

Комбинированные камерные печи до 1400 °С для удаления связующего и спекания в одном процессе

N

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Combi Chamber Furnaces up to 1400 °C for Debinding and Sintering in One Process

The combi chamber furnaces N 100 DB - N 1500/14 DB are specially developed for debinding and sintering in one process. The furnaces have a fresh air supply providing for dilution of the exhaust gases produced during debinding, for safe prevention of an inflammable atmosphere in the furnace chamber. The standard version of the furnaces is equipped with the debinding package DB100. This debinding package provides for an injection of fresh air for atmosphere dilution which means that the furnace works under overpressure during debinding.

As a professional solution for production furnaces, we recommend the debinding package DB200. The furnace then has a warm fresh-air injection with variable speed through distribution tubes in the furnace chamber. The exhaust fan operates also with a variable fan speed. The PLC automatically regulates a negative pressure inside the furnace chamber.



Combi chamber furnace N 300/14 DB200

Standard Equipment

- Tmax 1280 °C, 1340 °C or 1400 °C
- Five-sided heating from all four sides and from the floor for a good temperature uniformity
- Multi-layer insulation consisting of lightweight refractory bricks backed by special insulation
- Self-supporting and long-life ceiling construction, with bricks laid in arched construction
- Motorized exhaust air flap on the furnace roof
- Debinding package DB50 for chamber furnace N 100.. see page 8
- From model N 200: debinding package DB100 with fresh-air fan, air-preheater and controls see page 9
- Over-temperature limiter with adjustable cutout temperature as temperature limiter to protect the furnace and load
- Controller with touch operation P570 (50 programs with each 40 segments) for models N 100.., controls description see page 76
- From model N 200: HiProSystems H1700, including Siemens PLC control and 7" touch panel as operator interface see page 84



Combi chamber furnace N 1000/14 DB200-3

Additional Equipment

- Multi-zone control adapted to the particular furnace model for optimizing the temperature uniformity
- Commissioning of the furnace with test firing and temperature uniformity measurement (also with load) for the purpose of process optimization see page 13
- Debinding package DB200 with safety concept see page 9
- Thermal or catalytic exhaust cleaning systems see page 12
- Redundant thermocouples to increase process safety
- Calibration interfaces for the measuring range
- SiC support beams for ease of loading/unloading using a forklift
- Guiding rails for forklift



Production line consisting of combi chamber furnaces N 650 DB200 with catalytic post combustion for alternating operation

Model	Tmax	Inner dimensions in mm			Volume in l	Outer dimensions ¹ in mm			Heating power for single-zone heating control kW ²	Electrical	Weight in kg
	°C	w	d	h		W	D	H		connection*	
N 100 DB50	1280	400	530	460	90	1100	1150	1850	11	3-phase	350
N 200 DB..	1280	400	530	720	140	850	1350	2220	15	3-phase	500
N 300 DB..	1280	450	700	780	230	900	1600	2280	20	3-phase	800
N 450 DB..	1280	550	760	1000	350	1390	1570	2520	40	3-phase	1400
N 650 DB..	1280	660	850	1100	610	1250	1680	2720	62	3-phase	1600
N 1000 DB..	1280	740	1000	1250	940	1800	1800	2800	57	3-phase	2700
N 1500 DB..	1280	840	1200	1400	1400	1660	2300	2950	75	3-phase	3300
N 100/H DB50	1340	400	530	460	90	1100	1150	1850	15	3-phase	350
N 200/H DB..	1340	400	530	720	140	850	1350	2220	22	3-phase	500
N 300/H DB..	1340	450	700	780	230	900	1600	2280	30	3-phase	800
N 450/H DB..	1340	550	760	1000	350	1390	1570	2520	40	3-phase	1400
N 650/H DB..	1340	660	850	1100	610	1250	1680	2720	62	3-phase	1600
N 1000/H DB..	1340	740	1000	1250	940	1800	1800	2800	75	3-phase	2700
N 1500/H DB..	1340	840	1200	1400	1400	1660	2300	2950	110	3-phase	3300
N 100/14 DB50	1400	400	530	460	90	1100	1150	1850	15	3-phase	350
N 200/14 DB..	1400	400	530	720	140	850	1350	2220	22	3-phase	500
N 300/14 DB..	1400	450	700	780	230	900	1600	2280	30	3-phase	800
N 450/14 DB..	1400	550	760	1000	350	1390	1570	2520	40	3-phase	1400
N 650/14 DB..	1400	660	850	1100	610	1250	1680	2720	62	3-phase	1600
N 1000/14 DB..	1400	740	1000	1250	940	1800	1800	2800	75	3-phase	2700
N 1500/14 DB..	1400	840	1200	1400	1400	1660	2300	2950	110	3-phase	3300

¹Outer dimensions vary depending on the scope of supply. Dimensions on request.

²Depending on furnace design connected load might be higher

*Please see page 80 for more information about supply voltage



Catalytic or thermal post combustion as additional equipment available (picture shows thermal post combustion)



Injection of preheated air through perforated ceramic tubes



SiC support beams for ease of loading/unloading using a forklift



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