

Vulcan® Box Furnace

with Programmable Controls


Owner & Operator's Manual

Models:	3-130	3-550	3-550PD	3-1750
100V	---	9493487	9493825	---
100-120V	9493302	---	---	---
120V	---	9493308	9493826	---
200-240V	9493303	9493309	9493827	9493409
230 (EURO only)	---	---	---	9493658

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SAFETY



- Never operate furnace in close proximity to combustible materials or place materials on top of the furnace.
 - Caution: To provide continued protection against risk of electric shock, connect to properly grounded outlet only.
 - The furnace must be electrically grounded to a three wire electrical outlet or receptacle. The electrical service provided must be a dedicated line of the proper size according to local electrical codes.
 - Disconnect the line cord before attempting to service the furnace.
 - Do not attempt to service the furnace until you read and understand the service manual. (See Service Manual under Accessories on page 15)
 - Do not operate the furnace controls with tongs or other tools; the tongs will damage the control switches.
 - Do not use solvents or liquid cleaners on the control panel; they will enter the panel and damage it.
 - Do not place firing trays or other hot objects directly in front of the furnace; they will melt the graphic overlay.
 - Always verify that the power switch light is off before attempting to load or reach into the furnace chamber with any tools or instruments.
 - As a routine working precaution, always wear safety glasses and protective gloves when operating, loading, and unloading the furnace.
-  If the furnace is not used in the manner as specified in this manual, the protection provided by the furnace may be impaired.

OSHA AND CALIFORNIA PROPOSITION 65: MUFFLE DUST EXPOSURE

In keeping with the policy of DENTSPLY Ceramco to build safe products, comply with all National and State statutes and keep you, the valued customer informed; the services of a Certified Industrial Hygienist firm were employed to test and evaluate the lab operator's exposure to respirable refractory ceramic fiber (RCF) and crystobalite (a form of crystalline silica) present in the furnace muffle.

The findings of this test revealed that levels of exposure during the normal operation of this equipment, as outlined in the operator's manual, were far less than the Permissible Exposure Limit set by the Federal Government.

When it becomes necessary to replace the muffle, the person doing this work is recommended to wear a HEPA filter respirator and protective gloves as a precautionary matter.







Seal used muffle in a plastic bag and dispose of in accordance with local, state and Federal regulations.

Because this product and many similar products on the market today contain crystalline silica and ceramic fibers, it is necessary under the statutes of California Proposition 65 that DENTSPLY Ceramco include the following statement:

"This product contains substance(s) known to the State of California to cause cancer."

Material Safety Data Sheets for RCF materials supplied upon request.

SYMBOL TABLE

 - Alternating current	Courant alternatif
 - On (Supply)	Marche (alimentation)
 - Off (Supply)	Arrêt (alimentation)
 - Caution, Hot Surface	Attention, surface chaude
 - Protective Conductor Terminal	Borne de masse, châssis
 - Caution	Attention

FEATURES

- High Performance / Hybrid Muffle
 - Longer life and more durable than fiber
 - Faster heating and faster cooling than firebrick
- Wide operating temperature range
 - 50°C (122°F) --- 1100°C (2012°F)
- Smooth, low force vertical lift door, with roll back action gives maximum access with minimum vertical space
- Power operated door with automatic timed closing (3-550PD only)
- Programmable controller with 9 three stage programs (6 segments each) and 1 program with a single temperature hold
- Heavy duty construction with stainless steel front panel
- Delay Start operation that enables the user to program the cycle completion time rather than calculating the start time
- Easy to operate and program with user friendly graphic interface
- Programs linkable for 6 stage operation
- Integrated door safety switch breaks both sides of the power line to muffle
- Wide programmable linear temperature rates both positive and negative (0.1 to 40°C/minute)
- Agency Approved: ETL, CE
- Easy / Lower Cost Muffle Service
- Individual muffle heating plate replacement

APPLICATIONS

- WAX BURNOUT
- MATERIAL ASHING
- MATERIAL HEAT TREATING
- CERAMIC FIRING
- GLASS SEAL FIRING

INSTALLATION INSTRUCTIONS

UNPACKING CAUTIONS:

Carefully unpack and remove the furnace from its shipping carton. Save the carton and other packing material for future use in transporting the furnace.

The furnace shipping carton contains the following:

- One furnace complete w/ power cord
- Owner's & Operator's Manual
- Ceramic floor tray (shipped in the muffle)
- Muffle shelf (Model 1750 only)
- Auxiliary switch (Model 3-550PD only)
- Exhaust port ball plug (for heat treating applications only)

Shipping damage should be reported to the carrier as soon as detected.

LIFTING AND CARRYING:

NOTE: The 1750 models require two people.

1. Get a firm footing. Keep your feet shoulder width apart for a stable base.
2. Bend your knees. Don't bend at the waist.
3. Grip the base of the furnace and lift with your legs.
4. Keep the load close to your body and carry the unit to the destination. Keep your back upright during lifting.





