

Forté Technology, Inc.



...World leaders in moisture measurement

Forté Technology, Inc.

Company History

- 1956 - Established to measure moisture in cashmere.
- 1965 - Expanded into pulp industry.
- 2008 - Facility moved to Taunton, MA.
- Present - Serving clients worldwide in over 40 countries.

Experienced in a wide variety of applications including:

- Pulp
- Textiles
- Rubber
- Tobacco
- Food
- More

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Why Measure Moisture?

Quality Control

- An even moisture distribution can help prevent sheet breaks.
- Ensure that your customers are shipped pulp that meets their needs.

Increased Profits

- Your customers will never complain if the pulp you sell is dryer than expected.
- They will complain, however, if it is too wet.
- If you never get customer complaints, chances are, you are giving away pulp.

Accurate moisture measurement can increase profits!

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Functions Lead to Increased Profit

- Accurate Invoice Weights allow precise billing so you can invoice every kilogram of pulp that you ship.
- Real time measurements allow adjustments to be made within minutes instead of hours.
- Reduce energy costs by not over drying.
- Reduce sample collecting and testing which corresponds to reduced operations labor.

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Other Benefits of the Forté System

1. Instantaneous, non-destructive measurement test.
2. Automated testing with minimal human interface.
3. 100% of product tested for accurate determination of Invoice Weight.
4. A reliable solution for delivering more consistent bales to customers.
5. Provides archived data for identifying changes in moisture over time.
6. User friendly and configurable.

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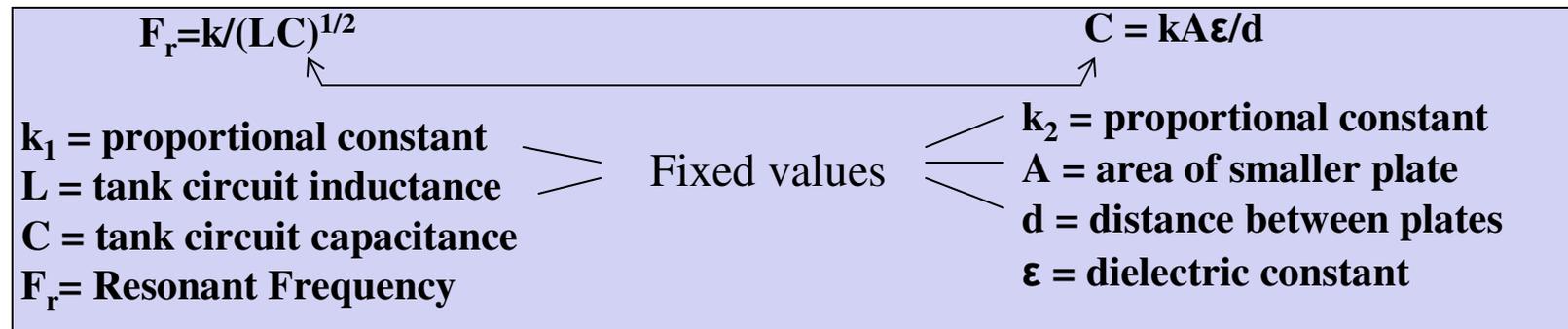
Forté Series 8760 Functions

- Calculates Moisture, Air-dry, and Invoice Weight for every bale produced.
- Builds units and lots to track production.
- Assigns bale serial numbers and lot numbers.
- Tracks bale origin and designates count.
- Records gross and net weights of each bale.
- Provides production reports, graphs and data for trend reports that can be analyzed for future production control.

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Principle of Operation



- Bale moisture is determined by the change in resonant frequency (F_r).
- The resonant frequency changes based on the dielectric constant of the bale.
- Water has a high dielectric constant of about 80. A dry bale of pulp has a dielectric constant of about 2-7.
- The electrode in the press constitutes a portion of the tank circuit capacitance.
- Forte electronics create a non-destructive RF field. The different dielectric constants create a shift in the resonant frequency. Two frequency readings are taken. The first reading is taken when the bale is slightly compressed. The second reading is taken after the bale has been compressed 4 inches (101.6 mm) more than the first reading.
- The second reading is subtracted from the first reading, obtaining the Forté number. This two step method reduces the effects of oscillator drift.
- The Forté number can be correlated into a moisture reading with these equations and several lab air-dry data points determined by oven tests.

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Forté 8760 Hardware

Bale Press Electronics

1. Pulp Oscillator
2. Electrode/Cover plate assembly with Bleeder Resistor
3. Photo Control unit
4. Vane (customer supplied)
5. Photo Reset Switch with reflector
6. Remote Power Supply

Forté Main Console*

1. Industrial Computer
2. DC Power Supply
3. Rack with Opto-isolated Discrete I/O Modules
4. I/O Connectors
5. Communication Interface
6. Uninterruptable Power Supply (UPS)

*Items can be supplied in a console or separately. If separately, industrial computer needs to be kept in a control room.

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Forté Main Console



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Forté Main Console - Components



1. Industrial Computer
2. Uninterruptible Power Supply
3. Communications Interface with DC power supply and Opto rack with modules
4. I/O Connectors
5. LCD Display
6. Rocket Port Interface

