Installation, Operation and Maintenance Instructions
1200 °C Tube Furnace (3-zone) - TZF Model: 400mm
301 Controller + 2132 End Zone Controllers

TZF 12/38/400 + 301 Controller + 2132 End Zone Controllers
Contents
This manual is for guidance on the use of the Carbolite Gero product specified on the front cover. This manual should be read thoroughly before unpacking and using the furnace or oven. The model details and serial number are shown on the back of this manual. Use the product for the purpose for which it is intended.

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### 8.0 Fault Analysis
1.0 Symbols and Warnings

1.1 Switches and Lights

Instrument switch: when the instrument switch is operated the temperature control circuit is energised.

Heat light: the adjacent light glows or flashes to indicate that power is being supplied to the elements.

Heat switch: the switch disconnects power to the heating elements; unless this switch is OFF there is a danger of electric shock when inserting objects into the product.

1.2 General Warnings

DANGER – Electric shock. Read any warning printed next to this symbol.
WARNING: Risk of fatal injury.

DANGER – Hot surface. Read any warning printed next to this symbol.
WARNING: All surfaces of a product may be hot.

DANGER – Read any warning printed next to this symbol.
Caution – Double Pole/Neutral Fusing
2.0 Installation

2.1 Unpacking and Handling

When unpacking or moving the product always lift it by its base or by both ends of the main body. Never lift it by its work tube or the surrounding insulation. Use two or more people to carry the product and control box. Remove any packing material from inside the product before use.

If an optional or special stand is separately supplied, assemble the product on to it. Some models may be supplied for customer mounting and may require customer preparation of mounting components before installation.

NOTE: This product contains Refractory Ceramic Fibre (also known as Alumino Silicate Wool - ASW). For precautions and advice on handling this material see section 7.2.

2.2 Siting and Setting Up

Place the product on a level surface in a well ventilated area.

Site away from other sources of heat and on a non-flammable surface that is resistant to accidental spillage or hot materials.

The surface on which the equipment is mounted should be stable and not subject to movement or vibrations.

The height of the mounting surface is important to avoid operator strain when loading and unloading samples.

Unless otherwise stated elsewhere in this manual, ensure that there is at least 150 mm of free space around the back and sides of the product. Clear space is required above the product to dissipate heat.

Work tubes:

It is recommended that the work tube has either insulation plugs or radiation shields fitted to minimise heat loss from both ends of the work tube. If the work tube has open ends, a significant amount of energy could be radiated from the ends of the work tube. Adjacent surfaces should always be made from a non-flammable material.

Ensure that the ends of the work tube are positioned at least 500 mm away from any adjacent surface so that any energy radiated cannot heat an adjacent surface to a dangerous temperature.
Ensure that the product is placed in such a way that it can be quickly switched off or disconnected from the electrical supply.

If the product is supplied with a work tube or any accessories fit these into position.

For optimum temperature uniformity, insulating plugs should be placed in the tube ends as shown in fig.1. With a long work tube, the stem of the plug assembly should line up with the end of the tube as in fig.2. Alignment of radiation shields is similar to that of plugs.

If stainless steel seals with gas inlets are supplied, they are to be fitted as shown in fig.3; the stem of any insulating plug should touch the seal.

For vertical models with stainless steel seals, a hook and eye arrangement holds the upper insulating plug assembly.

Horizontal models: if heavy fittings are to be clamped to the end of an extended work tube they can increase the bending stress at the centre of the tube. Support such fittings in such a way that expansion of the tube is allowed.

If a metal work tube is being used in the product, ensure that it is earthed for operator safety.
2.0 Installation

**Fig 1** - Insulating Plug (standard length tube)

**Fig 2** - Insulating Plug (long work tube)

<table>
<thead>
<tr>
<th>Key</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>Tube</td>
</tr>
<tr>
<td>B</td>
<td>Insulating Plug</td>
</tr>
<tr>
<td>C</td>
<td>Stem</td>
</tr>
</tbody>
</table>
For assembly details refer to the separate work tube end seal manual.

Under no circumstances should any objects be placed on top of the product. Always ensure that any vents on the top of the product are clear of any obstruction. Always ensure all cooling vents and cooling fans (if fitted) are clear of any obstruction.

### 2.3 Electrical Connections

Connection by a qualified electrician is recommended.
2.0 Installation

The product covered by this manual normally requires a single phase A.C. supply, which may be Live to Neutral non-reversible, Live to Neutral reversible or Live to Live. Some models may be ordered for 3-phase use, which may be star or delta.

Check the product rating label before connection. The supply voltage should agree with the voltage on the label and the supply capacity should be sufficient for the current on the label.

The supply should be fused at the next size equal to, or higher than the current on the label. A table of the most common fuse ratings is also given towards the back of this manual. When the mains cable is factory fitted, internal fuses are also fitted. It is essential that the operator ensures that the product is correctly fused.

Products with a factory fitted supply cable are designed to be wired directly to an isolator or fitted with a line plug.

Products without a factory fitted supply cable require a permanent connection to a fused and isolated supply. The product's electrical access panel should be temporarily removed, and connections made to the internal terminals.

If the product is to be connected by line plug. The plug should be within reach of the operator and should be easy to remove.

When connecting the product to an isolating switch ensure that both conductors (single phase) or on all live conductors (three phase), and should be within reach of the operator.

The supply MUST incorporate an earth (ground).

Electrical Connection Details:

<table>
<thead>
<tr>
<th>Supply</th>
<th>Terminal Label</th>
<th>Cable Colour</th>
<th>Supply Types</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-phase</td>
<td>L</td>
<td>Brown</td>
<td>Live - Neutral</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>Reversible or Live-Live</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>to live</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>to either power conductor</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>(For USA 200-240V, connect L1)</td>
</tr>
<tr>
<td></td>
<td>N</td>
<td>Blue</td>
<td>to neutral</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>to the other power conductor</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>(For USA 200-240V, connect L2)</td>
</tr>
<tr>
<td></td>
<td>PE</td>
<td>Green/ Yellow</td>
<td>to earth (ground)</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>to earth (ground)</td>
</tr>
</tbody>
</table>
### 2.0 Installation

<table>
<thead>
<tr>
<th>3-phase</th>
<th>L1</th>
<th>Black</th>
<th>to phase 1</th>
</tr>
</thead>
<tbody>
<tr>
<td>L2</td>
<td>Black</td>
<td>to phase 2</td>
<td></td>
</tr>
<tr>
<td>L3</td>
<td>Black</td>
<td>to phase 3</td>
<td></td>
</tr>
<tr>
<td>N</td>
<td>Light Blue</td>
<td>to neutral (except delta)</td>
<td></td>
</tr>
<tr>
<td>PE</td>
<td>Green/ Yellow</td>
<td>to earth (ground)</td>
<td></td>
</tr>
</tbody>
</table>

DO NOT connect a product ordered for three phase use to a single phase supply or to the wrong type of three phase supply.
3.0 301 Controller

Due to the complex nature of the furnace or oven control the use of technical terms throughout this manual is unavoidable. Explanations of these terms can be found in the"Glossary of Terms".

3.1 PID control

This controller uses PID (Proportional Integral Derivative) temperature control. This type of control uses a complex mathematical control system to adjust the heating power and achieve the desired temperature.

3.2 Basic Operation of the 301 Controller

<table>
<thead>
<tr>
<th>Key</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>Display</td>
</tr>
<tr>
<td>B</td>
<td>Over-Temperature Key (if fitted) The Over-Temperature key is used to access the over-temperature menu. Note: Over-Temperature is an option.</td>
</tr>
<tr>
<td>C</td>
<td>Page Key The Page key is used to scroll through the parameters and switch between menus.</td>
</tr>
<tr>
<td>D</td>
<td>Timer Key The Timer key is used to start, view, pause and reset the timer.</td>
</tr>
<tr>
<td>E</td>
<td>Arrow Keys The Arrow keys are used to adjust the value of the selected parameter and pause the output power.</td>
</tr>
<tr>
<td>F</td>
<td>Over-Temperature Indicator (if fitted) The Over-Temperature indicator shows green in normal use. It flashes red when over-temperature is triggered and is constantly red when over-temperature is reset and waiting for the temperature to drop.</td>
</tr>
</tbody>
</table>
3.0 301 Controller

<table>
<thead>
<tr>
<th></th>
<th>Timer Indicator</th>
<th>The Timer indicator shows when the timer is active.</th>
</tr>
</thead>
<tbody>
<tr>
<td>H</td>
<td>Output Indicator</td>
<td>The Output indicator shows when the controller is switching on the heating elements.</td>
</tr>
</tbody>
</table>

3.2.1 Menu System

The 301 Controller is divided into two menus; the Home Menu and the Setup Menu. The Home Menu contains all the basic operating controls: setpoint, setpoint ramp rate and timer time. The Setup menu contains all the set up features: timer type, timer band, output power and customer calibration. The features available vary depending on operator input or product specification.

3.2.2 Navigation Diagram

The following diagram details how to navigate to the various menu options within the 301 Controller. At each option, values can be set using the arrow keys.
### 3.0 301 Controller

#### Diagram:
- **HM**: Home Menu
- **SM**: Setup Menu
- **OTHM**: Over-Temperature Home Menu
- **OTSM**: Over-Temperature Setup Menu

#### Legend:
- **Page Key**: Key to progress through menus.
- **Black**: Progress through the menu.
- **White**: Return to previous menu.
- **Hold for 1.5 seconds**: Press and hold for 1.5 seconds.
- **Keep Held**: Keep held until release.
- **Press Page Key multiple times**: Press the page key multiple times.

#### Table:

<table>
<thead>
<tr>
<th>Button</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>HM</td>
<td>Home Menu</td>
</tr>
<tr>
<td>SM</td>
<td>Setup Menu</td>
</tr>
<tr>
<td>OTHM</td>
<td>Over-Temp. Home Menu</td>
</tr>
<tr>
<td>OTSM</td>
<td>Over-Temp. Setup Menu</td>
</tr>
<tr>
<td>Page Key</td>
<td>Progress through menus</td>
</tr>
</tbody>
</table>

---

**Note:**
- Pressing certain keys multiple times may lead to additional menu options or settings.
Please note that the Over-Temperature Menu is only available when the Over-Temperature Protection option is fitted.

