



Site:

Process: Denovo RTC LA-310 405-515-720-1...

Product: Denovo 11x8 wire basket

Data Collection Details:

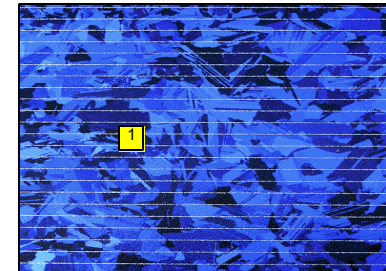
Created By: Telemetry Run
 Number of Probes: 1
 Sample Interval: 0:00.50 (mm:ss.t)
 Data Loaded: 7/15/2022 9:25:07AM
 Collection Started: 7/15/2022 9:25:07AM
 Max. Internal Temp.: 29.9 °C
 Logger: Datapaq Q18
 Logger ID: #1077
 Data Received: 100.0%
 Operator: JAMES
 Process: Denovo RTC LA-310
 405-515-720-11_0ipm
 Furnace: RTC LA-310
 Recipe: RTC 405-515-720_11_0ipm
 Product: Denovo 11x8 wire basket
 Time Printed: 7/18/2022 4:04:22PM

Notes:

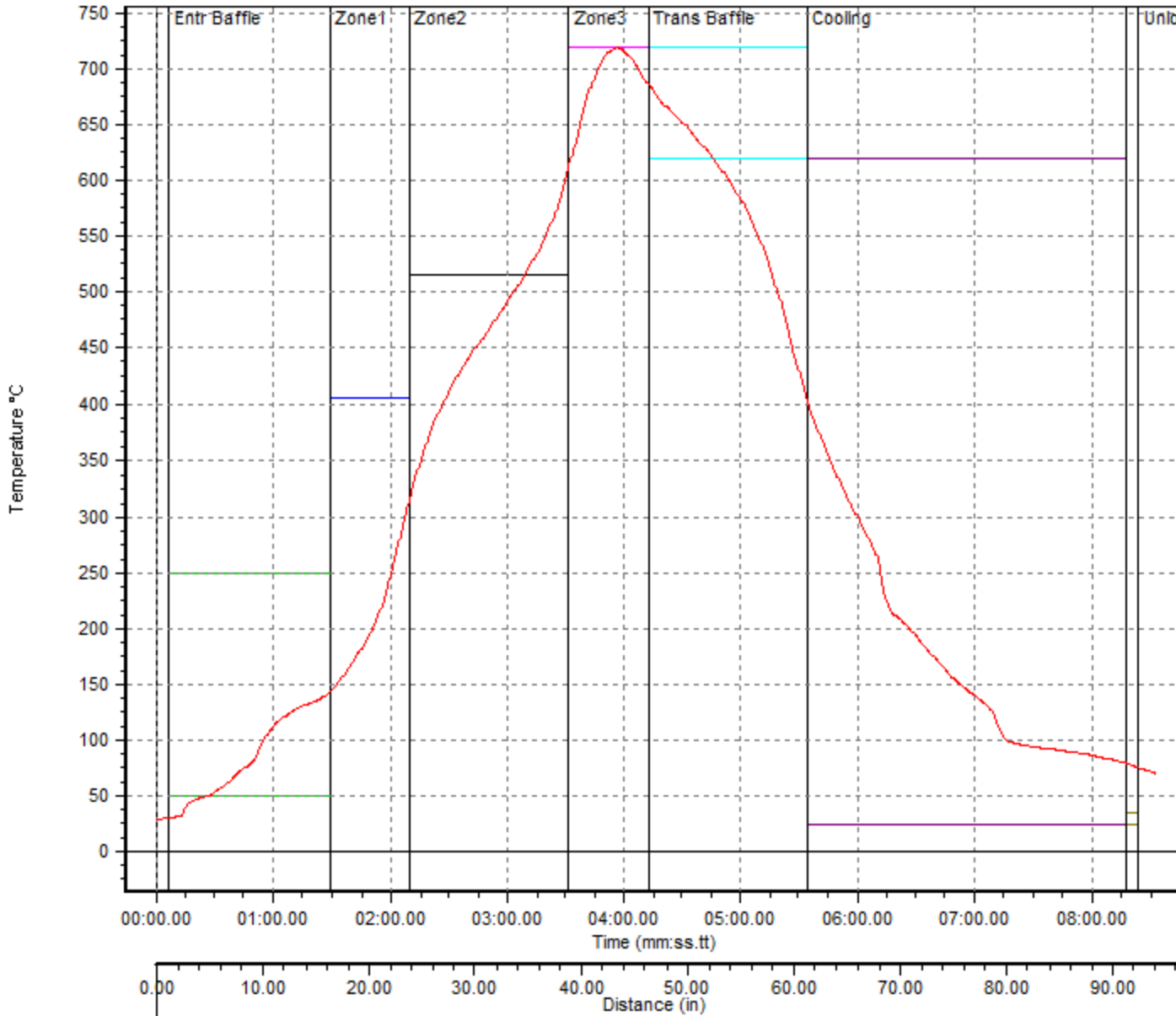
Prince & Izant BAG-7 paste
 Solidius 616C
 Liquidus 651C
 P&I Recommended Braze: 679C - 707C
 11"L x 8" W x 5/8"H

