

Наклонные печи К

Технические характеристики

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Tilting Furnaces K

Electrically Heated, for Melting and Holding

The electrically heated tilting furnaces are characterized by very good melt quality and high melting performance with optimum energy efficiency. They are ideal as a flexible solution for pre-melting but also for direct pouring into large moulds.



Tilting furnace K 150/12

Standard Equipment

- K ../12 for aluminum and zinc alloys
- K ../13 for copper alloys such as bronze or brass
- Free-radiating heating elements on support tubes for long service life and simple replacement
- Twelve months warranty on heating elements
- Multi-layer insulation for optimum energy efficiency and low external wall temperatures
- Incl. crucible
- Electro-hydraulic tilting device with safe two-hand operation on the furnace
- Uniform and precise pouring due to optimum pivot point
- Emergency outlet for safe draining of the melt in case of crucible breakage
- No exhaust gas discharge needed
- Integrated safety system which continues to operate the furnace at reduced power in case of malfunction in the thermocouple, in order to prevent the freezing of the melt
- Over-temperature limiter in furnace chamber for protection against overheating. The limiter switches the heating off when the set limit temperature is reached, and only switches it back on after the temperature has fallen again.
- Low-maintenance furnace chamber control with temperature measurement behind the crucible



Tilting furnace K 150/12 and bale-out furnace T 180/11 as premelting and holding system

Additional Equipment

- Safety fence
- Work platform for easy charging
- Collecting pan under the emergency outlet see page 39
- Crucible breakage monitor with visual and audible signal (only for models K ../12)
- Bath control with thermocouples in the furnace chamber and in the melt. The furnace temperature is controlled through the melt. Temperature overshoots are reduced, thus the quality of the melt is improved
- Heating system operated through thyristors
- Multi-step switching of the furnace heat (see page 43)
- Models with increased heating power
- Process control and documentation via Nabertherm Control Center (NCC) for monitoring, documentation and control see page 42



Three tilting furnaces with work platform for melting of aluminum

Model	Tmax furnace °C	Tmax melt bath °C	Crucible	Capacity in kg			Heating power in kW ⁴	Melting performance ^{3,6} in kg/h Al	Consumption melting ⁶ kWh/kg Al	Consumption holding Lid closed/open kWh/h	Outer dimensions ⁵ in mm			Weight in kg
				Al	Zn	Cu					W	D	H	
K 80/12	1200	1050	TP 287	180	470	-	50	126 ¹	0.4 ¹	4/10 ¹	2050	1520	1580	1750
K 150/12	1200	1050	TP 412	330	870	-	60	147 ¹	0.4 ¹	5/12 ¹	2120	1600	1860	2350
K 180/12	1200	1050	TP 412H	370	980	-	60	160 ¹	0.4 ¹	5/12 ¹	2120	1600	1860	2450
K 240/12	1200	1050	TP 587	570	1500	-	80	180 ¹	0.4 ¹	8/17 ¹	2260	1760	1860	2800
K 360/12	1200	1050	TBN 800	750	-	-	100	260 ¹	0.4 ¹	11/20 ¹	2370	1810	1950	3500
K 400/12	1200	1050	TBN 1100	1050	-	-	126	295 ¹	0.4 ¹	12/22 ¹	2370	1930	2100	3700
									Cu	Cu				
K 10/13	1300	1150	A 70	20	50	70	16	47 ²	0.3 ²	5/8 ²	1890	1240	1440	1000
K 20/13	1300	1150	A 150	45	120	150	20	63 ²	0.3 ²	5/8 ²	1890	1400	1460	1300
K 40/13	1300	1150	A 300	90	240	300	26	84 ²	0.3 ²	5/8 ²	2000	1450	1540	1650
K 80/13	1300	1150	TP 287	180	470	550	50	190 ²	0.3 ²	6/11 ²	2050	1520	1580	1950

¹Al at 700 °C

²CuZn at 1000 °C

³The specified melting performances are maximum values. In practice, approx. 80 % are achieved.

⁴Depending on furnace design connected load might be higher

⁵External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

⁶Values for other materials, e. g. zinc, on request



Charging of transport ladle with tilting furnace K 360/12



Tilting furnace K 40/13 with extended spout
(sculpture foundry Knaak)



Filling a mould with liquid bronze
(photographer Andrea Künstle)



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