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Bale Press Electronics

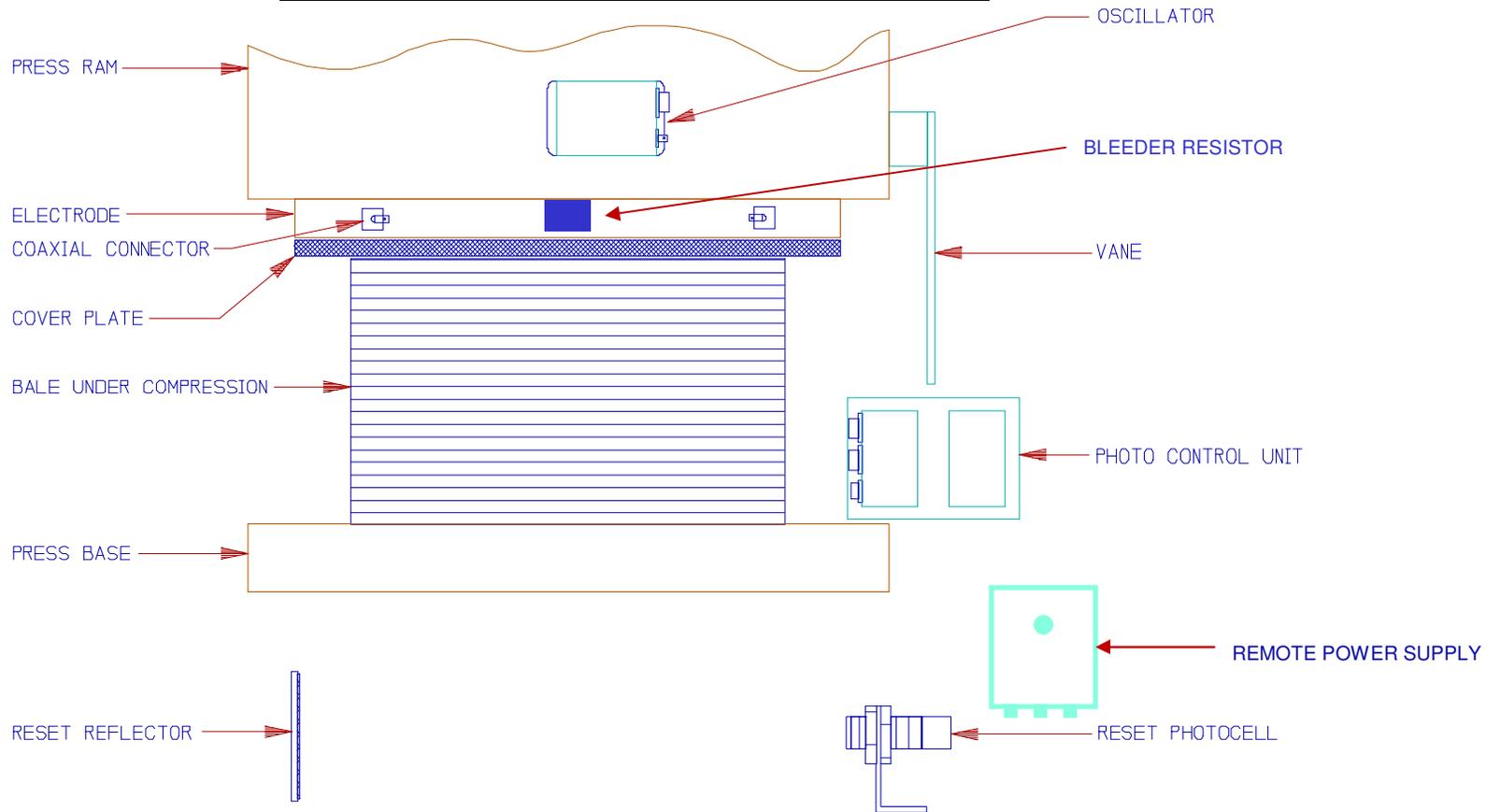
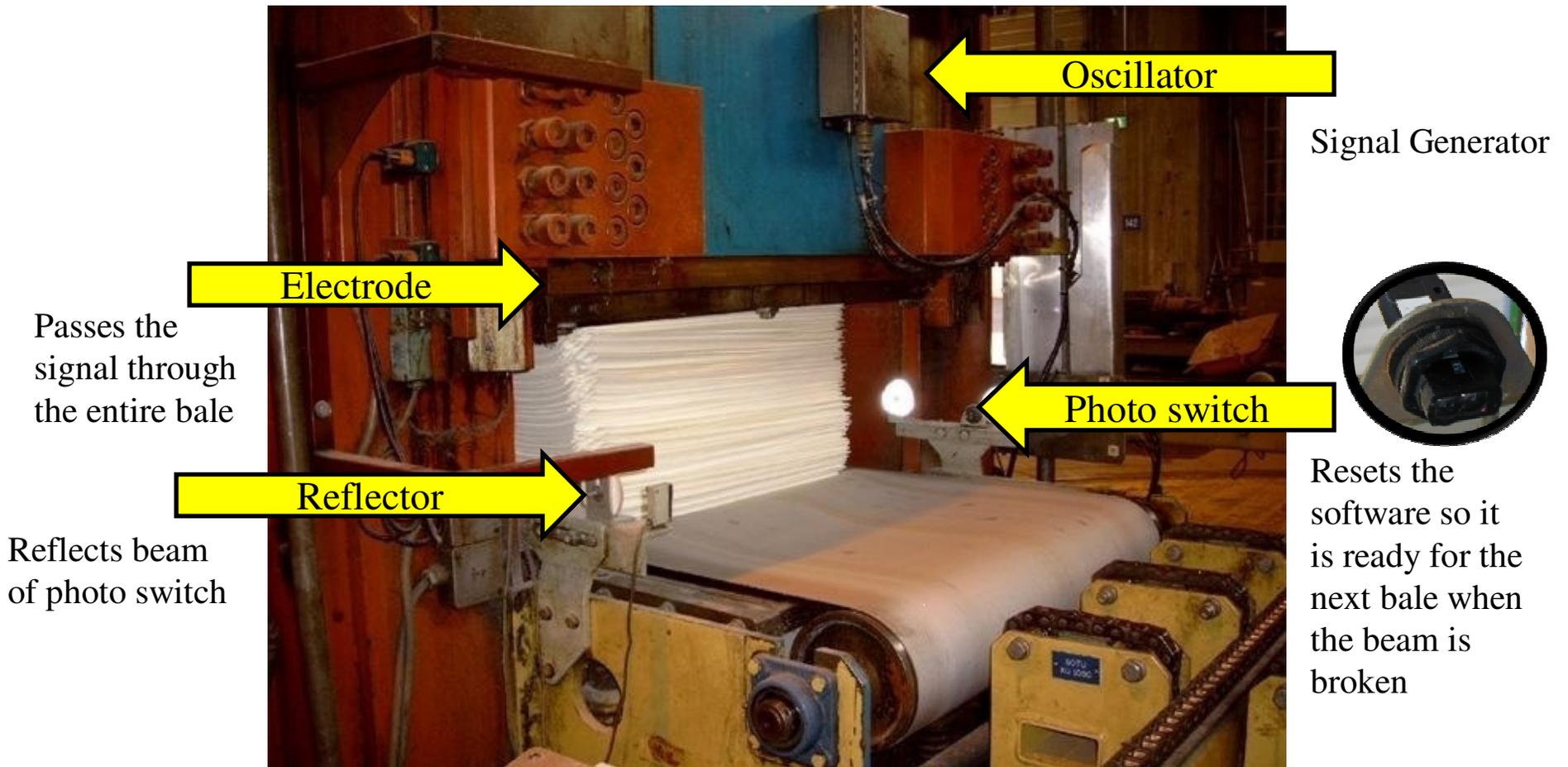


FIGURE 1 : PRESS ELECTRONICS (INTERCONNECTING CABLES OMITTED FOR CLARITY .)

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Typical Bale Press



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Typical Bale Press

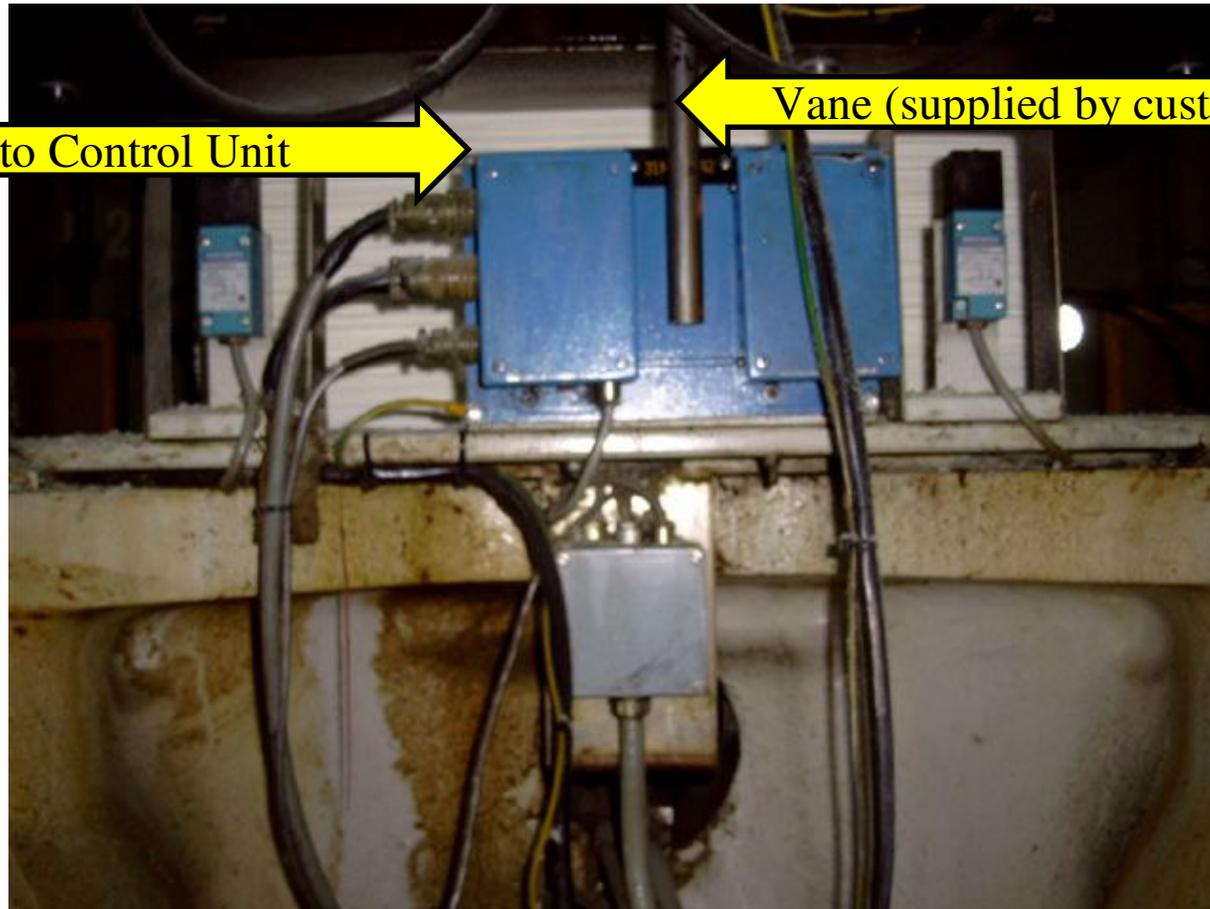


Photo Control Unit

Vane (supplied by customer)

