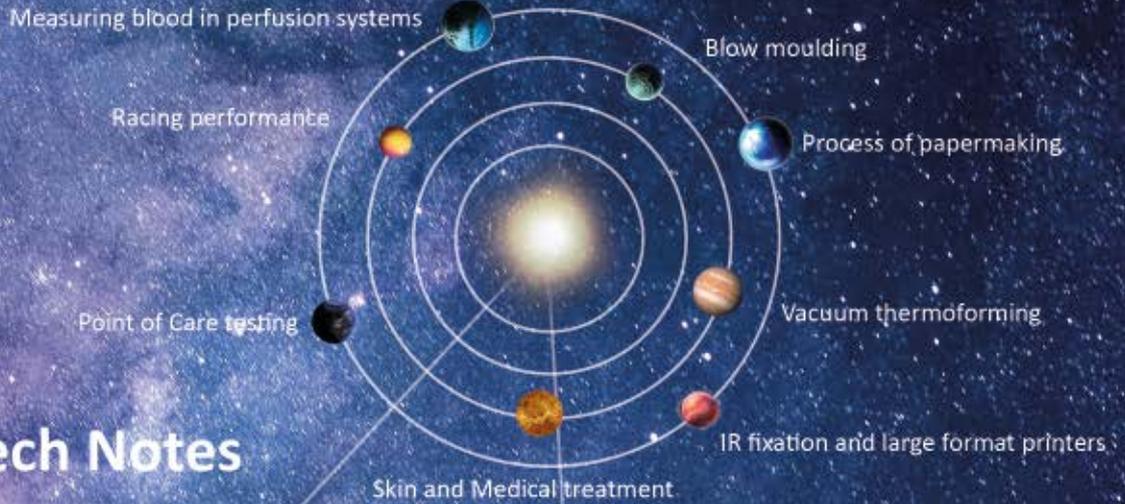
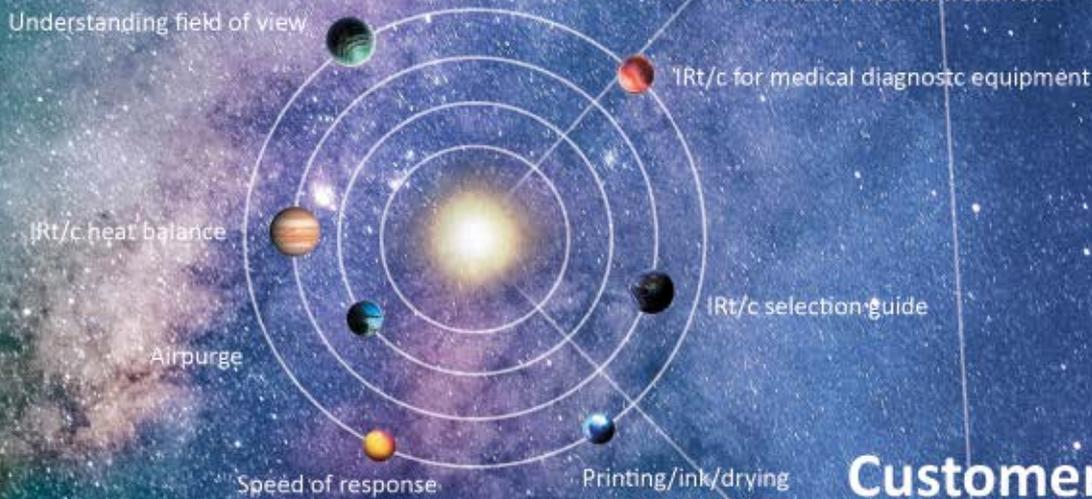


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## **Application Notes**



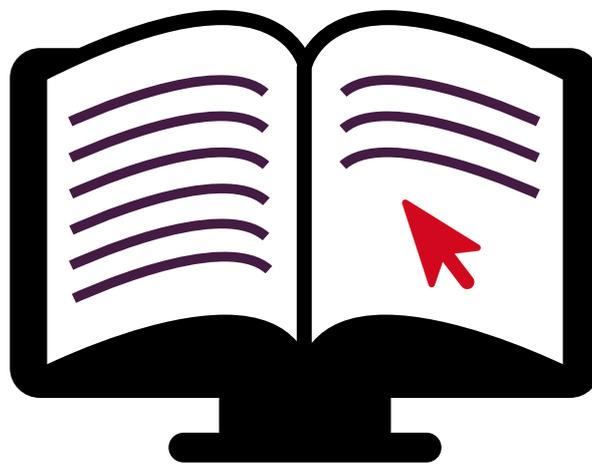
## **Tech Notes**



## **Customers**



***Technote e-Book***



**Technote e-Book**

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Exergen Corporation  
400 Pleasant Street  
Watertown, MA 02472  
USA

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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### INFRARED TECHNOLOGY

#### A bit of history

In 1665, Sir Isaac Newton became the first to slit sunlight into colors with a prism, thus demonstrating the existence of light as radiated energy of differing wavelengths. About 135 years later, another English astronomer/scientist, William Herschel, measured the heat content of each the colors of Newton's spectrum. Herschel was shocked to discover that his thermometer registered the greatest heat beyond the red – in an area of the spectrum he could not see: a serendipitous result, as lore has it, of his thermometer rolling off the red area of the spectrum. He coined the term INFRARED to describe this heat energy, which was beyond the red. All objects emit infrared energy at temperatures above absolute zero (-273°C, -460°F).

Herschel demonstrated that infrared heat radiation and light are simply two forms of electromagnetic energy. Our eyes see light energy because we are equipped to see the wavelengths of light. We cannot see infrared because the wavelengths are too long for our eyes. The very first non contact thermometer was the human eye. An example of a special infrared sensing adaptation from the animal world is the pit viper, which can actually locate warm-blooded animals in the dark with its infrared sensing pit organs below its eyes. An infrared sensor, like Herschel's thermometer and the viper's pit organs, is slightly heated when viewing the longer wavelengths of infrared energy, and provides quantitative information regarding the source of energy.

At the turn of the twentieth century, the German physicist Max Planck discovered the correct mathematical formulation of the relationship between temperature and infrared radiation, for which he won the Nobel Prize, thus paving the way for its use as a method of measuring temperature WITHOUT CONTACT. An unanticipated result of Planck's discovery was quantum physics, arguably the most important scientific development of this century. Then of course we have the unforgettable Albert Einstein who confirmed Planck's Quanta by using the photoelectric effect although Einstein did not really like the result. Recent advances in the technology of infrared temperature measurement have stimulated development of devices that are without doubt, more sensitive than Herschel's thermometer. Several applications of this technology have made it possible to design devices capable of making fast, accurate, and safe non-invasive measurement. In the eighties Dr. Frank Pompei started Exergen, a worldwide leader of unique, patented sensor technologies that set the benchmark for non-contact infrared temperature measurement throughout a wide range of medical and industrial applications such as digital printing, automotive, food, agriculture, aesthetical etc. He not only invented the world's first infrared thermocouple, the world's first pocket sized scanner and non invasive medical infrared thermometer, he also introduced the Speed Boost Equation. Dr. Pompei has filed over 75 patents and next to being the CEO of Exergen Corp, he is also a Guest Scholar at Harvard University.

In this e-book you will find a wide variety of tech notes, which we will keep on adding with every customized solution. You will be guided by our character... our vipIR. Why this vipIR? First of all it stands for very important product infrared. Of course the vipIR is a snake with a wink to the viper and in particular the pit viper which we mentioned a bit earlier. The pit viper's organs are small facial cavities covered by a thin membrane of sensory cell that respond to temperature differences of just .003°C, and can detect the presence of a warm-blooded animal at distances of up to 50 cm in total darkness simply from the animal's infrared radiation.

We do hope that this e-book will provide you with the information you are looking for. If not, check out our website [www.exergenglobal.com](http://www.exergenglobal.com) or give us a call at **+31413376599** or **+16176496322**.

#### Exergen Global offices:

---

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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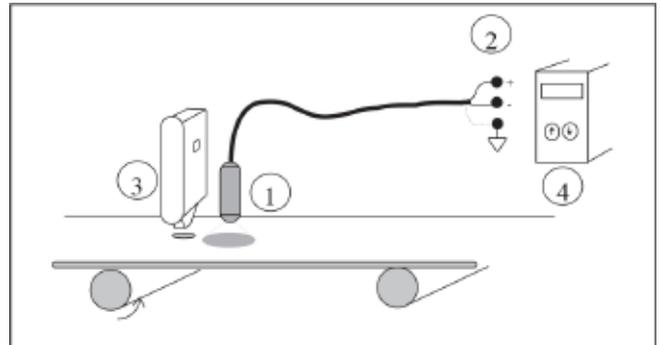
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## QUICK INSTALLATION GUIDE PRE-CALIBRATED MODELS

All infrared-based sensing systems must be calibrated for specific material surface properties (for example, the amount of heat radiated from the target surface, environmental heat reflections, etc.). This calibration is performed by measuring the target surface temperature with a reliable independent surface temperature probe. The easiest and fastest method of accurately calibrating out these effects is to use an Exergen Microscanner D-Series hand-held Infrared Thermometer with a patented Automatic Emissivity Compensation System, which gives a true reading regardless of emissivity. Your Authorized IRT/c Distributor will be pleased to make a D-Series available for your installation. To calibrate Adjustable models (IRT/c. xxA) see Tech Note #60.

The following procedure is recommended:

1. Install the IRT/c as close as practical to view the target material to be measured.
2. Wire the IRT/c to the controller, PLC, transmitter, etc. in standard fashion (including



ground shield as in Tech Note #82). As with conventional thermocouples, red wire is always (-).

3. Bring the process up to normal operating temperature and measure the actual temperature of the target material with the Microscanner D-Series Infrared Thermometer.
4. Adjust "input offset," "zero," "low cal," on the readout device to match the Microscanner reading. Installation Complete. (For OEM installations preset the same adjustments. Individual calibration is not required.)

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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www.exergenglobal.com

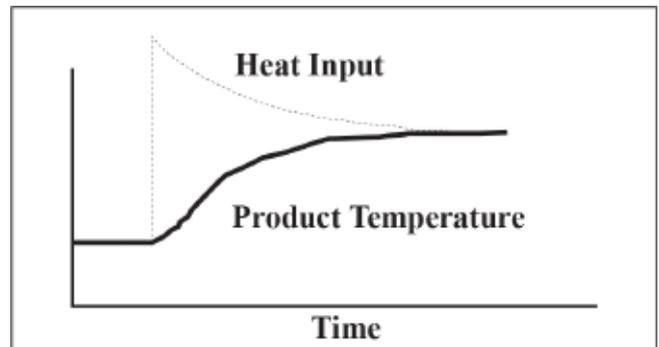
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## IRt/c SETUP WITH AUTO-TUNE TEMPERATURE CONTROLLERS

In many applications, heating elements are employed to heat a product in an oven, furnace, or with jets of hot air. Conventional control devices using contact thermocouples measure and control the oven air temperature, IR heating element temperature, or air jet temperature in an effort to maintain product temperature and therefore, quality; often with less than satisfactory results.

Replacing the contact thermocouple (for example, measuring oven temperature) with a non-contact IRt/c measuring product temperature directly will insure that product temperature is maintained. Some readjustment of the controller parameters is required because of differences in sensor response times (an IRt/c is much faster) and time required to heat the product compared to the original sensor (slower). After installing the IRt/c and calibrating the controller reading using a



Microscanner D-Series (see Tech Note #1), initiate the self-tuning cycle of the controller and check to see that the control is stable and accurate. If it will not self tune properly, manually adjust the control coefficients to achieve stable control. Because the product temperature is likely to change temperature more slowly than the original sensor, start with slowly increasing the “D” of the PID coefficients.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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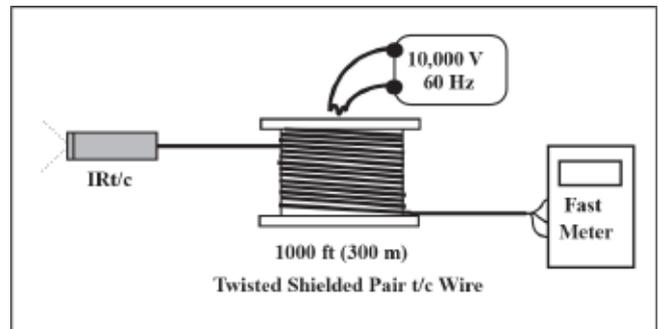
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## IRt/c CAN BE USED WITH UP TO 1,000 FEET (300 M) OF THERMOCOUPLE EXTENSION WIRE

With twisted shielded pair thermocouple extension wire, an IRt/c can be mounted as far as 1,000 ft (300 meters) from the readout device, even in a very fierce electrical noise environment. The extraordinary noise suppression characteristics designed into the IRt/c make this possible, without using a transmitter. The IRt/c housing is electrically isolated from the signal leads and is connected to the shielded ground of the extension cable. For long distances, the twisted shielded extension cable should be used, and the shield connected to a good electrical ground.

A demonstration test was performed with a 1000 ft (300 m) coil of twisted shielded pair of extension wire, with 100 ft (30 m) unwound, connecting an IRt/c to a fast (100 msec response) A/D conversion



module to a computer. As a noise generator, a 60 Hz 10,000 volt transformer and spark generator was set up to spark within 6 inches (15 cm) of the wire. The test results showed less than 0.1°C of noise at any relative position of the wire, spark, and transformer.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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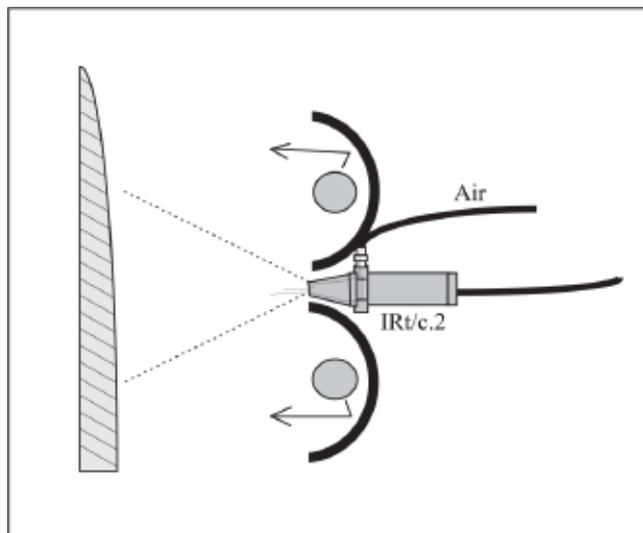
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## IRt/c CONTROLS PAINT CURING WITH RADIANT HEATERS

A rather logical combination of heating method and control is radiant heat with an IRt/c for control. They work extraordinarily well together, since both the heating and measuring occur right at the surface, where the paint is located. The IRt/c reading is unaffected by reflections from the heater, since the spectral response of the 6-14 micron IRt/c lens filters out the shorter wavelengths of the radiant heater energy.

The IRt/c may be mounted in the shroud or reflector of the radiant heater, such that it can see through the elements. Select any of the IRt/c models, depending on the field-of-view required to see past the elements to the painted surface. Test the location by turning on the heater with no target present. The change in reading should be small. Care should be taken in mounting the IRt/c in such a way as to keep its temperature below 200°F (93°C) and to keep the lens clean. The IRt/c.3x, .5, and .10 are the preferred models



for this application because of their built-in air purge. They can be used in environments with temperatures up to 250°F (121°C) or higher when the air purge system is used. The narrow fields-of-view allow more leeway in positioning, and thus more flexibility in installation.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
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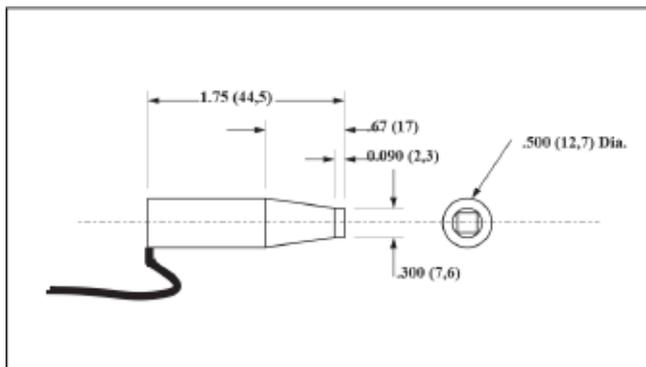
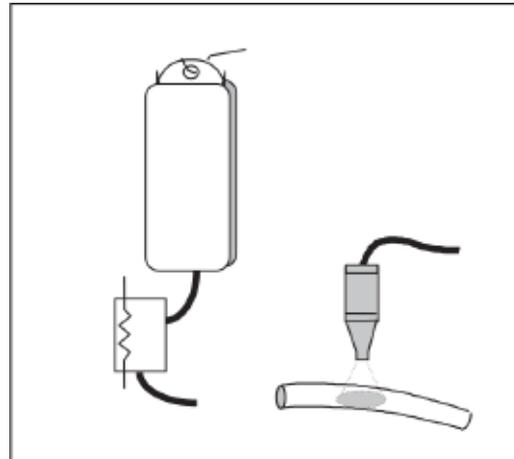
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## IRt/c FOR MEDICAL DIAGNOSTIC EQUIPMENT: IRt/c.2G-J-37

Many processes in clinical diagnostics and therapies involve blood samples and other fluids that must be heated to 98.6°F (37°C) for optimum performance. Since sterility and absolute prevention of contamination are paramount, measuring and controlling fluid temperatures is not a trivial task. Using accurate thermistors or thermocouples in the disposable fluid handling components is generally much too expensive, and use of contact devices creates the risk contamination and inaccuracies.



The IRt/c is an excellent solution to the problem. Its small size, low cost, and easy interface with standard thermocouple closed-loop control circuitry are ideal. The IRt/c.2G J-37 is designed and calibrated to be highly accurate at 37°C. The J-type is offered because the leads are easily soldered to circuit boards with standard materials, and off-the-shelf cold junction compensation amplifiers are available. It is equipped with a hard pure germanium crystal lens that withstands repeated cleanings, and a failsafe xenon gas fill system. Its hermetically sealed stainless steel construction permits it to be gas sterilized.

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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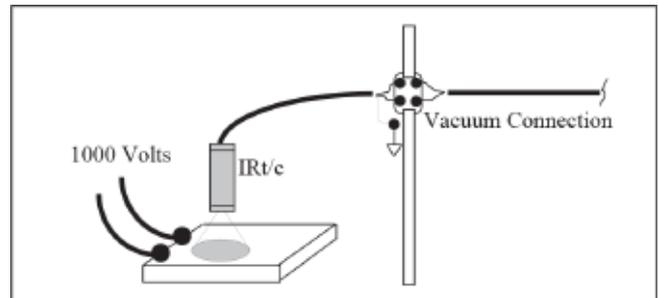
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## IRt/c SOLVES VACUUM FURNACE ELECTRICAL ISOLATION PROBLEM

A vacuum furnace manufacturer employs a heat treating process in which the metal parts experience an electrical potential of 1000 volts. To control the heating process to produce the correct metallurgical properties, a conventional thermocouple embedded in one of the parts produces the temperature signal for the controller. However, since the parts are at 1000 volts, an elaborate electrical isolation system has to be employed to permit the thermocouple to work safely, at a cost of well over \$2,000.

Replacing the contact thermocouple with a noncontact IRt/c, the manufacturer effectively replaced \$2,000 worth of equipment with about 1 inch (2.5 cm) of vacuum separation between the IRt/c and test part - which is free. Unlike a contact thermocouple, the IRt/c can easily see the part through the vacuum, measure its temperature



without touching, remaining completely isolated electrically by the gap between the part and IRt/c. Since the part is heated to 1000°F (538°C), an aluminum clamp is employed as a heat sink to keep the IRt/c itself below 200°F (93°C). Since the part emissivity is low (shiny metal) the test part has a small area painted with Rustoleum® Barbecue Black Paint, rated to 1300°F (704°C), to raise the emissivity.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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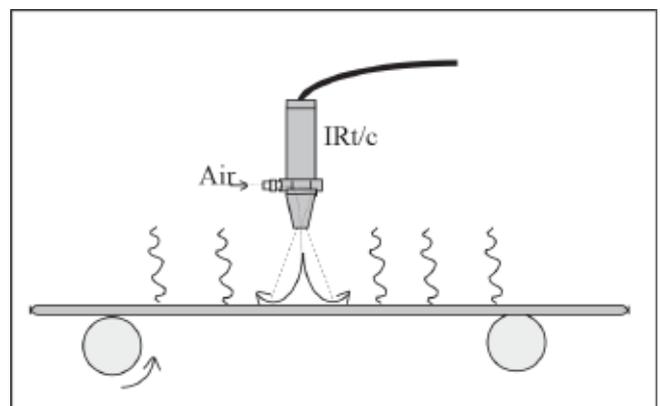
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## TEMPERATURE MEASUREMENTS IN STEAMING ENVIRONMENTS

A common problem in processing of paper and other material is measuring temperature in an area in which steam (water) is used to heat and cool the material. The resulting steam vapor makes it very difficult to use non-contact infrared devices because steam vapor is opaque to infrared wavelengths commonly used, i.e. the sensor cannot see through the vapor fog very well, and thus would report temperatures that were too low. In addition, condensing steam vapor on the sensor lens would render the IRt/c completely blind to infrared wavelengths.

The IRt/c air purge models solve the problems in a simple and inexpensive fashion. The air jet from the built-in air purge clears a path to the target material by “blowing away” the steam vapor in

the optical path, replacing it with dry air. Care is required in the set-up of distance to the target and air pressure employed, to prevent cooling of the target area by the air jet.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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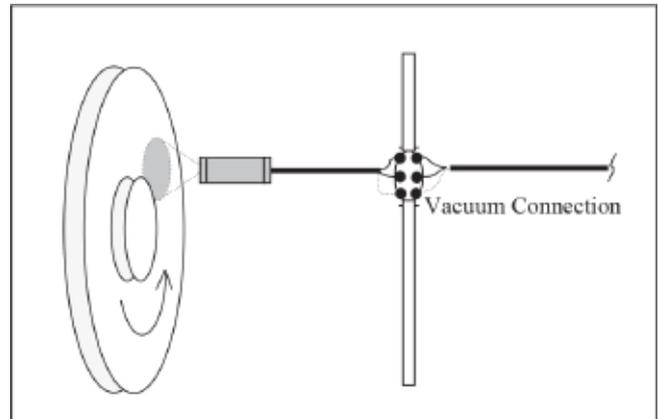
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## ROTOR DISK TESTS IN VACUUM

Large steam and gas turbine rotor disks require spin testing to assure mechanical reliability at the high forces experienced during full speed operation. This testing is usually conducted in a large vacuum chamber to minimize the required power to drive the rotor. However, the vacuum is not perfect and rotor heating does occur during the test. To properly assess performance, the disk temperature must be known. Standard methods of measuring temperature, such as disk-mounted sensors, using slip rings or telemetry to transmit the data, are clumsy and expensive.

The IRt/c can directly measure the temperature of the rotor under full speed conditions. With its hermetically sealed construction, the IRt/c operates in a vacuum without any requirement for protection. Its thermocouple leads can be connected to a standard thermocouple vacuum connector.

Test installation design considerations should include IRt/c body temperature and target



emissivity. To assure that the IRt/c will remain below 200°F (95°C) even with very hot targets, use a solid metal mounting arrangement to heat sink the IRt/c body, since the internal construction is designed to readily conduct away the radiated heat. For emissivity considerations, a shiny metal rotor disk should have black painted stripes in the areas of measurement. For best accuracy, the IRt/c read-out device can be calibrated to the precise surface conditions by using a Microscanner D-Series.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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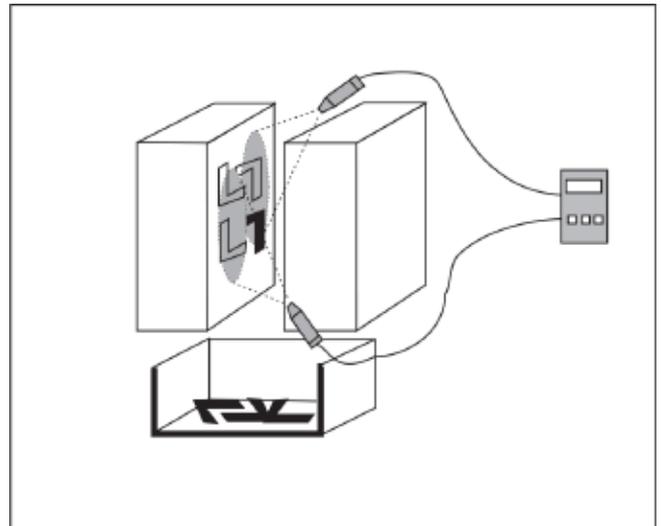
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## **IRt/c MONITORS PLASTIC INJECTION MOLD CLEARING**

In high volume plastic injection molding machinery, a molded part that does not clear the mold can cause serious problems, including a long down time to clean up or make repairs.

A particularly useful property of the mold is its shininess, which means low emissivity. Accordingly, the infrared radiation from an open mold is primarily reflected from the room, and thus an IRt/c pointed at the mold would not read much higher than room temperature. However, if a part is still in the mold, the IR radiation is far higher since the high emissivity of the plastic part is easily seen by the IRt/c as the temperature of the hot part. By mounting an IRt/c so that it can view the part as the mold opens, a reliable and inexpensive part detection system can be installed. Simply connect the IRt/c to a simple thermocouple controller with alarms interfaced to the mold position. For efficient coverage of the mold, two IRt/c's can be wired in parallel and



connected to a single controller, so that a part viewed by either sensor will alarm.

For harsh environments, the IRt/c.3x or IRt/c.5 models with narrow field-of-view and built-in air purge are recommended.

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

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400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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TN-009-1-EN

## IRt/c'S ARE INTRINSICALLY SAFE WHEN USED WITH BARRIERS

“Field Apparatus having energy storing or generating characteristics of <1.2V, 0.1A, 25 mW or 25 microJ shall be considered Simple Apparatus (nonenergy storing). These general purpose devices may be used in a hazardous (classified) location without further approval when connected to a certified intrinsically safe circuit.” -Quote from R. Stahl, Inc. Comprehensive Product Manual On Intrinsic Safety Barrier and Repeater Relays.

Examples of non-energy storing Intrinsically Safe Apparatus are:

- Thermocouples, RTD's, LED's
- Dry Switch Contacts
- NAMUR Inductive Proximity Switches
- Non-inductive Strain Gauge Devices and Resistors

The IRt/c falls into the category of thermocouples, since it generates its signal by converting the radiated heat energy to an electrical signal via Seebeck effects, the basic driving force of thermocouples. Like all thermocouples, it requires no power source and generates signals measured in millivolts of voltage, microamps of current and nanowatts of power. IRt/c's have a small capacitance, but at one microFarad, the energy storage is measured in nanojoules and is a thousand times lower than the 25 microJ criterion.

Accordingly, the IRt/c qualifies as a Simple Apparatus for use in hazardous locations, and with the appropriate barrier, qualifies as Intrinsically Safe.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
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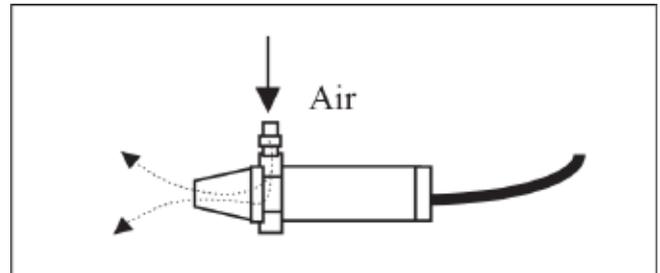
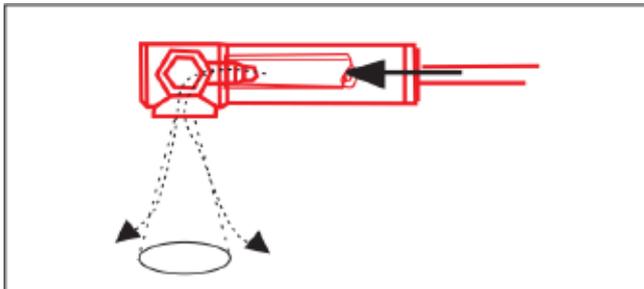
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## IRt/c.3X REDUCES AIR PURGE AIR CONSUMPTION BY A FACTOR OF 100

An air purge is ideal for keeping the lenses of infrared temperature sensing heads in continuous manufacturing duty service clean, especially in particularly dirty or oily environments. Even a small amount of dirt or oil coating on a lens can affect the reading: if 5% of the lens area is covered, then 5% of the reading is lost. For conventional IR devices, with lens size of 1" (2.5 cm) or more, upwards of 1 CFM (.03 cubic meter/min.) is required to maintain cleanliness. At typical costs for plant compressed air, a single continuous duty conventional IR sensor uses approximately \$100 of air per year. Clearly, if a plant has many IR installations, the cost of air is of considerable concern.



The small 1/4 inch (.6 cm) lenses of the IRt/c.3x and IRt/c.3SV make it possible to purge with as little as .01 CFM (.0003 cubic meters/min.) of air. With such a small amount of air, it becomes possible to use instrument air, if it is conveniently available, which is already clean and dry, without adding the additional hardware to clean and dry the IR purge air. In addition, the IRt/c.3x can be air purged with a small inexpensive air pump, thus not requiring a plant air source. At the very low flow rate, the IRt/c air cost is only approximately \$1 per year, a 100-fold reduction over conventional IR devices.

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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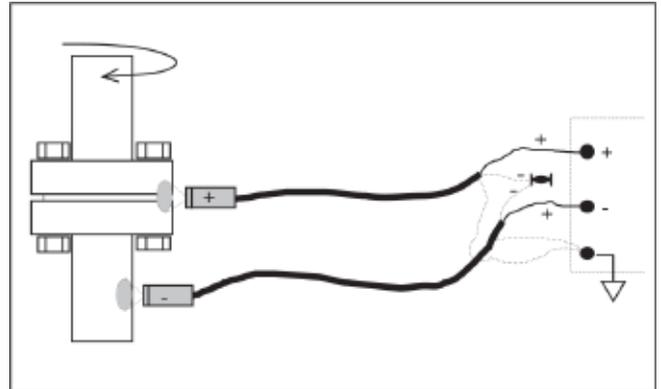
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## IRt/c MONITORS MECHANICAL DRIVES FOR BEARING FAILURE

For certain highly loaded mechanical drive elements, such as the main rotor drive for a helicopter, it is imperative that impending failure be detected before a catastrophe occurs. A central element of the drive, such as a universal joint or coupling, will telegraph its impending failure well in advance by displaying an increase in temperature. For example, if a drive transmitting 1000 hp (750 kW) of shaft power with a universal joint loses only 0.1% in drive efficiency, the joint will increase in temperature as much as several hundred degrees until it is able to dissipate an additional 750 watts of energy as heat. This increase in temperature is a direct and reliable indication of the increased inefficiency caused by a degradation in parts performance.

Monitoring the joint with an IRt/c provides a fast and direct indication of joint temperature, and thus the increasing inefficiency due to wear or failure. A more sensitive method of monitoring the joint is to employ two IRt/c's wired differentially



(connecting the two minus leads together and measuring across the plus leads, see example), measuring the difference in temperature between the joint and adjoining shaft. This difference is a direct measure of the heat created in the joint and will not be influenced by ambient temperature effects, since the differential pair arrangement cancels those effects. Accordingly, a very high precision can be achieved. An IRt/c with built-in air purge is recommended if the environment is oily or dusty.

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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Tel: +1 617 649 6322  
Fax: +1 617 923 9911

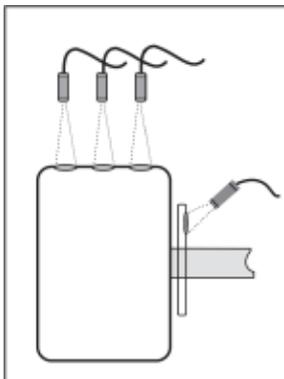
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## MONITORING TIRE TEMPERATURE FOR RACING PERFORMANCE

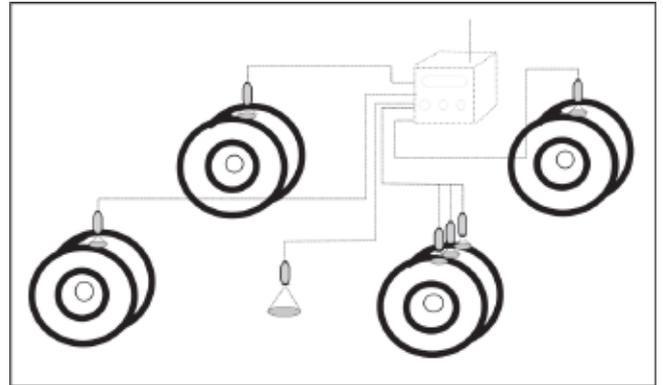
Tire temperature is of critical concern in automotive racing for two reasons: the tire temperature directly affects its adhesion and its wear characteristics, and tire temperature patterns provide valuable information on the set-up and performance of the suspension. For example, excessive loading of a tire caused by out-of-tune suspension will cause that tire to become considerably warmer than the others.



Use three sensors for profiling, one sensor for brake rotor.

The IRt/c has proven to be an ideal measuring device for onboard data acquisition, due its small size, ruggedness, and low cost. It may be connected to standard thermocouple read-out

systems. Installation should include connecting the shield to a suitable ground in order to avoid interference from the electrically harsh environment of a racing automobile. Mechanical installation should include attention to air flow patterns to minimize dirt building on the lens. The IRt/c.3x or .5 are recommended because their narrower field of view allows them to be positioned further away.



systems. Installation should include connecting the shield to a suitable ground in order to avoid interference from the electrically harsh environment of a racing automobile. Mechanical installation should include attention to air flow patterns to minimize dirt building on the lens. The IRt/c.3x or .5 are recommended because their narrower field of view allows them to be positioned further away.

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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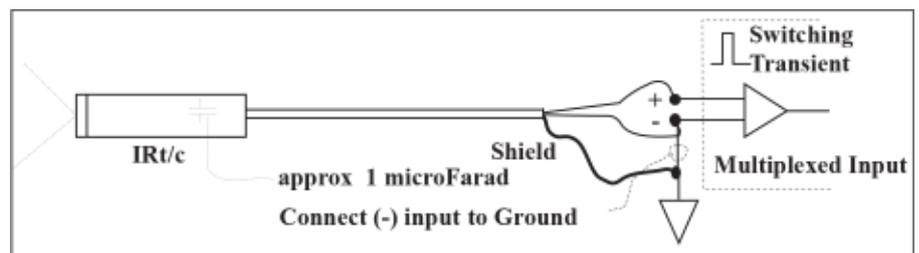
## MULTIPLEXED DATALOGGING APPLICATIONS

An occasional problem introduced by switching-type thermocouple dataloggers is signal offset caused by the switching transient. The IRt/c is a completely passive device and produces an electrical signal entirely via thermoelectric effects, but does contain both resistance and capacitance above the levels found with conventional thermocouples. Many interface devices generate a small leakage current, which induces no shift in signal with conventional low impedance (<100 ohm) thermocouples, but may induce an offset with the higher IRt/c impedance (~3K ohm). This type of offset is normally stable and is simply calibrated out by adjusting the device's OFFSET or ZERO adjustment.

However, switching the thermocouple input can also cause offsets in IRt/c readout due to the presence of capacitance, if the signal leads are connected

in a differential fashion to the amplifier input. A switching transient voltage stores a charge in the capacitance, which can cause the equivalent of leakage current offset. This offset could also be calibrated out, but may not be stable. A preferred method is simply to ground the negative side of the t/c input as shown.

The ground provides a path for the charge caused by the switching transient to dissipate, thus eliminating the offset. The twisted shielded pair wire with shield connected to ground will compensate for any loss of noise rejection, and thus provide a clean signal.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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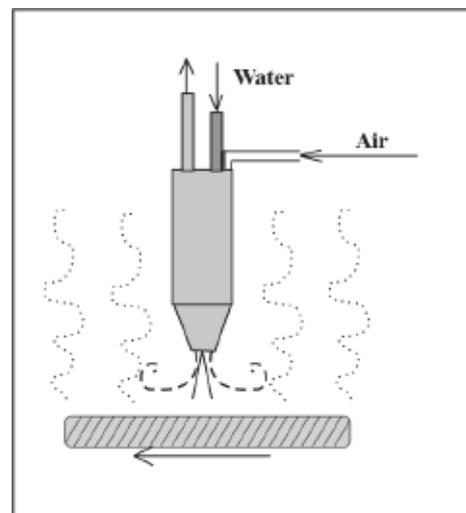
## AIR PURGING IS RECOMMENDED WHEN USING WATER COOLING

Very often the environment inside an oven contains vapors from the process which may condense on cooler surfaces inside the oven. When an IRt/c is used inside the oven to monitor the temperature of the process, the IRt/c must be cooled if the environment is above 212°F (100°C). Using the convenient IRt/c Cooling Jacket Kit available, either air or water may be used. For temperatures above 700°F (370°C) water is required, along with a small amount of purge air.

The purge air has two important functions:

1. It keeps the IRt/c lens clear of vapors that would condense on its window, since the window temperature might be below the condensing temperature of some of the vapors of the process.
2. The internal convective heat transfer characteristics are optimal for cooling at very high environmental temperatures.

The IRt/c.3x is particularly suited for this service since the air consumption required to keep its lens clean is as little as .01 CFM (300 cc/min). A small convenient self-contained air pump is available.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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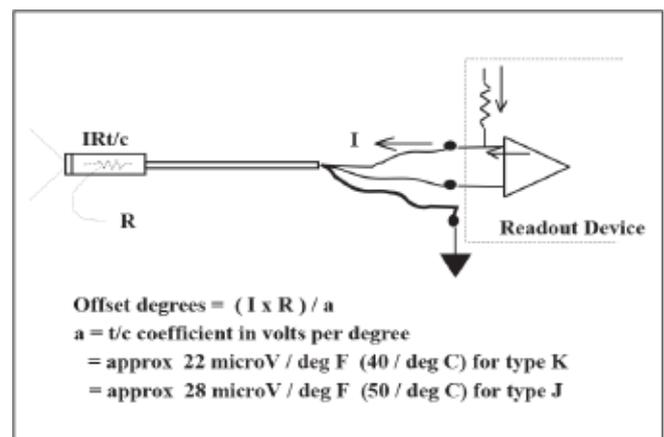
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## WHY OFFSETS ARE CAUSED BY LEAKAGE CURRENTS

Some thermocouple readout devices produce leakage currents which can create offsets when using an IRt/c. The current originates from two sources within the device: leakage current actually generated by the input amplifier, and leakage current intentionally injected to the thermocouple circuit to detect an open circuit due to wire breaks. These currents are normally of no consequence with conventional thermocouples with resistances < 100 ohms. However, with the higher resistance of the IRt/c (~ 3 Kohms), devices with high currents will create offsets.

As an extreme example, a device producing 1 microamp of current will result in less than one degree offset with an ordinary t/c with 10 ohms resistance. That same device reading an IRt/c at 3 Kohms will produce an offset of the order of 100°F (55°C). Most readout devices have considerably smaller leakage currents and consequently smaller offsets. As a general rule, the smaller the offset the better, and readout devices should be chosen accordingly if other factors are equal.

The offset calibration procedure presented in the IRt/c Manual is recommended for field use. For designers of readout devices, it is recommended that both sources of leakage current be reduced to 10 nanoamps or less to minimize offset errors. For recommendations on low offset readout devices contact Exergen.



#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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www.exergenglobal.com

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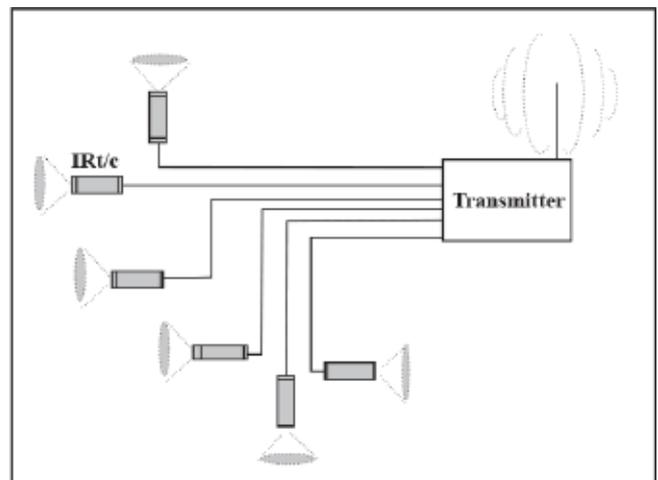
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## IRt/c'S AS DISPOSABLE INFRARED SENSORS

Destructive testing is commonly used in a number of industries, including, for example military weapons testing and fire safety testing. Thermocouples are routinely used for temperature measurement, and are connected to telemetering equipment to transmit the data before the sensor is destroyed in the test. Infrared would be preferred for a number of these measurements because of speed, convenience, and non-contact capability, especially in measuring the radiant temperature. However, the cost, complexity, and general fragility of conventional IR systems have made such applications impractical and prohibitively expensive.

The IRt/c, however, is ideally suited for this type of service. Its compatibility with thermocouple telemetering devices, small size, ruggedness

of construction, and overall reliability makes it an excellent replacement for standard thermocouples. At one-tenth the cost of most conventional IR devices, it is economical enough to be used in "disposable" applications.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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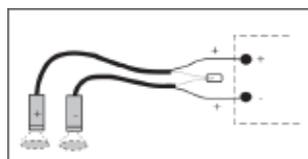
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## DETECTING HOT MELT ADHESIVE IN PRODUCT ASSEMBLY, PACKAGING

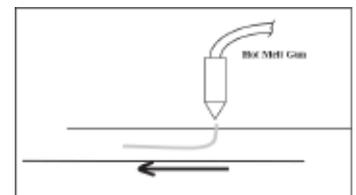
Much of the production of modern society is held together by means of adhesives, and without on-line inspection equipment, modern high volume production machinery can quickly fill a warehouse with improperly bonded scrap. Hot melt adhesive is probably the most widely used because of its solvent-free operation, high setting speed, and economy of use. With upwards of 100,000 hot melt “guns” in operation, there are many thousands of installations that can benefit from on-line inspection.

Hot melt bonding power is a function primarily of hot melt quantity and temperature. The more adhesive applied, the greater the area bonded. The hotter the adhesive, the less viscous it is - it becomes better able to “grip” the substrate material. However, if the hot melt is too hot, it chars, forming a residue which plugs the injection nozzles of the guns. Nonmeltable contaminants also enter the melting system at times. These contaminants also eventually clog the nozzle or filters. Either way, the adhesive flow is blocked and poor product is produced.

A pair of IRt/c’s, wired differentially (connect the minus leads together and measure across the plus leads) reliably detects the infrared energy radiated by the adhesive. This heat energy is proportional to the amount and temperature of the adhesive it sees, which in turn is an excellent indication of the hot melt bonding power. Wired differentially, one IRt/c will give a (+) response to heat, while the other will give a (-) response to heat. Fixture the (+) IRt/c to view the adhesive shortly after it is applied by the gun.