INSTALLATION:

1. Remove all packing material from in and around the furnace. The furnace should be located at least 15cm (6") away from walls, shelves, and heat sensitive materials. Open the furnace door and remove the packing material from inside the furnace. NOTE: The furnace front panel may show some discoloration around the muffle due to the calibration and burning cycles performed at the factory.
2. The furnace should **not** be located directly under shelves and other airflow restrictions.
3. On high voltage (200-240 volt) units, connect the power cord to the socket in rear of furnace.
4. Positioning the furnace:
 - a) (Combustion, Burnout or Reaction Processes) Position the furnace under a vent hood or connect the exhaust port to a ventilation system to prevent exposure to the exhaust fumes. The furnace exhaust port **25 mm (1") OD by 25 mm (1") long** [50 mm (2") OD by 20 mm (0.8") long on 1750 Model] can be ducted into the exhaust hood for more effective ventilation. Stainless Steel flexible metal tubing can be used for this ducting.
 - b) (Heat Treating or Non-Reaction Processes) Position the furnace under a vent hood. Plug the exhaust port with the ball plugs provided in the furnace accessory kit. This will reduce heat loss and electricity requirements.
5. Connect the furnace to a power circuit or receptacle with an overcurrent protection (circuit breaker or fuse) rating of 20 Amps on the low voltage model and 10 Amps on the high voltage model. This circuit should only supply the furnace. The 1750 North American model requires a 20A supply (breaker/receptacle). The 1750 European model requires a dedicated 32A supply breaker/receptacle).
6. (3-550PD only) Plug the auxiliary switch cord into the two prong socket located next to the power cord/socket.
7. Turn on the furnace's green power switch (right-hand side of the control panel) and the LCD display will come on. The light in the green power switch lights when the door is closed and the start key is pressed.
8. At this time, your new furnace should be ready to operate. Please review the OPERATIONS and SETUP & MAINTENANCE sections of the manual before proceeding to select special options.


OPERATIONS

RUNNING A PROGRAM:

The furnace has 9 three stage programs and one single temperature hold program. The furnace is sold with the program parameters set to the factory defaults which can be used for testing. First time operation will require the user to enter their desired parameters into one of these programs.

1. Turn on green power switch (right-hand side of control panel)
After a short delay for internal testing, the furnace will display approximate room temperature, program time (hours:minutes), and program number. All red LEDs are off. (If any of the LEDs are on, the furnace was already running a program when it was last turned off.)
2. Select or change the program to the desired number by pressing the digit key (1-9) for the desired program followed by the ENTER  key. The display will be updated to show the new program number and its approximate run time.
3. Pressing the green Start  key will start this program. The red LEDs will come on and the time will start to count down. The green power switch will light when the door is closed. The LEDs will be turned off as each segment of each stage of the program is completed.
 - During program operation, the total program cycle time is counting down as indicated by the flashing colon in the time.
 - If a program is started when the muffle is already heated, the furnace will heat or cool at the first ramp rate to the first temperature from the current muffle temperature. It will not cool to room temperature before starting.
 - The program will end by maintaining the last muffle temperature, displaying "Hold", beeping every 3 seconds and flashing the last Temp LED. See information on End Of Program options (point 1) in the "Setup & Maintenance" section if other operations are preferred.
4. Pressing the  key will change the temperature display from °C to °F and back. This key is not active during parameter programming.
5. A short power outage during the operation of a program will not terminate or abort the program unless the muffle temperature drops more than 32°C (58°F). If the power outage occurs when the muffle temperature is close to, or at room temperature (e.g. during Delay Start operation) the furnace will continue the program when power is restored regardless of the temperature drop or the amount of time that has expired.
6. Pressing the Escape  key cancels beeping at the end of a program. It also will return the furnace to a display of the current conditions during programming operations.
7. Opening the door during a cycle interrupts power to the heating elements.

STOPPING A PROGRAM:

1. Pressing the red Stop  key will stop the program that is currently running. The red LEDs will go out and the display will show the current program number, approximate cycle time, and the current muffle temperature.

