



Eurotherm®

Optimizing efficiency and regulatory compliance

Vacuum heat treatment control solutions

Meeting the requirements of industrial vacuum heat treatment standards is easier with accurate control of temperature and vacuum pressure.

Choose from a range of control solutions designed to help you achieve:

- Surface/core hardness requirements
- Conforming microstructure
- High quality finish

Optimize cycle times, and record the process to meet heat treatment data regulations.



Applicable heat treatment standards

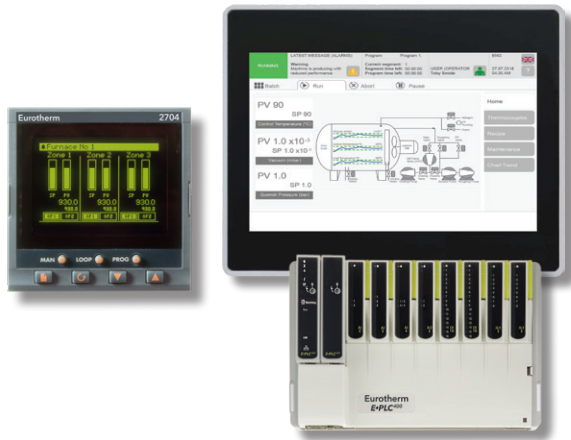
AMS2750
CQI-9
AMS2769

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 **WATLOW®**
Powered by Possibility

Vacuum heat treatment control

Vacuum pump sequence and integrated control systems

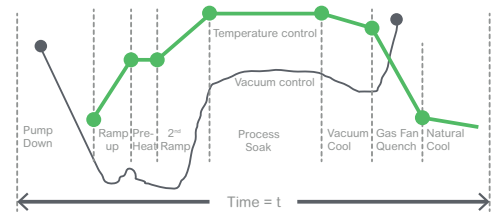


Eurotherm vacuum cycle overview

Vacuum control

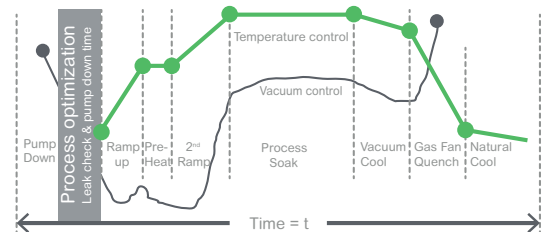
Provides multi-setpoint control via a setpoint program and sequencing of the vacuum pumping system, with bumpless transfer between low vac and high vac gauges.

Vacuum HT control



Provides multi-setpoint control via a setpoint program and sequencing of the vacuum pumping system, with temperature cycles.

Advanced vacuum HT system control



Setpoint control as above, plus leak-rate detection and pumping-time systems to aid the optimization of cycle-times. This IIoT ready system also allows enhancement with predictive maintenance functionality.

Products at a glance

2704VC, ideal for vacuum control

Features:

- High vac / low vac control
- Furnace temperature control
- Setpoint programming

Associated products:

- 6100/6180 data recorder

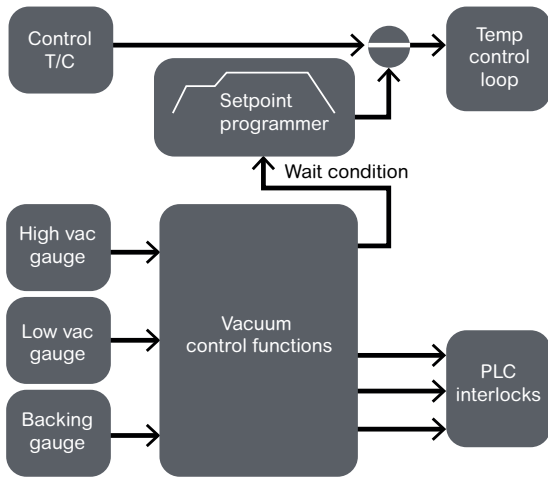
E+PLC⁴⁰⁰ with E+HMI, ideal for advanced vacuum HT systems

Features:

- High vac / low vac / partial pressure control
- Furnace temperature control
- Load thermocouple inputs
- Quench gas control (gas type/pressure)
- Setpoint programming
- Inbuilt trend and tamper resistant data recording
- IIoT (Industrial Internet of Things) ready
- Easily integrated with 3rd party PLCs (hybrid system)

Control system overview

Features and functions



Control system overview

Specialized functions for vacuum HT control

T/C block

The thermocouple linearization function block converts the mV input reading and cold junction temperature into a temperature output. It also provides scaling, low pass filtering, offset and manual-override capabilities.

