



Site:

Process: Denovo RTC LA-310 460-560-780-8...

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: 3/15/2023 10:16:42AM
 Collection Started: 3/15/2023 10:16:42AM
 Max. Internal Temp.: 25.9 °C
 Logger: Datapaq Q18
 Logger ID: #1077
 Data Received: 100.0%
 Operator: JAMES
 Process: Denovo RTC LA-310
 460-560-780-8-0ipm
 Furnace: RTC LA-310
 Recipe: RTC 460-560-780_8_0ipm
 Product: Denovo 11x8 wire basket
 Time Printed: 3/16/2023 9:26:46AM

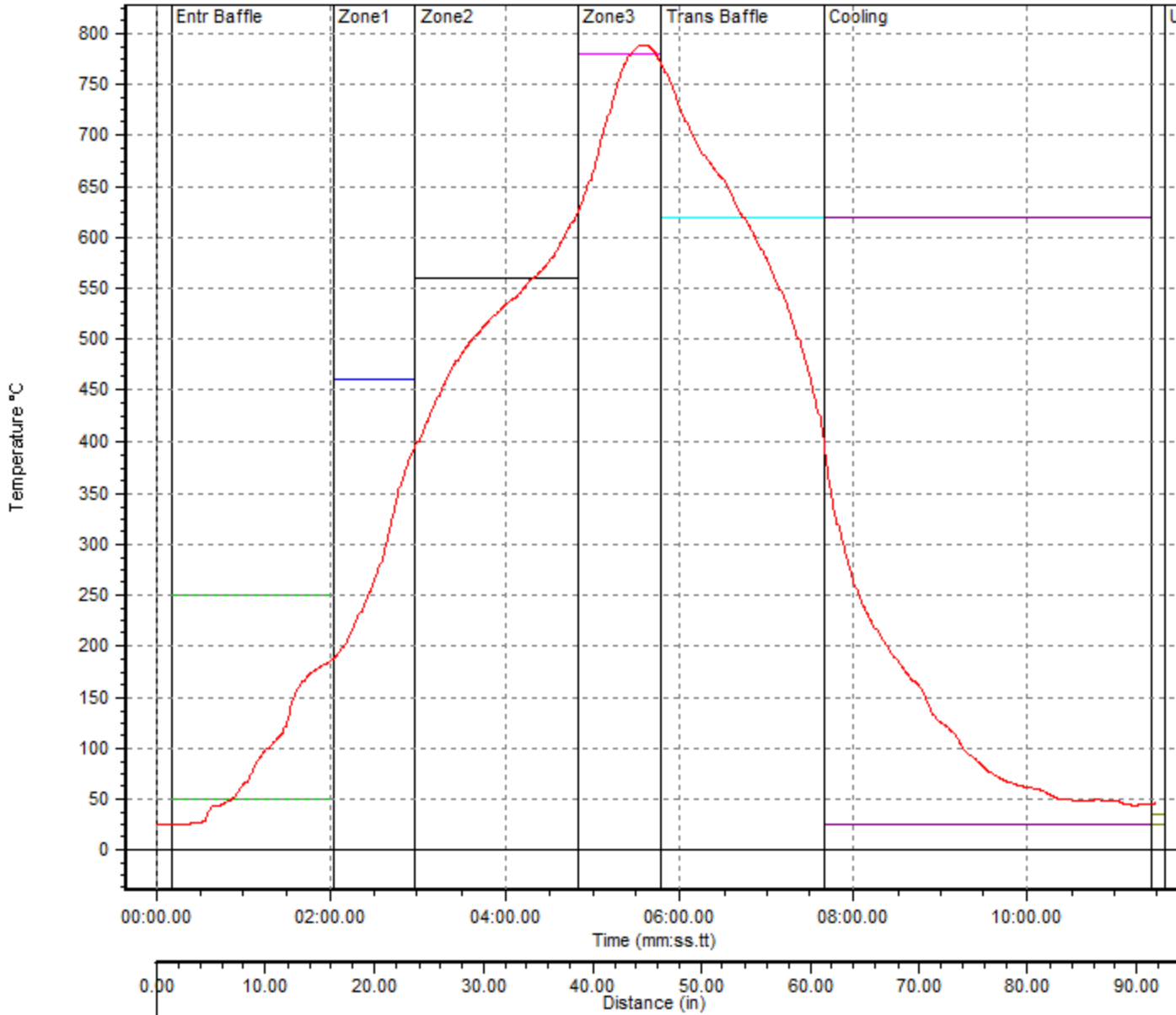
Notes:

Prince & Izant BAG-24 paste
 Solidius 660C
 Liquidus 707C
 P&I Recommended Braze: 735-762C
 11"L x 8" W x 5/8"H

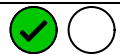
Probe Map:

		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
8.00 in/min	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	460.0	560.0	780.0	620.0	620.0	35.0	0.0
	Lower (°C):	0.0	50.0	460.0	560.0	780.0	620.0	25.0	25.0	0.0



Site:

Process: Denovo RTC LA-310 460-560-780-8...

