



Manufacturers of High Temperature & High Vacuum Equipment

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Specification Sheet

Equipment Model: **G-ATM-16**
Hydrogen / Reducing Atmosphere Furnace
PLC Touchscreen Controls

Type	Hydrogen, Horizontal Front or Top Loading
Chamber	Stainless Steel Coldwall
Maximum Temperature	1600° C.
Hot Zone	5" (13 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 - 1/4" Swagelok connection
	25 - 50 psig, Hydrogen - 3/8" Swagelok connection

Purge gas is Nitrogen.

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

Process gas can be humidified via a bubbler up to 18° C. Dewpoint (Optional)

Cooling Requirements - 25 psig at zero back pressure, at 4 gallons per minute (3GPM minimum)

Note: Maximum back pressure is 15 psi. Room temperature inlet water (20 C / 68F)

BTU Load, 36,000 (3 tons) for chiller calculation

Heat up ramp rate 60° C per minute - empty chamber. (25 C recommended)

All Molybdenum Hot Zone & Elements. All Insulators are made of High Alumina ceramics.

Standard Features:

Burn-off Column
Equipment on casters to roll into place
IDEC touchscreen PLC controls
Watlow EZ-Zone Overtemp Control
40 Programs - 15 Segments per Program
MFCs for gas input (Mass Flow Controllers)
Sight glass for calibration flag melts
Vacuum purge with automatic leak check (Rate of Rise)
O2 analyzer for Hydrogen safety
Cascade Braze Control with Type "K" Survey TC
Tower Indicating lights
Complies with NFPA 86 Oven and Furnace regulations.
Fully Automatic - One button push starts the run.

Common Options:

Bubbler for humidification of process gas
Heated Bubbler for dewpoint up to 30°
Additional Survey Thermocouples
Dewpoint Monitor -60 to +40° C
Custom moly furniture, loading racks

Automatically it will pumpdown → inert gas purge → process gas fill → ramp to temperature and soak → bubbler for humidification (optional)
→ cool down to specified temperature → post inert purge



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Equipment Description

Camco Model G-ATM-16-FL/TL

5" Dia. X 10" Depth, 1600° C

**REDUCING/INERT ATMOSPHERE,
COLDWALL FURNACE**

For Automatic, Continuous Operation to 1600° C
Touchscreen PID controller with 2 MFCs



Overview

The Concepts & Methods Co., Inc. "G-ATM-16", reducing/inert atmosphere furnace is designed to reproducibly metallize, braze, clean fire and otherwise process loads of up to 5" diameter by 10" deep. One of 40 selected ramp and soak programs is accurately controlled up to 1600° C. The MFC process gas controls, temperature controls and safety interlocks are integrated in a single Touchscreen PID controller to assure simple, reliable, programmed operation. The furnace chamber is located within the right half of the base unit and is of the "coldwall" variety.

It incorporates a Molybdenum heating element of six sections supported by high alumina insulators. This surrounds the twelve-inch diameter by eighteen-inch high work area. Work is placed on a molybdenum hearth plate, which in turn is held by the support structure within the chamber. A series of six cylindrical heat shields, the bottom end stack of nine shields, and the removable front shield stack of seven heat shields. A double wall, water jacketed stainless steel chamber contains these items as well as the two insulated power feedthroughs, control and work thermocouples and other required features.

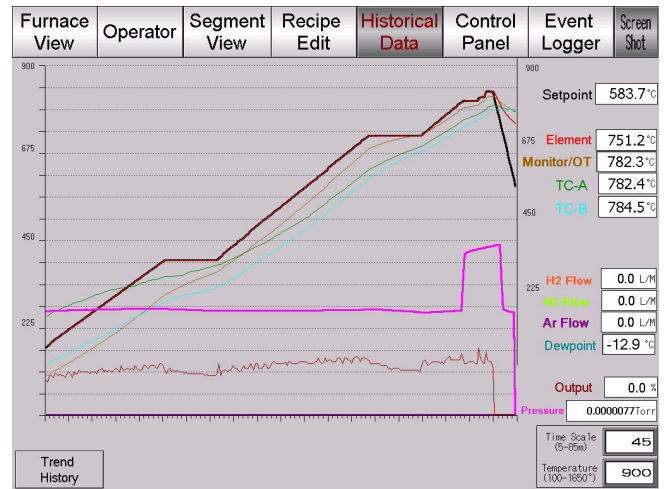
The water-jacketed cover assembly is reliably silicone gasket sealed to the chamber through use of an interlocked camming latch. A 5/8" diameter sightport is located at the center of the cover, and its centerline is vertical. In registration with this are holes of approximately 7/16" diameter, which penetrate the top 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 feedthrough 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."

