

Supplier of Solutions to the Heat Treatment Industry

Survey report number	Funditor - 160625
Customer	Ashton & Moore Limited
Address	12 Smith Street Birmingham West Midlands B19 3EX 0845 618 8196

Furnace Identifier	AM56
Furnace Manufacturer	Funditor
Model No.	Unknown
Serial No.	Unknown
Instrument Type	D

Survey Date/Time start	16 Jun 2025 08:15:00
Survey Date/Time end	16 Jun 2025 12:34:00
Data Source	VASLAB_006 : Group 1
Next Survey Due	16 Aug 2025

Test Method	VASWP - 004
Survey Engineer	Owen Harrison
Report generated by:	Owen Harrison

Survey Result	PASS
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Customer Acceptance signature/stamp

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Equipment Classes				
Class	From (°C)	To (°C)	Low Tolerance (°C)	High Tolerance (°C)
2	100.0	250.0	-5.0	5.0

Summary of +/- Readings											
Note: Max/Min channels are evaluated over the stable period											
	100.0		150.0		250.0						
	Min (°C)	Max (°C)	Min (°C)	Max (°C)	Min (°C)	Max (°C)					
PV (°C)	98.5	104.8	147.6	154.0	245.2	254.6					
DEV (°C)	-1.5	4.8	-2.4	4.0	-4.8	4.6					
TC	TC6	TC3	TC3	TC5	TC9	TC5					

Survey Engineer Comments											
Overtemperature policeman tested and found to be working											

Declaration	
Survey Result	The survey results meet the defined criteria and the equipment is deemed to have PASSED. 1) All test instruments have current calibration certificates 2) All tests have been carried out to the method stated
Survey Engineer	Owen Harrison
Approved	Signed <i>O. Harrison</i> Date 16/06/2025 Printed O.Harrison

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Setup Notes
Data summary provides snapshot data at 2 minute intervals
Dimensions apply to the qualified workzone unless otherwise stated
The furnace thermocouple positions are detailed on the furnace information sheet
All readings are corrected measurements
This survey meets the requirements of AMS2750H latest revision

Test Instrument Details				
Type	Make & Model No.	Serial No.	Certificate No.	Expiry Date
Graphic Recorder	6100A	PL 13140000523-1313	LAB - 006 - 310325	30 Jun 2025

Furnace Appliance Instrumentation			
Make & Model No.	Serial No.	Function	Calibration Date
West 4100+	AM 58	Controller	16 Jun 2025
West 6700+	AM 60	Over Temp	16 Jun 2025

Controller Offsets, °C		
Controller	Offset as found (°C)	Offset as left (°C)
West 4100+	0.0	0.0

Survey Setpoint Temperature(s) / Required Tolerance, °C			
SP	Setpoint (°C)	Low Tolerance (°C)	High Tolerance (°C)
SP1	100.0	-5.0	5.0
SP2	150.0	-5.0	5.0
SP3	250.0	-5.0	5.0

Test Thermocouples - Serial Numbers	
Thermocouple	Serial Number
TC1	014309-1-1/011
TC2	014309-1-1/012
TC3	014309-1-1/013
TC4	014309-1-1/014
TC5	014309-1-1/015
TC6	014309-1-1/016
TC7	014309-1-1/017
TC8	014309-1-1/018
TC9	014309-1-1/019

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Thermocouple Correction Factors as Indicated / Interpolated From Calibration Certificates						
	100.0	150.0	250.0			
TC1	0.3	0.2	0.2			
TC2	0.3	0.2	0.2			
TC3	0.3	0.2	0.2			
TC4	0.3	0.2	0.2			
TC5	0.3	0.2	0.2			
TC6	0.3	0.2	0.2			
TC7	0.3	0.2	0.2			
TC8	0.3	0.2	0.2			
TC9	0.3	0.2	0.2			

Recorder Correction Factors as Indicated / Interpolated From Calibration Certificate						
	100.0	150.0	250.0			
TC1	0.0	0.0	0.0			
TC2	0.1	0.0	0.0			
TC3	0.1	0.0	0.0			
TC4	-0.1	0.0	0.1			
TC5	0.1	0.1	0.1			
TC6	-0.1	-0.2	-0.2			
TC7	-0.1	-0.2	-0.2			
TC8	0.0	0.0	-0.1			
TC9	-0.1	-0.1	-0.1			