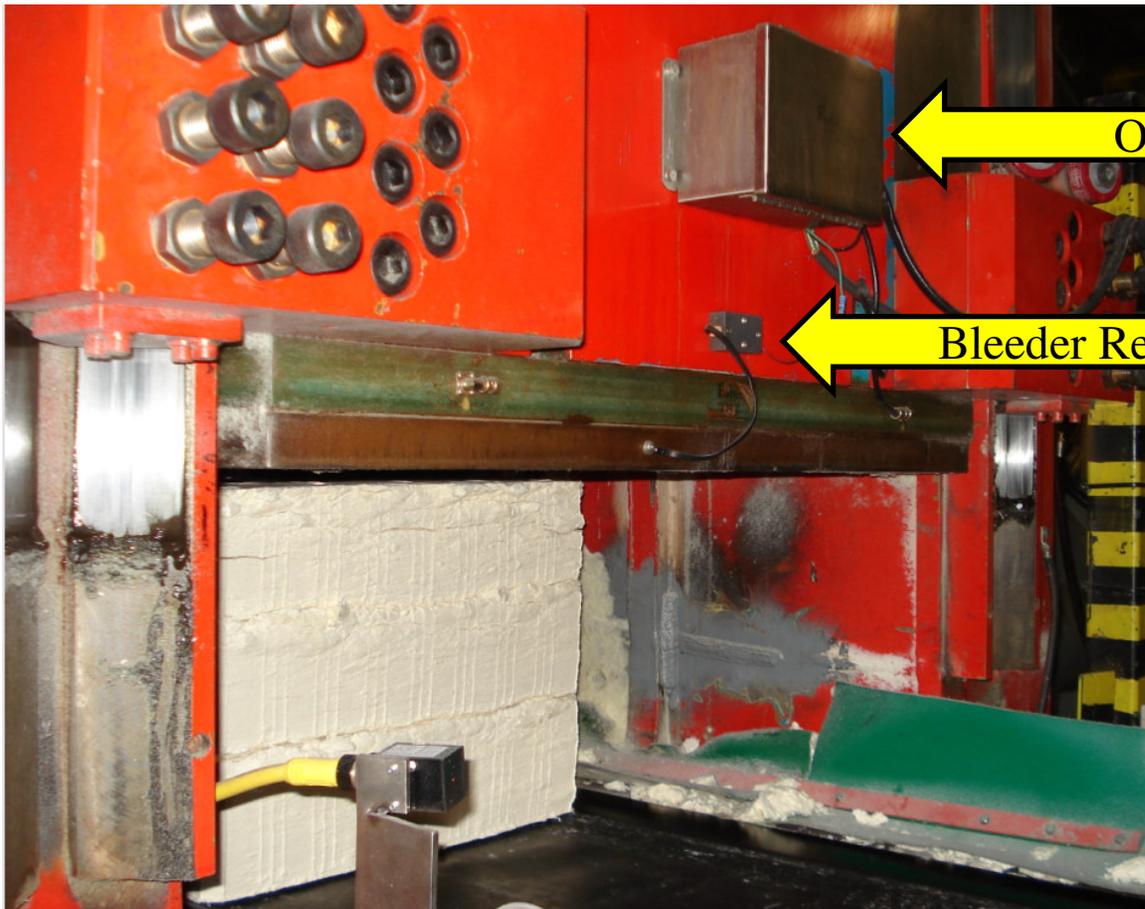
Accepts and transmits the 2 frequency readings

Triggers 2 frequency readings to be taken.

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Typical Bale Press



Oscillator

Signal Generator

Bleeder Resistor

Discharges any stored
up potential energy

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Remote Power Supply



Supplies
voltage to
other Forté
Equipment.

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Industrial Computer Components

- Windows XP Professional operating system
- Dual hard drives - RAID 1
- AC5 Interface Card
- Rocket Port Interface Card
- Optional Analog Interface

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Rocket Port Interface - RS232/RS422



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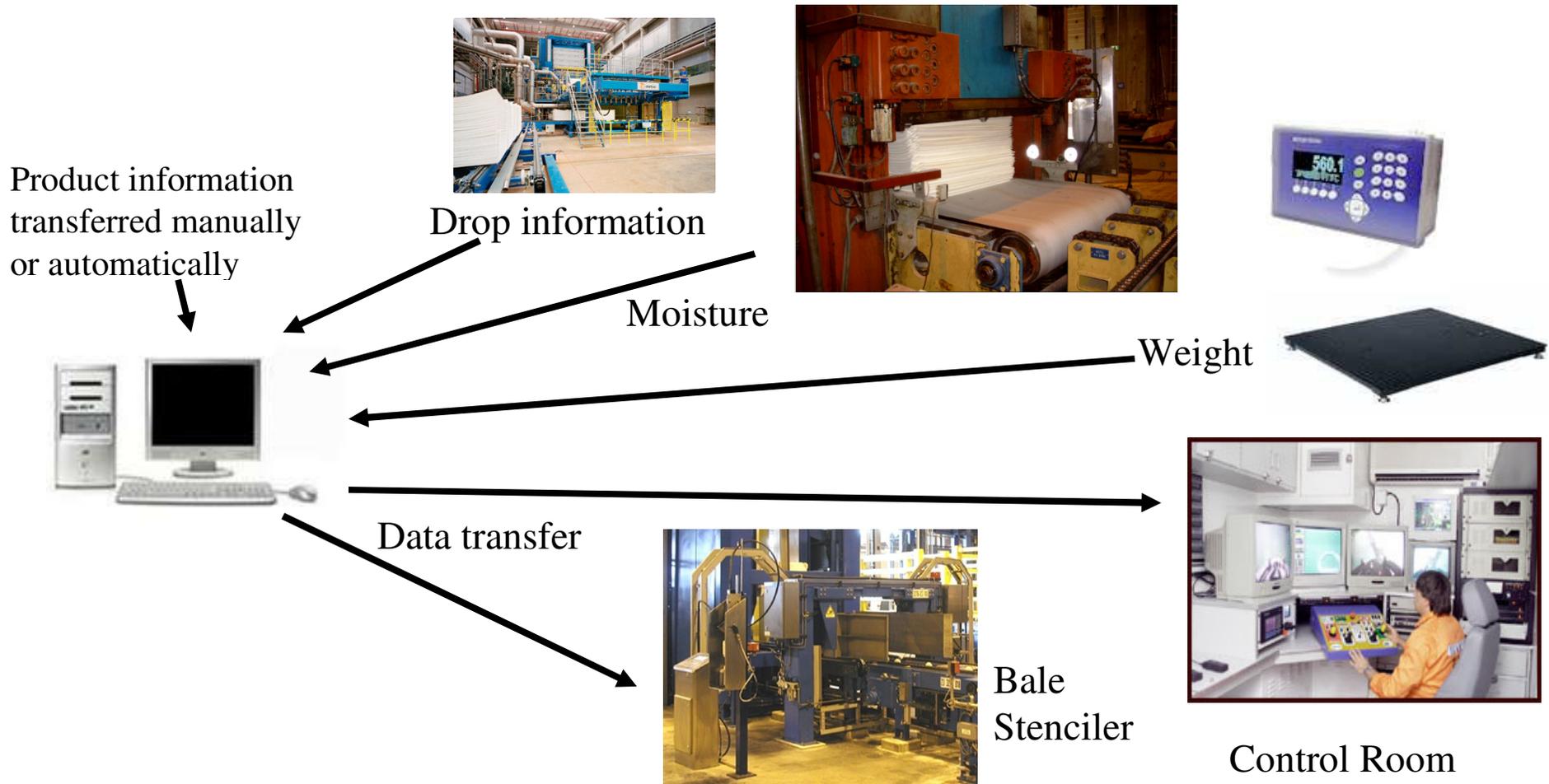
Features of the Forte Software Application

- Easy to learn and use.
- Familiar Windows pull down menus.
- User definable fields.
- Configurable summaries, reports, screen displays.
- Several methods of output to mill-wide information system.
- Utilizes SQL databases.
- Archives bale and measurement data for two years.
- Remote displays available.
- Optional input of Quality data.
- System log for ease of troubleshooting.

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Mill Interface



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Main Application

Forté 8760 Current Login (Forte - Forte)

Setup Applications System-Info Conveyors Views Security Help Shutdown

Lot Size: 280 BaleCnt: 204 Curr Lot#: 12 Next Lot#: 13

Bale(Next Ser) #: 3060

Stock: HARDWOOD Next Stock: SOFTWOOD

204 : Bale Count

Drop Res Approach Station 4 Conveyor Line 1 Weigh Station KG 249.0 0 Conveyor Line 1 Reset Press Station 5 1 Conveyor Line 1 Marker Station 12

Drop Res Approach Station 4 Conveyor Line 2 Weigh Station KG 252.0 1 Conveyor Line 2 Reset Press Station 5 0 Conveyor Line 2 Marker Station

Bale UID# = 2944 has been transferred to the archive

Summary

Configuration Summaries Production Summary Output

Last Bale Assigned

Time	Stock	Lot	Cal	Serial#	Bale# in Lot	Wt kg	%AD	Inv Wt kg	Wt Limits	Forte
10:38:53	HARDWOOD	12	H70S30	003059	204	248.0	91.38	228.7		412

