

Rotary Hearth Furnaces up to 1300 °C with and without Air Circulation Electrically Heated or Gas-Fired



Rotary hearth furnace
DH 3020/1480/450/11, movable on rails,
for preheating of molds for two forges



Gear rim drive under the furnace



Rotary table with base plates made of
highly heat-resistant steel to protect the
insulation



Exhaust hood above charging opening

The compact furnaces of the DH product line are optimally suited for continuous processes on a small floor space. They are designed for preheating processes such as the preheating of metal parts for forging. Charging and discharging can be done at one position – either by a person or fully automatic. The hearth rotates in pre-set segments individually reconciled with the workpart geometry. The rotational speed and rotational intervals can be defined by the control system or by manual switching.

The rotary hearth furnaces are specifically designed for the required throughput and charge dimensions. They are heated electrically or alternatively gas-fired by means of powerful gas burners. Subject to the temperature range these furnaces are equipped with or without air circulation.

- Tmax 1100 °C, 1200 °C or 1300 °C without air circulation
- Tmax 260 °C, 600 °C or 850 °C with air circulation
- Wire heating elements in the furnace ceiling for furnaces up to 1200 °C
- SiC heating rods in the furnace ceiling for furnaces up to 1300 °C
- Gas heating as an alternative to electrical heating
- Models for 650 °C and 850 °C with powerful air circulation for better heat transfer onto the charge and to optimize the temperature uniformity
- Very compact design compared with continuous furnaces
- Designed for continuous operation at one working temperature
- Table diameter up to 3000 mm
- Hearth movement in defined segments
- Low-vibration movement of the rotary hearth
- Parallel swivel door
- Motor-driven or rotational motion initiated by foot switch
- Furnace bottom can be lowered using a forklift truck for maintenance purposes
- Defined application within the constraints of the operating instructions



Rotary hearth furnace DH 1200/-/300/11

Additional equipment

- Exhaust hood above the door opening for discharge of the warm exhaust air when door is open
- Pneumatic drive of the parallel swivel door
- Charging aids for ease of loading and unloading
- Multi-zone control for adjustable thermal profile during the cycle
- Protective gas connections
- Process control and documentation with Controltherm MV software package see page 76



Pre-heating of steel rings for forging

Model	Tmax °C	Inner dimensions in mm			Volume in l	Outer dimensions in mm			Heating power in kW ¹	Electrical connection*	Weight in kg
		Ø Outer	Ø Inner	h		W	D	H			
DH 1200/-/300/11	1100	1200	0	300	340	2200	2200	2500	54.0	3-phase	1000
DH 1500/800/250/11	1100	1500	800	250	630	2400	2300	2450	21.0	3-phase	1500
DH 3020/1480/450/11	1100	3022	1480	450	2500	4000	4000	2500	98.0	3-phase	3500

¹Depending on furnace design connected load might be higher

*Please see page 76 for more information about supply voltage



Furnace bottom can be lowered for maintenance purposes