Autotune PID control

Provides a channel output to control a process variable (PV), using a precision PID control algorithm designed by Eurotherm. Autotune is included, as well as a 'cutback' feature to control overshoot behavior. A gain scheduling feature is available for adding extra PID tuning sets, to help maintain tight control at different setpoints.

Thermocouple life*

Derives the working lifespan of thermocouples in days or number or times used, under different ranges of operating temperature. The block monitors usage times and temperatures, and indicates whether the thermocouple is still valid for use according to the AMS2750 standard.

* Available in E+PLC only

Vacuum input

Converts raw electrical measurements into vacuum pressure values. It also supplies a gas calibration factor for non-N₂-type atmospheres, low pass filtering, offset, and manual override. Provides vacuum gauge linearization for several common vendors, as well as user defined linearization capability.

Gauge switch

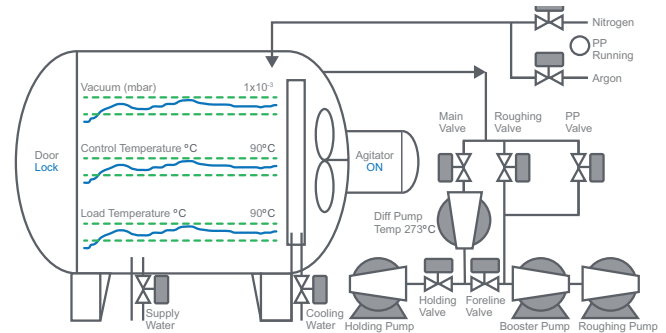
Allows for smooth (bumpless) switching between a "low" vacuum gauge, such as a Pirani gauge, and a "high" ionization type such as an inverted magnetron or Penning gauge.

Pump-down timer

Optimizes vacuum cycle time by alerting operators to a controller detected event or leak in the vacuum system. It can be configured to signal an alarm if a particular vacuum pressure has not been reached in a given amount of time.

Leak rate



Implements a leak test strategy for a vacuum chamber, using industry standard leak-rate methodology.



Typical vacuum furnace layout, visualized in E+PLC

Vacuum sequence and integrated control systems

Example solutions dependent on I/O options

	Discrete control example		System Control	
	Vacuum control		Advanced vacuum heat treatment control	
				
	2704VC		E+PLC ⁴⁰⁰ 4 module base ¹	E+PLC ⁴⁰⁰ 16 module base x 2
Typical control inputs (dependent on optional I/O board or module selection)				
Furnace thermocouple	✓	✓	✓	✓
Low vacuum gauge	✓	Dependent on customer specified I/O	Dependent on customer specified I/O	✓
High vacuum gauge	✓			✓
Load thermocouple	✓			✓
Program start	✓			✓
Additional thermocouple inputs	Dependent on optional I/O			32
Additional analog inputs		6		
Digital inputs for sequencing		16	96	
Typical control outputs (dependent on optional I/O board or module selection)				
Roughing pump	✓	Dependent on customer specified I/O	Dependent on customer specified I/O	✓
High vacuum gauge on/off	✓			✓
Diffusion pump	-			✓
Furnace heater	✓			✓
End of cycle/partial pressure alarm	-			✓
Additional analog outputs	-			2
Digital outputs for sequencing	-			16
Typical control function				
Autotuning PID	✓	✓	✓	✓
Extra PID sets	2	6	6	6
Vacuum algorithms	Basic	Advanced	Advanced	Advanced
Setpoint programming	Basic	Advanced	Advanced	Advanced
Data recording	-	✓	✓	✓
Batch management	-	✓	✓	✓

¹ E+PLC⁴⁰⁰ with any number of modules from zero upward can be used to create a hybrid advanced vacuum heat treatment control system, in combination with Eurotherm and 3rd party PLCs.

Product I/O options shown are for example only. Contact your local Eurotherm sales representative to discover the most suitable solution for your process.

Scalable integrated systems and services, from single machine to enterprise solutions, including:

- Power control (SSR/SCR) and process control
- Data management, alarm management and supervisory systems
- System design, engineering and installation
- Calibration and maintenance services

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