### 3.2.3 Basic Function Guide

<table>
<thead>
<tr>
<th>Abbreviation</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>HOLd</td>
<td>Used to pause the current program and set new parameters.</td>
</tr>
<tr>
<td>SPoC</td>
<td>Used to set the desired temperature (setpoint) of the product (°C).</td>
</tr>
<tr>
<td>SPrr</td>
<td>Used to set the heating rate of the product, e.g. increase by 5°C per minute.</td>
</tr>
<tr>
<td>t1, t2, t3, t4, t5</td>
<td>Indicates the timer type in use. See section 3.5 for more details.</td>
</tr>
<tr>
<td>tTyp</td>
<td>Used to set the timer type.</td>
</tr>
<tr>
<td>t.bnd</td>
<td>Available when t1 or t4 is in use. Allows the timer to start the countdown before the desired setpoint is reached.</td>
</tr>
<tr>
<td>rSt</td>
<td>Used to reset the timer.</td>
</tr>
<tr>
<td>OPHi</td>
<td>Used to set the maximum output power.</td>
</tr>
<tr>
<td>CLSt</td>
<td>Used to set the customer calibration type.</td>
</tr>
<tr>
<td>FAcT</td>
<td>Used to select the factory calibration settings.</td>
</tr>
<tr>
<td>PASS</td>
<td>Flashes when a password is required to access further options.</td>
</tr>
<tr>
<td>CCL1</td>
<td>Select to access the single point calibration option.</td>
</tr>
<tr>
<td>CCL2</td>
<td>Select to access the dual point calibration options.</td>
</tr>
<tr>
<td>OFSt</td>
<td>Used to set the single point calibration offset temperature (°C).</td>
</tr>
<tr>
<td>CALL</td>
<td>Used to set the low temperature point (°C) for dual point calibration.</td>
</tr>
<tr>
<td>CALH</td>
<td>Used to set the high temperature point (°C) for dual point calibration.</td>
</tr>
<tr>
<td>OFSL</td>
<td>Used to set the offset value for the low temperature point (°C) for dual point calibration.</td>
</tr>
<tr>
<td>OFSH</td>
<td>Used to set the offset value for the high temperature point (°C) for dual point calibration.</td>
</tr>
<tr>
<td>Ot</td>
<td>Used to set the Over-Temperature limit (°C).</td>
</tr>
<tr>
<td>Ott</td>
<td>Displayed when the Over-Temperature protection has been activated.</td>
</tr>
<tr>
<td>PV</td>
<td>Displayed before the current temperature when checking the Over-Temperature sensor temperature.</td>
</tr>
</tbody>
</table>
3.0 301 Controller

3.2.4 Home Display

The Home Display is the first display you see when the controller is switched on, it shows the actual temperature of the product. When entering the menus, the controller will automatically return to the Home Display if no keys are pressed for 30 seconds.

Finding the Home Display

- To find the Home Display from the Home Menu, press the Page key until the current temperature is shown on the display.
- To find the Home Display from the Setup Menu, press and hold the Page key for 1.5 seconds.

3.2.5 Hold Mode

‘Hold’ mode turns the output off; this allows parameters to be set without the controller instantly trying to control at the new settings.

When the output indicator is off, the Home Display flashes between the current temperature and HOLD.

To enter 'Hold' mode:

- Start at the Home Display.
- Press and hold the up and down Arrow keys together for 1.5 seconds
- The display will flash HOLD to show that ‘Hold’ mode has been entered.

To exit 'Hold' mode:

- Start at the Home Display.
- Press and hold the up and down Arrow keys together for 1.5 seconds OR start the timer (See "The Timer").
- Note: The ‘Hold’ mode function is disabled when the timer function is operating.
3.2.6 Checking the Temperature Setpoint from the Home Display

- Start at the Home Display.
- Press either the up or down Arrow key.
- The setpoint will show on the display for 3 seconds before returning to the home display.

3.2.7 Changing the Temperature Setpoint

- Start at the Home Display.
- Repeatedly press the Page key to scroll through the Home Menu until \( \text{SP}^\circ \text{C} \) is displayed.
- Use the up and down Arrow keys to alter the value.
- A single press of the up or down Arrow key shows the current setting.
- To alter this, either keep the key pressed or press it again. The value will then be stored without any further input.

3.2.8 Changing the Temperature Setpoint Ramp Rate

- Start at the Home Display.
- Repeatedly press the Page key to scroll through home menu until \( \text{SP}rr \) is displayed.
- Use the up and down Arrow keys to turn off or alter the value.
- A single press of either the up or down Arrow key shows the current setting. To alter, either keep pressed or press again. The value will then be stored without any further input.
- See section 3.4 for more information.

This will cause the product to heat as quickly as possible which may not be appropriate where the product contains sensitive ceramic components. For products with ceramic components, e.g. a tube furnaces fitted with a long ceramic work tube, use the ramp rate feature set with a low heating rate such as 5\( ^\circ \text{C} \) per minute (300\( ^\circ \text{C} \) per hour), to prevent damage.
3.2.9  Changing the Timer Time

- Start at the Home Display.
- Repeatedly press the Page key to scroll through the Home Menu until \( t1, t2, t3, t4 \) or \( t5 \) shows on the display.
- Use the up and down Arrow keys to turn off, or alter the value.
- A single press of either the up or down Arrow key shows the current setting (Hr:Min).
- To alter this, either keep pressed or press again. The value will then be stored without any further input.
- See 3.5 for more information.

3.3  Advanced Operation

3.3.1  Entering the Setup menu

- Start at the Home Display.
- Press and hold the Page key for 1.5 seconds
- The display will change to the first parameter in the Setup Menu.

3.3.2  Changing the Timer Type

- Start at the Home Display.
- Hold the Page key for 1.5 seconds to enter the set-up menu.
- Once entered, repeatedly press the Page key until \( t\text{yp} \) is displayed.
- Use the up and down Arrow keys to alter the value.

To alter this, either keep pressed or press again. The value will then be stored without any further input. A single press of the up or down key shows the current setting.

Note: This function is disabled when the timer is operating. see section 3.5 for more information on the timer types and functions.
3.3.3 Changing the Timer Band

- Start at the Home Display.
- Hold the Page key for 1.5 seconds to enter the Setup Menu.
- Once entered, repeatedly press the Page key until $bnd$ is displayed.
- Use the up and down Arrow keys to turn off or alter the value.

A single press of the up or down key shows the current setting. To alter this, either keep pressed or press again. The value will then be stored without any further input. See section 3.5 for more information.

Note: This is only available when timer type 1 or 4 is selected.

3.3.4 Changing the Maximum Output Power

Note: Output Power is a product specific setting and will not appear on all furnaces and ovens.

- Start at the Home Display.
- Hold the Page key for 1.5 seconds to enter the set-up menu.
- Once entered, repeatedly press the Page key until $OP.Hi$ is displayed.
- Use the up and down Arrow keys to alter the value.

A single press shows the current setting. To alter this, either keep pressed or press again. The value will then be stored without any further input.

Caution: Do not increase the power limit value to a value above the design level for the oven or furnace model, or to a value above that correctly calculated for silicon carbide elements. The heating elements could burn out, or other damage could be caused. Refer to the Fuses and Power Settings section of your product manual (section 10.0 for more information on power limits.)
3.0 301 Controller

3.3.5 Changing the Customer Calibration Type

- Start at the Home Display.
- Hold page key for 1.5 seconds to enter the set-up menu.
- Once entered, repeatedly press page key until CL5E is displayed.
- Use the up and down Arrow keys to display the current calibration type.
- Use the up and down Arrow keys to display the password screen.
- Use the up and down Arrow keys to enter the Calibration Password (see 3.3.6).
- Press the page key to confirm password. The value will then be stored without any further input.
- See section 3.8 for more information.

3.3.6 Calibration Password

Once entered the calibration password remains active for 30 seconds after leaving the set up menu to allow time to revisit if necessary.

The Calibration Password for this instrument is: 525

3.4 Temperature Setpoint Ramp Rate

3.4.1 Setpoint Ramp Rate

The SPrr controls the rate at which the temperature in a furnace or oven changes per minute. When SPrr has a numeric value, e.g. 5 °C/min, the product will attempt to heat or cool at that rate. When the value of SPrr = off, the product will heat or cool as quickly as possible.

Setpoint ramp rate is useful when materials susceptible to thermal shock are being heated.

3.4.2 Limitations of Setpoint Ramp Rate

The setpoint ramp rate should not be set higher than the maximum heat up or cool down rate of the furnace or oven.

The setpoint ramp rate only resets its start position when the ramp rate is changed or the controller is taken out of 'Hold' mode.

Changes in the temperature setpoint do not affect the ramp rate.

If the temperature is set below the current temperature of the furnace or oven then after a period of time adjusted to a temperature higher than the current temperature...
without adjustment of the ramp rate, the controller can become out of step and appear to switch off. Putting the controller into, then out of 'Hold' mode will reset the ramp rate and force the controller back into control.

### 3.5 The Timer

#### 3.5.1 Starting the Timer

- Start at the Home Display.
- Press the Timer key once to start the timer.

If the 301 Controller is in 'Hold' mode, pressing the Timer key will automatically exit 'Hold' mode and the controller will start to operate.

#### 3.5.2 Checking the Time Remaining

- Start at the Home Display
- Press the Timer key once to check the time remaining.
- The display will flash \( \ell \) 3 times.
- It will return to the Home Display automatically.

#### 3.5.3 Pausing the Timer

- Start at the Home Display
- Press and hold the Timer key for 1.5 seconds; the display alternately shows \( \ell \) \( \ell \) and the current temperature.
- To resume the timer, press the Timer key once.
3.5.4 Resetting the Timer

- When the timer count has ended, or the timer is paused, start at the Home Display.
- Press and hold the Timer key for 1.5 seconds.
- \textit{rSE} is displayed to indicate timer reset.

3.5.5 Timer Function Description

The 301 Controller has an in-built timer, which can be set to one of five types:

**Timer Type t1**

On pressing the Timer key; 'Timer Type 1' waits for the setpoint to be reached, then begins the countdown. On completion of the countdown, the product switches off power to the elements ('\textit{End}' flashes on the display).

**Timer Type t2**

On pressing the Timer key; 'Timer Type 2' starts the countdown immediately. On completion of the countdown, the product switches off power to the elements ('\textit{End}' flashes on the display).

**Timer Type t3**

On pressing the Timer key; 'Timer Type 3' immediately switches the product heating off and starts to countdown. On completion of the countdown, the furnace or oven switches on the power to the elements. This can be used to delay the start of heating.