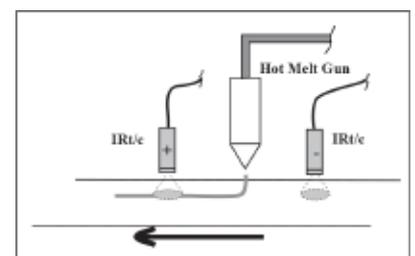


Fixture the (-) IRt/c to view an area of the substrate in which there is no adhesive. The (-) IRt/c is called the Reference, since it automatically compensates the (+) unit for any changes in substrate temperature, such that the net signal provided by the IRt/c pair is created only by the net heat of the adhesive being added to the substrate (the hot melt being applied properly to the carton, etc.).



The Reference IRt/c is a very powerful tool. It can be located next to the (+) IRt/c for corrugated carton, on the under side of a plastic base cup while hot melt is applied to the top, or upstream of a coating head with the (+) downstream. The differential pair of IRt/c’s will reliably report the presence or absence of hot melt compared to a reference area by the presence or absence of the characteristic heat signature. With set-up calibration, the pair of IRt/c’s will also indicate quantitatively how much hot melt is being applied.

The IRt/c.3x is usually the model of choice due to its smaller tip, narrower field-of-view, and built-in air purge for dirty environments, but any of the IRt/c models may be used. The output signal from the differential pair is in the range of 1 millivolt for a typical set-up. Any suitable amplifier can be used.



Since the IRt/c’s are measuring differentially, no cold junction compensation is required, and

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## DETECTING HOT MELT ADHESIVE IN PRODUCT ASSEMBLY, PACKAGING

might cause errors if present. The amplified signal can be interfaced by computer, PLC, or other control device. Be sure to “design in” adequate sensitivity adjustment. For best performance, it is recommended that both IRt/c’s are mounted in a single aluminum fixture in order to minimize any thermal differences between them.

Set up and operation involve fixturing the IRt/c’s at the desired inspection points, operating the adhesive applications at the minimum acceptable

adhesive level, then adjusting the alarm limits to that level.

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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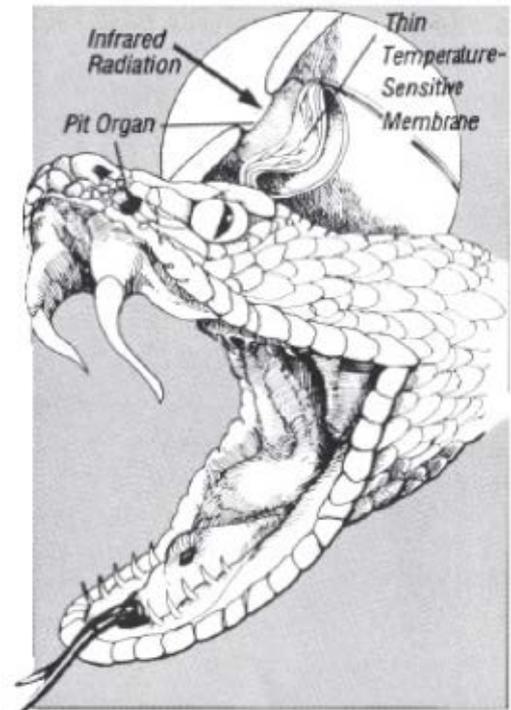
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## HOW THE PIT VIPER MEASURES INFRARED RADIATION

Like the IRt/c, the pit viper has the ability to “see” infrared radiation.

Pit vipers comprise a family of snakes that share a sophisticated thermal adaptation that stems from the evolution of specialized pit organs located near their eyes. These organs sense the infrared radiation of an approaching warm-blooded animal and send signals to the snake’s brain. These signals are used with the visual picture provided by the snake’s eyes, giving the snake more complete information about its environment.

Pit organs are small facial cavities covered by a thin membrane of sensory cells that respond to temperature differences between the target and the snake’s body temperature. These sense organs are so sensitive they can resolve differences of just .003°C. Pit vipers can detect the presence of a warmblooded animal at distances of up to 50 centimeters in total darkness simply from the animal’s infrared radiation. The pit viper quickly and accurately scans the target with its infrared-sensing pit organs before deciding to strike to defend its nest or attack its prey.



***The non-contact temperature capability of both the pit viper and the IRt/c provides the survival edge in a fiercely competitive environment.***

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## RELATIVE HUMIDITY MEASUREMENT

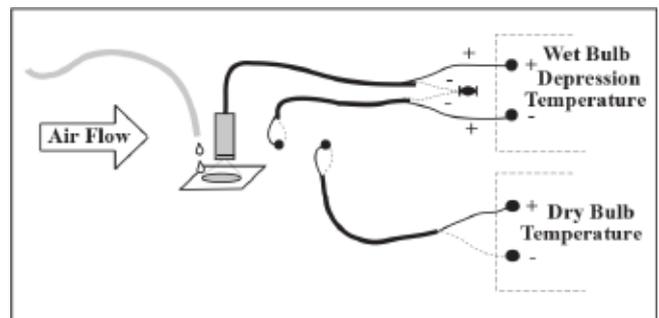
IRt/c's can be used to accurately and reliably measure actual relative humidity in many situations where there is a convenient source of water and flowing air.

An IRt/c aimed at a wet porous surface with ambient air blowing across the wet surface can actually measure what is called "wet bulb" temperature for that ambient area. More precisely, wet bulb temperature is the equilibrium temperature of the air-water interface when a water film is evaporated. When air is moved over a wet surface, the water cools by evaporation until it reaches wet-bulb temperature, then the cooling stops, no matter how much more air is moved over the surface. The temperature at which the cooling stops is the wet bulb temperature.

The IRt/c measures the temperature of the air-water interface on a surface directly. The quality of the water or of the absorbing material does not affect the reading, since the IRt/c can directly view the air-water interface, and the wet bulb

equilibrium temperature is not materially affected by impurities.

The highest precision method is to employ an IRt/c wired differentially with a conventional thermocouple to measure the quantity "wet bulb depression". The differential pair arrangement guarantees high accuracy, since RH is a strong function of wet bulb depression and a weak function of dry bulb temperature. Standard psychrometric tables, charts, and software algorithms can be used with the data to obtain accurate relative humidity for your environmental measurements.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

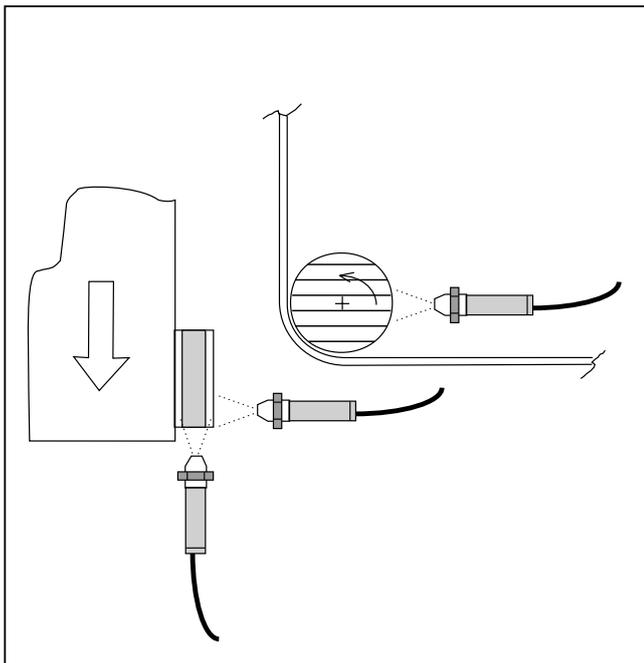
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## CONTROLLING WEB ROLLER TEMPERATURE

The IRt/c infrared thermocouples have quickly become the sensors of choice for monitoring and controlling both web and roller temperatures. Here are some tips on accurate roller temperature measurement.



### 1. Uncoated Metal or Chrome Rolls

Shiny, uncoated metal rolls are a difficult surface for any infrared temperature sensor to properly measure, because the sensor will see too many environmental reflections. The solution is to simply paint a small black stripe on an unused end of the roller. Aim the IRt/c sensor at the black paint stripe. It will then measure the temperature accurately and reliably regardless of changes in the surface conditions of the rest of the roller. If there is very little space on the edge of the roller, move the sensor closer and paint a very small black stripe. The minimum spot size of the IRt/c is 0.3 inches (8 mm), and for the IRt/c.3x it is 0.25 inches (6 mm) when the sensor is brought close to the surface.

### 2. Dull Metal Rollers

Dull metal rollers can provide a reliable signal. However, it is best to test the surface, as the surface emissive properties may be changed by dirt, moisture, cleaning, etc. When in doubt, it is best to simply paint a stripe to eliminate these variations.

### 3. Non-metallic Surfaced Rollers

These will provide a reliable IR signal at any point the IRt/c is aimed. No painted stripe is required.

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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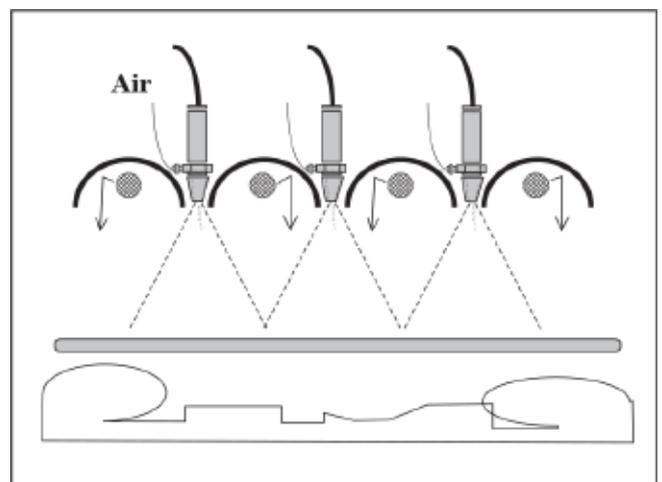
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## CONTROLLING VACUUM FORMING AND THERMOFORMING PROCESSES

For forming plastics, radiant heat with an IRt/c is an excellent combination of heating method and control. They work extraordinarily well together, since both the heating and measuring occur right at the surface, where the plastic is located. The IRt/c reading is unaffected by reflections from the heater, since the spectral response of the 6 to 14 micron IRt/c lens filters out the shorter wavelengths of the radiant heater energy.

The IRt/c may be mounted in between ceramic heaters, or in the shroud or reflector of the radiant heater, such that it can see in between the elements. Select any of the IRt/c models, depending on the field-of-view required to see past the elements to the painted surface. Care should be taken in mounting the IRt/c in such a way as to keep its temperature below 200°F (93°C) and to keep the lens clean. The IRt/c.3x is the

preferred model for this application because of its small physical size and builtin air purge. It can be used in temperatures up to 250°F (121°C) when the air purge system is used. For still narrower fields of view, the IRt/c.5 and IRt/c.10 with 5:1 and 10:1 FOV respectively are very popular.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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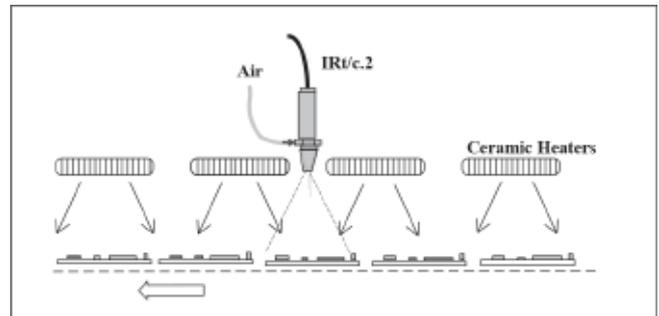
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TN-022-1-EN

## CONTROLLING PRINTED CIRCUIT BOARD PREHEAT DURING WAVE SOLDERING

The IRt/c is an excellent solution to the problem of heater control for PC board preheat. IRt/c's work particularly well in this process, since both the heating and measuring occur right at the surface, where the solder must flow. The IRt/c reading is unaffected by reflections from the heater, since the spectral response of the 6-14 micron IRt/c lens filters out any shorter wavelengths of the radiant heater energy.

The IRt/c may be mounted in between ceramic heaters, or in the shroud or reflector of the radiant heater, such that it can see in between the elements. Select the IRt/c model with the field-of-view required to see past the elements to the PC boards. Care should be taken in mounting the IRt/c in such a way as to keep its temperature



below 200°F (93°C) and to keep the lens clean. The IRt/c.3x is the preferred model for this application because of its small physical size and built-in air purge. It can function in temperatures to 250°F (121°C) when the air purge system is used. For still narrower fields of view, the IRt/c.5 and IRt/c.10 with 5:1 and 10:1 FOV respectively are very popular.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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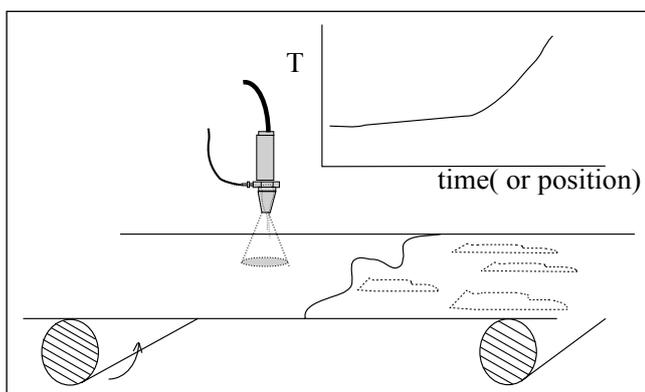
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## IRt/c CONTROLS PRODUCT DRYING (PAPER, WOOD, TEXTILES, FILM)

In processing of products such as paper, wood and textiles, it is important to be able to determine quickly when the products are sufficiently dry.

The surface temperature of a “wet” product will change (rise) very slowly as constant heat is applied to the product. This occurs because the moisture in the product absorbs much of the heat energy as it evaporates. At the point that the product becomes “dry”, however, the same constant heat supply will quickly raise the temperature until it reaches the same as the surrounding air, or higher if the heat source is radiation. If temperature vs. time is plotted for a heated drying process, the target “dry” temperature point can clearly be seen as the beginning of a rapid rise in surface temperature.

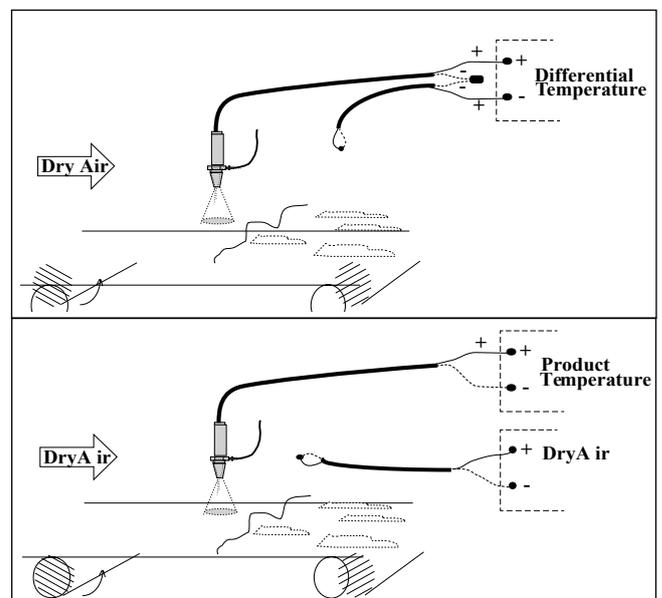
IRt/c's can be used to monitor these changes in surface temperature. With their fast 0.1 second response time, IRt/c's can quickly detect when the surface temperature begins to rise rapidly, an indication that the products have reached a low moisture content. (See also Tech Note #67)



A simple implementation method is to measure the difference in temperature between the product and the ambient air. Determine the delta T that results in the correct dryness, and set the control system to maintain that delta T.

The IRt/c is particularly convenient because it can be wired differentially with an ordinary thermocouple. The combined signal can be fed to a single control channel. Alternatively, if absolute temperature is preferred, the IRt/c and thermocouple can be read and controlled independently.

For hot, humid, dusty environments, the IRt/c.3x is recommended because of its small size and super-efficient purge air system. Fully developed, patented IRt/c-based drying systems are available. Contact Exergen for referrals.



#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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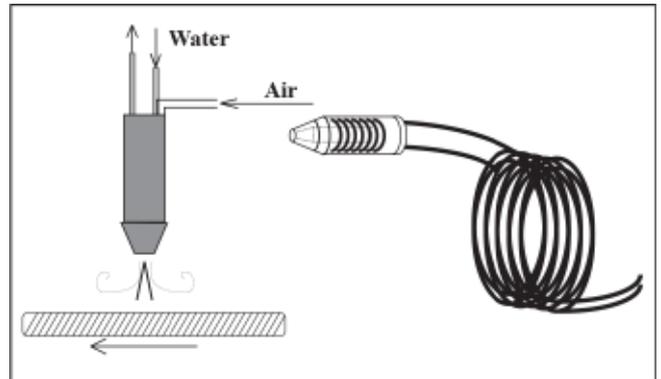
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## COOLING JACKET KIT FOR ENVIRONMENTS TO 1000°F (540°C)

A convenient and inexpensive kit makes it possible to use either the IRt/c or IRt/c.3x with air, water, or both for service in harsh environments. Measuring only 4.16" x 1" (106 x 25 mm) overall, the CJK-1 is physically small enough to fit into tight areas and closely monitor process temperatures from the optimum position - up close. With its all stainless steel housing, it can withstand the harshest environments.

Extraordinarily efficient in design, the CJK requires only .05 gpm (190 cc/min) to protect an IRt/c at 1000°F (540°C). A small amount of air purge insures that optimum cooling is maintained, and prevents condensation on the lens (see Tech Note #15).



The water cooling system consists of a seamless monotube, in order to eliminate the possibility of leaking joints. For convenience, the seamless tubing includes an extra 3 ft (1 m) tubing length.

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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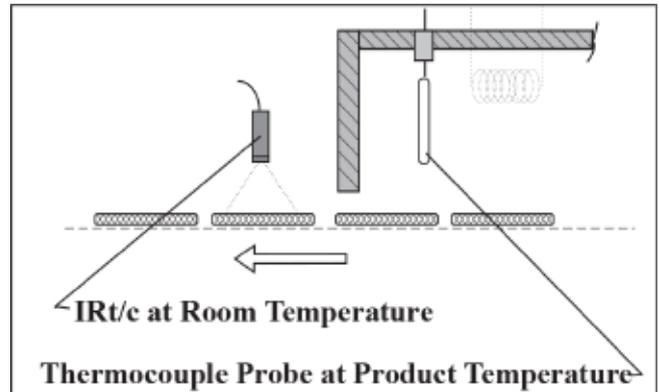
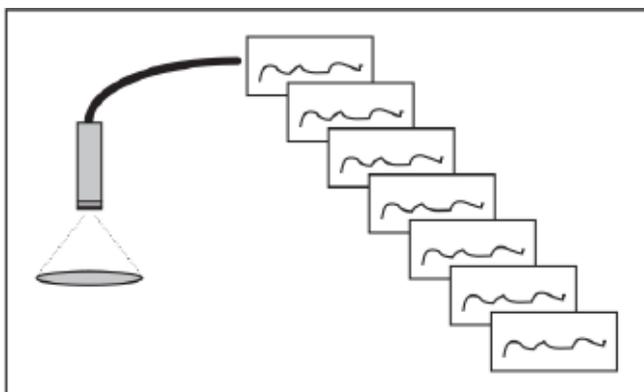
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## IRt/c REPEATABILITY AND LONG-TERM ACCURACY

The ability of the measuring device to maintain its calibration under service conditions and over a long period of time is of fundamental interest in temperature control. The IRt/c is rated at less than 0.1°C repeatability and has no measurable long term calibration change, which makes it well suited for reliable temperature control. These attributes are inherent in the basic design and construction of each IRt/c.

Repeatability is defined as the ability of a measuring device to reproduce its calibration under identical conditions. The IRt/c is a solid, hermetically sealed, fully potted system that does not change mechanically or metallurgically during service. There are no active electronic components and no power source to produce the signal – only the thermoelectric effects that produce a thermocouple signal. Long term accuracy is influenced by the same things that influence repeatability: mechanical changes and metallurgical changes. It is well known that thermocouples can change calibration over time due to these effects.



Mechanical changes occur because conventional thermocouples are generally constructed as small and light as possible to enhance response time, making them vulnerable to deformations that can change the thermoelectric properties. More importantly the conventional thermocouple must operate at elevated temperature since it merely measures its own temperature.

The metallurgical changes which affect thermoelectric properties are a strong function of temperature; they are negligible at room temperature, but are of serious concern at high temperature.

The IRt/c solves both problems by its design and basic operation. Its solid fully potted construction in a mechanically rigid stainless steel housing, and operation at near room temperature conditions, essentially eliminate the classical drift problems of conventional thermocouples. Every IRt/c is double annealed at temperatures above 212°F (100°C) to ensure long term stability, and tested five times prior to packaging. Barring a small percentage of failure, the IRt/c has essentially unlimited long term calibration accuracy.

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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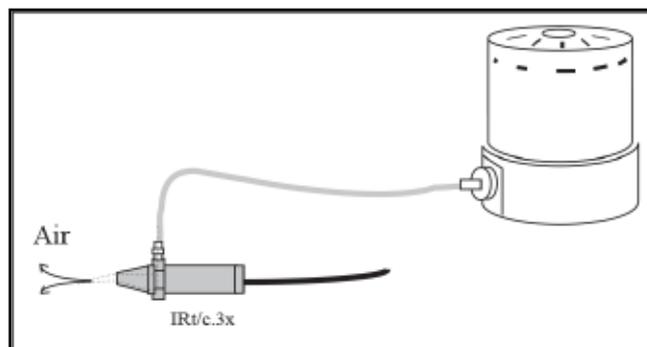
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## **AIR PUMP ACCESSORY KEEPS IRt/c'S CLEAN AND COOL**

For IRt/c installations in which a purge air source is not convenient, or is too expensive to install, 3rd party air pump kits are ideal. Most air pumps are rated for continuous duty and produce 120 cubic inches/ minute (2000 cc/min) air flow, which is more than sufficient for purging; and will cool an IRt/c.3x in environments up to 240°F (115°C). And most pumps are available in both 120 VAC and 12V DC versions.

Air Pump Kits are recommended for installations in which dust, dirt, or vapors are present which might coat the IRt/c lens, or for situations in which long term operation has been a problem due to fouling of the lens. At less than \$100; requiring



only a few minutes to install; and its small size; Air Pump Kits provide you a convenient and inexpensive assurance of long term, trouble-free operation of your IRt/c temperature control system.

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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Tel: +1 617 649 6322  
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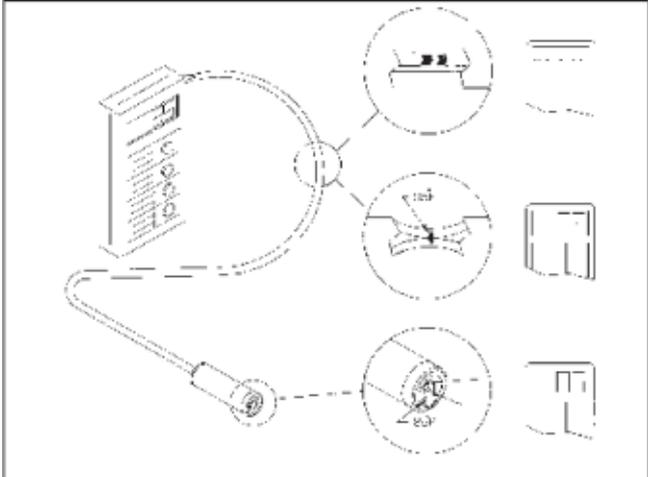
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## IRt/c TROUBLE SHOOTING GUIDE

There are only three possible failure modes for an IRt/c sensor. If an IRt/c sensor is installed and does not function as expected the failure may be due to something other than the sensor. It is recommended that the sensor is checked out for response after installation to ensure that it is connected to the readout instrument properly. This can be done simply by placing a hand or a heat source in front of the sensor after it is installed and making sure the reading changes (this is still valid even if the temperature is well below the calibration point). If the sensor gives a reading very different from the expected reading:

1. Check initial calibration. If the controller has been changed, or the offset adjusted after the sensor has been installed, the temperature reading may be very different from the actual temperature.
2. Check the sensor lens. If dirt has accumulated on the lens over time, then the reading may be lower than expected. Clean the lens using a Q-tip and alcohol. The lens needs to be treated gently, it can be easily scratched.
3. If the sensor reading does not change even though the target temperature is changing, the sensor may be burnt out. Check the impedance of the sensor, if the impedance is  $>15\text{kohm}$ , then the sensor is probably burnt out. If the impedance is  $<100\text{ohm}$ , then there is a short in the thermocouple wire and the temperature being measured is at the short.
4. If the temperature suddenly reads about half of what it should, then the hermetic seal may be compromised and the Xenon gas may have escaped.

For more information regarding the calibration testing of IRt/c sensors, see Tech Note #74. For process control applications, the system can be programmed to check the sensor circuit every time it is powered up, see Tech Note #39. If a PLC is used for process control, a sensor short will have the same effect as a "Heater Burn Out Protection" feature.



Symptom	Action	Result
1) Sensor reads high	Check initial calibration	Adjust zero offset of readout to bring reading back to normal.
2) Sensor reads low	Clean lens of sensor	If sensor does not correct, check points 3 and 4 below.
3) Sensor reading does not change	Check impedance of sensor	If sensor reads open, replace. If sensor has impedance of a few 10W, then there is a short in the t/c wire.
4) Sensor reading suddenly drops by about half	Check through points 1 to 3 above	If still reads low, replace sensor.

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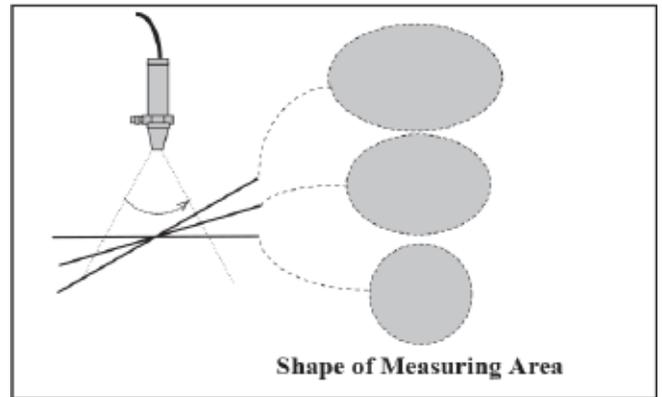
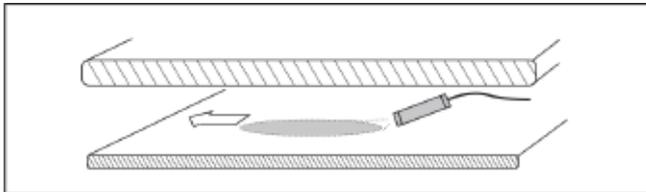
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5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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www.exergenglobal.com

## IRt/c CAN MEASURE OBLIQUELY

Often, an area needs to be temperature monitored, but because of space limitations, the IRt/c cannot be placed to view the target area squarely. In such situations the IRt/c can be angled obliquely to view the target area. The field-of-view then becomes elliptical instead of circular, and the IRt/c averages the temperature it sees.



To apply this method, be sure to estimate the size of the field-of-view footprint, and confirm that the IRt/c is measuring the area you wish to measure.

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5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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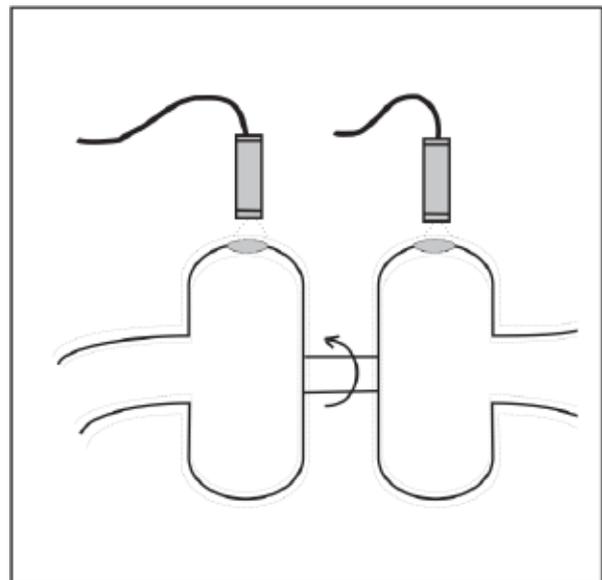
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## IRt/c MEASURES VIBRATING OBJECTS

Measuring the temperature of objects that are nominally stationary, but vibrate, can be a difficult problem because of mechanical fatigue of any contact device. An example is continuous monitoring of the casing temperature of both the turbine and compressor side of a turbocharger. Thermocouples or other contact devices fail after only a few hours due to the high frequency vibration present during turbocharger operation.

The IRt/c provides a simple and inexpensive solution. Mounting the IRt/c's to a non-vibrating surface, they can monitor the turbocharger temperature without being subject to the destructive vibration.

Wherever there is a requirement for machinery monitoring, temperature should be included; and for machines that vibrate, the best solution is the IRt/c.



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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
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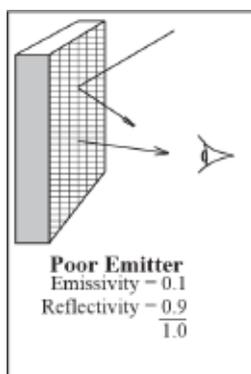
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## WHAT IS EMISSIVITY?

Emissivity is a surface property which determines how much radiation an object emits at a given temperature compared to a blackbody at the same temperature. Emissivity (along with background thermal radiation) is a primary source of errors in infrared temperature measurement. Emissivity can be more easily understood if it is realized that infrared has similar properties to visible light.

Mirrors figure prominently in the discussion of heat radiation and emissivity\*. Since heat and light radiation behave similarly, what we see with our eyes is similar to what the IRt/c sees. When you look in a mirror with your eyes, you see only reflections, nothing of the mirror itself. If the mirror is perfect, it has 100% reflectivity. Therefore, it emits nothing because it reflects everything. For this condition, the emissivity is zero.

If we consider an imperfect mirror, the eye then sees mostly reflection, but also some of the imperfections on the mirror surface. If, for example, we saw 90% of the mirror as a perfect reflector and 10% as imperfections, 90% of the mirror would reflect; the remaining 10% would emit. Therefore, the emissivity equals 0.1.



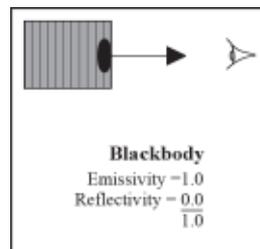
Consider for a moment the exact opposite of a perfect mirror, which is a perfect emitter. The eye looks at a perfect emitter and sees no reflection at all, only the emitting surface. Since 100% of the surface emits, and 0% reflects, the emissivity equals 1.0. This type of object is called a *blackbody*.

Finally, consider a good emitter. The eye sees a small amount of reflection interspersed with the large amount emitting. If 10% of the surface did not emit, and instead reflected, we would have 10% reflecting and the remaining 90% emitting. Therefore, the emissivity equals 0.9.

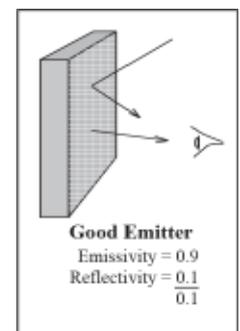
Accordingly, we can state the following rule of emissivity:

*The emissivity of a surface is simply the percentage of the surface that emits. The remaining percentage of the surface reflects.*

Shiny metal surfaces act like mirrors, with emissivities in the range 0.05 to 0.2. Accordingly, they have only 4% to 25% emitting area compared to reflecting area, and for that reason are difficult to measure with infrared methods. Non-metals, organic materials, and coated metals have emissivities in the range of 0.8 to 0.95 and thus have 400% to 1900% emitting area compared to reflecting area, and thus are much more easily measured successfully.



\*See "Through the Looking Glass-The Story of Alice's Quest for Emissivity" available from Exergen.



#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
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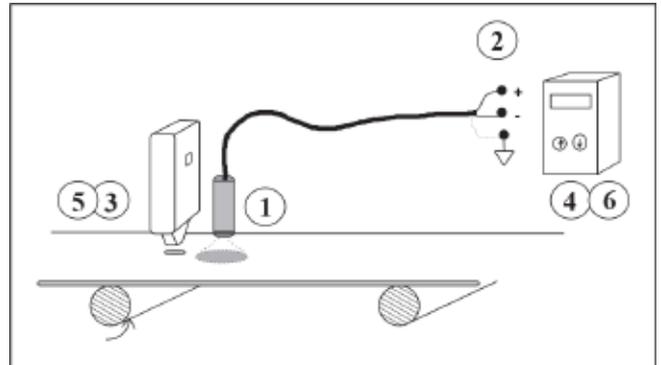
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## WHERE IS THE EMISSIVITY ADJUSTMENT?

### In the readout device.

The normal setup and calibration as shown in the IRt/c Operating Manual and Tech Note #1 automatically compensates for the emissivity and reflectivity of the material whose temperature is being controlled, and completely accounts for these effects at the controlled temperature.

However, for processes in which the control temperature set-point varies, the control device will provide higher accuracy over a wider range if its SPAN or GAIN adjustment is used to calibrate the process. Accordingly, the calibration set-up should include a standard two point method of setting the span.



1. Install IRt/c as close as possible.
2. Wire connections in standard fashion.
3. At low operating temperature, measure actual temperature with D/DX Series.
4. Adjust OFFSET, ZERO, or LO CAL to match reading on D/DX Series.
5. At high operating temperature, measure actual temperature with D/DX Series.
6. Adjust SPAN, GAIN, or HI CAL to match reading on D/DX Series.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
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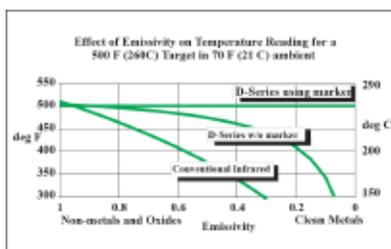
## WHY THE D/DX SERIES IS RECOMMENDED FOR IRT/c TEMPERATURE CONTROL CALIBRATION

Because of its speed, accuracy, and its patented Automatic Emissivity Compensation System (AECS).

As in all infrared temperature control systems, IRT/c installations should be calibrated to the characteristics of the materials and the process being controlled, in order to insure that the control temperature is accurate. Accordingly, the calibration reference must be selected such that its accuracy is independent of the variables that influence the temperature control accuracy. In the case of infrared temperature control, the major variables are emissivity and ambient reflections.

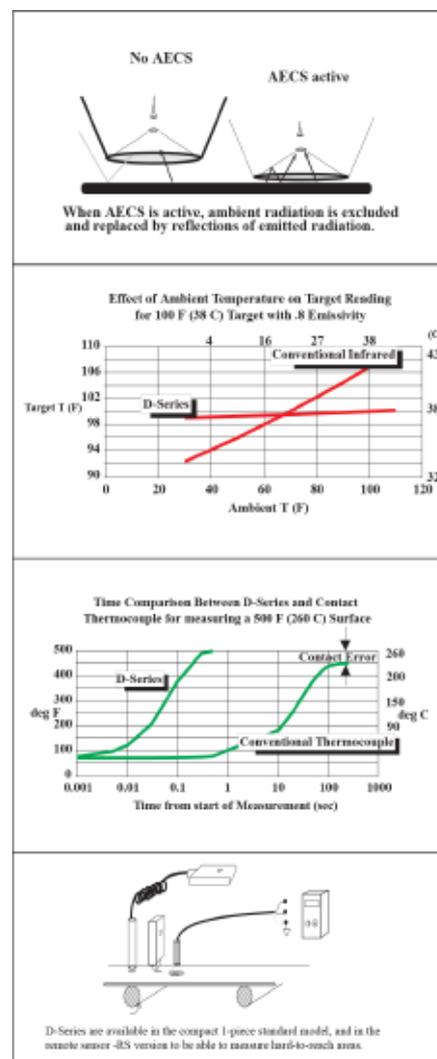
The Microscanner D/DX Series has the necessary accuracy and independence from emissivity and reflection errors, due to its AECS feature. The reflective cup configuration of the sensing head automatically corrects for emissivity by creating a tiny blackbody at its point of measurement. By "trapping" the emitted radiation, and excluding the ambient radiation (thereby replacing the reflected ambient radiation with reflected emitted radiation) the sensing eye sees a blackbody; and thus can report the temperature precisely.

The result of AECS is illustrated below.



Conventional infrared devices are strongly influenced by both emissivity and ambient variation, while the D/DX Series remains accurate.

Additional factors in calibration accuracy are speed and contact error when using conventional thermocouples. The D/DX Series overcomes both problems, and makes it possible to complete the temperature control set-up very quickly and accurately.



For further information on Exergen's Microscanner D/DX Series Infrared Scanner/Thermometers call or fax Exergen or your local Authorized IRT/c Distributor.

Exergen Global offices:

The Netherlands  
 Pastoor Clercxstraat 26  
 5465 RH Veghel  
 Tel: +31(0) 413 37 65 99  
 Fax: +31(0) 413 37 93 10

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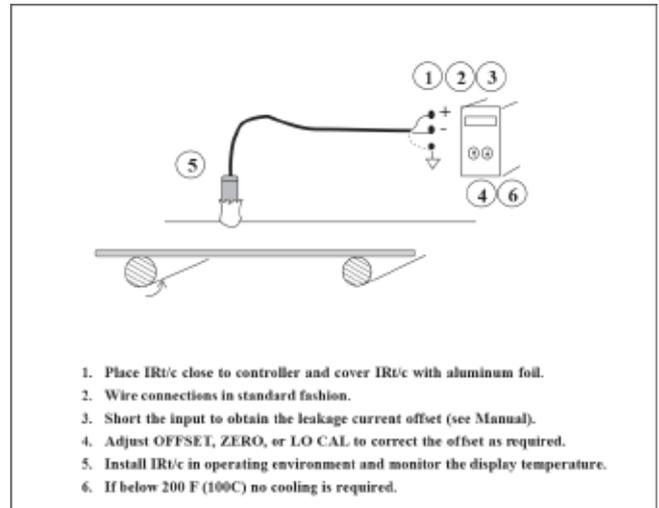
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## CHECKING IRt/c AMBIENT TEMPERATURE

In many installations, it may not be clear whether cooling is required, and it may not be easy to obtain the temperature of the environment experienced by the IRt/c. The IRt/c itself will tell you what its own temperature is, by using the procedure illustrated below.

The basic method is to temporarily “blind” the IRt/c using aluminum foil, so that it can only see itself. The temperature that it produces is then its own temperature only.

Before running this test, be sure to check for leakage current offsets as described in the manual.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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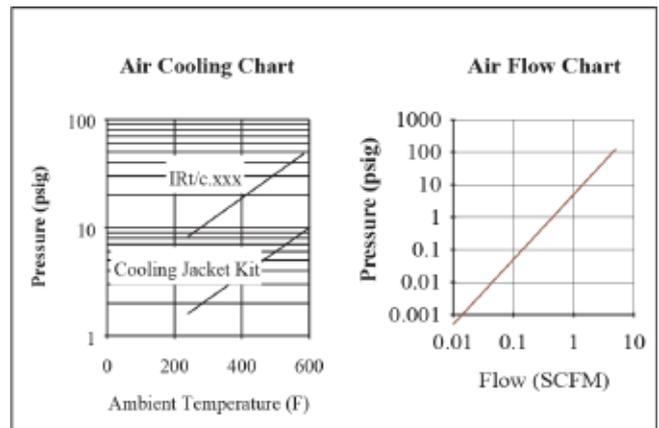
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## AIR PURGE AND AIR COOLING REQUIREMENTS

The limiting air flow restriction for all of the IRt/c models and Cooling Jacket Kit is the air fitting supplied with the unit. Accordingly, all IRt/c's with built-in air purge, and the Cooling Jacket Kit (CJK-1) all have essentially the same pressure vs. air flow characteristics, and the air flow chart applies to all. However, the air consumption requirements for purging or cooling for each are somewhat different due to size and operation variables. Refer to the table or chart for specific model requirements for minimum pressure for purging, or for cooling in elevated ambient conditions. IRt/c.xxx refers to all models with the 1.375" (34,9 mm) housing

diameter. If water cooling is used with the Cooling Jacket Kit, air purge pressure only is required.



To convert to metric units  
the following may be used:

$\text{deg C} = (\text{deg F} - 32) \times (5/9)$
$\text{kPa} = \text{psig} / .15$
$\text{cubic m/min} = \text{SCFM}/35$

Model	Air Purge Pressure
IRt/c.3x	> 0.1 psig
IRt/c.xxx	> 5 psig
Cooling Jacket	> 0.1 psig

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Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
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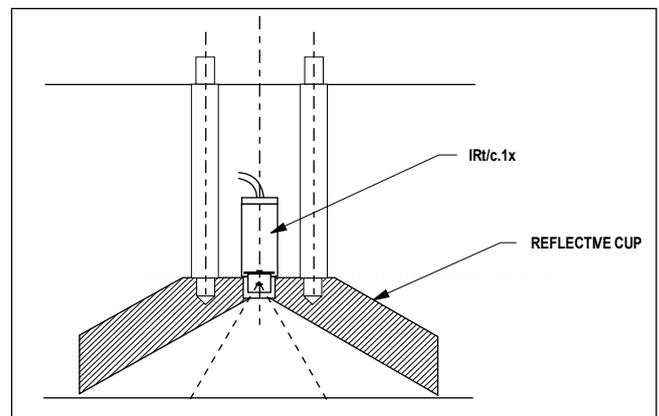
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## LARGE DIAMETER REFLECTIVE CUP USED FOR SILICON WAFER TEMPERATURE MEASUREMENT

Silicon wafer fabrication involves many operations, most of which require the accurate determination of the temperature of the silicon. The surface temperature is an essential control variable for efficient high quality processing of material.

As the wafer is processed the emissivity of the surface can vary considerably due to the different properties of the substrate layers. To enable the accurate rapid measurement of the wafer temperature, a reflective cup was developed. The reflective cup prevents ambient radiation from entering the sensor and replaces it with reflected emitted radiation. By reducing errors caused by ambient reflections and emissivity variations the measurement error can be reduced by about a factor of ten.

The IRt/c.1X is a good sensor to use for this application, it is small and can easily be mounted to the reflective cup.



