Комбинированные колпаковые печи до 1400 °C для удаления связующего и спекания в одном процессе DB

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Combi-Top Hat Furnaces or Combi-Bottom Loading Furnaces with Wire Heating up to 1400 °C for Debinding and Sintering in One Process

Like the bogie hearth furnace, the top hat and bottom loading furnaces will be equipped with a safety system for debinding in air to allow for a safe operation of debinding and sintering processes performed in one step. Based on the dilution principle, fresh air will be supplied to the furnace chamber in a controlled way to reliably prevent a combustible atmosphere forming inside the furnace by the exhaust gases evaporating from the charge. In addition, debinding-related functions will be monitored to protect the operator and the surrounding.

For small amounts of binder, the basic versions of the combi top hat and bottom loading furnaces are equipped with the DB100 debinding package. With this package, pre-heated fresh air is blown into the furnace so that the combi bogie hearth furnace is operated with overpressure during the debinding phase.

The DB200 debinding package is used for alternating debinding processes and/or large amounts of binder. Like the DB100 debinding package, preheated fresh air is supplied to the furnace chamber via a fresh air fan with air preheater. The furnace also has an exhaust gas fan, which removes the exhaust gases from the furnace via a separate outlet during debinding. For this purpose, the flow rates of the fresh air and exhaust gas are coordinated to ensure that there is always a slight underpressure in the furnace chamber during debinding.

Top hat furnace H 3000 DB200-3 with interchangeable table system for two tables and catalytic post combustion system KNV 320 installed on the housing

Top hat furnace H 3000 DB-S with manual interchangeable table system for two tables

Standard Design

Refer to top hat furnaces or bottom loading furnaces with wire heating see page 28

- HiProSystems H1700, including Siemens PLC control system and 7" touchpanel as operating interface see page 84

Debinding Package DB100

- Basic design for safe debinding operation with small amounts of binder
- 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 debinding 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

Top hat furnace H 500 DB200 with catalytic post combustion, automatic table changing system and security scanners to protect the danger zone

Lift bottom furnace HF 450/10 LB DB200-2 with fiber insulation for fast heating and cooling times

Additional Equipment

- Tmax 1400 °C
- Sides with fiber insulation to reduce cycle times
- Fabric cover on the fiber roof (and sides) to reduce fiber dust
- Multiple-zone control, adapted for the respective furnace model to optimize temperature uniformity
- Additional tables, interchangeable table system, also motorized
- With debinding package DB200: Thermal or catalytic exhaust air treatment systems see page 12
- Redundant thermocouples to increase process reliability
- Calibration interfaces for the measuring section

Catalytic post combustion integrated on the furnace housing to save space

Manual interchangeable table system for two tables for parallel loading and unloading of the charge

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