

# Which Furnace for Which Process?

The next two double pages give an overview of which furnaces can be used in additive manufacturing for which process. This double page describes furnaces which can be used for processes in which no combustible substances escape.

## Atmosphere

Air

## Maximum Temperature

300 °C

850 °C

1280 °C

650 °C

650 °C

## Requirement Oxygen Content

21 %

21 %

21 %

1 %

0,10 %

## Vacuum

-

-

-

-

-

## Flammable Process Gas

-

-

-

-

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## Furnace Type

TR, page 60  
KTR, page 62

NA, page 42  
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LH, page 30  
NW, page 34  
N, page 36  
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## Furnace Heating

Electric



Chamber oven KTR 2000 for curing after 3D-printing



Chamber furnace LH 60/12 with protective gas box for heat treatment in a protective gas atmosphere



Forced convection chamber furnace NA 250/45 for heat treatment in air

Process Gas			Vacuum	
1100 °C	1150 °C	2400 °C	≤ 600 °C	≥ 600 °C
0,01 %	0,00 %	0,00 %	0,00 %	0,00 %
-	-	≤ 10 <sup>-5</sup> mbar	≤ 10 <sup>-5</sup> mbar	≤ 10 <sup>-5</sup> mbar
-	x	x	x	x
With protective gas box LH, page 30 NW, page 34 N, page 36 NA*, page 42 SAL*, page 48	NR(A), page 14 SR(A), page 21 LBR(A), page 20	VHT, page 22 LBVHT, page 27	NR(A), page 14 SR(A), page 21 LBR(A), page 20	VHT, page 22 LBVHT, page 27

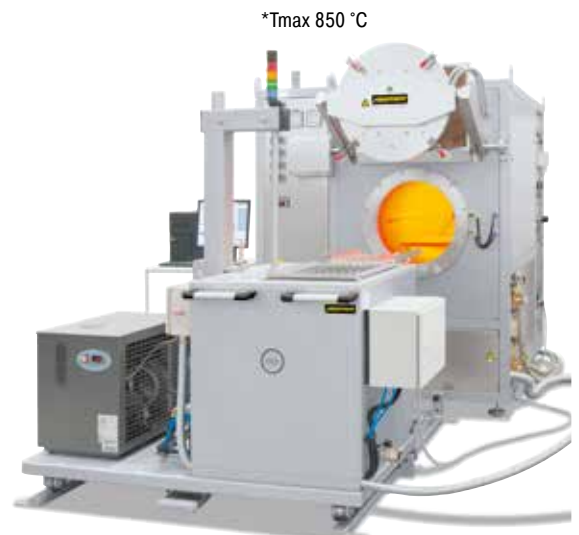
Electric



SAL 250/65



Cold-wall retort furnace VHT 100/12-MO for processes in high vacuum



Semi-automatic annealing plant with retort furnace NR 50/11 and water quenching bath on rails

\*Tmax 850 °C