

5" Wide X 4" High X 10" D., 1500° C Front Loading
REDUCING/INERT ATMOSPHERE,
COLDWALL LABORATORY FURNACE
TABLE TOP MODEL

For programmed continuous operation to 1500° C.



Size: 39" (100 cm) W. x 26" (66 cm) D. x 20" (51 cm) H.

Standard Features:

- Burnoff column
- Bubbler for humidification of process gas
- Equipment fits on table top or bench
- Honeywell Controls - Ramp & Soak
- DCP302 Program Controller
- UDC2500 Overtemp Control
- 19 Programs - 20 segments per program
- Stainless Steel top
- Sight glass for calibration melts
- Fully automatic - One button push starts the run. Automatically it will purge - process gas fill - ramp to temperature and soak - bubbler for humidification of process gas - cooldown - post purge.

Options:

- Paperless Chart Recorder
- Survey Thermocouple
- Dewpoint Monitor
- Vacuum Purge
- Tower Indicator Lights
- Computer Controls



Manufacturers of High Temperature & High Vacuum Equipment

370-G Industrial Road | San Carlos, CA 94070
 Phone (650) 593-1064 | Fax (650) 593-4458

Specification Sheet

Equipment Model: G-1500 Furnace



Type	Coldwall, Horizontal, Front Loading
Maximum Temperature	1550 Degrees C.
Hot Zone	4" (10 cm) W. x 5" (13 cm) H. x 10" (25 cm) Deep
Frame Dimensions	39" (100 cm) W. x 30" (76 cm) D. x 21" (53 cm) H.
Power Requirements	240V 1 Ph. 60A 60 Hz. or 230V 1 Ph. 60A 50HZ
Gas Requirements	25 – 50 psig, Nitrogen – ¼" swagelok connection
	25 – 50 psig, Hydrogen – ¼" swagelok connection

Purge gas is Nitrogen.

Process gas is Hydrogen or Nitrogen or a mixture of both.

Process gas can be humidified via a heated bubbler to over 18 degrees C. Dewpoint.

Cooling Requirements - 25 psig at zero back pressure, at 4 gallons per min.

Note: maximum back pressure is 15 psig.

Heat up ramp rate 75 degrees C per minute - empty chamber.

All Molybdenum Hot Zone & elements. All insulators are made of High Alumina.

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Equipment Description

CAMCo 5”W. x 4”H. x 10” D., 1550 Deg.C

REDUCING/INERT ATMOSPHERE
COLDWALL LABORATORY FURNACE
For Automatic, Programmed Operation to 1550 Deg. C

Higher temperature and high vacuum versions available.

Model G-1500



Overview

This compact front-loading, bench top furnace is designed for automatic program controlled thermal processing of work in wet and dry, inert and reducing atmospheres. The heat shielded work area includes a Molybdenum hearth plate, which supports a load 4” high, 5” wide and 10” deep for uniform ramp and soak processing to temperatures to 1550 deg. C. The low thermal mass heat shields allow cooldown to be programmed at a rate such that three complete process runs can be done in a day shift. The furnace chamber is constructed of double walled stainless steel with water passages between the walls. The heat shields and elements are constructed of pure Molybdenum and high alumina insulators support the elements.

Base Unit

The cabinet measures approximately 39” wide by 30” deep by 21” high. Its substantial frame is constructed of heavy steel structural shapes. Steel panels are readily removed to gain access for efficient, on the spot service. The square tubular support feet provide a convenient location in which to insert bars for lifting. The left side of the cabinet contains the logic controller, gas valving, bubbler column, power components and electronics. A fan located at the rear of the unit draws cooling air through the cabinet to cool the power control module. The right side of the cabinet contains the chamber, gas-plumbing bulkhead, Thermocouples and is baffled from the electronics. There are no high voltage components on the chamber side of the frame. The finish used on this, and all CAMCo equipment, is baked powder coating chosen for its durability and solvent resistance.

