

Высокотемпературные печи с верхним колпаком с изоляцией до 1800 °С НТ

Технические характеристики

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High-Temperature Top Hat Furnaces or Bottom Loading Furnaces with Molybdenum Disilicide Heating Elements and Fiber Insulation up to 1800 °C

High-temperature top hat furnaces are ideal for applications that require high temperatures, such as sintering of ceramic components. The furnace is designed so that the table can be accessed from three sides and also ensures ergonomic loading and unloading of large components. Complex structures and smaller components can also be charged safely. The furnaces can be equipped with a movable top hat or a movable table.

The basic furnace comes with one fixed table. The system can be extended with one or more changeable tables, either manually or electrically driven, for example, to achieve higher throughput. Other additional equipment, like controlled cooling systems to short process cycles or the addition of a debinding package for debinding and sintering in one process provide for tailored solution for individual needs.



Top hat furnace HT 1000/17 LT



Top hat furnace HT 750/18 LTS

Standard Equipment

- Tmax 1600 °C, 1750 °C or 1800 °C
- Recommended maximum working temperature approx. 50 °C below Tmax of the furnace. Higher working temperatures will increase wear and tear.
- Top hat furnaces: electrohydraulically driven top hat with fixed table
- Bottom loading furnaces: driven table and fixed top hat
- Two-hand operation for manual hood/table movement
- Gently running, low-vibration spindle drive or electrohydraulic drive for larger models
- Motorized hood locking securing the hood in upper position
- Safe and tight closing of the furnace by means of labyrinth seal
- Heating from all four sides provides for good temperature uniformity
- High-quality fiber insulation backed by special insulation
- Side insulation constructed with tongue and groove blocks provides for low heat dissipation to the outside
- Long-life, robust roof insulation with special suspension
- Furnace table with special bottom reinforcement to accommodate high charge weights (distributed load 5 kg/dm²)
- Motorized exhaust air flap in the furnace roof, controlled via the extra function of the controller
- Heating elements switched via SCR's
- Controller with touch operation P570 (50 programs with each 40 segments), controls description see page 86
- NTLog Basic for Nabertherm controller: recording of process data with USB-flash drive see page 87
- Freeware NTEdit for convenient program input via Excel™ for Windows™ on the PC see page 87
- Freeware NTGraph for evaluation and documentation of firings using Excel™ for Windows™ on the PC see page 87
- MyNabertherm App for online monitoring of the firing on mobile devices for free download see page 84

Additional Equipment

- Cooling system to cool the furnace with a defined temperature gradient or with a preset fresh air volume. Both operating modes can be switched on and off for different segments by means of the extra function of the controller.
- Stainless steel exhaust hood as interface to customer's exhaust system
- Customer-specific arrangement of the heating elements to optimize temperature uniformity, for example, with heating elements between the charge stacks
- Special heating element qualities e.g. for zirconoxide applications
- Thermoelement for the heating control with calibration certificate
- Protective gas connection for purging the furnace with non-flammable process gases (not completely gas-tight)
- Automatic gas supply system with solenoid valve and rotameter, controlled by the extra function of the controller
- Bottom insulation made of durable lightweight refractory bricks for especially heavy charge weights (Tmax 1650 °C)
- Options for table exchange systems:
 - Manual or automatic table exchange system with one or two tables
 - Multi-table exchange system with tables transportable by fork lift
- An electric mover ensures smooth movement of the freemoving table



High-temperature bottom loading furnace
HT 166/16 LB DB200-3S



Top hat furnace HT 558/18 LT



High-temperature top hat furnace HT 550/17 LT with manual interchangeable table system including rail system and second table for optimized loading and unloading



High-temperature top hat furnace HT 1700/17 LT DB200-5 for debinding and sintering ceramic powders



High-temperature top hat furnace HT 1030/16 LT



High-temperature top hat furnace HT 230/17 LT with driven hood

Model	Tmax °C	Inner dimensions in mm			Volume in l	Outer dimensions ¹ in mm			Heating power in kW ²	Electrical connection*	Weight in kg
		w	d	h		W	D	H			
HT 64/16 LB, LT	1600	400	400	400	64	1100	1750	2400	36	3-phase	1100
HT 166/16 LB, LT	1600	550	550	550	166	1350	2060	2600	42	3-phase	1500
HT 276/16 LB, LT	1600	1000	500	550	276	1800	2100	2600	69	3-phase	1850
HT 400/16 LB, LT	1600	1200	600	550	400	1900	2200	2680	69	3-phase	2600
HT 500/16 LB, LT	1600	1550	600	550	500	2100	2200	2680	69	3-phase	2700
HT 1000/16 LB, LT	1600	1000	1000	1000	1000	1800	2900	4000	140	3-phase	3000
HT 1030/16 LB, LT	1600	2200	600	780	1030	2950	2500	3050	160	3-phase	3200
HT 64/17 LB, LT	1750	400	400	400	64	1100	1750	2400	36	3-phase	1100
HT 166/17 LB, LT	1750	550	550	550	166	1350	2060	2600	42	3-phase	1500
HT 276/17 LB, LT	1750	1000	500	550	276	1800	2100	2600	69	3-phase	1850
HT 400/17 LB, LT	1750	1200	600	550	400	1900	2200	2680	69	3-phase	2600
HT 500/17 LB, LT	1750	1550	600	550	500	2100	2200	2680	69	3-phase	2700
HT 1000/17 LB, LT	1750	1000	1000	1000	1000	1800	2900	4000	140	3-phase	3000
HT 1030/17 LB, LT	1750	2200	600	780	1030	2950	2500	3050	160	3-phase	3200
HT 64/18 LB, LT	1800	400	400	400	64	1100	1750	2400	36	3-phase	1100
HT 166/18 LB, LT	1800	550	550	550	166	1350	2060	2600	42	3-phase	1500
HT 276/18 LB, LT	1800	1000	500	550	276	1800	2100	2600	69	3-phase	1850
HT 400/18 LB, LT	1800	1200	600	550	400	1900	2200	2680	69	3-phase	2600
HT 500/18 LB, LT	1800	1550	600	550	500	2100	2200	2680	69	3-phase	2700
HT 1000/18 LB, LT	1800	1000	1000	1000	1000	1800	2900	4000	140	3-phase	3000
HT 1030/18 LB, LT	1800	2200	600	780	1030	2950	2500	3050	160	3-phase	3200

¹External dimensions vary when furnace is equipped with additional equipment. Dimensions on request

²Depending on furnace design connected load might be higher

*Please see page 86 for more information about supply voltage



Motorized hood lock



Two-hand operation



Automatic gas supply system



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