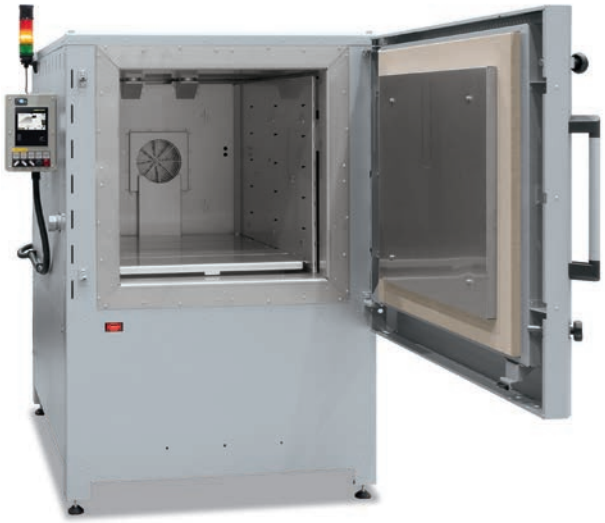
Forced Convection Chamber Furnaces up to 675 Liter
electrically heated

The very good temperature uniformity of these chamber furnace with air circulation provides for ideal process conditiones for annealing, curing, solution annealing, artificial ageing, sintering of PTFE, preheating, or soft annealing and brazing. The forced convection chamber furnaces are equipped with a suitable annealing box for soft annealing of copper or tempering of titanium, and also for annealing of steel under non-flammable process gases. The modular forced convection chamber furnace design allows for adaptation to specific process requirements with appropriate accessories.



Forced convection chamber furnace NA 500/45 with signal tower

Standard Equipment

- Tmax 450 °C, 650 °C, or 850 °C
- Horizontal air circulation with optimum distribution through stainless steel baffles
- Swing door hinged on the right side
- Base frame included in the delivery
- Temperature uniformity up to +/− 4 °C according to DIN 17052-1 see page 77
- Optimum air distribution enabled by high flow speeds
- One frame sheet and rails for two additional trays included in the scope of delivery
- Controller with touch operation B500 (5 programs with 4 segments each), controls description see page 84
- Automatic switch-off of air circulating fan for two minutes after door opening
- Side port and additional 3 mm thermocouple entry port

Additional Equipment for Models Tmax up to 450 °C

- Air inlet and exhaust air flaps when used for drying
- Controlled cooling via controlled flap and fan
- Additional frame sheet
- Gas supply boxes for different charging methods
- Gas feed fittings
- Charge control with documentation of the charge thermocouple
- Signal tower
- Charging systems

Forced convection chamber furnace NA 500/65

Further Additional Equipment for Models Tmax up to 650 °C and 850 °C

- Optimization of the temperature uniformity up to +/− 3 °C according to DIN 17052-1 see page 77
- Measuring frames and thermocouples for TUS measurements charge or comparative measurements
- Version according to AMS2750H or CQI-9
- Manual lift door for forced convection chamber furnace NA 120/65 and NA 120/85
- Pneumatic lift door from forced convection chamber furnace NA 250/65 upwards
- Manual roller conveyor in furnace chamber for high charge weights

Forced convection chamber furnace NA 60/65

Forced convection chamber furnace NA 60/85 with manual lift door and protective gas box for front loading

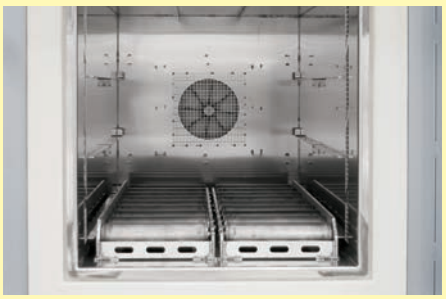
Model	Tmax	Inner dimensions in mm			Volume	Outer dimensions[1] in mm			Heating power	Electrical	Weight	Heat-up time[3] to Tmax	Cool-down time[3] from Tmax to 150 °C in minutes	
	°C	w	d	h	in l	W	D	H	in kW[2]	connection*	in kg	in minutes	Flaps[4]	Fan cooling[4]
NA 120/45	450	450	600	450	120	1075	1475	1500	9	3-phase	280	60	90	30
NA 250/45	450	600	750	600	250	1250	1660	1670	12	3-phase	650	60	120	30
NA 500/45	450	750	1000	750	500	1400	1910	1810	18	3-phase	800	90	240	45
NA 60/65	650	350	500	350	60	930	1310	1435	9	3-phase	240	90	210	30
NA 120/65	650	450	600	450	120	1030	1410	1535	12	3-phase	280	90	240	60
NA 250/65	650	600	750	600	250	1250	1700	1750	20	3-phase	650	90	480	60
NA 500/65	650	750	1000	750	500	1400	1950	1900	27	3-phase	850	90	600	90
NA 60/85	850	350	500	350	60	930	1310	1435	9	3-phase	315	150	480	90
NA 120/85	850	450	600	450	120	1030	1410	1535	12	3-phase	390	150	480	120
NA 250/85	850	600	750	600	250	1260	1700	1810	20	3-phase	840	180	900	180
NA 500/85	850	750	1000	750	500	1410	1950	1960	30	3-phase	1150	180	900	210
NA 675/85	850	750	1200	750	675	1410	2150	1960	30	3-phase	1360	210	900	210

[1]External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
[2]Depending on furnace design connected load might be higher
[3]Approx. information in empty furnace
[4]Additional equipment

*Please see page 84 for more information about supply voltage

Port for thermocouple

Tray



Roller conveyor in furnace chamber