Temperature Control

Temperature control and monitoring signals are received from two type “C” thermocouples. Multi-stage programmed thermal control and atmosphere sequencing is achieved through use of a Honeywell DCP302 Micro process controller. The controller receives its’ input signal from a thermocouple located close to the heating element. Thermocouple break protection assures that heating power is removed from the furnace in the event of sensor failure.

A 5/8” diameter sight port is located at the center of the cover, and its centerline is in line with the Over Temperature thermocouple. In registration with this are holes of approximately 7/16” diameter, which penetrate the front heat shield stack. A “flag” in close thermal proximity to the work monitoring thermocouple may thus be watched, and a precise calibration thereby obtained. This viewpoint can also be used in conjunction with an optical pyrometer.

The sight glass is sealed through use of an “O” ring, and is readily removable to facilitate cleaning or replacement. There is a feed through at the side of the chamber and related holes in the cylindrical shields that allow survey thermocouples to be inserted to monitor actual temperature of load. These thermocouples can be used in conjunction with the “Active Closed Loop Braze Control Option”.

Load temperature monitoring and Overtemp is provided by a second thermocouple located within close proximity to the load. It drives a Honeywell UDC2500 process monitor, which provides digital readout of the load area temperature and provides an overtemperature shutdown signal. The process monitor also provides a safe chamber access interlock and access signal for the operator.

Operation

Work is loaded into the furnace, the front heat shield stack inserted, the cover closed and latched. One of nineteen selectable, user programmed thermal profiles is chosen, and the “start” key pressed. A one button push will start the run and automatically it will purge, process gas fill, ramp to temperature and soak, activate the bubbler for humidification of process gas, cooldown and post purge. Upon completion of the cooldown portion of the program, a lamp signals when the chamber may be opened and unloaded.

The front of the double wall, water-cooled chamber is closed in operation by a jacketed, water-cooled door. The door handle includes a cam locking arrangement to easily compress the silicone door seal gasket. Hydrogen is prohibited from entering the system and heating cannot begin until the door is closed and sealed and the chamber is purged of air. Power to the heating elements is prohibited if there is not enough water flow through the chamber cooling system.

Power Control

Power is proportionally controlled through use of a digitally controlled SCR single-phase power module. This unit is phase angle fired controlled, and includes current limiting made necessary by the strongly positive resistivity coefficient of the heating element. An adjustable, manual reset over current trip provides for automatic resumption of a run in the event of a brief power interruption. Impedance match of the heating elements to the incoming power is accomplished through the conservatively rated transformer driven by this power module.

Atmosphere Control

Customer supplied Hydrogen and Nitrogen gasses are admitted to the chamber through programmed valves and preset flowmeters. An interlock is included which provides for automatic Nitrogen purge in the event of loss of Hydrogen or chamber pressure. Operator set flowmeters control the flow of gasses to achieve the appropriate operating atmosphere. Gasses can be set and programmed to operate in pure Nitrogen, Nitrogen and Hydrogen mixture and pure Hydrogen. All gasses can be run wet or dry as described below.

Included is a system which, when called to do so by the installed program, humidifies a portion of the selected process gas via a bubbler column. This gas is then recombined with the remaining process gas in a pre-selected ratio to obtain the desired process dewpoint. The included bubbler will humidify the process gas to a dewpoint of up to 20 deg. C. Higher dewpoint equipment, and controlled temperature bubblers are available.

Exhaust gas is routed through a check valve and out a fitting at the rear of the cabinet. This valve establishes a slight positive pressure when the door is closed and sealed. As a safety feature, absence of this pressure prevents admission of Hydrogen and inhibits the application of heater power. An exhaust gas burnoff column electronically ignites the waste gas. Ignition is called for automatically at all times that Hydrogen is called for, and the unit attempts re-ignition should the flame be inadvertently extinguished. The ignitor is automatically tested to assure proper operation each time a run is started. All gas plumbing and components are stainless steel. All gas connections are high quality, high-pressure swagelok fittings.

Standard Safety Features

Thermocouple break protection assures that heating power is removed from the furnace in the event of sensor failure. Overtemperature indication is read on a separate control module from the monitor thermocouple. This overtemp alarm causes the heating elements to shut down as a further backup.

