

Dewaxing Furnaces

Electrically Heated (N../WAX) or Gas-Fired (NB../WAX)



N 150/WAX

N 660/WAX



Grid bottom

N 100/WAX - N 2200/WAX with Electrical Heating

The N and NB chamber furnaces are especially designed for dewaxing and subsequent firing of the ceramic form. The electrically heated models are operated below the ignition point of the wax during dewaxing. The furnaces have a heated stainless steel drain in the bottom of the furnace chamber, formed as a funnel with the discharge near the center of the furnace. The drainage is made of stainless steel. The stainless steel grids in the bottom can be removed for cleaning. To prevent draining wax from ignition, there is a tight stainless steel container under the furnace with a removable drawer for wax collection as a safety feature. After the dewaxing process is finished the furnace continues heating in order to sinter the molds.

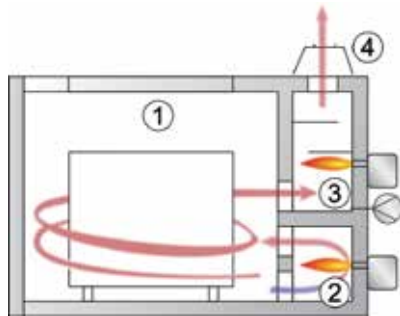
Standard equipment N../WAX, electrically heated

- Chamber furnace with wide-opening swinging door
- Tmax 850 °C
- Four side heating with freely radiating heating elements on ceramic carrier tubes
- Heated drainage in floor, controlled by a separate controller up to a maximum of 200 °C, to reliably prevent freezing of the draining wax - Release of furnace heating only possible after drain temperature is reached, to prevent clogging
- Stainless steel floor pan with grid bottom for level loading
- Rugged self-supporting, vaulted arch construction
- Exhaust gas vent in furnace ceiling for connection with ductwork (starting with N 440 manual exhaust air flap)
- Air inlet openings for reliable air exchange
- Dual shell furnace housing for low exterior temperatures
- Removable base included in delivery (fixed base for models N 440 and larger)
- First over-temperature limiter which must be set below the ignition point of the wax and prevents the wax from igniting during dewaxing. It is customers responsibility to set the required time interval for dewaxing. After this time has elapsed the over-temperature limiter will be deactivated to make sure that the furnace can continue with the sintering process.
- Second over-temperature limiter with manual reset for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load



Drain pan in floor

Chamber Furnaces for Heat Cleaning gas-fired with integrated thermal afterburner



1 Furnace chamber
 2 Gas heater of the furnace chamber
 3 Thermal afterburner
 4 Exhaust hood



NBCL 2300

The chamber furnaces in the model series NBCL are used for heat cleaning of components. An optimum temperature uniformity is not a priority for these processes. Examples are heat cleaning of electric motors, coated surfaces of steel components or the nozzles of plastic injection molding machines.

The furnaces are gas-fired and have an integrated thermal afterburner system which is also gas-fired. The pre-set, low-oxygen respectively reducing atmosphere in the furnace effectively prevents spontaneous combustion at the workpiece and subsequent damage as a result of over-temperature.

The generated exhaust gases are guided from the furnace chamber into the thermal afterburner where they are incinerated. Depending on the type of exhaust gas involved complete incineration is possible.

For safe operation, the furnace door locks after program start and cannot be opened again until the temperature has dropped below 180 °C at the process end. In case of a burner flame malfunction or gas shortage the process is aborted. In addition, the control system is equipped with an over-temperature limiter with manual reset that is set by the customer at a safe cut-off temperature to switch off the furnace if the limit is exceeded.

The furnaces are not suitable for components and coatings that contain solvents or a high concentration of water. These models must also not be used for charges with low flash points such as wood, paper or wax.



NBCL 1300

- Tmax 500 °C
- Standard sizes with furnace chambers up to 2500 liters
- Furnace housing with equipped for safe transport with forklift
- Furnace chamber size dimensioned to hold standard lattice boxes
- Furnace chamber insulation made of non-classified fiber material, floor and rear wall insulated with lightweight refractory bricks
- High performance, atmospheric burner fueled by liquified gas or natural gas
- Completely automated temperature controls
- Integrated thermal afterburner for exhaust gas cleaning



Gas burners for furnace heating and thermal afterburner

Model	Tmax °C	Inner dimensions in mm			Outer dimensions in mm			Burner rating furnace chamber in kW	Burner ratingTNV in kW
		w	d	h	W	D	H		
NBCL 1300	500	1200	900	1000	2160	2310	2450	50	100
NBCL 2300	500	1200	1200	1600	2160	2605	3050	100	100
NBCL 2500	500	1200	1600	1300	2160	3000	2750	100	100