 SCR panel .....	4-8
Figure 3-34 Recipe Editing box .....	3-28	Figure 4-19 Oxygen Sampling System and Analyzer .....	4-8
Figure 3-35 Recipe screen .....	3-29		
Figure 3-36 Recipe Belt Speed Editor .....	3-29		

Figure 4-20 TMF Encoder located behind Rear Unload panel.....	4-18	Figure 4-45 TCP/IP Properties.....	4-50
Figure 4-21 Oxygen Analyzer, Moisture Analyzer and OSS Sampling System .....	4-19	Figure 4-46 PAC-S1 Controller and EB2 Brain grounding .....	4-51
Figure 4-22 OSS Sampling System for Oxygen Analyzer only .....	4-20	Figure 4-47 PAC-S1 Connectors, Indicators and Pin outs .....	4-52
Figure 4-23 Sample–Purge valve on OSS panel.....	4-20	Figure 4-48 Belt Speed Calibration Diagram ..	4-54
Figure 4-24 PAC-S1 Connectors, Indicators and Pin outs.....	4-22	Figure 4-49 IPS Inlet Pressure Switch .....	4-55
Figure 4-25 EB-2 Brain LED's and Network Interfaces .....	4-26	Figure 4-50 Air Pressure sensor .....	4-55
Figure 4-26 Lamp String Failure screen .....	4-36	Figure 8-1 IR Furnace Process Sections .....	8-1
Figure 4-27 Serial Element Monitor Comm Test screen.....	4-37	Figure 8-2 Heating Chamber Construction. End view.....	8-4
Figure 4-28 Belt Installation .....	4-41	Figure 9-1 Dominant Wavelength Graph .....	9-1
Figure 4-29 Inserting the Belt Splice.....	4-42	Figure 9-2 Temperature Profile .....	9-3
Figure 4-30 Sprocket Alignment.....	4-42	Figure 9-3 Equilibrium Profile.....	9-5
Figure 4-31 Belt Tracking Adjustment Diagram.....	4-43	Figure 9-4 Non-equilibrium profile.....	9-5
Figure 4-32 Remove Front Exit side Panel .....	4-44	Figure 9-5 Temperature Profiling Apparatus.....	9-6
Figure 4-33 Front Exit Side Panel off.....	4-44	Figure 9-6 Data Logger .....	9-6
Figure 4-34 Adjust Belt Alignment.....	4-44	Figure 9-7 Brass Forging Sample With 2 thermocouples .....	9-7
Figure 4-35 Drip Tray Cleaning Diagram .....	4-45	Figure 9-8 Metal Plate Sample with Wire Sheath Type K Thermocouple .....	9-7
Figure 4-36 Air Rake Alignment Ring .....	4-45	Figure 9-9 Silicon Wafer Entering Furnace .....	9-7
Figure 4-37 SCR installed .....	4-46	Figure 9-10 Recording Setpoints .....	9-7
Figure 4-38 Lamp Replacement.....	4-47	Figure 9-11 Brass forging sample exiting furnace.....	9-8
Figure 4-39 Furnace Controller connections....	4-49	Figure 9-12 Sample plate exiting furnace .....	9-8
Figure 4-40 Network icon .....	4-50	Figure 9-13 880 °C Annealing profile .....	9-10
Figure 4-41 Open Network and Sharing Center .....	4-50	Figure 9-14 880 °C Brass Forging profile .....	9-10
Figure 4-42 Network and Sharing Center .....	4-50	Figure 9-15 250 °C Curing Profile .....	9-11
Figure 4-43 Connection Status .....	4-50	Figure 9-16 860 °C Thick Film profile.....	9-11
Figure 4-44 Connection Properties .....	4-50	Figure 9-17 860 °C Spike profile .....	9-12
		Figure 9-18 652 °C 1205 Brazing profile.....	9-12

TABLES

---

Table 1-1 Furnace Arrangement ..... 6

Table 1-2 Furnace Lamp Wiring Configuration ..... 6

Table 1-3 Gas Supply Pressure ..... 8

Table 1-4 Initial Pressure Alarm Settings ..... 12

Table 1-5 Summary of Advanced Features & Options ..... 15

Table 3-1 Main Furnace Power ..... 3-2

Table 3-2 Special Controls ..... 3-4

Table 3-3 Software – Furnace Control ..... 3-5

Table 3-4 Starting the Furnace ..... 3-16

Table 3-5 Restarting the Furnace after Auto Shut Down ..... 3-22

Table 3-6 Starting UCD System Cycles ..... 3-26

Table 3-7 UCD System Cycle Modes ..... 3-26

Table 3-8 Recipe Zone Editor Temperature Fields ..... 3-30

Table 3-9 PID Initial settings ..... 3-33

Table 3-10 Trends Menu Buttons ..... 3-35

Table 3-11 Typical Alarms ..... 3-37

Table 3-12 Initial Alarm Settings ..... 3-38

Table 4-1 Electrical Panel Location (Plan View) ..... 4-5

Table 4-2 Recommended Maintenance & Frequency ..... 4-10

Table 4-7 Element Monitor Screen ..... 4-36

Table 4-8 Element Monitor Status ..... 4-37

Table 4-9 SCR Firing Board DIP Switch Settings ..... 4-46

Table 4-10 Tools needed for replacing Lamps ..... 4-47

Table 4-12 Initial Alarm Settings ..... 4-55

Table 9-1 Equilibrium Belt Speed Recommendations ..... 9-9