Other numerous interlock functions protecting the operator and equipment include:

- Panel Interlock
- High Cabinet Temperature
- Low Coolant Flow
- Low Gas Pressure Switches

- Hydrogen is prohibited from entering the system and heating cannot begin until the chamber cover is closed, sealed and purged. At the end of a programmed run the chamber is inhibited from being opened until the work has cooled to a pre-defined safe temperature.
- Purge Assure Circuit provides an internally set minimum timed Nitrogen purge regardless of the program status whenever power or the program is interrupted.

Documentation

Facilities information is supplied to assist in site preparation for installation. An operating manual is supplied with the equipment. Worksheets included in the manual provide a convenient form to depict the desired process for entry into the microprocessor controller. The worksheets also serve as a hard copy of the program. The unit is shipped with an example program stored in memory, depicted by the example worksheet.

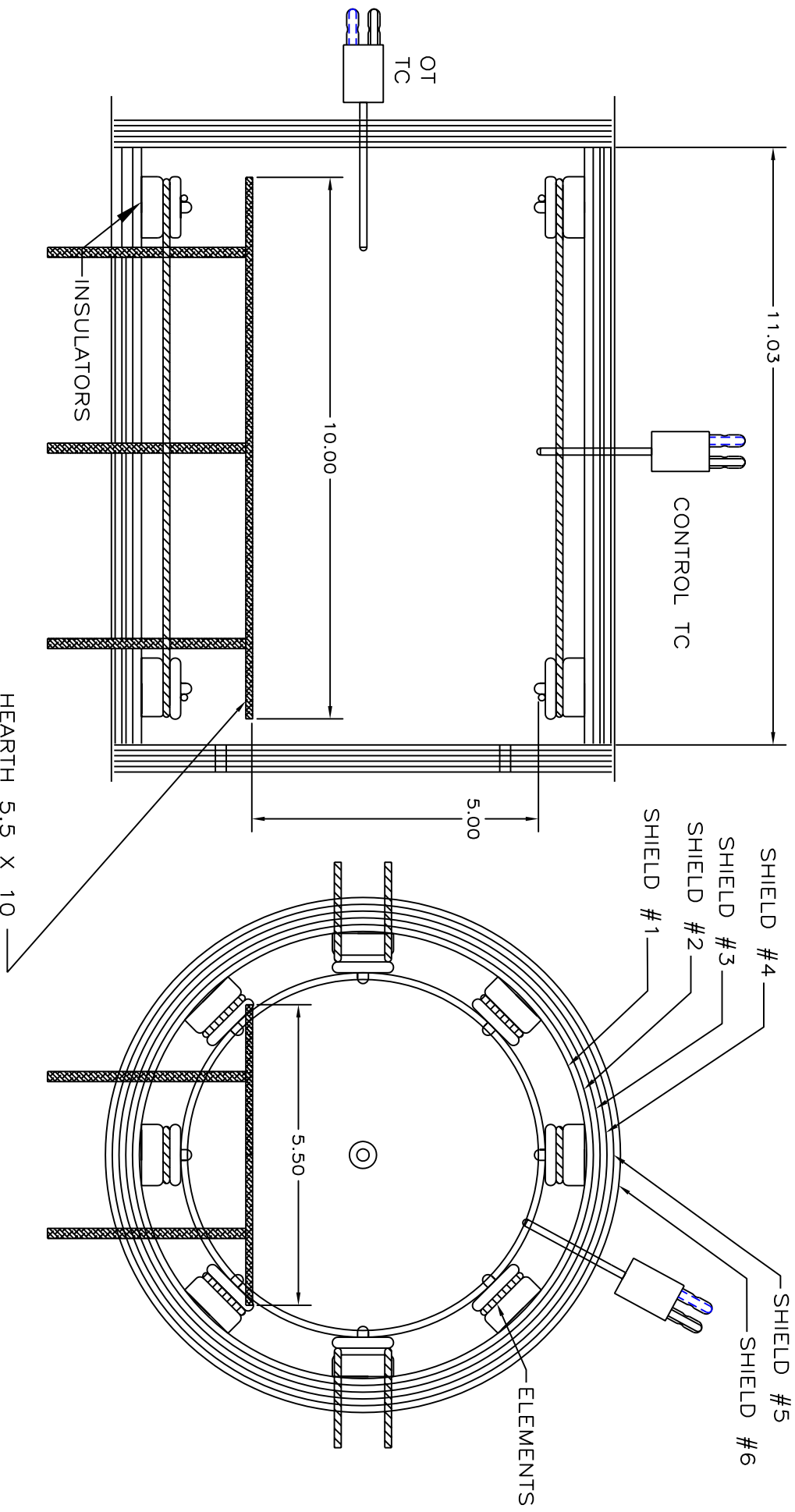
Wiring and plumbing schematics along with a published spare parts list are also included in the manual. Vendor supplied manuals for the program controller, overtemp, SCR, recorder, dewpointer, and other small items are supplied in our documentation. A program and operation section has a complete button-by-button push instruction for installation of a generic program. The relatively simple operation of the furnace is well described and documented in the manual.