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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

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Watertown, MA 02472  
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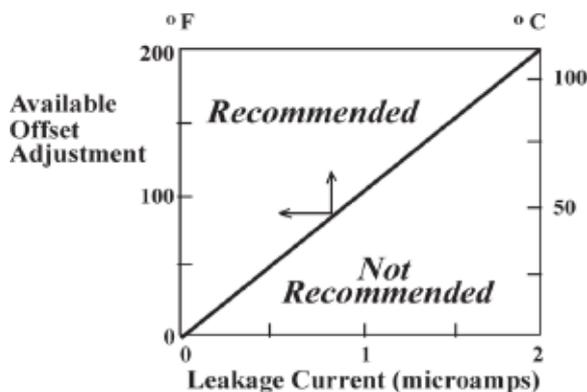
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## SELECTING TEMPERATURE CONTROLLERS

IRt/c infrared thermocouples are designed to be used with all thermocouple readout devices and controllers, but due to the higher impedance levels of the IRt/c compared to standard t/c's, some controllers are better suited than others. Leakage current generated by the controller (see Tech Note #16) creates an offset in reading which should be adjusted out for accurate temperatures. If the offset produced by the leakage current is larger than the available offset adjustment of the controller, the IRt/c will still produce repeatable readings and control accurately, but the temperature indication will be incorrect.



Accordingly, recommended controllers are those which have low leakage currents and/or sufficient offset adjustment to produce an accurate IRt/c reading (see chart for relationship between leakage current and offset).

Following is a list of controller manufacturers with models known to have low leakage currents and are recommended for use with the IRt/c:

**Athena, Cal Controls, Eurotherm, Fenwal, Fuji, Honeywell, Love, Newport, Omega, Omron, Partlow, Red Lion, Syscon, Watlow, Yamatake-Honeywell, Shinko Technos, and others**

This list is not a comprehensive one - manufacturers are constantly improving their models. Contact your local Authorized IRt/c Distributor for specific models, or the controller manufacturer to inquire as to suitability of specific models for service with an IRt/c (sensor impedance of ~5 Kohms).

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
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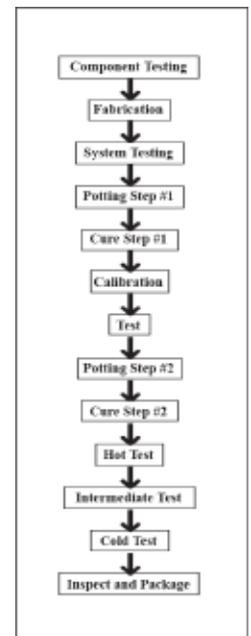
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## HOW THE IRT/c IS MANUFACTURED FOR RELIABILITY

The IRT/c is designed and manufactured to provide a lifetime of reliable operation in the most demanding service conditions. To assure this performance, every IRT/c is put through a rigorous process of manufacture, including seven separate test stages. At the end of this process, the IRT/c is ready to be installed, and is ready to provide you with reliable infrared temperature data for many years.

As an additional reliability feature, all IRT/c's are manufactured with a Xenon gas fill hermetically sealed into the sensing system. If the hermetic seal is broken by mechanical or thermal damage to the sensor, the Xenon immediately escapes, and the IRT/c radiation sensitivity (difference

between target and sensor temperature) immediately drops by more than a factor of two, thus providing an obvious indication of failure, rather than a gradual change which can cause poor quality service for a long period of time before a failure is detected.



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5465 RH Veghel  
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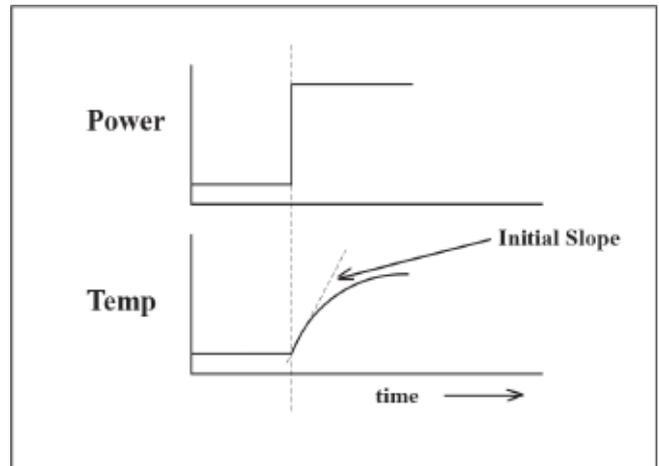
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## A SOFTWARE METHOD OF SELF-TESTING IRt/c'S

For many OEM applications, it is important to be able to test the IRt/c for proper operation each time the system is started, assuring the user that all systems are functioning, much the same way that a microprocessor can be programmed to check itself when powered up. This feature is especially useful to check for cleanliness of the lens in applications where a user might inadvertently spill something on its surface.

The test is performed by applying a known power input to the target to be heated, and monitoring the initial rate of change of temperature of the target as seen by the IRt/c. This rate of change is dependent only on the power level and independent of the initial temperature of the target, as long as the target began at a uniform temperature. Sufficient time must be allowed after the previous powerdown.



If the IRt/c is clean and functioning normally, it will report the correct rate of change, and the machine becomes operational. If the rate of change is lower than normal, the user is alerted to clean the lens. If this still does not produce the desired response, service is required on the IRt/c or heater, target, control, etc.

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Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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## MONITORING PLASTIC EXTRUSIONS

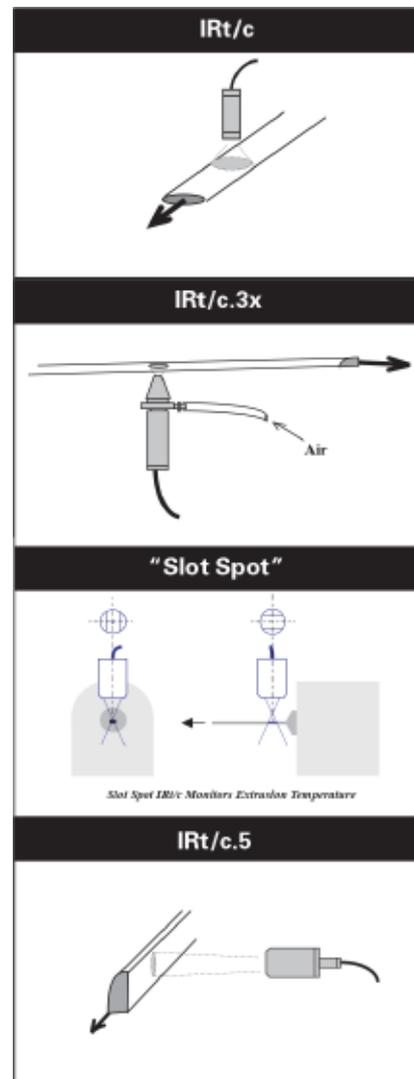
IRt/c's are well suited for monitoring the temperature of plastic extrusions, either at the point of extrusion to monitor correct extrusion temperature, or after air cooling to monitor/control the cooling process prior to cutting to length. The model recommended depends on the monitoring geometry.

For extrusions of 1" (2.5 cm) width or more, the standard IRt/c may be used at a distance of 1/2" (1.3 cm), which is sufficient to keep the lens clean in a reasonably clean environment.

For smaller extrusions, or for up-reading; the IRt/c.3x is preferred due to its smaller 0.25" minimum spot size (6 mm), and built-in air purge, which will maintain cleanliness even when very close to the hot plastic and pointed up.

For larger extrusions, in which more convenient positioning at greater distance is desired, the IRt/c.5 is recommended, due to its narrow 5:1 field-of-view.

For the smallest extrusions, the "Slot Spot" models, with their tightly focused optical systems, can measure to 2 mm (see Tech Note #80).



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USA  
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Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

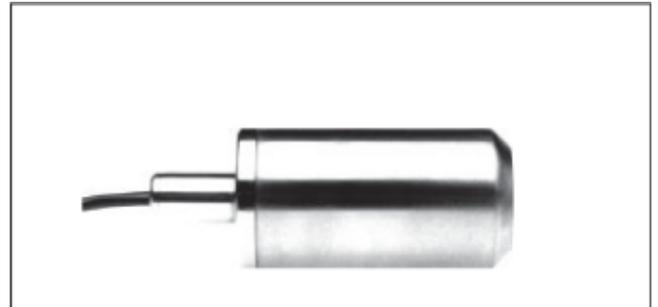
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## **IRt/c.5 HAS 5:1 FIELD-OF-VIEW AND BUILT-IN AIR PURGE**

The IRt/c.5 model extends the range of applications for infrared thermocouple thermometry to situations where geometry requires that the sensor be mounted remotely from the target. In addition to the narrow 5:1 field of view (11° included angle), this model retains all of the ruggedness and elegant ease-of-use features of the original IRt/c models, is hermetically sealed, and is equipped standard with an internal air cool/purge system. As do all IRt/c's, this new model exceeds all applicable NEMA standards, and is intrinsically safe.



**For drawings indicating field of view, mounting, air purge path, etc., see the Catalog Section of this book.**

*Specifications (where different from other models):*

**Sensing Range:** -50 to 1200°F (-45 to 650°C)  
**Field of View:** 11° approx. (5:1)  
**Minimum Spot Size:** 0.8" (2 cm)  
**Output impedance:** 4 Kohms to 8 Kohms, varies by model  
**Weight:** 6.5 oz with cable (184 gm)

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The Netherlands  
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5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
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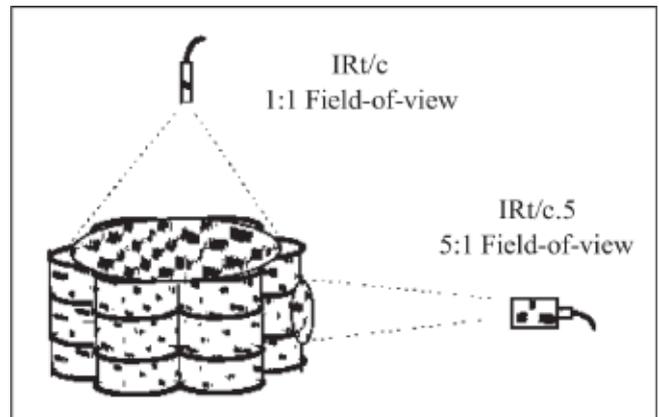
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TN-041-1-EN

## MONITORING DANGEROUS CHEMICALS AND HAZARDOUS ENVIRONMENTS

Handling, processing, or storage of certain materials involves an element of risk of fire, chemical damage, or explosion. Many times these materials are monitored using pyroelectric, air temperature, or ultraviolet devices to detect a fire situation, in order to activate alarms and extinguishing systems. These devices do not, however, provide the earliest possible indication of a problem, because they cannot detect the initial heat prior to the fire.

The IRt/c, however, is capable of detecting even the smallest temperature rise which must occur before a fire starts, and transmit the information in as little as 80 milliseconds to the thermocouple monitoring device, thus providing the maximum time to initiate extinguishing or cooling measures. The wide field-of-view standard IRt/c can average a wide area for broad coverage of heat build-up, or the narrower IRt/c.3x, .5, and .10 models can



monitor specific areas from greater distances. Actual fire types and special conditions should be evaluated prior to applying IRt/c's.

As a "simple device" all IRt/c models are rated intrinsically safe (Tech Note #10), and as hermetically sealed devices meet or exceed all applicable NEMA ratings.

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Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
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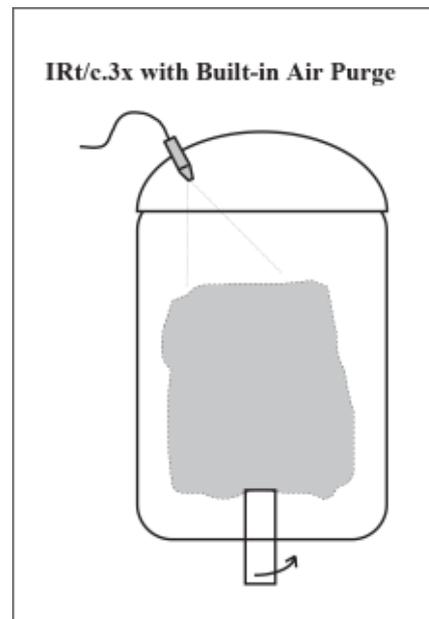
## BREAD AND PASTRY DOUGH MIXING TEMPERATURE

Measuring the temperature of bread and pastry dough while mixing is difficult at best with conventional contact thermocouple probes, due to breakage and possible contamination of the food. However, the temperature is quite important since too high a temperature will cause too much rise, leading to holes in the baked product, and too low a temperature will not allow the dough to rise sufficiently, resulting in a product that is flat.

The IRt/c solves the problem by monitoring temperature without contact, completely eliminating breakage and possible contamination. Wired into a temperature controller, the information can be used to control mixing speed motors to maintain proper dough temperatures.

The recommended models are the IRt/c.3X and .5, since their built-in air purge keeps the lens clean even in the dusty interior of the mixer. Hermetically sealed, the IRt/c can be washed

down during normal cleaning procedures. The recommended mounting location is the lid of the mixer, where the IRt/c has a clear view of the dough, and swings out of the way when loading and unloading.



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5465 RH Veghel  
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Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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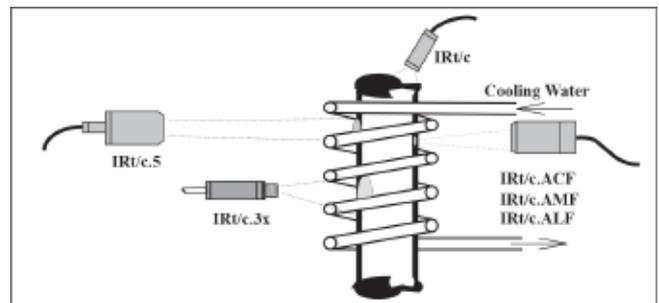
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### INDUCTION HEATER CONTROL

The induction heating process can be readily controlled by the temperature of the part as measured by an IRt/c non-contact infrared thermocouple. Several issues should be considered in an installation:

- 1. The effect of the field on the IRt/c:** since the measuring signal is electrically isolated from the housing, the IRt/c will operate in even a very strong field. The shield wire should be attached to a proper signal ground. If there is excessive heating from the field, consider using the cooling jacket kit, with the same water source as is used to cool the coil.
- 2. The field-of-view:** the preferred method is to view the part between the coil turns or from the end. Select the IRt/c model that best suits the requirements. For small gaps between coils, consider the focused models.
- 3. Part temperature:** IRt/c models can be used to measure target temperatures up to 5000°F (2760°C). Select the correct model for the control temperature desired.
- 4. Part surface material:** For bare metal parts the *Lo E* models are recommended. For coated or non-metal surfaces the *Hi E* models should be used.



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5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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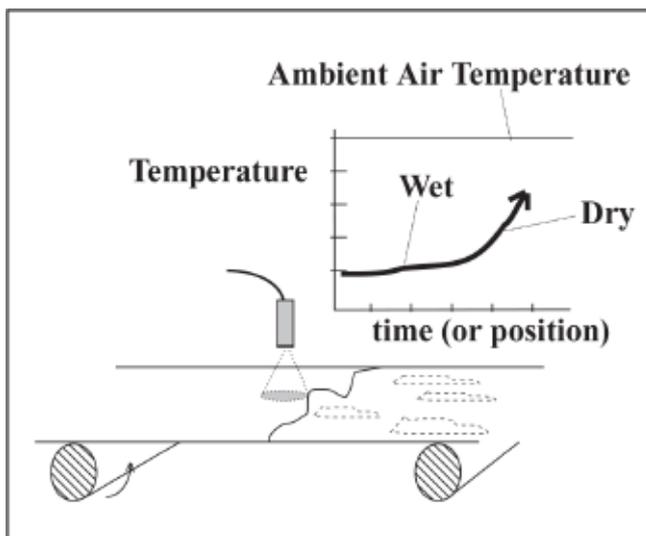
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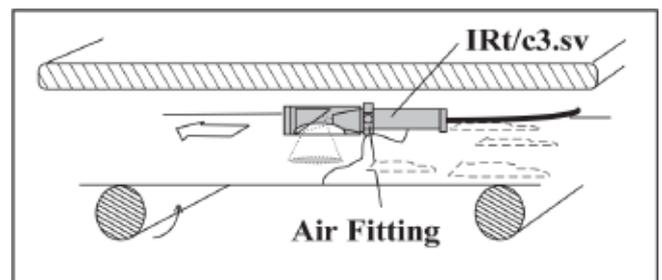
## PRINTING/INK DRYING

For high speed printing processes, the limiting factor on productivity of the equipment is usually ink drying time. With non-contact monitoring of the inked surface temperature, press production can be maximized while assuring top quality.

The surface temperature of freshly inked paper will be considerably cooler than ambient air temperature, and will rise very slowly as the paper absorbs heat. This occurs because the ink solvent absorbs much of the heat energy as it evaporates.



At the point that the product becomes “dry,” however, the same constant heat supply will quickly raise the temperature until it reaches the same as the surrounding air, or higher if the heat source is radiation. If temperature vs. time is plotted for a heated drying process, the target “dry” temperature point can clearly be seen as the beginning of a rapid rise in surface temperature. The IRt/c’s can be used to monitor these changes in surface temperature. With their fast response time, the IRt/c’s can quickly detect when the surface temperature begins to rise rapidly, an indication that the ink has dried, thus allowing press speeds to be maximized. Since all IRt/c’s are rated intrinsically safe (see Tech Note #10), and are hermetically sealed to meet or exceed all applicable NEMA ratings, they can be used in hazardous environments with alcohol-based and other volatile inks. For tight areas, the IRt/c.SV or IRt/c.3SV is recommended.



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The Netherlands  
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5465 RH Veghel  
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Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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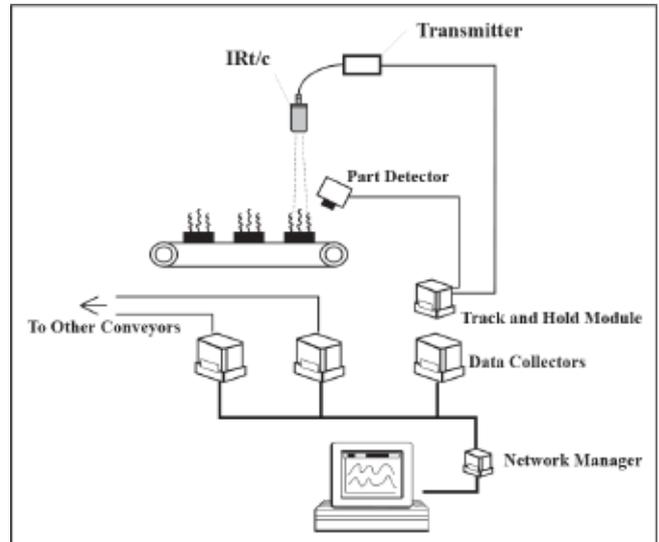
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## DISCRETE PARTS MONITORING

Parts on a moving conveyor can be monitored for temperature either continuously – measuring an average of conveyor and part – or discretely – measuring each individual part. For parts which completely, or nearly completely, cover the conveyor, measuring continuously will give good results.

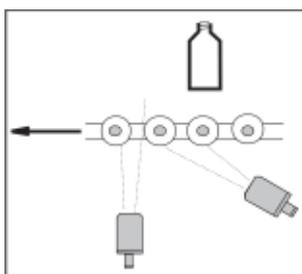
A powerful method of improving the optical density of the product as seen by the IRt/c is to angle the IRt/c such that it cannot see between the products. By doing this, temperature monitoring and control can be performed continuously with simple controllers, without the requirement for additional logic.

However, for applications in which each individual part must be measured for communication to a central process control computer, additional devices are required. The most important are the part detection device, which detects when the

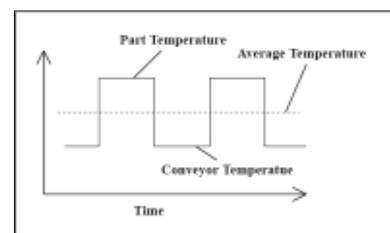


**Typical recommended system for discrete part monitoring with IRt/c's.**

part is within the field of view of the IRt/c; and the sample and hold device, which holds the previous reading when the part is not in view. Suitable control modules are available from various manufacturers to provide the necessary logic.



**Angling the IRt/c permits it to continuously monitor bottle temperatures**



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The Netherlands  
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5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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Tel: +1 617 649 6322  
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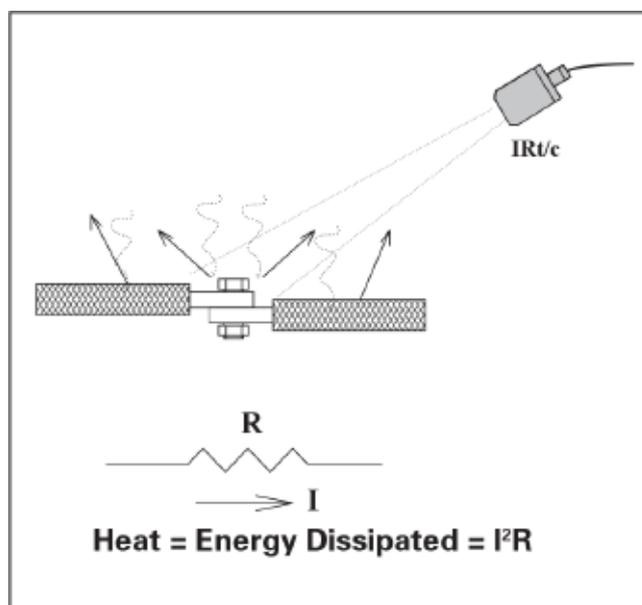
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## ELECTRIC POWER TRANSMISSION AND DISTRIBUTION CONTROL

The capacity of highly loaded electric power conductors, especially switching and transforming equipment, is limited by the temperature rise characteristics caused by the slight resistive losses. Accordingly, equipment utilization capacity is a direct function of the local temperature at critical points in the equipment.

With continuous real time monitoring with IRt/c's, critical equipment can be used much more effectively. If the temperature is below operating limits, additional power may be safely routed through the equipment. With the non-contact capability of the IRt/c, installation is simple, and live conductors may be safely and easily monitored. Inexpensive standard thermocouple transmitters and data collection equipment may be used to transmit the information to a central office where load switching decisions are made.



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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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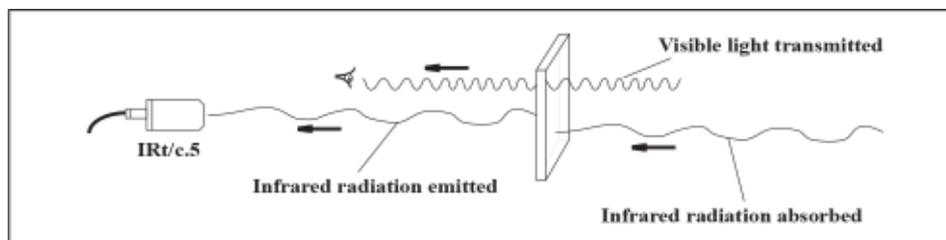
## GLASS MONITORING

Glass processing, whether of sheets, bottles, or other forms, usually involves temperature as a primary control variable. Since glass is impossible to measure by contact means, plants must use either ambient temperature as an indirect approximation, or an infrared device to measure the glass directly. An often asked question is whether infrared devices can measure glass correctly, since to the eye the glass is transparent.

The answer lies in the physics of glass and the well known “greenhouse effect.” The short wave radiation of visible light that we can see (~ 0.3 - 0.8 microns) can pass through glass essentially unaffected. The much longer infrared wavelengths that are normally measured for temperature

assessment (~ 5 - 20 microns) cannot pass through the glass, and are absorbed. As a consequence of the inability of glass to transmit the long wavelengths of infrared, the glass will emit those wavelengths created by its temperature, and thus can be measured with an IRt/c. At much higher temperatures the infrared wavelengths become shorter, and some transmission occurs.

If the glass is within the temperature range of the IRt/c, the sensor will measure its temperature accurately – just as if the IRt/c were looking at an opaque material surface. Follow the normal installation and calibration procedures. The glass will have emissivity in the range of 0.9 and above, and therefore will provide good results.



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5465 RH Veghel  
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Fax: +31(0) 413 37 93 10

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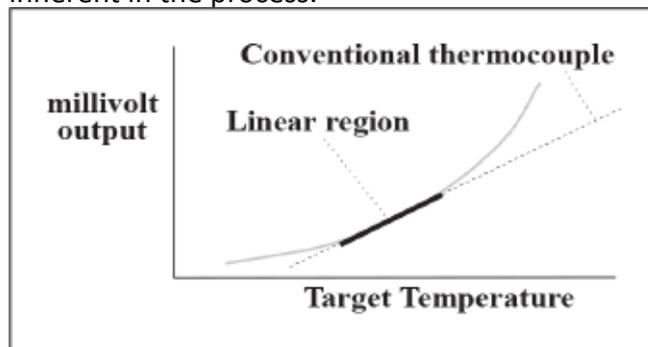
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## HOW THE IRt/c TEMPERATURE SELECTION GUIDE WORKS

All IRt/c's are self-powered devices, which rely on the incoming infrared radiation to produce the signal through thermoelectric effects. Accordingly, the signal will follow the rules of radiation thermal physics, and be subject to the non-linearities inherent in the process.

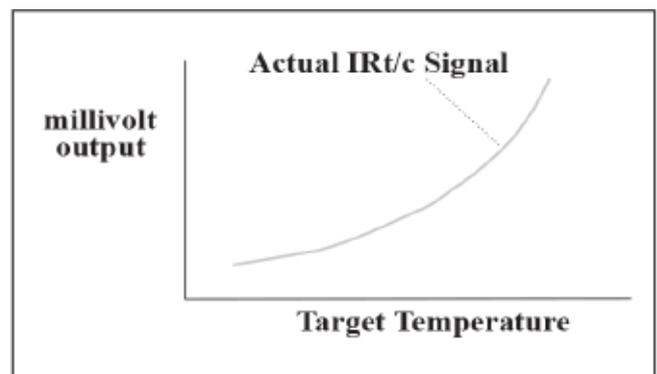


The linear region matches the conventional t/c to a specified tolerance.

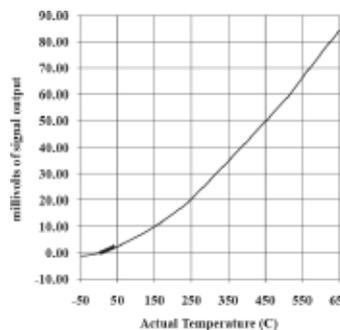
However, over a range of temperatures, the IRt/c output is sufficiently linear to produce a signal which can be interchanged directly for a conventional t/c signal. For example, specifying a 2% match to t/c linearity results in a temperature range in which the IRt/c will produce a signal within 2% of the conventional t/c operating over that range. Specifying 5% will produce a somewhat wider range, etc.

Each IRt/c model is specifically designed for optimum performance in the region of best linear fit with conventional t/c's, but can be used outside

of this range by simply calibrating the readout device appropriately. The output signal is smooth and continuous over its entire rated temperature range, and maintains 0.01°C repeatability over its entire range.

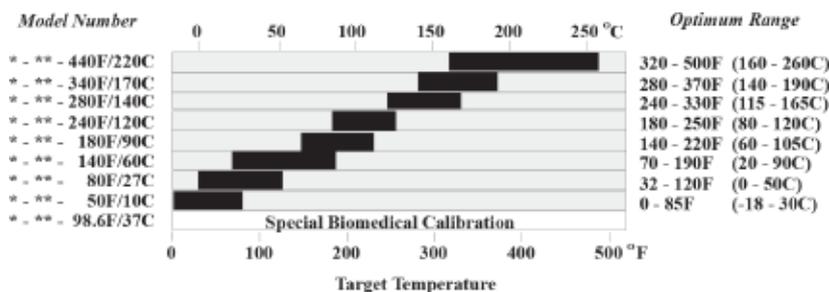


The actual signal generated by the IRt/c can be approximated with a fourth order polynomial function of target temperature. This fourth power dependence is due to radiation physics, and not a limitation of the IRt/c.



Signal produced by the IRt/c-K-80F/27C has its 2% linear range centered at 80°F (27°C), but produces a repeatable signal to 1200°F (650°C).

The Temperature Selection Guide is a summary of the linear range performance of each IRt/c model.



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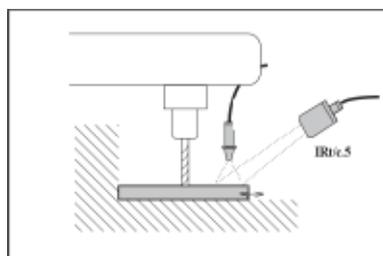
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## IMPROVING MACHINING TOLERANCE

Precision machining tolerances of metal and nonmetal parts are substantially impaired by uncertainty in part temperature, due to the dimensional changes which occur with temperature. For example, most metals have thermal expansion coefficients of approximately 10 ppm per °F (approximately 20 ppm per °C). If a 10 inch (25 cm) part undergoing machining increases in temperature by only 10 °F (5 °C) from the set-up, the part will have increased in size by .001 inch (.025 mm). Accordingly, the best that the machine can do, regardless of the machine's quality, is + 0.0005" (+ 0.012 mm). If the temperature uncertainty is higher, the tolerance increases in direct proportion. This effect is especially important as the tool wears, and significantly more frictional energy is imparted to the part.

The IRt/c solves the problem by monitoring the part temperature continuously, and reporting the temperature to the computer, which in turn adjusts the position of the cutting tool accordingly. An additional benefit is detection of worn tools, due to the higher than anticipated part temperatures, or rate of change of temperature.



Any of the IRt/c models can be used, although the IRt/c.3x and .5 are preferred for their narrower fields of view and

built-in air purge. Emissivity of the metal parts is normally not a problem due to the presence of cutting oils and coatings. If the parts are completely clean, then a thin coating of oil will be sufficient to increase the emissivity for accurate measurements.

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Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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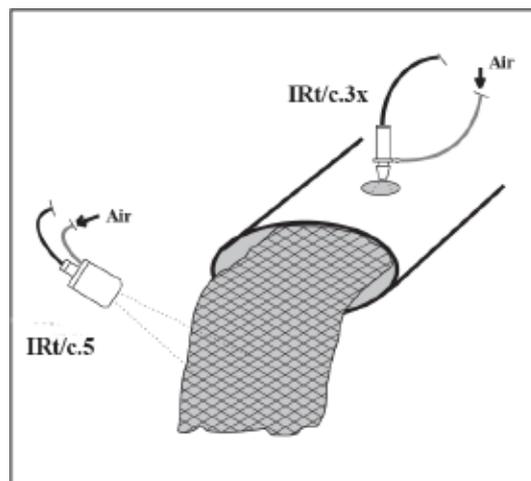
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## ASPHALT TEMPERATURE MONITORING

Asphalt properties are particularly sensitive to temperature, and it is important that the asphalt is applied at the correct temperature in order to perform to its specifications. Accordingly, temperature monitoring is a common requirement, but the thermocouples normally used have severe breakage problems due to the harsh abrasiveness of the material, and must constantly be replaced at high cost and interruption of production.

The IRt/c solves this problem directly, since the temperature is monitored without contact. The normal thermocouple controller can be used – simply calibrate offset if necessary. The IRt/c.3x and .5 models are recommended for their built-in air purge, which will keep the lens clean by preventing vapors from condensing on the lens.

The IRt/c.3x can be mounted in the chute to view the asphalt through a small hole, while the IRt/c.5 can be mounted some distance away due to its narrow 5:1 field of view.



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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## SPEED OF RESPONSE

One of the outstanding features of the IRt/c is its speed of response – 0.05 to 0.2 seconds. This attribute makes it possible to monitor the temperature of fast moving materials in production lines, and rapid heating and cooling. For applications in which high speed is required, care should be taken in selection of the readout device, since most thermocouple readouts are much slower than the IRt/c.

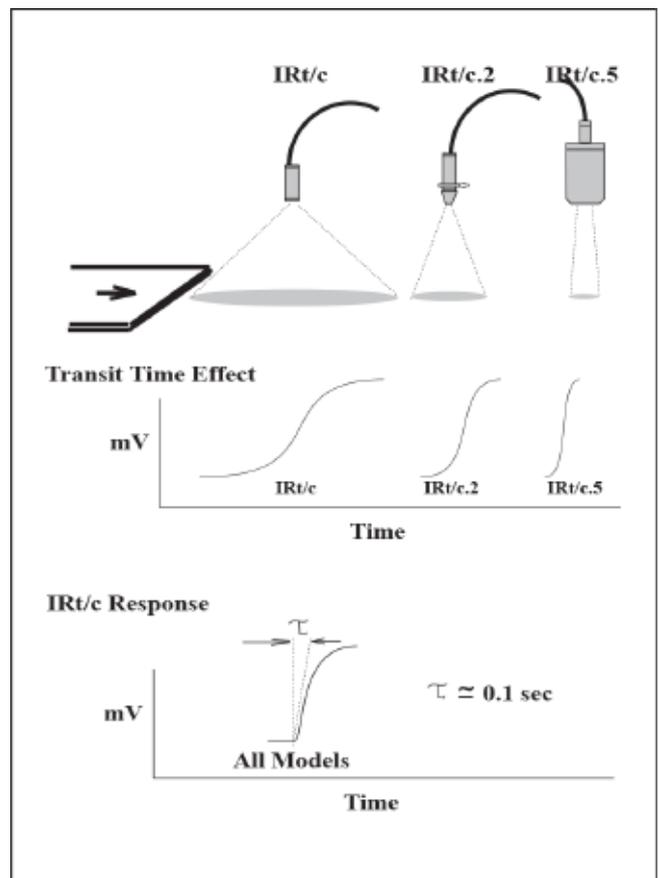
In applying the IRt/c, the dynamic characteristics can be described mathematically as a pure exponential response, following the equation:

$$\Delta mV = c(1 - e^{-t/\tau})$$

Accordingly, the IRt/c signal can be modeled analytically for applications in which faster speeds are required. For any given IRt/c, the time constant will be repeatable to within a few percent, and thus can be successfully modelled.

A common limitation in applying the IRt/c to high speed applications is the transit time of the target across the field of view. The characteristic time constant equation of response applies to the IRt/c response only. If the target requires time to completely fill the field of view, the transit time

must be added to the IRt/c time constant. For best results, place the IRt/c as close as possible to the target to minimize the spot size, and therefore the transit time effect.



#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## IRt/c QUICK SELECTION GUIDE

### 1. How Large Is Your Target?

- If it is smaller than 0.8 inches (2 cm), you must select either the micro IRt/c, micro IRt/c.4, IRt/c.2G, IRt/c.01, IRt/c.03, IRt/c.1x, IRt/c.3x, or focused model.
- If it is smaller than 0.3 inches (8 mm) you must select the IRt/c.3x or focused model.
- If it is larger than 0.8 inches (2 cm), select any of the sensors.

### 2. How Close Can The Sensor Be Mounted?

- See Tech Note #36, Tech Note #41, and Tech Note #55 and use the field-of-view drawings showing the distance from the sensor versus the approximate diameters of the spot size.
- For example, the IRt/c.3x, at a distance of 3X has a spot size of 1X (at a distance of 1 foot, the spot size is 4 inches, at a distance of 1.5 meter, the spot size is 0.5 meter).
- See Tech Note #29 if you wish to position an IRt/c at an angle other than 90° from your target surface.
- If using a focused model, refer to individual model specifications for optimum distance.

### 3. What Is The Ambient Temperature Where The Sensor Is To Be Placed?

- If ambient is less than 160°F (70° C) choose any sensor.
- If ambient is less than 185°F (85°C) choose any sensor except micro IRt/c, IRt/c.01 and IRt/c.03.
- micro IRt/c, IRt/c.01 and IRt/c.03 If ambient is less than 212°F (100° C) choose any sensor except IRt/c.01 and IRt/c.03.
- If ambient is greater than 212°F (100° C), see Tech Note #35 for air cooling flow requirements for the IRt/c Cooling Jacket Kit and IRt/c.XXX built-in air purge/cool system.
- If ambient is greater than 500°F (260°C), it is usually best to specify an IRt/c or IRt/c.2 sensor along with the Cooling Jacket Kit and utilize the water cooling feature. (Cooling the smaller sensors with water is less expensive over time, compared to cooling the IRt/c.5 with air.)

### 4. What Is Your Target Temperature?

- Use Temperature Selection Guide. See Tech Note #49.

### 5. Choosing A Temperature Controller/Input Device?

- See Tech Note #37 and Tech Note #14 for help in selecting or using available thermocouple input devices.

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## HOW TO USE INFRARED EFFECTIVELY

As somewhat less commonly understood methods of temperature measurement, infrared methods have their own characteristics which lead to both good applications and difficult applications. The three simplified rules below will help you evaluate the potential use of infrared techniques, and estimate of the degree of difficulty involved. These rules apply to infrared physics in general, and are not a limitation imposed by the design of IRT/c's specifically.

### 1. Simple Applications

- All non-metallic surfaces
- Food, Paper, Plastics, Coated Metals, Stone, Clay, Glass, Liquids, Textiles, etc.

### 2. More Difficult Applications\*

- Bare Metals\*\*
- Shiny, unpainted, uncoated metal surfaces\*\*

### 3. "In Between" Applications\*

- Dull Metal Surfaces
- Thin "See-through" Plastics

\* For temperatures in the correct range, the Lo E models provide very good performance if emissivity variations are not too great.

\*\* It is always repeatability that counts, and there are various "tricks" that can be used to improve repeatability in difficult applications, but experimentation is required.

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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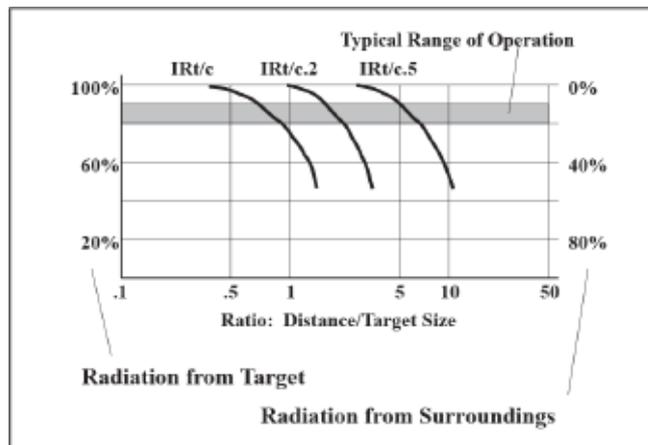
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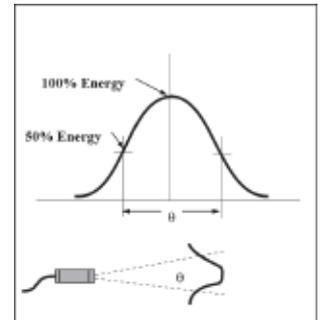
## UNDERSTANDING FIELD-OF-VIEW

IRt/c's are rated optically for their field-of-view by the actual dimensional equations describing their construction. However there are, in practice, some secondary effects which can influence performance, including optical scatter, unwanted reflections, atmospheric scatter, and others.

The graph illustrates the relative contribution to the signal produced by the target and by the area surrounding the target due to these effects. Note that the sum of radiation from the target and radiation from the surroundings is always one, and as the sensor is placed further away than its rated field-of-view, there is less target signal and more surroundings signal. Mathematically this effect is identical to a reduction in emissivity, and can be calibrated out the same way, as long as the temperature of the surroundings is repeatable.

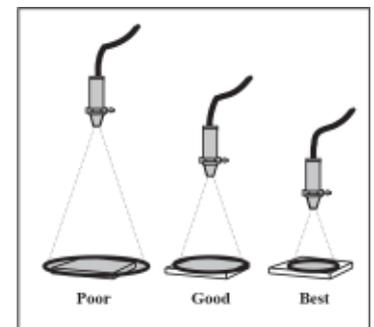


Under typical conditions, placing the IRt/c such that the target exactly fills the field of view results in approximately 80 to 90% target signal, and 10 to 20% surroundings signal.



A common convention in infrared thermometry, and the one used to verify the optical performance of IRt/c's, is to define the field-of-view by the "1/2 energy points" in an optical traverse experiment. The resultant data looks like a "Bell Curve" as indicated in the illustration. The field-of-view is simply the angle between the 50% energy points.

As always, closer is best; use the closest possible position for the IRt/c.



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The Netherlands  
 Pastoor Clercxstraat 26  
 5465 RH Veghel  
 Tel: +31(0) 413 37 65 99  
 Fax: +31(0) 413 37 93 10

USA  
 400 Pleasant Street  
 Watertown, MA 02472  
 Tel: +1 617 649 6322  
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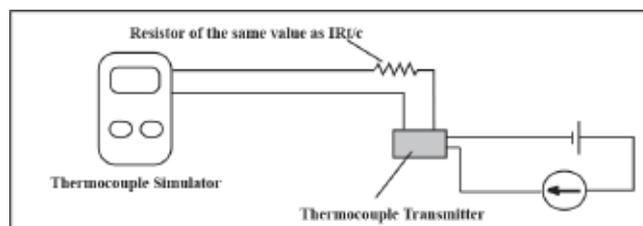
## CALIBRATING WITH THERMOCOUPLE SIMULATORS

A common practice in thermocouple transmitter calibration is to set the 4 to 20 mA range on the bench before installation. The usual procedure is to employ a thermocouple simulator which can be programmed to produce a thermocouple equivalent signal of the desired type and temperature range. In this fashion, the 4 mA is set with the ZERO, and the 20 mA with the SPAN for the desired range.

Bench calibration of a transmitter can be performed to operate with any IRt/c by adding the following step to the normal method:

- Measure the electrical resistance of the IRt/c to be used with the transmitter, and add a resistor of the same value in series with the simulator.

With this step, the simulator “looks” to the transmitter exactly the same as the IRt/c, and any offsets caused by transmitter leakage currents can be calibrated out. Good practice is to check to make sure that the calibration remains stable on the bench, in case the transmitter leakage current is not constant. As always with infrared devices, a final trim calibration should be performed in actual operation (see Tech Note #1).



#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## MEASURING OBJECTS SMALLER THAN THE FIELD-OF-VIEW

For some non-contact temperature monitoring tasks, the object to be measured is too small to adequately fill the field-of-view of one of the IRt/c models. The monitoring can still be successfully performed if two conditions are met:

- The object size and distance from the IRt/c are constant.
- The area surrounding the object within the field-of-view of the IRt/c has a repeatable temperature.

The signal produced by the IRt/c represents the average temperature within its view. Accordingly, the signal can be represented by the equation:

$$T = (T_t A_t / A) + (T_s A_s / A)$$

where  $T$  is the output signal,  $T_t$  the target object temperature,  $A_t$  the target object area,  $T_s$  the surroundings temperature,  $A_s$  the surroundings area as seen by the IRt/c, and  $A$  the total area seen by the IRt/c.

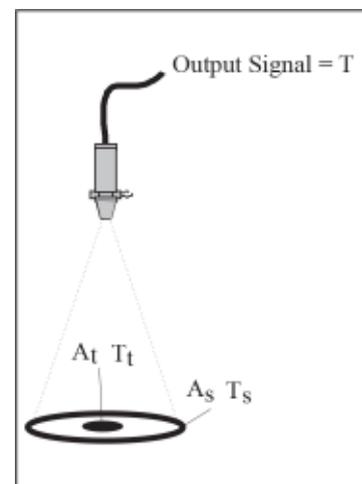
For example, to measure the temperature of a thin rubber strip 0.1" (2.5 mm) wide moving continuously 1" (25 mm) away from an IRt/c.2, at a temperature expected to be about 200°F (93°C), and a surrounding temperature at 80°F (27°C). At 1" (25 mm) distance, the IRt/c.2 spot size will be approximately 0.5" (13 mm).

