

Issued: 29 October 2010
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10-012 HT

Background: It appears that there are still misinterpretations on the requirements related to furnaces' Instrumentation Types.

AMS2750D paragraph 3.3.1.4.1 requires for Instrumentation Type D (quote) "Each control zone shall have at least one control sensor attached to a control instrument that displays and controls temperature" (end quote).

In some cases customers, processes, material specifications, or supplier preference require that part temperature needs to be monitored during heat treatments beyond the minimum Instrumentation type levied by the specification. Using load thermocouples to comply with this requirement may or may not change the classification of a furnace's Instrumentation Type.

The "declaration" of the Furnace Instrumentation Type is determined by the physical configuration of the furnace. However, it is acceptable for a supplier to comply with a higher Class of Instrumentation while still maintaining a declaration of a lower Instrumentation Type. For example, if the Supplier uses a load thermocouple on an otherwise Type D Furnace, they have the option to designate the furnace as Type B or they can continue to designate it as Type D. They meet and exceed the Type D requirements. If they declare the furnace as Type D, they must meet the more stringent Type D test frequencies. If they declare the furnace as Type B and use the lesser Type B test frequencies, they must use a load thermocouple on each load to maintain Type B Instrumentation.

Procedure: If the Supplier is meeting or exceeding the minimum instrumentation requirements of the specification and meeting or exceeding the corresponding Test Frequencies of the lowest Type of Instrumentation then no NCR shall be issued.

Effectivity Date: 01 November 2010