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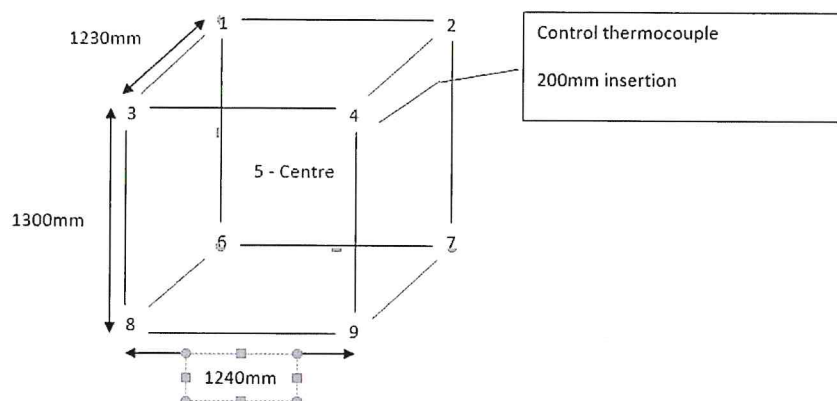
Customer

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Thermocouple Locations



Note

Work zone dimensions

Width (x)(m)	1.240	Height (y)(m)	1.300
Depth (z)(m)	1.230	Volume(m3)	1.983

Location Comments

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Survey Thermocouple Temp. (°C) During Measurement Period											
	100.0		150.0		250.0						
	Min (°C)	Max (°C)	Min (°C)	Max (°C)	Min (°C)	Max (°C)					
TC1	99.6	104.3	148.3	153.4	246.7	254.3					
TC2	99.8	104.6	148.3	153.9	246.7	254.0					
TC3	99.3	104.8	147.6	153.9	245.4	252.9					
TC4	99.4	104.2	147.9	153.3	245.3	252.0					
TC5	99.9	104.7	148.7	154.0	247.2	254.6					
TC6	98.5	103.7	148.1	153.9	245.5	253.8					
TC7	99.4	104.3	148.4	153.8	245.7	253.8					
TC8	99.3	103.1	147.6	151.9	245.6	251.2					
TC9	99.2	103.2	147.6	152.1	245.2	251.2					

Survey Thermocouple Deviations (°C) During Measurement Period											
	100.0		150.0		250.0						
	Min (°C)	Max (°C)	Min (°C)	Max (°C)	Min (°C)	Max (°C)					
TC1	-0.4	4.3	-1.7	3.4	-3.3	4.3					
TC2	-0.2	4.6	-1.7	3.9	-3.3	4.0					
TC3	-0.7	4.8	-2.4	3.9	-4.6	2.9					
TC4	-0.6	4.2	-2.1	3.3	-4.7	2.0					
TC5	-0.1	4.7	-1.3	4.0	-2.8	4.6					
TC6	-1.5	3.7	-1.9	3.9	-4.5	3.8					
TC7	-0.6	4.3	-1.6	3.8	-4.3	3.8					
TC8	-0.7	3.1	-2.4	1.9	-4.4	1.2					
TC9	-0.8	3.2	-2.4	2.1	-4.8	1.2					

Max. Difference Across Survey Thermocouples (°C) During Measurement Period						
100.0	150.0	250.0				
6.2	6.4	9.3				

Note: Monitoring Threshold (°C)	
55.0	

Maximum Over/Under Shoot on Ramp to Set Point (°C)						
	100.0	150.0	250.0			
TC1	4.4	3.4	4.4			
TC2	4.8	3.8	4.3			
TC3	4.8	3.9	3.0			
TC4	4.0	3.0	1.8			
TC5	4.8	3.9	4.6			
TC6	4.3	4.7	4.2			
TC7	4.8	4.0	4.4			
TC8	2.7	1.4	0.9			
TC9	2.9	1.8	0.5			