Computing the results for the equation gives:

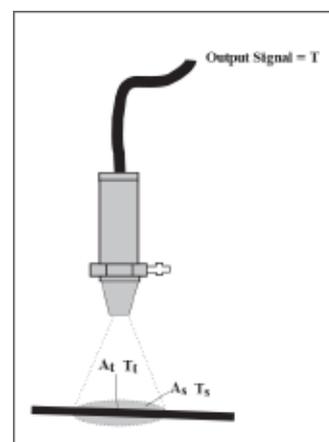
$$T = (200)(.5)(.1) / [\pi(.25)^2] + (80)[\pi(.25)^2 - (.5)(.1)] / [\pi(.25)^2]$$

This result shows that the average signal will be 31°F (17°C) above the surroundings temperature, compared to an actual object temperature of 120°F (67°C) above surroundings, or approximately one-fourth, which is the ratio of object area to surroundings area measured. Therefore, if the surroundings are expected to be repeatable to Exergen Global offices:

1°F (.6°C), the IRt/c signal will be repeatable to 4°F (2°C). For the final display on a controller, or other read-out device, calibrate in standard fashion by using the available offset adjustment. If the object is to be controlled over a wide range of temperatures, calibrating with a span adjustment will yield greater accuracy.



If the target temperature falls within the range of one of the LoE models, the LoE model should be used, even if the target is not metallic. Since a small target results in the same radiation mathematics as low emissivity, a LoE model will reduce errors due to size change and positioning by a factor of approximately 4. See Tech Note #59.



## MEASURING HIGH TEMPERATURES WITH IMMERSION THERMOWELLS

Like ordinary thermocouples, the high temperature IRt/c models can be used with immersion “thermowells” to measure high temperature gases or liquids, while maintaining the integrity of the vessel. However, the IRt/c has significant advantages over ordinary thermocouples, RTDs, etc. in this application.

### Survivability

Since the IRt/c sensor elements are positioned in a non-contact mode, outside of the heated area, and kept at a low temperature, the entire temperature sensing system can be designed to survive for a much, much longer period of time than conventional thermocouples or RTD’s. The only part requiring maintenance is the thermowell itself, an inexpensive and easily replaced part. Users enjoy savings because there are no replacement thermocouple parts, no replacement labor, and no production losses from downtime for sensor replacement.

### Sensor Stability and “Drift”

Even worse than sensor failure is a sensor that reads incorrectly, feeding inconsistent or inaccurate information to your control systems. Sensor stability and drift can be significant problems with standard thermocouples when measuring high temperatures, due to chemical and metallurgical changes that long exposure to high temperatures causes. The IRt/c, however, is essentially immune to those effects, since the sensor remains at a low temperature – far below that of the contact device, and below the levels which are the major sources of drift.

### Sensor Speed

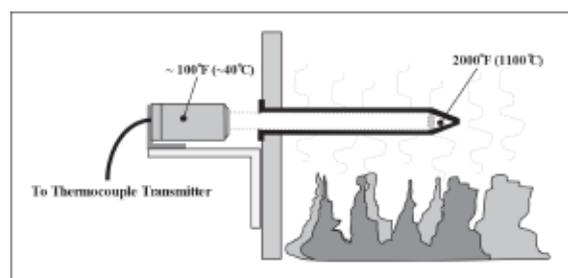
With its 0.1 to 0.2 second response time, the IRt/c

is far faster than any conventional thermocouple or RTD placed inside a well. Accordingly, for all practical purposes, the temperature measurement speed is the same as that of the well itself.

### How To Use The IRt/c With A Thermowell

The technique is to mount an IRt/c sensor so that it aims directly into a hollow thermowell. The well should have a minimum inner diameter to accommodate the minimum spot size of the sensor selected. Choose the appropriate sensor for the temperature range and length of the well you are using. For example, to measure up to 2000°F (1100°C), 6 feet (2 m) into a stack, use an IRt/c.100A-HiE sensor looking into a thermowell of that length with an inside diameter of at least .8 inches (20 mm). The spot diameter for the IRt/c.100A at 72 inches distance is .8 inches (at 2 meters distance, the spot diameter is 20 mm.) The sensor can then “see” all the way into the hollow well tube and monitor the tip end temperature, ignoring the sidewall temperatures. Choose appropriate thermowell material (stainless steel, Hastelloy®, Inconel®, ceramic, etc.) to withstand the temperature, oxidation and other rigors of the environment where it is to be placed.

If the thermowell is sealed with a sight glass, then a *Lo E* model should be specified (see Tech Note #66).



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
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office@exergenglobal.com  
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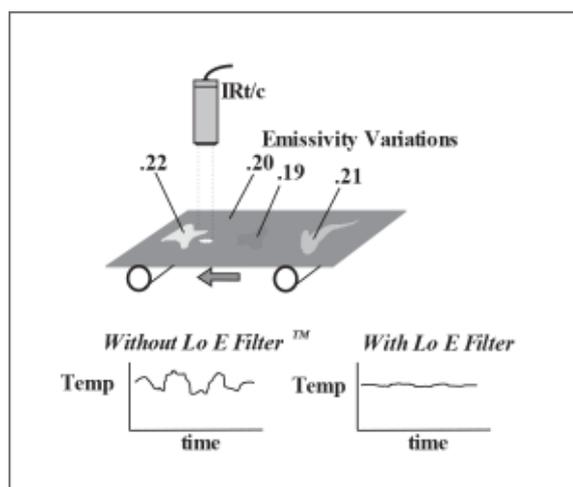
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## HOW THE LO E FILTER REDUCES ERRORS DUE TO EMISSIVITY VARIATIONS

Emissivity is the property of a material's surface that describes its "efficiency" at emitting thermal radiation. An emissivity value of 1.0 represents emission at 100%, and 0 describes emission at 0% (or perfect reflection - see Tech Note #31).

For non-metals and coated metals this efficiency of emission, called emissivity, is very high (0.8 or greater), and variations are usually not a problem. For example, for a production process in which a non-metallic material is to be controlled, and normal material variations cause emissivity variations of  $\pm 0.01$ , the associated temperature error will be of the order of .01 divided by .9, or  $\sim 1\%$  of reading, an acceptable variation. In contrast, if we are to control the temperature of a metal with emissivity 0.2, then variations of  $\pm 0.01$  will produce an error of the order of  $(.01/.2)$ , or  $\sim 5\%$  of reading. Additionally, metal finishes, which play a significant role in emissivity, tend to cause more variations than changes in finish in non-metals.

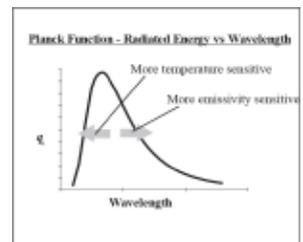


The IRt/c *Lo E Filter* design filters out the effects of these emissivity variations on measured temperature by approximately a factor of four, and thus reduces the errors by a factor of four. Thus, with the Lo E Filter, the errors are of the same order as those commonly experienced for high emissivity targets.

The method takes advantage of the basic physics of thermal radiation, in which the mathematical description of the energy distribution is by a formula called the Planck function:

$$q_{\lambda} = \epsilon \frac{2\pi hc^2 \lambda^{-5}}{e^{ch/k\lambda T} - 1}$$

where  $q_{\lambda}$  is radiated energy at a given wavelength,  $\epsilon$  is the emissivity,  $T$  the absolute target temperature,  $\lambda$  the wavelength, and the other symbols are for various physical constants. The Planck function integrates to the more familiar Stefan-Boltzman equation:



when all Radiated Energy =  $q = \int_0^{\infty} q_{\lambda} d\lambda = \epsilon \sigma T^4$  wavelengths are measured. The Lo E Filter works by measuring the energy content of the radiation, as described by the Planck function, over wavelengths that are more selectively sensitive for temperature variations, and therefore proportionately less sensitive to emissivity variations, as follows:

$$\text{Filtered Radiated Energy} = \int_{\lambda_1}^{\lambda_2} q_{\lambda} d\lambda \approx \epsilon \sigma T^x$$

where  $x \gg 4$

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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## HOW THE LO E FILTER REDUCES ERRORS DUE TO EMISSIVITY VARIATIONS

If we compute the partial derivative of each expression with respect to emissivity and temperature, we obtain the following relations for the slope of the signal with respect to temperature divided by the slope of the signal with respect to emissivity:

$$\frac{\partial}{\partial \epsilon}(\epsilon \sigma T^4) = \sigma T^4, \quad \frac{\partial}{\partial T}(\epsilon \sigma T^4) = 4\epsilon \sigma T^3 \Rightarrow \frac{4\epsilon \sigma T^3}{\sigma T^4} = \frac{4\epsilon}{T}$$

$$\frac{\partial}{\partial \epsilon}(\epsilon \sigma T^x) = \sigma T^x, \quad \frac{\partial}{\partial T}(\epsilon \sigma T^x) = x\epsilon \sigma T^{(x-1)} \Rightarrow \frac{x\epsilon \sigma T^{(x-1)}}{\sigma T^x} = \frac{x\epsilon}{T}$$

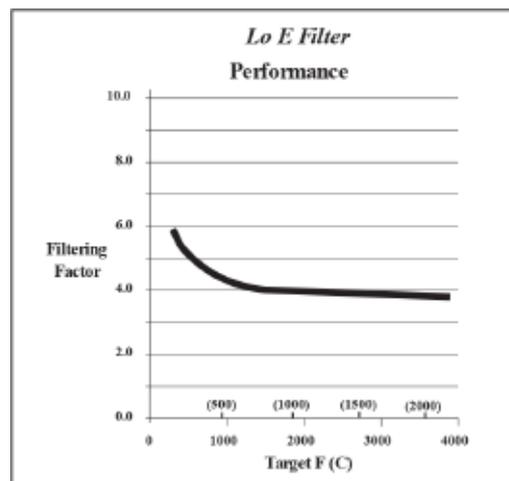
where  $x \gg 4$

Accordingly, by optimum selection of the wavelengths to be measured, the sensitivity to emissivity variations can be significantly reduced, i.e. filtered, by enhancing the relative sensitivity to temperature. In practice, the best wavelengths are the shorter ones, since they provide the most sensitivity to temperature, and the least sensitivity to emissivity, as is predicted by the integration of the Planck function.

The “filtering factor” for the IRt/c Lo E models is based on the selection of .1 to 5 micron for the

measured wavelengths, and results in a factor of from four to six error reduction, depending on target temperature.

As an additional benefit of the Lo E Filter, errors due to such factors as smoke, dust, moisture, etc. which may partially block the optical path to the target, are also filtered. These factors behave mathematically identically to emissivity, and therefore will be filtered by the same factor of four to six.



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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

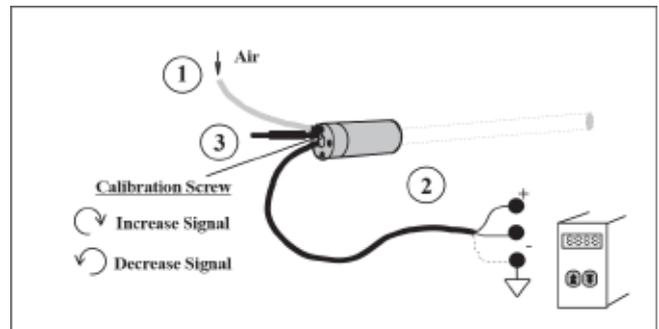
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Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## SET-UP AND CALIBRATION INSTRUCTIONS FOR ADJUSTABLE MODELS

### For all IRt/c Models with "A" in model designation (IRt/c.xxxA)

1. Connect air purge first if installing in process already at operating temperature. Provide minimum 5 psig (30 kPa) air pressure.
2. Install IRt/c and align to view the desired target. Bring target to operating temperature if not already there. Connect leads to readout device to be used (controller, PLC, etc.).
3. If the target temperature is not known, measure the target temperature with an accurate reference. Remove the setscrew to expose the calibration screw. Adjust the calibration screw to obtain reading desired. Replace the setscrew cover when complete. For final process adjustments, the ZERO or OFFSET adjustments available on readout devices can be conveniently used.



**Installation and calibration complete.**

**To maximize the linear range, see Tech Note #70.**

**Calibration screw operates like a radio volume control: clockwise increases signal.**

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5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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Tel: +1 617 649 6322  
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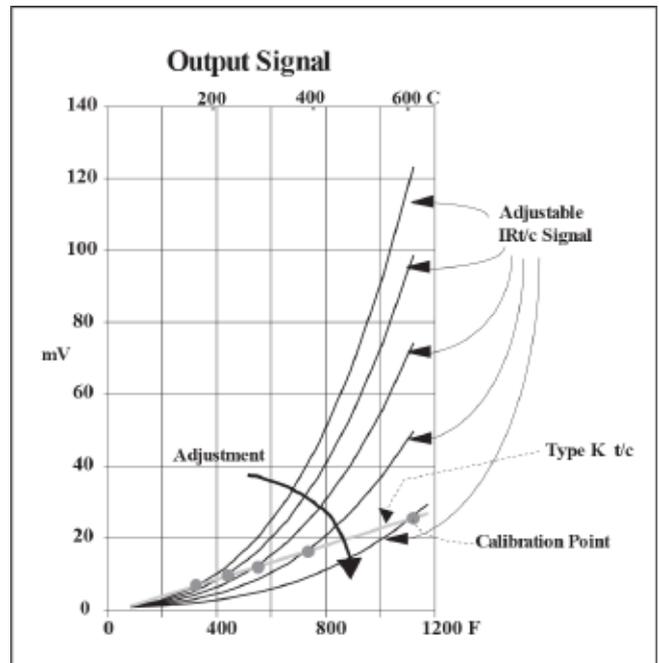
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## HOW THE ADJUSTABLE IRt/c MODELS WORK

All IRt/c models with the “A” designator (example: IRt/c.10A-K-LoE) can be field calibrated for the specific requirements of the application to precisely indicate the actual temperature of the target, and to correct for reflective errors caused by ambient variations (see Tech Note #64).

The basic operation of the IRt/c adjustment is to rescale the signal output until it matches the actual temperature for the thermocouple type in use. In the vicinity of the calibration point, the output will match the linearity of the t/c. When the adjustment is made to actual temperature, the Automatic Ambient Compensation System is automatically correctly scaled.

The above chart shows the actual performance of a .10A-HiE model as an illustration of the effect of adjustment on the signal.



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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
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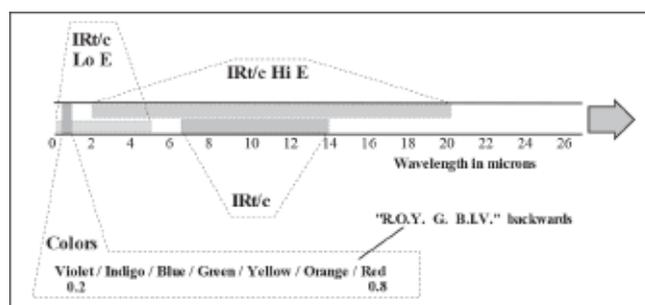
## WHY COLOR DOES NOT AFFECT READINGS

In many IRt/c installations, such as paint curing, web drying, printing, etc., the temperature control system must be able to accurately measure materials with a variety of colors. Ideally the same calibration set-up would be used for all colors, rather than having to recalibrate each time a new color is run.

Because the IRt/c measures the radiated wavelengths that indicate temperature, which are generally ten times longer than the wavelengths that indicate color, color changes do not influence temperature readings. Even for situations in which the target temperature is sufficiently high such that appreciable energy is radiated at visible wavelengths, *all IRt/c models except Lo E completely filter out the visible wavelengths.*

Except to the extent that color might indicate a change in surface texture, and thereby affect emissivity, there will be no effect of color on the reading.

The energy contained in the radiation we see as color has nothing to do with the temperature (except if the target is hot enough to be incandescent), and is simply a function of which particular wavelengths are reflected to our eyes.



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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## POTENTIAL ERRORS CAUSED BY AMBIENT TEMPERATURE EFFECTS

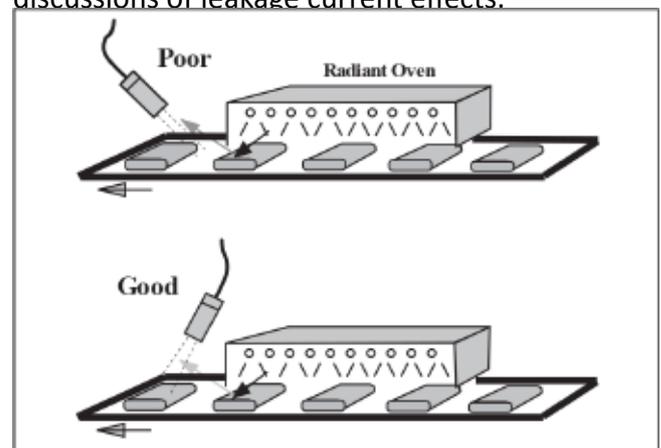
If the ambient temperature of a temperature control installation changes significantly, there are several sources of potential inaccuracies that can be minimized by attention to installation details.

**Reflective Errors:** For situations in which the IRt/c itself is at the same temperature as ambient sources of radiated energy, the patented design of the IRt/c will compensate for reflected energy and maintain accuracy. See Tech Note #64 for discussion.

If the ambient source of radiant energy is too hot for an uncooled IRt/c, the principal precaution to employ is to take advantage of the generally specular characteristics of reflected energy. The term specular means “mirror-like,” and reflective errors can be minimized by avoiding viewing angles in which the surface can reflect a hot source.

**Leakage Current Effects:** For installations in which the readout device generates appreciable leakage current, there is a potential inaccuracy due to small shifts in IRt/c impedance with ambient temperature. For example, if the readout device leakage current generates an offset of 100°F (55°C), which is calibrated out at installation, and sometime later the ambient temperature for the IRt/c is much hotter, the IRt/c impedance might be

a few percent different than it was at calibration. Accordingly, the temperature offset caused by the leakage current will also shift by a few percent. If the original offset requirement is 100°F (55°C), then a shift of ~ 5% impedance will cause a shift in reading of ~ 5°F (~ 3°C). In general, always choose a readout device with the lowest leakage current available to avoid this potential problem. See Tech Note #14, #16, #37, and #56 for further discussions of leakage current effects.



#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
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Watertown, MA 02472  
Tel: +1 617 649 6322  
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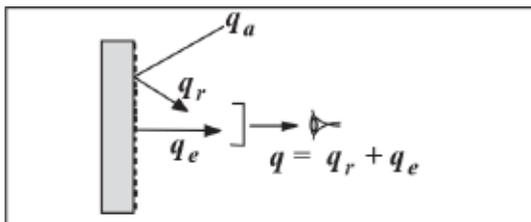
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## ADJUSTABLE MODELS COMPENSATE FOR REFLECTIVE ERRORS

For high precision temperature control in applications where the ambient temperature varies, reflective effects may cause unacceptable errors under some operating conditions. For example, an incubator is designed to warm a baby by measuring the child's skin temperature, and modulate the ambient temperature inside the incubator to maintain the skin within the desired range. Even though skin has a high emissivity (> 0.9), there is potentially an error of  $\pm 1^\circ\text{F}$  ( $0.6^\circ\text{C}$ ) caused by changes in the reflective component of the radiation as the ambient is modulated  $\pm 10^\circ\text{F}$ .



The basic principles can be understood by considering the radiation leaving a surface, as measured by any detector (including an eye). The total radiation  $q$  is made up of the reflected and emitted radiation components as follows:

$$q_a = \text{ambient radiation} = \sigma(T_a)^4$$

$$q_r = \text{reflected radiation} = \rho q_a$$

$$q_e = \text{emitted radiation} = \epsilon \sigma(T_s)^4$$

where  $\rho$  is reflectivity,  $\epsilon$  is emissivity,  $\sigma$  is the *Stefan-Boltzman* constant, and  $T_a$  and  $T_s$  are absolute ambient and surface temperature respectively.

Since emissivity plus reflectivity is always unity for non-transparent surfaces, the total radiated energy can be written as:

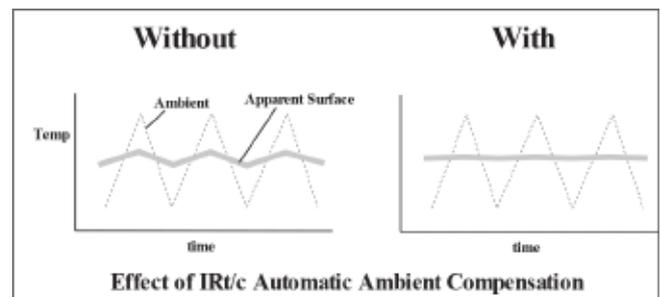
$$q = q_r + q_e = (1-\epsilon)\sigma(T_a)^4 + \epsilon\sigma(T_s)^4$$

This expression can be further simplified into a linear approximation that applies to the ambient temperatures over which the IRT/c can operate uncooled:

$$T = (1-\epsilon)T_a + \epsilon T_s$$

where  $T$  is the apparent surface temperature measured by radiation. As indicated by the final result, if the emissivity is 1.0, the effect of ambient temperature is zero. If the emissivity is 0.9, the effect of ambient temperature is 10%, etc. (As an aside, this expression can be used to obtain the actual emissivity.)

Non-adjustable IRT/c's are designed and calibrated to automatically compensate for this effect when the emissivity is 0.9, a good general assumption for most non-metallic materials, and sufficient for good accuracy under most conditions. With the adjustable models, however, when the IRT/c is calibrated in place it automatically compensates for the reflective errors as indicated in the above equation for any emissivity within its normal operating range. This patented automatic ambient compensation feature significantly improves the IRT/c control accuracy under real world conditions of varying ambient temperatures.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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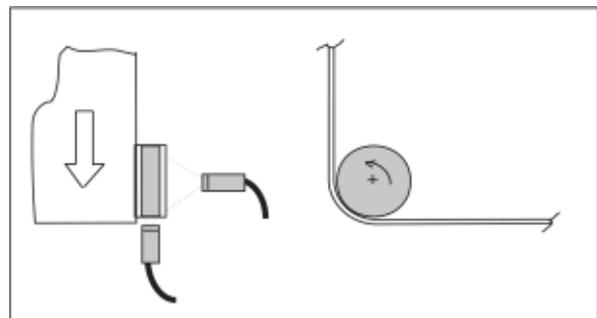
## PAINTING METAL SURFACES TO INCREASE EMISSIVITY

Even with the availability of *Lo E Filter* models, as a general rule higher emissivities require less careful attention to set-up details and calibration, and are more “forgiving” in long term service using any IR temperature measuring device. Accordingly it is recommended that where possible, surface emissivity should be increased. If it is not possible to increase emissivity, then a *Lo E Filter* model should be specified.

As an example, to control a metal roller temperature, paint either the end or an unused edge, and monitor with an IRT/c.

A recommended paint for most service is

RUST-OLEUM®  
7778  
BAR-B-Q-BLACK  
Rated to 800°F (427°C)



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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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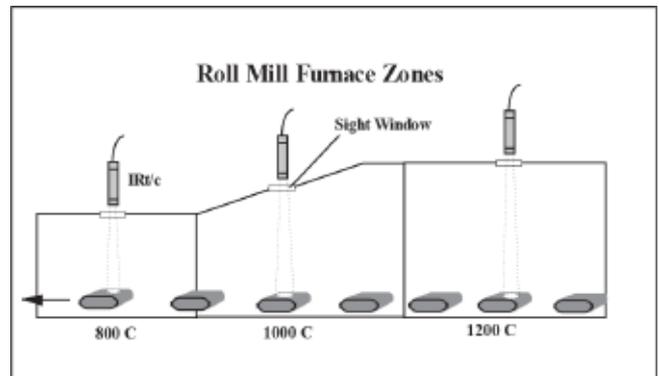
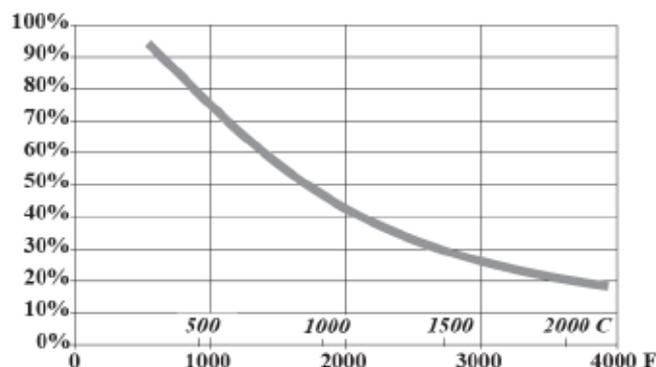
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## LOOKING THROUGH SIGHT WINDOWS WITH LO E FILTER MODELS

Commonly, many types of furnaces are equipped with sight windows to permit visual inspection of the processing of the materials. These windows would conveniently provide a means for monitoring the temperature if the IR sensor could deliver reliable readings through the glass. Such glass can be normal window glass, tempered glass, quartz, etc.

### Approximate Signal Loss Through Sight Glass



Lo E IRt/c models can “see through” such windows and will provide reliable readings if the losses are not too great. The adjustability feature of these models allow them to be calibrated to include the loss through the window. As a general recommendation, targets above about 500°C should provide good results, but the only way to be sure is to actually install the appropriate IRt/c and monitor results. If there is insufficient signal to read out the correct temperature, the OFFSET adjustment on the readout device may be used to add signal.

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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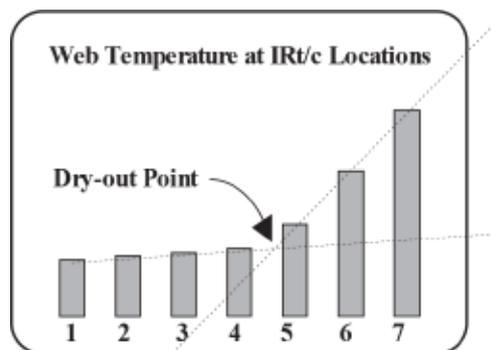
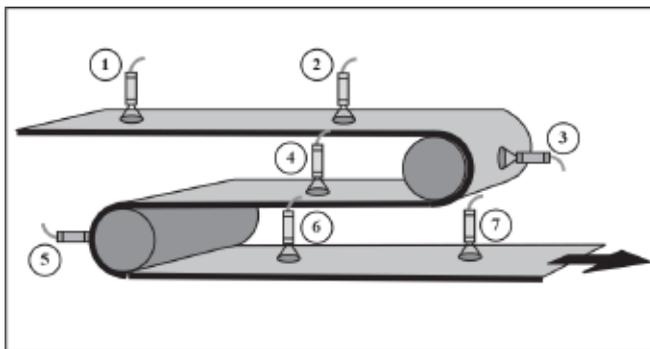
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## MEASURING LOCATION OF DRY-OUT POINT IN WEB PRODUCTION

For many types of continuous web production processing, such as paper, printing, photographic film, textiles, etc., an important parameter for quality and throughput rate is knowledge of the point at which “dry-out” occurs. More important even than the absolute temperature, the location of this point provides a highly precise indication of the rate of heat input into the product, and allows direct control of the energy input to force the dry-out point to a specific spot in the drying process.

The IRt/c is particularly well suited to this application due to its small size, low cost, outstanding speed, hermetically sealed construction, and its intrinsically safe character.

Connected to inexpensive multi-channel thermocouple input cards for PLC's or computers, the dryout point is easily calculated by the intersection of the slopes of the temperature vs. position data provided by the IRt/c's.



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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

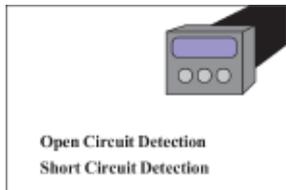
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## FAIL-SAFE CONTROL INSTALLATION METHODS

Although extraordinarily reliable, like any other measuring device, an IRt/c installation should be designed to “fail-safe” under all foreseeable situations. Accordingly, the possible failure modes should be considered as part of the installation design, as recommended in the *Operating Principles Manual* supplied with every IRt/c.

### Open Circuit Detection



As in all thermocouple installations, a primary protection recommended is open circuit detection, which will alert if wires are broken, or if the IRt/c

is physically damaged to the point of opening the electrical circuit. Standard circuit techniques involve using a small leakage current that generates negligible voltage when the circuit is closed, but drives the input amplifier into saturation if the circuit opens. Only a very small amount of current is required, ~1 nanoamp, which produces a negligible signal offset with the higher impedance of the IRt/c, although some devices produce far more current than required, and thus produce more offset (see Tech Notes #16, #37).

### Short Circuit Detection

Also a commonly available feature of thermocouple control devices, this safety feature detects if the load is on solidly for a time that is too long for the normal process requirements. This would be the case if a thermocouple were shorted somewhere between the measuring junction and the controller, and thus not reporting the temperature of the process, but the temperature at the short. This safety feature in a controller is highly recommended, since it not only will protect

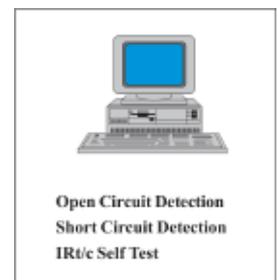
against short circuits, but also against any other possible failure in the IRt/c which might maintain electrical continuity, but renders it blind to the process.

### Calibration Drift

There are no known processes that can cause a significant calibration drift in the IRt/c. Since there are no active electrical components, the signal is generated entirely by thermoelectric effects, and the materials are kept at comfortably low temperatures. A significant feature of the IRt/c design and construction is the presence of a Xenon gas fill in the detection system, which provides an immediate and dramatic change in sensitivity (factor of ~3) if mechanical damage occurs sufficient to cause a leak (see Tech Note #38). A common *apparent* source of drift can be a dirty lens, since the optical signal will degrade in direct proportion to the lens area blocked. Employing the built-in air purge feature of most IRt/c's prevents this problem.

### IRt/c Self-Test

A powerful method of checking an IRt/c installation is to test the response against an expected range on *every measurement cycle*. This option is highly recommended if there is computing power available, since it takes full advantage of the fact that any failure of the IRt/c will result in a dramatic change in sensitivity; and thus failure to respond to normal thermal processes will be easy to detect. Refer to Tech Note #39 for further details.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## SELECTING HI E OR LO E BASED ON EMISSIVITY TABLE

Metals	Emissivity Range	IRT/c Selection
Aluminum		
highly polished plate, pure	0.04 - 0.06	Lo E
oxidized at 1110 F (600 C)	0.11 - 0.19	Lo E
commercial sheet	0.09	Lo E
Brass		
highly polished plate, pure	0.1	Lo E
oxidized at 1110 F (600 C)	0.61 - 0.59	Lo E
Chromium, polished	0.08 - 0.36	Lo E
Copper		
polished	0.05	Lo E
heated at 1110 F (600 C)	0.57	Lo E
Gold, pure, highly polished	0.02 - 0.03	Lo E
Iron and steel (excluding stainless)		
iron, polished	0.14 - 0.38	Lo E
cast iron, polished	0.21	Lo E
cast iron, oxidized at 1100 F (600 C)	0.64 - 0.78	Lo E
wrought iron, polished	0.28	Lo E
wrought iron, dull oxidized	0.94	Hi E
iron plate, rusted	0.69	Lo E
steel, polished	0.07	Lo E
steel, oxidized at 1110 F (600 C)	0.79	Lo E
rolled sheet steel	0.66	Lo E
steel plate, rough	0.94 - 0.97	Hi E
Lead, gray oxidized	0.28	Lo E
Mercury	0.09 - 0.12	Lo E
Molybdenum filament	0.10 - 0.20	Lo E
Nickel		
polished	0.07	Lo E
plate, oxidized at 1110 F (600 F)	0.37 - 0.48	Lo E
Platinum		
polished plate, pure	0.05 - 0.10	Lo E
wire	0.07 - 0.18	Lo E
Silver, pure, polished	0.02 - 0.03	Lo E
Stainless steel		
polished	0.07	Lo E
type 310, oxidized from furnace service	0.90 - 0.97	Hi E
Tin, bright	0.06	Lo E
Tungsten filament, aged	0.03 - 0.35	Lo E
Zinc		
commercial pure, polished	0.05	Lo E
galvanized sheet	0.21	Lo E

Nonmetals	Emissivity Range	IRT/c Selection
Asbestos	0.93 - 0.94	Hi E
Brick		
red, rough	0.93	Hi E
fire clay	0.75	Hi E
Carbon		
filament	0.53	Hi E
lampblack, rough deposit	0.78 - 0.84	Hi E
Glass (Pyrex, lead, soda)	0.85 - 0.95	Hi E
Marble, light gray, polished	0.93	Hi E
Paints, lacquers, and varnishes		
white enamel	0.91	Hi E
flat black lacquer	0.96 - 0.98	Hi E
aluminum paints	0.27 - 0.67	Lo E
oil paints, 16 colors	0.92 - 0.96	Hi E
Porcelain, glazed	0.92	Hi E
Quartz, opaque	0.68 - 0.92	Hi E
Water	0.95 - 0.96	Hi E
Wood, oak, planed	0.90	Hi E

Note: Lower emissivity surfaces require more stable conditions than high emissivity surfaces for accurate temperature control. These tables include approximate values, which can vary significantly with surface condition. For best results, install an IRT/c and test. Emissivity data from *Heat, Mass, and Momentum Transfer* by Rohsenow and Choi (Prentice-Hall, 1961).

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## CALIBRATING FOR WIDE LINEAR RANGE WITH ADJUSTABLE MODELS TO STANDARD THERMOCOUPLE INPUTS

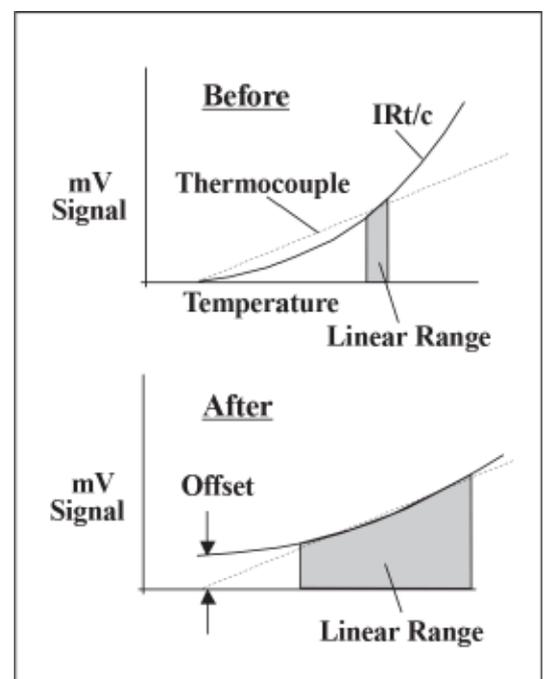
All IRt/c models with the “A” designator (example: IRt/c.10A-K-Lo E) are equipped with a calibration adjustment feature that makes it possible to precisely calibrate the IRt/c to the temperature control requirements. However, for installations in which monitoring of temperature rather than control is desired, a wide linear range is convenient. Accordingly, the procedure described below can be used to produce a very wide linear range when using controllers, meters, PLCs, transmitters, etc. for temperature monitoring. The only requirement is that an OFFSET, ZERO, LO CAL, or equivalent adjustment be available to offset the reading.

*Example:* Apply a Lo E model to monitor steel at 1800°F (980°C). Cover the IRt/c with aluminum foil such that it cannot see the target, then set the readout device offset so that the display reads approximately 75% of target temperature:  $.75 \times 1800 = 1350^\circ\text{F}$  ( $.75 \times 980 = 735^\circ\text{C}$ ). Remove foil, point IRt/c at intended target, and adjust the calibration screw on the back of the IRt/c until the readout display reads the correct temperature, or within a few percent of the correct temperature. Fine tune the reading at the readout device as required. The calibration is complete, and the linear range over which the reading will be within 2% of actual is approximately  $1800^\circ\text{F} \pm 250^\circ\text{F}$  ( $980^\circ\text{C} \pm 140^\circ\text{C}$ ).

The method involves simply “rotating” the output curve of the IRt/c to better fit the linear thermocouple requirement over a wider temperature range, as shown in the graph. The steps are as follows:

1. **Set the readout device to the offset value shown in Table I.**
2. **Adjust the calibration screw on the IRt/c to the correct target temperature.**
3. **Calibration complete.**

Models: IRt/c.xxxA (Applies to all Adjustable Models)	Target Temperature °F (°C)	Optimum Offset (% of Target Temperature)	Approximate 2% Linear Range (from Target Temperature), °F (°C)
Lo E	800 (425)	~ 75%	± 100 (60)
	1000 (540)	~ 75%	± 150 (80)
	1600 (870)	~ 75%	± 200 (110)
	2000 (1100)	~ 75%	± 300 (170)
	2800 (1540)	~ 75%	± 400 (220)
	3600 (2000)	~ 75%	± 400 (220)
Hi E	200 (90)	~ 60%	± 25 (15)
	500 (260)	~ 60%	± 50 (30)
	1000 (540)	~ 60%	± 200 (110)
	1500 (820)	~ 60%	± 500 (280)
	2100 (1150)	~ 60%	± 800 (330)
	3000 (1650)	~ 50%	± 800 (440)



Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## PRINTING PRESS APPLICATIONS

IRt/c infrared thermocouples are revolutionizing the printing industry because their small size allows them to be mounted in the tight spaces typical of both web and sheet fed presses, and their low cost allows economical installation and control on even the smallest of presses. Additionally, since many presses are already equipped with thermocouple controllers and PLC thermocouple inputs, the IRt/c is a simple installation.

Applications include not only printing onto paper, but also cloth, plastic, and any other printing web application.

### Location 1: INK ROLLERS, PLATENS CONVENTIONAL PRESSES (water/ink)

On conventional presses (water/ink processes), the quality of the process is very dependent on the difference in surface tension between water and ink, and this surface tension is highly temperature sensitive. When presses operate, heat is generated due to friction in the pressing area. Heat build-up can significantly alter the surface tension of the water/ink resulting in a deterioration in print quality.

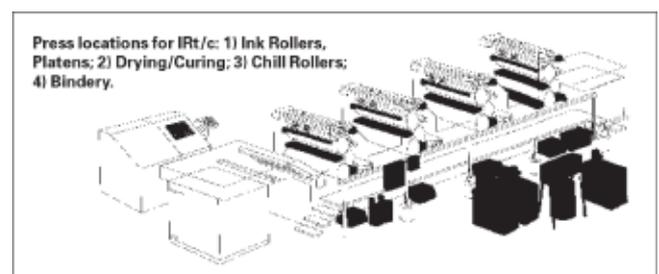
IRt/c sensors easily monitor any roll surface temperatures within presses. Connected to a display with alarm signal, they can alert the operator of deteriorating temperature conditions before poor quality impressions are made. Connected to a temperature controller, PLC or computer, the IRt/c quickly signals an installed press temperature control system to provide cooling to the press area, or signal cooling systems to provide cooling to the ink and/or water supplies to maintain proper surface tension.

Temperature is also important when there is risk of thin wall cylindrical platen(s) becoming loose or sloppy due to thermal expansion (or contraction). On large diameter metal cylinders, a small temperature change can result in a significant change in the circumference of the roll, and thus affect the proper "fit." By measuring the surface temperature of the roll, the proper fit of the plate can be maintained by either (1) cooling the area or (2) slowing down the press so friction heat decreases to a low enough level to maintain print quality.

### WATERLESS INK PRESSES and CONVERSIONS

"Waterless" ink technology involves the use of special inks to eliminate the need for the water/ink combination. This technology has significant cost and performance advantages for the printer in elimination of waste treatment, and higher quality product. The waterless ink technology can be applied to virtually all types (web and sheet fed) and sizes of presses from large multi-color presses down to the small presses.

Conventional presses can be converted to use these inks by providing a method to control the surface temperature of the rolls where the ink is applied to the platens. This is typically done by using hollow rolls and supplying chilled water



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## PRINTING PRESS APPLICATIONS

through the rolls to keep the surface at a desired temperature. The IRt/c is a key component of the package required to convert a press, since waterless inks are very temperature sensitive and must be applied with strict ink and surface temperature control.

The surface temperatures are easily monitored by an IRt/c. The output signal is sent to a discrete temperature controller, PLC, or custom computer control system to regulate the refrigerated circulators providing cooling water.

The IRt/c sensing system is precise enough to also allow manipulation of color characteristics for waterless printing. For example, running a particular waterless ink at different temperature extremes allows for choosing between brilliant or softer colors.

### Location 2: DRYING/CURING

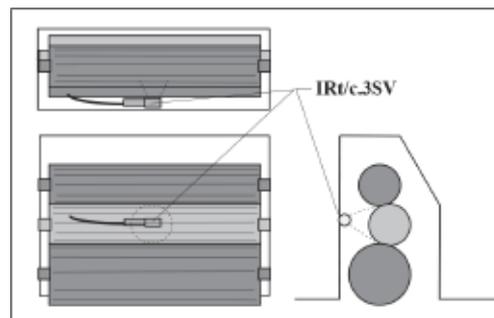
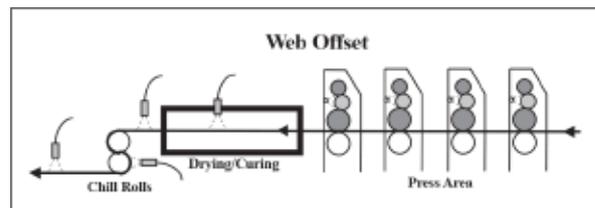
After ink is applied to the paper (or cloth, plastic, etc.) in the printing area, the web (or sheet) typically travels through a drying/curing process. IRt/c sensors are used where they (1) “look” directly at the web or sheet while it is inside the dryer or (2) at the web just as it exits the dryer. Either method can be used to control drying temperature or UV curing.

For web presses, a much more accurate way is also possible. By using multiple IRt/c sensors along the web while in the dryer, the actual “Dry-Out” point can be located and controlled within the dryer. See Tech Note #67.

### Location 3: CHILL ROLLERS

For web offset printing, as the web leaves the

dryer, it runs through a chill roller(s) to cool the web so that the paper (cloth, plastic, etc.) can be cut and stacked, or rolled, without the material sticking together.



Small size fits into tight press area. The model IRt/c.3SV is recommended due to its convenient side view and extraordinary ability to keep itself clean in the harshest ink spray environments.

By using IRt/c sensors to measure the surface temperature of the web at the point where it is being chilled, the IRt/c signal can control the amount of chilling. This control will eliminate “over chilling” (condensation problems due to high ambient humidity common in press rooms) and “underchilling” problems, automatically.

### Location 4: BINDERY

Hot melt glue guns and applicators periodically “plug up” or run out of glue. Properly used IRt/c sensors or an Exergen AAM system can instantly alert machine operators prior to products being glued improperly. See Tech Note #18 and/or the section on the Exergen AAM Series (Applied Adhesive Monitors) in *The IRt/c Handbook*.