B A L E

Time	Stock	Lot	Cal	Serial#	Bale# in Lot	Wt kg	%AD	Inv Wt kg	Wt Limits	Forte
10:08:41	HARDWOOD	12	H70S30	003043	188	251.0	91.90	232.8		407
10:09:16	HARDWOOD	12	H90S10	003044	189	253.0	81.58	208.5		536
10:09:22	HARDWOOD	12	H70S30	003045	190	249.0	90.51	227.5		431
10:09:57	HARDWOOD	12	H90S10	003046	191	250.0	84.69	213.8		461
10:10:02	HARDWOOD	12	H70S30	003047	192	252.0	94.36	239.9		364
10:10:37	HARDWOOD	12	H90S10	003048	193	249.0	86.70	218.0		420
10:10:42	HARDWOOD	12	H70S30	003049	194	246.0	93.16	231.3		376
10:11:17	HARDWOOD	12	H90S10	003050	195	248.0	87.59	219.3		402
10:11:22	HARDWOOD	12	H70S30	003051	196	246.0	91.37	226.9		409
10:11:58	HARDWOOD	12	H90S10	003052	197	253.0	87.93	224.6		404
10:12:03	HARDWOOD	12	H70S30	003053	198	246.0	92.82	230.4		382
10:12:38	HARDWOOD	12	H90S10	003054	199	245.0	85.91	212.6		428
10:12:43	HARDWOOD	12	H70S30	003055	200	249.0	93.19	234.1		380
10:13:18	HARDWOOD	12	H90S10	003056	201	247.0	85.37	213.0		442
10:13:24	HARDWOOD	12	H70S30	003057	202	251.0	92.11	233.3		403
10:38:34	HARDWOOD	12	H70S30	003058	203	249.0	94.22	236.7		362

L O T

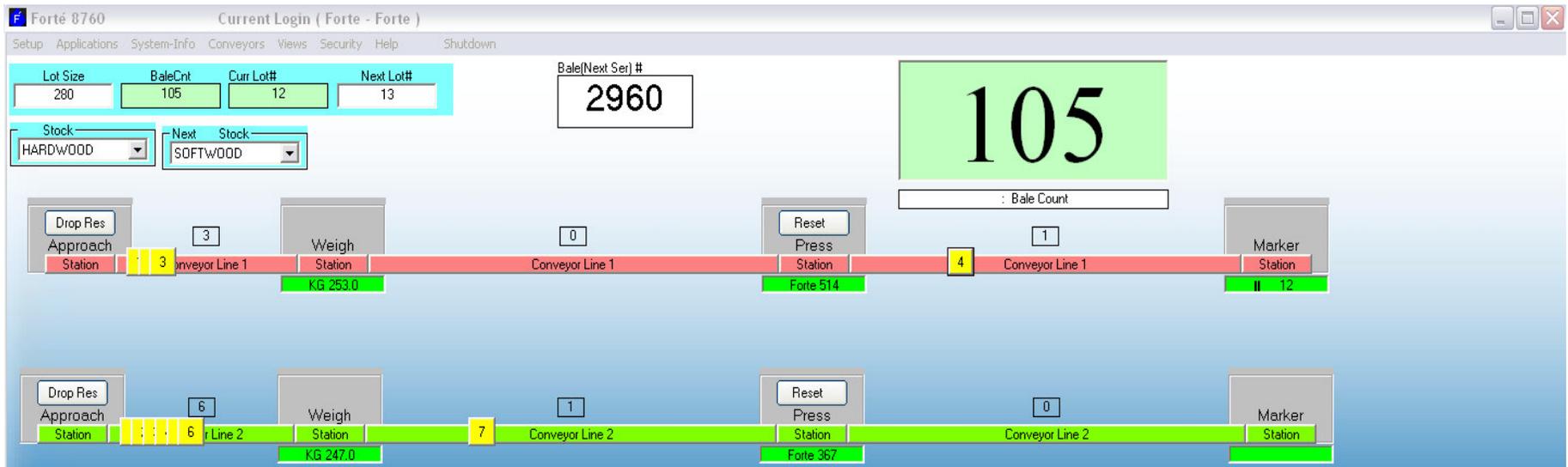
Status	Dt Open	Tm Open	Stock/Grade	Batch	Bales	NW kg	Inv. Wt kg	Ship Wt. Kg	AV %MC
Open	10/09/08	10:43:43	HARDWOOD	12	204	50857.0	45907.2	51285.4	19.60

CurrentLot/Bale Bale Summary Lot Summary Day Summary Shift Summary Period Summary Prior Totals Alarms Quality Summary

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Schematic View of Measuring Window

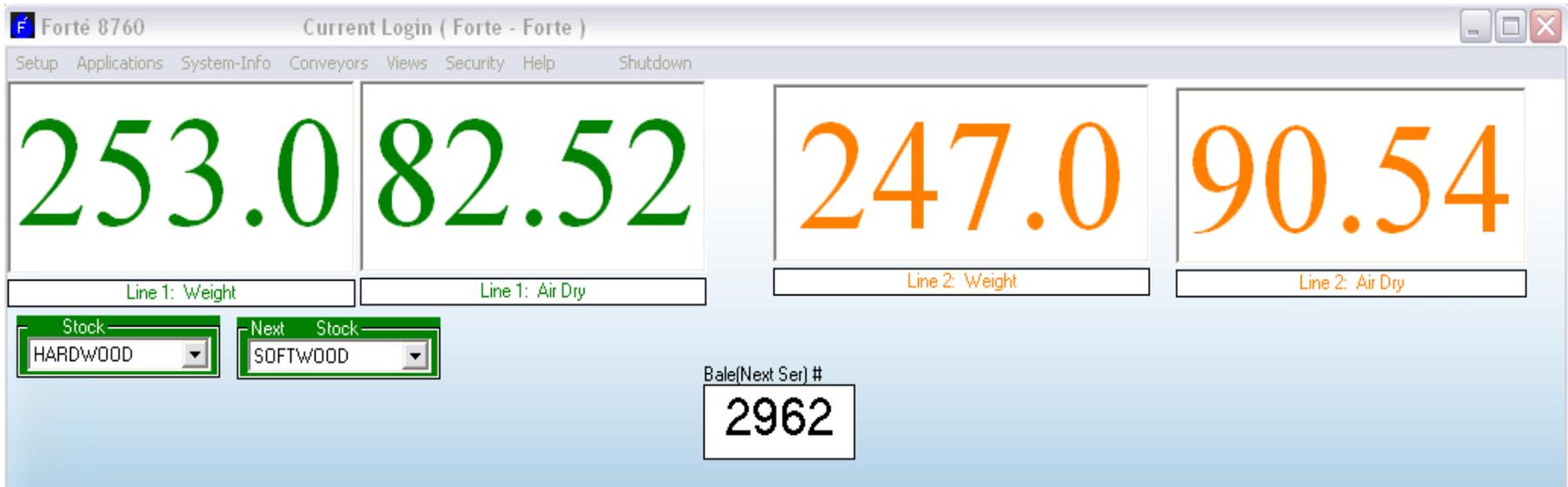


User configurable display includes Stock, Bale and Lot data.

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Console View of Measuring Window



Optional view includes large number displays for ease of viewing.

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Summary Window

F Summary											
Configuration Summaries Production Summary Output											
Last Bale Assigned	Time	Stock	Lot	Cal	Serial#	Bale# in Lot	Wt kg	%AD	Inv Wt kg	Wt Limits	Forte
	10:13:24	HARDWOOD	12	H70S30	003057	202	251.0	92.11	233.3		403
B A L E	10:08:41	HARDWOOD	12	H70S30	003043	188	251.0	91.90	232.8		407
	10:09:16	HARDWOOD	12	H90S10	003044	189	253.0	81.58	208.5		536
	10:09:22	HARDWOOD	12	H70S30	003045	190	249.0	90.51	227.5		431
	10:09:57	HARDWOOD	12	H90S10	003046	191	250.0	84.69	213.8		461
	10:10:02	HARDWOOD	12	H70S30	003047	192	252.0	94.36	239.9		364
	10:10:37	HARDWOOD	12	H90S10	003048	193	249.0	86.70	218.0		420
	10:10:42	HARDWOOD	12	H70S30	003049	194	246.0	93.16	231.3		376
	10:11:17	HARDWOOD	12	H90S10	003050	195	248.0	87.59	219.3		402
	10:11:22	HARDWOOD	12	H70S30	003051	196	246.0	91.37	226.9		409
	10:11:58	HARDWOOD	12	H90S10	003052	197	253.0	87.93	224.6		404
	10:12:03	HARDWOOD	12	H70S30	003053	198	246.0	92.82	230.4		382
	10:12:38	HARDWOOD	12	H90S10	003054	199	245.0	85.91	212.6		428
	10:12:43	HARDWOOD	12	H70S30	003055	200	249.0	93.19	234.1		380
	10:13:18	HARDWOOD	12	H90S10	003056	201	247.0	85.37	213.0		442
10:13:24	HARDWOOD	12	H70S30	003057	202	251.0	92.11	233.3		403	
L O T	Status	Dt Open	Tm Open	Stock/Grade	Batch	Bales	NW kg	Inv. Wt kg	Ship Wt. Kg	AV %MC	
	Open	10/09/08	10:43:43	HARDWOOD	12	202	50360.0	45441.3	50784.2	19.63	

CurrentLot/Bale

Displays user configurable bale and measurement data.