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Setpoint (°C) 100.0, °C						
	08:17:00	08:19:00	08:21:00	08:23:00	08:25:00	08:27:00
TC1	59.8	74.1	86.9	94.3	97.1	96.7
TC2	58.9	72.9	85.8	93.0	95.9	96.1
TC3	58.7	72.2	84.5	92.5	96.0	97.0
TC4	58.0	71.9	84.1	92.4	95.4	95.0
TC5	60.8	75.3	88.0	95.9	98.2	97.3
TC6	61.1	76.0	88.7	96.7	98.7	97.3
TC7	61.5	76.4	89.3	97.1	99.0	97.8
TC8	55.4	68.8	80.8	88.8	91.7	92.4
TC9	56.6	70.8	83.2	91.2	93.3	93.2
	08:29:00	08:31:00	08:33:00	08:35:00	08:37:00	08:39:00
TC1	95.0	95.7	98.0	100.1	101.5	103.2
TC2	95.0	95.4	97.8	100.2	101.4	103.2
TC3	95.4	94.3	96.1	98.4	100.0	101.7
TC4	94.0	94.2	96.8	98.6	100.5	102.1
TC5	95.3	95.8	98.1	100.4	101.6	103.5
TC6	94.8	94.9	96.9	99.3	100.4	102.3
TC7	95.6	95.6	98.0	100.3	101.5	103.3
TC8	92.5	94.0	96.4	98.5	100.0	101.3
TC9	92.6	93.8	96.5	98.4	100.1	101.7
	08:41:00	08:43:00	08:45:00	08:47:00	08:49:00	08:51:00
TC1	103.8	104.1	102.1	100.1	100.3	101.0
TC2	104.2	104.6	102.3	100.0	100.4	101.1
TC3	103.0	104.5	103.4	99.8	99.5	100.1
TC4	103.0	103.6	101.9	99.4	99.7	100.4
TC5	104.2	104.2	102.4	100.2	100.5	101.1
TC6	103.3	103.7	101.9	99.0	99.2	99.9
TC7	104.0	104.3	102.3	99.9	100.2	100.9
TC8	101.9	102.2	100.8	99.3	99.6	100.3
TC9	102.2	102.1	100.3	99.1	99.5	100.3
	08:53:00	08:55:00	08:57:00	08:59:00	09:01:00	09:03:00
TC1	101.6	101.7	102.6	103.8	102.8	99.9
TC2	101.6	101.8	102.8	104.1	102.9	100.1
TC3	100.7	100.9	102.0	104.0	104.5	100.5
TC4	101.0	101.1	102.2	103.7	102.7	99.6
TC5	101.6	102.0	102.9	104.1	103.2	100.1
TC6	100.4	100.7	101.8	103.2	102.3	98.9
TC7	101.4	101.6	102.6	103.8	102.8	99.7
TC8	100.8	101.0	101.7	102.6	101.3	99.5
TC9	100.7	100.9	101.7	102.8	101.0	99.2
	09:05:00	09:07:00	09:09:00	09:11:00	09:13:00	09:15:00
TC1	100.2	101.1	101.0	99.9	103.5	103.6
TC2	100.3	101.3	101.2	100.1	104.0	104.1
TC3	99.7	100.5	100.4	100.6	103.3	104.0
TC4	99.9	100.7	100.6	99.7	103.4	103.6

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Setpoint (°C) 100.0, °C						
	09:05:00	09:07:00	09:09:00	09:11:00	09:13:00	09:15:00
TC5	100.4	101.3	101.2	100.2	103.8	104.0
TC6	99.0	100.0	99.8	98.9	102.7	102.9
TC7	100.0	100.9	100.8	99.7	103.5	103.6
TC8	99.8	100.7	100.5	99.5	102.6	102.5
TC9	99.9	100.7	100.6	99.5	102.9	103.0
	09:17:00	09:19:00	09:21:00	09:23:00	09:25:00	
TC1	102.7	100.5	100.7	101.3	100.3	
TC2	102.9	100.6	100.8	101.4	100.5	
TC3	103.6	101.4	100.2	100.7	99.9	
TC4	102.7	100.1	100.4	100.9	100.1	
TC5	103.0	100.7	100.9	101.4	100.4	
TC6	102.1	99.5	99.5	100.1	99.1	
TC7	102.7	100.3	100.4	101.1	100.1	
TC8	101.7	100.1	100.4	100.9	100.0	
TC9	101.9	99.9	100.4	100.8	99.9	