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
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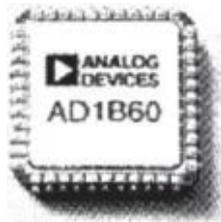
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### OEM LOW COST INTERFACE

Designing the advantages of infrared temperature sensing into your OEM equipment is now easier and much, much lower cost than it has ever been. The IRt/c product line can be conveniently interfaced with many standard thermocouple devices at the component level for custom board design. For example, Analog Devices, Inc. manufactures numerous low-cost thermocouple input components that work well with the IRt/c, such as the following two models.



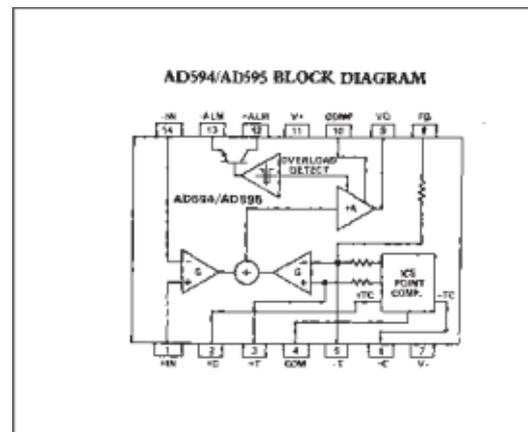
#### Model AD1B60 Intelligent Digitizing Signal Conditioner for the IRt/c

- Complete IRt/c sensor-to-digital signal conditioning and data conversion
- Directly connect up to 4 IRt/c's per chip
- Cold junction compensation built in
- Software switchable open thermocouple detection
- Allows IRt/c linearization over complete temperature sensing range
- Digital output
- Under \$50 in 100 piece quantities

#### Model AD594 (type J), AD595 (type K) IRt/c Amplifier with CJC

- Direct connection with IRt/c sensors
- Built-in cold junction compensation
- 10 mV/deg C output (0 to 10 V output)
- Under \$7 per unit in 100 piece quantities (AD594AQ)

For more information about component level IRt/c design, or assistance in board level design for interface with the IRt/c product line, please contact Exergen directly. Contact Analog Devices directly for information on these and other models: Analog Devices, Inc., One Technology Way, PO Box 9106, Norwood, MA 02062 (Phone: 800-262-5643, 617-329-4700)



#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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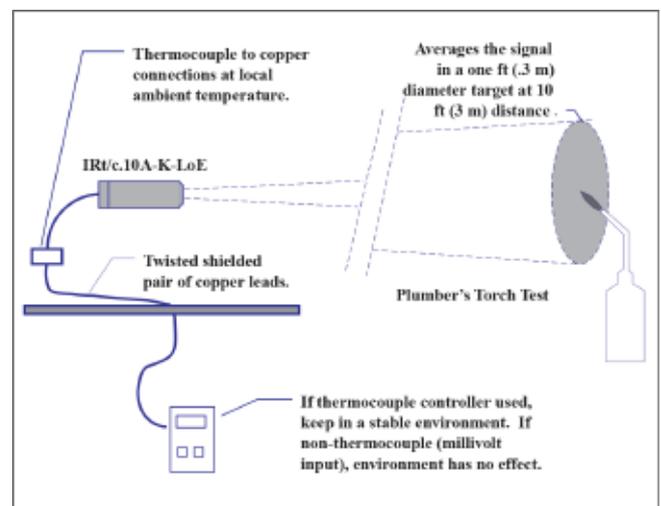
## FLAME DETECTION

Many industrial processes involve highly flammable materials and are a constant potential hazard. As a result, for safety and loss prevention, flame detection devices are specified to alert or shut down the process in the event of a fire. The IRT/c, alone or in conjunction with other devices can provide a good solution. *Since the IRT/c is intrinsically safe, it can be mounted in the hazardous area when used with the appropriate barrier (see Tech Note #10), thus making it suitable for locations not possible with other flame detection devices.*

The recommended model is the IRT/c.10A-K-LoE. With spectral sensitivity of 0.1 to 5 $\mu$ m, this model will measure the short wave radiation created by a flame, while filtering out the changes in ambient target temperature.

It is strongly recommended that the system be tested for the desired response and control set-up. For example, the ability of the system to

detect a plumber's propane torch flame at 10 ft (3 m) can be tested, resulting in an indicated temperature rise of the order of 50°F (30°C). The monitor/controller can be set appropriately, and all flames that are larger or more luminous than the torch will alarm. Customary testing, redundancy, etc. should be observed, as required for the application.



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5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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TN-073-1-EN

## CALIBRATION TESTING PROCEDURES

For many OEM and general temperature control applications it is sometimes desirable to test sensors before being placed into service, or to conduct routine checking while they are in service. Accordingly, recommended procedures are presented to allow easy checking with commonly available equipment. However, prior to testing, it is important to understand what indications an actual IRt/c failure might cause.

### Factory Calibration

The pre-calibrated IRt/c sensors (models without the "A" suffix that indicates user adjustability) are calibrated under conditions that optimize performance in actual use: target emissivity = 0.9 (a good general value for non-metals), and ambient temperature elevated to approximately 1/4 of the elevation of target temperature above room temperature (accurately simulates the effect of reflected energy). Since this type of test would require specialized devices, the procedures outlined have test standards that are slightly different, since they use blackbodies, or test surfaces/ambients whose properties vary to some extent.

### What to Look For When Testing

*Open Circuit:* An open circuit (resistance > 15 KW) indicates a broken wire, and open circuit detection systems will perform normally to detect it.

*No Response to Thermal Radiation:* Sensor reads ambient temperature accurately, but does not respond when pointed at a hot target. This fault is similar to a short circuit with an ordinary thermocouple, in that the circuit is complete, but is measuring the ambient temperature at the short, and not at the measuring junction. For the

IRt/c, this fault is the same as if the sensor were covered with foil, thus blinding it.

*Sensor Reads Low:* There are only two ways an IRt/c can shift after factory calibration: the lens becomes dirty; or the sensor loses its hermetically sealed Xenon gas.

- If the lens becomes dirty, the signal loss is directly proportional to the amount of dirt on the lens. Infrared energy is a form of light and therefore the situation is similar to ordinary window glass becoming dirty and blocking out sunshine. If considerably dirty before cleaning, the window will let more light through after cleaning, thus increasing the signal. If it was already clean, additional cleaning doesn't let any more light through, and the signal remains the same.
- If the durable IRt/c hermetic seal somehow fails, the Xenon gas will immediately escape. For even a small leak, the Xenon will escape quickly, within seconds. It is a "fail-safe" design. The Xenon gas will not leak gradually. If this occurs, the mV output sensitivity will immediately drop to approximately 50% or less of normal signal. For example, if a type K-180F/90C sensor looks at a high emissivity 212°F (100°C) surface and reads correctly on a thermocouple meter, or gives you 3.3 mV on a DVM, then the sensor is within specifications. If the signal is only approximately 1.7 mV, or reads in the neighborhood of 140°F (60°C) with a thermocouple meter (and the lens is clean), the fail-safe gas seal has been compromised.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## CALIBRATION TESTING PROCEDURES

The fail-safe feature is quite important, since a breach of the sensor gas seal would permit contaminants to enter the sensitive detection system and cause unpredictable drift.

### Conducting Pass/Fail Testing

For your convenience, 212°F (100°C) is recommended as a test target temperature, even though it might be outside the 2% linear range of the IRT/c being tested, since the strict repeatability of the IRT/c permits it to be tested at any temperature within its specified range. A digital volt meter (DVM) with at least 0.1 mV resolution is recommended instead of a thermocouple readout, since the DVM will be faster, and will not generate a leakage current that can cause readings to vary from sensor to sensor due to resistance variations. An electronic ice point reference is desirable, but not necessary for pass/fail testing.

### Equipment

Best: Accurate Blackbody at 212°F (100°C).

Good Alternative: Pot of boiling water.

### Procedure

Make sure the sensor window is clean. If it is not, then clean with a mild solvent such as alcohol and wipe dry. Clip the DVM test leads to the IRT/c and

point at the target, bringing the IRT/c as close as possible to be sure that the IRT/c sees only the target, taking care that the clip lead connections (the effective cold junctions) remain at room temperature. Immediately read the DVM for the correct reading. For details of test set-up for the boiling water, see *Tech Note #75*.

### In-Service Inspection Methods

Measure the surface temperature of the target (with the target at normal operating temperature) with a Microscanner D-Series infrared thermometer. Make note of the temperature. Check the IRT/c display device and make sure the reading reproduces the original value that was obtained at installation calibration. If the IRT/c reading is incorrect, clean the lens with a cotton swab and alcohol (or similar cleaner) and recheck the display. If the reading is significantly lower, the fail-safe Xenon charge has escaped, indicating that the sensor should be replaced.

### Calibration Values

For specifications for the mV signals that should be obtained for the test conditions obtained above, for any given model IRT/c, please fill in the data below, and mail to Exergen: [info@exergenglobal.com](mailto:info@exergenglobal.com). The specifications will be return mailed to you.

Name _____
Company _____
Phone _____ Mail _____
IRT/c Model _____
Target Material and Temperature _____

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

[office@exergenglobal.com](mailto:office@exergenglobal.com)  
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## CHECKING CALIBRATION OF IRT/C OR D-SERIES WITH BOILING WATER

Exergen's Microscanner D-Series are designed as highly accurate and reliable temperature references as well as fast easy-to-use infrared scanners. Since all components making up a D-Series are drift-free *there is never a requirement to calibrate the instrument once it leaves the factory*, and no calibration means is provided on the instrument (except certain high temperature models). Accordingly, if the D-Series calibration has shifted from its factory setting, it requires repair since a component has failed. Similarly, non-adjustable IRT/c models are factory calibrated for life, and if they do not reproduce their calibration, they should be considered failed.

Unless you have technical experience with and have a laboratory infrared "blackbody," this calibration checking technique is recommended by the factory. Boiling water is a physical constant, easily used, and requires no technical set-up of elaborate equipment or checking of traceable standards.

### Boiling Point of Water

The open boiling point of (reasonably pure) water is affected by only one factor: barometric pressure. The standard 212°F (100°C) boiling point is for a barometric pressure of 30.00 inches of Hg (mercury), or in metric terms, 1 Bar (1000 millibars). This is "normal" at sea level. Barometric pressure can be affected by elevation above sea level, and by weather conditions.

**Elevation Correction:** The boiling point of water is lowered by approximately 2°F (1°C) for every 1000 ft (300 m) above sea level with no unusual weather conditions. If your weather is "normal" and you are not using the barometric pressure method,

you can simply use the following corrections.

Elevation	Boiling Temperature	
Sea level	212°F	100°C
1000 ft (300 meters)	210	99
2000 ft (600m)	208	98
3000 ft (900 m)	206	97
4000 ft (1200 m)	204	96
5000 ft (1500 m)	202	95

**Weather Conditions:** If you use this method, you do not need to put in a correction for elevation above sea level. It will be automatic by using the current barometric pressure dominating your area. Barometric pressure can be much lower during especially stormy conditions (low pressure areas), and much higher during extremely cool and dry conditions (high pressure areas). Consult the weather reports on TV, in your local newspaper, or call a weather service office for current barometric conditions in your area. Barometric pressure correction factors:

- 2°F / inch Hg (1°C / 30 millibars) change from 30.00 in. Hg (1 Bar)
- Add to the boiling temperature for higher than normal pressure.
- Subtract for lower than normal pressures.

**Note:** Always clean the sensor lens prior to calibration testing. A cotton swab with a mild cleaner such as alcohol works well.

### Checking Calibration

**Required Equipment:**

- Metal pot with cover, minimum 4" (10 cm) tall.
  - Solid paint marker or thin opaque tape.
1. Use a metal pot, with cover, for boiling water.
  2. Fill the pot at least 1/2 fill with water.

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
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Tel: +1 617 649 6322  
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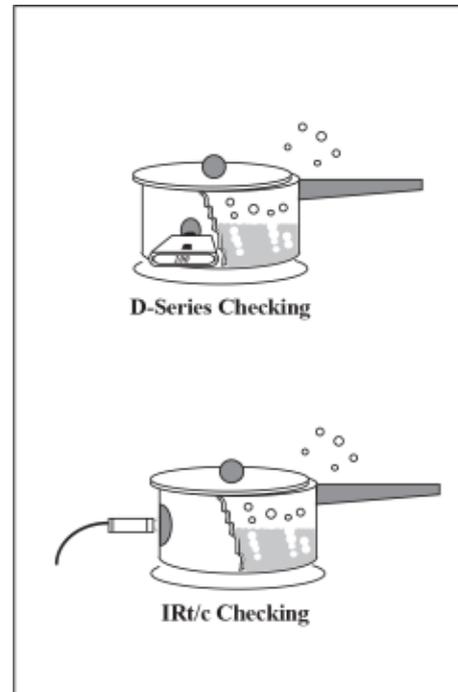
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## CHECKING CALIBRATION OF IRT/C OR D-SERIES WITH BOILING WATER

- Use the solid paint marker supplied with your DSeries, or a piece of opaque (non-see through) tape, or a thin electrical tape, to put a measuring spot at least 1in. (25 mm) in diameter on the outside surface of the pot. Make sure the measuring spot is at, or slightly below, the water level.
- Bring the water to a RAPID boil. Tilt the cover SLIGHTLY so that the water does not boil over. The condensing steam on the inside of the pot along with the rapidly boiling water will force the outside surfaces of the pot to be within a fraction of a degree of the temperature of the boiling water. (The temperature drop through the wall thickness of the average pot for boiling water is very small and can be ignored.)
- Briefly touch the nosepiece flat onto the black mark and note the temperature reading. For an IRt/c, bring the sensor as close as possible without touching.



The reading should be within  $\pm 2\%$  of the actual boiling point (for example  $\pm 2^\circ\text{C}$  for  $100^\circ\text{C}$  boiling point). If the reading is not within these limits, the instrument has a failed component and should be returned to Exergen for repair. Please call for an RMA number prior to shipment. For the IRt/c refer to *Tech Note #73* for specifications.

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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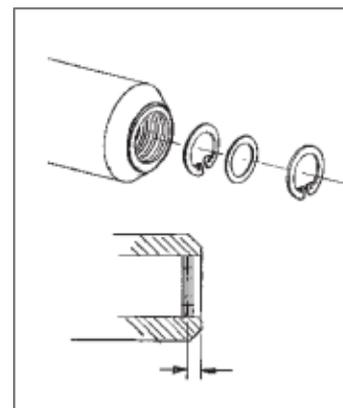
## INCREASING TEMPERATURE RANGE, IMPROVING ADJUSTMENT SENSITIVITY, AND REDUCING THE MINIMUM SPOT SIZE WITH THE APERTURE KIT

For all IRt/c adjustable models an Aperture Kit is provided to offer the ability to extend the target temperature range, improve the adjustment sensitivity of the adjustment potentiometer, and reduce the minimum spot size to as small as 1/4 in. (6 mm).

The kit consists of one 1/2 in. (13 mm) and one 1/4 in. (6 mm) stainless steel apertures and two retaining rings. The apertures and retainers are installed as shown, taking care that the retainers sit and lock between the internal threads. The precise axial location is not critical. Install only one aperture, based on the requirements of your application.

The function of the aperture is to reduce the quantity of radiated energy entering the IRt/c optical system, thus increasing the rated maximum target temperature before burn-out. In addition, since less signal is produced at a given temperature, the adjustment will be less “tweaky” when calibrating the IRt/c installation. The table below

lists the range of temperatures for each model recommended with and without the apertures. These recommendations are approximate, since the actual signal level will depend on the actual target characteristics (emissivity, etc.). If there is insufficient adjustment range available with the small aperture installed, simply replace it with the large one, or remove it. If the adjustment is too sensitive, install an aperture. Use the table below to set up your installation initially, to make sure that the IRt/c is not damaged by excessive radiation, then adjust up or down as required to



meet your calibration requirements. The ranges below assume that you are using the technique described in Tech Note #70 or an equivalent calibration method.

Model	No Aperture	1/2" (13mm) Aperture	1/4" (6mm) Aperture
IRt/c.10A- ** - HiE IRt/c.xxxACF- ** - HiE IRt/c.xxxAMF - ** -HiE	to 700°F to 370°C	500 to 1500°F 260 to 820°C	1300 to 2500°F 700 to 1370°C
IRt/c.10A- ** - LoE IRt/c.xxxACF- ** - LoE IRt/c.xxxAMF - ** -LoE	to 1400°F to 760°C	1200 to 1800°F 650 to 980°C	1600 to 2500°F 870 to 1370°C
IRt/c.20A- ** - HiE IRt/c.xxxALF - ** -HiE	to 1200°F to 650°C	1000 to 2500°F 540 to 1370°C	2300 to 3000°F 1260 to 1650°C
IRt/c.20A- ** -LoE IRt/c.xxxALF - ** -LoE	to 1800°F to 980°C	1000 to 2500°F 540 to 1100°C	2500 to 3500°F 1370 to 1930°C
IRt/c.100A- RS -HiE IRt/c.xxxAXLF - RS -HiE	to 2500°F to 1370°C	2000 to 4000°F 1100 to 2200°C	3500 to 5000°F 1930 to 2760°C
IRt/c.100A- RS -LoE IRt/c.xxxAXLF - RS -LoE	to 3500°F to 1930°C	2500 to 4500°F 1930 to 2500°C	4000 to 5000°F 2200 to 2760°C

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 Pastoor Clercxstraat 26  
 5465 RH Veghel  
 Tel: +31(0) 413 37 65 99  
 Fax: +31(0) 413 37 93 10

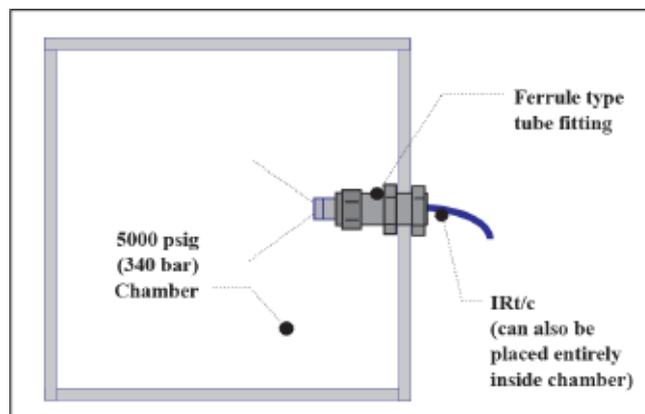
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## IRT/C TESTED AT 5000 PSIG (340 BAR) PRESSURE

For some types of processes, it is necessary to monitor temperatures of materials subjected to high gas pressures. Conventional contact devices are difficult to employ under these conditions and conventional IR devices are unsuitable because their optical and electronic components are unable to withstand high pressures.

With its elegant simplicity and solid construction, the IRT/c provides a solution. It has been tested at pressures up to 5000 psig (340 bar). A simple ferrule type tubing fitting may be used to provide a pressure-tight seal around the IRT/c housing. If using an IRT/c model with a lensed optical system (IRT/c.5; IRT/c.10; etc.), pierce the lens at its edge with a needle to provide pressure equalization.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## IRT/C TESTED FOR VACUUM AND MICROWAVE COMPATIBILITY

Tests for compatibility performed by customers contribute greatly to our understanding of how IRT/c's perform in some of the unusual environments where non-contact temperature measurements are required. Exergen has a policy of providing sensors free of charge to any laboratory for test purposes, in return for a copy of test results. This series of tests was performed by a customer who required the performance, and had the facility to test the IRT/c. The test was conducted in a 4 ft. by 4 ft. (1.2 m by 1.2 m) chamber in the following sequence:

### First Test

1. Vacuum exposure (15 minutes at 40 Torr)
2. Microwave Exposure (5 minutes, 3 KW at 2450 MHz)
3. Chamber load (15 pounds H2O)

### Second Test

1. Vacuum exposure (10 minutes)
2. Microwave Exposure (30 seconds, 3 KW at 2450 MHz)
3. Microwave Exposure (10 seconds, 3 KW at 2450 MHz)
4. Chamber load (1 pint H2O)

The IRT/c showed no ill effects and operated flawlessly when checked after the test sequence.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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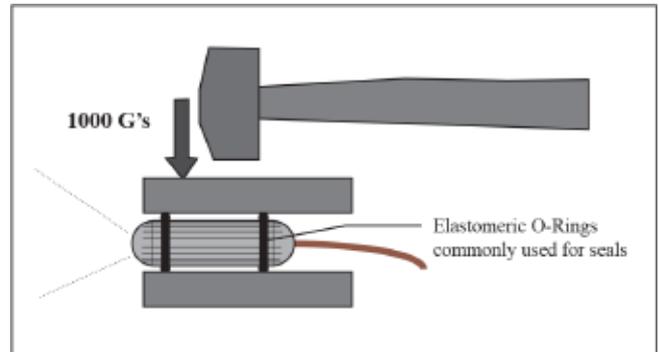
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TN-078-1-EN

## IRT/C'S WITHSTAND 1000G SHOCK

With simple "O-ring" mechanical supports, IRT/c's can withstand up to 1000 g shock without damage, and without shift in calibration. Such robustness makes them well suited to heavy duty applications where high levels of shock and vibration are common.

More modest forces of 10 g can be withstood on a continuous basis, but fatigue of the cable can be a problem. Mechanical support, coiling, or other appropriate cable management is recommended.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
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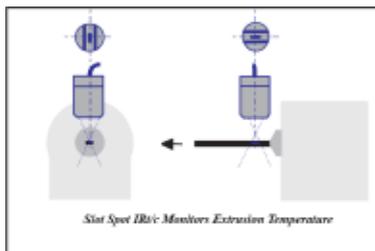
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## UNIQUE "SLOT SPOT" IRT/C'S MEASURE SMALL RECTANGULAR SPOTS

**IRt/c.2/15ACF-HiE for Non-Metal Targets, 0 to 2500 °F (-18 to 1370°C)**

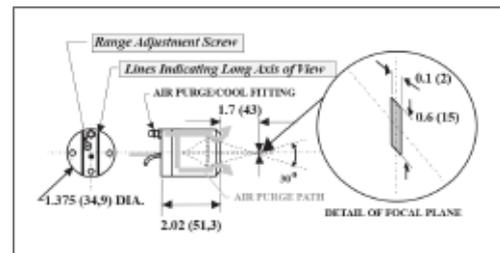
**IRt/c.2/15ACF-LoE for Metal Targets, 500 to 2500 °F (260 to 1370°C)**

Specifically designed for measuring temperatures of very small objects, the unique Slot Spot IRt/c makes it possible to monitor and control such difficult targets as small extrusions, yarn, thread, wire, glass fiber, and others.



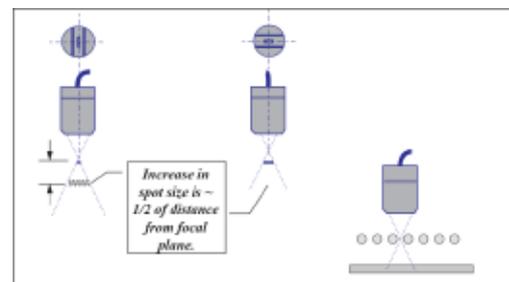
To use, follow all of the standard setup and calibration instructions supplied for all of the adjustable IRt/c models. Use the lines scribed on the back of the sensor to align the field-of-view on the target. The alignment can be fine-tuned by moving the sensor (closer, farther, rotate slightly) until a maximum signal is obtained. For convenience a handheld t/c meter or millivolt meter can be used. The sensor is positioned optimally when the maximum signal is obtained on the meter.

The Aperture Kit provided with the sensor may be used to extend the temperature range, or improve the resolution of adjustment. The wide linear



range calibration technique specified in Tech Note #70 is recommended. The table shows the temperature limits for each aperture.

For monitoring targets which are outside the focal plane, the field-of-view can be approximated by intersecting planes in both views with an included angle of approximately 30°. This results in one-half of the distance from the focal plane being added to each dimension. For example, if the target is 1" (25 mm) from the focal plane, 1/2" (13) would be added to both dimensions, resulting in a spot size 1.1" (28) long by 0.6" (15) wide. This feature makes the Slot Spot particularly well suited to monitoring temperature of a target through any opening that is slot-shaped.



Aperture	None	1/2" (13 mm)	1/4" (6 mm)
IRt/c.2/15ACF-HiE (Non-Metal Targets)	0 to 700°F (-18 to 370°C)	500 to 1500°F (260 to 820°C)	1300 to 2500°F (700 to 1370°C)
IRt/c.2/15ACF-LoE (Metal Targets)	500 to 1400°F (260 to 760°C)	1200 to 1800°F (650 to 980°C)	1600 to 2500°F (870 to 1370°C)

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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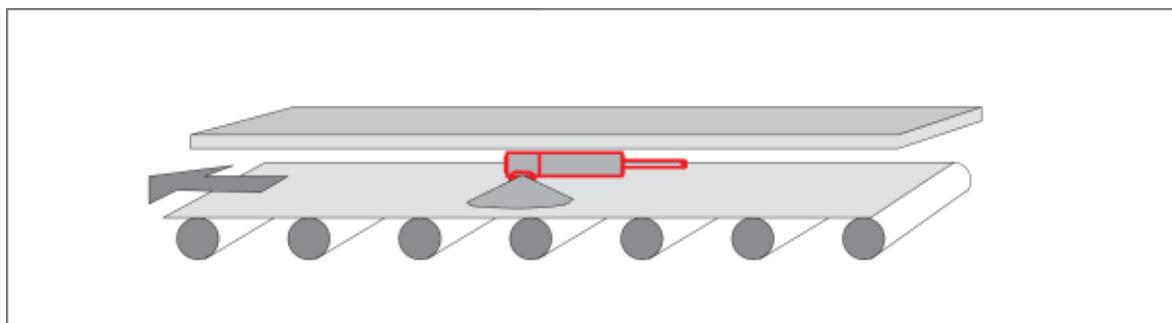
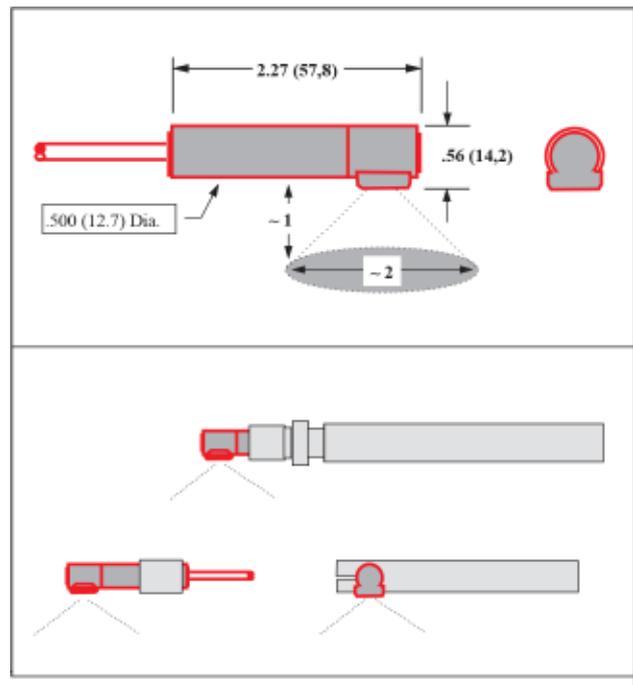
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## SIDE VIEW MODEL DESIGNED FOR MONITORING WEB PROCESSES

### IRt/c.SV

In heating, drying, coating, cooling, or any other thermal processing of webs of paper, plastic, metals, textiles, film, etc., often there is very little space available for a sensor to monitor web temperature. In a space as small as 0.56 in. (14.2 mm) the IRt/c.SV Infrared Thermocouple can be installed to monitor temperature of the moving web, and reliably control the process to maximize quality and throughput of product.

The IRt/c.SV has all of the same specifications as the standard IRt/c, including no power requirement, rugged stainless steel hermetically sealed construction, intrinsically safe, full electrical shielding, ~0.1 second response time, and ability to operate uncooled in environments up to 212°F (100°C). It is available in J,K,T,E thermocouple types, with linear range selections the same as the standard IRt/c. The solid filled 1/2 in. (12.7 mm) tubular housing can be held securely with convenient tube fittings or standard clamps to mount the sensor over the target area.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## GROUNDING AND SHIELDING FOR ELECTROSTATIC PROTECTION AND NOISE SUPPRESSION

Applies to All Models With Stainless Steel Housing  
All IRt/c models with stainless steel housing are built with complete electrical shielding of both the housing and cable, with the measuring elements electrically isolated from the housing (as in a conventional ungrounded thermocouple). By adhering to standard good practice in grounding and shielding techniques, IRt/c's can provide outstanding performance in the most severe electrical environments commonly found in production processes.

**Q. When is attention to grounding and shielding required?**

**A.** If the IRt/c must operate in extreme environments, employ long t/c cable runs, the measuring system is utilizing the high speed capability of the IRt/c, or if the process can generate high static electricity fields. For most installations, the built-in noise rejection characteristics of the IRt/c are sufficient to insure good performance, especially if the readout device is heavily filtered with a long input time constant.

**Q. Can I operate ungrounded?**

**A.** Yes, but it is not recommended, especially in applications where the process can generate high static electricity fields. Examples are web processes of all types, including printing, laminating, film drying, etc. Without either the housing or shield grounded to drain away the charge, a static charge can build in the housing, which may eventually discharge through the IRt/c sensing elements, and can cause damage to the sensor.

**Q. How do I use the shield correctly?**

**A.** The most important rule is to be sure the shield is grounded at only one point, preferably at the

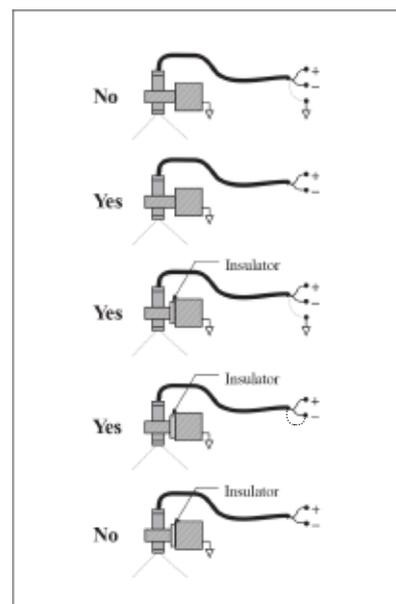
signal input ground. Keep in mind that the housing is connected to the cable shield, and if the housing is electrically in contact with machinery at the mounting point, that point will be a ground, and the shield wire should not be connected at the instrument end. For best possible performance, electrically isolate the IRt/c at the mounting point and ground the shield at a suitable ground on the readout instrument.

**Q. Can I ground the shield to the negative (red) thermocouple lead instead of to a chassis ground?**

**A.** Yes, but test both alternatives in your application and use the one that gives the cleanest signal. Be sure that the housing is electrically isolated, otherwise ground loop currents may cause errors.

**Q. Should the extension cable be shielded?**

**A.** As indicated above, if the installation requires high speed performance, twisted shielded extension cable and connectors with ground straps should be used throughout.



Aluminum foil is a suitable material to complete a shield if there are gaps in the shield coverage.

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
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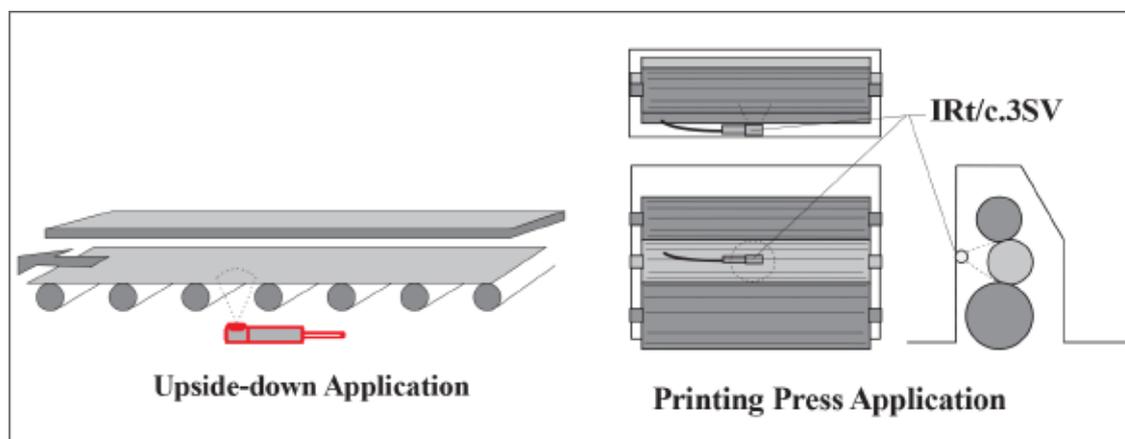
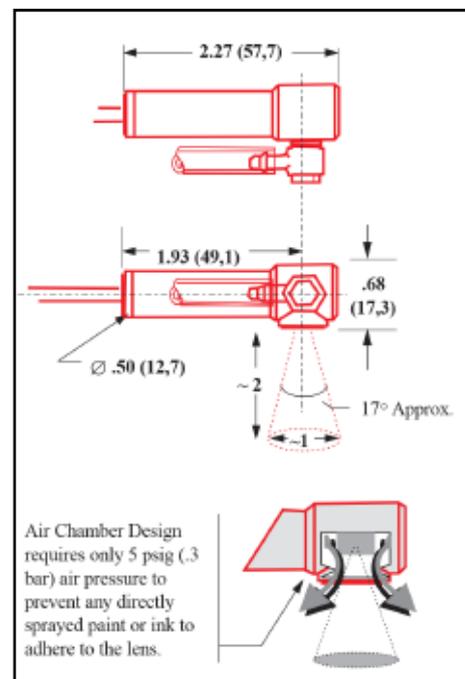
## SIDE VIEW MODEL DESIGNED FOR MONITORING TEMPERATURE IN DIRTY OR VAPOR-FILLED ENVIRONMENTS

### IRt/c.3SV

In heating, drying, coating, cooling, or any other thermal processing of webs of paper, plastic, metals, textiles, film, etc., often there is very little space available for a sensor to monitor web temperature, and the harsh environment requires a highly efficient air purge design to prevent fouling of the IR lens. In a space as small as 0.7 in. (18 mm), and in areas where ink or paint are being applied, the IRt/c.3SV Infrared Thermocouple can reliably control the process to maximize quality and throughput of product.

The IRt/c.3SV has all of the same specifications as the standard IRt/c, including no power requirement, rugged stainless steel hermetically sealed construction, intrinsically safe, full electrical shielding, ~0.1 second response time, and ability to operate uncooled in environments up to 212°F (100°C). It is available in J, K, T, E thermocouple types, with linear range selections the same as the standard IRt/c. The solid filled 1/2 in. (12.7 mm) tubular housing can be held securely with convenient tube fittings or standard clamps to mount the sensor over the target area.

Ideal applications are offset printing, where the presence of inks and physically tight locations make the IRt/c.3SV the sensor of choice. Targets that must be monitored “upside down” are also ideal applications, since the narrow field of view and air purge will prevent debris from blocking the lens. Only 5 psig (.3 bar), which consumes less than 1 SCFM (.03 m<sup>3</sup>/min) is required for direct paint spray environments.



Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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## USING THE IRT/C.01 IN A HIGH ELECTRICAL NOISE AREA

### Applies to All Models With ABS Plastic Housing

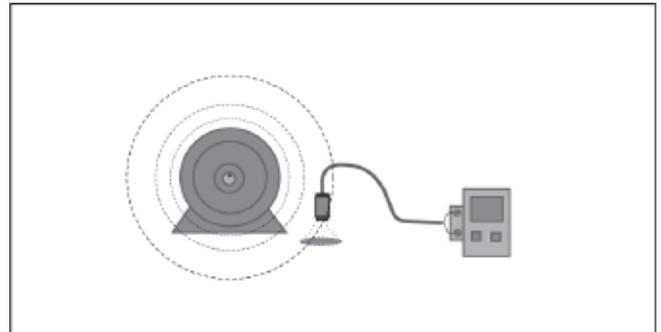
In applications where the low cost of the IRT/c.01 is important, and the other performance requirements are met by the sensor, there are occasional concerns that electrical noise in the environment can affect the readings. By employing one or more standard techniques, IRT/c.01's can provide outstanding performance in the most severe electrical environments commonly found in machinery.

#### 1. Employ Filtering in the Readout Device.

If the readout device is heavily filtered with a long time constant, there is normally never a problem with noise. Response time constants in the range of 1 second are in common use in temperature controllers, and are usually more than enough to prevent any significant noise interference.

#### 2. Add a Shield to either the IRT/c.01 or the EMI Source.

With aluminum foil, conduit, etc. the IRT/c.01 can be shielded from the source of electromagnetic radiation directly. Be sure to properly ground the shield. Refer to Tech Note #82 for recommendations.



#### 3. Consider Substituting a Fully-Shielded IRT/c Model.

If none of the above options provide the necessary performance, especially for high speed applications, select one of the fully shielded stainless steel IRT/c models for the application.

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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## IRT/C.01 SELECTION AND APPLICATION HINTS FOR OEMS

To assist you in specifying an IRT/c.01 model for your application, the following sequence of steps is recommended:

### Locate the IRT/c.01 close enough to make the measurement accurately.

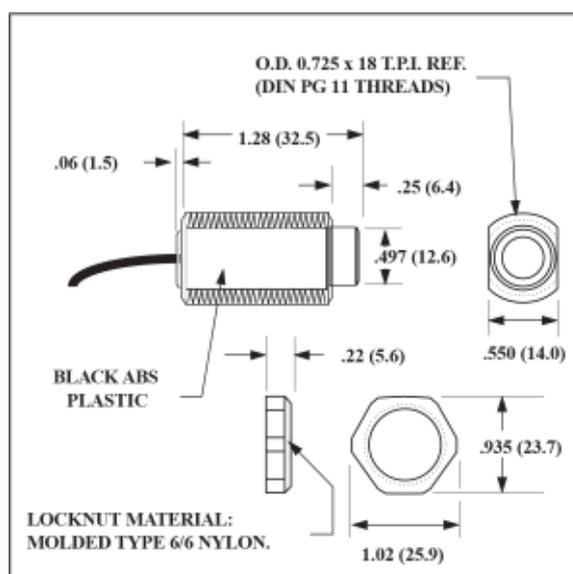
Referring to the 1:1 field-of-view specification, be sure that the target is large enough, or the sensor close enough such that the target is larger than the measuring spot. The IRT/c.01 can be physically close as to nearly touch the target, and is limited only by physical space and local temperature. Normal mounting is with the supplied locknuts (2 supplied), but alternative methods may be used to hold the cylindrical section or the flats, whichever is more convenient in locating as close as practical. For hot targets in close proximity (~ 1 inch or 2,5 cm) permit adequate ventilation of the mounting to keep the IRT/c.01 below its 160°F (70°C) rating. If the sensor face is likely to become dirty, mount in such a fashion to permit occasional cleaning with a mild solvent such as alcohol.

### Select the linear range required.

Referring to the Temperature Selection Guide, choose the model that has the center of its linear range closest to the control point for your application, and select the thermocouple type you prefer. If your application includes monitoring and control over a range of more than ~ 100°F (~ 50°C), and your thermocouple interface has computational ability, request a copy of the IRT/c Signal Output Table for your model, which has the data necessary to linearize over the entire operating range of the IRT/c.01.

### Calibrate just once!

Referring to Tech Note #1, best practice is to install the IRT/c.01, operate the process under normal conditions, and calibrate the read-out system based on the reading from a reliable reference (the D-Series is recommended). As long as the target materials are consistent, and there is no leakage current offset from the electronics, the initial calibration will be valid for all subsequent installations.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## INEXPENSIVE INFRARED SCANNING ARRAYS WITH IRT/C.01

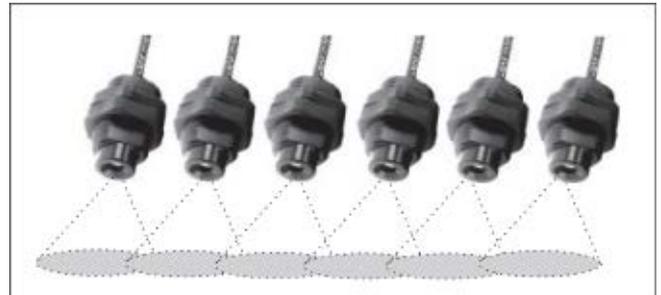
**For web drying, printing, laminating, paint curing, etc.**

With the low cost of the IRT/c.01 and its direct compatibility with inexpensive, widely available thermocouple input devices, powerful infrared scanning arrays can now be considered for applications in which thermal signatures are desired for process monitoring and control. Such applications include web drying, printing, laminating, paint curing, and any other thermal processing of moving material. Multiple input monitoring and control devices include data acquisition systems, personal computers, PLC's, and custom OEM cards. By taking advantage of the low cost performance of the IRT/c.01 and standard available components, infrared scanning arrays can be put to work controlling your process for approximately \$100 per channel.

Some tips on setting up an IRT/c infrared scanning array:

**Be sure to use identical models for each sensor in an array.**

This will keep all of your signals internally consistent within the software you use, and avoid any interpretation errors. Also, if you employ the available IRT/c Signal Output Tables, one table or curve will apply to all the sensors in an array. IRT/c's of the same model are interchangeable to < 1% of reading.



**Investigate low cost thermocouple interfaces.**

Prices per channel for computer A/D cards and PLC input cards for thermocouples have fallen to well under \$100, and are available for as little as \$30 for some systems. If the application is for high volume OEM equipment, consider using a boardlevel chips.

**For single channel use, consider IRT/c's in parallel.**

Wired in parallel to a single input channel, an array of IRT/c's produces an output signal which indicates the *average temperature* of the targets scanned. This attribute is particularly convenient for monitoring and controlling wide webs, which cannot easily be covered by a single sensor. To use, simply wire all of the red (-) t/c leads to the negative input terminal, and the other (+) leads to the positive input.

**Exergen Global offices:**

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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www.exergenglobal.com

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## TWO-COLOR PYROMETRY WITH IRT/C'S

### The IRT/c.L2 Method

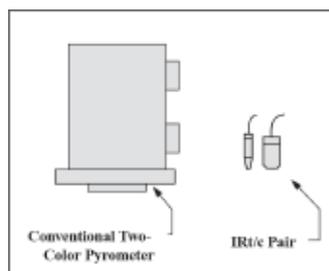
For many bare metal temperature monitoring applications, emissivity variations are too extreme for even the IRT/c-LoE models to provide reliable information. A common problem is aluminum, since emissivity is low and variable due to alloying, surface oxidation, surface finish variations, etc.

The traditional non-contact infrared solution has been two-color pyrometry, since this method yields significant improvements over single wavelength devices by ratioing signals at two nearby wavelengths, and thus deducing temperature from the ratio. The major drawbacks of conventional twocolor systems are size, complexity, and cost. The IRT/c innovation, and the availability of inexpensive computational power, have made possible a simple, reliable substitute for conventional two color pyrometry at a small fraction of the cost and small fraction of the size.