Probe Map:

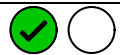
11.00x8.00 in		
#1	x	y
	7.70	4.00



Direction of travel through Furnace



Line Speed:	Zone:	Entrance	Entr Baffle	Zone1	Zone2	Zone3	Trans Baffle	Cooling	Exit	Unload
11.00 in/mir	Length (in):	1.25	15.00	7.50	15.00	7.50	15.00	30.00	1.25	15.00
	Upper (°C):	0.0	250.0	405.0	515.0	720.0	720.0	620.0	35.0	0.0
	Lower (°C):	0.0	50.0	405.0	515.0	720.0	620.0	25.0	25.0	0.0



Site:

Process: Denovo RTC LA-310 405-515-720-1...

Product: Denovo 11x8 wire basket

Probe	Maximum / Minimum				Time at Temperature					
	Maximum (°C)	Max. Reached (mm:ss.tt)	Mean (°C)	Deviation From 651.0°C	Time Above 651.0°C (mm:ss.tt)	Time To Reach 651.0°C (mm:ss.tt)	Time Above 679.0°C (mm:ss.tt)	Time To Reach 679.0°C (mm:ss.tt)	Time Above 707.0°C (mm:ss.tt)	Time To Reach 707.0°C (mm:ss.tt)
#1 (°C) Left	719.1	03:56.00	310.1	+68.1	00:53.50	03:37.50	00:33.50	03:42.50	00:16.00	03:49.00

Probe	Rise / Fall														Slopes	
	All (25.0 To 652.0°C)							(425.0 To 652.0°C)								
	Rise Time (mm:ss.tt)	Rising Slope (°C/sec)	Max Positive Slope (°C/sec)	Fall Time (mm:ss.tt)	Falling Slope (°C/sec)	Max Negative Slope (°C/sec)	Time Between (mm:ss.tt)	Rise Time (mm:ss.tt)	Rising Slope (°C/sec)	Max Positive Slope (°C/sec)	Fall Time (mm:ss.tt)	Falling Slope (°C/sec)	Max Negative Slope (°C/sec)	Time Between (mm:ss.tt)	Positive Slope (°C/sec)	Mean Slope (°C/sec)
#1 (°C) Left	***	***	***	***	***	***	***	01:03.50	3.60	6.77	01:00.00	-3.79	-6.72	02:03.50	7.15	-0.07

Probe	Peak Difference	
	Peak Difference (°C)	Time Reached (mm:ss.tt)
#1 (°C) Left	***	***

Job: 12-001 Denovo

Profile: P&I Bag 7 Paste

Model RTC LA-310

SN: 1302100102

Specification:
Ramp: 50-618 ~5 min 114C/min
Ramp: 620-704C fast
Dwell temp: >652 C for 3 min
Peak: 707-760C (707C)
Cooling: to 50C

	inches	Length	Height	Ht	Vol	Mass	
						min	max
Wire Basket	11.0	8.0	0.625	55.0 in3	7.0	10.0 oz	
TOTAL	11.0	8.0	0.625	55.0 in3	7.0 oz	10.0 g oz	

DATE: 15-Jul-22

Profile	Time	7.5 in.			15 in.		7.5 in.		Edge Heaters		FLOWMETER SETTINGS										Net flow		BELT	PROFILE RESULTS, MAX C					COMMENT
		Zone 1 deg C / % Pwr	Zone 2 deg C / % Pwr	Zone 3 deg C / % Pwr	L Edge Heat % Pwr	R Edge Heat % Pwr	ENTR STACK SCFH	ENTR BAFFLE SCFH	ZONE 1 SCFH	ZONE 2 SCFH	ZONE 3 SCFH	TRANS TUNNEL SCFH	TT STACK SCFH	Plenum SCFH	COOLING TUNNEL SCFH	Gas Usage SCFH	SPEED in/minute	Exit Z1 deg C	Exit Z2 deg C	Max Temp deg C	Time Above 651 sec	Time to Reach 651 min:sec							
2022	setpoint:	405	515	720	4.5%	4.5%	8	20	200	200	80	40	8	80	100	736	11												