CONTROL PANEL DESCRIPTION

°C / °F

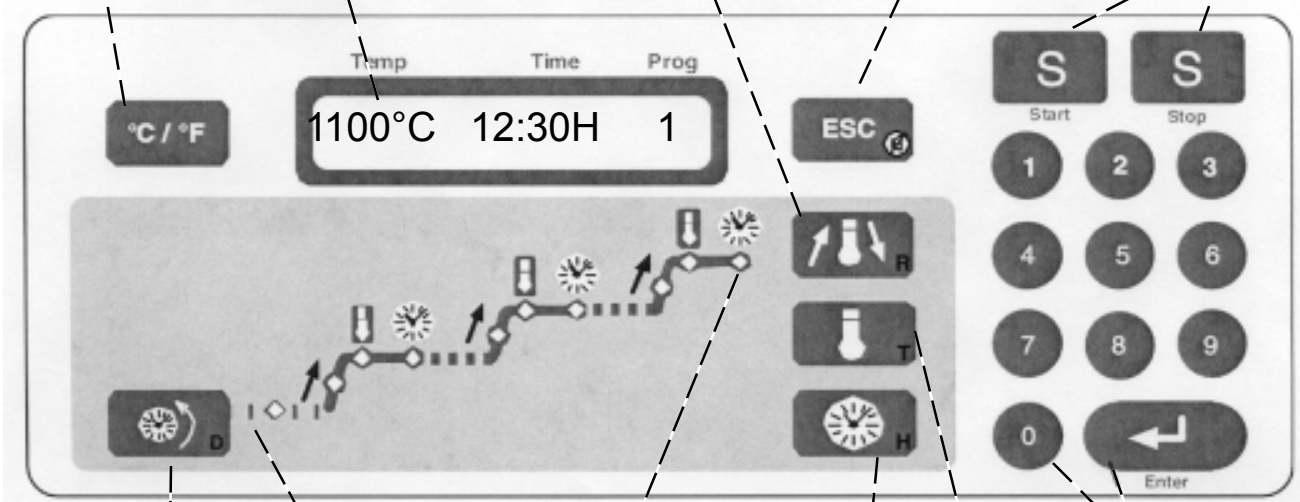
changes the temperature from °C to °F and back. This key is not active when viewing parameters.

LCD Display displays the furnace muffle temperature, program count down time, and program number. During parameter programming the display shows the current value and new value for confirmation. It signals program operation by flashing the colon in the program time.

Rate key displays the current program's heat rates in degrees per minute. Press once for R1 (rate 1), twice for R2 (rate 2), and three times for R3 (rate 3). The corresponding LED lights and the current value is displayed. New parameter values can be stored in memory at this time followed by the ENTER key.

ESC (Escape) key cancels or aborts parameter programming by returning the control to the current conditions display. The display shows the current muffle temperature, program number, and program time or time remaining. This key also cancels the beeping at the end of the program.

Green **START** key starts current program. Red **STOP** key stops or aborts program if already operating. The red LEDs turn on when the cycle is started and are turned off as the program is completed. The display counts down the time remaining in the program during operation.



Digit Keys are used to **CHANGE PROGRAMS** and enter new program parameters. **ENTER** key is used to store new program number or parameter in memory.

DELAY START activates the function that allows the furnace to automatically turn on at a later time and run a program. The delay time is programmed in the number of days and the time when the program is to be finished. The time is based on a 24 hour clock. Press this key once followed by the Start key to activate or start a delayed program and the LED will be turned on. Press this key several times to change the delay parameters.

Program Parameter LEDs indicate which parameters are activated and then completed as the program is running. All LEDs are turned on initially and then turned off as completed. During parameter programming the LED lights to indicate which parameter is currently selected. The LEDs do not light if a particular stage is turned off during that cycle.

Hold time key displays the current program's hold times in hours and minutes (hh:mm). Press once for H1 (hold 1), twice for H2 (hold 2), and three times for H3 (hold 3). The corresponding LED lights and the current value are displayed. New parameter values can be stored in memory at this time followed by the ENTER key.





Temperature key displays the current program's temperatures in degrees. Press once for T1 (temp 1), twice for T2 (temp 2), and three times for T3 (temp 3). The corresponding LED lights and the current value is displayed. New parameter values can be stored in memory at this time followed by the ENTER key.

PROGRAMMING:





The furnace increases productivity and reliability for the operator because cycles or programs can be preprogrammed and operated automatically. Once programmed, the parameters are retained in memory even with the loss of power. Parameters are not retained in memory if entered during the operation of a program.

Each program is made up of 3 stages which require 3 parameters each. The parameters are grouped into ramp rates (**R1, R2, R3**), temperatures (**T1, T2, T3**), and dwell or hold times (**H1, H2, H3**). The 1,2,3 indicates the stage number or sequence. The temperatures can be programmed in either °C or °F; the ramp rates in °C per minute or °F per minute; and the hold times in hours and minutes (hh:mm).




RAMP RATES (**R**) (0 - 40°C/minute)

1. Pressing the Rate  key makes the display show the current value of the R1 parameter followed by 3 blanks for a new value.
 - For example: R1 8.0°C/M -> _ _ _
 - The corresponding LED will also light to indicate the selected stage and parameter.
2. Use the digit keys (**0,1,2,...,9**) to enter the desired parameter value followed by the ENTER  key. The new parameter is now stored in memory.
 - If a value is entered that is out of the acceptable range, the furnace will beep and display the acceptable range.
 - Programming a Rate to 0 will cause the furnace to terminate the remainder of the program stages. For example, if R2 is set equal to 0 then at the end of the first hold time (H1) the furnace will go to the end of the program, making the program single stage.
3. Pressing the Rate  key additional times will display and give access to the Rate parameters for the other two stages. The 4th time the key is pressed the display circulates back to the beginning and the R1 parameter will be displayed again.
 - The Rate  key operates the same if pressed during the operation of a program with the following exception. The new Rate entered is used only for that one program or cycle and not stored in memory.
 - Negative ramp rates are also possible if slower than natural cooling.