**Timer Type t4**

On pressing the Timer key; 'Timer Type 4' waits for the setpoint to be reached, then begins the countdown. On completion of the countdown, the product continues to control as normal ('\textit{End}' flashes on the display).
Timer Type 5
On pressing the Timer key; 'Timer Type 5' starts the countdown immediately. On completion of the countdown, the product continues to control as normal ('End' flashes on the display).

3.5.6 The Timer Temperature Band
Timer type 1 or 4 starts the countdown when the setpoint temperature is reached. It is possible to set the timer running before the setpoint is reached by adjustment of the timer temperature band 't.bnd', e.g. 't.bnd' set to a value of 3 will result in the timer starting to countdown 3°C before the temperature setpoint is reached. This is useful when furnaces or ovens that take a long time to reach setpoint, are at a sufficiently high temperature for a specific customer process to occur.
### 3.5.7 Timer Function Table

<table>
<thead>
<tr>
<th>t_typ</th>
<th>Heating</th>
<th>On Pressing the Timer Key</th>
<th>During the Countdown</th>
<th>Completion of the Countdown</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>ON</td>
<td>ON</td>
<td>ON</td>
<td>OFF</td>
</tr>
<tr>
<td>t1</td>
<td>Timer</td>
<td>Starts when setpoint reached</td>
<td>Counts Down</td>
<td>OFF</td>
</tr>
<tr>
<td></td>
<td>Display</td>
<td>Flashes t1 3 times.</td>
<td>Current Temperature</td>
<td>Cycling Current Temperature/ End</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Shows Time remaining.</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Timer Indicator</td>
<td>Flashing until setpoint reached</td>
<td>ON</td>
<td>OFF</td>
</tr>
<tr>
<td>t2</td>
<td>Heating</td>
<td>ON</td>
<td>ON</td>
<td>OFF</td>
</tr>
<tr>
<td></td>
<td>Timer</td>
<td>Start Immediately</td>
<td>Counts Down</td>
<td>OFF</td>
</tr>
<tr>
<td></td>
<td>Display</td>
<td>Flashes t2 3 times</td>
<td>Current Temperature</td>
<td>Cycling Current Temperature/ End</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Shows Time remaining.</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Timer Indicator</td>
<td>ON</td>
<td>ON</td>
<td>OFF</td>
</tr>
<tr>
<td>t3</td>
<td>Output</td>
<td>OFF</td>
<td>OFF</td>
<td>ON</td>
</tr>
<tr>
<td></td>
<td>Timer</td>
<td>Starts Immediately</td>
<td>Counts Down</td>
<td>OFF</td>
</tr>
<tr>
<td></td>
<td>Display</td>
<td>Flashes t3 3 times</td>
<td>Time Remaining</td>
<td>END shows for 3 seconds then the Current Temperature.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Shows Time remaining</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Indicator</td>
<td>ON</td>
<td>ON</td>
<td>OFF</td>
</tr>
<tr>
<td>t4</td>
<td>Heating</td>
<td>ON</td>
<td>ON</td>
<td>ON</td>
</tr>
<tr>
<td></td>
<td>Timer</td>
<td>Starts when setpoint reached</td>
<td>Counts Down</td>
<td>OFF</td>
</tr>
<tr>
<td></td>
<td>Display</td>
<td>Flashes t4 3 times</td>
<td>Current Temperature</td>
<td>Cycling Current Temperature/ End</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Shows time remaining</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Timer Indicator</td>
<td>ON</td>
<td>ON</td>
<td>OFF</td>
</tr>
<tr>
<td>t5</td>
<td>Heating</td>
<td>ON</td>
<td>ON</td>
<td>ON</td>
</tr>
<tr>
<td></td>
<td>Timer</td>
<td>Starts Immediately</td>
<td>Counts Down</td>
<td>OFF</td>
</tr>
<tr>
<td></td>
<td>Display</td>
<td>Flashes t5 3 times</td>
<td>Current Temperature</td>
<td>Cycling Current Temperature/ End</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Shows Time remaining</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Timer Indicator</td>
<td>ON</td>
<td>ON</td>
<td>OFF</td>
</tr>
</tbody>
</table>
### 3.6 Ramp Dwell Programming

The 301 Controller has the capability to follow a Ramp Dwell program.

![Diagram showing SPrr, DT, and NCD phases]

#### 3.6.1 Setting up a Ramp Dwell program

**Set the Controller to Hold Mode:**

- Start at the home display
- Press and hold the up and down keys together for 1.5 seconds.
- The display will flash \textit{HOLD} to show that 'Hold' mode has been entered.
Set the Timer Type to \texttt{TYP}:

- Start at the home display.
- Press and hold the Page key for 1.5 seconds to enter the Setup Menu.
- Repeatedly press the Page key until \texttt{TYP} shows on the display.
- Use the up and down Arrow keys to set the value to \texttt{TYP}.
- The value will then be stored without any further input.
- See the 3.5 for more information.
- Press and hold down the page key for 1.5 seconds to return to Home Menu.

Set the Temperature Setpoint:

- Start at the Home Display.
- Repeatedly press the Page key until \texttt{SP°C} shows on the display.
- Use the up and down Arrow keys to alter the value (°C).
- The value will then be stored without any further input.
- Press and hold down the Page key for 1.5 seconds to return to the Home Menu.

Set the Setpoint Ramp Rate:

- Start at the Home Display.
- Repeatedly press the Page key until \texttt{SPrr} shows on the display.
- Use the up and down Arrow keys to alter the value (°C/Min).
- The value will then be stored without any further input.
- Press and hold down the Page key for 1.5 seconds to return to the Home Menu.
Set the Dwell Time

- Start at the Home Display.
- Repeatedly press the Page key until \( t \) shows on the display.
- Use the up and down Arrow keys to either switch off or alter the value (Hr:Min)
- The value will then be stored without any further input.
- Press and hold down the Page key for 1.5 seconds to return to the Home Menu.

Start the Timer

- Start at the Home Display.
- Pressing the Timer key starts the program.
- Pressing the Timer key will automatically exit 'Hold' mode if set (see section 3.2.5 for more information) and the controller will start to operate.
- Press and hold down the Page key for 1.5 seconds to return to the Home Menu.

### 3.7Maximum Output Setting

Depending on the furnace or oven model the maximum output power setting OP.Hi may be accessible or hidden.

For silicon carbide heated furnaces the parameter is accessible to allow compensation for element ageing, see the Fuses and Power Settings section of your product manual (section 10.0) for more information on power limits.

In many models the maximum output power setting depends on the supply voltage, refer to the Fuses and Power Settings section of your product manual (section 10.0).

### 3.8Customer Calibration

The controller is calibrated for life at manufacture, there may however be sensor or other system errors which affect the accuracy of the measured temperature. Customer calibration is used to compensate for these errors. Access to this function is disabled when the timer is operating.

The 301 Controller has three types of customer calibration: factory calibration, single point calibration and dual point calibration. See sections 3.3.5 & 3.3.6 to access these.

#### 3.8.1Factory Calibration - \( \text{FACT} \)

Factory calibration is the default setting, which has no offset adjustment. It simply displays the temperature measured by the control thermocouple.
3.8.2 Single Point Calibration - \textit{C.CL1}

Single point calibration uses an offset value to adjust the temperature over its whole range.

Single point calibration accurately sets the temperature for setpoint values close to the temperature at which the calibration offset is made. The accuracy is reduced for setpoint temperatures which are significantly higher or lower than the calibration offset.

Table showing examples of how to determine offset values:

<table>
<thead>
<tr>
<th>Measured Calibration Temp (°C)</th>
<th>Displayed Temp (°C)</th>
<th>Old Offset Value (°C)</th>
<th>New Offset Adjustment</th>
<th>New Offset Value (°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>252</td>
<td>250</td>
<td>0</td>
<td>2</td>
<td>2</td>
</tr>
<tr>
<td>248</td>
<td>250</td>
<td>0</td>
<td>-2</td>
<td>-2</td>
</tr>
<tr>
<td>252</td>
<td>250</td>
<td>2</td>
<td>2</td>
<td>4</td>
</tr>
</tbody>
</table>

The calibration temperature may be measured at the centre of the chamber or through a specially fitted port.

New Offset Value = Old Offset Value + New Offset adjustment

New Offset Adjustment = Measured Calibration Temperature – Displayed Temperature

Caution! - The procedure to determine the calibration temperature at the centre of a chamber is not covered in these instructions. If you are unsure how to do this safely, then seek advice as there is a risk of electric shock if done incorrectly.

3.8.3 Changing the Single Point Calibration Offset - \textit{OFSE}

- Start at the home display.
- Hold the Page Key for 1.5 seconds to access the Setup Menu.
- Repeatedly press the Page key until \textit{C.CL1} is displayed.
- Press the up or down Arrow keys to display the current calibration offset.
- If a password is required to access \textit{C.CL1}, enter the password using the up and down Arrow keys and press the Page key to accept. You will be returned to \textit{C.CL1}.
- Use the up and down Arrow keys to scroll to \textit{C.CL1}.
- Press the Page key to access \textit{OFSE}.
- Press the up or down Arrow keys to change the offset value.
- The value will then be stored without any further input.

Once \textit{C.CL1} has been selected as the customer calibration type, it is possible to start from the home display and go to \textit{OFSE} directly, and enter the password at this point when the calibration adjustment is required again.

3.8.4 Dual Point Calibration - \textit{C.CL2}

Dual point calibration uses two offset values at two corresponding temperatures to progressively change the calibration as the temperature increases or decreases. This is a more accurate representation of how the temperature difference will occur.
Caution! - Do not make $\text{CAL.L}$ and $\text{CAL.H}$ the same value as the controller will not work correctly and could cause the furnace or oven to overheat.

3.8.5 Changing the Calibration, Low Temperature - $\text{CAL.L}$

- Start at the home display.
- Hold the Page Key for 1.5 seconds to access the Setup Menu.
- Press the Page key until $\text{CL.5E}$ is displayed.
- Press the up or down Arrow keys to display the current calibration offset.
- If a password is required to access $\text{CL.2}$, enter the password using the up and down Arrow keys and press the Page key to accept. You will be returned to $\text{CL.5E}$.
- Use the up and down Arrow keys to scroll to $\text{CL.2}$.
- Press the Page key to access $\text{CAL.L}$.
- Press the up or down Arrow keys to change the offset value.
- The value will then be stored without any further input.

Once $\text{CL.2}$ has been selected as the customer calibration type, it is possible to start from the home display and go to $\text{CAL.L}$ directly (or any of the other settings in $\text{CL.2}$) and enter the password at this point when calibration adjustment is required again.

