



Site:

Process: SierraTherm_525Ap-5_5-ipm

Product: Glass-random shape 4x4-in L

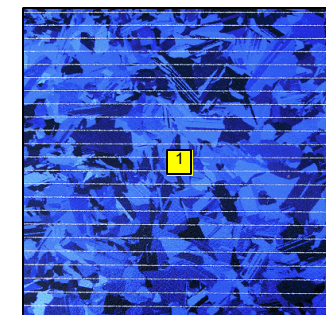
Data Collection Details:

| | |
|---------------------|-----------------------------|
| Created By | Telemetry Run |
| Number of Probes | 1 |
| Sample Interval | 0:00.50 (mm:ss.t) |
| Data Loaded | 3/10/2023 12:09:19PM |
| Collection Started | 3/10/2023 12:09:19PM |
| Max. Internal Temp. | 19.5 °C |
| Logger | Datapaq Q18 |
| Logger ID | #1077 |
| Data Received | 100.0% |
| Operator | JAMES |
| Process | SierraTherm_525Ap-5_5-ipm |
| Furnace | ST1K14-150C72-12A |
| Recipe | 520ApI-5_5ipm |
| Product | Glass-random shape 4x4-in L |
| Time Printed | 3/10/2023 12:59:04PM |

Notes:

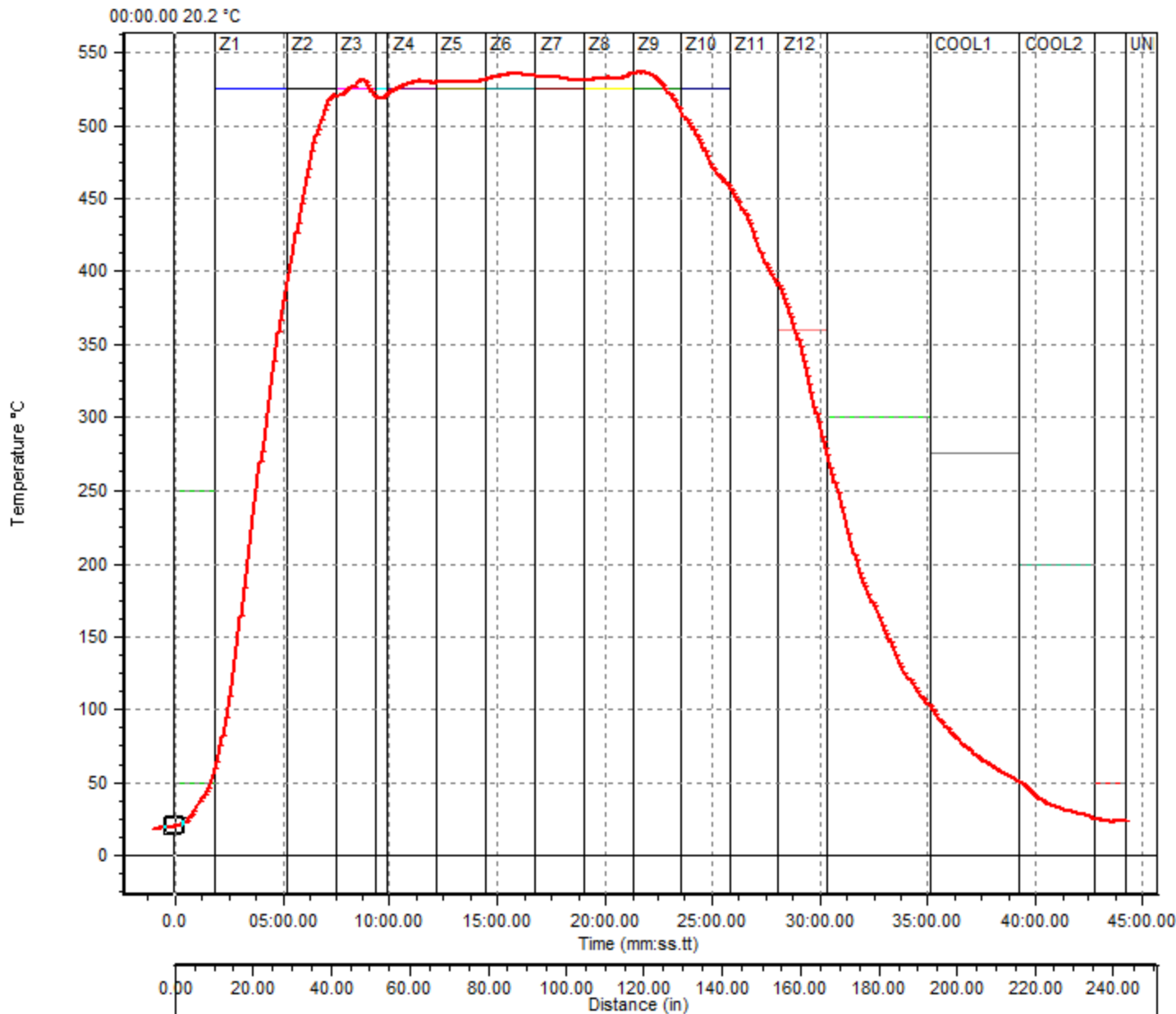
Capture full zone widths
 >500C for 10 min - Apple 1105 material. Dwell target 15 min
 in 4.5 x 4.5 sq thin glass
 Koartan 5635 Low Temp Glass Paste