TEMPERATURES (**T**) (50 - 1100°C or Tmax)

1. Pressing the Temp  key makes the display show the current value of the T1 parameter followed by 4 blanks for a new value.
 - For example: T1 160°C -> _ _ _ _
 - The corresponding LED will also light to indicate the selected stage and parameter.
2. Use the digit keys (**0,1,2,...,9**) to enter the desired parameter value followed by the ENTER  key. The new parameter is now stored in memory.
 - If a value is entered that is out of the acceptable range the furnace will beep and display the acceptable range.
3. Pressing the Temp  key additional times will display and give access to the Temp parameters for the other two stages. The 4th time the key is pressed the display circulates back to the beginning and the T1 parameter will be displayed again.
 - The Temp  key operates the same if pressed during the operation of a program with the following exception. Any new parameter entered is used only for that one program or cycle and not stored in memory.

HOLD TIMES (**H**) (0 - 99:59 mm:ss)



1. Pressing the Hold  key makes the display show the current value of the H1 parameter followed by 4 blanks for a new value.
 - For example: H1 1:00H -> _ _ : _ _ (1 hours and 00 minutes)
 - The corresponding LED will also light to indicate the selected stage and parameter.
2. Use the digit keys (**0,1,2,...,9**) to enter the desired parameter value up to 99 minutes and 59 seconds followed by the ENTER  key. The new parameter is now stored in memory.
3. Pressing the Hold  key additional times will display and give access to the Hold parameters for the other two stages. The 4th time the key is pressed the display circulates back to the beginning and the H1

parameter will be displayed again.

- The Hold  key operates the same if pressed during the operation of a program with the following exception. Any new parameter entered is used only for that one program or cycle and not stored in memory.

PROGRAM 0

Program 0 is a single temperature hold program. The furnace will heat to this temperature and maintain it as long as power is applied.








1. Press the **0** key. The display shows the current programmed temperature and the 0 program number.
2. For example: T0 100°C -> _ _ _ _
3. Use the digit keys (**0,1,2,...,9**) to enter the desired temperature followed by the ENTER  key. The new parameter is now stored in memory after 3 seconds. The display shows: 100°C ***** 0 where 100 is the current muffle temperature, 0 the program number, and ***** indicates that the program is not started.
4. Pressing the Start  key will cause the furnace to heat at full power to the programmed temperature. The display will show "xxxx°C *Hold* 0" "xxxx" is the current muffle temperature, the word "Hold" illustrates single stage and 0 for the program number. The T1 LED will also be on.

SPECIAL FEATURES


DELAY START (D)

The Delay Start functions as a timer that automatically starts a program so that it is completed at a selected time up to 7 days later. The delay is programmed in terms of the number of delay days and the desired completion time. The furnace uses a clock to keep track of time when the furnace power switch is on. If a power outage should occur during a "Delay Start", the completion time will be delayed by the length of time the power was off.

Programming The Delay Start:

1. Pressing the Delay Start  key makes the display show the current value of the time of day and beep.
 - For example: Now = 7:30 -> _ _ : _ _
 - The corresponding LED will also light to indicate the Delay Start is selected.
2. Use the digit keys (**0,1,2,...,9**) to enter the current time of day followed by the ENTER  key. The new parameter is now stored in memory. The time of day must be entered in as a 24 hour clock (11:34PM is 23:34), (8:10AM is 08:10).
 - Programming the current clock time "Now = 7:30 -> _ _ : _ _" is only displayed and requested if there has been a power outage since the last time the Delay Start was operated. Turning the power switch off stops the internal delay start timer.
3. Pressing the Delay Start  key again makes the display show the current value of the Delay D parameter in days.
 - For example: Day: 1 [1,2,...,7]
 - The corresponding LED will also light to indicate the Delay Start is selected.
4. Use the digit keys (**0,1,2,...,7**) to enter the desired number of days of delay followed by the ENTER  key. The new parameter is now stored in memory.
 - If a value is entered that is greater than 7, then the furnace will display and use 7.
5. Pressing the Delay Start  key again displays the program completion time. The furnace will calculate the approximate time that the program needs to start so that it is completed by the programmed time.
 - For example: End = 8:00 -> _ _ : _ _
 - The computer uses a 24 hour clock. For example if 14:30 is programmed, the completion time is 2:30 PM.
6. Pressing the Delay Start  key again will show the actual time (Now).
 - Pressing the key additional times will cycle through the other parameters. Press the Escape  key to stop the function.