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Setpoint (°C) 150.0, °C						
	09:30:00	09:32:00	09:34:00	09:36:00	09:38:00	09:40:00
TC1	123.0	137.4	145.0	147.0	147.7	146.4
TC2	122.2	136.6	144.4	146.2	146.6	145.9
TC3	122.1	135.5	142.0	146.2	148.0	146.9
TC4	121.9	135.2	141.8	145.2	146.6	145.5
TC5	124.2	138.6	145.8	148.5	148.9	146.9
TC6	125.4	140.5	147.0	150.0	150.3	148.1
TC7	124.7	139.7	146.1	149.2	149.4	147.1
TC8	118.5	131.4	138.9	141.2	142.5	142.9
TC9	119.8	134.0	141.3	143.3	143.7	143.2
	09:42:00	09:44:00	09:46:00	09:48:00	09:50:00	09:52:00
TC1	144.8	145.3	147.5	149.2	150.8	152.0
TC2	144.6	145.1	147.6	148.9	150.9	151.8
TC3	145.4	143.5	145.5	147.0	148.8	150.1
TC4	144.0	143.5	146.1	147.7	149.5	150.8
TC5	145.2	145.8	148.0	149.7	151.1	152.4
TC6	145.9	145.9	148.1	149.3	150.9	152.4
TC7	145.2	145.9	147.9	149.6	151.2	152.5
TC8	142.3	143.0	145.7	147.0	148.8	149.4
TC9	142.6	143.8	146.2	147.5	148.9	149.9
	09:54:00	09:56:00	09:58:00	10:00:00	10:02:00	10:04:00
TC1	153.0	152.2	149.5	148.2	148.9	149.8
TC2	153.5	152.6	149.6	148.3	148.9	149.8
TC3	152.7	153.5	150.8	147.4	147.5	148.4
TC4	152.8	152.1	149.3	147.5	148.2	149.2
TC5	153.5	152.8	150.0	148.7	149.2	150.0
TC6	153.5	153.1	149.9	148.2	148.7	149.6
TC7	153.3	152.5	149.9	148.5	149.1	149.8
TC8	150.6	150.0	148.1	147.3	147.8	148.8
TC9	151.2	150.4	148.0	147.3	148.1	149.0
	10:06:00	10:08:00	10:10:00	10:12:00	10:14:00	10:16:00
TC1	150.8	151.9	152.5	152.9	150.6	148.6
TC2	150.8	152.1	152.7	153.0	150.8	148.7
TC3	149.5	150.6	151.7	153.6	152.0	148.2
TC4	150.3	151.2	152.1	152.9	150.4	148.3
TC5	150.9	152.4	153.0	153.5	151.2	149.1
TC6	150.6	152.0	152.7	153.3	151.1	148.6
TC7	150.9	152.1	152.7	153.2	151.1	148.8
TC8	149.6	150.5	150.8	151.0	149.3	148.0
TC9	150.0	150.7	151.1	150.8	149.1	147.9
	10:18:00	10:20:00	10:22:00	10:24:00	10:26:00	10:28:00
TC1	149.3	149.8	150.8	151.8	152.3	152.7
TC2	149.3	149.8	150.9	152.1	152.5	152.8
TC3	148.2	148.6	149.7	150.9	151.5	153.1
TC4	148.9	149.3	150.5	151.5	152.1	152.6

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Setpoint (°C) 150.0, °C						
	10:18:00	10:20:00	10:22:00	10:24:00	10:26:00	10:28:00
TC5	149.5	150.1	151.1	152.2	152.7	153.1
TC6	149.0	149.5	150.6	151.8	152.6	153.2
TC7	149.4	149.9	150.9	151.9	152.7	153.1
TC8	148.6	148.9	149.9	150.7	150.9	151.1
TC9	148.6	149.1	150.1	151.0	151.3	151.3
	10:30:00	10:32:00	10:34:00	10:36:00	10:38:00	10:40:00
TC1	151.1	149.1	149.5	150.0	151.1	152.0
TC2	151.2	149.2	149.6	150.1	151.2	152.3
TC3	152.7	149.0	148.6	149.0	150.0	151.1
TC4	151.0	148.9	149.1	149.6	150.7	151.8
TC5	151.7	149.5	149.8	150.3	151.4	152.5
TC6	151.8	149.0	149.2	149.7	150.9	152.1
TC7	151.5	149.2	149.6	150.1	151.2	152.3
TC8	149.9	148.6	148.9	149.4	150.3	151.0
TC9	149.7	148.6	149.0	149.5	150.5	151.3