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Stock Operations

Stock System 80-4003-7.4

Stock Operations Print System Log Maintenance Grade User

Name

HARDWOOD

Name

KRAFT-17
SOFTWOOD
HARDWOOD

Calibration

Cal 1 HARDWOOD

Cal 2 SOFTWOOD

Tare Wt. 2.1 kg

%AD Limits

Low 88 %AD

Caution Limits

Enable Caution Low 90 %AD

Caution High 103 %AD

High 105 %AD

Scale Weight Limits

Low 230.0 kg

Caution Limits

Enable Caution Low 240.0 kg

Caution High 260.0 kg

High 270.0 kg

Stock Labels

Text Field 1 Transition

Text Field 2

Text Field 3

Text Field 4

Apply Modify Cancel

Parameters Defaults Target

- Define Stocks.
- Assign calibrations.
- Enter Tare Weights.
- Define %AD and weight cautions and limits for a digital output.

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Defaults

Stock System 80-4003-7.4

Stock Operations Print System Log Maintenance Grade User

Name

HARDWOOD

Name

KRAFT-17

SOFTWOOD

HARDWOOD

Stock Default Values

Weight 250 kg

Net Wt. 247.9 kg

Forte 843

Moisture 92 %AD

Sheet Cnt. Sh Cnt

Brightness Bright

Grade

Grading Criteria

Undo

Apply System Defaults

Apply Defaults to all

Apply Modify Done

Parameters Defaults Target

Enter default data in the event that communication is lost.

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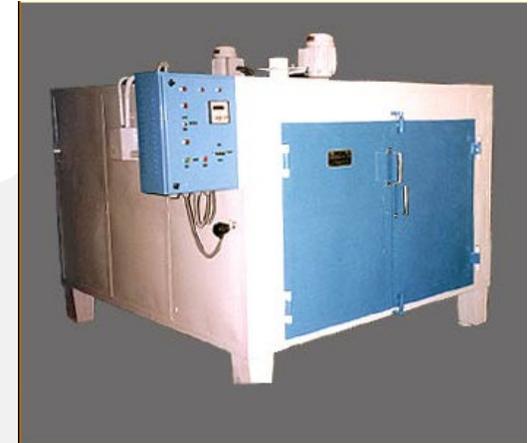
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Calibration

Purpose - As with any secondary measurement, the Forte system requires calibration. This is necessary to convert the Forte number to an accurate Air-Dry.

How - The Forte is calibrated using the oven dry method.

Importance – The better the oven-dry data, the more accurate the moisture, air-dry reading determined by the Forté system.



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Proper Calibration - Samples

- Product - Collect samples from standard bale production.
- Low, medium, and high moisture levels.
 - Use new bales that are the same size.

- Quantity - At least 10 bales (preferably from different bale positions).
- 5-10 samples per bale (including the outside and center while avoiding the top layer and edges).

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Proper Calibration - Procedure

- Method - Record Forté Number and Bale Weight for each sample bale.
- Perform standard lab oven-dry tests.
 - Enter Forté Number, Bale Weight, and Air-Dry into Forté calibration program.

- Type
- Each material requires a separate calibration.
(Example: hardwood, softwood)
 - Calibrations are saved on the hard drive by the Forté software.

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Calibration

Input lab data for each sample.

Mode
 Edit Input

Sample Number

Status

Date

Weight kg

Forte

Lab %AD

Samples for Calibration - H90S10 (Logarithmic)

Data Samples Zoom Print Maintenance

Sample	Active	Weight kg	Forte	Lab %AD	Created	Changed
12	YES	460	750	88	10/6/2008	10/14/2008
13	YES	445	720	88	10/9/2008	10/14/2008
14	YES	405	612	90	10/9/2008	10/14/2008
15	YES	460	649	91	10/14/2008	10/14/2008
16	YES	438	648	90	10/14/2008	10/14/2008

Mode
 Edit Input

Sample Number

Status

Date

Weight kg

Forte

Lab %AD

A and B Constants

Points	A	B	S.D.	Corr
All	-55.251	99.326	0.36	-0.97
Curr	-55.25	99.326	0.36	-0.97
Prev				

16 Samples for Calibration - H90S10 (Logarithmic)

Calibration coefficients are automatically calculated or can be entered manually.

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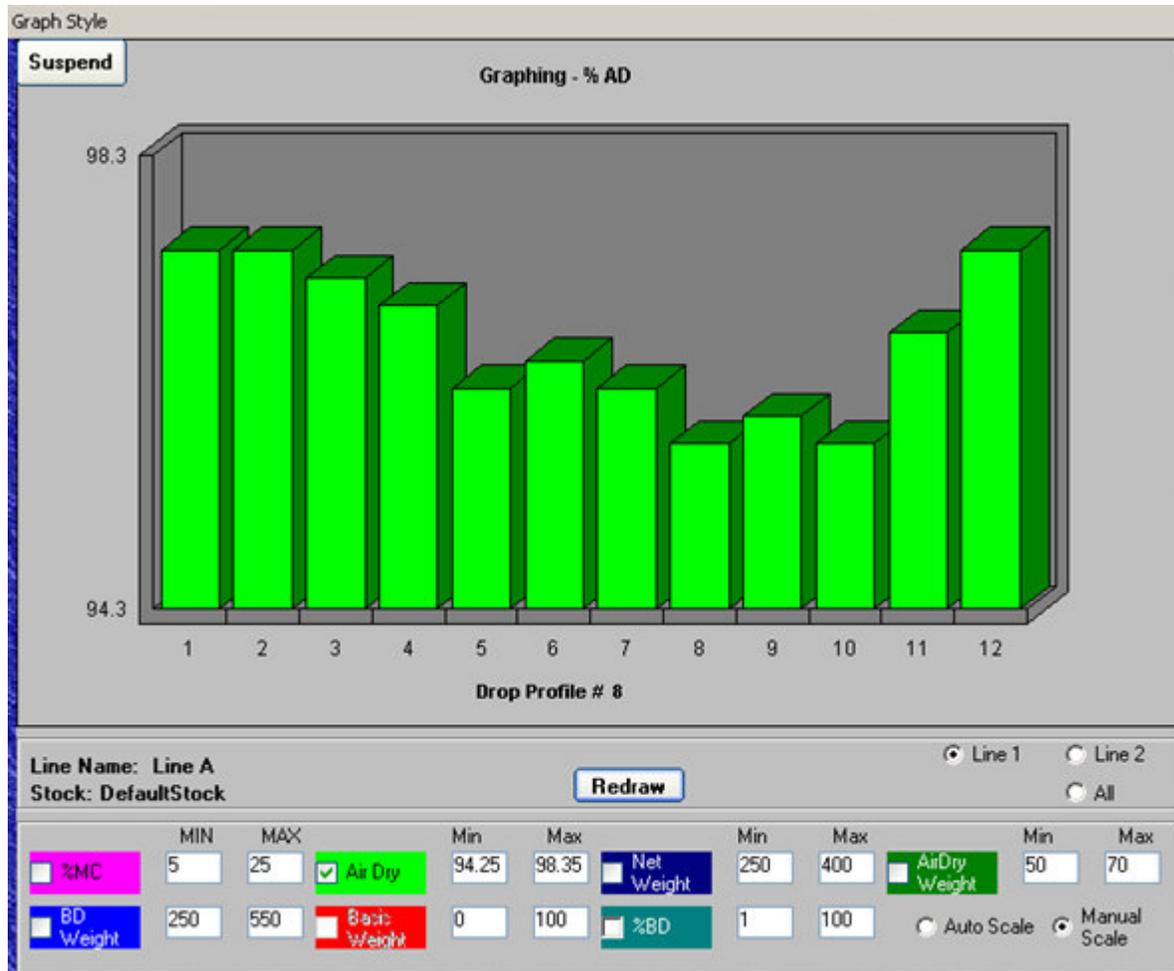
Calibration - Recommendation

- The Forté engineer will help with the initial calibration during the system installation.
- Forté recommends two calibration samples be collected every month for the first year to verify that the calibration continues to be accurate.
- After the first year, a verification calibration once a year is sufficient.
- The additional samples added to the calibration, reduce the standard deviation, ensuring the most accurate moisture content readings.