3.8.6 Changing the Calibration, Low Temperature Offset - $\text{OFS.L}$

- Start at the home display.
- Hold the Page Key for 1.5 seconds to access the Setup Menu.
- Repeatedly press the Page key until $\text{CL.5E}$ is displayed.
- Press the up or down Arrow keys to display the current calibration offset.
- If a password is required to access $\text{CL.2}$, enter the password using the up and down Arrow keys and press the Page key to accept. You will be returned to $\text{CL.5E}$.
- Use the up and down Arrow keys to scroll to $\text{CL.2}$.
- Press the Page key twice to access $\text{OFS.L}$.
- Press the up or down Arrow keys to change the offset value.
- The value will then be stored without any further input.

3.8.7 Changing the Calibration, High Temperature - $\text{CAL.H}$

- Start at the home display.
- Hold the Page Key for 1.5 seconds to access the Setup Menu.
- Repeatedly press the Page key until $\text{CL.5E}$ is displayed.
- Press the up or down Arrow keys to display the current calibration offset.
- If a password is required to access $\text{CL.2}$, enter the password using the up and down Arrow keys and press the Page key to accept. You will be returned to $\text{CL.5E}$.
- Use the up and down Arrow keys to scroll to $\text{CL.2}$.
- Press the Page key three times to access $\text{CAL.H}$.
- Press the up or down Arrow keys to change the offset value.
• The value will then be stored without any further input.

3.8.8 Changing the Calibration, High Temperature Offset - **OFS.H**

• Start at the home display.
• Hold the Page Key for 1.5 seconds to access the Setup Menu.
• Repeatedly press the Page key until **Cl SE** is displayed.
• Press the up or down Arrow keys to display the current calibration offset.
• If a password is required to access **ClL2**, enter the password using the up and down Arrow keys and press the Page key to accept. You will be returned to **Cl SE**.
• Use the up and down Arrow keys to scroll to **ClL2**.
• Press the Page key four times to access **OFS.H**.
• Press the up or down Arrow keys to change the offset value.
• The value will then be stored without any further input.
3.9 Over-Temperature Protection

![Image of 301 controller with Over-Temperature protection indicator]

This controller may be fitted with the over-temperature protection option. If the over-temperature option is fitted the 301 display will include the Over-Temperature key and indicator (as shown in the diagram above). An independent control circuit and temperature sensor provide the over-temperature protection.

There are two uses for over-temperature protection:

1. To prevent a sample being heated in a furnace or oven from over-heating.
2. To provide an extra safety system to prevent the furnace or oven from heating in the event of a fault.

3.9.1 Over-Temperature (O/T) home display

When the Over-Temperature key is pressed and held the O/T home display is shown.

The home display shows the over-temperature limit setting.

Finding the O/T home display from the O/T Home Menu:

- Press and hold the Over-Temperature key.
- Repeatedly press the Page key until the O/T limit value shows on the display.

Finding the O/T home display from the O/T Setup Menu:

- Press and hold the Over-Temperature key.
- Press and hold the Page key for 1.5 seconds.
3.9.2 Changing the Over-Temperature Limit

Note: If protection of the sample being processed is required, the over-temperature limit is normally set 15 °C above the temperature setpoint of the controller. If protection of the furnace or oven is required, the over-temperature limit is normally set 15 °C above the maximum setpoint of the furnace or oven.

- Start at the home display.
- Press and hold the Over-Temperature key.
- Repeatedly press the Page key until OE shows on the display.
- Use the up and down Arrow keys to change the offset value.

A single press shows the current setting. To alter either keep pressed or press again. The value will then be stored without any further input.

3.9.3 Checking the Over-Temperature Sensor Temperature

- Start at the home display.
- Press and hold the Over-Temperature key.
- Press and hold the Page key for 1.5 seconds.
- Current temperature (PU) is displayed for 1 second, followed by the over-temperature sensor value for 3 seconds; this sequence is then repeated.
3.9.4 Over-Temperature Protection Calibration

The over-temperature protection circuit can be calibrated in the same way as the main controller. However, this is not normally necessary as the level of accuracy required for over-temperature protection is not as critical as it is for the main control temperature.

- Start at the home display.
- Press and hold the Over-Temperature key.
- Press and hold the Page key for 1.5 seconds.
- Repeatedly press the Page key until CLSE is displayed.

Now follow the procedure in "Customer Calibration".

3.9.5 Over-Temperature Activation

During normal operation, the over-temperature indicator is green. If the temperature of the furnace or oven goes above the over-temperature limit, the over-temperature circuit activates. The power supply to the heating elements is switched off and the over-temperature indicator changes to flashing red.

Pressing the over-temperature key shows ÖSE in the display to indicate that the over-temperature has been triggered.

The reason for the over-temperature activation must be investigated; an incorrect setting in the over-temperature limit is may be the cause. When you are satisfied with the reason for the over-temperature activation it can be reset.
3.9.6 Resetting Over-Temperature Activation

- Start at the home display.
- Press and hold the Over-Temperature key until **OT** is displayed.
- Repeatedly press the Page key until **OT** is displayed and the red indicator stops flashing.
- Press the up or down Arrow key to check the over-temperature limit value.
- Press the up or down Arrow key to alter the value if necessary.
- Press the Page key to return to the over-temperature display.

The over-temperature has now been reset.

If the temperature is still above the over-temperature setpoint then over-temperature indicator will be red but not flashing.

When the temperature falls below the over-temperature limit, the indicator changes back to green.

When the current temperature falls below the over-temperature setpoint, the furnace/oven starts to heat again.
3.10 RS232 Communication Option

The 301 Controller can be supplied with the capability to communicate with other devices via an RS232 link. If this option has been ordered, the furnace or oven will be supplied with a 9 pin ‘D’ socket for connecting to an external device. Plugging this into a computer will allow the controller to be accessed from that computer. The computer must have appropriate communication software installed such as Eurotherm’s ‘i-Tools’.

**RS232 Communication Addressing:**

<table>
<thead>
<tr>
<th>Modbus Address</th>
<th>= 2</th>
</tr>
</thead>
<tbody>
<tr>
<td>(Main)</td>
<td></td>
</tr>
<tr>
<td>Modbus Address</td>
<td>= 3</td>
</tr>
<tr>
<td>(O/Temp)</td>
<td></td>
</tr>
<tr>
<td>Baud Rate</td>
<td>= 9600</td>
</tr>
<tr>
<td>Byte Format</td>
<td>= 8</td>
</tr>
</tbody>
</table>

**RS232 Communication Cables**

Connecting the furnace or oven to a computer is done via a "straight" cable as follows:

<table>
<thead>
<tr>
<th>Product end of cable</th>
<th>RS232 Cable: product to PC</th>
<th>Computer end of cable</th>
</tr>
</thead>
<tbody>
<tr>
<td>female 9-pin</td>
<td></td>
<td>9-pin male</td>
</tr>
<tr>
<td>Rx</td>
<td>3</td>
<td>3</td>
</tr>
<tr>
<td>Tx</td>
<td>2</td>
<td>2</td>
</tr>
<tr>
<td>Com</td>
<td>5</td>
<td>5</td>
</tr>
</tbody>
</table>

3.11 Temperature Controller Replacement

Before handling the controller: wear an anti-static wrist strap or otherwise avoid any possibility of damage to the unit by static electricity. Refer to the detailed instructions supplied with the replacement controller.

If the temperature controller is fitted to the back of the control panel it can be separated from the base by removal of the screws. If the temperature controller is fitted inside the product base it can be separated from the top by removal of the screws.
### 3.12 Glossary of Terms

<table>
<thead>
<tr>
<th>Term</th>
<th>Description</th>
<th>Unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>Setpoint (SP)</td>
<td>The target temperature the furnace or oven is trying to reach.</td>
<td>°C</td>
</tr>
<tr>
<td>Setpoint Ramp Rate (SPrr)</td>
<td>The speed at which the furnace or oven is allowed to heat up or cool down</td>
<td>°C/Min</td>
</tr>
<tr>
<td>Element</td>
<td>The heating device used in the furnace or oven.</td>
<td>-</td>
</tr>
<tr>
<td>Thermocouple</td>
<td>A thermoelectric device for measuring temperature.</td>
<td>-</td>
</tr>
<tr>
<td>PID</td>
<td>Proportional Integral Derivative: the control system used by the controller</td>
<td>-</td>
</tr>
<tr>
<td>Over-Temperature</td>
<td>The condition which a furnace or oven may enter if part of the main control circuit fails.</td>
<td>-</td>
</tr>
<tr>
<td>Over-Temperature Protection</td>
<td>A system to prevent the product or process being damaged if it has gone into an Over-Temperature condition.</td>
<td>-</td>
</tr>
<tr>
<td>Furnace or Oven</td>
<td>This refers to the product purchased from Carbolite Gero</td>
<td>-</td>
</tr>
</tbody>
</table>

### 3.13 Controller Fault

#### Fault Code Diagnostic Table

<table>
<thead>
<tr>
<th>Error Code</th>
<th>Explanation</th>
<th>Actions</th>
</tr>
</thead>
<tbody>
<tr>
<td>$5br$</td>
<td>Temperature sensor failure</td>
<td>Check all terminal connections between the temperature sensor (thermocouple) and temperature controller. It is recommended to loosen then tighten the screws in the terminal blocks in case the connections are oxidised. If this does not correct the error then replace the furnace or oven temperature sensor (thermocouple).</td>
</tr>
<tr>
<td>$0000$</td>
<td>Input over range</td>
<td></td>
</tr>
<tr>
<td>$-000$</td>
<td>Input under range</td>
<td></td>
</tr>
<tr>
<td>$E$ followed by numerical code</td>
<td>Controller Error</td>
<td>Turn the furnace or oven off and back on to see if this clears the error. If not contact Carbolite Gero Service – (see back cover)</td>
</tr>
</tbody>
</table>
4.0 2132 Controller

4.1 Description

The 2132 Controller is made by Eurotherm, and is fitted and configured by Carbolite Gero for immediate use. It is a digital instrument with PID control algorithms.

The 2132 Controller features:

- Easy use as a simple temperature controller, where on setting the required temperature the controller immediately attempts to reach and maintain it.
- A ramp-to-setpoint feature, which may be used to limit the heating (or cooling).
- A timer function which allows for heating for a predetermined time, either from start or from reaching temperature; or alternatively for delaying the start of heating.
- An alarm output which may be used in conjunction with the timer, for example to give an audible alarm at the end of the timing period.