The IRT/c.L2 method of twocolor pyrometry incorporates the following:

- A short wave (LoE) IRT/c model and long wave IRT/c model viewing the same target area.
- Two thermocouple input channels to a computer or PLC.
- Computational ability to solve two equations in two unknowns on-line.

Depending on the models selected, the cost for such a system can be well under \$1000.



The equations to be solved are as follows:

For the short wave (LoE) model:

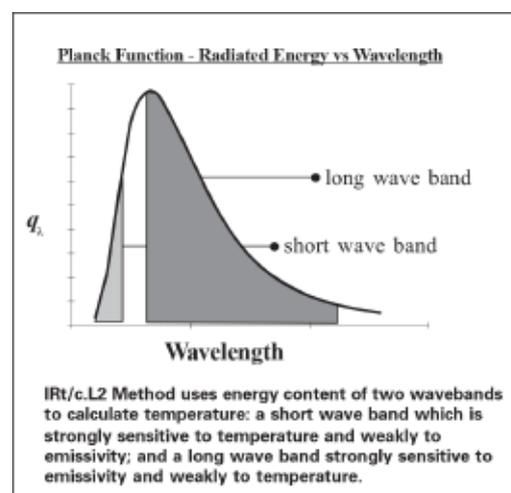
$$S_{SW} = A(\epsilon/25)(1.771E-17 T^6 - 6.584E-14 T^5 + 2.062E-10 T^4 + 1.625E-07 T^3 - 5.366E-05 T^2 + 1.116E-02 T - 8.615E-01)$$

For the long wave model (example IRT/c.2-K-440F/220C):

$$S_{LW} = (\epsilon/9)(-5.335E-16 T^6 + 8.684E-13 T^5 - 4.670E-10 T^4 + 4.446E-08 T^3 + 8.892E-05 T^2 + 1.622E-02 T + 1.300E+00)$$

where  $S_{SW}$  and  $S_{LW}$  are signals produced in millivolts (referenced to 0°C cold junction compensation),  $\epsilon$  is emissivity, T is target temperature, and A is an arbitrary calibration constant that represents the position of the adjustment screw for the adjustable LoE model.

IRT/c.L2 Method uses energy content of two wavebands to calculate temperature: a short wave band which is strongly sensitive to temperature and weakly to emissivity; and a long wave band strongly sensitive to emissivity and weakly to temperature.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## TWO-COLOR PYROMETRY WITH IRT/C'S

An initial calibration has to be performed with both devices viewing the same known target temperature. The value for  $\epsilon$  is immediately computed by the  $S_{LW}$  equation, and the value for A by the  $S_{SW}$  equation. A variety of computational methods can be employed to compute  $\epsilon$  and T continuously from the two equations in two unknowns, with the simplest being a computation of differentials in signal relative to the initial calibration. The only assumption required for the method to work in its differential form is that the

ratio of emissivities for the two wave bands employed remain constant, i.e.  $(\epsilon_{SW}/\epsilon_{LW}) = \text{constant}$ . For the example and recommended combination of IRT/c.10A-LoE (*short wave*), and IRT/c.2-K-440F/220C (*long wave*) these wavelength bands are 0.1 to 5 micron and 6.5 to 14 micron respectively. Note that the emissivity coefficient can include any effect that is not wavelength dependent, such as intervening dust, partial obstruction, or target smaller than the fields-of-view.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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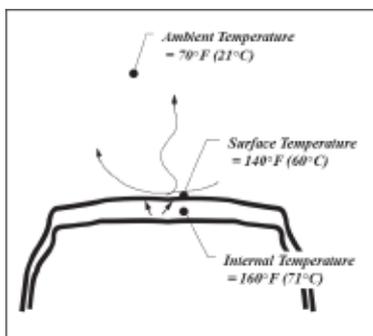
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## MEASURING TIRE TREAD INTERNAL TEMPERATURE

with the IRt/c-HB (Heat Balance)<sup>™</sup> Series Infrared Thermocouple

### Model IRt/c.5-HBT-J-80

By its very nature, infrared measures *surface* temperature, but most material properties of interest relate to *internal* (bulk) temperatures. For many materials, such as metals, the gradient between the surface and internal temperatures is small enough to ignore. For other materials, such as rubber products, the gradient can be quite large when the material is exposed to an ambient temperature that is much different from its bulk temperature. This problem is particularly acute in the manufacture and testing of tires, since surface temperature may not be a reliable indication of internal tread temperature, which is the property of interest, due to the action of rapid convection and radiation at the surface, and slow conduction internally.

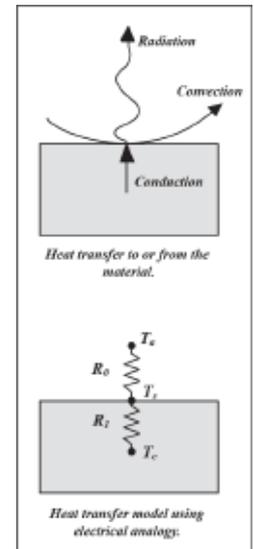


The IRt/c Heat Balance Series Infrared Thermocouples actually calculate the internal temperature by solving the equation that describes the heat balance between internal, surface, and ambient temperatures, and produce an *unpowered thermocouple signal that represents the internal temperature!*

This breakthrough method was first developed and patented by Exergen Corporation for use in the medical field to solve the problem of obtaining

human core body temperature noninvasively, and is in use in literally hundreds of thousands of clinical infrared thermometers. The application to tire temperature measurement is the first industrial application of the method.

Mathematically, the IRt/c-HB employs what is called the *Heat Balance Equation*, which follows from the basic heat transfer electrical analog circuit shown:



$$T_c = K(T_s - T_a) + T_s$$

where  $K = \frac{R_1}{R_0}$

The *Heat Balance Equation* is continuously solved by the IRt/c, and produces a thermocouple millivolt signal that represents  $T_c$ . For the IRt/c.5HBT-J-80, the signal is a type J, and the  $K$  is programmed to calculate temperature approximately 1/4" (6 mm) deep.

All of the other outstanding characteristics of the IRt/c, including unpowered simplicity, rugged hermetically sealed system, intrinsic safety, and compatibility with standard thermocouple interfaces with PLC's, computers, controllers, etc., makes the *Heat Balance Series* an outstanding selection for the measurement of tire temperature, and the improved performance made possible by accurate measurements.

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## MEASURING TIRE TREAD INTERNAL TEMPERATURE

with the IRt/c-HB (Heat Balance)<sup>™</sup> Series Infrared Thermocouple

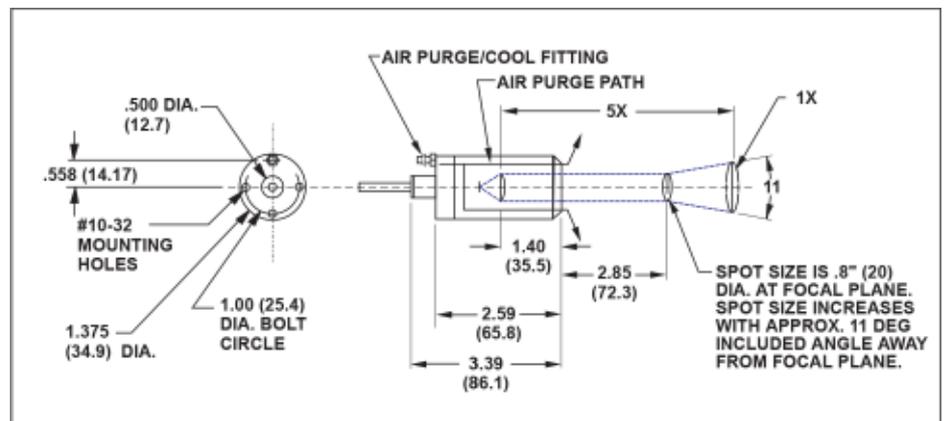
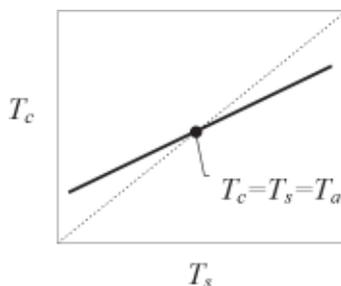
### Set-up and Calibration

System set-up and calibration is the same as for all other IRt/c models except that the reference temperature is obtained with a probe type unit to penetrate to the depth of measurement. Following Tech Note #1, the process is as follows:

- Install the IRt/c in the location it will be used.
- Wire IRt/c to readout device.
- Place tire to be measured in normal location. Tire temperature must be significantly different from ambient for the calibration to be accurate.
- Measure internal temperature with insertion probe.
- Adjust readout device OFFSET, or ZERO until IRt/c reading agrees with probe.

Calibration complete.

The new technology embodied in the IRt/c Heat Balance Series can be used in other applications where internal bulk temperature is required.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## IRT/C SPECIFICATIONS: REAL WORLD PERFORMANCE ACCURACY

The table below summarizes some of the major differences between how IRT/c's are designed and calibrated, compared to conventional infrared devices, with the objective of providing the best possible accuracy under actual real-world conditions.

### Why the IRT/c is Different

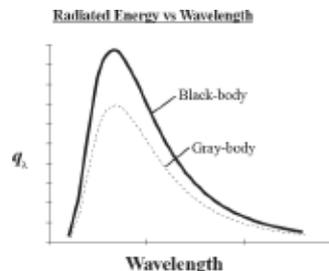
The concept of a black-body is a highly useful and essential mathematical construction in the application of infrared radiation physics, and has had firm theoretical support from the time of Max Planck nearly 100 years ago. However, in the real world application of infrared methods for temperature control, IR devices do not measure black-bodies.

More realistically, real-world measurements are performed on targets that approximate what is termed a gray-body, i.e. materials which have an emissivity less than 1. Gray-bodies also have the further characteristic that emissivity is constant at all wavelengths of interest. Then for gray bodies:

$$q_{gb} = q_{bb} \epsilon$$

at all wavelengths, where  $q_{gb}$  and  $q_{bb}$  are radiated energy from a gray-body and black-body respectively.

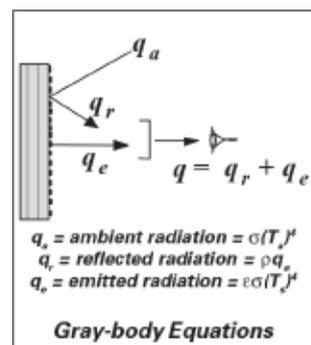
	IRT/c	Conv. IR
Designed and calibrated to black-body conditions?	No	Yes
Designed and calibrated to real-world conditions?	Yes	No
Calibrated with multiple gray-bodies?	Yes	No
Calibrated with multiple ambient temperatures?	Yes	No
Constructed to minimize ambient reflective errors?	Yes	No
Designed to minimize emissivity shift errors?	Yes	No
Calibrated with NIST traceable standards?	Yes	?



An important element which is missing when working with black-bodies, but present with graybodies is reflected radiation. For nontransparent

materials, emissivity plus reflectivity always equals one:

$$\epsilon + \rho = 1$$



Accordingly, for a black-body  $\epsilon = 1$ , and therefore  $\rho = 0$ . But for a gray-body  $\epsilon < 1$  and therefore  $\rho > 0$ , and the reflected radiation due to ambient temperature must be considered. Refer to Tech Note #64

for further details.

IRT/c's are specifically designed to be accurate and reproducible under real world conditions of targets that approximate gray-bodies, with ambient temperatures that vary, thus with reflected radiation that varies. The performance specifications of the IRT/c, unlike conventional infrared devices, include graybody effects.

Mathematically the signal output of an IRT/c is a complex function of target temperature, ambient temperature, target emissivity, reflected energy, thermocouple type, etc. To clarify the specifications we can represent the change in signal with respect to a variable of interest, while holding all other variables constant, as a partial derivative.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

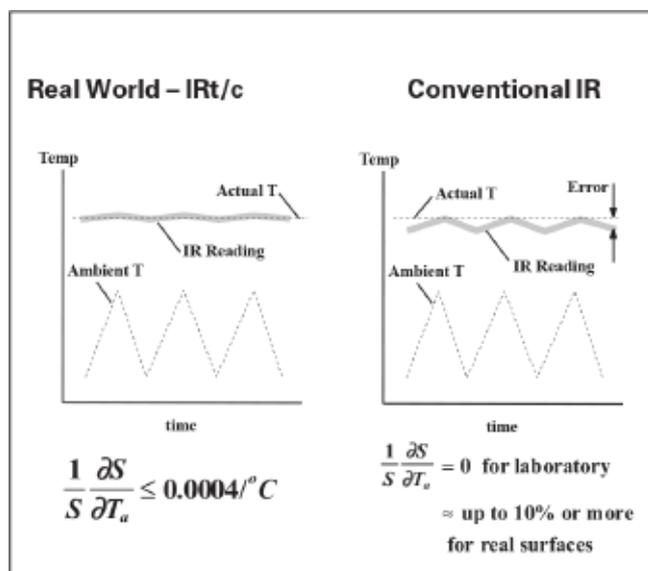
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## IRT/C SPECIFICATIONS: REAL WORLD PERFORMANCE ACCURACY

### Ambient Temperature Coefficient Specification

The variation in output signal with ambient temperature, which is the Ambient Temperature Coefficient specification, can be represented as below:

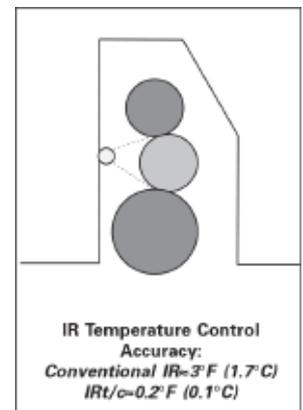
where S is the output signal and T<sub>a</sub> is the ambient



temperature. This equation describes the output of the IRT/c, including a gray-body assumption of emissivity = 0.9, and that the sensor itself is at the same temperature as the environment.

What this means in practice is that when an IRT/c is installed and calibrated in place (Tech Notes #1, #64), the IRT/c body tends to change temperature with the ambient background that the target sees, then internally applies the correction required to reduce errors. Without this feature this error could be many times higher, and cause unwanted shifts in process control temperature.

For example, waterless printing processes require that the ink application roll to be temperature controlled in order to maintain high quality. If the temperature is to be controlled at 80°F (26.7°C), and the press enclosure can vary over the range 70 to 100°F (21.1 to 37.8°C) due to warm-up, weather, air ventilation, etc.; then a conventional IR device will produce an error of about 3°F (1.7°C), while an IRT/c will produce an error of only 0.2°F (0.1°C). Thus, the IRT/c provides ten times more accurate control than the conventional device. To estimate the improvement in control accuracy produced by the IRT/c for a specific application, the following approximation can be applied:



$$\text{Error with Conventional IR} = (1 - \epsilon) (\Delta T_s) (T_s - T_a)$$

$$\text{Error with IRT/c} = (0.9 - \epsilon) \left( \frac{\Delta T_s}{10} \right) (T_s - T_a)$$

### Compensating for Emissivity Variations

A common assumption for conventional IR thermometry is that emissivity is constant with changes in target surface temperature. Real materials do not have this characteristic. The average value for nonmetals for which the change in emissivity with respect to surface temperature has been reported, is approximately - 2% per 100°F target temperature change (- 3% per 100°C).

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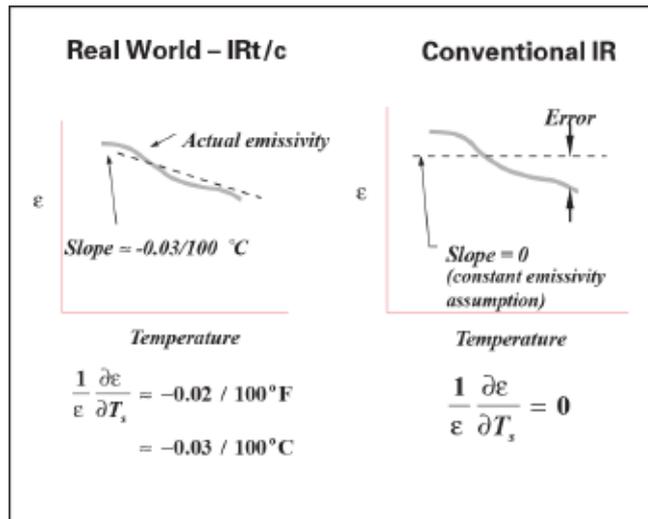
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5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## IRT/C SPECIFICATIONS: REAL WORLD PERFORMANCE ACCURACY

Applying the partial derivative mathematical formulation, the emissivity variation is:

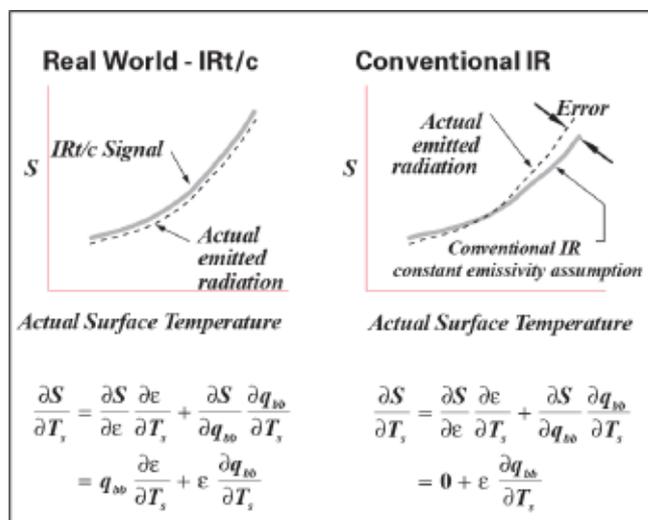


Conventional IR misses this effect, and will cause process control errors.

The signal produced by the IR device is proportional to the radiation emitted by the surface:

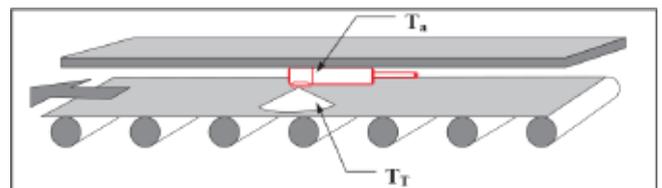
$$S = \epsilon q_{bb} \text{ (conventional IR assumption)}$$

then the change in signal with respect to target surface temperature may be presented as follows:



Note that the conventional IR device loses one term of the signal change with respect to surface temperature. When the IR signal is converted to a temperature indication, the signal in the conventional device is linearized, whereas in the IRT/c the signal is unchanged.

Since real-world emissivity for most non-metal materials decreases with temperature, the constant emissivity assumption of conventional IR devices produces errors in readings that are not obvious to the typical IR user and can be highly misleading over a wide temperature range. The IRT/c, however, is specified for a useable specific temperature range, where the effect of emissivity change is accounted for in the linearity specification, and the user is confident that his process control will be accurate. Note that testing an IRT/c with a black body will not give the same linear range as a realbody.



A second effect on linear range is the effect of target surface temperature on ambient temperature, and therefore the reflected component of radiation to the sensor. As target temperature increases within a process, the increased radiation heat transfer to the surroundings will cause the target ambient radiant background to also increase in temperature.

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## IRT/C SPECIFICATIONS: REAL WORLD PERFORMANCE ACCURACY

For example, a laminating process that has several temperature control settings that depend on the material and feed speeds, may operate with target temperatures that are 100°F (56°C) different. As the material changes temperature, the background radiation in the vicinity of the measurement will also change temperature, and influence the IR reading.

Accordingly, the variation in signal with target temperature has the additional component as follows:

Real World - IRt/c	Conventional IR
$\frac{\partial S}{\partial T_s} = \frac{\partial S}{\partial T_a} \frac{\partial T_a}{\partial T_s}$ $\frac{\partial T_a}{\partial T_s} = e$ $\frac{\partial S}{\partial T_a} = S(1 - \epsilon)$ $\frac{\partial S}{\partial T_s} = S(1 - \epsilon)e$ <p><math>e \approx 0.25</math> by test</p> $\frac{1}{S} \frac{\partial S}{\partial T_s} = 0.25(1 - \epsilon)$	$\frac{\partial T_a}{\partial T_s} = 0$
<p>For a typical case of <math>e = 0.9</math>, the change in signal is = 2.5%, which is accounted for in the ambient compensation system over the linear range.</p>	<p>The 2.5% error is present, but not accounted for in the design or calibration, thus resulting in process control error.</p>

### Comparison to Standard Thermocouples

Standard thermocouples are generally specified as adhering to ASTM and ANSI specifications, which prescribe a basic accuracy of  $\pm 2.2^\circ\text{C}$ , or 0.75% of reading, whichever is higher. Likewise, IRt/c's are also specified to be within the same  $\pm 2.2^\circ\text{C}$  limits, or to the percentages stated in their specifications, whichever is higher.

However, it is important to note that *when an IRt/c is calibrated to installation, this error disappears.*

### Repeatability and Interchangeability

The cardinal requirement for the IRt/c, as in any measuring device, is to repeat its calibration. The *repeatability* of IRt/c's is specified at  $<0.1^\circ\text{C}$ .

*Interchangeability* uncertainty from one device to another is 2% *maximum*, since each individual device is built and tested to conform to standards with a  $\pm 1\%$  tolerance, so is therefore able to produce a maximum of  $\pm 2\%$  difference between any two devices. *Typical* interchangeability uncertainty, determined by test, is described statistically with standard deviation of approximately  $0.5^\circ\text{C}$ .

### Summary

1. The IRt/c is a different type of device compared to conventional IR, since it is carefully designed and built to produce real world accuracy for temperature control, with some subtle features that make a significant improvement over conventional IR.
2. In-place calibration is always recommended, as it always is with any IR device due to uncertainties in emissivities and ambient temperature.
3. For OEM applications, or multiple same-use applications in a factory, once the initial system has been qualified and calibrated, IRt/c's of the same model can be substituted without the necessity of recalibration.

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

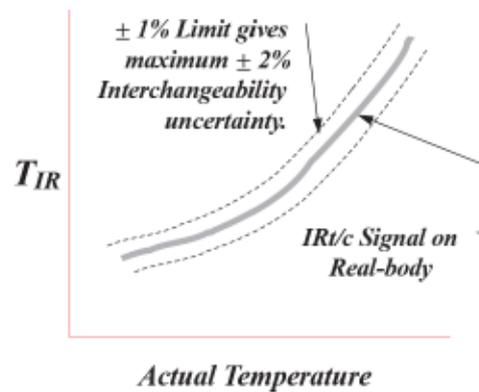
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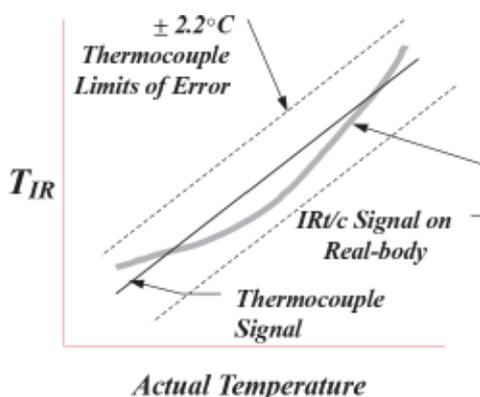
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### IRT/C SPECIFICATIONS: REAL WORLD PERFORMANCE ACCURACY

4. An added benefit of the IRT/c is its *specified* useable linear range per model. (A user is not led into believing that his measurement is accurate over a wide temperature range, a common misunderstanding with conventional IR. Thermal physics and scientific data demonstrate that trying to track real-world surface temperatures over a range greater than approximately 100°F (56°C) involves accounting for increasing errors that cannot be handled by conventional IR devices. This includes not only permanently mounted IR sensors, but portable handheld IR devices, also.) There is one exception to this rule, however, the Microscanner D-Series portable IR scanners. (See Tech Note #91, #33) They have the largest useable target temperature ranges with the least amount of possible errors due to emissivity and ambient reflections. Use of the Microscanner D and DX Series is recommended for calibrating and checking IRT/c sensors in temperature ranges less than 1600°F (850°C).



5. An IRT/c's full performance *cannot be accurately checked with a black-body*. Standard laboratory black-bodies can be used for pass-fail or reproducibility testing only. Contact Exergen for availability of specialized test devices.
6. An IRT/c's full performance *cannot be accurately checked with a conventional handheld portable IR device*, there are too many external sources of error. See Tech Note #91.



#### Notes

1. Thermal Radiative Transfer and Properties, MQ Brewster ed., John Wiley & Sons, 1992.
2. ASTM Standard E230, ANSI MC96, Manual on the use of Thermocouples in Temperature Measurement, Fourth ed., ASTM 1993.

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## IRT/C'S MORE ACCURATE THAN CONVENTIONAL IR IN REAL WORLD

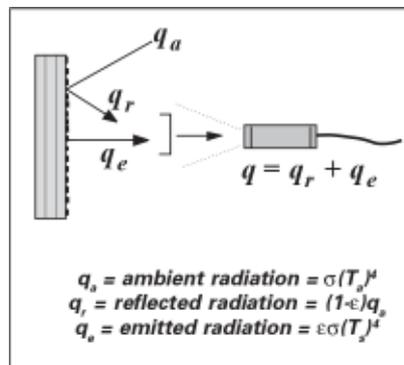
A common misunderstanding amongst even experienced manufacturers and users of infrared temperature measurement equipment is that the *accuracy of temperature measurement is solely a specification of the infrared device*. This statement is correct only in the laboratory under controlled conditions with blackbody (emissivity = 1.0, reflectivity = 0) targets. In the real world, designs and specifications that are applicable in the laboratory can be misleading and sometimes outright incorrect. Following is a summary of the key points of accuracy in a comparison between the IRT/c and conventional IR (detailed mathematical development is presented in Tech Note #89).

1. **Real-world materials have emissivity < 1, and therefore have reflectivity > 0, which causes errors from varying background temperatures.**

Even non-metals, with emissivity approximately 0.9 and reflectivity approximately 0.1, must reflect about 10% of the energy incident from the background ambient. This reflected energy, unrelated to the target temperature, is nevertheless measured by the infrared sensor, and therefore will introduce significant errors if the ambient temperature changes, as it does in the real world. Conventional IR devices, calibrated with blackbodies, usually ignore this effect, and thus are subject to the error. IRT/c's are specifically designed and tested to include a correction for

this effect and thus improves their real-world accuracy.

2. **Real-world materials have emissivities that change significantly with temperature, which causes significant errors even with perfect calibration and linearization.**



Probably the most misleading concept in infrared thermometry is that emissivity is constant with varying temperature. Real-world materials have emissivity variations that range from an average of 2% per 100°F (60°C) temperature change for nonmetals, to 10% per 100°F (60°C) temperature<sup>1</sup> change for some paints, and well over 100% per 100°F

(60°C) temperature change for some metals. Accordingly, accuracy of real-world temperature measurements should be considered valid only for a limited temperature range. Specifications of accuracy for conventional infrared devices specified over wide target temperature ranges are largely meaningless. (The sole exception is Exergen's D-Series, due to its Automatic Emissivity Compensation System.)

IRT/c's are specifically designed and tested to maintain very high accuracy over a limited temperature range, and specifically not specified to imply accuracy over a wide target temperature range.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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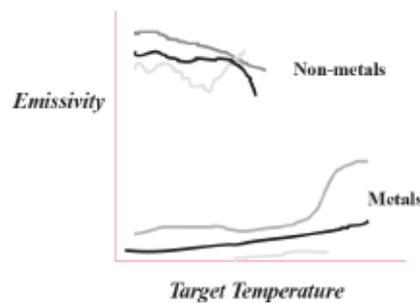
## IRT/C'S MORE ACCURATE THAN CONVENTIONAL IR IN REAL WORLD

For this reason IRT/c's are offered in a variety of temperature range selections, each of which is optimized for a specific limited temperature range, which correctly reflects the realworld material characteristics, and maximizes the accuracy.

3. **Real-world temperature control is most accurate if the IR sensor is designed, built, calibrated, and tested at factory conditions that are designed to reflect actual field conditions.**

Conventional IR devices are designed, built, and tested to standards traditionally defined by blackbodies, which do not include the errors caused by reflected energy and emissivity variations of realworld materials. IRT/c's are designed, built, and tested to standards that include elevated and

variable ambient background temperatures, and real-world target materials that change emissivity with temperature, thus maximizing the accuracy of temperature measurement and control.



1. *Thermal Radiation Heat Transfer*. R Siegel and JR Howell, ed., second edition, Hemisphere Publishing Corporation 1981.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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## DISPOSABLE WINDOW

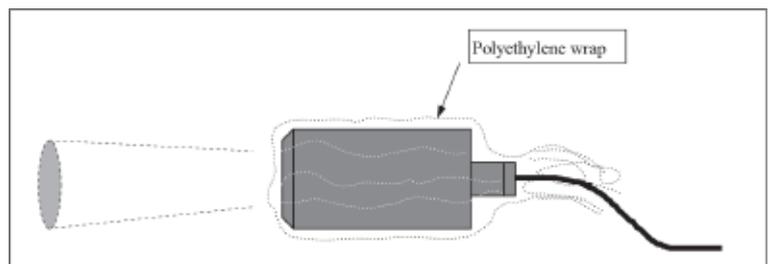
A not uncommon problem in some industrial environments, such as foundries, is maintaining optical cleanliness during washdown, or protecting the lens from debris when air purge is impractical or insufficient. In addition, sometimes a barrier is necessary between the process to be monitored and the IRt/c.

Windows made of common materials such as glass, etc. will significantly attenuate infrared radiation from targets below about 1000°F (540°C) and are not generally suitable for low temperature service. *However, windows made of polyethylene will transmit very efficiently at all temperatures if they are thin enough.* "Thin" means generally less than about 0.005 in. (0.1 mm).

An excellent material is a commonly available plastic wrap brand called *Glad*

*Cling Wrap*®, which can easily be wrapped around the IRt/c for cleanliness, or formed into a window. If the polyethylene is dirty or damaged, it can easily be replaced. With maximum temperature rating at about 212°F (100°C), this material can be used in many processes.

The transmission coefficient of such thin polyethylene is in the neighborhood of 90%, and therefore only a small recalibration of the readout device may be required. Other brands of plastic wrap are not recommended, unless you can confirm that they are made from polyethylene.



#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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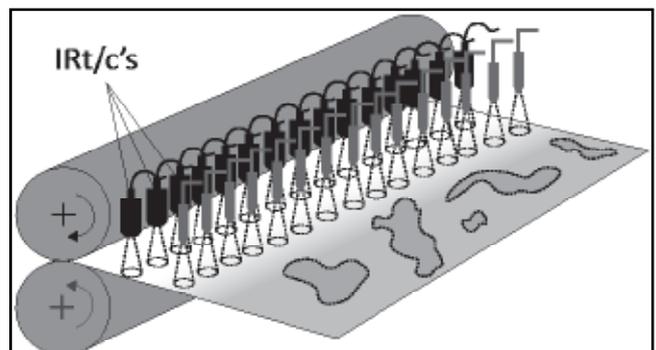
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## DRYING PAPER WEBS WITH JETS OF AIR CONTROLLED BY IRT/C'S

A basic problem in controlling moisture content of paper webs is non-uniformity of drying across the web. Standard methods cannot address this problem because typically the entire web is measured for moisture content, and the process is adjusted to insure that no part of the web has too much or too little moisture. Accordingly, the overall basis weight and paper properties are not optimum, since there are significant non-uniformities. IRT/c's, along with inexpensive PLC's or other computing power, makes it possible to eliminate these nonuniformities and maximize the value of the paper.

The method consists of spanning the web with a series of simple modules consisting of an IRT/c and a controllable air jet configured to dry the strip scanned by the IRT/c. The IRT/c signal is the input

to a temperature control system which controls the air jet based on local temperature and other process parameters. By individually drying each strip to the same standard, the web can maintain uniformity and therefore high quality. Any IRT/c model with built-in air purge is suitable. Where mounting space permits, the IRT/c.5 sensor is the recommended model.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## IN-LINE PRE-CALIBRATED TRANSMITTER FOR EASY, RELIABLE INSTALLATION

### Model t/c.XMTR- \* - \*\* 4-20 mA Transmitter

Current loop transmitters for thermocouples have traditionally been designed as “hockey pucks” in order to fit thermowell heads, thus complicating installation for applications not using a thermowell, and requiring a housing for protection. Additionally, they generally have to be calibrated to a specific range, usually with thermocouple simulators or other such device, thus requiring significant set up time and the possibility of unauthorized recalibration.

The t/c.XMTR is designed to overcome both of the costly inconveniences:

- In-line design is only slightly larger than the cable and requires no mechanical support.
- Precalibrated for thermocouple type and temperature range eliminates all adjustments, requirements for simulators, etc.
- Hermetically sealed stainless steel construction is suitable for the harshest service without any additional packaging.

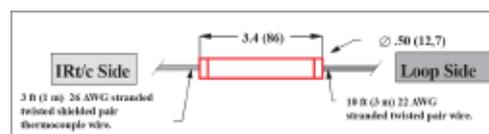
The t/c.XMTR is specifically designed to interface to any model IRt/c (or any conventional thermocouple) by a simple thermocouple connector or splice. The 2-wire current loop can be used in any conventional current loop circuit that is scaled for the temperature range of interest.

### Model Selection

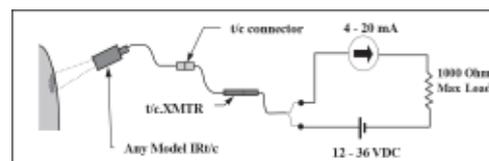
1. Select the correct IRt/c model for the application: target temperature, target material, field-of-view.
2. Select the t/c.XMTR model for the t/c type and temperature range from the table below.  
Example: t/c.XMTR-K150

### Installation

1. Install IRt/c as normal.
2. Connect IRt/c output cable to the thermocouple input side of the transmitter using standard t/c connector, splice, or other standard method of connecting thermocouple cables. Transmitter should be located in a an environment no higher than 158°F (70°C) in temperature. Additional t/c extension wire may be added as required. Use of twisted shielded t/c wire is recommended (same as on the IRt/c and transmitter), and maintain shield connections.
3. Check load on transmitter and power supply voltage for correct range (10 VDC minimum @ 10W; to 22 VDC minimum @ 1KW).



4. Set readout device (controller, computer, PLC, etc.) for 4 to 20 mA range to match the t/c.XMTR model range.
5. Perform final calibration of IRt/c installation in accordance with IRt/c instructions, using offset on current loop readout device.
6. Installation complete.



Model Numbers Example: t/c.XMTR-J-150	J150 K150	J500 K500	J1200 K1200	K2000	S3000
Temperature at 4 mA	32°F				
Temperature at 20 Ma	150°F (65°C)	500°F (260°C)	1000°F (540°C)	2000°F (1100°C)	3000°F (1650°C)

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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## EASY UPGRADE OF EXISTING TEMPERATURE CONTROL SYSTEMS WITH IRt/c AND t/c.XMTR

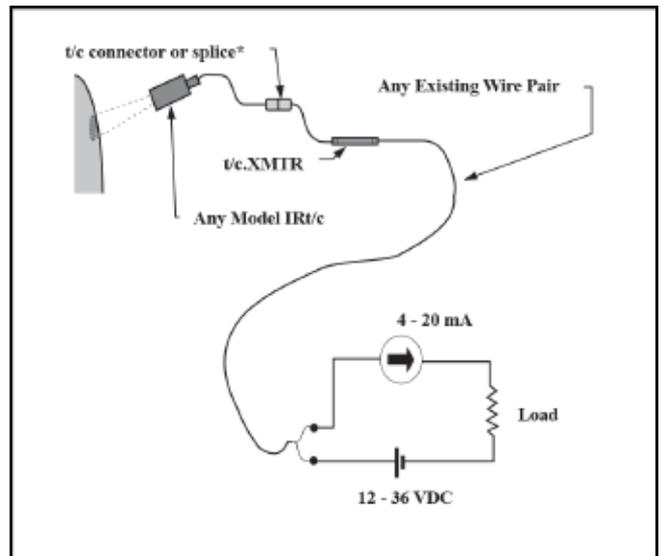
- Replace conventional infrared sensing systems for superior accuracy, reliability, and low cost.
- Replace contact temperature sensors for noncontact measurement of actual product temperature instead of oven temperature.
- Retrofit using existing PLC analog inputs (4-20 mA, 0-5 V, 0-10 V).

The t/c.XMTR is specifically designed to make replacement or retrofit simple and inexpensive:

- In-line t/c.XMTR design is only slightly larger than the cable and requires no mechanical support.
- Precalibrated for thermocouple type and temperature range eliminates all adjustments, requirements for simulators, etc.

*\*For OEM's, IRt/c's and t/c.XMTR can be factory supplied wired together.*

- Hermetically sealed stainless steel construction is suitable for the harshest service without any additional packaging.
- Use any existing wiring, including thermocouple, RTD, etc.



The t/c.XMTR is specifically designed to interface to any model IRt/c (or any conventional thermocouple) by a simple thermocouple connector or splice. The 2-wire current loop can be used in any conventional current loop, 0-5V, or 0-10V circuit that is scaled for the temperature range of interest.

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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### PRECALIBRATED HI E AND LO E MODELS FOR OEM APPLICATIONS

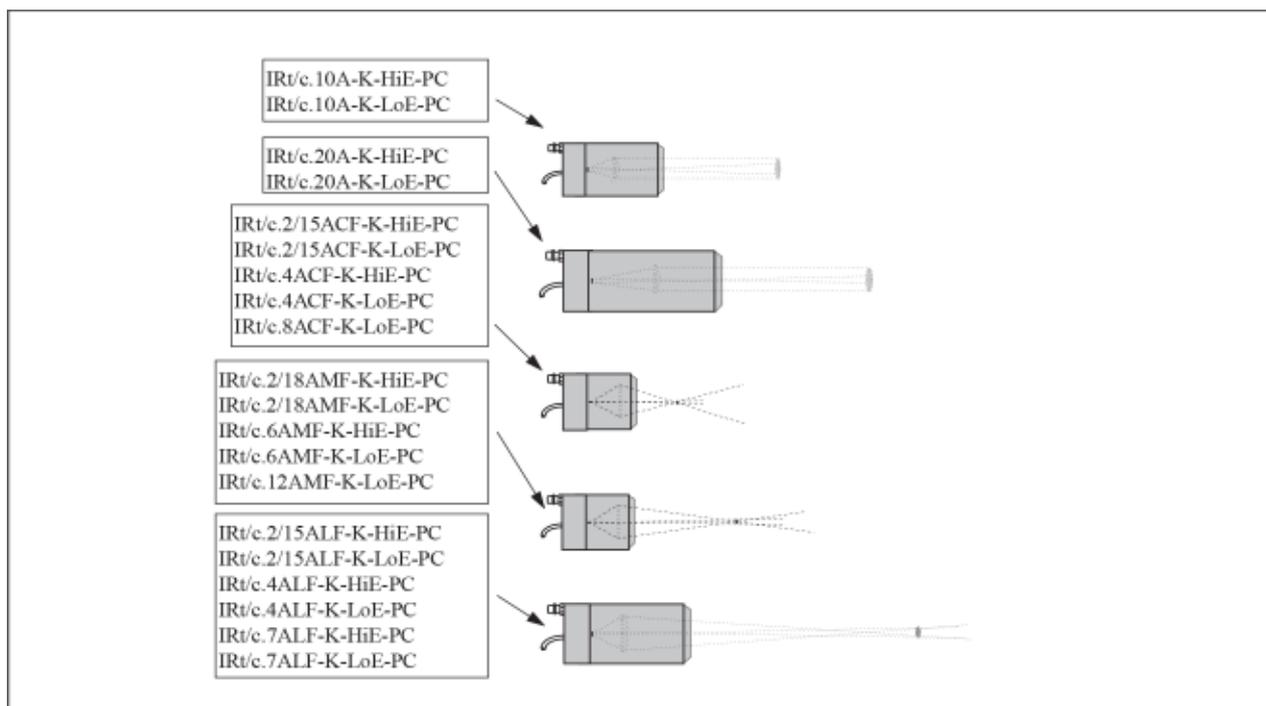
#### Add “PC” Suffix to Any Type K Adjustable Model

Non-adjustable IRt/c’s are particularly attractive in applications where reproducibility and interchange-ability are important, or where tamperproof sensors are desired. For low temperature applications, the many non-adjustable IRt/c models available provide the user with a wide selection to fit such needs. However, many higher temperature applications, with both high and low emissivity targets also require precalibrated non-adjustment features. In addition, for systems in which linearization software is employed in the readout device, the installation calibration can be performed more conveniently in software rather than making an adjustment on the IRt/c.

To take advantage of these models, the following is required:

1. Thermocouple input to programmable readout device (or 4-20 mA if transmitter is employed).
2. Signal output lookup table for either *HiE - PC* or *LoE - PC IRt/c models*.

The following models are available with the PC calibration designation, with the same signal output at all temperatures. The maximum recommended target temperature for all models is 2000°F (1100°C). The minimum recommended target temperature depends on the precision of the thermocouple input amplification system, but a reasonable lower limit is 700°F (370°C) for the HiE and 1000°F (540°C) for the LoE. For other specifications, refer to the Model Selection Chart or the individual model specification sheet.



#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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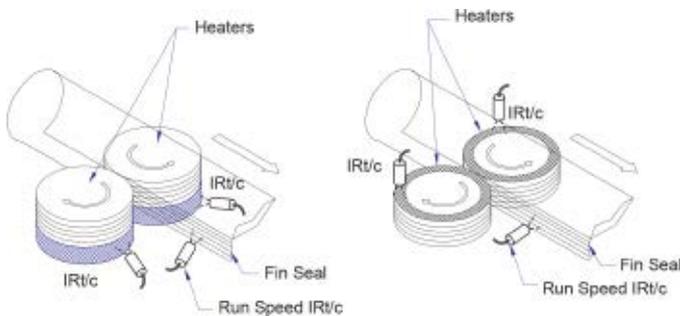
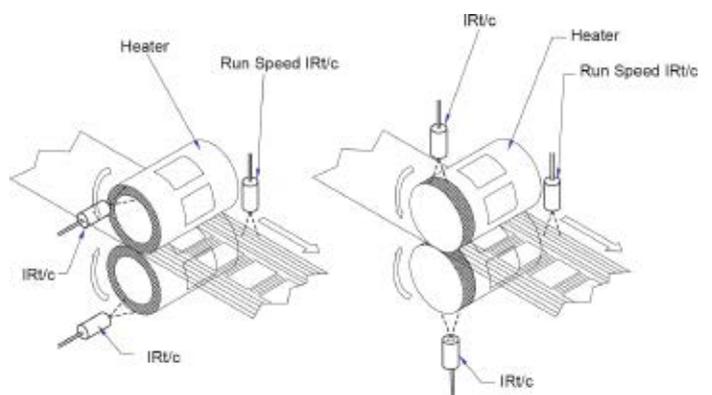
## IRT/C NON-CONTACT HEAT SEALING TEMPERATURE CONTROL FOR PACKAGING MACHINERY (OEM & RETROFIT)

IRT/c infrared thermocouples can accurately control the temperature of rotating and moving stainless steel heaters common in the packaging industry, without touching the heaters.