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Setpoint (°C) 250.0, °C						
	10:48:00	10:50:00	10:52:00	10:54:00	10:56:00	10:58:00
TC1	202.3	212.1	221.4	229.2	235.9	240.2
TC2	201.1	211.0	220.2	228.0	235.2	239.0
TC3	194.1	203.2	210.9	218.7	225.8	230.6
TC4	192.4	201.7	209.6	217.2	224.8	231.4
TC5	198.8	208.3	216.8	224.9	232.1	238.0
TC6	196.0	205.4	214.5	222.6	229.6	236.6
TC7	196.2	205.7	214.6	223.1	230.6	236.6
TC8	190.6	200.1	207.8	215.1	222.4	229.8
TC9	194.0	202.6	211.4	217.9	225.0	229.4
	11:00:00	11:02:00	11:04:00	11:06:00	11:08:00	11:10:00
TC1	244.4	245.1	242.9	245.1	247.3	248.4
TC2	243.6	245.0	242.5	244.4	246.6	248.1
TC3	237.7	241.0	238.6	240.6	242.8	244.5
TC4	237.9	241.3	238.8	241.2	243.1	245.0
TC5	244.1	246.1	243.6	245.8	247.7	249.2
TC6	243.2	246.4	243.3	245.3	247.2	249.1
TC7	243.0	245.7	243.0	245.2	247.2	249.2
TC8	237.1	241.8	239.5	241.3	242.9	244.9
TC9	236.4	240.3	239.1	241.3	242.3	243.9
	11:12:00	11:14:00	11:16:00	11:18:00	11:20:00	11:22:00
TC1	249.2	248.9	247.6	245.0	244.0	245.9
TC2	249.1	248.7	247.8	245.0	243.6	245.5
TC3	246.6	246.8	245.6	244.0	241.9	242.8
TC4	246.4	246.6	245.5	242.8	241.3	242.9
TC5	250.1	250.0	248.3	245.5	244.3	246.4
TC6	250.9	250.3	248.4	245.6	243.1	244.9
TC7	250.8	250.7	248.4	245.3	243.1	245.0
TC8	246.0	245.9	244.6	242.5	241.7	243.2
TC9	244.8	244.6	243.9	242.2	241.0	243.2
	11:24:00	11:26:00	11:28:00	11:30:00	11:32:00	11:34:00
TC1	247.3	249.8	251.9	252.5	250.6	248.4
TC2	246.9	249.4	251.9	252.3	250.4	248.1
TC3	244.1	246.5	249.1	250.9	250.2	248.1
TC4	244.6	246.7	249.3	250.4	249.0	246.9
TC5	247.8	250.5	252.7	253.2	251.3	249.3
TC6	246.4	249.0	252.0	253.5	251.4	248.7
TC7	246.6	249.2	252.1	253.4	251.4	248.8
TC8	244.9	246.6	248.7	249.3	248.2	246.2
TC9	244.6	246.5	248.0	248.8	247.2	245.6
	11:36:00	11:38:00	11:40:00	11:42:00	11:44:00	11:46:00
TC1	246.6	247.5	248.8	250.7	252.7	254.4
TC2	246.3	247.2	248.4	250.3	252.3	254.3
TC3	245.5	245.2	246.5	248.2	249.9	251.6
TC4	244.7	245.4	246.4	248.1	250.2	251.4