Standard Features

This furnace has the IDEC Microsmart EC6A Plus control with a standard 10" HMI touchscreen display. This controller supports a number of modern standard features as Web Servers, FTP, Mobile connectivity and a cross-platform desktop app. Mass Flow Controllers (MFCs) for controlling gasses, an automated bubbler for wet hydrogen and burn-off column for exhaust gas are controlled by the IDEC. The base unit fits through a standard door without any disassembly, and is designed to be placed on a sturdy tabletop. Its substantial frame is constructed of heavy wall square steel tubing. Service access is readily gained through panels on all sides of the machine. The plate steel floor within the left half of the base unit supports the heavy heater power transformer and closes the bottom. The painted 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 achieved from two type "C" thermocouples. Multi-stage programmed Ramp & Soak Temperature control along with process gas sequencing is achieved through use of the IDEC, PLC Touchscreen controller. The controller receives its' input signal from a thermocouple located close to the heating element. This can be changed to operate with any TC in the chamber or a combination of all (cascade control). Thermocouple break protection assures that heating power is removed from the furnace in the event of sensor failure. Multiple thermocouples can be used to control and monitor the load. These are flexible, Inconel sheathed type "K" thermocouple that can be attached directly to the load (limited to 1200 C). This signal can be used for process load control.



Overtemp & Safe Access Control

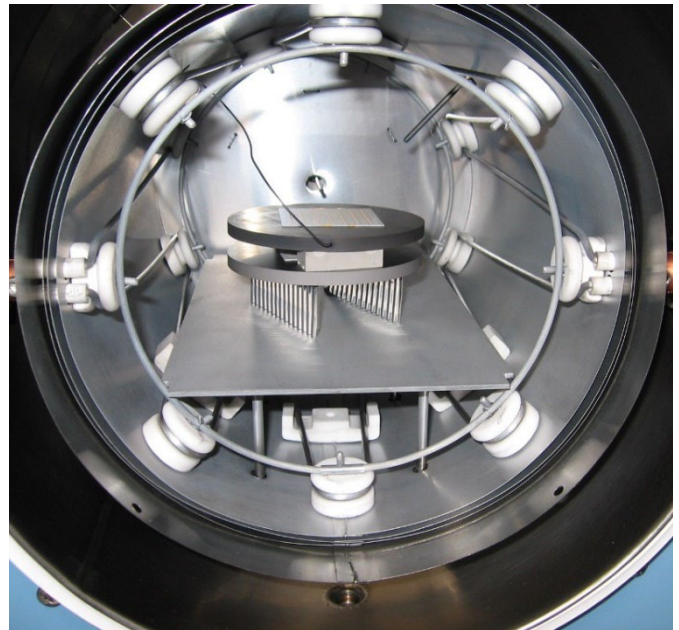
Over temperature monitoring is provided by a third thermocouple located within close proximity to the load. It drives a Watlow Limit Controller, which provides digital readout of the load area temperature and provides an over temperature shutdown signal. The process monitor also provides a safe access temperature interlock and run complete signal for the operator.

Operation

The work is loaded into the furnace, the top heat shield stack inserted, the cover closed and latched. One of 40 selectable, user programmed thermal recipes is chosen, and the "start" key pressed. Gas flows and dewpoint are set. The furnace will automatically pre-purge, process gas fill, perform the pre-programmed ramp & soak temperature profile, cool down, and post purge. Upon completion of the cooldown portion of the program, the chamber is opened and unloaded. Chambers can be ordered either front or top loading, to accommodate for different loading configurations, shapes and ergonomics.

Power Control

Power to the elements is proportionally controlled through use of a digitally controlled SCR single-phase power module. This unit is phase angle fired control and includes current limiting made necessary by the strongly positive resistivity coefficient of the heating elements. In the event of a power outage at higher temperature, the load temperature would drop to a level where a hard application of heat might thermally shock damage the parts. In this event, an abort relay will trip, and the program will resume and time out under process atmosphere without the application of heat. Impedance match of the heating elements to the incoming power is accomplished through the conservatively rated 12KVA transformer driven by this power module.