7/15/2022

Run 1	09-24	405	515	720	4.5	4.5	8	20	200	200	80	5	8	80	135	-	11	316	667	719.1	53.5	3:37.5	PASS 63.5 405
Run 2																							
Run 3																							
Run 4																							
Run 5																							
Run 6																							
Run 7																							
Run 8																							
Run 9																							
Run 10																							
Run 11																							
Run 12																							
Run 13																							
Run 14																							
Run 15																							

Certified by: *Jm Clark* Date: 7/15/2022



ProControl

THERMAL PROCESS MANAGER

LCI Furnaces
LOCHABER CORNWALL, INC.
www.lcifurnaces.com

Trends

Deviation

Zone	1	2	3
Setpoint	405.0°C	515.0°C	720.0°C
Actual	402.6°C	516.3°C	720.6°C
Top Power	3.1 %	7.4 %	18.9 %
Btm Power	3.1 %	7.4 %	18.9 %

Edge Heat Power
Left 4.5 %
Right 4.5 %

Avg Pwr
9.8 %

Belt Speed
Setpoint 11.0 in/min
Actual 11.0

Cabinet 37 °C

Process

Warm Up
Process Start
Cool Down
READY

Denovo Dental
LA-310 S/N: 1303100102
F/O: 18-006
Voltage: 480 Vac 60 Hz
Version: 13.1218.180816

Recipe 08.12.19default

ALARM

ALERT

MAINT

ACK ALMS

User: Engr/Tech

Friday
07/15/2022
09:13:47

Security

Process

Recipe

Profile

Monitor

Maint.