4.2 2132 Controller Operation

4.2.1 Controls

Most Carbolite Gero products are fitted with an instrument switch which cuts off power to the controller and other parts of the control circuit.

To operate the controller, power must be supplied to the product and the instrument switch must be on. If a time switch is included in the product circuit, this must be in the 'ON' position.

When an over-temperature condition occurs, the controller cuts the power to a contactor, which in turn cuts power to the heating elements. Power is not restored until the controller is 'reset'.

Some components will operate after the over-temperature feature isolates the power supply e.g. cooling fans will continue to operate, provided that there is a power supply to the product. In some cases the product may not do so, if other options (such as a door switch) are fitted.
When switched on, the controller lights up, goes through a short test routine and then displays the measured temperature or the over-temperature setpoint.

The page key allows access to parameter lists within the controller.

A single press of the page key displays the temperature units, normally set to °C; further presses reveal the lists indicated in the navigation diagram.

The scroll key allows access to the parameters within a list. Some parameters are display-only; others may be altered by the operator.

A single press of the scroll key in the 'Home' list displays the temperature units; further presses reveal the parameters in the current list indicated in the navigation diagram.

To return to the 'Home' list at any time, press page and scroll together, or wait for 45 seconds.

The down and up keys are used to alter the setpoint or other parameter values.

4.2.3 Basic Operation

Normally no operator action is required other than entering the setpoint, as the controller starts to control on being switched on, as described above.

4.2.4 Altering the Setpoint

With the display at 'Home', showing the measured temperature, press down or up once to display the setpoint; press again or hold down to adjust it. The display returns to the measured temperature when no key is pressed for 30 seconds.
4.2.5 Stopping and Starting Control

It is possible to stop and start the controller without altering the setpoint. Press scroll \( \downarrow \) until the legend 'm-A' (manual/auto) appears. In this controller, manual means OFF and auto means ON. Press down \( \downarrow \) or up \( \uparrow \) once to show the current on/off state: 'mAn' for OFF and 'Auto' for ON. Press down \( \downarrow \) or up \( \uparrow \) to change between manual and auto (off and on) as required.

**Note that timer modes 1 & 3 set the controller to 'mAn' at the end of the timing period. If the controller unexpectedly does not control it may be in manual, possibly as the result of previous use of the timer function.**

4.2.6 Altering the Ramp Rate

It is only possible to limit the rate of heating by setting a ramp rate if the timer feature is not in use.

To enable direct setting of the ramp rate, first ensure that the 'StAt' parameter and 'dwEll' parameter are both set to OFF (see sections 4.3.1 and 4.3.2).

Press scroll \( \downarrow \) until 'SPrr' (setpoint ramp rate) is displayed. Use down \( \downarrow \) or up \( \uparrow \) to display and adjust the value.

The ramp rate sets the maximum rate of heating or cooling in degrees per minute. A value of OFF cancels the ramp rate, allowing heating and cooling at the maximum rate. When this feature is in use, there is a “working setpoint” which can be viewed at any time by scrolling to 'w.SP' and pressing \( \downarrow \) or \( \uparrow \).

Fig 1 and fig 2 indicate the possible difference between operating without and with a ramp-to-setpoint value (depending on the load and the value used).
4.3 Operating with the Timer

This controller can be used as a process timer allowing timed heating or timed delay, according to the options in the table. There are 5 timer modes, but 2 of them are affected by whether the setpoint ramp rate feature is being used, making 7 entries in the table. The table also shows the status of the timer light on the controller. A visual impression of the different modes is given in fig 3.

<table>
<thead>
<tr>
<th>Key</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>T1</td>
<td>Temperature</td>
</tr>
<tr>
<td>T2</td>
<td>Time</td>
</tr>
<tr>
<td>SP</td>
<td>Setpoint</td>
</tr>
<tr>
<td>WSP</td>
<td>Working Setpoint</td>
</tr>
<tr>
<td>AT</td>
<td>Actual Temperature</td>
</tr>
<tr>
<td>Timer Mode</td>
<td>Description</td>
</tr>
<tr>
<td>-----------------------------------</td>
<td>-----------------------------------------------------------------------------</td>
</tr>
<tr>
<td>mode 1 Timed dwell and switch off</td>
<td>The timer starts timing when the actual temperature is within 1 °C of the setpoint. At the end of the timing period, control switches off (i.e. goes into Manual) to allow cooling and 'End' flashes on the display.</td>
</tr>
<tr>
<td>mode 2 Timed dwell and stay on</td>
<td>The timer starts timing when the actual temperature is within 1 °C of the setpoint. At the end of the timing period, control remains on, maintaining the setpoint temperature and 'End' flashes on the display.</td>
</tr>
<tr>
<td>mode 3, with SPrr off Time from cold and switch off</td>
<td>The timer starts timing immediately. At the end of the timing period, control switches off (i.e. goes into Manual) to allow cooling and 'End' flashes on the display.</td>
</tr>
<tr>
<td>mode 3, with SPrr active Dwell from working setpoint and switch off</td>
<td>The timer starts timing when the working setpoint is within 1 °C of the setpoint. At the end of the timing period, control switches off (i.e. goes into Manual) to allow cooling and 'End' flashes on the display.</td>
</tr>
<tr>
<td>mode 4, with SPrr off Time from cold and stay on</td>
<td>The timer starts timing immediately. At the end of the timing period, control remains on, maintaining the setpoint temperature and 'End' flashes on the display.</td>
</tr>
<tr>
<td>mode 4, with SPrr active Dwell from working setpoint and stay on</td>
<td>The timer starts timing when the working setpoint is within 1 °C of the setpoint. At the end of the timing period, control remains on, maintaining the setpoint temperature and 'End' flashes on the display.</td>
</tr>
<tr>
<td>mode 5 Delayed switch on</td>
<td>The timer starts timing immediately and control starts at the end of the timing period. There is no 'End' condition in this mode.</td>
</tr>
</tbody>
</table>
4.3.1 Setting the Timer Mode

Scroll to 'tm.OP'; use ▲ or ▼ to view and alter the mode. The mode shows as 'OPt.1' to 'OPt.5'.

It is not possible to alter the mode while the timer is operating; if the mode cannot be altered, scroll to the 'StAt' parameter and set its value to OFF.

4.3.2 Setting the Time Period

Method 1

Scroll to 'tmr' (time remaining). Use ▲ or ▼ to view the remaining time; the units are always in minutes. Use ▲ or ▼ to set or alter the time. Setting 'tmr' automatically activates the timer; the 'm-A' parameter changes to 'Auto' and the 'StAt' parameter changes to run.

Note that the 'tmr' display shows 0 (zero) during the last minute of timing and also shows 0 when the time has expired. The timer light indicates whether timing is still in progress.

Method 2

Scroll to 'dwEll' and use ▲ or ▼ to set the timing duration. The advantage of method 2 is that 'dwEll' need only be set once if repeated use of the same time period is required.

Scroll to 'StAt' and use ▲ or ▼ to set the parameter value to run. This copies the dwell time into 'tmr' and activates the timer as in method 1.

4.3.3 Running with the Timer

Once the timer is activated by method 1 or 2 above, the control sequence depends on the 'Timer' mode, as previously given in the table. Fig 3 gives another representation of the timer action.
**Fig 3 - Timer Modes**

<table>
<thead>
<tr>
<th>Key</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>T1</td>
<td>Temperature</td>
</tr>
<tr>
<td>T2</td>
<td>Time</td>
</tr>
<tr>
<td>SP</td>
<td>Setpoint</td>
</tr>
<tr>
<td>WSP</td>
<td>Working Setpoint (if setpoint ramp rate active)</td>
</tr>
<tr>
<td>AT</td>
<td>Actual Temperature</td>
</tr>
<tr>
<td>M245</td>
<td>Modes 2, 4 &amp; 5</td>
</tr>
<tr>
<td>M13</td>
<td>Modes 1 &amp; 3</td>
</tr>
<tr>
<td>TM</td>
<td>Timing</td>
</tr>
<tr>
<td>E</td>
<td>End</td>
</tr>
<tr>
<td>1</td>
<td>Mode 5</td>
</tr>
<tr>
<td>2</td>
<td>Reaching Temperature Modes 1 &amp; 2</td>
</tr>
<tr>
<td>3</td>
<td>Modes 1 &amp; 2</td>
</tr>
<tr>
<td>4</td>
<td>Modes 3 &amp; 4 with setpoint ramp rate</td>
</tr>
<tr>
<td>5</td>
<td>Modes 3 &amp; 4 with setpoint ramp rate off</td>
</tr>
<tr>
<td>6</td>
<td>Reaching temperature and continuing temperature Mode 5</td>
</tr>
<tr>
<td>7</td>
<td>Continuing at temperature modes 2 &amp; 4, or cooling down modes 1 &amp; 3</td>
</tr>
</tbody>
</table>

### 4.3.4 Stopping the Timer

To stop the timer at any time while it is operating, change the 'StAt User Calibration' parameter to OFF. This is the same as reducing 'tmr' to zero. The controller then acts as though it has reached the end of the time period.
4.3.5 End of Time Period

Modes 1 and 3: heating stops at the end of timing; the 'm-A' parameter changes to 'mAn'.

Modes 2 and 4: heating continues at the end of timing; the 'm-A' parameter remains at 'Auto'.

Mode 5: heating starts at the end of the timing period; the 'm-A' parameter remains at 'Auto'.

In modes 1 to 4 the alarm message 'End' flashes on the display at the end of timing; the 'StAt' parameter remains at run.

In mode 5 there is no 'End' message; the 'StAt' parameter changes to OFF at the end of timing.

4.3.6 Cancelling the Alarm

To acknowledge (cancel) the 'End' alarm, press page and scroll together; the 'StAt' parameter changes to OFF.

Alternatively cancel the alarm by directly changing the 'StAt' parameter from run to OFF.

4.3.7 Program Example

To heat up at 10 °C per minute to 500 °C; to hold at 500 °C for 1 hour; then to allow to cool down.

(This example uses timing mode 1, as on the first row of the timer table, but also includes the use of ramp rate).

To create this program

1. Start with display at home; use arrow keys to alter the setpoint to 500.
2. Press scroll until 'sp.rr' shows; use arrow key to set value to 10 (if you do not want to limit the ramp rate, ignore this step or set the value to OFF)
3. Press scroll until 'tm.op' shows; use arrow key to set value to opt.1
4. Press scroll until 'dwell' shows; use arrow key to set value to 60

   To operate this program

5. Press scroll until 'stat' shows; use arrow key to set value to run
   - heating starts when run is set;
   - timing starts when the working setpoint reaches 499 °C;
   - heating stops 61* minutes later and 'End' flashes on the display.
6. Cancel 'End' by pressing page and scroll together.