Atmosphere Control

Customer supplied Hydrogen and Nitrogen gasses are admitted to the chamber through programmed Mass Flow Controllers (MFC). Gasses and flow rates can be changed from segment to segment. An interlock is included which provides for automatic Nitrogen purge in the event of loss of Hydrogen/Nitrogen or chamber pressure. An optional feature is a system which, when called to do so by the controller, humidifies a portion of the selected process gas via a water bubbler column. This gas is then recombined with the remaining dry process gas in a pre-selected ratio to obtain the desired process dewpoint (Wet Hydrogen Process). This bubbler column can humidify the process gas to a dewpoint level of up to 20° C. Higher dewpoints are achievable through a controlled temperature bubbler (optional).

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 Burn-off 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 (Thermocouple burn-up) assures that heating power is removed from the furnace in the event of sensor failure. Over temperature 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, vacuum purged with rate of rise and checked with an internal O₂ analyzer set to 1%. At the end of a programmed run the chamber is inhibited from being opened until the work has cooled to a predefined safe temperature.
- A Purge Assure Circuit provides an internally set minimum timed Nitrogen purge regardless of the program status whenever power or the program is interrupted.
- A normally open solenoid valve on the nitrogen purge circuit assures that the furnace is always under a constant flow of gas in the event of a power failure. This feature will purge the chamber of hydrogen so that the furnace chamber will have a safe atmosphere to be opened to.
- Camco furnaces comply to NFPA 86 Oven and Furnace regulations.

Documentation

Facilities information is supplied to assist with site preparation and installation. A hard and soft copy of the operating manual is supplied with the equipment. Pre-programmed recipes are included in the manual and controller to provide a convenient form to depict the desired process for entry into the PLC controller. The unit is shipped with several example program stored in memory, depicted in the recipe screen. 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 controller, SCR, recorder, dewpoint monitor, and other small items are supplied in our documentation. The touchscreen pages are full of information for easy to understand instructions and explanations for what is happening during the heat profile. The relatively simple operation of the furnace is well described and documented in the manual.

Facilities Requirements

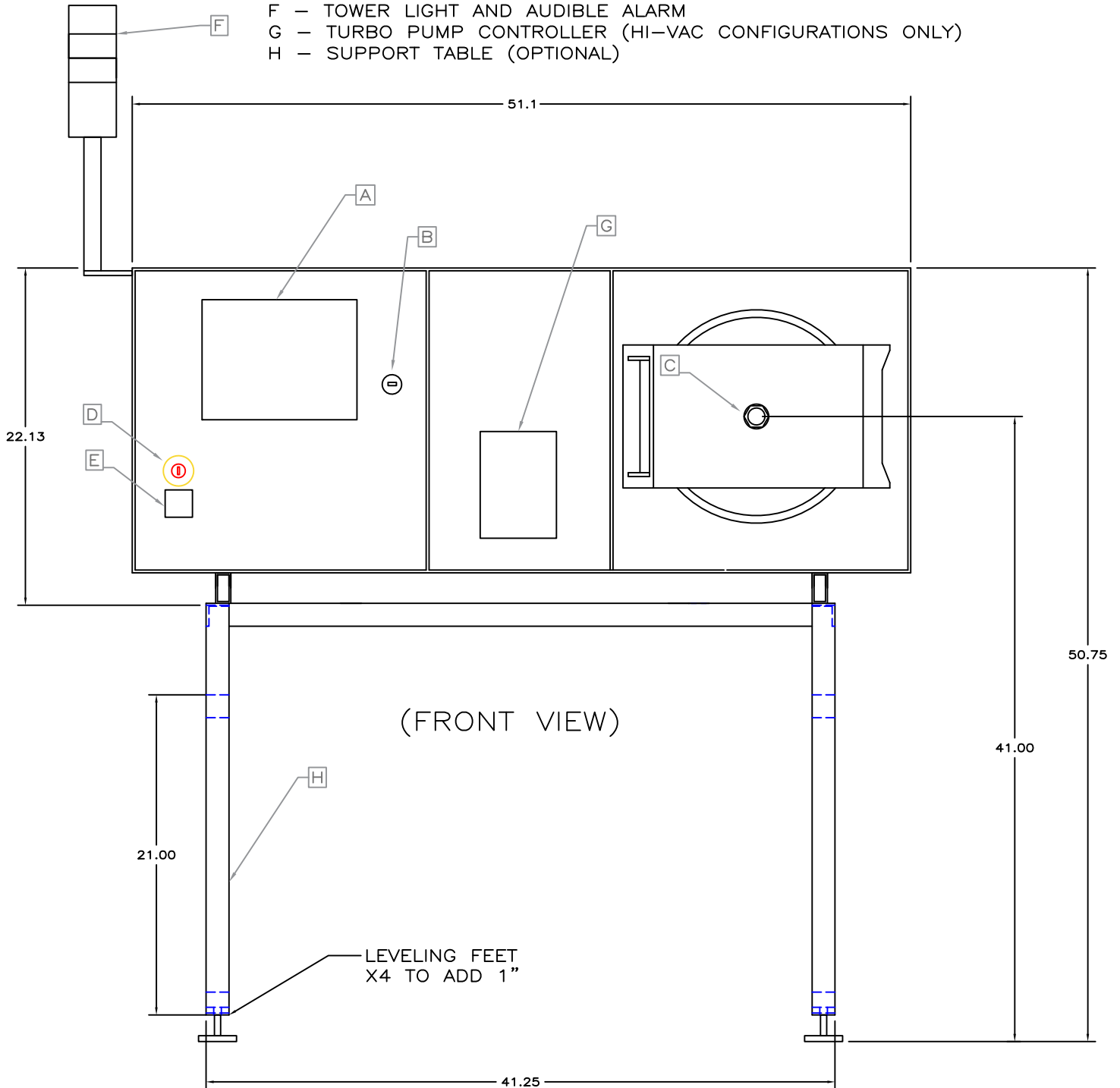
The G-ATM-16 is typically run at 220VAC single-phase, 60hz, requiring a 60A service. This furnace can be built to international specs if required. Please inquire with Camco for a complete list of available configurations. Additional equipment requirements and options are listed on the attached specification sheet.