Logging

Gas Flow



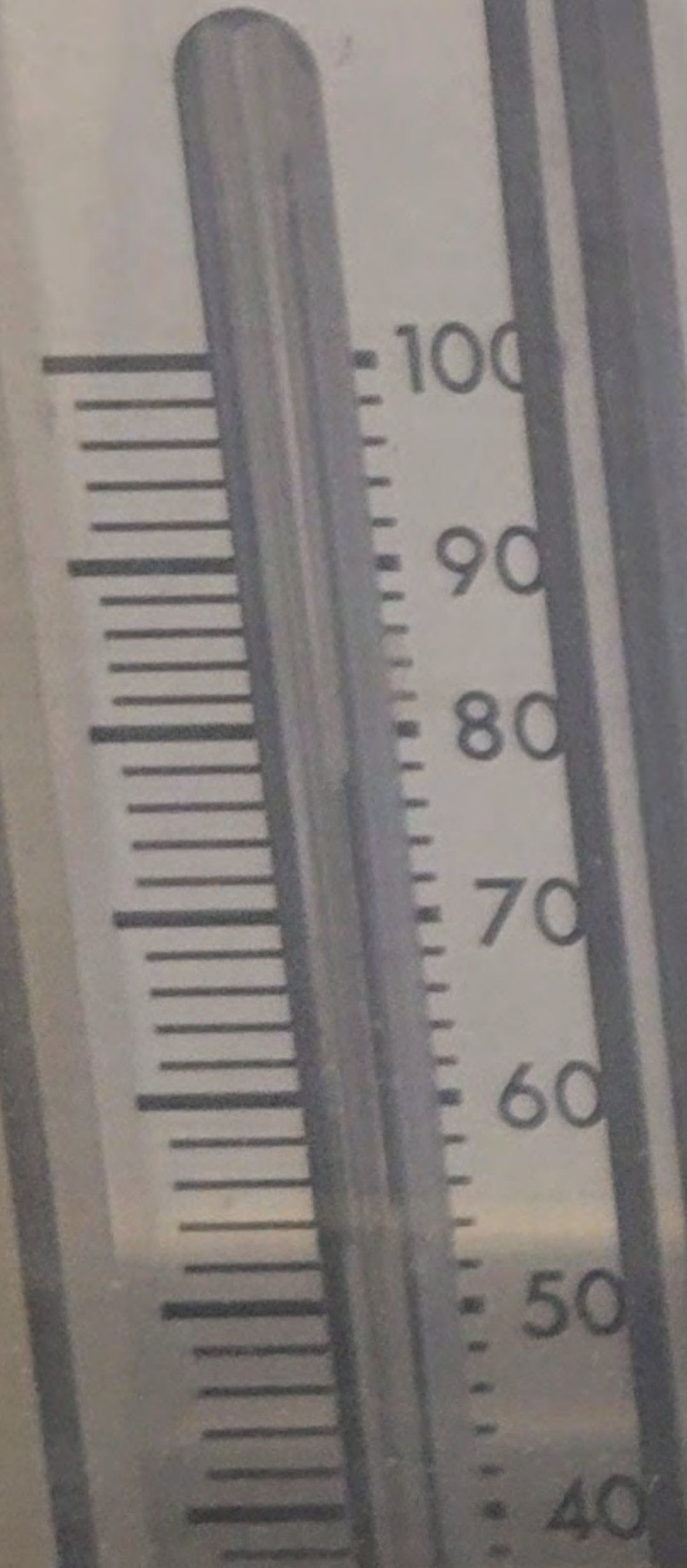
LCI Lochaber Corn... Event Log Viewer

9:35 AM



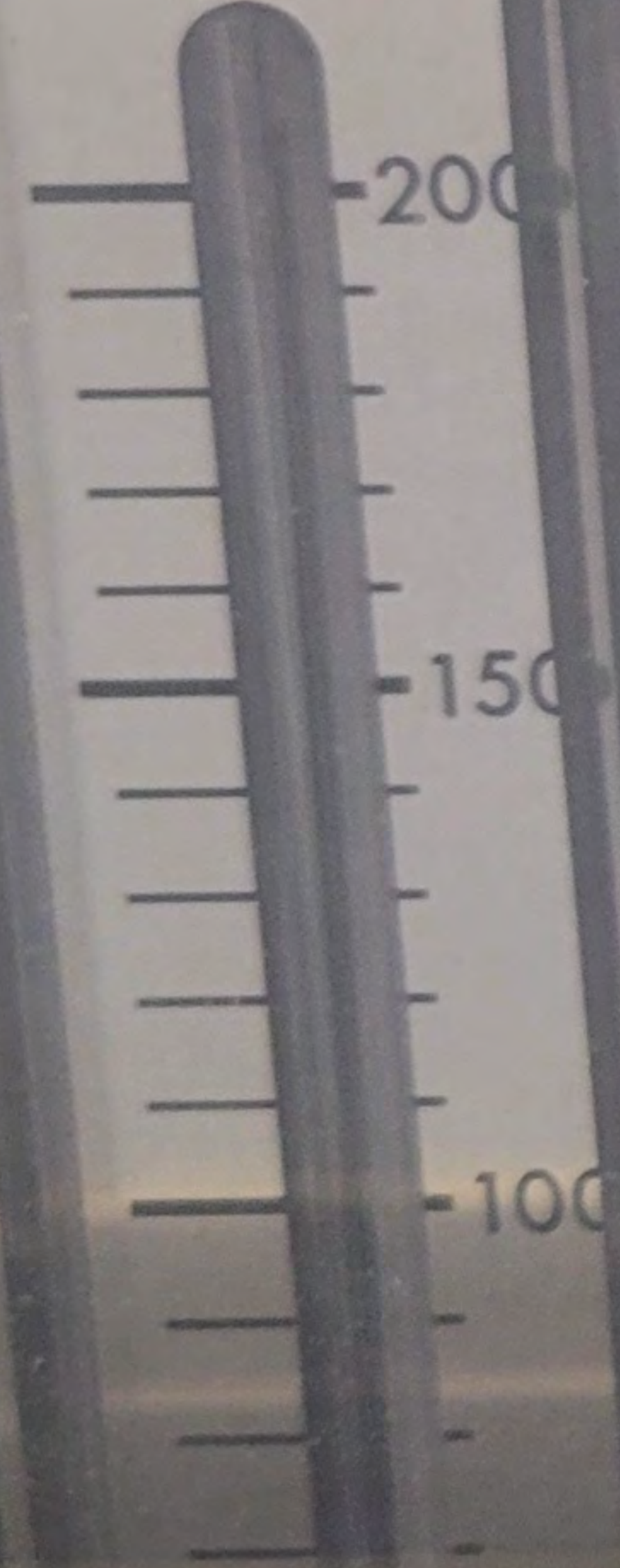