* note that the timer runs for an extra minute, when tmr has counted down to zero; allow for this when testing the system with short durations such as 1 or 2 minutes.

4.4 Altering Power Limit

Overview

Depending on the furnace or oven model the power limit parameter OP.Hi (Output High) may be accessible or hidden.
For silicon carbide heated furnaces the parameter is accessible to allow for compensation for element ageing. In wire-heated chamber or tube furnaces, reducing the power limit is a convenient method of improving control at low temperatures, as outlined below.

The power limit may be set to zero to permit demonstration of the controls without heating.

In many models the power limit setting depends on the supply voltage; usually the furnace or oven manual contains details: if in doubt, contact Carbolite Gero for advice.

The power limit parameter does not apply to the over-temperature controller, if fitted.

**Altering the value**

Press page .{47} until oP (output list) is displayed. Press scroll .{47} until OP.Hi (Output High) is displayed. Press down ▼ or up ▲ once to display the value of OP.Hi and write down the value. To alter the value, use down ▼ or up ▲.

**Note:** setting the value to zero prevents the furnace or oven from heating.

Caution: Do not increase the power limit value to a value above the design level for the oven or furnace model, or to a value above that correctly calculated for silicon carbide elements. The heating elements could burn out, or other damage could be caused.

**Control at Low Temperatures**

If a product is to be used at temperatures much lower than its design maximum, control stability can often be improved by reducing the power limit. Remember to make a record of the original setting before altering the power limit.

Example: It is desired to operate a 1200 °C furnace at 300 °C. The normal control settings can be expected to cause excessive overshoot as the furnace reaches temperature. If the power limit OP.Hi is normally set to 100%, try a setting of 40%. This should greatly reduce the overshoot. (There is no firm calculation rule to get this example setting of 40% – experimentation may be required to achieve a good result. Avoid power limits below approximately 30% – control accuracy is reduced at such levels.)

Depending on the furnace or oven model the power limit parameter OP.Hi (Output High) may be accessible or hidden.

For silicon carbide heated furnaces the parameter is accessible to allow for compensation for element ageing. In wire-heated chamber or tube furnaces, reducing the power limit is a convenient method of improving control at low temperatures, as outlined above.

The power limit may be set to zero to permit demonstration of the controls without heating.

In many models the power limit setting depends on the supply voltage; usually the furnace or oven manual contains details: if in doubt, contact Carbolite Gero for advice.

**User Calibration**
The controller is calibrated for life at manufacture against known reference sources, but there may be sensor errors or other system errors. User calibration allows compensation for such errors and this controller allows for a user 2-point calibration. This setting is password protected to avoid accidental alteration.

Page to iP, scroll to CAL.P and use up ▲ to alter the password. The password is 3. If the correct password is entered, the display shows PASS. Scroll to CAL and use up ▲ or down ▼ to observe the setting FACt (factory values, as manufactured) or USEr (user values). Change to USEr.

NOTE: before checking the calibration of the controller, or of the complete system, remember to reset the controller to factory calibration values by setting the CAL.P parameter to FACT.

To enter a user calibration, scroll to each of the following parameters in turn and set the desired values.

Pnt.L low temperature for which an offset is to be entered
OFS.L offset value for the low temperature
Pnt.H high temperature for which an offset is to be entered
OFS.H offset value for the high temperature

Example: the controller reads 3 °C low at 400 °C and 5 °C low at 1000 °C. The parameter values should be Pnt.L=400, OFS.L=3, Pnt.H=1000, OFS.H=5.

Negative or positive values can be entered: if the controller is reading high, negative offsets would be appropriate.

Fig 4 gives a graphical representation of the 2-point calibration.
### 4.5 Audible Alarm

If an audible alarm is supplied for use with the timer function, then it is normally configured to sound at the 'End' condition and to go off when the alarm is acknowledged as given in section 4.3.6.

It is not feasible to cover all possible alarm features which may be included by customer special order, within this manual.

### 4.6 Temperature Controller Replacement

Before handling the controller: wear an anti-static wrist strap or otherwise avoid any possibility of damage to the unit by static electricity. Refer to the detailed instructions supplied with the replacement controller.

Ease apart the two lugs at the side; grip the instrument and withdraw it from its sleeve; push in the replacement.

---

Key

<table>
<thead>
<tr>
<th>Key</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>User Temperature Reading</td>
</tr>
<tr>
<td>B</td>
<td>Factory Temperature Reading</td>
</tr>
<tr>
<td>UC</td>
<td>User Calibration</td>
</tr>
<tr>
<td>UF</td>
<td>Factory Calibration</td>
</tr>
<tr>
<td>Key</td>
<td>Description</td>
</tr>
<tr>
<td>-----</td>
<td>-------------</td>
</tr>
<tr>
<td>HL</td>
<td>Home List</td>
</tr>
<tr>
<td>IL</td>
<td>Input List</td>
</tr>
<tr>
<td>OL</td>
<td>Output List</td>
</tr>
<tr>
<td>AL</td>
<td>Access List</td>
</tr>
<tr>
<td>1</td>
<td>Measured temperature; use arrow keys to access setpoint</td>
</tr>
<tr>
<td>2</td>
<td>Output power (read only)</td>
</tr>
<tr>
<td>3</td>
<td>Present only if SPrr in use</td>
</tr>
<tr>
<td>4</td>
<td>Manual/Auto (mAn = off, Auto = on)</td>
</tr>
<tr>
<td>5</td>
<td>Setpoint ramp rate OFF or value</td>
</tr>
<tr>
<td>6</td>
<td>Timer mode</td>
</tr>
<tr>
<td>7</td>
<td>Time remaining</td>
</tr>
<tr>
<td>8</td>
<td>Dwell time for timer</td>
</tr>
<tr>
<td>9</td>
<td>Timer status run or OFF</td>
</tr>
<tr>
<td>10</td>
<td>Enter password</td>
</tr>
<tr>
<td>11</td>
<td>If User Calibration</td>
</tr>
<tr>
<td>12</td>
<td>User 2-Point Calibration</td>
</tr>
<tr>
<td>13</td>
<td>Power limit setting, if present</td>
</tr>
<tr>
<td>14</td>
<td>For factory access to lists and parameters not available to the operator</td>
</tr>
</tbody>
</table>
5.0 Operation

5.1 Operating Cycle

This product is fitted with an instrument switch which cuts off power to the control circuit.

Connect the product to the electrical supply.

Turn on the instrument switch to activate the temperature controllers. The controllers illuminate and go through a short test cycle.

**Over-Temperature option only.** If the digital over-temperature option has not yet been set as required, set and activate it according to the over-temperature controller instructions.

Switch on the heater switch, located on the instrument panel. Unless a time switch is fitted and is switched off, the product will start to heat up. The Heat light(s) glow steadily at first and then flash as the product approaches the desired temperature or a program setpoint.

**Over-Temperature option only.** If the over-temperature circuit has tripped, an indicator on the over-temperature controller flashes and the heating elements are isolated. Find and correct the cause before resetting the over-temperature controller according to the instructions supplied.

To switch off power to the heating elements, use the heater switch. To switch the product off, use both the heater switch and the instrument switch. If the product is to be left switched off and unattended, isolate it from the electrical supply.

5.2 Control Method

Set the three temperature controllers to the desired setpoints. The setting and operation of the end zone controllers depends on the 3-zone control options selected when the product was ordered. These options are described in the 3-zone control methods section.

5.3 3-Zone Control Methods

There are three different control options (A, B & C).

(A) Back to back thermocouples
(B) Retransmission of Setpoint
(C) Independent control

The models listed in this manual are designed to achieve an extended uniform temperature zone, through use of three control zones, rather than achieving different temperatures in each zone.

For A & B, the control zones are linked so that they all follow the centre zone controller in a master-slave approach.
Note:
- Option A is **NOT** applicable when using the CC-T1 controller
- Option B is **NOT** applicable when using the Eurotherm 2132 End Zone Controller

A. Back-to-Back Thermocouples
This is the most commonly supplied option. The centre zone of the tube furnace is controlled directly by the centre zone temperature controller. The two end zone thermocouples are wired in opposition to the centre zone reference thermocouple. If the temperatures of the centre and end zones are the same then 0°C will be displayed on the end zone controllers. If the end zone temperatures are either higher or lower than the centre zone, the end zone controller will display the difference in temperature (higher = positive value, lower = negative value).

It is best practice to set the setpoint of the two end zone controllers to zero. Alternatively, a small temperature difference (offset) can be created by setting a non-zero value, for example to compensate for heat losses at the end or where using a gas flow. However, the sum of the centre zone controller setpoint and the end zone controller offset MUST NOT exceed the furnace maximum temperature.

To alter the setpoint with the display showing the Home screen, press Down ▼ or Up ▲ once to display the setpoint and then press again or hold down to adjust it. The display returns to the measured temperature when no key is pressed for a short period of time.

Sometimes a furnace using this type of control does not cool down because the end zones lose heat first and therefore the end zone controllers try to compensate for this by switching on the end zone elements, preventing the furnace from cooling.

B. Retransmission of Setpoint
Three independent thermocouples are connected to three controllers. The three controllers are linked together and the centre zone controller communicates the desired setpoint to the end zone controllers. If the centre zone controller is set to a setpoint or is running a program, the end zone controllers will automatically follow.

For products with the CC-T1 controller, please refer to the separate CC-T1 controller manual for details on enabling and disabling setpoint retransmission.

For other products, additional communication modules are fitted in the controllers. The communication between the controllers of the Eurotherm 3000 series is known as Broadcast communications. It is possible to switch off the linked control and allow the controllers to work independently. In the level 2 menu of the end zone controllers (see controller operating instruction), scroll to L-r. Where the end zone controller is a 3216 use the ▲ up ▼ down buttons and select NO. Where the end zone controller is a 3508 use the ▲ up ▼ down buttons to select SP1, (SP1 = Local, and SP2 = Remote). There is no need to alter the centre zone controller.
5.0 Operation

It is possible to set an offset (local trim) between the centre and end zone controllers. This can be either a positive or negative difference from the centre zone temperature. Once entered, this offset will always be added to, or subtracted from, the retransmitted setpoint temperature.

For products with the CC-T1 controller, please refer to the separate CC-T1 controller manual for details on how to set an offset trim.

