

Камерные печи для предварительного нагрева форм и инструментов N

Технические характеристики

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Chamber Furnaces to Preheat Molds and Tools

These universal chamber furnaces with radiation heating have been specifically designed to withstand heavy-duty use in the tool shop and industry. They are particularly useful for processes such as tool making or for hardening jobs, e.g. annealing, hardening and forging. With help of various accessories, these furnaces can be customized to every application requirements.



Annealing furnace N 7/H, as table-top model with optional protective gas box



Chamber furnace N 41/H with optional protective gas box

Standard Equipment

- Compact, robust design construction with double-walled housing
- Door can be opened when furnace is hot
- Deep furnace chamber with three-sides heating: from both side walls and bottom
- Heating elements on support tubes ensure free heat radiation and a long service life
- Bottom heating protected by heat-resistant SiC plate (models N 81/.. - N 641/.. also with side SiC plates)
- Stainless steel upper door jamb protects furnace structure when furnace is opened hot up to model N 87/H. Models N 81/... - N 641/.. with compact stainless steel door.
- Temperature uniformity up to ± 10 °C according to DIN 17052-1 see page 94
- Low energy consumption due to multi-layer insulation
- Base frame included in the delivery, N 7/H - N 17/HR designed as table-top model
- Exhaust opening in the side of the furnace, or on rear wall of chamber furnace in the N 31/H models and higher
- Parallel swinging door (user protected from heat radiation) up to N 87/H guided downwards, from N 81 guided upwards
- Door movement cushioned with gas dampers/struts
- Heat resistant zinc paint for protection of door and door frame (for model N 81 and larger)
- NTLog Basic for Nabertherm controller: recording of process data with USB-flash drive
- Controller with touch operation B500 (5 programs with 4 segments each), controls description see page 84
- Freeware NTEdit for convenient program input via Excel™ for Windows™ on the PC
- Freeware NTGraph for evaluation and documentation of firings using Excel™ for Windows™ on the PC
- MyNabertherm App for online monitoring of the firing on mobile devices for free download

Additional Equipment

- Side heating elements protected with SiC tiles
- Thermocouple inlet with a diameter of 15 mm in the side
- Pneumatic door opening, controlled by foot pedal
- Protective gas boxes for heat treatment under non-flammable protective and reaction gases
- Gas feed fittings
- Charging devices
- Charge control



Chamber furnace N 87/H



Chamber furnace N 81/13 with pneumatic lift door

Model	Tmax °C	Inner dimensions in mm			Volume in l	Outer dimensions ⁴ in mm			Heating power in kW ³	Electrical connection*	Weight in kg
		w	d	h		W	D	H			
N 7/H ¹	1280	250	250	140	9	800	650	600	3.0	1-phase	60
N 11/H ¹	1280	250	350	140	11	800	750	600	3.5	1-phase	70
N 11/HR ¹	1280	250	350	140	11	800	900	600	5.5	3-phase ²	70
N 17/HR ¹	1280	250	500	140	17	800	900	600	6.4	3-phase ²	90
N 31/H	1280	350	350	250	30	1040	1030	1340	15.0	3-phase	210
N 41/H	1280	350	500	250	40	1040	1180	1340	15.0	3-phase	260
N 61/H	1280	350	750	250	60	1040	1430	1340	20.0	3-phase	400
N 87/H	1280	350	1000	250	87	1040	1680	1340	25.0	3-phase	480
N 81	1200	500	750	250	80	1300	2000	2000	20.0	3-phase	950
N 161	1200	550	750	400	160	1350	2085	2300	30.0	3-phase	1160
N 321	1200	750	1100	400	320	1575	2400	2345	47.0	3-phase	1570
N 641	1200	1000	1300	500	640	1850	2850	2650	70.0	3-phase	2450
N 81/13	1300	500	750	250	80	1300	2000	2000	22.0	3-phase	970
N 161/13	1300	550	750	400	160	1350	2085	2300	35.0	3-phase	1180
N 321/13	1300	750	1100	400	320	1575	2400	2345	60.0	3-phase	1600
N 641/13	1300	1000	1300	500	640	1850	2850	2650	80.0	3-phase	2500

¹Table-top model

²Heating only between two phases

³Depending on furnace design connected load might be higher

⁴External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

*Please see page 86 for more information about supply voltage



Working with protective gas boxes for a protective gas atmosphere using a charging cart



Chamber furnace N 7/H as table-top model



Deep furnace chamber with three-sides heating



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