Running A Delay Start Program:

1. Select the desired program number (See previous section on RUNNING A PROGRAM)
2. Pressing the Delay Start  key the display shows the programmed delay in days.

3. Pressing the green start (S) key will start the delay timer.
 - The corresponding LED will also light to indicate the Delay Start is selected.
 - If the program run time is longer than the current delay time the furnace will skip the delay and start the program immediately.

LINKING PROGRAMS

Programs can automatically run in sequence by using the Linking feature. With this method, a 6 stage (12 segment) program can be run automatically. Additional programs can also be linked as each program is completed.

Running Linked Programs:

1. Press the green Start (S) key with the first program to be run. The furnace will start operation.
2. Use the digit keys (1,2,...,9) to enter the next program number to be run followed by the ENTER (↵) key. The furnace will now run the first program followed automatically by the second. The program cycle time on the display will be the combination of the two programs. The display will alternately show the first program and then the second program number will be displayed for a shorter time.

POWER DOOR (3-550PD only)

The remote activation switch is used to operate the power door. Activating the switch once, will cause the door to open or close. Activating the switch while the door is moving will cause the door to stop. Once stopped, activating the switch again will cause it to reverse directions.

The furnace will also automatically close the door after a programmed amount of time during a firing cycle. This feature is disabled at the factory and needs to be activated to operate. See Setup, page 12 for instructions.

SPECIFICATIONS

PARAMETER

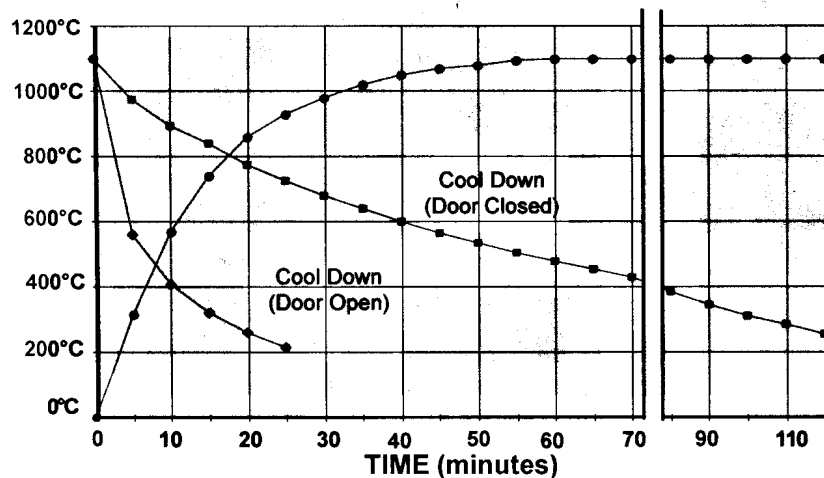
- Temperature Range: 50°C (122°F) - 1100°C (2012°F) / 1° Resolution
- Hold Time Range: 0:00 - 99:59 (hours:minutes) / 1 Min Resolution
- Ramp Rate Range: 0 - 40.0°C/minute (72°F) / 0.1°C Resolution
- Temperature Accuracy: ± 5°C (± 9°F) at steady state
- Muffle Temperature Uniformity: ± 8°C (± 15°F) at steady state

ELECTRICAL	3-130	3-550	3-1750	3-1750(EURO)
Voltage Range:	100-120	100	----	----
@ 50/60Hz	----	120	----	----
	200-240	200-240	200-240	230
Steady State				
Current: 100V	----	14.7	----	----
Amps 120V	6.5	12.0	----	----
240V	4.4	10.0	20.0	19.0
Max Power Watts:	780 (120V)	1470 (100V)	4800	4370
	1060 (240V)	1440 (120V)		
		2400 (240V)		
Watts to Maintain 1000°C	525	1050	2200	2200

ENVIRONMENTAL

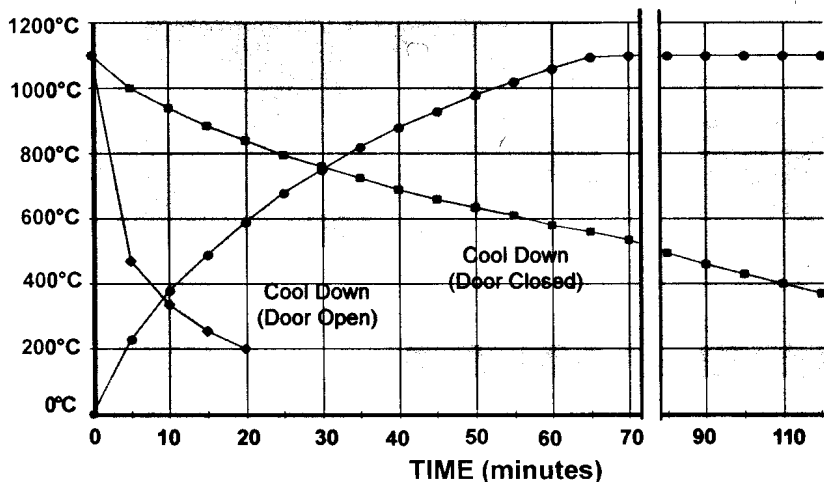
- Ambient Operating Temperature: 5 - 40°C
- Relative Humidity: Maximum 80%, non-condensing