To make this adjustment on other controllers, enter the level 2 menu of the end zone controllers (see controller operating instruction), scroll to LOC.T (local trim) and use the up ▲ down buttons to enter the desired positive or negative value. This will then be added to, or subtract from, the end zone set temperature. There is no need to alter the centre zone controller.

C. Independent Control

The three controllers are completely independent. Note that it is not possible to maintain very different temperatures in the three zones because of heat transfer between the zones. The models listed in this manual are designed to achieve an extended uniform temperature zone by the use of three control zones rather than achieving different temperatures in each zone.

5.4 General Operating Advice

Heating element life is shortened by overheating. Do not leave the product at high temperature when it is not required. The maximum temperature is shown on the product rating label and in section 11.0 towards the back of this manual.

Lightweight ceramic fibre insulation can easily be marked by accidental contact. Some fine cracks may develop in the surface of the insulation due to the progressive shrinkage of the insulation materials. Cracks are not usually detrimental to the functioning or the safety of the product.

Clean up any spillages in the insulation, as these can increase the rate of degradation of the insulation material.

5.5 Operator Safety

The ceramic materials used in the product manufacture become electrically conductive to some extent at high temperatures. DO NOT use any conductive tools within the product without isolating it. If a metal work tube is used, it must be earthed (grounded).
5.0 Operation

Switch off the heater switch whenever loading or unloading the product. The elements are isolated when the heater switch is OFF. This switch cuts both sides of the circuit via a contactor.

5.6 Tube Life

A ceramic work tube may crack if work pieces are inserted too quickly or at temperatures below 900 °C (when the tube is more brittle). Large work pieces should also be heated slowly to ensure that large temperature differences do not arise.

Poor thermal contact should be encouraged between the work piece and the tube; crucibles or boats should be of low thermal mass and should have feet to reduce the contact with the tube (fig. 4).

Fig 4 - Avoidance of thermal contact

Do not set too high a heating or cooling rate. As tubes are susceptible to thermal shock and may break. Tubes which extend beyond the heated part of the furnace are more at risk. A general rule for maximum heating or cooling rate is 400 ÷ internal diameter in mm to give (°C/min); for 75 mm i/d tubes this comes to 5 °C per minute. The controller can be set to limit both the heating and cooling rate.

5.7 Pressure

Work tubes are not able to accept high internal pressure. When gas seals or similar fittings are in use, the gas pressure should be restricted to a maximum of 0.2 bar (3 psi). A pressure of approximately half of that should normally be sufficient to achieve the desired flow rate. The operator must ensure that the exhaust path from the tube is not blocked, so that excess pressure does not occur.

A suitably regulated gas supply should always be used.

It is recommended that a pressure relief system should be used to avoid an over pressurisation of the work tube.

Please note: A product should not be heated up if any valves that have been fitted are closed to create a sealed volume. A sealed work tube should not be heated from cold due to the pressure increase caused by the trapped air or gas expanding during the heating process.
5.8 Power Adjustment

The product control system incorporates electronic power limiting. The power limit parameter OP.Hi is accessible to the operator and can be used to adjust the product to the actual supply voltage.

Some models covered by this manual are fitted with 208 V elements and are designed for use over the range of voltages 200 V- 250 V; the power limit parameter is set accordingly. These models may be relocated to a different voltage within the range: the power limit should be reset to match the voltage.

To check whether the furnace is a 208 V model:

- look at the OP.Hi parameter
- make a note of the value and compare with the 10.0;
- observe the rating label; if a range of voltages is stated, it is not a 208 V multi voltage model;
- if in doubt, check with Carbolite Gero – each product has its own record card.

Refer to the controller instructions for how to change the power limit.

5.9 Running at Low Temperatures

The power limit may be adjusted to a low level in order to achieve better control when operating the product at a low temperature. Before changing the power limit, record the default settings for possible future use. Refer to the Power Settings section of this manual for default power limits. If the product fails to reach the desired temperature, refer to the Temperature Controller and Fault Analysis sections.
6.0 Maintenance

6.1 General Maintenance

Preventive rather than reactive maintenance is recommended. The type and frequency depends on the product use; the following are recommended.

6.2 Maintenance Schedule

CUSTOMER QUALIFIED PERSONNEL

<table>
<thead>
<tr>
<th>Maintenance Procedure</th>
<th>Method</th>
<th>Frequency</th>
</tr>
</thead>
<tbody>
<tr>
<td>Safety</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Over-Temperature Safety Circuit (if fitted)</td>
<td>Set an over-temperature setpoint lower than the displayed temperature and check for an over-temperature alarm as detailed in this manual</td>
<td></td>
</tr>
<tr>
<td>Over-Temperature Safety Circuit (if fitted)</td>
<td>Electrical measurement</td>
<td></td>
</tr>
<tr>
<td>Safety Switch Function (split models only)</td>
<td>Set a safe temperature above ambient, and open the furnace to see if the heater light goes out</td>
<td></td>
</tr>
<tr>
<td>Safety Switch Function (split models only)</td>
<td>Electrical measurement</td>
<td></td>
</tr>
<tr>
<td>Electrical Safety (external)</td>
<td>Visual check of external cables and plugs</td>
<td></td>
</tr>
<tr>
<td>Electrical Safety (internal)</td>
<td>Physically check all connections and cleaning of the power plate area</td>
<td></td>
</tr>
<tr>
<td>Function</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Temperature Calibration</td>
<td>Tested using certified equipment, frequency dependent on the standard required</td>
<td></td>
</tr>
<tr>
<td>Operational Check</td>
<td>Check that all functions are working normally</td>
<td></td>
</tr>
<tr>
<td>Operational Check</td>
<td>Thorough inspection and report incorporating a test of all functions</td>
<td></td>
</tr>
<tr>
<td>Work Tube Position</td>
<td>Visually check that the tube is central to the heated zone (horizontally / vertically)</td>
<td></td>
</tr>
<tr>
<td>End Plugs / Radiation Shields</td>
<td>Visual check for damage or wear, and correct positioning</td>
<td></td>
</tr>
</tbody>
</table>
## 6.0 Maintenance

<table>
<thead>
<tr>
<th>Seals (if fitted)</th>
<th>Check all seals and O-rings and clamps</th>
</tr>
</thead>
</table>

### Performance

<table>
<thead>
<tr>
<th>Element Circuit</th>
<th>Electrical measurement</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Power Consumption</td>
<td>Measure the current drawn on each phase / circuit</td>
<td></td>
</tr>
<tr>
<td>Cooling Fans (if fitted)</td>
<td>Check whether the cooling fans are working</td>
<td></td>
</tr>
</tbody>
</table>
6.2.1 Cleaning
The product's outer surface may be cleaned with a damp cloth. Do not allow water to enter the interior of the case or chamber. Do not clean with organic solvents.

Under no circumstances should any objects be placed on top of the product. Always ensure that any vents on the top of the product are clear of any obstruction. Always ensure all cooling vents and cooling fans (if fitted) are clear of any obstruction.

6.3 Calibration
After prolonged use, the controller and/or thermocouple may require recalibration. This is important for processes that require accurate temperature readings or for those that use the product close to its maximum temperature. A quick check using an independent thermocouple and temperature indicator should be made from time to time to determine whether full calibration is required. Carbolite Gero can supply these items. Depending on the controller fitted, the controller instructions may contain calibration instructions.

6.4 After-Sales Service
Carbolite Gero Service has a team of Service Engineers who can offer repair, calibration and preventive maintenance of furnace and oven products both at the Carbolite Gero factory and at customers’ premises throughout the world. A telephone call or email often enables a fault to be diagnosed and the necessary parts to be despatched.

In all correspondence please quote the serial number and model type given on the rating label of the product. The serial number and model type are also given on the back of this manual when supplied with the product.

Carbolite Gero Service and Carbolite Gero contact information can be found on the back page of this manual.

6.5 Recommended Spare Parts and Spare Parts Kit
Carbolite Gero can supply individual spare parts or a kit of the items most likely to be required. Ordering a kit in advance can save time in the event of a breakdown.

Each kit consists of one of each type of thermocouple, one solid state relay and one heating element.

When ordering spare parts please quote the model details as requested above.
7.0 Repairs and Replacements

7.1 Safety Warning - Disconnection from Power Supply

Immediately switch the product off in the event of unforeseen circumstances (e.g. large amount of smoke). Allow the product to return to room temperature before inspection.

Always ensure that the product is disconnected from the electrical supply before repair work is carried out.

Caution: Double pole/neutral fusing may be used in this product.

7.2 Safety Warning - Refractory Fibre Insulation

Insulation made from High Temperature Insulation Wool Refractory Ceramic Fibre, better known as (Alumina silicate wool - ASW).

This product contains alumino silicate wool products in its thermal insulation. These materials may be in the form of blanket or felt, formed board or shapes, slab or loose fill wool.

Typical use does not result in any significant level of airborne dust from these materials, but much higher levels may be encountered during maintenance or repair.

Whilst there is no evidence of any long term health hazards, it is strongly recommended that safety precautions are taken whenever the materials are handled.

Exposure to fibre dust may cause respiratory disease.

When handling the material, always use approved respiratory protection equipment (RPE-eg. FFP3), eye protection, gloves and long sleeved clothing.

Avoid breaking up waste material. Dispose of waste in sealed containers.

After handling, rinse exposed skin with water before washing gently with soap (not detergent). Wash work clothing separately.

Before commencing any major repairs it is recommended to make reference to the European Association representing the High Temperature Insulation Wool industry (www.ecfia.eu).

Further information can be provided on request. Alternatively, Carbolite Gero Service can quote for any repairs to be carried out either on site or at the Carbolite Gero factory.

7.3 Temperature Controller Replacement

Refer to the controller instructions for more information on how to replace the temperature controller.
7.4 Solid-state Relay Replacement

Disconnect the product from the power supply and remove the appropriate cover as given above.

Make a note of the wire connections to the solid state relay and disconnect them.
Remove the solid state relay from the base panel or aluminium plate.
Replace and reconnect the solid state relay ensuring that the bottom of it has good thermal contact with the base panel or aluminium plate.
Replace the access panel.

7.5 Thermocouple Replacement

The coverings and guards which must be removed to gain access to the thermocouple depend on the model, its orientation (horizontal or vertical), and possibly other options and fittings.
It will usually be necessary to separate the product from its base or stand. On horizontal models one outer end-cap will need to be removed and on vertical models the terminal cover. Within some models the thermocouple lies inside the product body; the body must be removed from the control base and the end-cap and insulation ring removed from one end.

