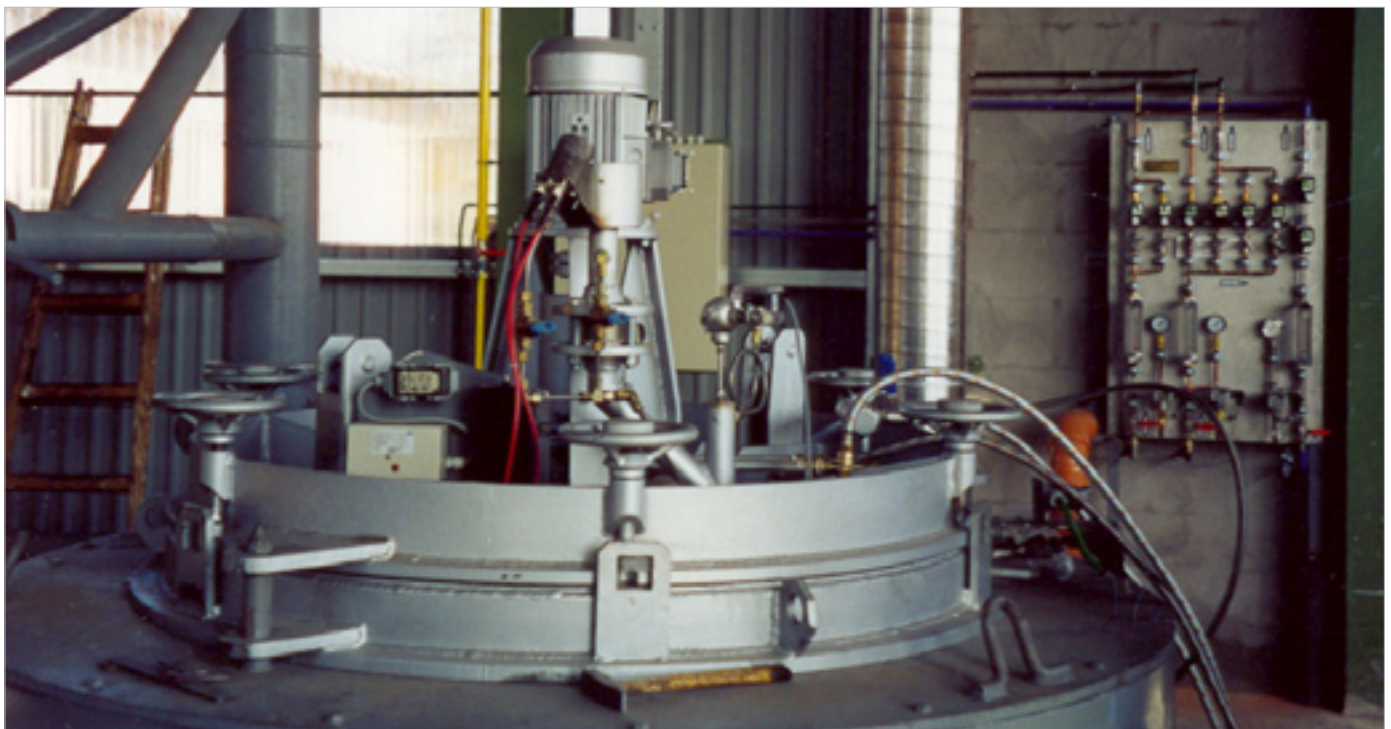


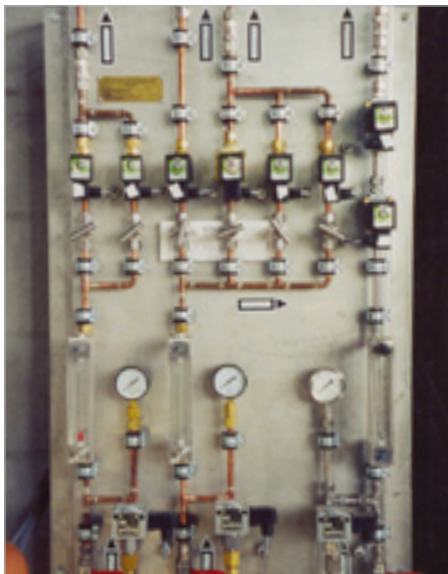
PIT FURNACE WITH A NITRIDING RETORT CHAMBER



FEATURES OF THE APPLIANCE IN THE PHOTO

Heating Method:	electric resistance heating, indirect
Voltage:	3 x 400 V, 50 Hz
Power:	150 kW
Chamber Dimensions (mm):	Ø 1200 x 2500
Max. Operating Temperature:	950 °C
Batch Weight:	1.000 kg
Thermal Insulation:	vacuum formed ceramic fibres
Controls:	PLC programme control
Heat Treatment Process:	nitridation

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<p>Description:</p>	<p>This is a directly heated heat-treating furnace that is designed for batch operation and with a vertical, fully gas-tight chamber that is normally sunk below the shop floor level. The furnace door is fitted with a fan for even temperature distribution and a homogenous active gas atmosphere. Nitridation is achieved through the decomposition of the ammonia that is fed into the furnace. To access the furnace chamber, the top cover needs to be removed. The products are mechanically loaded into the furnace and then held by a support frame. The feeding is carried out by an overhead crane.</p>
<p>Pit Furnace Applications:</p>	<p>Annealing, carburisation, nitridation, nitro cementation, annealing under protective atmosphere and stress-relief of products of different shapes, sizes and weights hung from grates or segments (such as shafts, splined shafts, piston pins, etc.) or of smaller parts in baskets. It is particularly suitable for small and medium-sized plants that heat treat small batches of non-identical parts. The gases that are used include nitrogen, ammonia, carbon dioxide, methanol and distilled water.</p>
<p>Buying Criteria:</p>	<p>Dimensions, quantities and weight of products, the required heat treatment process and its target parameters</p>