NOTE: The 1200° version of this furnace has the same basic requirements, only it has less heat shielding. The benefits of this, should you never need to go above 1200° for any reason, is slightly improved cycle times, as the furnace will cool down faster with less shielding and mass.

REV.	DATE	DESCRIPTION
A	3/23/22	ADD SHEET FOR VAC/COMBO PLC
B	6/6/24	MOVE CHAMBER TO RIGHT SIDE

INTERFACE COMPONENTS

- A - HMI TOUCHSCREEN
- B - USB PORT
- C - SIGHT PORT
- D - EMERGENCY OFF SWITCH
- E - OVERTEMP LIMIT CONTROLLER
- F - TOWER LIGHT AND AUDIBLE ALARM
- G - TURBO PUMP CONTROLLER (HI-VAC CONFIGURATIONS ONLY)
- H - SUPPORT TABLE (OPTIONAL)



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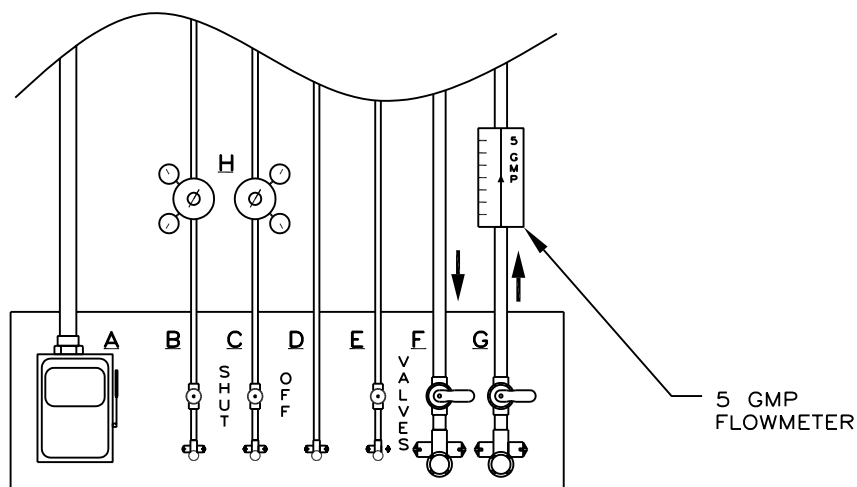
		TOL'S EXCPT AS NOTED fract. ±1/32 .XX ±.010 .XXX ±.005 .XXXX ±.0005 ANGLES ±1/2'	DRN.BY: PAB		 Concepts & Methods Company, Inc.		
			APP.BY:				
			DATE: 3/23/22				
			MAT: NOTED				
G— FURNACES			FINISH: DARK BLUE TEXTURED		TITLE: G FURNACE TABLE WITH SHELF WIDE		
USED ON TASK	FWO				DWG.NO: 89154	SHEET 5 OF 5	REV: B

UTILITIES: PREPARED AS SHOWN
BY CUSTOMER.