While the furnace is a complete, stand-alone unit as described, many applications suggest the inclusion of one or more of the options described in the enclosed data or web site. Other, less commonly ordered options can also be provided. Please inquire.

5" Wide X 4" High X 10" D., 1500° C Front Loading



G-15 HOT ZONE LAYOUT



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USED ON TASK	FWO
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TOL'S EXCEPT AS NOTED	DRN. BY: T BARULICH
frcct. ± 1/32	APP. BY:
.XX ± 0.10	DATE: 5-1-07
.XXX ± .005	MAT: MOLY
.XXXX ± .0005	FINISH:
ANGLES ± 1/2°	

DRN. BY: T BARULICH	TITLE: G-15 HOT ZONE LAYOUT
APP. BY:	DWG. NO: 98023
DATE: 5-1-07	SHEET 4 OF 4
MAT: MOLY	REV:

CAWVE
Concepts & Methods Company, Inc.

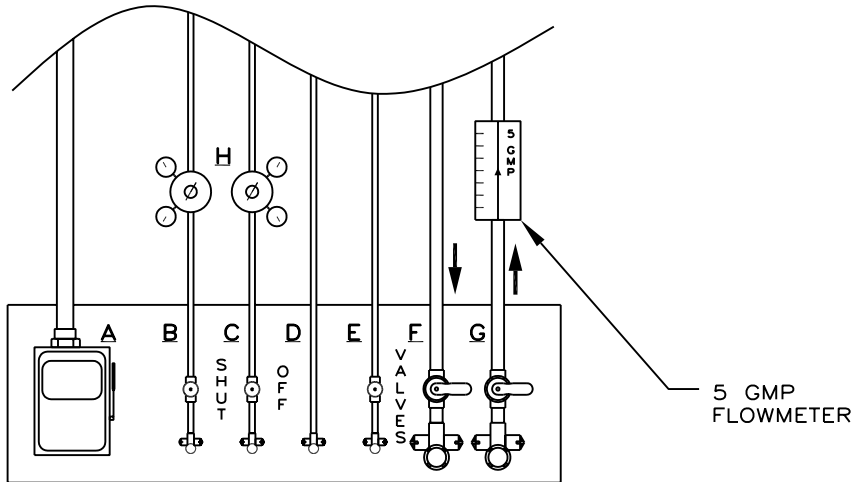
REV.	DATE	DESCRIPTION

UTILITIES: PREPARED AS SHOWN BY CUSTOMER.