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Setpoint (°C) 250.0, °C						
	11:36:00	11:38:00	11:40:00	11:42:00	11:44:00	11:46:00
TC5	247.2	248.1	249.7	251.1	253.3	254.6
TC6	245.9	246.5	247.9	249.7	252.3	254.2
TC7	245.8	246.6	248.2	249.8	252.4	254.4
TC8	244.9	245.8	247.1	248.5	250.2	250.8
TC9	244.6	245.6	246.7	248.1	249.9	250.5
	11:48:00	11:50:00	11:52:00	11:54:00	11:56:00	11:58:00
TC1	253.1	249.8	246.8	247.4	248.9	250.4
TC2	252.8	249.6	246.7	247.2	248.7	250.3
TC3	252.1	249.9	246.1	245.6	246.5	248.1
TC4	251.0	247.8	245.4	245.5	246.9	248.3
TC5	253.6	250.0	247.4	248.0	249.4	250.8
TC6	253.4	249.5	246.0	246.2	247.6	249.4
TC7	253.5	249.3	246.0	246.3	247.8	249.4
TC8	249.8	247.4	245.6	246.1	247.2	248.3
TC9	249.1	247.0	245.0	245.6	246.8	248.3
	12:00:00	12:02:00	12:04:00	12:06:00	12:08:00	12:10:00
TC1	252.0	253.5	253.2	249.9	247.2	247.4
TC2	252.0	253.5	253.4	250.2	247.3	247.3
TC3	249.5	252.3	252.3	249.9	246.8	245.7
TC4	249.6	251.4	251.4	248.1	245.9	246.0
TC5	252.6	254.3	253.4	250.3	247.7	247.9
TC6	251.3	253.7	253.1	249.9	246.3	246.2
TC7	251.2	253.7	253.0	249.8	246.4	246.3
TC8	249.7	250.8	250.4	248.5	246.1	246.2
TC9	249.4	250.1	249.5	247.8	246.0	246.1
	12:12:00	12:14:00	12:16:00	12:18:00	12:20:00	12:22:00
TC1	248.6	250.0	251.6	253.1	253.3	250.5
TC2	248.4	250.0	251.5	252.9	253.4	250.9
TC3	246.7	248.0	249.1	251.7	252.9	250.8
TC4	246.9	248.1	249.5	251.1	251.1	248.9
TC5	249.0	250.7	252.2	253.6	253.9	250.9
TC6	247.2	249.0	250.6	252.8	253.0	250.4
TC7	247.4	249.2	250.8	252.7	253.2	250.0
TC8	247.2	248.5	249.6	250.5	250.3	248.5
TC9	246.8	248.2	249.2	250.0	250.2	248.0
	12:24:00	12:26:00	12:28:00			
TC1	247.9	247.4	248.6			
TC2	247.4	247.4	248.6			
TC3	247.1	245.9	247.0			
TC4	246.2	246.1	247.2			
TC5	248.2	248.0	249.2			
TC6	246.5	246.2	247.4			
TC7	246.6	246.3	247.4			
TC8	246.4	246.4	247.4			

Survey report number Funditor - 160625
Customer Ashton & Moore Limited
Furnace Identifier AM56

Setpoint (°C) 250.0, °C						
	12:24:00	12:26:00	12:28:00			
TC9	245.9	246.3	247.1			