Typically, uncoated stainless steel heaters are difficult for IR sensors to measure reliably because of reflected infrared signals that can change after a heater surface is cleaned. The solution to this problem is simple:

Choose an unused location on the heaters, as close as possible to the surface you wish to measure. Mechanically mount a surface that is reliable for the IRT/c to measure.

There are at least two choices for a reliable infrared target surface that meet the needs of the packaging industry (able to withstand repeated daily cleanings, durable to provide years of service):



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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## IRT/C NON-CONTACT HEAT SEALING TEMPERATURE CONTROL FOR PACKAGING MACHINERY (OEM & RETROFIT)

### 1. Black, hard-anodized aluminum coated surface

A black, hard-anodized aluminum hoop, ring, disk, or strip can be used. The surface must be “hard-anodized”. It can be mounted in place onto the steel heaters by using thermal epoxy, small screws, or other suitable mounting methods.

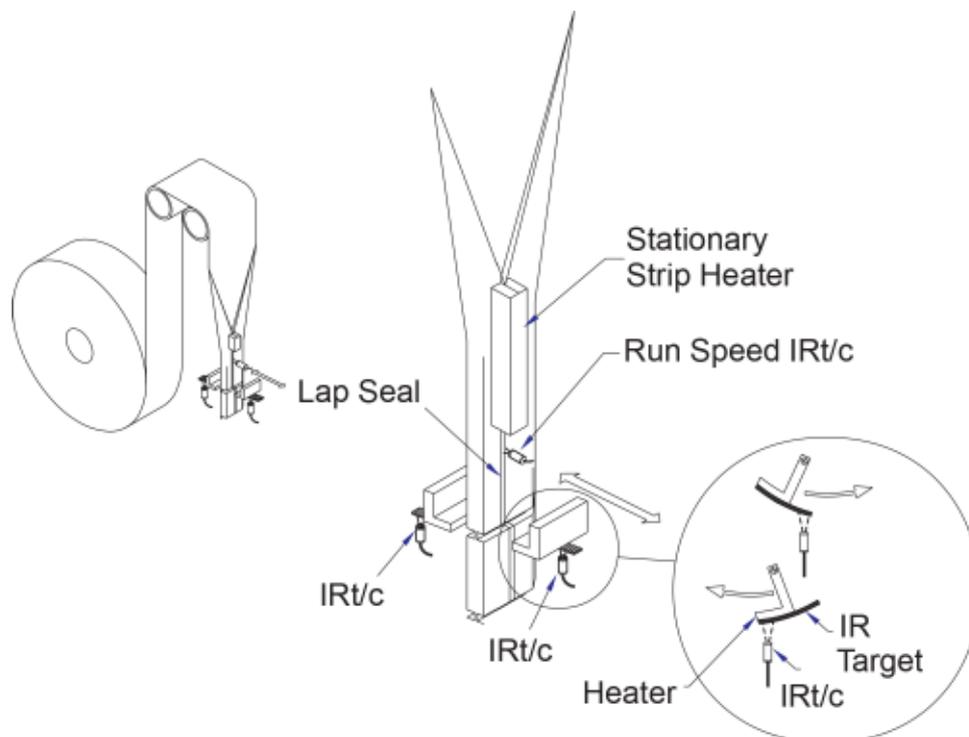
This method is very good for “retrofit” situations. The IR target surface can be added right onto existing heaters.

### 2. Teflon coating, directly applied onto an unused part of the stainless steel heaters

This is an excellent choice for OEMs that already use teflon coatings in other parts of their machines. Simply have a teflon coating added to the best target area prior to installing the heaters.

### “Open and Close” Heaters/Cutters - IRt/c control

For jaw heaters/cutters that “open and close”, attach a small piece of coated metal to each heater head. This strip will come to the same temperature as the heater head as heat is conducted through the attachment point. The length of the strip should be just long enough so that the IRt/c sensor constantly looks at the strip during each “open and close” cycle giving a constant update of the temperature of the heaters.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## IRT/C NON-CONTACT HEAT SEALING TEMPERATURE CONTROL FOR PACKAGING MACHINERY (OEM & RETROFIT)

### High Speed / High Performance Heat Sealing

For Rotating Heaters and for Stationary Strip Heaters, an additional IRt/c can be added to control the sealing much more accurately as the machine begins to increase speed. The technique is as follows:

1. During start-up, control the heaters using the sensors directly measuring the heaters.
2. As the machine speeds up, switch temperature measurement for the heater control system to a "run speed IRt/c". This sensor is aimed directly at the actual fin seal, or lap seal, just after it is formed by the heaters. The "run speed IRt/c" will measure the actual seal temperature directly from the seal itself.

#### Explanation

By measuring the actual temperature of the seal during high speed running, the heater control can be very precise, on the order of a few degrees. This will allow very tight tolerance heat sealing. This system will automatically reduce the following possible sources of high speed heat seal error:

- Dirt build-up on the heater sealing surface that impedes heat transfer to the seal
- Packaging material changes in thickness
- Changes in pressure applied to the seal

The control accuracy of this type of high performance system can also allow the use of a wider variety of packaging material compositions on the same machine.

#### IRt/c's - Reliable, Durable

The rugged IRt/c sensors need no power supply, and are designed for years of trouble-free operation in industrial environments.

No maintenance is required. The sealed IRt/c sensors can even be steam-cleaned.

For "dusty" packaging environments, we recommend using the IRt/c.3X or other IRt/c models with built-in air-purge system. With a small amount of air, the sensor window will remain clear.

With the Exergen IRtc2132 temperature controllers, even small packaging machines can now benefit from reliable IRt/c temperature control for thermal sealing of packaging.

If additional technical assistance is needed, please contact Exergen.

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## WEB DRYING - IRT/C'S FOR TRANSPARENT & REFLECTIVE FILMS, PAPER & TEXTILES (OEM & RETROFIT)

By using IRt/c sensor technology, a dramatic increase in high quality output of web processing can be achieved.

- Increase drying speeds up to 20% or more
- Reduce scrap up to 75% or more
- Faster setup time when a new material is setup for processing
- Greater variety of web materials to be processed on the same machine

### BACKGROUND

A common problem in high speed manufacturing of packaging films, paper and textiles, is dryer oven control for high speed drying of adhesives, inks and coatings onto the material.

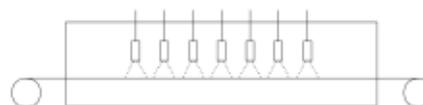
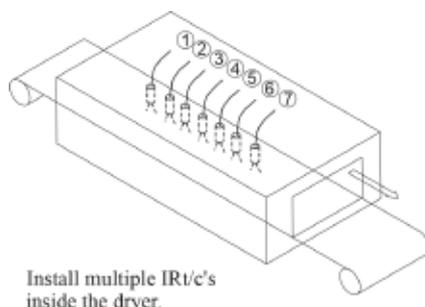
With transparent films, IR sensors tend to “see” right through the film. And the amount of “see through” can vary with the thickness and composition of the film. With metallic films, IR sensors tend to see mostly reflections. These reflections can vary due to the surface condition and composition of the metallic component of the

particular film. Measuring the true temperature of transparent and reflective films is extremely difficult, even with expensive IR sensors with special filtering. **Measuring the drying process, however, is easy with IRt/c sensors.**

### HOW IT WORKS

The key to measuring the drying process of webs is to use multiple IRt/c sensors to get a relative temperature profile. Multiple IRt/c sensors installed in the dryer, allow you to control the drying process with the utmost precision.

What the IRt/c's see: When a coating, even a thin coating, of glue, ink, or other finish is added to a surface, the coating itself becomes visible to IRt/c sensors. The drying characteristics of the coating can be seen even on reflective and transparent films. Even if it is a partial coating, the sensor can still “see” it. (The reason for this is that liquids, even very thin layers of liquids, are highly “emissive”, in other words they absorb and emit IR very well.)



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

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## WEB DRYING - IRT/C'S FOR TRANSPARENT & REFLECTIVE FILMS, PAPER & TEXTILES (OEM & RETROFIT)

Because the IRT/c can see this thin layer, it then becomes easy to use multiple sensors to graphically, or numerically, display a “trend” of what occurs on the surface of the web. It is this “trend” that is important in controlling the drying. A trend plot of relative temperatures in a drying process will always show a lower relative temperature while the coating is drying. The heat energy of the oven, goes into evaporating the carrier of the coating, so the relative temperature indication by the IRT/c is “lower”.

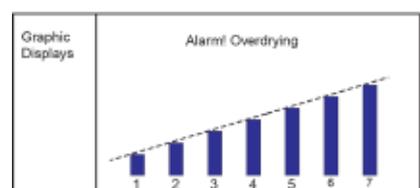
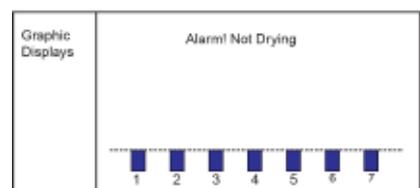
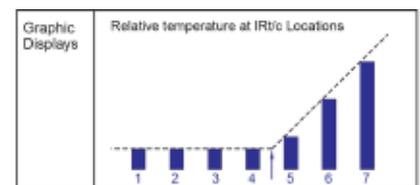
As soon as the coating becomes dry, however, evaporation stops. The heat energy of the oven then goes into heating the coating and substrate. The relative temperature indication by the IRT/c becomes “higher”. These “lower” and “higher” relative temperature indications of the drying process by the IRT/c sensor are totally independent of the emissivity and transmissivity problems for “see through” and “reflective” films. Because of this, the relative temperature information of the IRT/c sensors can reliably be used for accurate drying control. For opaque, non-metallic web materials such as paper and textiles, the IRT/c sensors will also display true web temperature along with the trends.

### MANUAL WEB DRYING CONTROL

Install each IRT/c with an IRTc.2132 controller/display unit, or with an appropriate data acquisition display system, (or other means of display). No calibration is necessary for relative temperature data. The machine operator can then quickly observe the relative temperature trends shown by the IRT/c's and decide if, and where, the web is being dried. To make a decision, the operator simply looks for the characteristic relative temperature change, **sensor to sensor**, to see where the evaporation process stops. If

the sensors show relatively little change, (**sensor to sensor**) all the way through the oven, then the web isn't being dried (i.e. evaporation isn't complete). If the sensors show a steady increase in web temperature from the first sensor position, then the coating is missing, or, is drying so fast that overdrying occurs (and wasting energy!).

Using the sensor display information, the operator can then manually adjust the dryer controls so that the web dryout point is both moved to, and maintained within, the desired location inside the dryer. Manual adjustments based on our sensor display information allow the user to maximize production efforts while minimizing energy costs.



Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## WEB DRYING - IRT/C'S FOR TRANSPARENT & REFLECTIVE FILMS, PAPER & TEXTILES (OEM & RETROFIT)

### AUTOMATIC WEB DRYING CONTROL

Install the IRT/c sensors and connect to a PLC or industrial computer. No calibration is necessary for relative temperature data. Write a short program to calculate the temperature difference from sensor to sensor in this way:

$((T3-T2)-(T2-T1))$ ,  $((T4-T3)-(T3-T2))$ ,  $((T5-T4)-(T4-T3))$ , etc. These calculations represent the change in "slope" from sensor-to-sensor for relative temperatures of each sensor.

The maximum value found for  $((T3-T2)-(T2-T1))$ ,  $((T4-T3)-(T3-T2))$ ,  $((T5-T4)-(T4-T3))$ , etc., tells precisely where the "dryout point" of the web is occurring in the oven.

With some quick tests on actual product, the program can be further refined to fit the drying profiles more precisely, such as setting a minimum or maximum value for the changes in slope for startup conditions, high speed, etc.

### INSTALLATION GUIDELINES

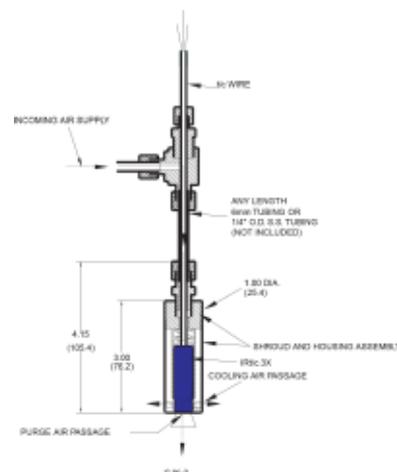
1. Select enough sensors to give relative temperature indication over the length of the oven. For maximum control of long ovens, we recommend at least one sensor every 20 inches (0.5 meters). For compact, high speed drying ovens where control has to be very precise because drying must occur within a very short distance on the web, we recommend sensors be spaced about every 6 inches (15 cm), or less.
2. We recommend that the sensors be installed right inside the oven, if possible, as close as possible to the web. By mounting sensors close to the target web, other minor sources of

IR errors are minimized. (IRT/c sensors can be installed inside drying ovens up to 750 F (450 C) with air cooling alone.) We recommend using the IRT/c.3X model for web drying. If this is not possible, IRT/c's can be installed outside the oven, looking through a sight tube at the web. Select an IRT/c model with a field of view that can look down the sight tube at the web.

3. For internal oven air drying temperatures up to 212 F (100 C), the sensors can be installed inside the oven with no air cooling. Select the IRT/c.3X (or IRT/c.3SV for tight spaces) sensors and use the built-in air purges to keep the sensor window clean for zero maintenance.
4. For internal oven air drying temperatures above 212 F (100 C) select the IRT/c.3X sensor with the CJK-2 (air cooling jacket kit). This combination will allow the sensor to be kept clean and cool in up to 750 F (450 C) drying ovens with air only.

### IRT/c's - RELIABLE, DURABLE

The rugged IRT/c sensors need no power supply, no periodic calibration, and are designed for years of trouble-free operation with all types of dryer ovens. For additional technical assistance, please contact Exergen.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com  
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## IRT/C'S -- USE WITH HEATED METAL ROLLERS / WEB PROCESSES TO INCREASE PRODUCTION (OEM & RETROFIT)

By using IRt/c sensor technology, a dramatic increase in high quality output of web processing can be achieved. Use the IRt/c's with chrome-plated, stainless steel, or other uncoated metal rollers as well as with coated rollers. IRt/c systems enable the user to:

- **Increase throughput speeds up to 20%, or more, on the same machine**
- **Reduce scrap up to 75% or more**
- **Shorten set-up times**
- **Process a greater variety of web materials on the same machine**

Applications / Processes that would benefit from the use of IRt/c technology:

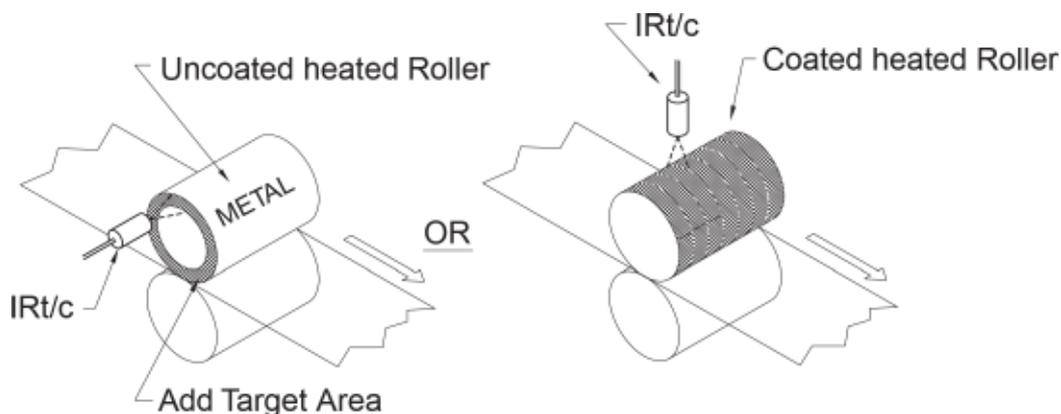
- **Textile Processing**
- **Paper Processing**
- **Opaque Films Processing**
- **Any continuous web processes using heated (or cooled) rollers**

Use of Exergen's unique patented, non-contact infrared sensors solves past technical difficulties associated with temperature measurement of shiny, uncoated metal rollers (due to the high infrared reflectivity of the uncoated metal surfaces). Exergen has developed and tested a two stage approach to accurately measure and control the heat output of heated (or cooled) metal rollers using our IRt/c's—even at very high speeds.

### Stage 1: START-UP and STAND-BY Temperature Control

During start-up and stand-by conditions, the temperature of the heated roller will become fairly uniform throughout the roller surfaces. Because of this, the temperature can be reliably measured at any convenient location on the surface, or the edge, of the rollers.

So, for **Stage 1**, simply install an IRt/c so that it can see a reliable signal from the roller.



Stage 1: Start-up, Stand-by

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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## IRT/C'S -- USE WITH HEATED METAL ROLLERS / WEB PROCESSES TO INCREASE PRODUCTION (OEM & RETROFIT)

### UNCOATED METAL ROLLERS

On an unused edge of the roller, install a durable non-metallic target surface finish. This can be done with:

1. a durable epoxy paint
2. the addition of a thin metallic hoop, or ring, with a Teflon coating
3. or the addition of a thin hoop, or ring, of black, hard-anodized aluminum.

Install an IRT/c sensor so that it looks at this coated surface. Use this sensor to control the temperature of the roller during start-up and stand-by modes

**COATED METAL ROLLERS** (silicon coating, Teflon, any non-metallic coating, etc.)

Install an IRT/c to aim at the center, or any convenient location, on the surface of the roller.

### Stage 2: RUNNING Temperature Control

For **Stage 2**, install an additional IRT/c sensor to look directly at the web surface after it contacts the heated roller. **As the web begins to move**, (or, at a preset rpm) the **temperature control system for the roller should be switched over to a control system connected to this IRT/c sensor**.

This IRT/c sensor should be mounted so that it looks at the side of the web material that is heated by the roller. For webs heated on two sides, sensors should be mounted on each side to control each heated roller.

**For wide webs:** multiple IRT/c sensors can be installed across the web.

**For multi-zone rollers:** use at least one IRT/c for each zone across the web.

### Explanation

The most common errors in web processing are as follows:

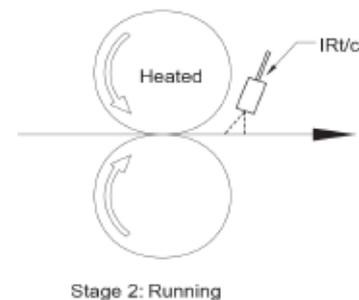
**Temperature Measurement Errors** - errors due to incorrect temperature measurement.

- Thermocouple "Slip ring" signal errors
- Internal temperature sensor location errors

**Heat Transfer Errors** - errors caused by variations of heat transfer to the web.

- Web material changes in thickness, moisture content, etc.
- Dirt build-up on the heater roller surface that can impede heat transfer to the web
- Changes in pressure applied to the web as it contacts the heated roller

As the roller speeds up, heat is removed from the roller surface by the web material. Temperature gradients appear inside the roller, and on the roller surface. Conventional embedded, surface, or edge temperature sensors cannot adequately track and compensate for all these temperature variations, nor can they adequately measure the amount of heat transferred to the web material. Exergen's Two Stage IRT/c Sensor & Control System automatically reduces all these sources of web temperature processing errors. Thus, the actual temperature of the webs can be both tightly (to within a few degrees) and consistently controlled through the use of IRT/c sensor technology. The rugged IRT/c sensors need no power supply, no periodic calibration, and are designed for years of trouble-free operation. For additional technical assistance, please contact Exergen.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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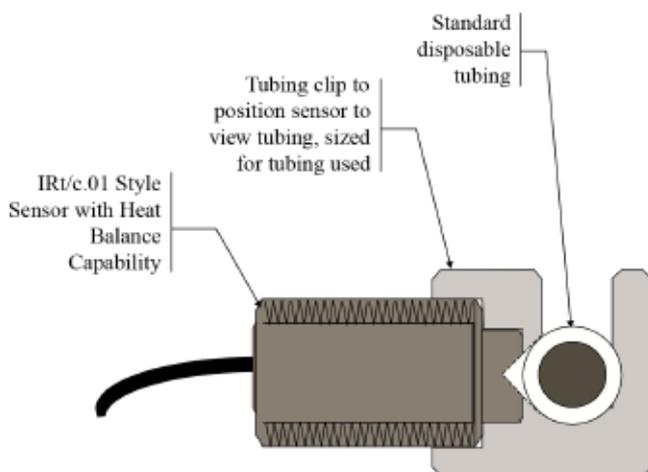
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## IRT/C HEAT BALANCE SERIES FOR MEDICAL APPLICATIONS

The Heat Balance (HB) Series of IRt/c infrared thermocouples have the ability to measure the **internal temperature** of the target material, non-invasively, by employing a patented heat balance technique. A typical application in medical equipment is monitoring or controlling the temperature of fluid transported through disposable tubing when warming or cooling:

- Transfusion systems
- IV warming systems
- Dialysis systems
- Cardio-pulmonary bypass systems
- ECMO systems
- Blood analyzers

The IRt/c.01HB model pictured, actually measures the internal fluid temperature by measuring both tubing surface and ambient temperatures then calculating the internal temperature necessary to maintain the heat balance. A convenient clip head provides a reproducible mounting location for the sensor and can be quickly attached to new tubing and removed from used tubing.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## IRT/C HEAT BALANCE SERIES FOR MEDICAL APPLICATIONS

### Principles of Operation

Fluid at temperature  $T_f$  flowing in tubing transfers heat via convection through thermal resistance  $R_f$  to the tubing inside surface, which in turn conducts heat to the tubing external surface through thermal resistance  $R_t$ , which then transfers to the environment via radiation and convection thermal resistance  $R_o$ . The temperatures of the wetted surface of the tubing, outside surface of the tubing, and the local ambient are given by  $T_w$ ,  $T_s$ , and  $T_a$ , respectively.

Employing the method of thermal analysis with electrical analogs: current = heat flow, and voltage = temperature, the heat transfer equation may be written as follows:

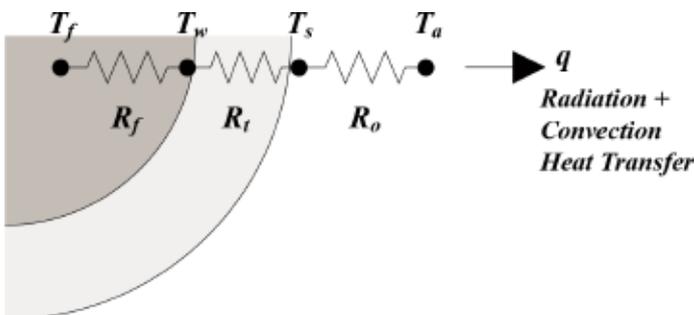
$$q = \frac{1}{R_f + R_t + R_o} (T_f - T_a)$$

and via heat balance:

$$= \frac{1}{R_o} (T_s - T_a)$$

Accordingly,

$$T_f = \frac{R_f + R_t + R_o}{R_o} (T_s - T_a) + T_a$$



The IRT/c-HB Series measures both  $T_s$  and  $T_a$ , and solves this equation automatically for fluid temperature

$T_f$ , providing a highly accurate method of monitoring or controlling the temperature of interest.

The configuration shown above is the model IRT/c.01HB-J-37C with its convenient tubing clip. Any of the IRT/c models can be configured for the HB calculation. Contact the factory for further details.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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## ACCURATE TEMPERATURE CONTROL IN WATERLESS PRINTING WITH IRT/C SENSORS: HOW TO INCREASE PRINTING SPEED

By Francesco Pompei, Exergen Corporation

At the heart of waterless printing is the requirement for accurate temperature control of the ink roller system due to the importance of maintaining proper viscosity. A significant barrier to improvement in the quality of ink temperature control for waterless printing systems is the delay caused by the mass of the roller, especially when increasing speeds.

Water-cooled systems are particularly subject to this delay since the roll is cooled from the inside, and the entire mass of the roll must change temperature in order to control the surface, where the ink properties are, of course, determined. Air-cooled systems are less influenced by the delay, but still require an optimal control strategy to maximize speed.

At the heart of the temperature control are non-contact infrared sensors that are designed specifically for the waterless printing application. One such model is the IRT/c-WP series from Exergen, which is the most accurate available. The discussions below use these sensors.

### Water-Cooled Systems

A change in temperature on the cooled roller outside surface  $T_s$ , will be sensed by the IRT/c infrared sensor within a tenth of a second, and the correction to the water cooling temperature  $T_w$  will occur within a few seconds. However, the entire mass of the roll must change temperature from the inside-out before the surface can change and thus correct the temperature of the ink – a

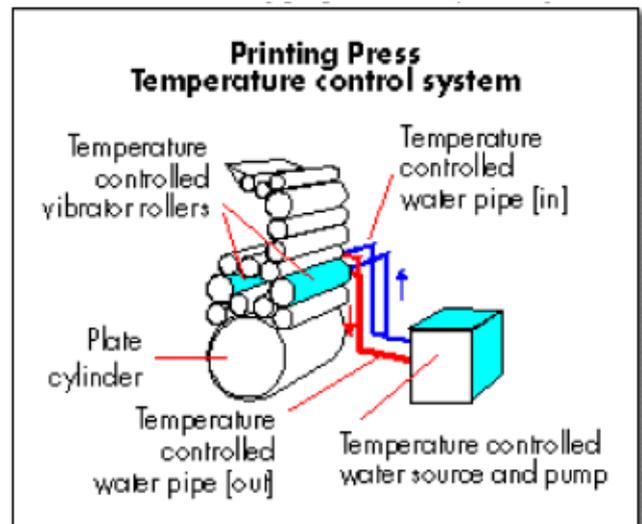


Figure 0 system. Systems and presses will vary in terms of the vibrators which receive temperature

process requiring several minutes. The several minutes that the temperature is incorrect may cause reduced quality printing, and thus prevent operation at higher speeds.

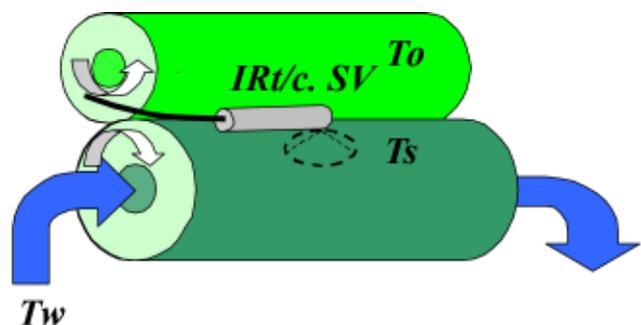


Figure 2. Cooling roll controlled by IRT/c sensing inked surface temperature.

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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## ACCURATE TEMPERATURE CONTROL IN WATERLESS PRINTING WITH IRT/C SENSORS: HOW TO INCREASE PRINTING SPEED

The remedy for this problem is the application of the *Speed Boost Equation™* (see [www.exergenglobal.com](http://www.exergenglobal.com) for details):

$$V^* = \frac{T_\infty - T_s}{T_s - T_o} \quad \text{Eq. 1}$$

where  $V^*$  is relative speed,  $T_\infty$  is the temperature of the energy source,  $T_s$  the temperature of the surface, and  $T_o$  the temperature of the feed material into the process. For the example in the diagram, the cooling water  $T_w$  is the energy source.

Accordingly, if the speed of the roll  $V$  is measured and available to the temperature control system, the Speed Boost Equation then becomes:

$$V = K \frac{T_w - T_s}{T_s - T_o} \quad \text{Eq. 2}$$

where  $K$  is a proportionality constant.

Then the control equation for the water temperature  $T_w$  becomes:

$$\begin{aligned} T_w &= \frac{V}{K}(T_s - T_o) + T_s \\ &= \left(1 + \frac{V}{K}\right)T_s - \frac{V}{K}T_o \end{aligned} \quad \text{Eq. 3}$$

Accordingly, any change in  $V$  should be accompanied by an immediate change in  $T_w$  in accordance with the above equation. In the same manner, a control loop gain in response to a change in  $T_s$  at constant  $V$  can be immediately established by selecting  $(1+V/K)$ , taking care to account for the offset  $((-V/K)*T_o)$ . This strategy assumes that the ink feed temperature  $T_o$  is sufficiently constant to be treated as constant.

Adding the control loop PID contribution to correct the value of  $T_w$  in response to minor perturbations, we end with which is the governing control equation.

$$T_w = \frac{V}{K}(T_s - T_o) + T_s + PID(T_s - T_{setpoint}) \quad \text{Eq. 4}$$

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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## ACCURATE TEMPERATURE CONTROL IN WATERLESS PRINTING WITH IRT/C SENSORS: HOW TO INCREASE PRINTING SPEED

### Variable Feed Roll Temperature To

As is the case in many high performance installations, the feed roll temperature is not always constant, since friction from the rolls will gradually warm the rolls. Accordingly, to further improve performance, the addition of a second IRT/c is recommended to monitor the feed roll temperature  $T_o$ . With this additional sensor, equation 4 is again employed, but  $T_o$  is treated as variable and its value measured by a second IRT/c. This measure is recommended when the quantity in the denominator of equation 2 ( $T_s - T_o$ ) is less than  $\sim 10$  C, and is greater than the quantity in the numerator ( $T_w - T_s$ ). This situation will exist as the speed  $V$  is increased and the heat transfer characteristics of the roll are improved.

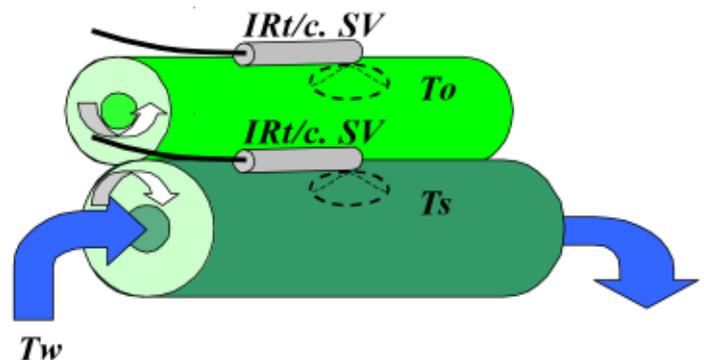


Figure 3. Higher performance cooling system with both  $T_s$  and  $T_o$  monitored with IRT/c sensors.

### Maximal Speed and Performance Strategy

For maximum print speeds at maximum quality, the quantities  $(T_w - T_s)$  and  $(T_s - T_o)$  must be accurately controlled under all conditions. The PID feedback control is not sufficient since at maximum speeds the feedback requires significant time to respond due to the thermal lag of the roller from the inside to the outer surface, and will produce ink temperature errors and thus poor quality.

The IRT/c sensors provide an elegantly simple and robust method of achieving the maximal accuracy by employing their inherent thermocouple character. Rewriting equation 4:

$$(T_w - T_s) = \frac{V}{K}(T_s - T_o) + PID(T_s - T_{setpoint}) \quad \text{Eq. 5}$$

#### Exergen Global offices:

The Netherlands  
 Pastoor Clercxstraat 26  
 5465 RH Veghel  
 Tel: +31(0) 413 37 65 99  
 Fax: +31(0) 413 37 93 10

USA  
 400 Pleasant Street  
 Watertown, MA 02472  
 Tel: +1 617 649 6322  
 Fax: +1 617 923 9911

office@exergenglobal.com  
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## ACCURATE TEMPERATURE CONTROL IN WATERLESS PRINTING WITH IRT/C SENSORS: HOW TO INCREASE PRINTING SPEED

we see that the critical temperatures for control are the differences ( $T_w - T_s$ ) and ( $T_s - T_o$ ), with the PID feedback a small trim on the setpoint of  $T_s$ . From basic thermocouple characteristics we can directly measure these temperature differences with accuracy of order 0.1C by simply wiring IRT/c's differentially as common thermocouples.

Further, the feed water temperature  $T_w$  may be measured by an ordinary immersion thermocouple, then wired in series with an IRT/c monitoring  $T_s$  to produce a direct signal for ( $T_w - T_s$ ).

The end result from the application of the Speed Boost Equation is balanced cooling input that correctly adjusts the flow of heat to maintain consistent balance in the heat into and out of the roll surface. With this balance, temperature control is maintained accurately, and speed may be increased to maximal values permissible by the press without loss of quality.

### Air-Cooled Systems

Air cooling systems have the significant advantage that there is less delay in response to a cooling load change, since only the immediate surface must change temperature. However, the roll does require re-establishment of distribution of temperature around the roll as conditions change, especially speed, and therefore optimal control requires the Speed Boost method.

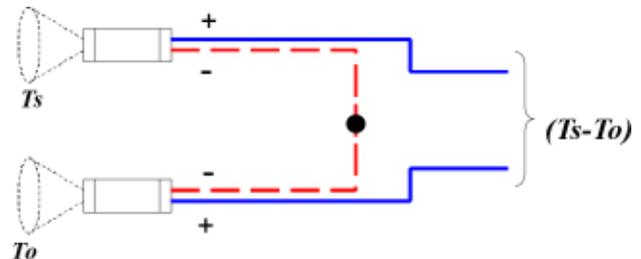


Figure 4. IRT/c's wired differentially to produce a direct and accurate signal for ( $T_s - T_o$ ).

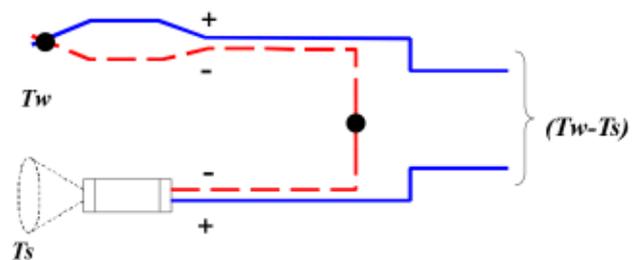


Figure 5. IRT/c and thermocouple wired differentially to produce a direct and accurate signal for ( $T_w - T_s$ ).

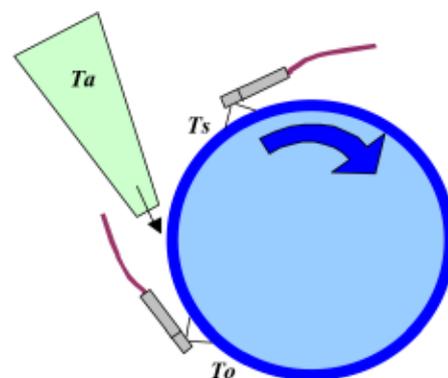


Figure 6. Air-cooled arrangement showing two IRT/c's monitoring the roll surface temperature just prior to the air jet ( $T_o$ ) and just after the air ( $T_s$ ). The air supply temperature ( $T_a$ ) can be monitored with a standard thermocouple.

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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## ACCURATE TEMPERATURE CONTROL IN WATERLESS PRINTING WITH IRT/C SENSORS: HOW TO INCREASE PRINTING SPEED

Applying again eq. 1,

$$V^* = \frac{T_\infty - T_s}{T_s - T_o}$$

and referring to the temperatures in Figure 6, the equation can be re-written as

$$V = K \frac{T_a - T_s}{T_s - T_o} \quad \text{Eq. 6}$$

where  $K$  is the proportionality constant.

Then the control equation for the air temperature  $T_a$  becomes:

$$\begin{aligned} T_a &= \frac{V}{K}(T_s - T_o) + T_s \\ &= \left(1 + \frac{V}{K}\right)T_s - \frac{V}{K}T_o \end{aligned} \quad \text{Eq. 7}$$

Accordingly, any change in  $V$  should be accompanied by an immediate change in air temperature  $T_a$  in accordance with the above equation.

Adding the control loop PID contribution to correct the value of  $T_a$  in response to minor perturbations, we end with

$$T_a = \frac{V}{K}(T_s - T_o) + T_s + PID(T_s - T_{setpoint}) \quad \text{Eq. 8}$$

which is a form of governing control equation that can be applied. The differential IRT/c wiring illustrated in Figures 4 and 5 is the method of choice to assure highest possible performance in controlling for quality and speed. By adding the air temperature  $T_a$  as a thermocouple, and a second IRT/c for  $T_s$ , then the governing equation becomes

$$(T_a - T_s) = \frac{V}{K}(T_s - T_o) + PID(T_s - T_{setpoint}) \quad \text{Eq. 9}$$

and the performance is the highest possible speed with the best possible quality.

Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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**Exergen Global offices:**

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

## OFFSET, DIGITAL, INKJET DRYING PROCESS

### General Information

For high speed printing processes, the limiting factor on the productivity of the equipment is usually ink drying time. To maximize printing speed without quality loss, it is important to be able to determine quickly when the printed substrate is sufficiently dry or fused.

The surface temperature of a “wet” substrate will change (rise) very slowly as constant heat is applied to the product. This occurs because the moisture in the substrate absorbs much of the heat energy as it evaporates.

At the point that the substrate becomes ‘dry’, however, the same constant heat supply will quickly raise the temperature until it reaches the same as the surrounding air.

### The Optimal Solution

Infrared temperature sensors will allow for fast measurement and no contact with the product.

With the response time of the IRT/cs averaging around 100 milliseconds, you can quickly detect the dry out point and increase your production speed and yield.

You can also find the ‘dry out’ point by installing an array of IRT/cs, and with the side view mounted sensors you can reach hard to access areas on any web process.



### Why Exergen IR Non-Contact Sensors?

- IRT/cs are self powered and intrinsically safe
- Repeatability error of 0.01°C (0.02°F)
- Interchangeability error  $\pm 1\%$
- Resolution of approx. 0.0001°C
- Side view sensors if the available space is limited
- All sensors are CE and RoHS rated

### Commercial Advantages

Increase:

- production by increasing the printing speed
- quality of the end product
- yield
- profit

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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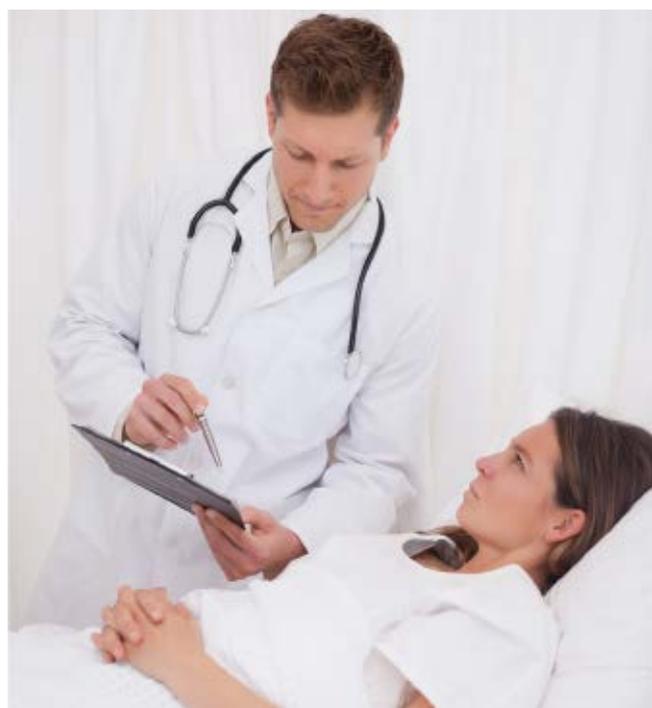
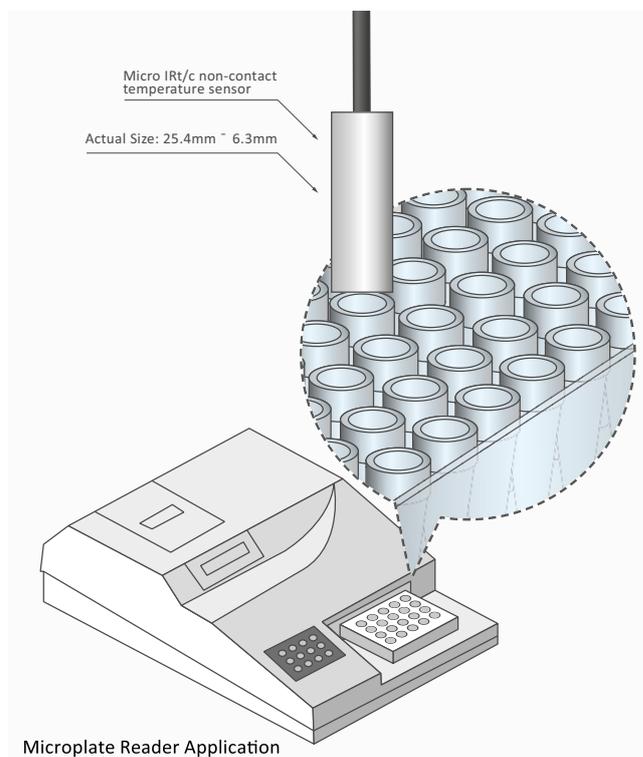
## PLATE READERS

### General Information

For many plate reader assays performed in (hospital) laboratories it is essential to monitor and control the temperature of liquid samples accurately. In plate readers the results of assays can be affected by temperature fluctuations of the samples, risking faulty diagnosis for patients. Governments are installing strict regulations for laboratories to control the temperature in their laboratory instruments. Contact thermometers are ruled out as they contaminate the samples and influence the temperature of the samples. Exergen noncontact infra-red temperature sensors are the only available option to measure sample temperature accurately.

### The Optimal Solution

IRt/c sensors are used to monitor the changes in, and quickly detect, fluctuations in sample temperature, allowing accurate control of the actual sample temperature. In a plate reader the micro IRt/c is placed above a single well allowing individual sample monitoring up to 0.1°C accuracy, or to measure if a temperature gradient over the microtiter plate exists.



### Why Exergen IR Non-Contact Sensors?

- Non contact – no sample contamination or obstruction of moving objects
- IRt/cs are self powered and intrinsically safe
- Repeatability error of 0.01°C (0.02°F)
- Interchangeability error  $\pm$  1%
- Resolution of approx. 0.0001°C
- Side view sensors if the available space is limited

### Commercial Advantages

Increase:

- assay speed: monitor when the sample has reached the required temperature to immediately start the assay
- yield: fewer assays will fail due to temperature fluctuations
- quality: you can prove that you are safely within the prescribed temperature ranges.
- profit

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## NON-CONTACT DOUGH MEASUREMENT

### General Information

Measuring the temperature of bread and pastry dough while mixing is important since too high a temperature will cause too much rise, resulting in holes in the baked product, and too low a temperature will not allow the dough to rise sufficiently, resulting in a baked product that is flat. Measuring temperature with conventional contact t/c probes, due to breakage and contamination of the food. IRt/c improves profitability by monitoring temperature without contact, thus completely eliminating breakage and contamination, and control mixing speed motors to maintain proper dough quality and throughput.

### The Optimal Solution

When the kneader is charged with the flour/meal and the other ingredients, a very accurate amount of water with a specific temperature is added. After a few minutes the ingredients are kneaded into a solid mass. The dough temperature rises as a result of the frictional heat.

With the IRt/c.5 sensor the dough temperature is measured constantly and accurately so the kneading can be stopped when the dough reaches the specified temperature.

As the dough is not homogeneous the temperature will differ from place to place. The IR sensor overcomes this problem by measuring an average temperature of a part of the dough.