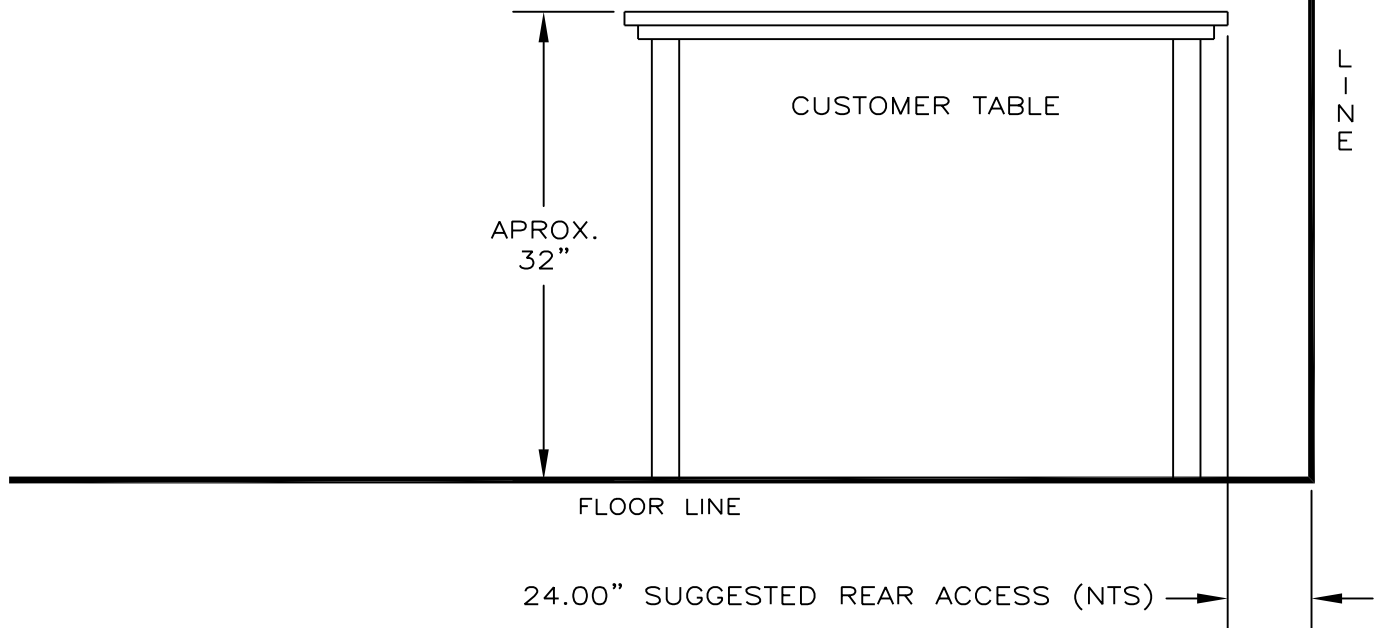
REV.	DATE	DESCRIPTION
A	3-1-06	DELETE 480V OPTION

- A: 60A. @ 208 OR 240V. 60 Hz SINGLE PHASE DISCONNECT.
- B: NITROGEN, 30 TO 50 PSIG AT A MAXIMUM FLOW OF 30 SCFH
- C: HYDROGEN 30 TO 50 PSIG AT A MAXIMUM FLOW OF 30 SCFH
- D: PROCESS ATMOSPHERE EXHAUST (NOT NEEDED WITH BURNOFF OPTION)
- E: D.I. WATER FOR BUBBLER MAKEUP
- F: COOLING WATER SUPPLY; 25 PSIG MIN. AT 2.5 GPM – SEE NOTE
- G: COOLING WATER RETURN OR PRESS. DRAIN IF USED--SEE NOTE
- H: LINE PRESSURE REGULATORS SET AT 40 PSI.

- 1/4" TUBE
- 1/4" TUBE
- 3/8" TUBE
- 1/4" POLYFLO
- 1/2" FPT
- 1/2" FPT



SUGGESTED UTILITY PANEL LAYOUT
LOCATE ON WALL BEHIND TABLE



NOTE: (MAX. BACK PRESSURE 15 PSIG AT 4 G.P.M.)