3-130 PERFORMANCE CURVES

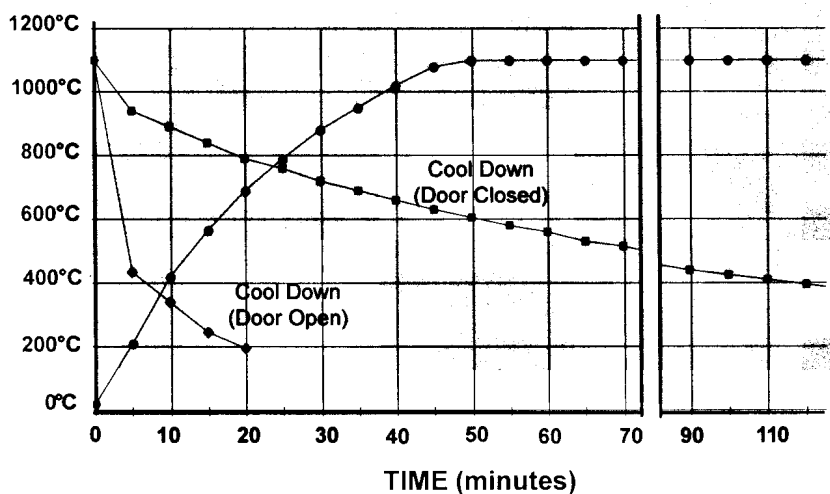


Test Conditions: Nominal line voltage, no load in the muffle only floor tray, full power applied to the muffle for the Heating Curve. The programmable rates are linear and fall below the heating curve and above the cooling curve (door closed) for some selections.

3-550 PERFORMANCE CURVES



3-1750 PERFORMANCE CURVES



OUTLINE DRAWINGS mm(in)

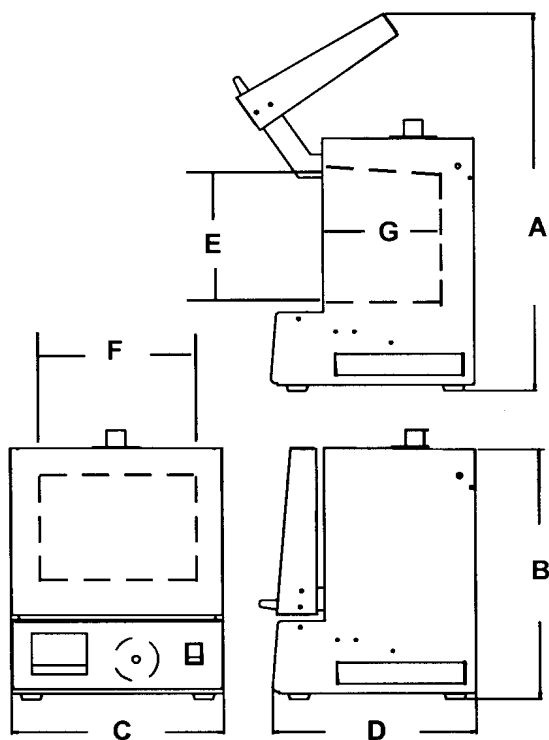
MECHANICAL

Exterior Dimensions:

MODEL	A	B	C	D
3-130	510mm(20.0")	350mm(13.8")	290mm(11.5")	330mm(13.0")
3-550	630mm(25")	410mm(16.0")	400mm(15.8")	430mm(17.0")
3-1750	815mm(32")	545mm(21.5")	610mm(24")	535mm(21")

Internal Muffle Dimensions:

MODEL	E	F	G
3-130	120mm(4.6")	140mm(5.7")	130mm(5.2")
3-550	180mm(7.0")	230mm(9.0")	230mm(9.0")
3-1750	250mm(10.0")	360mm(14.0")	320mm(12.5")










Model	Furnace Weight:	Shipping Weight:
3-130	13kg(28lbs)	16kg(35lbs)
3-550	23kg(51lbs)	28kg(62lbs)
3-550PD	25kg(56lbs)	31kg(67lbs)
3-1750	45kg(100lbs)	67kg(148lbs)

SETUP & MAINTENANCE

SETUP:

The Vulcan furnace goes through a self test that lasts for 4 to 6 seconds each time that power is applied. After the test, the display will show the word "SETUP?" for approximately 5 seconds. In the Setup mode, several different options are available for the user to select.