Disconnect the product from the power supply. Remove terminal cover to gain access to the thermocouple connections. Make a note of the thermocouple connections.

Thermocouple cable colour codings are:

<table>
<thead>
<tr>
<th>thermocouple leg</th>
<th>colour</th>
</tr>
</thead>
<tbody>
<tr>
<td>positive (type K)</td>
<td>green</td>
</tr>
<tr>
<td>negative</td>
<td>white</td>
</tr>
</tbody>
</table>

Disconnect the thermocouple from its terminal block. Withdraw the thermocouple from its sheath and remove any broken bits of thermocouple.
Bend the new thermocouple carefully to match the shape of the original (working from the terminal end). Should the length differ from that of the original this will usually not be important provided that the thermocouple tip is within a tube diameter's distance from the product centre.
Insert the new thermocouple into position, restoring any removed porcelain spacers and ensuring correct polarity. Re-assemble the product.
7.6 Element Replacement

See section 7.2 - wearing a face mask is required.

The coverings and guards which must be removed to enable replacement of the wound tube element depend on the furnace model, its orientation (horizontal or vertical), and other options and fittings. The general procedure is:

Disconnect the product from the electrical supply.

Remove all outer guards, meshes and terminal covers from the product's body. For a horizontally mounted product remove the product body from its base; to reach the bolts or screws which fix the body to the base, remove the back panel from the base.

Disconnect all electrical leads from the terminal blocks on the product case. Note the colours and positions of the connecting leads to enable correct reassembly. Take care not to crack porcelain terminal blocks - use two spanners where appropriate.

Remove the thermocouples.

Lay the furnace body horizontally with the split in the cylindrical case uppermost.

Remove the two metal end-caps from the body. Except TZF 12/38, undo the self-tapping screws which hold the terminal strip to the case join. The case should spring open slightly. Remove the ceramic board disc from one end.

Use a sharp knife to cut right through the insulation down to the wire-wound tube element along the whole length of the body, but do not cut either of the ceramic board end discs. The knife cut must be in line with the element lead wires. Slide the element gently out through the end of the product body.

Check the cylindrical case and clean out as appropriate.

Remove any insulation sleeving from the tails of the old element and fit to the replacement element.

Slide in the new element(s). Close up the product again, refitting the terminal strip (where applicable) and the end-caps. Any cut made in the insulation should close up completely: if the insulation appears loose or damaged in any way, please contact the Carbolite Gero service division.

Reverse the rest of the disassembly process. Take care to make all connections to the correct terminals. Do not over tighten the connectors in porcelain terminal blocks.

Let the product heat up at its maximum rate to 900 °C without interruption and then soak for 1 hour. Fumes may be emitted: this should be done in conditions of good ventilation.

Check that the product is controlling properly to rule out the possibility that the element failed because of a fault in the control system.

If you have any problems with this procedure, please contact the Carbolite Gero service division.
7.7  Fuse Replacement

Fuses are marked on the wiring diagram with type codes, e.g. F1, F2. For more information on fuses refer to section 10.0.

*Depending on model and voltage, the different fuse types may or may not be fitted.*

If any fuse has failed, it is advisable for an electrician to check the internal circuits. Replace any failed fuses with the correct type. For safety reasons do not fit larger capacity fuses without first consulting Carbolite Gero.

The fuses are located at the cable entry point. Remove the back panel or control box back panel to gain access to the fuses.
## 8.0 Fault Analysis

### A. Furnace Does Not Heat Up

<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>1.</strong> The HEAT light is <strong>ON</strong></td>
<td>The heating element has failed</td>
<td>Check also that the SSR is working correctly</td>
</tr>
<tr>
<td><strong>2.</strong> The HEAT light is <strong>OFF</strong></td>
<td>The controller shows a very high temperature or code such as S.br</td>
<td>The thermocouple has broken or has a wiring fault</td>
</tr>
</tbody>
</table>

- The controller shows a low temperature
  - The door switch(es) (if fitted) may be faulty or need adjustment
  - The contactor/relay (if fitted) may be faulty

- The heater switch (if fitted) may be faulty or need adjustment

- The SSR could be failing to switch on due to internal failure, faulty logic wiring from the controller, or faulty controller

- There are no lights glowing on the controller
  - Check the supply fuses and any fuses in the furnace control compartment

- The controller may be faulty or not receiving a supply due to a faulty switch or a wiring fault.
### B. Product Overheats

<table>
<thead>
<tr>
<th></th>
<th>Product only heats up when the instrument switch is ON</th>
<th>The controller shows a very high temperature</th>
<th>The controller is faulty</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>The controller shows a low temperature</td>
<td>The thermocouple may be faulty or may have been removed out of the heating chamber</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>The thermocouple may be connected the wrong way around</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>The controller may be faulty</td>
</tr>
<tr>
<td>2.</td>
<td>Product heats up when the instrument switch is OFF</td>
<td>The SSR has failed &quot;ON&quot;</td>
<td>Check for an accidental wiring fault that could have overloaded the SSR</td>
</tr>
</tbody>
</table>
9.0 Wiring Diagrams

9.1 WC-13-01
Connections below show single phase with indirect safety switches and over-temperature control.
9.2 WC-13-31
Connections below show single phase with indirect safety switches and over-temperature control.
9.3 2- and 3-phase With Neutral

Each SSR is connected to a different phase. The control circuit is taken between L1 and N.

Safety switch A applies for 2-phase. Safety switch B applies for 3-phase.

If type F1 fuse is present, one per phase if fitted.

If type F2 fuse is present, one is fitted; if type F3 fuse is present, one per phase is fitted.

Note that on 2- or 3-phase models there may be three separate neutrals taken to a common supply terminal, depending on EMC filter requirements.

9.4 Independent Zones (control method C)

When this is ordered there are three independent thermocouples (instead of the four shown) connected to the three controllers; the words “master” and “slave” may be replaced by “centre” and “end”.

9.5 Control by Broadcast Comms (control method B)

When this is ordered there are three independent thermocouples connected to the three controllers; the controllers are linked together (not shown), and remain “master” and “slave”.

The communication between the controllers of the Eurotherm 3000 series is known as Broadcast comms. The wiring connections between the controllers are as follows:
10.0  Fuses and Power Settings

10.1  Fuses

F1-F3: Refer to the circuit diagrams.

<table>
<thead>
<tr>
<th></th>
<th>Internal Supply Fuses</th>
<th>Fitted if supply cable fitted. Fitted on board to some types of EMC filter.</th>
<th>GEC Safeclip of the type shown (glass type F up to 16 A) 38 mm x 10 mm type F fitted on EMC filter circuit board(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>F1</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>F2</td>
<td>Auxiliary Circuit Fuses</td>
<td>Fitted on board to some types of EMC filter. May be omitted up to 25 Amp/phase supply rating.</td>
<td>2 Amps glass type F On board: 20 mm x 5 mm Other: 32 mm x 6 mm</td>
</tr>
<tr>
<td>F3</td>
<td>Heat Light Fuses</td>
<td>May be omitted up to 25 Amp/phase supply rating.</td>
<td>2 Amps glass type F 32 mm x 6 mm</td>
</tr>
<tr>
<td></td>
<td>Customer Fuses</td>
<td>Required if no supply cable fitted. Recommended if cable fitted.</td>
<td>See rating label for current; See table below for fuse rating.</td>
</tr>
</tbody>
</table>

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<table>
<thead>
<tr>
<th>Model</th>
<th>Phases</th>
<th>Volts</th>
<th>Supply Rating</th>
</tr>
</thead>
<tbody>
<tr>
<td>TZF 12/38/400</td>
<td>1-phase</td>
<td>110-120</td>
<td>20 A</td>
</tr>
<tr>
<td>TZF 12/38/400</td>
<td>1-phase</td>
<td>200-240</td>
<td>10 A</td>
</tr>
<tr>
<td>TZF 12/38/400</td>
<td>2-or 3-phase</td>
<td>380/220-415/240</td>
<td>6 A</td>
</tr>
</tbody>
</table>

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10.2  Power Settings

The power limit settings (parameter OP.Hi) for this model are voltage dependant. The figures represent the maximum percentage of time that controlled power is supplied to the elements. Do not attempt to “improve performance” by setting a value higher than the recommended values. To adjust the parameter refer to the "Changing the Maximum Output Power" of the control section of the manual.

<table>
<thead>
<tr>
<th>Volts:</th>
<th>110 V</th>
<th>120 V</th>
<th>208 V</th>
<th>200 V</th>
<th>220 V</th>
<th>230 V</th>
<th>240 V</th>
</tr>
</thead>
<tbody>
<tr>
<td>TZF 12/38 1-phase</td>
<td>100</td>
<td>100</td>
<td>100</td>
<td>83</td>
<td>84</td>
<td>83</td>
<td>100</td>
</tr>
</tbody>
</table>
### User Power Setting Adjustments

<table>
<thead>
<tr>
<th>Date</th>
<th>% Power</th>
<th>Comments</th>
</tr>
</thead>
<tbody>
<tr>
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Note: If a new set of elements are fitted then return the power settings to the original value.

Please refer to the rating label for product specific information.
11.0 Specifications

Carbolite Gero reserves the right to change the specification without notice.

<table>
<thead>
<tr>
<th>Model</th>
<th>Max Temp (°C)</th>
<th>Max Power (kW)</th>
<th>Work Tube Bore (mm)</th>
<th>Work Tube Length (mm)</th>
<th>Heated Length (mm)</th>
<th>Net Weight (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>TZF 12/38/400</td>
<td>1200</td>
<td>1.3</td>
<td>38</td>
<td>450</td>
<td>400</td>
<td>20</td>
</tr>
</tbody>
</table>

Note: Weights are approximate for horizontal models and do not include fittings or vertical stands.

11.1 Environment

The models listed in this manual contains electrical parts and should be stored and used in indoor conditions as follows:

Temperature: 5 °C - 40 °C

Relative humidity: Maximum 80 % up to 31 °C decreasing linearly to 50 % at 40 °C
<table>
<thead>
<tr>
<th>Engineer Name</th>
<th>Date</th>
<th>Record of Work</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
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<td></td>
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</table>
The products covered in this manual are only a small part of the wide range of ovens, chamber furnaces and tube furnaces manufactured by Carbolite Gero for laboratory and industrial use. For further details of our standard or custom built products please contact us at the address below, or ask your nearest stockist.

For preventive maintenance, repair and calibration of all furnace and oven products, please contact:

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Email: ServiceUK@carbolite-gero.com

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