ENTRANCE
EXHAUST

SCFH
AIR



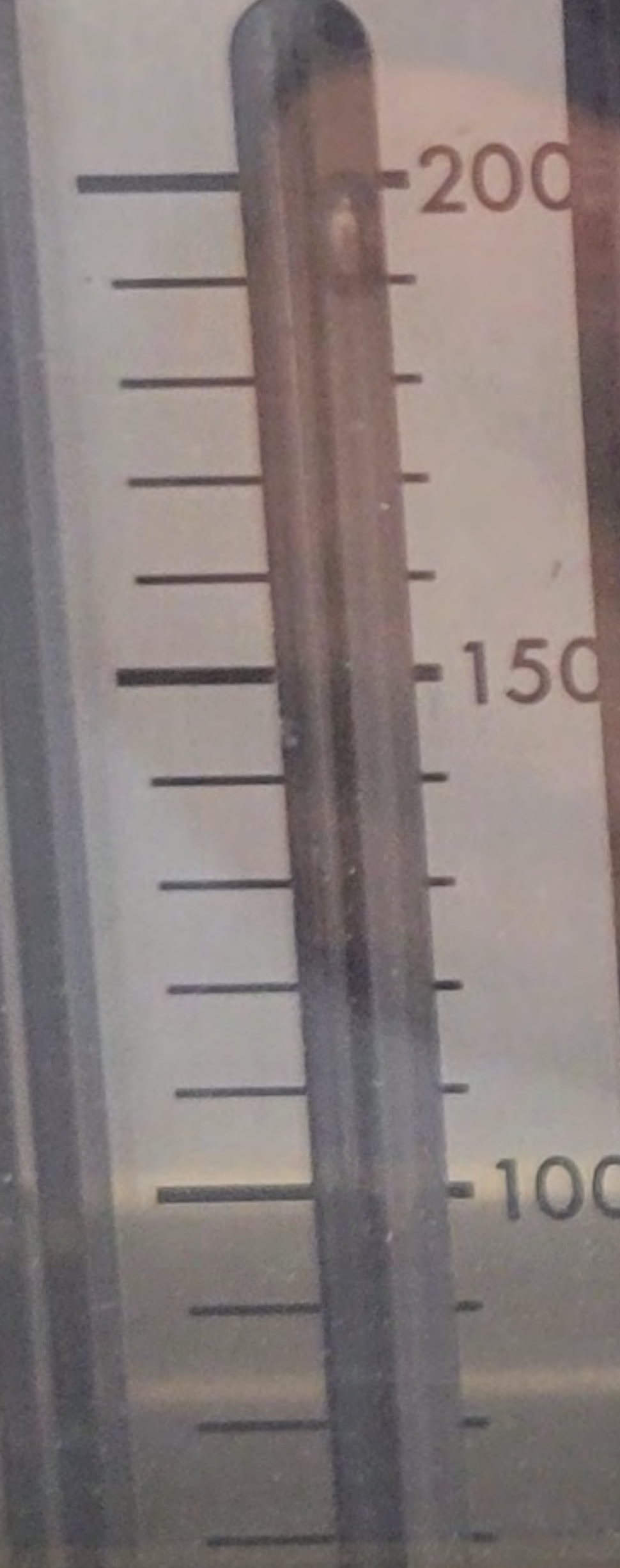
ENTRANCE
BAFFLE

SCFH
AIR



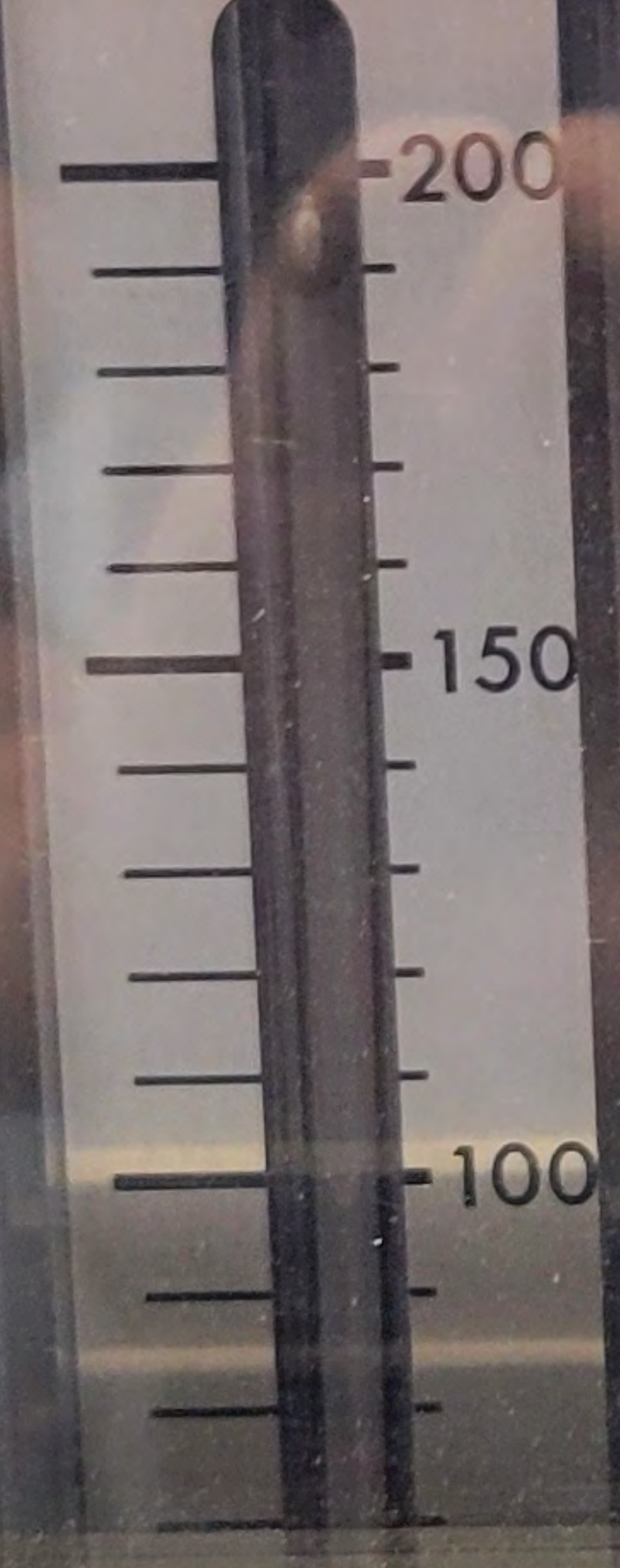
ZONE
1

