

Камерные печи с принудительной конвекцией до 850 °С для удаления связующего НА

Технические характеристики

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Forced Convection Chamber Furnaces up to 850 °C for Debinding

Forced convection chamber furnaces equipped with a passive safety system are suitable for pure debinding processes. With their air circulation, these furnaces provide very good temperature uniformity and very good heat transfer into the product. Equipped with the DB200 debinding package, the furnaces have a fresh air fan which supplies preheated fresh air into the furnace chamber. The PLC control system monitors all functions which are relevant for debinding to protect the operator and the surrounding. In addition, a slight underpressure is ensured in the furnace via an exhaust gas fan with variable speed, so that the exhaust gases are actively removed from the furnace during debinding. Consequently, the forced convection chamber furnaces can be used flexibly for various applications from development through to production.



Forced convection chamber furnace NA 500/85 DB200-3 with safety package for debinding in air and thermal post combustion

Standard Design

- Tmax 600 °C, 650 °C or 850 °C
- Temperature uniformity according to DIN 17052-1 to +/- 5 °C see page 89
- Optimum air distribution ensured with high flow rates
- Double door from an interior width of 1500 mm and above (450 °C models), higher temperatures and smaller sizes are equipped with a single, right-hinged door
- Motor-driven exhaust air flaps in the furnace roof for separate discharge of the exhaust gases during debinding and the exhaust air during cooling (850 °C models with stainless steel exhaust hood)
- Over-temperature limiter with manual reset as over-temperature protection for the furnace and the charge
- 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



Production plant with three forced convection chamber furnaces NA 250/85 DB200 for debinding and catalytic post combustion system KNV 320 (reduced footprint construction)

Additional Equipment

- Temperature distribution measurement
- Thermal and catalytic exhaust air treatment see page 12
- Redundant thermocouples to increase process reliability
- Calibration interfaces for the measuring section
- Design for processes in low-dust atmospheres
- Other/customized furnace sizes on request



Forced convection chamber furnace NAC 250/65 DB200-3 with safety package for debinding in air in a low-dust atmosphere and catalytic post combustion



Forced convection chamber furnace NA 4000/60B DB200 for debinding in air with gas-fired thermal post combustion system TNV 300

Model	Tmax °C	Inner dimensions in mm			Volume in l	Outer dimensions ¹ in mm			Electrical connection*
		w	d	h		W	D	H ²	
NA 120/65 DB200	650	450	600	450	120	990	1470	2215	3-phase
NA 250/65 DB200	650	600	750	600	250	1170	1650	2550	3-phase
NA 500/65 DB200	650	750	1000	750	500	1290	1890	2600	3-phase
NA 120/85 DB200	850	450	600	450	120	885	1420	2215	3-phase
NA 250/85 DB200	850	600	750	600	250	1115	1685	2250	3-phase
NA 500/85 DB200	850	750	1000	750	500	1290	1890	2600	3-phase
NA 1000/60 DB200	600	1000	1000	1000	1000	2015	2150	2415	3-phase
NA 1500/60B DB200	600	1500	1000	1000	1500	2015	2650	2450	3-phase

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

²Height including exhaust gas fan

*Please see page 80 for more information about supply voltage



Thermal post combustion



Customized charging rack on request



Optional design with lift door for furnaces up to 500 liters



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