

Комбинированные печи с выдвижным подом и нагревом проволоки до 1400 °С для удаления связующего и спекания в одном процессе DB

Технические характеристики

По вопросам продаж и поддержки обращайтесь:

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Ярославль (4852)69-52-93

Россия +7(495)268-04-70

Казахстан +(727)345-47-04

Беларусь +(375)257-127-884

Узбекистан +998(71)205-18-59

Киргизия +996(312)96-26-47

эл.почта: nme@nt-rt.ru || сайт: <http://nabertherm.nt-rt.ru/>

Combi Bogie Hearth Furnaces with Wire Heating up to 1400 °C for Debinding and Sintering in One Process

The combi bogie hearth furnaces were developed especially for debinding with subsequent sintering in one process. Equipped with a passive safety system, all functions relevant for debinding processes are monitored to ensure safe operation of the furnace. Also as part of the safety package, the furnace atmosphere is diluted with fresh air to prevent forming of a combustible atmosphere by the exhaust gases evaporating from the charge during debinding.

In the basic model, the furnaces are equipped with the DB100 debinding package. With this debinding package, preheated fresh air is supplied into the furnace chamber ensuring that the combi bogie hearth furnace is operated with overpressure during the debinding phase.

For high binder amounts and/or varying debinding processes, these production furnaces are equipped with the DB200 debinding package. The bogie hearth furnace then has a fresh air fan, which blows preheated fresh air into the furnace chamber via an air preheater, and an exhaust gas fan on the exhaust gas duct. This ensures that the volume of fresh air required for the debinding process is blown-in and, at the same time, an underpressure in the furnace chamber is automatically regulated via the furnace control system. The combi bogie hearth furnaces and the debinding packages can be customized to suit many different process requirements.



Combi bogie hearth furnace W 1000 DB200-3



Combi bogie hearth furnace W 1500/14 DB200-3 with thermal post combustion. lift door and bogie on rails

Standard Design

Such as bogie hearth furnaces with wire heating up to 1400 °C (see page 22), however:

- No adjustable fresh air flap
- Stainless steel exhaust air hood as an interface to the customer's extraction system
- HiProSystems H1700, including Siemens PLC control system and 7" touchpanel as operating interface see page 84

Debinding Package DB100

- Basic model for safe debinding operation with small binder amounts
- Fresh air fan and fresh air preheater
- Exhaust gas and exhaust air removed via one outlet with a motor-driven flap in an exhaust hood
- Performance of the debinding package customized to the process requirements
- For more details about the DB100 debinding package see page 9

Debinding Package DB200

- Professional solution for large amounts of binder and changing varying processes
- Fresh air fan, fresh air preheater and monitoring of fresh air and exhaust gas flow rates
- Separate discharge of exhaust gases during debinding and exhaust air during cooling via separate outlets with motor-driven flaps
- Extendable with catalytic or thermal post combustion for a single furnace or alternating operation with two furnaces see page 12
- Performance of the debinding package customized to the process requirements
- For more details about the DB200 debinding package see page 9



Furnace system with six combi bogie hearth furnaces W 2254/14 DB200-3 with catalytic post combustion for alternating operation, lift door and transfer system with loading/unloading station for automatic operation



Two combi bogie hearth furnaces W 2254/14 DB200-4 with catalytic post combustion for alternating operation

Additional Equipment

- Multiple-zone control to optimize temperature uniformity
- Electro-hydraulic lift door
- Various extension options for transfer operations:
 - Additional bogies
 - Bogie with flanged wheels running on rails
 - Electric chain drive for bogie on rails
 - Bogie transfer system manually operated with parking rails to exchange bogies with one or multiples furnaces
 - Automatic operation for bogie transfer system
 - Alternating operation of two bogies with lift doors at the front and back of the furnace or with turntable in front of the furnace
- With debinding package DB200: Thermal or catalytic post combustion systems see page 12



Turntable to exchange bogies in front of the furnace



Thermal post combustion



Electro-hydraulic lift door



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