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% Air-Dry Graph across a Drop



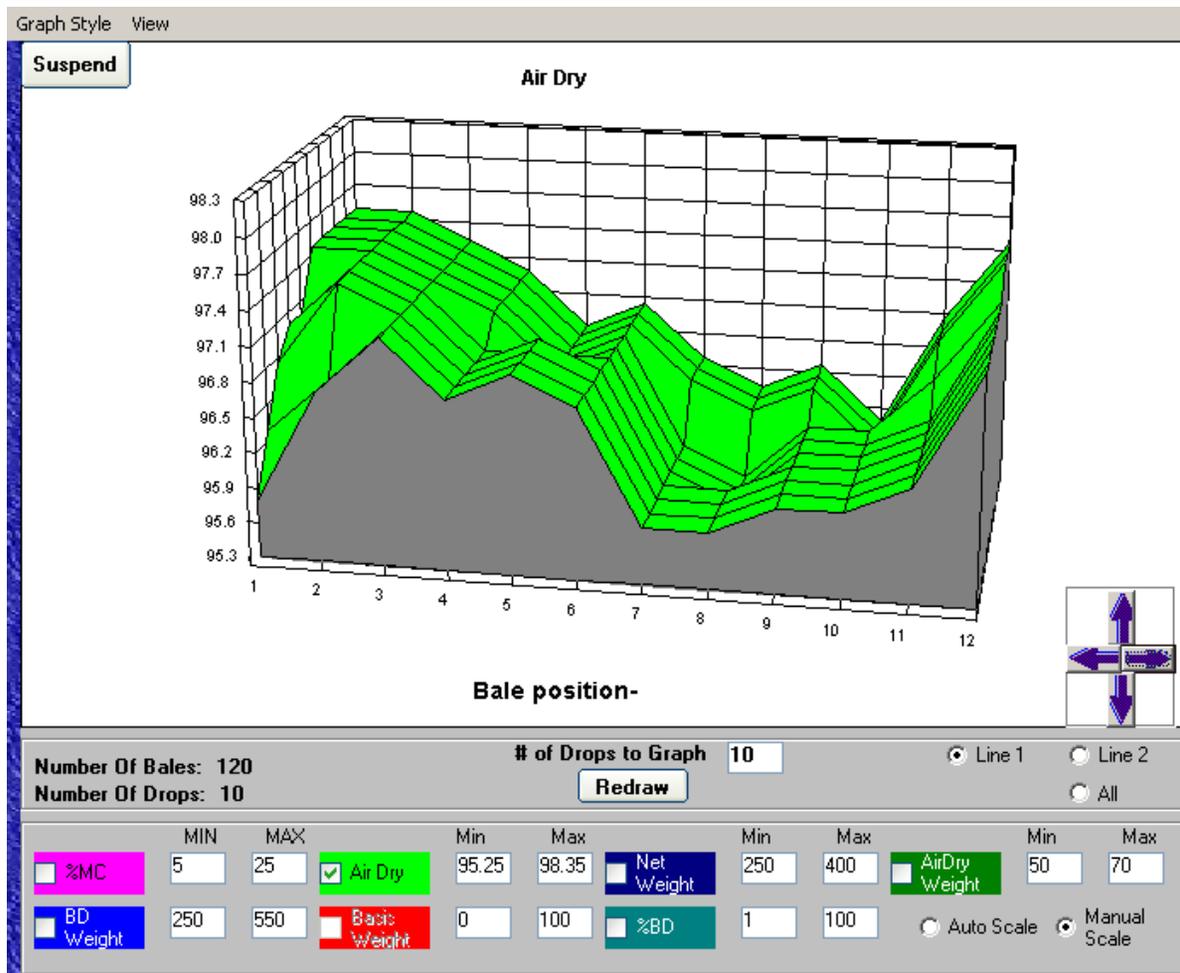
This graph displays a drop of twelve bales.

This can be used by the Wet End operator to control the dryer and prevent sheet breaks.

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% Air-Dry Graph by Bale Position and Drop