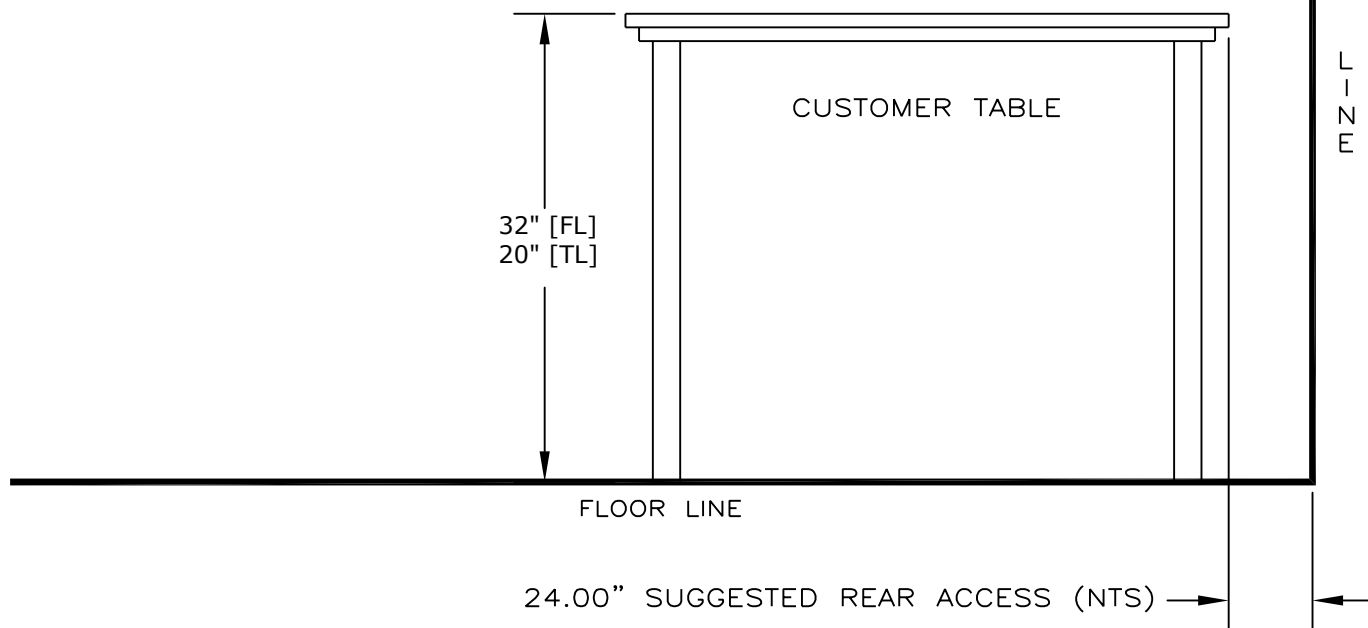
REV.	DATE	DESCRIPTION
A	3-1-06	DELETE 480V OPTION