Survey report number

Funditor - 160625

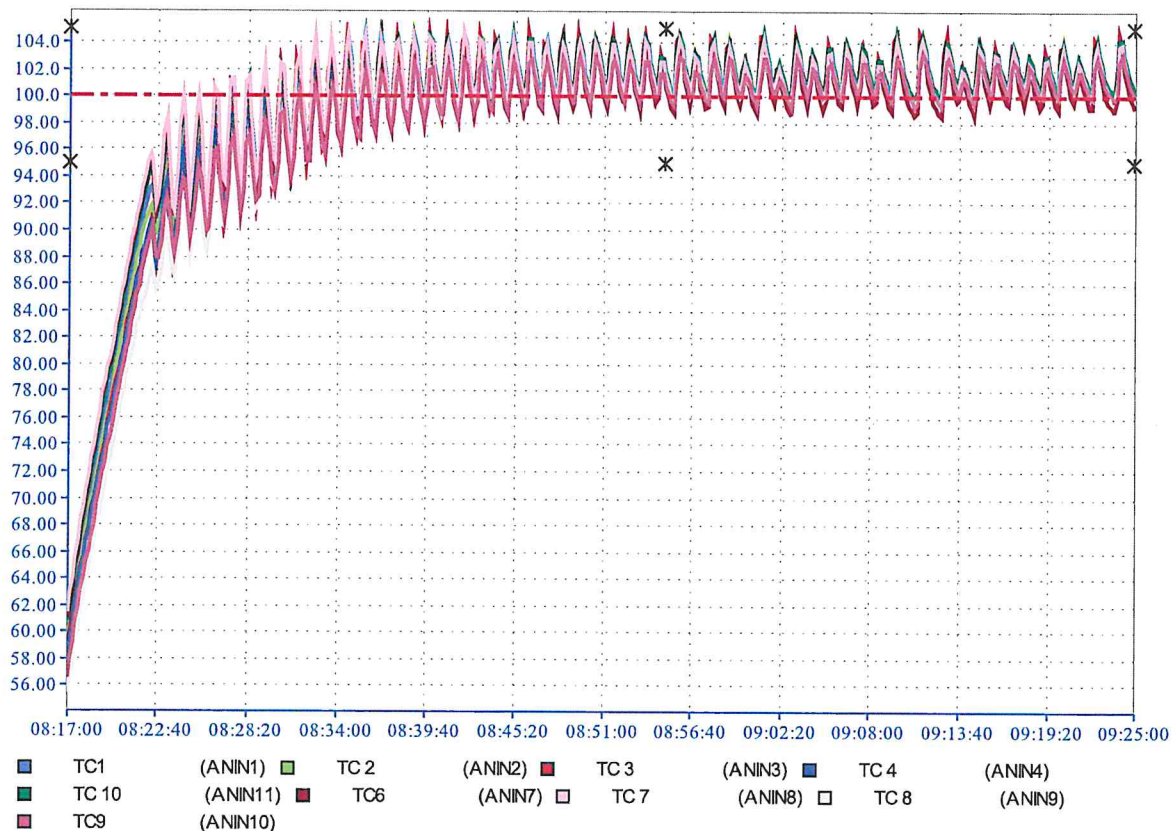
Customer

Ashton & Moore Limited

Furnace Identifier

AM56

Trend for Setpoint 100.0, °C



Survey report number

Funditor - 160625

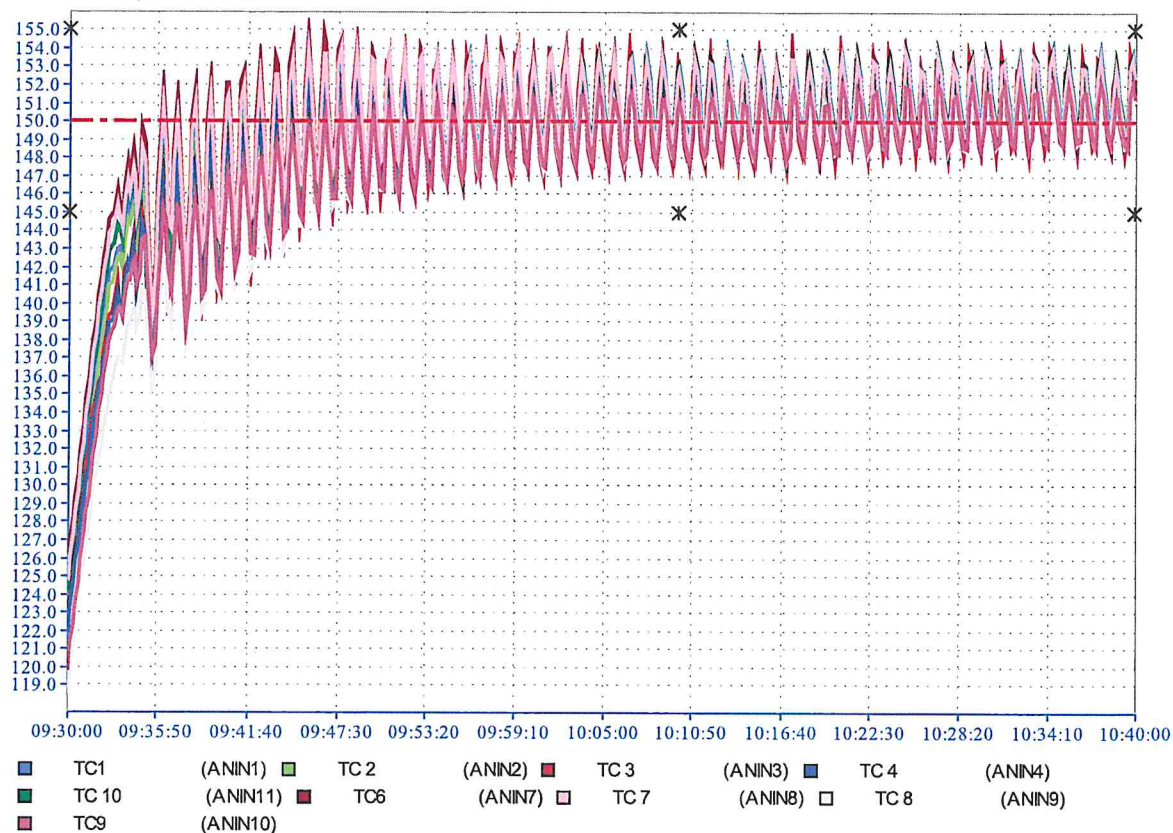
Customer

Ashton & Moore Limited

Furnace Identifier

AM56