SCFH
AIR



ZONE
2

SCFH
AIR



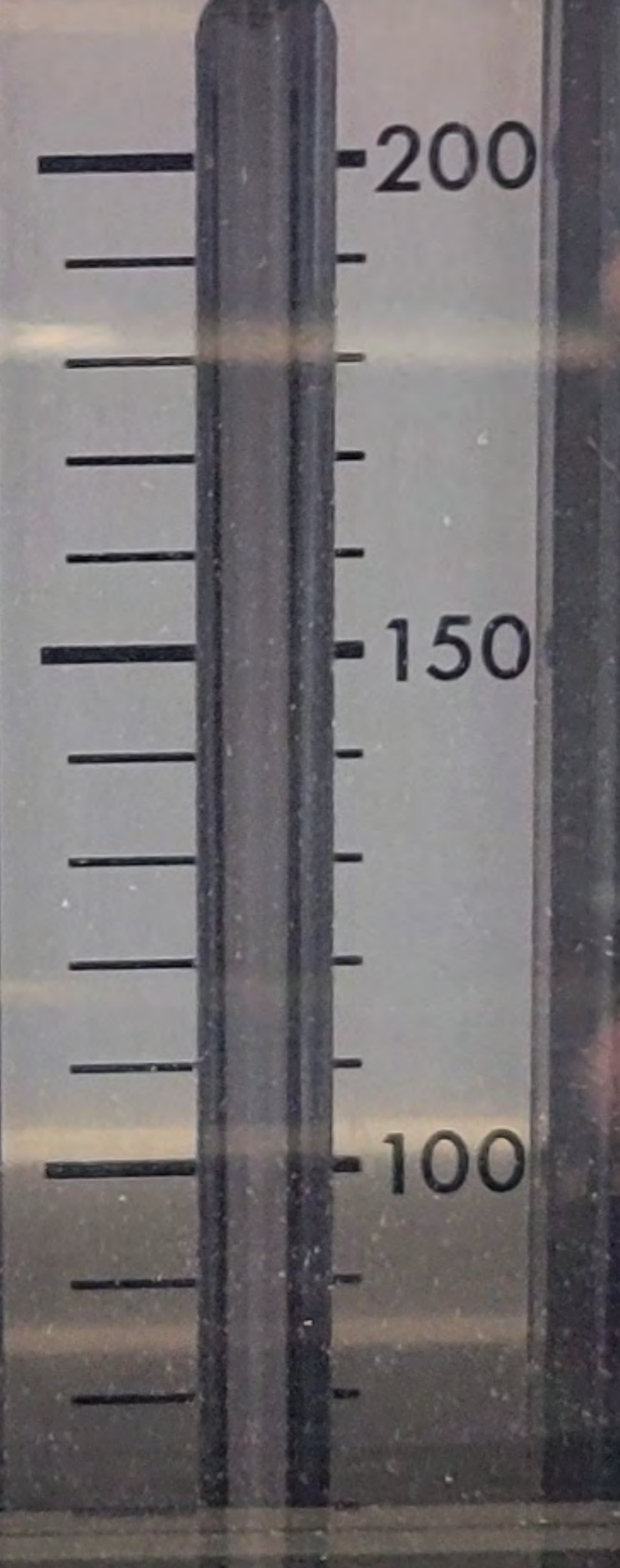
ZONE
3

SCFH
AIR



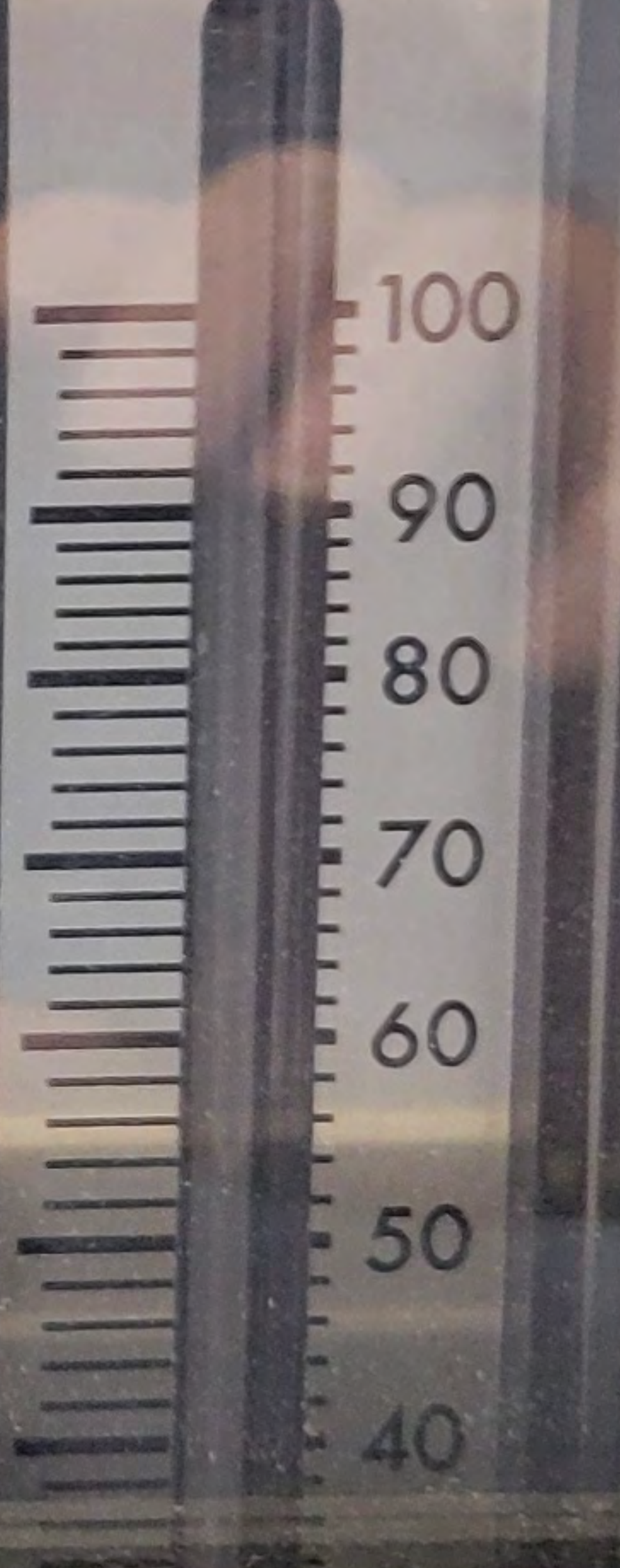
TRANSITION
TUNNEL