- 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

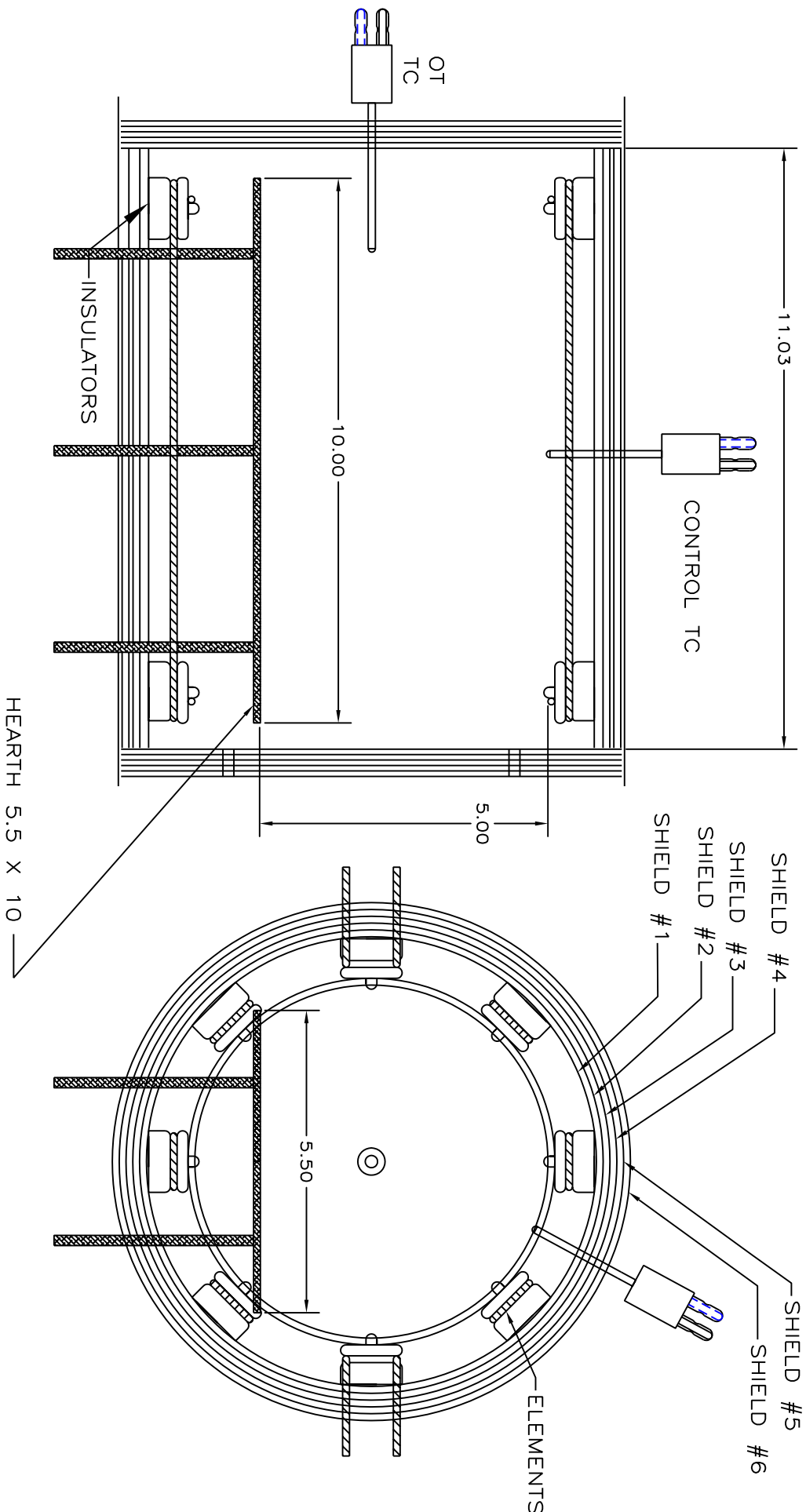


NOTE: (MAX. BACK PRESSURE 15 PSIG AT 4 G.P.M.)

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

G-15 HOT ZONE LAYOUT



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		TOL'S EXCEPT AS NOTED		DRN.BY: T BARULICH	CAWVE Concepts & Methods Company, Inc. TITLE: G-15 HOT ZONE LAYOUT DWG.NO: 98023 SHEET 4 OF 4 REV:
		fract.	± 1/32	APP.BY:	
		.XX	±.010	DATE: 5-1-07	
		.XXX	±.005	MAT: MOLY	
		.XXXX	±.0005	FINISH:	
USED ON TASK	FWO	ANGLES ± 1/2°			

Camco Model G-ATM-1600 FL
Hydrogen Coldwall Furnace
Front Loading

5" Wide x 5" High x 10" D., 1600° C



Top Loading [TL] Model:



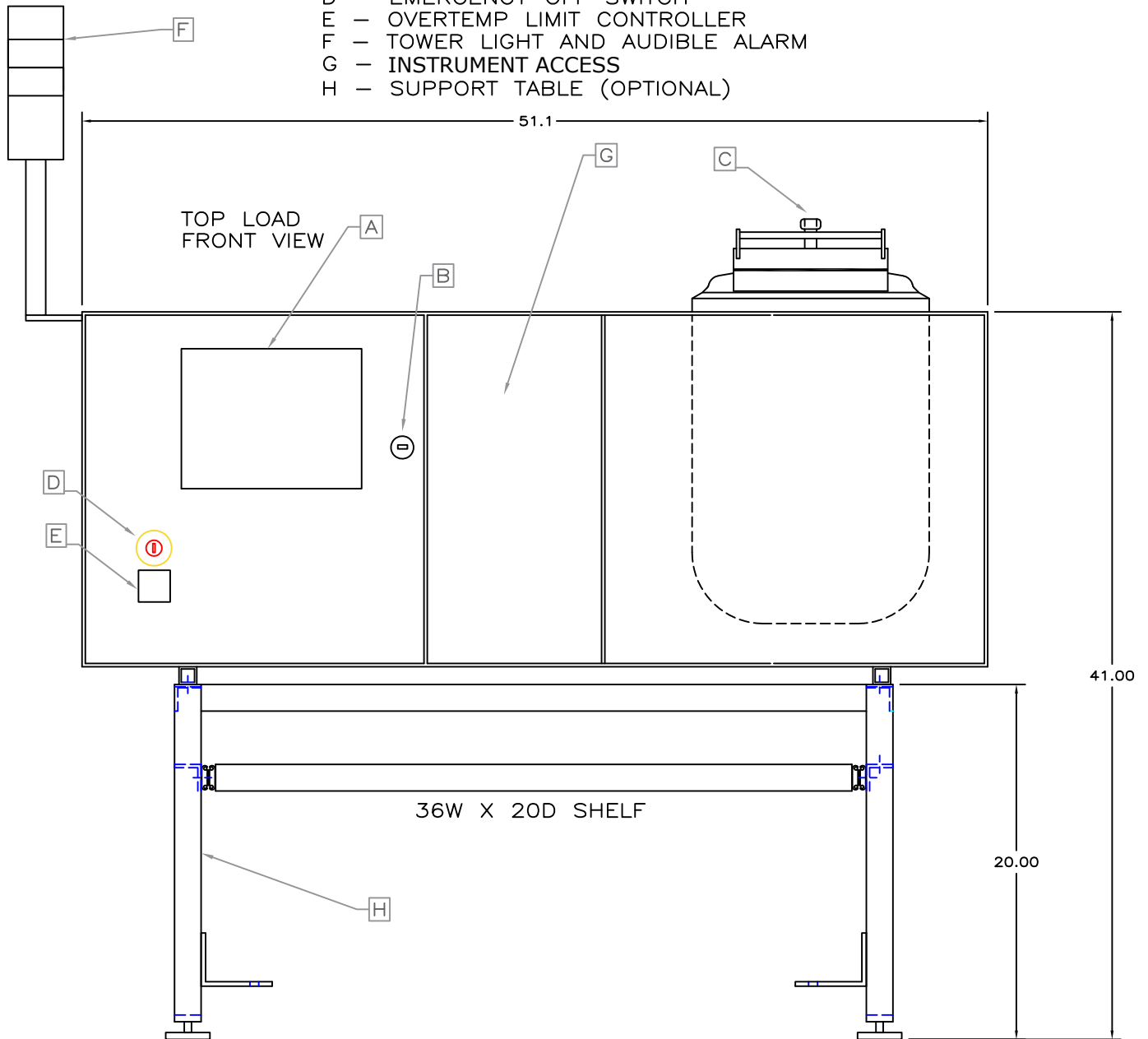
Top-Loading (vertical chamber) is identical in almost every other way to front-loading [FL]. The hot zone has marginally larger volume (full cylinder rather than D-Shaped) as well as slightly improved temperature uniformity, though it is usually less convenient to load. For certain part geometries and load configurations, however, the top loading model is preferred.



