

Наклонные печи КВ

Технические характеристики

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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/>

Tilting Furnaces KB

Gas-Fired, for Melting and Holding

The gas-fired tilting furnaces in the KB product lines provide for high melting performance, making them ideal for melting operations. The use of high-quality insulation materials results in very low energy consumption. Designed with an exhaust vent over the crucible edge, these tilting furnaces achieve very high melting rates and optimum energy efficiency.



Tilting furnace KB 400/12 with exhaust gas discharge over the crucible edge

Standard Equipment for all Tilting Furnaces

- KB ../12 for aluminum and zinc alloys
- KB ../14 for copper alloys such as bronze or brass
- Modern and powerful two-stage burner for high melting capacity and low maintenance operation
- Exhaust gas discharge over the crucible edge see page 6
- 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 discharge of the melt in case of a crucible break
- 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 for the furnace chamber with automatic reset to protect against over-temperature. The limit controller switches off the heating when the pre-set limit temperature has been reached and does not switch it on again until the temperature falls below the setting again.
- Low-maintenance furnace chamber control with temperature measurement behind the crucible

Standard Equipment for Tilting Furnaces KB ../14

- Insulation with an additional wear-and-tear layer made of copper-resistant refractory concrete

Additional Equipment for all Tilting Furnaces

- Safety fence
- Work platform or platform for easier charging
- Collecting pan under the emergency outlet see page 39
- Information on other accessories see page 38 - 39

Additional Equipment for Tilting Furnaces KB ../12

- Side exhaust gas discharge including cover see pages 7
- Insulated exhaust gas diverter connecting piece (exhaust flue) for side-wall exhaust gas vent to a connected customer suction system
- Crucible breakage monitoring with optical and acoustic signal
- SMS-alarm message in case of crucible breakage
- Bath control system (only when equipped with side exhaust gas discharge) see page 40
- Process control and documentation via Nabertherm Control Center (NCC) for monitoring, documentation and control see page 42



Melting furnace plant consisting of two tilting furnaces KB 360/12 with side exhaust gas discharge and one work platform



Tilting furnace KB 150/12 in production

Model	Tmax furnace °C	Tmax melt bath °C	Crucible	Capacity in kg			Burner output kW	Melting performance ^{3,6} in kg/h Al	Consumption melting ⁶ kWh/kg Al	Consumption holding Lid closed kWh/h	Outer dimensions ⁴ in mm			Weight in kg
				Al	Zn	Cu					W ⁵	D	H	
KB 80/12	1200	1050	TP 287	180	470	-	300	220 ¹	1.3 - 1.5 ¹	10	2730	1530	1680	2100
KB 150/12	1200	1050	TP 412	330	870	-	300	240 ¹	1.0 - 1.3 ¹	11	2830	1630	1880	2600
KB 180/12	1200	1050	TP 412 H	370	970	-	300	260 ¹	1.0 - 1.3 ¹	13	2830	1630	1980	2800
KB 240/12	1200	1050	TP 587	570	1500	-	390	400 ¹	1.0 - 1.3 ¹	15	3120	1840	1980	3100
KB 360/12	1200	1050	TBN 800	750	-	-	450	420 ¹	1.0 - 1.3 ¹	17	3170	1890	2080	3300
KB 400/12	1200	1050	TBN 1100	1000	-	-	450	450 ¹	1.0 - 1.3 ¹	19	3170	1890	2150	3600
KB 40/14	1400	1250	R 400/TP 982	-	-	400	400	330 ²	1.0 - 1.3 ²	22	2710	1530	1550	2400
KB 60/14	1400	1250	R 500	-	-	500	400	360 ²	1.0 - 1.3 ²	25	2710	1530	1550	2700
KB 80/14	1400	1250	R 600	-	-	600	400	380 ²	1.0 - 1.3 ²	25	2710	1530	1710	3400

¹Al at 700 °C

²CuZn at 1000 °C

³The stated melting performances are maximum values. Daily operation comes up to roughly 80 %.

⁴External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

⁵Incl. burner and hydraulic system

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



Hydraulic system with flame resistant hydraulic fluid



Two-stage burner, mounted on furnace frame



Cast copper alloy



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