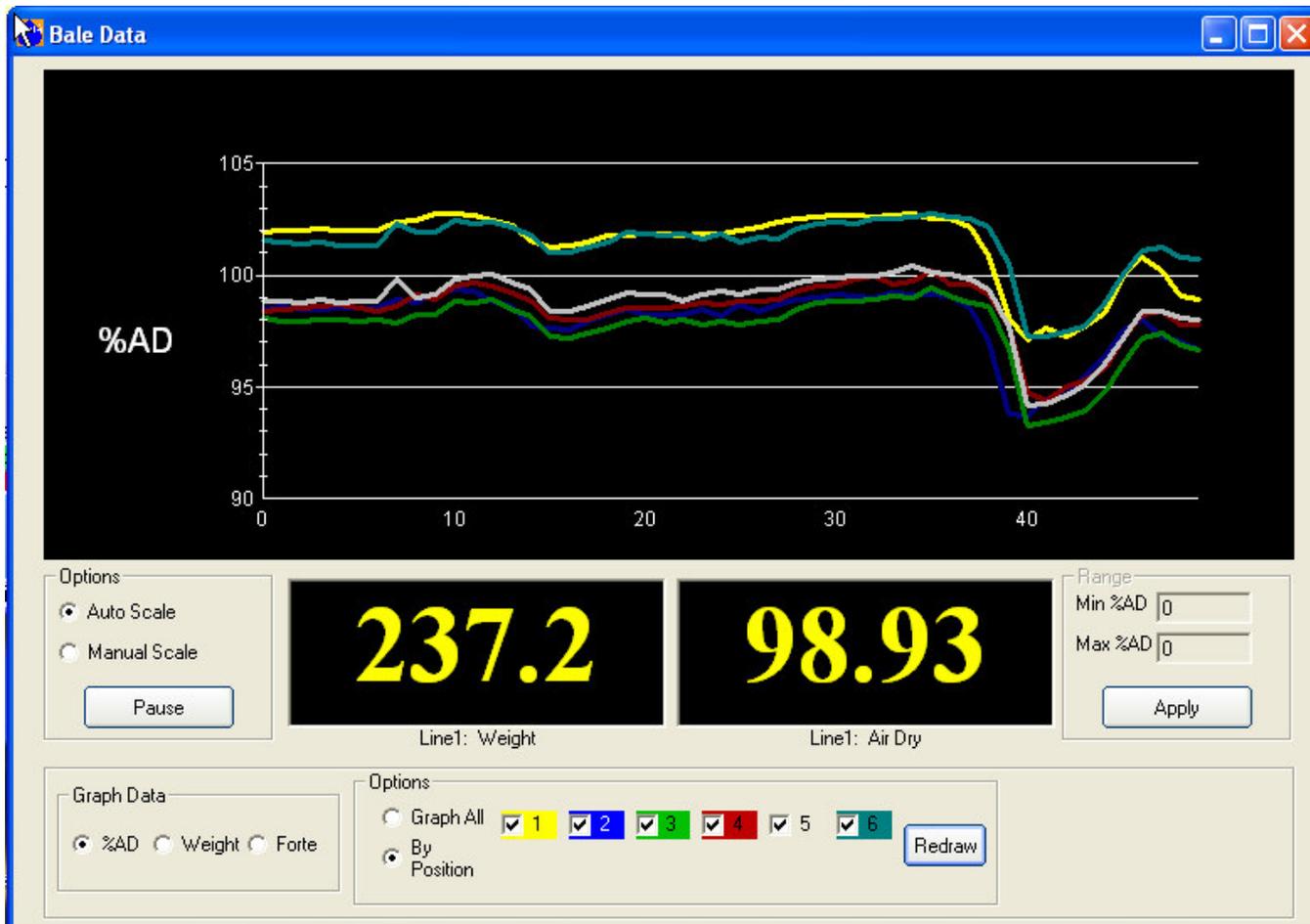


This carpet graph displays several drops

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Trends by Drop Position

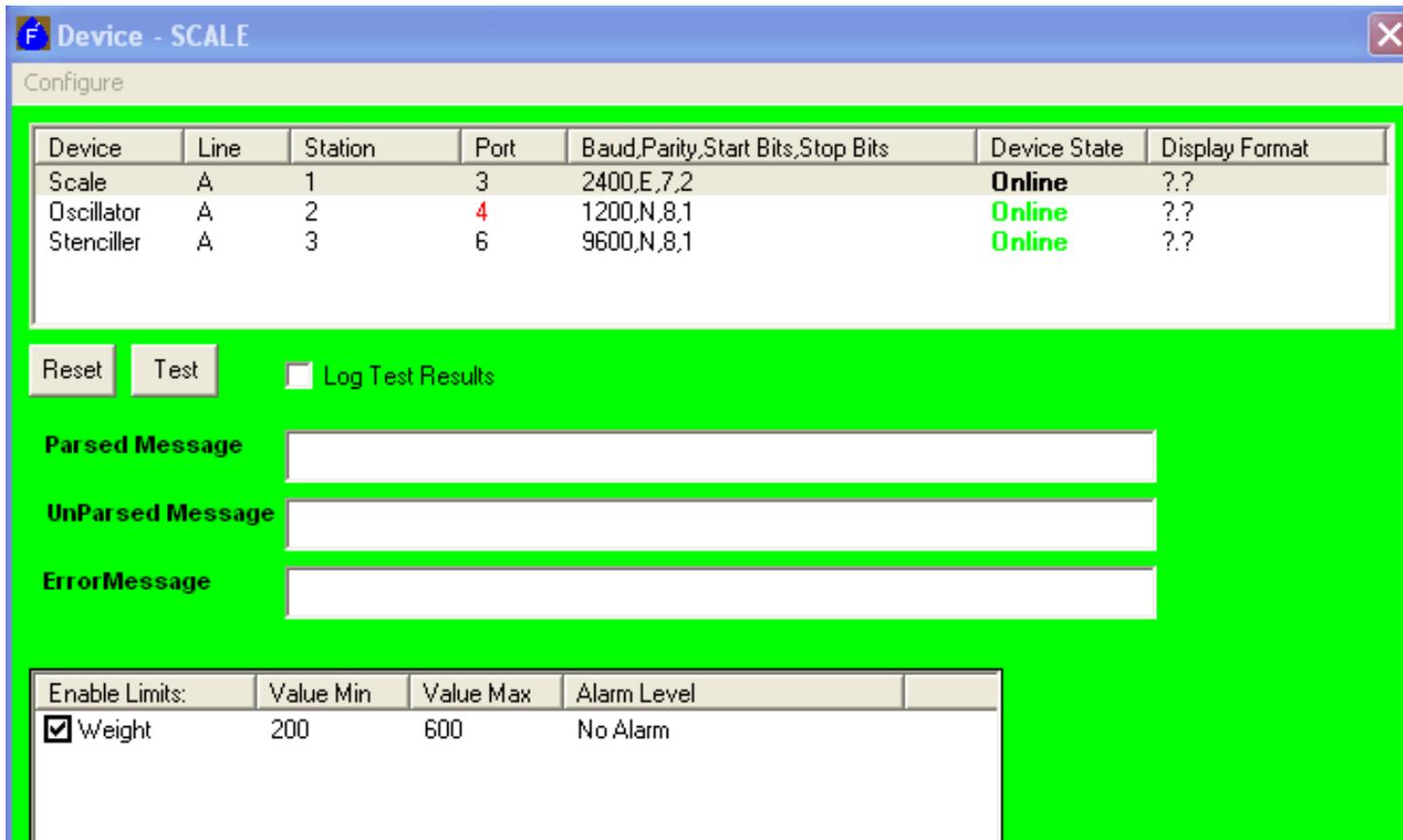


The last 300 bales are displayed by drop position. This allows the user to view trends in moisture or weight both horizontally and vertically across the pulp web.

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Devices



The screenshot shows a software window titled "Device - SCALE" with a "Configure" tab. It contains a table of device configurations and status information.

Device	Line	Station	Port	Baud,Parity,Start Bits,Stop Bits	Device State	Display Format
Scale	A	1	3	2400,E,7,2	Online	??
Oscillator	A	2	4	1200,N,8,1	Online	??
Stenciller	A	3	6	9600,N,8,1	Online	??

Below the table are controls for "Reset", "Test", and "Log Test Results" (unchecked). There are three text input fields labeled "Parsed Message", "UnParsed Message", and "ErrorMessage". At the bottom, there is a table for "Enable Limits":

Enable Limits:	Value Min	Value Max	Alarm Level
<input checked="" type="checkbox"/> Weight	200	600	No Alarm

View the status of connected devices.

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Alarm



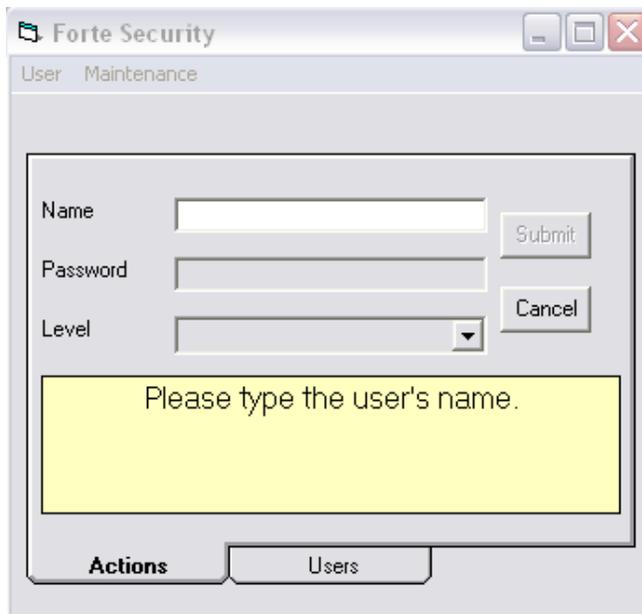
The on screen alarm alerts the user to any system malfunction or, optionally, the alarm will display if bale weight or %AD exceeds the defined limits.

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Security

Standard operation does not require anyone to be logged into the system. There are 5 windows that require a user to be logged on in order to access restricted areas. There are 9 different access levels. The Forté system automatically logs every user off after 15 minutes to help prevent unauthorized changes to the Forté system. A user with sufficient access needs to be logged on in order to shut down the Forté system.



Forté Security

User Maintenance

Name

Password

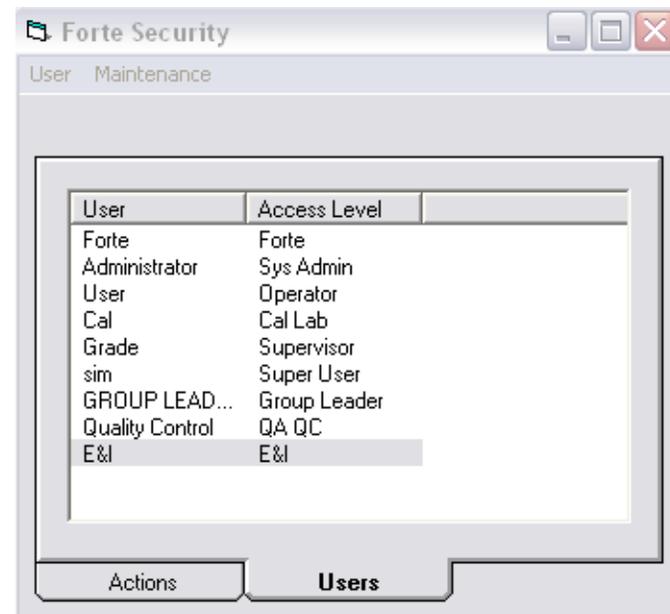
Level

Submit

Cancel

Please type the user's name.

Actions Users



Forté Security

User Maintenance

User	Access Level
Forte	Forte
Administrator	Sys Admin
User	Operator
Cal	Cal Lab
Grade	Supervisor
sim	Super User
GROUP LEAD...	Group Leader
Quality Control	QA QC
E&I	E&I

Actions Users

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Maintenance



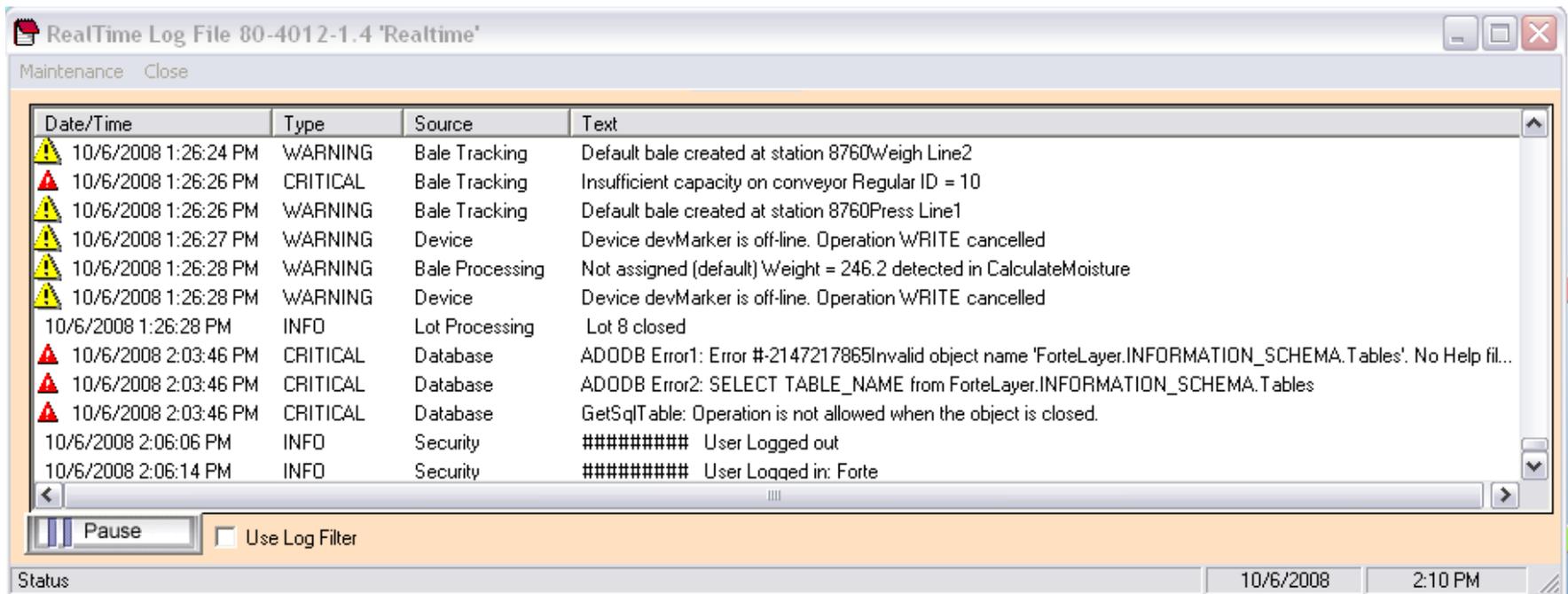
- Electrode and cover plate should be cleaned with ammonium chloride or isopropyl alcohol at least once a year, more often if hydraulic fluid and grease are prevalent at bale press.
- Reset photo switch and reflector need to be kept aligned and free from contaminants.
- Inspect all external cables and ground connections for wear and abuse.
- Clean the conveyor passageway through the test cell, removing stray pieces of product and wrapper material.