### Why Exergen IR Non-Contact Sensors?

- Non contact measuring: no errors occur in relation to frictional heat
- Quick, continuous measurement every 100ms
- Accuracy of 0.1°C
- High repeatability: 0.1°C/ automatic calibration
- Easy to mount on cover, lid or kneader arm
- Built-in air purge for self cleaning lens
- No cleaning needed

### Commercial Advantages

- Longer life than a PT100
- Shorter total setting-time other machinery
- Smaller waste figures, less losses, more profits
- Shorter operation times

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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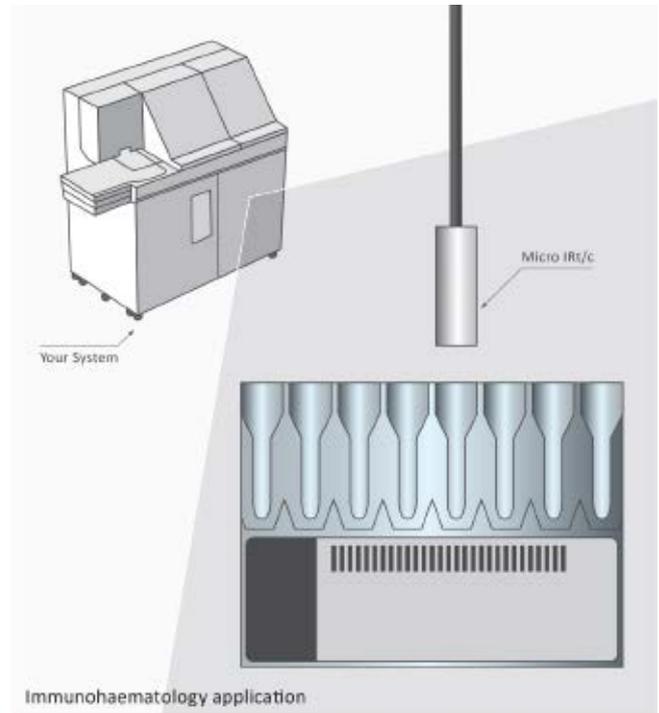
### (IMMUNO) HAEMATOLOGY

#### General Information

For many medical biochemical assays performed in hospital laboratories it is essential to monitor and control the temperature of liquid samples accurately. In haematology instruments the results of assays can be affected by temperature fluctuations of the samples, risking faulty diagnosis for patients. Governments are installing strict regulations for laboratories to control the temperature in their diagnostic instruments. Contact thermometers are ruled out as they contaminate the samples and influence the temperature of the samples. Exergen non-contact infrared temperature sensors are the only available option to measure sample temperature accurately.

#### The Optimal Solution

IRt/c sensors are used to monitor the changes in, and quickly detect, fluctuations in sample temperature, allowing accurate control of the actual sample temperature. In a haematology machine the micro IRt/c is placed above a single well allowing individual sample monitoring up to 0.1°C accuracy.



#### Why Exergen IR Non-Contact Sensors?

- Non contact – no sample contamination or obstruction of moving objects
- IRt/cs are self powered and intrinsically safe
- Repeatability error of 0.01°C (0.02°F)
- Interchangeability error  $\pm 1\%$
- Resolution of approx. 0.0001°C
- Side view sensors if the available space is limited

#### Commercial Advantages

##### Increase

- assay speed: monitor when the sample has reached the required temperature to immediately start the assay
- yield: fewer assays will fail due to temperature fluctuations
- quality: you can prove that you are safely within the prescribed temperature ranges.
- profit

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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### SKIN TREATMENT SYSTEMS

#### General Information

Many medical or cosmetic skin treatment therapies (e.g. hair removal therapies, cellulite and acne treatment, skin rejuvenation) induce heat in one or more layers of the skin. This has beneficial effects as part of the treatment, but there's a risk that the skin will be overheated, causing discomfort, pain and in the worst case injuries.

To prevent overheating of the skin, its temperature must be monitored throughout the treatment.

Contact thermometers are ruled out as they are fixed to one position, while the probe for the therapy is moved over the skin. Exergen non-contact infra red temperature sensors are the only available option to measure sample temperature accurately.



#### The Optimal Solution

IRt/c sensors are used to monitor the temperature of the skin during the treatment. Based on the actual skin temperature, the therapy intensity can be adjusted to prevent overheating. For example, in a cellulite treatment probe the Micro IRt/c sensor is placed above the skin to monitor the temperature up to 0,5°C accuracy.

#### Why Exergen IR Non-Contact Sensors?

- Non contact – no skin contact or interference with treatment
- IRt/c's are self powered and intrinsically safe
- Repeatability error of 0,01°C (0.02°F)
- Interchangeability error ± 1%
- Resolution of approx. 0,05°C
- Small size to fit in the limited available space



#### Commercial Advantages

Increase

- safety: you can prove that you are safely within the prescribed temperature ranges
- assay speed: shorten treatment sessions by using the minimum allowed power.
- yield: fewer sessions will fail due to temperature issues
- profit – gain more trust from the specialists that use the system

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## OFFSET, DIGITAL, INKJET DRYING PROCESS

### General Information

For high speed graphic processes, the limiting factor on the productivity of the equipment is usually the drying/curing time. To maximize the speed without quality loss, it is important to be able to determine quickly when the substrate is sufficiently dry or cured.

For instance: the surface temperature of a "wet" substrate will change (rise) very slowly as constant heat is applied to the product. This occurs because the moisture in the substrate absorbs much of the heat energy as it evaporates. At the point that the substrate becomes 'dry', however, the same constant heat supply will quickly raise the temperature until it reaches the same as the surrounding air.

### The Optimal Solution

Infrared temperature sensors will allow for fast measurement and no contact with the product.

With the response time of the IRt/c's averaging around 100 milliseconds, you can quickly detect the exact temperature point and increase your production speed and yield.

For drying applications you can also find the 'dry out' point by installing an array of IRt/c's, and with the side view mounted sensors you can reach hard to access areas on any web process.



### Why Exergen IR Non-Contact Sensors?

- IRt/c's are self powered and intrinsically safe
- Repeatability error of 0.01°C (0.02°F)
- Interchangeability error ± 1%
- Resolution of approx. 0.0001°C
- Side view sensors if the available space is limited
- All sensors are CE and RoHS rated

### Commercial Advantages

- Increase production by increasing the drying speed
- Increase the quality of the end product
- Increase your yield
- Increase your profit



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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# INFRARED FIXATION ON LARGE FORMAT PRINTERS

## General Information

Flags, carpet, tiles and everything else that is printed on Large Format Printers with protective paint needs to be completely dried, cured or fixated before the end-products can be cut, folded, or otherwise worked on. Depending on the paint, most of the inks are water based and short- or middle wavelength IR lamps can be used for drying. Many of these processes are performed at low speed and at low temperatures, so the surface temperature of the printed material will change very slowly and the entire process will take a long time. Other challenges that often occur is that the end-quality is unpredictable since operators don't know when the printed material is dry.

## The Optimal Solution

The use of infrared temperature measurement methods in production processes is limited to material surfaces and thus has serious limitations in thermal process monitoring, particularly when speed increases are factored in. However, the right Infrared Non-Contact Temperature Sensor that can work at a speeds up to 50msec, will enable high speed curing, drying or fixation at high temperatures. Non-contact IR sensors also ensure the highest quality results with little to no processing errors and therefore less wasted material and less energy usage.



## Why Exergen IR Non-Contact Sensors?

- Non contact measuring: There is no other way to measure
- Quick, continuous measurement every 50ms / 100ms
- Accuracy of 0.1°C
- High repeatability: 0.1°C/ automatic calibration
- Easy to mount
- Built-in air purge for self cleaning lens
- No cleaning needed

## Commercial Advantages

- Optimal quality
- Higher speed > More production
- Smaller waste figures, less losses, more profits
- Shorter operation times

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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# GRINDING USED PLASTICS IN GRANULATION MACHINES FOR RECYCLING

## General Information

A significant amount of heat is created when PET bottles or other used plastics are ground for recycling using a granulation machines. When operators increase the granulation grinding wheel speed in order to maximize machine throughput, the temperature of the ground plastic increases further.

The heat that is generated during this process must be measured and controlled to prevent the plastics from melting and blocking, or perhaps even destroying, the machine. A good control system will find the right balance between the operating speed and the temperature of the plastic.

The basis of this control system is reliable temperature measurement.

## The Optimal Solution

The most accurate way to determine the temperature of the ground plastic in the machine is to measure the plastic itself using a non-contact sensor. Non-contact measurement is preferable to measuring any indirect reference point in the machine using a contact sensor. A contact sensor reacts much more slowly than an Infrared non-contact sensing solution and can actually be too slow to react to the dynamics of the process.



## Why Exergen IR Non-Contact Sensors?

Infrared sensors are not all alike. For example, one of the challenges commonly encountered using Infrared temperature sensors is thermal shock. Thermal shock occurs because many Infrared temperature sensors have issues with rapid ambient temperature change and register false readings for a long period before returning to a steady state.

Exergen Infrared temperature sensors have a unique (patented) method of compensating for ambient temperature fluctuation and minimizing its impact on the reading. With this technology, temperature reading continuity can be guaranteed, even under harsh thermal conditions such as the cold in Alaska or the heat in the Saharan desert.

An additional benefit to using Exergen sensors is the fact that they do not need any calibration. These sensors are passive devices that have no drift; not in 1 year and not in 10 years.

Exergen sensors are also interchangeable (interchangeability error  $\pm 1\%$ ) so if a sensor ever needed to be replaced due to, for example, mechanical damage, a new sensor can be ordered with exactly the same specifications, allowing a simple drop in replacement, with no programming or calibration required.

## Commercial Advantages

- Increased production throughput in a secure, controlled manner
- A robust solution ideal for harsh conditions
- Sensor does not need service or calibration in the field, saving cost and increasing reliability
- Easy replacement in case of a damaged sensor

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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AN-604-EN-V0

# MEASURING BLOOD TEMPERATURE IN PERFUSION SYSTEMS

## General Information

When supplying blood to patients it is essential that the blood's temperature is carefully warmed to 37°C to ensure patient safety and wellbeing.

Blood must be warmed to this temperature prior to infusion, because, depending on its source, the blood can be at room temperature, refrigerated or any temperature in between. If the infused temperature is too low or too high, the risk of hypothermia or hyperthermia increases, presenting possible complications or even patient shock.

To ensure that the correct blood temperature is maintained from start to finish, the amount of heat applied to the blood must be tightly controlled, and be adjusted to the flow and inlet temperature of the donor blood. The foundation of efficient and effective blood temperature management is a well-controlled heat exchange and a reliable temperature measurement mechanism.

## The Optimal Solution

For a variety of reasons, it's preferable to measure blood temperature non-invasively. Non-contact temperature sensors are ideally suited to this application and have many advantages over invasive sensors, chief among them the fact that sterility is guaranteed as the sensor has no contact with the bloodstream. Additionally, while contact sensors are disposable, non-contact sensors can be re-used, which amounts to big cost savings. Non-contact sensors are mounted at critical locations in the perfusion system, allowing very easy and fast 'click-on' of disposable tubing, which is critical in trauma situations.



## Why Exergen IR Non-Contact Sensors?

Exergen has developed a special sensor, called the heat balance sensor, which measures blood temperature through tubing. This sensor provides the accuracy and reliability required for the best possible heating control in the perfusion system, ensuring optimal safety for the patient.

Exergen Infrared temperature sensors also have a unique (patented) method of compensating for ambient temperature fluctuations to minimize their effects on the reading, and guarantee temperature measurement continuity. Whether the perfusion equipment is used in an ambulance, in an air-conditioned operating room, or under harsh military conditions, Exergen sensors provide accurate control.

An additional benefit to using Exergen's non-contact sensors is the fact that they do not need any calibration. These sensors are passive devices that have no drift -- not in 1 year and not in 10 years. Exergen sensors are also interchangeable (interchangeability error +/-1%) so if a sensor ever needed to be replaced due to, for example, mechanical damage, a new sensor can be ordered with exactly the same specifications, allowing a simple drop-in replacement, with no programming or calibration required.

## Commercial Advantages

- Guaranteed patient safety under all conditions
- Non-invasive and therefore sterile
- Re-useable solution for greater cost effectiveness allows for very fast system operation in critical trauma situations
- Sensor does not need service or calibration in the field, saving costs and increasing reliability

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## FLYWHEEL/BEARINGS

### General Information

A flywheel is a rotating mechanical device that is used to store energy. Energy is transferred to a flywheel by applying torque to it, thereby increasing its rotational speed, and hence its stored energy. Conversely, a flywheel releases stored energy by decreasing its rotational speed.

Flywheel energy storage systems are long-lasting, low-maintenance, and environmentally-sound alternatives to batteries in uninterruptible power supply systems.

A prerequisite for long-lasting optimal performance in flywheels is minimized friction. High performance bearings are used in flywheels for efficiency, to reduce wear and to facilitate extended use at high speeds. However, worn bearings can have a significantly negative impact on flywheel performance and longevity, so it is essential to monitor the state of the bearing. Measuring the temperature is the preferred way to detect overheating and premature bearing failure.

### The Optimal Solution

Since the bearing's critical components are rotating, its temperature can only be measured by use of a non-contact, infrared temperature sensor. Given the compact design of the bearing there is not much space available to position the sensor, so a small sensor is required.

To reduce friction, the flywheel and bearing are placed in a vacuum. The sensor solution should be able to perform in vacuum conditions, and be allowed to be placed inside the bearing cavity without disrupting the vacuum.

Since energy supply and demand increases and decreases rapidly in a flywheel energy system, a temperature sensor that can respond rapidly is needed.



### Why Exergen IR Non-Contact Sensors?

Exergen's non contact Micro IRt/c sensors are the smallest sensors available on the market and are ideally suited to measure rotating components in confined spaces. The IRt/c is hermetically sealed and exceeds NEMA 4X, IP67 – meaning that they can be used in harsh environments, including applications performed in a vacuum.

With response times ranging from 25 to 100 milliseconds, IRt/c's are ideally suited to the task. Further advantages of the IRt/c are:

- Self-powered and intrinsically safe, no service or calibration needed
- Repeatability error of 0.01°C (0.02°F)
- Interchangeability error of +/-1%
- Accurate compensated output signal in dynamic ambient temperature environments

### Commercial Advantages

- Reliable monitoring improves performance
- High speed response in demanding market
- Ability to plan maintenance intelligently and avoid down-time
- Contributor to flywheel lifetime of > 20 years

#### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## PROCESS OF PAPERMAKING

### The Challenge

During the process of papermaking, a dilute fiber suspension is drained through a screen, creating a mat of randomly interwoven fibers. Water is removed from this mat of fibers by pressing and drying it to eventually make paper.

When paper is drying, the remaining water is evaporated using heat. In one method, the paper web is held over dryers that are heated using infrared heating lamps; another method employs steam. In both cases, the challenge is to achieve maximum drying with minimum energy at high speeds, and to ensure that the required paper quality is reached, particularly with respect to moisture profiles and flatness. At the end of the drying process, the paper needs to have a residual moisture of approximately 2% to 9% depending on the grade.

### The Optimal Approach

Measuring the drying process, however, is easy with IRT/c thermal sensors and can be accomplished using multiple sensors to obtain a relative temperature profile. Multiple IRT/c sensors installed in the dryer can control the drying process with the utmost precision, and can do so at greater speeds and with more reliability than contact sensors. The IRT/c can “see” when there is even the smallest amount of water on the paper surface. This is possible because liquids, even very small particles of water, are highly “emissive”, in other words they absorb and emit IR very well.

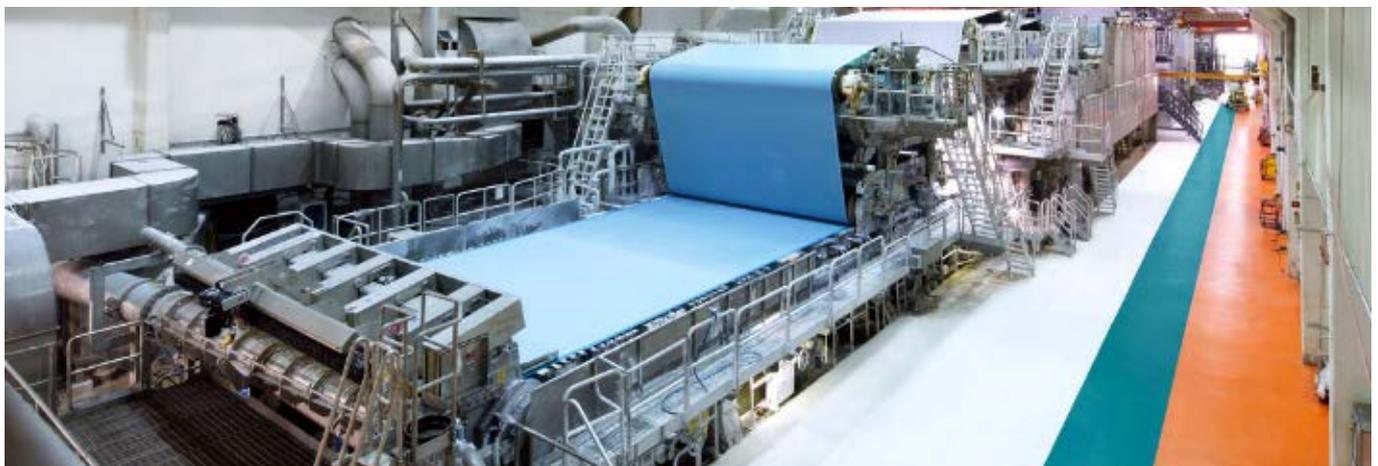


### Solution: IR Non-Contact Sensors

- Non-contact, very fast readings up to 25ms
- Self-powered and intrinsically safe, no service or calibration needed
- Repeatability error of 0.01°C (0.02°F)
- Interchangeability error of +/-1%
- Accurate compensated output signal in dynamic ambient temperature environments

### Commercial Advantages

- Optimized process due to very accurate and fast readings, faster production
- Better yield
- Better quality of the end product.



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## BLOW MOULDING

### General Information

In the process of making PET bottles (polyethylene terephthalate) there is a fine line where the high output per bottle blowing machinery and the requested quality of the bottle come together. Taking into account that such machines must be able to produce a broad range of sizes and shapes and produce various quality bottles, it's obvious that many variables must be kept under control during the process. One of the key parameters to control is the temperature.

### How does this work?

The bottle blowing station machine's infeed starwheel picks up the preforms and transfers them to the preform conveyor belt. Then, while rotating continually, they run through a system intended to uniformly heat up the preform. When a set temperature is reached, the preform is moved to the blow molding section of the machine, where it is molded in the desired shape by applying pressurized air. If the temperature of the preform is not uniform, or has not reached or has exceeded the desired value, the end product will have defects: holes in the bottle if the temperature was too high, not completely extended bottles if the temperature was too low, or variances in the thickness of the bottle if the temperature was not uniform (or combinations of these three). These bottles have to be discarded and this reduces the yield of the machine and increases the waste.

To avoid defects or deformities in the end product, it is essential that the temperature of the preform is monitored and controlled in the heating step prior to molding. This monitoring enables a temperature variance comparison and (if necessary) allows for an automatic correction of the heating parameters, making sure the optimum quality and speed is obtained.



### The Optimal Solution

Since the preforms are moving and rotating, their temperature can only be measured by use of a non-contact, infrared temperature sensor. As small temperature variations during the heating can result in deformities of the end product, it is essential to employ a sensor with high accuracy and speed. The ambient temperature close to the heater can vary significantly and the sensor must be able to deal with these variations without generating measurement errors.

Finally, blow molding machines generally operate 24/7 to optimize yield and profit, so a sensor should be employed that will not create any downtime or require regular maintenance or recalibration.

### Why Exergen IR Non-Contact Sensors?

Exergen's non-contact IRt/c sensors are the most accurate sensors available and are ideally suited to measure moving and rotating objects. The IRt/c's patented Ambient Temperature Compensation methodology ensures optimal performance in varying ambient temperatures. Further advantages of the IRt/c are:

- Self-powered, no service or calibration needed
- Provides response times ranging from 25 to 100 milliseconds that won't slow down the process
- Repeatability error of 0.01°C (0.02°F) – consistent readings now and in 10 years time
- Interchangeability error of +-1% - results will remain the same between different machines.

### Commercial Advantages

- Optimized process due to very accurate and fast readings, faster production
- Better yield, less scrap and waste
- Better quality of the end product.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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### CLEAN MICRO AIR PURGE

#### The Challenge

Infrared temperature sensors are ideally suited for use in manufacturing, textiles, printing and other production settings, providing a highly effective solution to ensure machinery does not overheat or otherwise malfunction. However, oil, thread, dust, airborne chemicals and other debris emitted during production can quickly obscure the IR temperature sensing heads. Even the smallest amount of debris coating a lens can contaminate it and affect the reading: for example, if 5% of the lens area is covered, then 5% of the reading is lost. Additionally, the ambient heat present during production processes can reach as much as 175 degrees C, causing sensors to quickly overheat and produce inaccurate temperature readings. These issues are especially challenging when equipment requires micro IR sensors – typically used in tight areas or for up-close monitoring.

#### The Optimal Approach

To ensure that IR temperature sensor readings remain accurate, the sensing lens must remain clean and ambient temperature must be controlled. Using air to clean the lens and cool the sensor has proven to be a very cost-effective and efficient solution. Air is already available in the majority of production environments, or can be easily and cost-effectively added using low-cost air pumps.



#### Solution: Clean Micro Air-Purge Jacket

Exergen's Clean Micro Air-Purge Jacket provides an easy-to-implement solution that keeps its micro IRT/c sensor lenses cool, clean and debris free, helping to ensure accurate temperature readings and peak performance. The Jacket's small size (3/8" x 3" (9.5 x 76 mm)) fits into tight areas and makes it possible to clean the lens surface with as little as 3.5 SCFH (1.7 L/min) of air. The device is designed to either use available instrument air, eliminating the need for additional hardware, or, in the absence of instrument air, use a small, inexpensive air pump. The airflow through the Air-Purge Jacket not only keeps the lens clean, but also cools the micro IRT/c sensor, allowing it to operate in environments of up to 347°F (175°C). Installing the Clean Micro Air-Purge Jacket is fast and simple, requiring only a standard 3/8" tube fitting or 3/8" ID tubing and an inexpensive, easy-to-use mounting bracket. The Clean Micro Air-Purge Jacket is fully integrated into Exergen's micro IRT/c sensor, passing savings on to customers and enhancing device performance quality.

#### Commercial Advantages Micro Air-Purge

- Significantly reduces sensor maintenance
- Ensures optimal performance for machines and apparatus
- Allows production in higher temperature settings
- Commercially integrated design is higher quality than add-on devices

#### Commercial Advantages Sensors

- Sensors do not need service or calibration in the field, saving costs and increasing reliability
- Interchangeability allows easy replacement in case of a damaged sensor
- Passive devices that are longer life and have no drift
- High repeatability
- MTBF of 1000 years



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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

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# MONITORING TIRE TEMPERATURE FOR RACING PERFORMANCE WITH NON-CONTACT IR/TC SENSORS

## General Information

Tire temperature is of critical concern in automotive racing for two reasons:

1) Tire temperature directly affects the tire's adhesion and wear characteristics. For example, as it takes lap after lap around an oval track, a race car's tires will begin to build up excessive heat in those areas that grip the curves. Temperature readings can help drivers and pit crews know when tires have begun to wear excessively or unevenly, and signal the proper time to bring the car in for a pit stop. By measuring the tire temperature, pit crews can save drivers precious time, ensuring they change the tires at the right moment, not too early, not too late.

2) Tire temperature patterns provide valuable information regarding the set-up and performance of the automobile's suspension. For example, out-of-tune suspension will place excessive loading on a tire and cause that tire to become considerably warmer than the others. The rubber in the areas with excessive load will wear much more quickly than other parts of the tire and will begin to lose their grip. When this occurs, the four tires could wear out differently, requiring the racer to make more frequent pit stops and lose precious time....

## The Optimal Solution

The IRT/c has proven to be an ideal measuring device for on-board data acquisition, due its small size, ruggedness, reliability and low cost. It may be connected to standard thermocouple read-out systems making it easier to read and use. Installation should include connecting the shield to a suitable ground in order to avoid interference from the electrically harsh environment of a racing automobile. Mechanical installation for an air purge system should include attention to air flow patterns to minimize dirt building on the lens -- and a daily cleaning of the lens will assure long life of the sensor on the automobile.



## Why Exergen IR Non-Contact Sensors

- Interchangeable, plug-and—play solution. From sensor to sensor the interchangeability error is < 0.5°C.
- Repeatability. Sensors will be repeatable within 0.1°C under the same conditions.
- Non-contact. Contact sensors can break, can't measure a moving target, and can also damage the material being measured, such as the tire.

## Commercial Advantages

- Price. Compared to other IR options, the IRT/c devices are low cost.
- Self-Powered. No power supplies or batteries needed to energize the sensor, and no noise from electronics to have to worry about.
- Size. The IRT/c is as small as 0.25" in diameter, making it easy to mount and fit anywhere in the vehicle that may have tight constraints.
- Reliable. These passive devices have a Mean Time Between Failure rate of over 1,000 years, so they will outlive the tire, automobile and driver.
- Speed. Just like the race car, the sensor is fast, providing a reading every 100 milliseconds. If a tire spins 1500 Revolutions per Minute, the sensor takes a reading every 2.5 revolutions.

## Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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# INCREASING SAFETY, RELIABILITY AND SPEED FOR DIAGNOSTIC, SKIN AND MEDICAL TREATMENTS

## General

Help Your Customers Increase Safety, Reliability & Speed with Exergen's IR Sensors

For processes such as diagnostic procedures, skin treatments and medical interventions where blood or saline solutions are involved, temperature monitoring and control are essential in the success and reliability of the procedure. Employing IRt/c technology increases the speed and reliability of the procedures while assuring patient safety.

## Cosmetic

In the cosmetic market, our customers provide advanced solutions for a broad range of medical-aesthetic applications, including body contouring, skin rejuvenation, cellulite reduction, acne treatment, hair removal, wrinkle reduction etc. These applications are aimed at treating patients by heating up very specific target areas (subdermal fat tissue, scar tissue, vascular lesions etc.) with electrical and/optical energy (laser, IPL, infrared light). The treatments are most efficient when high temperatures are reached in the target areas. However, this increases the risk of burns. By monitoring the skin temperature in real-time, treatment efficacy can be optimized while assuring patient safety and preventing overheating of the skin.

## Diagnostic

Diagnostic procedures are more frequently taking place at the point-of-care, or are otherwise automated in clinical laboratories. Speed, accuracy and reliability are key to assure proper diagnoses, yet many diagnostic procedures are based on physical or chemical processes that are temperature sensitive. To assure reliable diagnostic results, temperature monitoring and control of the biological samples and processes are essential.

Diagnostic applications include OA point-of-care blood analyzers, plate readers, immunohematology analyzers and immunohistochemistry equipment.



## Interventions

As medical professionals introduce new techniques and devices into their practices, they need foolproof, reliable thermal measurement solutions to ensure patient safety and device sterility. Exergen's non-contact infrared temperature sensors provide fast and contamination-free measurement to help monitor and control fluid temperature.

Our sensors are ideally-suited to a range of applications in which fluid must reach a certain temperature, including: transfusion systems, IV warming systems, dialysis systems, cardio-pulmonary bypass systems, ECMO systems, and IVF workstations. They are also employed in the thermal management systems of surgical platforms.

Our patented Heat Balance method allows us to measure fluid temperature non-invasively using disposable tubing. Exergen's sensors provide other benefits not found in competitive sensors: our IRt/cs are self-powered and have zero drift, so they do not require service or calibration. They have repeatability error rates of just 0.01°C (0.02°F) and interchangeability error of +/-1%, meaning that they provide accurate, reliable measures time after time, and that replacement sensors (if needed) will be exactly the same, with no programming needed. We also have extensive medical device knowledge and background through collaboration with our Medical Division, a group that is recognized world-wide for its award-winning Temporal Scanner product line.

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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# IR SENSORS FOR ACCURATE TEMPERATURE MONITORING IN HIGH-END EXHAUST GAS ABATEMENT SYSTEMS

## General Information

Exergen's sensors are used in high-end exhaust gas abatement systems around the globe. Many of the special gases used in semiconductor wafer processing and other manufacturing industries are either toxic, pyrophoric or corrosive. Unused process gases and hazardous by-products must be removed from exhaust lines efficiently and safely for safety and to ensure compliance with regulatory emission standards.

The unused gases are chemically converted to safe, stable solids in absorber columns. These columns consist of solid beads that (often) contain proprietary chemicals that react with the exhaust gasses, resulting in slight temperature increases. This process starts at the bottom of the column (several months generally) it moves upward. Once all beads have fully reacted, they can no longer extract the hazardous by-products from the gasses and must be replaced. The time remaining before a column needs replacement can be monitored using temperature sensors that detect increased heat within the column, signaling when it has reached the column top.

The absorber columns are specifically designed to clean gasses in a manner that meets customer specifications. However, if the gasses have higher concentrations of gasses or contain components other than those specified by the customer, there is the potential for an exothermic reaction that can overheat the column swiftly, risking dangerously high pressure levels and hazardous gas leaks. Fortunately, this scenario can be detected early and prevented by shutting down the system before it overheats.

## The Optimal Solution

Thermal sensors are an ideal solution to monitor column temperatures, allowing operators to determine when a column should be replaced and if it is at risk for overheating from exothermic reactions. Downtime of these systems is very costly so should be limited to the minimum— therefore the ideal sensor for this application should require zero recalibration or maintenance. Sensors used in this setting must also be extremely accurate in order to maximize the column's lifetime and avoid overheating. Finally, since the sensors are used in potentially hazardous environments, in which flammable conditions might occur, they must be intrinsically safe.



## Why Exergen IR Non-Contact Sensors?

Exergen IRt/c sensors are non-contact sensors that don't need to be replaced or remounted when a column is replaced. They are passive devices, resulting in:

- zero in-field recalibration or maintenance, which considerably limits system downtime
- intrinsically safe in potentially flammable environments
- very fast and accurate to reliably monitor safety and lifetime of the columns
- very small, easy to mount on any size of column

## Commercial Advantages

- Accurate temperature monitoring prevents column overheating and optimizes safety
- Allows for easy and swift replacements of columns
- Provides reliable data on when a column is exhausted and needs replacement – not too early, not too late
- No downtime added by the sensor, no maintenance or calibration needed

### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## VACUUM-SEALING PACKING MACHINES

### General Information

We like our food to be as fresh as can be. Vacuum-Sealing packaging can extend the shelf life of food products by preventing exposure to the natural atmosphere, thereby slowing down the microbial deterioration of the product. The vacuum also fixes the product within the pack, providing a degree of protection and reducing the packaging volume.

In order to have effective vacuum-sealing packaging it is that the seal must be closed 100%. If any air comes into the packaging, the quality cannot be guaranteed and the product cannot be sold. Having a reliable vacuum-sealing packaging solution is key to prevent issues and/or delays in production.

After the vacuum process the sealing of the plastic bag is created using a hot resistance wire that fuses both sides of the vacuumed plastic bag together. The temperature of the plastic and the ambient temperature of the machine can vary throughout the day. This temperature variability can result in failed seals in the early morning when the melting wire may be cold. If the heat is increased to prevent this situation, the temperature later in the day may be too high, and may burn plastic as a result.

### The Optimal Solution

Manufacturers can gain much greater control over the sealing process, and adjust it to meet ambient conditions, by measuring the temperature of the seal and creating a feedback loop to the resistance wire. Contact thermal sensors are not a viable option for use with vacuum-sealing packaging applications -- for several reasons. First and foremost, a contact sensor will be damaged if it touches melting plastic, and secondly, contact sensors are too slow to react in time to determine when the ideal fusing temperature of the plastic has been reached.

The Exergen Micro IRt/c is an ideal solution for the job; the non-contact sensor does not need to touch the plastic. Additionally its very small form factor, fast (50ms) response time and repeatable accuracy of 0.01°C (0.02°F) makes it a proven solution for this challenge.



### Why Exergen IR Non-Contact Sensors?

- Fast reading; 50ms response time
- No contact with sealed, hot plastic
- Accurate with repeatability of 0.01°C (0.02°F)
- These sensors need no programming nor calibration, so are very easy to use
- Small size that fits in the limited available space; the 6.3mm (0.25") tube fits easily in the bar of the vacuum processing machine

### Commercial Advantages

- Always a quality seal due to a controlled constant temperature
- Fully automated and reliable solution
- A high ROI
- No scrap – not lose any production time.



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The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## VACUUM THERMOFORMING

### General Information

Thermoforming is one of the oldest and most common methods of processing plastic materials. Vacuum formed products are all around us and play a major part in our daily lives.

The process involves heating a plastic sheet until it is soft and then draping it over a mould. A vacuum is then applied, pulling the sheet into the mould. After cooling down the sheet is ejected from the mould. In its advanced form, the vacuum forming process utilizes sophisticated pneumatic, hydraulic and heat controls, thus enabling higher production speeds and more detailed vacuum formed applications.

The heaters used in vacuum forming are generally infrared elements mounted within a reflector plate. In order to obtain the best vacuum forming results, it is essential that the plastic sheet is heated uniformly over its entire surface area and throughout its thickness. In order to achieve this, it is necessary to have a series of heating zones that are controlled by energy regulators.

The plastics used vary from Acrylonitrile Butadiene Styrene (ABS), Polyvinyl Chloride (PVC), Polypropylene (PP) to Acrylic (PMMA) and many more. Each of these plastics has its own specifications and each requires different optimum temperature ranges wherein the forming should take place. Typical products created by vacuum forming are lunch box containers and yogurt containers.

### The Optimal Solution

In order to process the heated plastic at the optimum forming/stretch temperature it is important to measure the actual temperature of the plastic. Based on this measurement, a feedback loop that controls the timing of the heater will assure the quality is stable under changing ambient temperature conditions. Temperature variations in the processed plastic sheets are also kept under control using this method.

Measuring the temperature of the plastic needs to be done without the use of contact sensors, which would touch the plastics and leave a mark on the target. Also, because they touch the target, contact sensors are likely to become contaminated over time. An infrared non-contact temperature sensor avoids these issues and is also well suited to the application because it measures a zone rather than a specific and small point, providing more extensive target temperature information.



### Why Exergen IR Non-Contact Sensors?

High accuracy with a repeatability error of only 0.01°C (0.02°F).

No drift and no need for programming/calibration as these are passive devices

### Commercial Advantages

- Higher quality and speed
- Less vulnerable to changing process temperatures
- Optimized production lines, therefore less waste in first production line



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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## POINT-OF-CARE TESTING (POCT)

### General Information

Point-of-care testing (POCT) is medical diagnostic testing performed at or near a patient's bedside. As opposed to conventional medical testing, which entails sending specimens to laboratories, POCT yields results in minutes instead of hours or days.

POCT can include blood glucose testing, blood gas, metabolites and electrolytes analysis, etc. Tests are performed on portable instruments, with the use of disposable test strips or cartridges. The challenge with POCT instruments is to provide the complexity of conventional lab equipment in small, portable devices.

In a subset of these instruments, analytical methods are used that are temperature sensitive. For instance, the conductivity of blood samples is a quantitative measure of analyte content. However, conductivity varies when blood temperature changes, so the blood sample's temperature must be accurately monitored and controlled to assure reliable diagnostic results. If the temperature of the diagnostic sample is not within specifications, faulty results will be generated.

### The Optimal Solution

Measuring blood sample temperatures using a non-contact (IR) sensor is the preferred approach to ensuring accurate, reliable diagnostic results. In POCT applications, non-contact sensors have many advantages over contact sensors. The main advantage of an IR sensor is its ease of use. Unlike contact sensors, IR sensors can be integrated into test cartridge holders, ensuring that the cartridge and sensor are properly aligned for accurate results.

Additionally, contact sensors have slow response times, while IR sensors can offer the fast response required by POCT applications in which the blood sample is small and may rapidly change temperature.

Since POCT instruments are designed to be small and portable, a small-sized sensor is ideally suited to this application, and, as with any diagnostic results, the temperature sensor must ensure a high level of accuracy.

Another criteria in considering the right temperature sensor for POCT applications is the device's susceptibility to cleaning agents. POCT instruments must be thoroughly cleaned on a regular basis with potent cleaning agents that meet hospital regulations. A sensor solution must be chosen that can withstand the corrosive properties of harsh detergents.



### Why Exergen IR Non-Contact Sensors?

Exergen's Infrared sensors are the smallest sensors available in the world and are easy to mount in portable platforms. The company's patented Ambient Temperature Compensation methodology ensures optimal, accurate sensor performance whether the POCT is performed in an ambulance or in an air-conditioned operating room. Further advantages of Exergen's IR sensors are:

- Self-powered – accurate, durable and reliable
- Fast response times, ranging from 25 to 100 milliseconds, to allow faster process control
- Repeatability error of 0.01°C (0.02°F) – consistent readings now and in 10 years' time
- Interchangeability error of +-1% - results will remain the same between different machines.

### Commercial Advantages

- Standardized blood sample testing under all conditions – providing reliable test results
- Small, cost-effective and easy to mount in specialized POCT equipment
- No lens corrosion due to clinical cleaning
- Sensor does not need service or calibration in the field, saves cost, more reliable



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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AN-701-EN-V0

# EXERGEN'S SENSOR SOLUTION ESSENTIAL COMPONENT OF ABLATION, COOLING SYSTEM

## General Information

A subset of surgical devices, including surgical drills, cutters and ablation probes, employ heat to incise or cauterize tissue. When using surgical instruments that employ heat, it is a challenge to ensure that those portions of the instrument that do not need to conduct heat remain cool enough to avoid any negative side effects. In most cases, the necessary cooling can be achieved using pressurized gas or liquid, along with thermal sensors that measure temperatures.

This application note discusses an instance in which thermal management was employed in a setting where gas was used to cool an ablation probe, but the concepts can be applied to any number of other instruments and to instances that use liquid, rather than gas for cooling.

## Challenges

Exergen recently worked with a medical device company challenged with the need to apply enough energy to an ablation probe's tip to successfully conduct a procedure while ensuring the probe's shaft remained cool enough to avoid complications. The company used a CO<sub>2</sub>-based cooling system equipped with Exergen's thermal management sensor. The cooling system was housed on a compact, portable platform, and included CO<sub>2</sub> tanks. The thermal sensor was an essential component of the cooling system, providing the means to measure a CO<sub>2</sub> tank's temperature to gauge its capacity and ensure it maintained sufficient pressure during procedures. If the CO<sub>2</sub> tank in the cooling system lost pressure, it would fail to cool the ablation probes and could cause serious injury to the soft tissue.



## Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
www.exergenglobal.com

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# EXERGEN'S SENSOR SOLUTION ESSENTIAL COMPONENT OF ABLATION, COOLING SYSTEM

## The Optimal Solution

The optimal thermal management solution for this application was Exergen's high speed, non-contact micro IRt/c.SV temperature sensor. Contact sensors weren't well-suited to the task because they need as much as 15 seconds to acclimate before registering an accurate measurement. This would have caused unnecessary and potentially dangerous delays when empty CO2 tanks had to be replaced, because the contact sensors would need to be positioned on the tanks and then require time to acclimate. The ideal sensor for this cooling system also needed to provide real-time measures.

Another important consideration for this cooling system was a sensing device that was easy to mount, yet wouldn't be dislodged if it protruded outside of the platform footprint. It was also important to select a device that would eliminate the area around the tank from its field of view, since an inclusion of that view would cause measurement errors. Also, the sensor needed to account for the fact that the tanks used for the application differed in size and material from one hospital to the next. Some tanks were painted, some rusty, and some shiny aluminum – yet the measurements couldn't be affected by the differing reflective properties of the tanks.

## Why Exergen IR Non-Contact Sensors?

With a size of just ¼" in diameter and 1.47" long, the Exergen side view non-contact micro IRt/c.SV sensor integrated easily, securely and unobtrusively into a bracket on the CO2 tank. In this application, the bracket served the dual purpose of housing the sensor and preventing radiation from surrounding heat sources (for example, a surgeon walking by) to reflect off of the CO2 tanks surfaces and create measurement errors.

Since it is a non-contact sensor, the micro IRt/c.SV's location on the cooling system's cart remained constant and that constancy eliminated the risk of misaligning cylinders during replacement and ensured an accurate temperature reading at all times. The sensor's < 50 millisecond response time provided real-time measurement and experienced no downtime in temperature detection following cylinder replacement.

## Commercial Advantages

- Fast results so no machine downtime
- Guaranteed patient safety under all conditions
- Re-useable solution and this cost effective
- Sensor does not need service or calibration in the field, saves cost, more reliable



### Exergen Global offices:

The Netherlands  
Pastoor Clercxstraat 26  
5465 RH Veghel  
Tel: +31(0) 413 37 65 99  
Fax: +31(0) 413 37 93 10

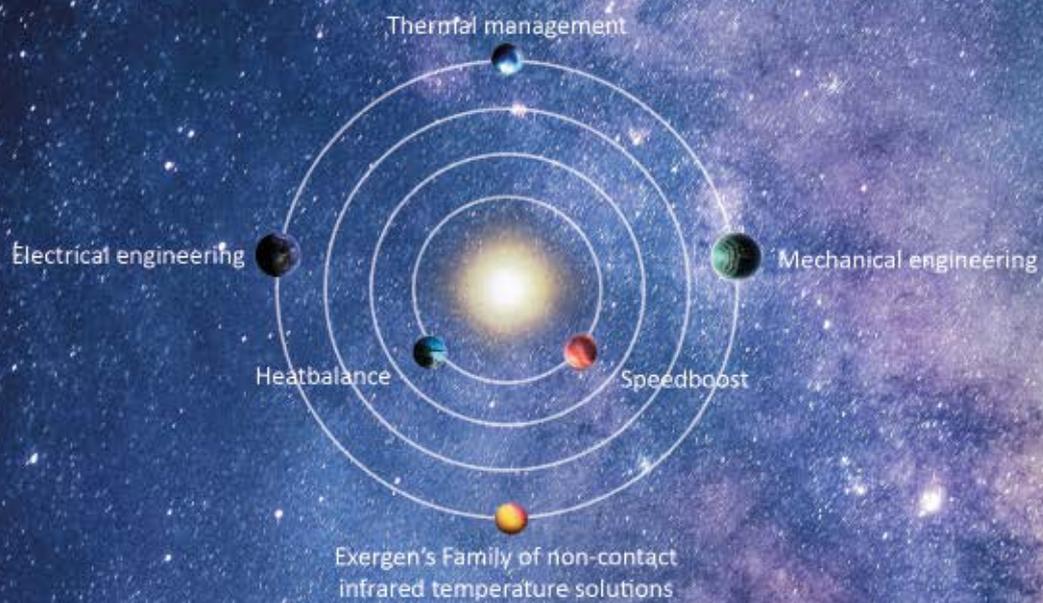
USA  
400 Pleasant Street  
Watertown, MA 02472  
Tel: +1 617 649 6322  
Fax: +1 617 923 9911

office@exergenglobal.com  
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# Sensoranics Methodology™



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