



BTU International, Inc.
 23 Esquire Road
 North Billerica, MA 01862
 Phone: 978-667-4111

Line	Order Qty	Part Number/Description	Rev
1	1.00 SET	HMT-17 CHT SERIES CONVECTION HEAT TREATING OVEN PER BTU SPECIFICATION CHT204-8-126S.	

Rel	Date	Quantity
1	12/10/2010	1.00

Functional Buy Off		Inclusive Dates Performed:				
Criteria	Sample Size	Defect found		Result / Remark		
Temp peak setting	-	Setting 350 degree C		Can setting 350 degree C.		
Engineering Buy Off		Inclusive Dates Performed:				
Variable Characteristic	Specs	S. Size	Average	Std. Dev.	Cpk	Remark
Peak temp Capability	350 +/- 5	32	350.31	0.69	2.26	
Temperature maintain	135 +/- 5	32	135.22	0.79	2.01	
Max Rising (+) Slope Capability	5 +/- 5	32	4.78	0.42	4.14	
Out of temperature control	+/- 5degree	32	-	-	-	

ENGINEERING BUY-OFF

DATA CPK TEMPERATURE MAINTAIN
SPECIFICATION : TEMPERATURE
TOLERANCE +/- 5 DEGREE C

No.	MAX 135 +/- 5 °C
1	135
2	136
3	135
4	135
5	134
6	135
7	135
8	135
9	134
10	133
11	135
12	137
13	135
14	135
15	136
16	135
17	135
18	134
19	135
20	136
21	135
22	136
23	136
24	136
25	136
26	135
27	136
28	135
29	136
30	135
31	136
32	135
Avg	135.22
Std	0.79
Cpk	2.01

DATA CPK PECK TEMP CAPABILITY
SPECIFICATION : TEMPERATURE
TOLERANCE +/- 5 DEGREE C

No.	MAX 350 +/- 5 °C
1	350
2	351
3	350
4	350
5	351
6	350
7	351
8	352
9	351
10	350
11	349
12	349
13	350
14	350
15	349
16	350
17	350
18	351
19	350
20	351
21	350
22	351
23	350
24	350
25	351
26	350
27	351
28	351
29	350
30	350
31	350
32	351
Avg	350.31
Std	0.69
Cpk	2.26

DATA CPK MAX RISING (+)SLOP CAPABILITY
SPECIFICATION : TEMPERATURE
TOLERANCE +/- 5 DEGREE C

No.	MAX 5 +/- 5 °C
1	5
2	4
3	5
4	4
5	5
6	5
7	5
8	5
9	5
10	4
11	5
12	4
13	5
14	5
15	5
16	5
17	4
18	5
19	5
20	5
21	5
22	4
23	5
24	5
25	5
26	5
27	5
28	4
29	5
30	5
31	5
32	5
Avg	4.78
Std	0.42
Cpk	4.14

MACHINE COMMISSIONING/ BUY-OFF REPORT

MACHINE MODEL : CHT204-9-126S

SERIAL NUMBER : HMY-17

INSTALL BY : MILLENNIUM HI-TECH CORPORATION

FACILITY REQUIREMENT : ELECTRICAL SUPPLY

PHASE	REQUIRE	ACTUAL
L1/L2	380 +/- 10%	387
L2/L3	380 +/- 10%	385
L3/L4	380 +/- 10%	383
L4/L5	380 +/- 10%	388
L5/L6	380 +/- 10%	384
L6/L7	380 +/- 10%	385
L8/L9	380 +/- 10%	382

UTILITY REQUIREMENT : AIR 10-100 PSI

EXHAUST 200 SCFM

SETUP AND CHACK MACHINE

- VERIFY ALL WARNING LABELS ARE CLEARLY INDICATED LEVEL AND ALIGN MACHINE.
- INSTALL PC, MONITOR AND KEYBOARD
- INSTALL LIGHT TOWER
- VERIFY EASE OF OPERATION DOOR, PANELS AND TOP HOOD COVER.
- VERIFY THAT ALL ELETRICAL COMPONENT AND WIRE ARE WELL SECURED.

MACHINE BUY-OFF REPORT

1. MACHINE COMMISSIONING / BUY-OFF REPORT
 - 1.1 TEST SETUP TEMPERTURE CURE PROFILE / ACTUAL TEMP 3 POINT

Temperature			
Zone	Setpoint °C	Actual °C	Power %
Z1	180	179	7
Z2	170	169	5
Z3	150	149	7
Z4	145	144	10
Z5	145	144	11
Z6	145	144	10
Z7	145	144	10
Z8	145	144	9
Z9	145	144	12

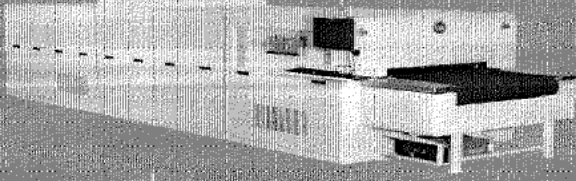
Scheduler Status: No recipes or sequences are pending.

BTU System Console - [System Monitor Graphic]

Recipe: Edit | Status | Reports | Profiles | Database | Tool | Config | Monitor | Help

BTU **Convection**
Heat Treating Furnace

HMT-17
 Ready Hours: 18:18
 Active Recipe: TEMP135DEGREEEQ(40MIN)



Temperature			
Zone	Setpoint °C	Actual °C	Power %
Z1	180	179	7
Z2	170	169	5
Z3	150	149	7
Z4	145	144	10
Z5	145	144	11
Z6	145	144	10
Z7	145	144	10
Z8	145	144	9
Z9	145	144	12

Settings	
Heat	On
Conveyor	On

Conveyor	
Setpoint	2.49 ipm
Actual	2.45 ipm

Scheduler Status: No recipes or sequences are pending

For Help, press F1

Profile: Inactive | Data Collection: Inactive | Master: 2 | Schedule: Enabled | Active Recipe: TEMP135DEGREEEQ(40MIN)

BTU System Console | Unified Fabric | 8:18 PM