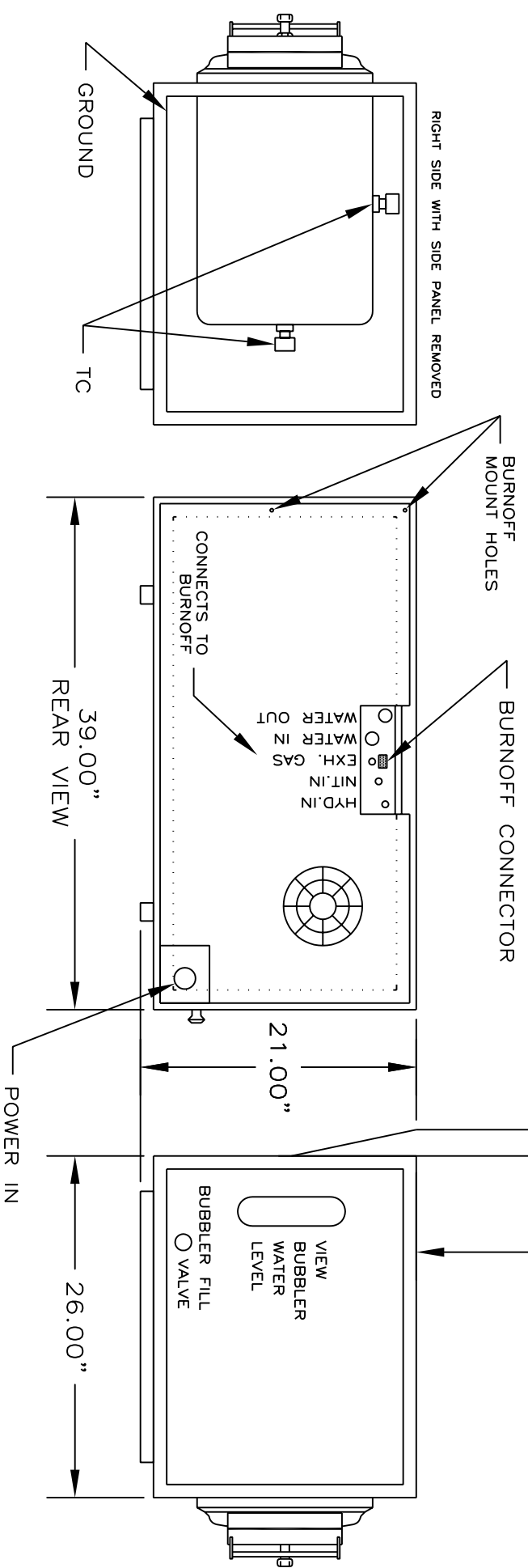
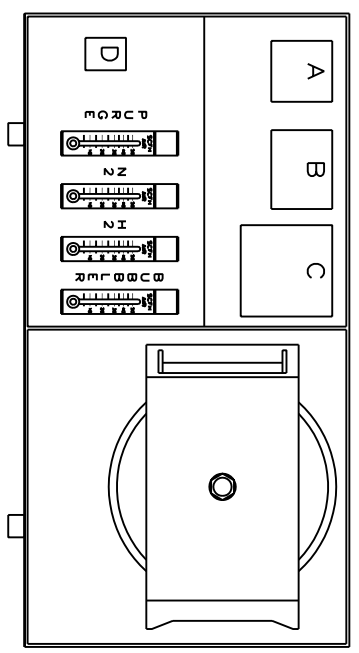
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		TOL'S EXCPT AS NOTED	DRN.BY: ZEVADA 08/22/00	
		fract. ±1/32	APP.BY:	
		.XX ±.010	DATE: 01/05/89	
		.XXX ±.005	MAT:	
USED ON TASK	FWO	.XXXX ±.0005	FINISH:	TITLE: G FURNACE FACILITIES PREP.
		ANGLES ±1/2'		DWG.NO: 86531
				SHEET 1 OF 2
				REV: A

REV.	DATE	DESCRIPTION

(FRONT VIEW)

- A: PROGRAM CONTROL
- B: WORK MONITOR
- C: RECORDER
- D: HOUR METER



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TOL'S EXCEPT AS NOTED				DRN. BY: ZEVADA 08/01/00			
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.XX ± 0.10				DATE: 01/05/89			
.XXX ± 0.005				MAT:			
.XXXX ± 0.0005				FINISH:			
ANGLES ± 1/2°							
USED ON TASK				FWO			
 Concepts & Methods Company, Inc.				TITLE: G FURNACE FACILITIES PREP.			
				DWG. NO: 86531			