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Probe	Maximum / Minimum				Time at Temperature					
	Maximum (°C)	Max. Reached (mm:ss.tt)	Mean (°C)	Deviation From 660.0°C	Time Above 660.0°C (mm:ss.tt)	Time To Reach 660.0°C (mm:ss.tt)	Time Above 707.0°C (mm:ss.tt)	Time To Reach 707.0°C (mm:ss.tt)	Time Above 735.0°C (mm:ss.tt)	Time To Reach 735.0°C (mm:ss.tt)
#1 (°C) Left	788.7	05:35.00	322.3	+128.7	01:29.00	04:59.50	00:58.00	05:09.00	00:44.00	05:14.50

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	04:41.00	2.23	5.96	***	***	***	***	01:49.00	2.07	4.23	01:04.00	-3.55	-7.93	02:53.00	5.96	-0.15

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

Job: 12-001 Denovo

Profile: P&I BAG-24 Paste

Model: RTC LA-310

SN: 1303100102

DATE: 15-Mar-23


	Furnace			
	Target deg C	Min deg C	Max deg C	duration (time)
solidus	651	454	518	40s
liquidus	707	518	618	3-4 min
braze	735-762	652	760	40s

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

FM Size: 100 200 200 200 200 200 100 200 200

Profile	POWER SETTINGS				Edge		FLOWMETER SETTINGS								Net flow Furnace in (out) pos (neg) pressure	BELT SPEED cm/minute	PROFILE RESULTS, MAX C					COMMENT	
	Time	Zone 1 deg C / % Pwr	Zone 2 deg C / % Pwr	Zone 3 deg C / % Pwr	Left % Pwr	Right % Pwr	ENTR EXH STK SCFH gr	ENTR BAFFLE SCFH gr	ZONE 1 SCFH gr	ZONE 2 SCFH gr	ZONE 3 SCFH gr	TRANS TUNNEL SCFH gr	TRANS EXH STK SCFH gr	ELEMENT PLENUM SCFH gr			CACT COOLING SCFH gr	Exit Z1 deg C	Exit Z2 deg C	Max Temp deg C	Time Above 735 sec		Time to Reach 735 min:sec
	setpoint:	460	560	780	4.5%	4.5%	8.5	20	190	190	90	15	9.0	80			130	323	8.0				

Run 1	10-13	460	560	780	4.5	4.5	8.5	20	190	190	88	17	8.0	85	135	323	8.0	400	625	788.7	44	5:14.5	PASS
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:  Date: 3/15/2023



ProControl THERMAL PROCESS MANAGER

LCI Furnaces
LOCHABER CORNWALL INC.
www.LCIthermal.com

Trends

Deviation

Zone	1	2	3
Setpoint	460.0°C	560.0°C	780.0°C
Actual	460.1°C	561.3°C	782.8°C
Top Power	5.0 %	9.1 %	32.0 %
Btm Power	5.0 %	9.1 %	32.0 %

Edge Heat Power
 Left **4.5 %**
 Right **4.5 %**

Avg Pwr
15.4 %

Belt Speed
 Setpoint **8.0** in/min
 Actual **8.0**

Cabinet **25 °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 **02.08.23.BAg24**

ALARM

ALERT

MAINT

ACK ALMS

User : Engr/Tech

Wednesday
 03/15/2023
 09:47:42

Security

Process

Recipe

Profile

Monitor

Maint.

Logging

Gas Flow



LCI Lochaber Corn...

Event Log Viewer

10:14 AM



ENTRANCE
EXHAUST

ENTRANCE
BAFFLE

ZONE
1

ZONE
2

ZONE
3

TRANSITION
TUNNEL

TRANSITION
EXHAUST

ELEMENT
PLENUM

COOLING

SCFH
AIR

SCFH
AIR

SCFH
AIR

SCFH
AIR

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SCFH
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SCFH
AIR

"MANUFACTURED UNDER ONE
OR MORE OF THE FOLLOWING
PATENTS: PATENT NOS.
4,406,944; 4,477,718; 4,517,448
AND PATENTS APPLIED FOR."
79377