The first is the END OF PROGRAM operation which allows the user to select how the furnace should operate at the end of the program. The second is the TMAX parameter which limits the maximum temperature that can be programmed into the furnace. The last is TEMPERATURE ADJUSTMENT/CALIBRATION which allows the user to alter the furnace temperature calibration.

1. Turn on power to the furnace. Pressing the ENTER  key when the word "Setup?" is being displayed will start the Setup mode first with the End of Program options.
 - The current END OF PROGRAM option is now displayed as "Hold = 1 (2),(3)". The **(1)** option is the factory default. It will cause the furnace to maintain or hold the last programmed temperature, display "Hold" and beep every 3 seconds until the red Stop  key is pressed. Pressing the Escape  key will stop the beeping but not the program.
 - The **(2)** option will cause the furnace to maintain or hold the last programmed temperature, and display "Hold" but without beeping until the red Stop  key is pressed.
 - The **(3)** option will cause the furnace to turn off and cool to room temperature at the end of the program and display "End". The Stop key does not have to be pressed.
 - Use the digit keys **(1,2,3)** to change the END OF PROGRAM option.
2. Pressing the ENTER  key when the desired End Of Program is selected will store it in memory and then advance to TMAX which is the next option. The TMAX value limits the maximum temperatures that the furnace can be programmed to or fire to. The factory setting for TMAX is 1100°C. Use the digit keys **(0,1,2,...,9)** to enter the desired TMAX value followed by the ENTER  key. The new Maximum Temperature is now stored in memory and the next option is displayed.
3. (3-550PD only) The automatic closing portion of the Power Door feature is shipped from the factory in the disabled condition of 0 (Door 0sec-->). A delay time before closing of 1 to 99 seconds can be entered to activate the auto closing. The automatic closing is only active during firing cycles.
4. The final option is the temperature adjustment/calibration which is displayed as "Tcal 1000°C->__:_:_". The factory setting for Tcal is 1000°C. Use the digit keys **(0,1,2,...,9)** to enter the desired Tcal value followed by the ENTER  key. The new Temperature Calibration is now stored in memory. Entering a 1000 will return the furnace to the factory calibration. See the next section on Temperature Adjustment/Calibration for specifics on how to determine the adjustment number.

TEMPERATURE ADJUSTMENT/CALIBRATION:

Every VULCAN furnace is calibrated in the factory at 1000°C. Under normal use the furnace should not require calibration. The electronics used in the VULCAN furnaces are very stable and will have minimal drifts over the life of the furnace. Thermocouple replacement could be a potential requirement for calibration if high accuracy is required.

This calibration can be altered by entering a new Tcal value in the Setup mode listed previously. The Tcal value has a range of 900 to 1100°C.

For example:

A program is operating at a stable temperature and a separate thermocouple is inserted in the furnace and a digital thermometer measures the muffle temperature. The display shows 875°C which is the programmed temperature but the digital thermometer reads 868°C. A new calibration value could be calculated by dividing the display temperature by the actual temperature (digital thermometer) and then multiplying by the current Tcal value (factory default is 1000°C). In this case the result is 1008 ($875/868 = 1.008$; $1.008 * 1000 = 1008$). 1008 is entered in as the Tcal value. With this method the furnace calibration can be done at the normal operation temperature.

Second example:

Programmed temperature is 1050°C and the digital thermometer reads 1065°C. The old Tcal value is 985°C.

$(1050/1065 = 0.986 \text{ then } 0.986 * 985 = 971)$

971 should be entered as the new Tcal value.

CLEANING:

- Vacuum dust and dirt from the furnace rather than attempting to blow the dust off. This will minimize the amount of air born particles.
- Use a soft damp cloth to clean the control panel. Avoid excess water or solution when cleaning the furnace. These solutions can attack the panel or electronics and cause the furnace to malfunction.

TROUBLESHOOTING

ERROR CODES:

Err codes can be cleared from the display by turning the front panel power switch off and then on again.

Code	Description	Possible Cause
Err 1	Over Temperature	Temp > 1120°C, shorted thermocouple, shorted triac, shorted optotriac, wiring connections, computer PCB
Err 2	Open Thermocouple (TC)	Open TC tip, connection to TC, TC to PCB connection, computer PCB
Err 3	Temp > Tmax	Muffle temperature has exceeded the programmed limit temperature TMAX (see SETUP?).
Err 7	Brown-out	Low line voltage < 90VAC (<190VAC for 200-240V), wall socket shared with other loads, furnace connected with small extension cord
Err 8	EEPROM error	Parameter program memory error; computer PCB
Err 19	Line frequency	No line frequency detected, computer PCB

TROUBLESHOOTING THE VULCAN "3-" CONTROL

PROBLEM

CHECK LIST / CAUSES

Dead, Not Operating
No Power / Display

- Check power receptacle or outlet for power
- Check line or power cord connections
- Turn on green power switch

Not Heating
During Program
Operation

- Does the green power switch light when the Start key is pressed?
- No: - Is door completely closed? Door switch may be interrupting power.
- Yes:- Check the fuses on the controller PCB
- Check heating element plates for continuity

Door Too Loose or
Tight

- The amount of force or drag on the door movement can be changed by adjusting the hex screws located on the upper rear corners of the furnace cabinet. Turning the screw clockwise adds drag and requires more force

Heating Too Slow

- Rate programmed wrong. 1.5°/minute rather than 15.0°/minute
- Large loads will slow down response time and increase the time to temperature by 2 to 5 times

Program Turns Off
Too Early

- Programming a Rate to zero will terminate the remainder of the program
- End of program option has been changed from 1 or 2 to option 3 which turns off the furnace at the end of the program [End].