Trend for Setpoint 150.0, °C



Survey report number

Funditor - 160625

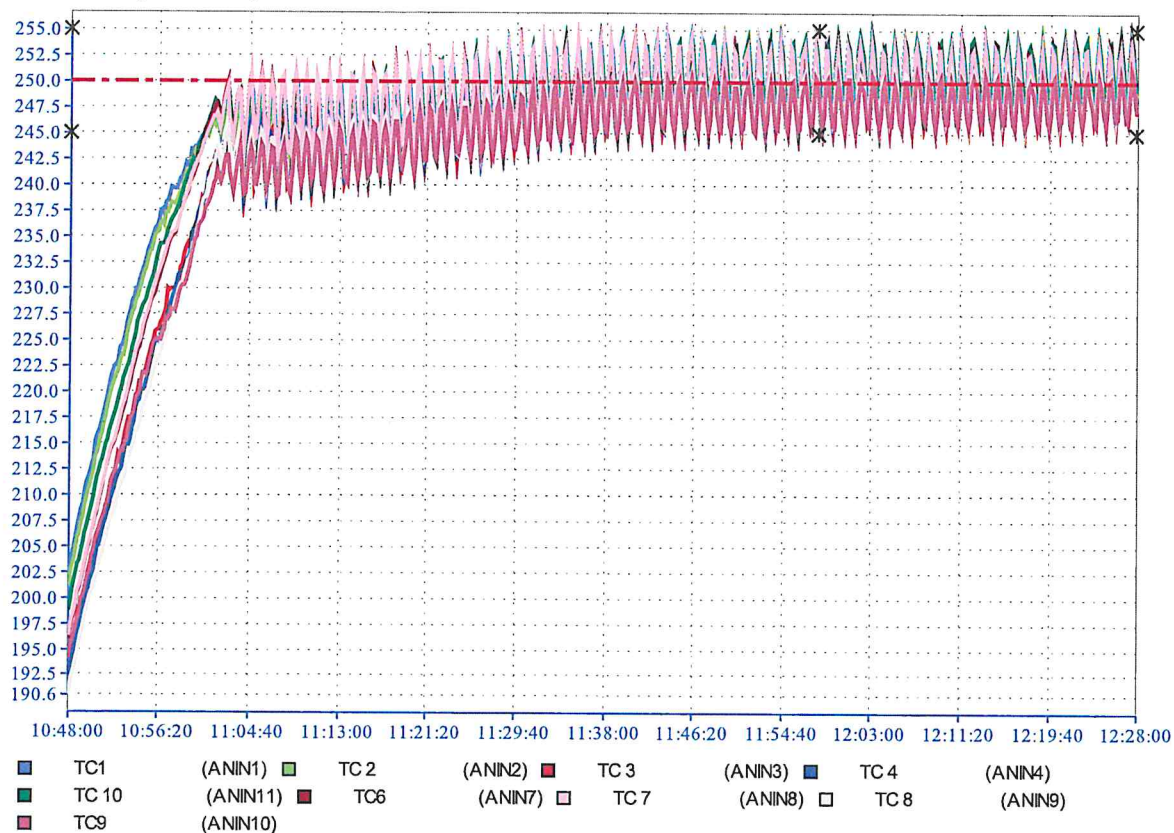
Customer

Ashton & Moore Limited

Furnace Identifier

AM56

Trend for Setpoint 250.0, °C



Survey report number

Funditor - 160625

Customer

Ashton & Moore Limited

Furnace Identifier

AM56

Summary Trend, °C