REV.	DATE	DESCRIPTION

INTERFACE COMPONENTS

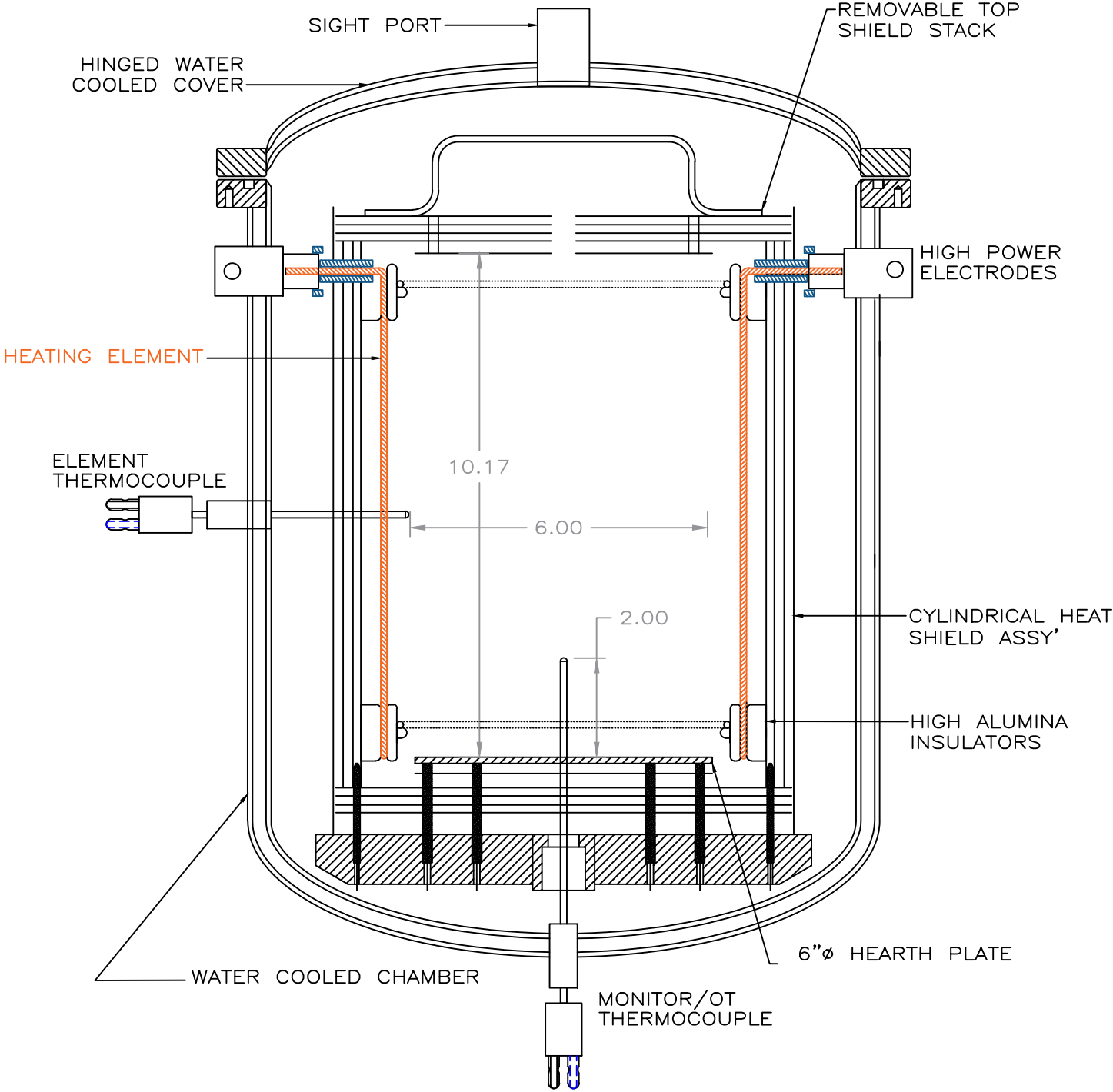
- A — HMI TOUCHSCREEN
- B — USB PORT
- C — SIGHT PORT
- D — EMERGENCY OFF SWITCH
- E — OVERTEMP LIMIT CONTROLLER
- F — TOWER LIGHT AND AUDIBLE ALARM
- G — INSTRUMENT ACCESS
- H — SUPPORT TABLE (OPTIONAL)



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		TOL'S EXCPT AS NOTED fract. ±1/32 .XX ±.010 .XXX ±.005 .XXXX ±.0005 ANGLES ±1/2"	DRN.BY: PAB		 Concepts & Methods Company, Inc.			
			APP.BY:					
			DATE: 11/2/20		TITLE: G FURNACE TABLE WITH SHELF VAC			
G-VAC TL FURNACES	757		MAT: NOTED		DWG.NO: 89154			
USED ON TASK	FWO		FINISH:		SHEET 3 OF 4		REV:	

REV.	DATE	DESCRIPTION



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		TOL'S EXCPT AS NOTED fract. ±1/32 .XX ±.010 .XXX ±.005 .XXXX ±.0005 ANGLES ±1/2"	DRN.BY: PAB		 Concepts & Methods Company, Inc.		
			APP.BY:				
			DATE: 10/28/20				
	757		MAT:		TITLE: HOT ZONE LAYOUT		
USED ON TASK	FWO		FINISH:		DWG.NO: 89023		SHEET OF