(3-550PD only)
Power Door Does Not
Open

- A hidden switch to activate the door is located between the °C/°F key and the Delay Start key. Try pressing it to test the operation.
- Check activation switch connections to back of furnace.
- Allow the furnace to cool and test the door by activating the switch and then lifting up/pushing door on the door in the appropriate direction of travel.

ACCESSORIES

DESCRIPTION	PART NUMBER
Tongs; 25cm (10") Stainless Steel	9390014
Tongs; 30cm (12") Stainless Steel	9390015
Tongs; 36 cm (14") Plated Steel	9491010B
Tray- Bottom, Model 130	9353053
Tray- Bottom, Model 550	9353057
Tray- Bottom, Model 1750	9353060
Shelf - free standing, Model 550	9493327
Shelf - Model 1750	9493396
Muffle Hardening Agent	9491006
Temperature Sticks	
705 °C (1300 °F)	9199073
815 °C (1500 °F)	9199074
Exhaust port ball plug	
Small (130, 550)	9491093A
Large (1750)	9492456
(3-550PD only) Activation Switch	9493932
Switch Bracket	9493933
Service Manual, VULCAN	9363049

PRODUCT SERVICE

Three methods of product service are available for the VULCAN. The first method is telephone assistance, available at the numbers listed below. The second is to return the furnace for servicing using the instructions below. The final method is to call DENTSPLY Ceramco at the phone numbers below and obtain a service manual for a nominal fee.

BEFORE RETURNING THE FURNACE, DO THE FOLLOWING:

1. Remove all firing trays, shelves and other loose items from inside the muffle. Pack the muffle with the original foam block or newspapers to prevent shipping damage to the heating plates.
2. The original packing material should be used for the return shipment. Contact DENTSPLY Ceramco for replacements if they are not available.
3. Call DENTSPLY Ceramco for a RMA number (Return Material Authorization). This is used to track and identify your furnace. Material received without this number may not be identifiable.
4. Equipment damaged in shipment as the result of improper packing may not be repaired at the expense of the carrier. DENTSPLY Ceramco will not be responsible for damages resulting from improper packing.

Ship Prepaid To:	DENTSPLY Ceramco
TEL 909.795.2461	RMA Number _____
FAX 909.795.5268	13553 Calimesa Blvd.
	Yucaipa, CA 92399-2303 USA

WARRANTY

WARRANTY: Except with respect to those component parts and uses which are herein after described, DENTSPLY Ceramco warrants this furnace to be free from defects in material and workmanship for a period of two years from the date of sale. DENTSPLY Ceramco's liability under this warranty is limited solely to repairing or, at DENTSPLY Ceramco's option, replacing those products included within the warranty which are returned to DENTSPLY Ceramco within the applicable warranty period (with shipping charges pre-paid), and which are determined by DENTSPLY Ceramco to be defective. This warranty shall not apply to any product which has been subject to misuse; negligence; or accident; or misapplied; or modified; or repaired by unauthorized persons; or improperly installed.

INSPECTION: Buyer shall inspect the product upon receipt. The buyer shall notify DENTSPLY Ceramco in writing of any claims of defects in material and workmanship within thirty days after the buyer discovers or should have discovered the facts upon which such a claim is based. Failure of the buyer to give written notice of such a claim within this time period shall be deemed to be a waiver of such claim.

DISCLAIMER: The provisions here-in state DENTSPLY Ceramco's sole obligations and exclude all other remedies or warranties, expressed or implied, including those related to *MERCHANTABILITY* and *FITNESS FOR A PARTICULAR PURPOSE*.

LIMITATION OF LIABILITY: Under no circumstances shall DENTSPLY Ceramco be liable to the buyer for any incidental, consequential or special damages, losses or expenses.

LIMITATION OF ACTIONS: The buyer must initiate any action with respect to claims under the warranty described in the first paragraph within one year after the cause of action has accrued.



570 W. College Ave.
York, PA 17404
PH: 800-487-0100
www.dentsply.com

Product Service Center
DENTSPLY Ceramco
13553 Calimesa Blvd.
Yucaipa, CA 92399-2303 USA
909-795-2461 • Fax: 909-795-5268

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