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Troubleshooting

The first place to look if a problem arises is in the System Info Log. This Log shows all of the steps the system has gone through, and any warnings that have occurred. The log may help determine the cause of the problem.



The screenshot shows a window titled "RealTime Log File 80-4012-1.4 'Realtime'". The window contains a table with the following columns: Date/Time, Type, Source, and Text. The table lists various system events, including warnings and critical errors. At the bottom of the window, there is a "Pause" button and a "Use Log Filter" checkbox. The status bar at the bottom shows "Status", "10/6/2008", and "2:10 PM".

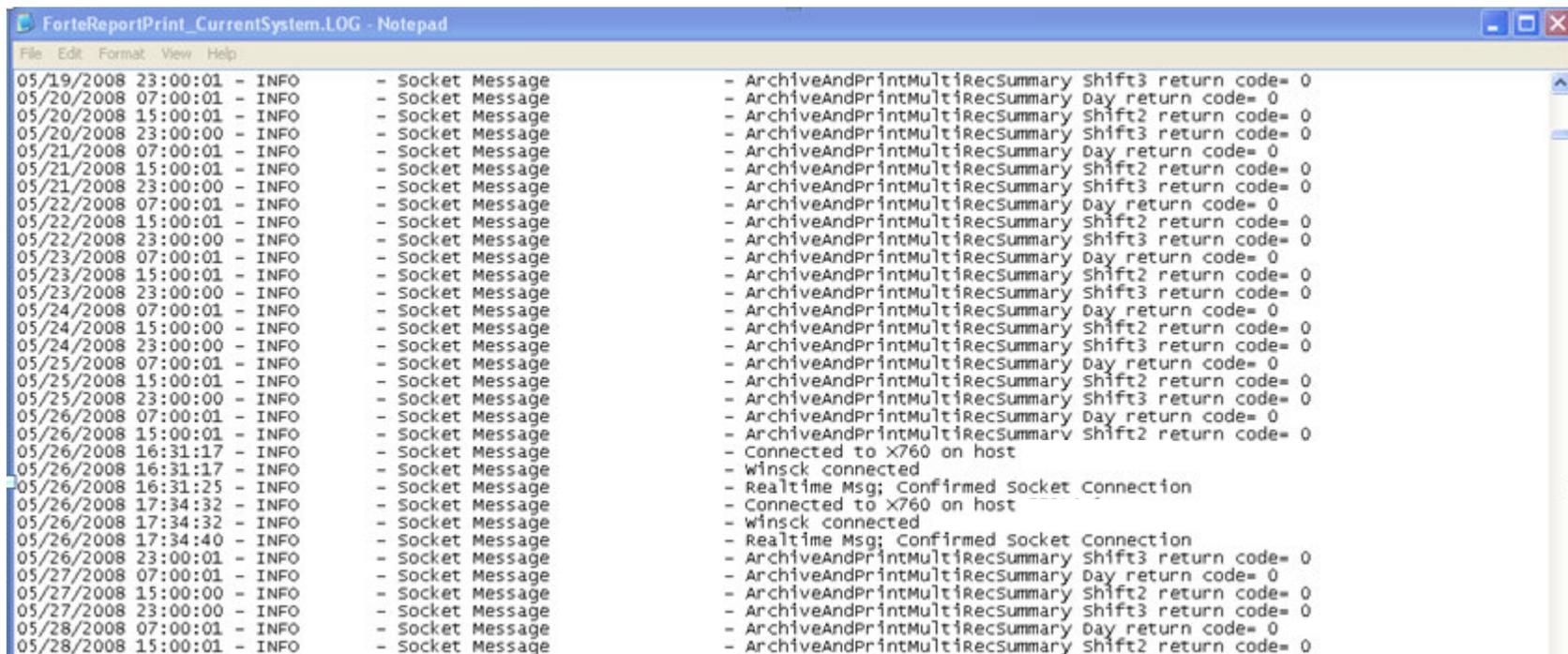
Date/Time	Type	Source	Text
10/6/2008 1:26:24 PM	WARNING	Bale Tracking	Default bale created at station 8760Weigh Line2
10/6/2008 1:26:26 PM	CRITICAL	Bale Tracking	Insufficient capacity on conveyor Regular ID = 10
10/6/2008 1:26:26 PM	WARNING	Bale Tracking	Default bale created at station 8760Press Line1
10/6/2008 1:26:27 PM	WARNING	Device	Device devMarker is off-line. Operation WRITE cancelled
10/6/2008 1:26:28 PM	WARNING	Bale Processing	Not assigned (default) Weight = 246.2 detected in CalculateMoisture
10/6/2008 1:26:28 PM	WARNING	Device	Device devMarker is off-line. Operation WRITE cancelled
10/6/2008 1:26:28 PM	INFO	Lot Processing	Lot 8 closed
10/6/2008 2:03:46 PM	CRITICAL	Database	ADODB Error1: Error #-2147217865Invalid object name 'ForteLayer.INFORMATION_SCHEMA.Tables'. No Help fil...
10/6/2008 2:03:46 PM	CRITICAL	Database	ADODB Error2: SELECT TABLE_NAME from ForteLayer.INFORMATION_SCHEMA.Tables
10/6/2008 2:03:46 PM	CRITICAL	Database	GetSqlT able: Operation is not allowed when the object is closed.
10/6/2008 2:06:06 PM	INFO	Security	##### User Logged out
10/6/2008 2:06:14 PM	INFO	Security	##### User Logged in: Forte

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Troubleshooting

If the System info log does not go back far enough, or the Forté software will not boot up at all, go into the ASCII Log. The ASCII Log can be found in C:\ForteSystem\Realtime\ASCIIlog. The ASCII Log goes back further than the Systems log to help determine the root cause of a problem.



```
05/19/2008 23:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift3 return code= 0
05/20/2008 07:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Day return code= 0
05/20/2008 15:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift2 return code= 0
05/20/2008 23:00:00 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift3 return code= 0
05/21/2008 07:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Day return code= 0
05/21/2008 15:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift2 return code= 0
05/21/2008 23:00:00 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift3 return code= 0
05/22/2008 07:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Day return code= 0
05/22/2008 15:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift2 return code= 0
05/22/2008 23:00:00 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift3 return code= 0
05/23/2008 07:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Day return code= 0
05/23/2008 15:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift2 return code= 0
05/23/2008 23:00:00 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift3 return code= 0
05/24/2008 07:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Day return code= 0
05/24/2008 15:00:00 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift2 return code= 0
05/24/2008 23:00:00 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift3 return code= 0
05/25/2008 07:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Day return code= 0
05/25/2008 15:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift2 return code= 0
05/25/2008 23:00:00 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift3 return code= 0
05/26/2008 07:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Day return code= 0
05/26/2008 15:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift2 return code= 0
05/26/2008 16:31:17 - INFO - Socket Message - Connected to X760 on host
05/26/2008 16:31:17 - INFO - Socket Message - winsck connected
05/26/2008 16:31:25 - INFO - Socket Message - Realtime Msg; confirmed socket connection
05/26/2008 17:34:32 - INFO - Socket Message - Connected to X760 on host
05/26/2008 17:34:32 - INFO - Socket Message - winsck connected
05/26/2008 17:34:40 - INFO - Socket Message - Realtime Msg; confirmed Socket Connection
05/26/2008 23:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift3 return code= 0
05/27/2008 07:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Day return code= 0
05/27/2008 15:00:00 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift2 return code= 0
05/27/2008 23:00:00 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift3 return code= 0
05/28/2008 07:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Day return code= 0
05/28/2008 15:00:01 - INFO - Socket Message - ArchiveAndPrintMultiRecSummary Shift2 return code= 0
```

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Recommendations

- Shut the program and computer down properly, do not just power off or the Forte databases may become corrupted.
- If the “B” value in the calibration needs to be adjusted frequently, there may be another problem. Check to see if the electrode needs to be cleaned.
- Wipe down the photo switch, reflector, and sides of electrode every couple of weeks.
- Create back ups.

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Are you using all of the features
the Forté system offers?



1. Production data input to Forté manually or via barcode, ethernet, etc.
2. Output of Forté data to a remote database through a shared file (text or Excel) or through ODBC interface.
3. Output of data to existing stenciller device.
4. Output to remote display or external alarm.
5. SQL database for process control.

FORTÉ SAVES YOU TIME & MONEY BY PROVIDING A RELIABLE SOLUTION FOR FULLY INTEGRATING MOISTURE MEASUREMENT INTO YOUR PRODUCTION AND SALES PROCESSES.

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