Probe Map:



| | | |
|--------------|------|------|
| 4.00x4.00 in | | |
| #1 | x | y |
| | 2.00 | 2.00 |

Direction of travel through Furnace



| Line Speed: | Zone: | Entrance | Collector | Z1 | Z2 | Z3 | EX | Z4 | Z5 | Z6 | Z7 | Z8 | Z9 | Z10 | Z11 | Z12 | TRANS TUNNEL | COOL1 | COOL2 | EXIT | UNLOAD |
|-------------|--------------|----------|-----------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|--------------|-------|-------|------|--------|
| 5.50 in/min | Length (in): | 0.25 | 10.00 | 18.25 | 12.50 | 10.25 | 3.25 | 12.50 | 12.50 | 12.50 | 12.50 | 12.50 | 12.50 | 12.50 | 12.50 | 12.50 | 26.25 | 23.00 | 19.00 | 8.00 | 24.00 |
| | Upper (°C): | 0.0 | 250.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 400.0 | 360.0 | 300.0 | 275.0 | 200.0 | 50.0 | 0.0 |
| | Lower (°C): | 0.0 | 50.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 525.0 | 400.0 | 360.0 | 300.0 | 275.0 | 200.0 | 50.0 | 0.0 |



Site:

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| Probe | Maximum / Minimum | | | | Time at Temperature | | | | | |
|----------------|-------------------|-------------------------|-----------|------------------------|-------------------------------|----------------------------------|-------------------------------|----------------------------------|-------------------------------|----------------------------------|
| | Maximum (°C) | Max. Reached (mm:ss.tt) | Mean (°C) | Deviation From 525.0°C | Time Above 525.0°C (mm:ss.tt) | Time To Reach 525.0°C (mm:ss.tt) | Time Above 515.0°C (mm:ss.tt) | Time To Reach 515.0°C (mm:ss.tt) | Time Above 100.0°C (mm:ss.tt) | Time To Reach 100.0°C (mm:ss.tt) |
| #1 (°C) Center | 537.0 | 21:35.00 | 320.3 | +12.0 | 13:42.50 | 08:03.50 | 16:16.00 | 07:06.00 | 32:48.00 | 02:27.50 |

| Probe | Rise / Fall | | | | | | | Slopes | | Peak Difference | |
|----------------|----------------------|-----------------------|-----------------------------|----------------------|------------------------|-----------------------------|-------------------------|-------------------------|---------------------|----------------------|-------------------------|
| | (25.0 To 360.0°C) | | | | | | | Positive Slope (°C/sec) | Mean Slope (°C/sec) | Peak Difference (°C) | Time Reached (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) | | | | |
| #1 (°C) Center | 04:15.00 | 1.31 | 2.06 | 13:57.00 | -0.40 | -1.16 | 18:12.00 | 2.06 | -0.11 | *** | *** |