SCFH
AIR



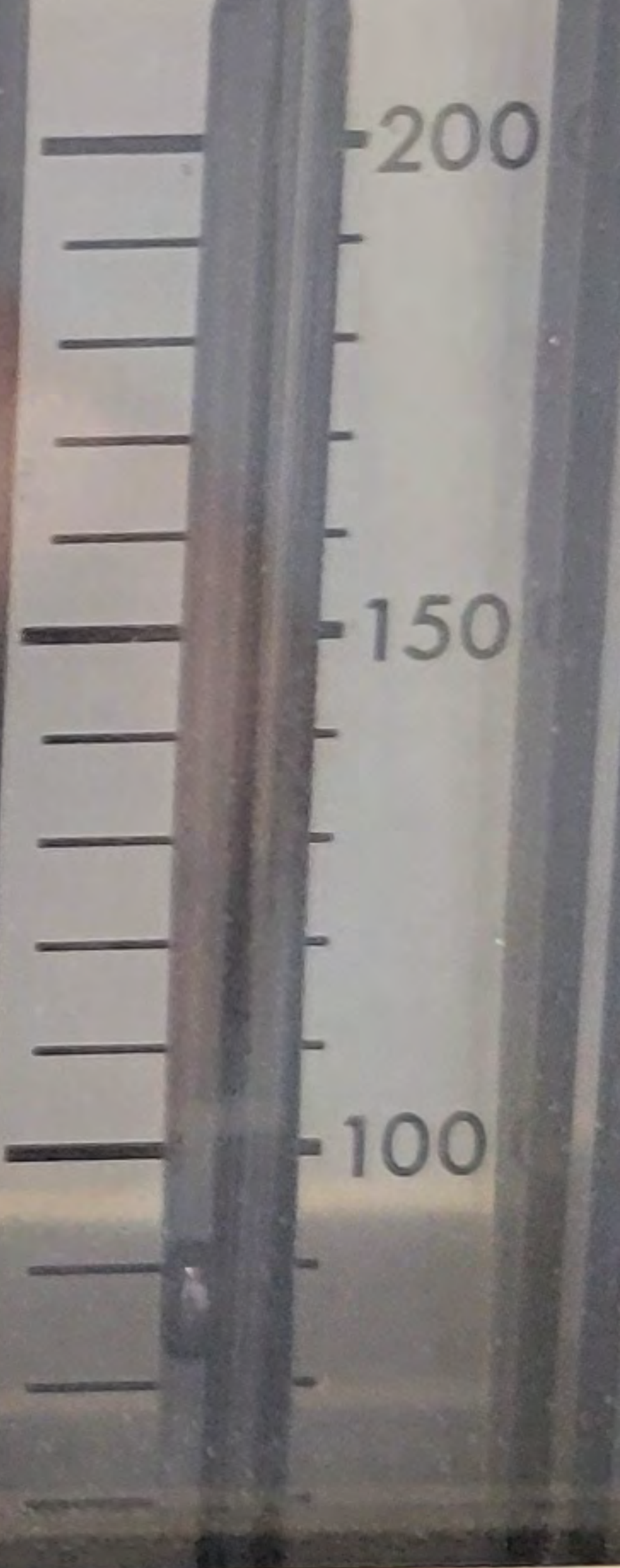
TRANSITION
EXHAUST

SCFH
AIR



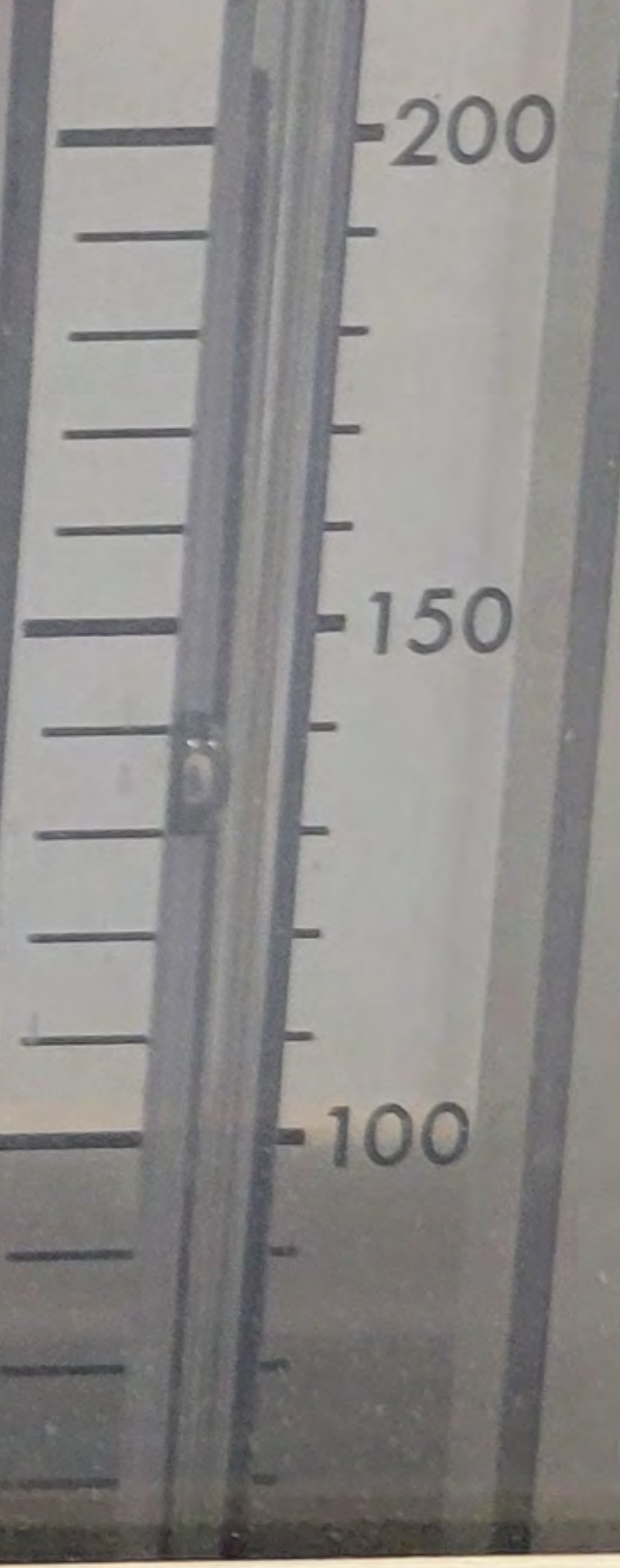
ELEMENT
PLENUM

SCFH
AIR



COOLING

SCFH
AIR



*MANUFACTURED UNDER
OR MORE OF THE FOLLOWING
PATENTS: PATENT NOS.
4,406,944; 4,477,718; 4,517,718
AND PATENTS APPLIED FOR

