LABORATORY FURNACES

Made in Germany

www.nabertherm.com
Facts
- Production of laboratory and industrial furnaces since 1947
- Production site in Lilienthal/Bremen - Made in Germany
- 500 employees worldwide
- 150,000 customers in more than 100 countries
- Very wide product range of furnaces
- One of the biggest R&D departments in the furnace industry
- High vertical integration

Global Sales and Service Network
- Manufacturing only in Germany
- Decentralized sales and service close to the customer
- Own sales organization and long term sales partners in all important world markets
- Individual on-site customer service and consultation
- Fast remote maintenance options for complex furnaces
- Reference customers with similar furnaces or systems close to you
- Secured spare parts supply, many spare parts available from stock
- Further information see page 78

Setting Standards in Quality and Reliability
- Project planning and construction of tailor-made thermal process plants incl. material handling and charging systems
- Innovative controls and automation technology, adapted to customer needs
- Very reliable and durable furnace systems
- Customer test center for process assurance

Experience in Thermal Processing
- Thermal Process Technology
- Advanced Materials
- Fiber Optics/Glass
- Foundry
- Laboratory
- Dental
- Arts & Crafts
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Ovens and Forced Convection Furnaces up to 850 °C

Furnaces with forced air circulation, resulting in a very good temperature uniformity

- Dual shell housing made of textured stainless steel sheets with additional fan cooling for low surface temperature
- Solid state relays provide for low noise operation
- Only fiber materials are used which are not classified as carcinogenic according to TRGS 905, class 1 or 2
- NTLog Basic for Nabertherm controller: recording of process data with USB-flash drive
- Defined application within the constraints of the operating instructions
- As additional equipment: Process control and documentation via VCD software package for monitoring, documentation and control
<table>
<thead>
<tr>
<th>Furnace Group</th>
<th>Model</th>
<th>Page</th>
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<tbody>
<tr>
<td>Ovens up to 300 °C</td>
<td>TR</td>
<td>6</td>
</tr>
<tr>
<td>Chamber ovens up to 260 °C</td>
<td>KTR</td>
<td>8</td>
</tr>
<tr>
<td>Forced convection chamber furnaces up to 850 °C</td>
<td>NA</td>
<td>10</td>
</tr>
</tbody>
</table>
Ovens up to 300 °C, also with Safety Technology According to EN 1539

With their maximum working temperature of up to 300 °C and forced air circulation, the ovens achieve a very good temperature uniformity. They can be used for various applications such as e.g. drying, sterilizing or warm storing. Short delivery times from stock are ensured for standard models.

Standard Equipment

- Tmax 300 °C
- Working temperature range: +20 °C above room temperature up to 300 °C
- Ovens TR 30 - TR 420 designed as tabletop models
- Ovens TR 450 - TR 1050 designed as floor standing models
- Horizontal forced air circulation results in temperature uniformity according to DIN 17052-1 better than +/- 5 °C in the empty oven (with closed exhaust air flap) see page 71
- Stainless steel furnace housing, material no. 1.4016 (DIN)
- Stainless steel chamber, alloy 304 (AISI)/DIN material no. 1.4301), rust-resistant and easy to clean
- Charging in multiple layers possible using removeable grids (number of removeable grids included, see table to the right)
- Large, wide-opening swing door, hinged on the right with quick release for models TR 30 - TR 240 and TR 450
- Double swing door with quick release for models TR 420, TR 800 and TR 1050
- Ovens TR 800 and TR 1050 equipped with transport castors
- Infinitely adjustable exhaust at the rear wall with operation from the front
- PID microprocessor control with self-diagnosis system
- Models TR .. LS: Safety technology according to EN 1539 for charges containing liquid solvents, achievable temperature uniformity +/- 8 °C according to DIN 17052-1 in the empty oven (with closed exhaust air flap) see page 71
- Controller R7 (resp. C450 for TR ..LS), alternative programmable controllers see page 75

Additional Equipment

- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the oven and load
- Fan speed of the air circulation fan can be reduced infinitely
- Window for charge observing
- Further removeable grids with rails
- Side inlet
- Electrical rotary device (associated sample holder will be individually adapted to the charge)
- Exhaust air duct DN 80
- Transport castors for models TR 240 - TR 450
- Upgrading available to meet the quality requirements of AMS 2750 E or FDA
Extricable metal grids to load the oven in different layers

Electrical rotating device (in this case with tailored platform for PARR autoclave containers)
Chamber Ovens up to 260 °C

The chamber ovens of the KTR range can be used for complex drying processes and heat treatment of charges to an application temperature of 260 °C. The high-performance air circulation enables optimum temperature uniformity throughout the work space. A wide range of accessories allow the chamber ovens to be modified to meet specific process requirements.

**Standard Equipment**

- Tmax 260 °C
- Electrically heated (via a heating register with integrated chrome steel heating elements) or gas-fired (direct or indirect gas-fired including injection of the hot air into the intake duct)
- Temperature uniformity up to +/- 3 °C according to DIN 17052-1 (for design without track cutouts) see page 71
- High-quality mineral wool insulation provides for outer temperatures of < 25 °C above room temperature
- High air exchange for fast drying processes
- Double-wing door for furnaces KTR 2300 and larger
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the oven and load
- Incl. floor insulation
- Controller B400 (5 programs with each 4 segments), alternative controllers see page 75

**Additional Equipment**

- Track cutouts for level drive-in of charging cart
- Base frame to charge the oven via a charging forklift
- Additional Door in the back for charging from both sides or to use the oven as lock between two rooms
- Fan system for faster cooling with manual or motor-driven control of the exhaust flaps
- Programmed opening and closing of exhaust air flaps
- Air circulation with speed control, recommendable for processes with light or sensitive charge
- Observation window and furnace chamber lighting
- Charging cart with or without rack system
- Process control and documentation via VCD software package or Nabertherm Control Center (NCC) for monitoring, documentation and control see page 74
Chamber oven KTR 22500/S with chamber lightning and drive-in tracks with insulated plugs which provide for an optimal temperature uniformity.

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions in mm</th>
<th>Heating power in kW</th>
<th>Electrical connection*</th>
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<tr>
<td>KTR 1000</td>
<td>260</td>
<td>1000 x 1000 x 1000</td>
<td>1000</td>
<td>1820 x 1430 x 1890</td>
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<td>3140 x 5400 x 3500</td>
<td>108</td>
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</tr>
</tbody>
</table>

1Depending on furnace design connected load might be higher.
2External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

*Please see page 75 for more information about supply voltage.

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Drive-in tracks with sealing shoes
Charging cart with pull-out trays
Pull-out shelves, running on rolls
High-Temperature Ovens, Forced Convection Chamber Furnaces up to 850 °C

These chamber furnaces with air circulation are characterized by their extremely high temperature uniformity. Hence, they are especially suitable for processes such as annealing, crystalizing, preheating, curing, but also for numerous processes in tool making. Due to the modular concept, the forced convection furnaces can be adjusted to the process requirements by adding suitable equipment.

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
- Temperature uniformity up to +/− 4 °C according to DIN 17052-1 (NAT 15/65 and NAT 30/85 up to +/− 5 °C) in the empty work space see page 71
- One frame sheet and rails for two additional trays included in the scope of delivery (NAT 15/65 and NAT 30/85 without frame sheet)
- Base frame included in the delivery, NAT 15/65 and NAT 30/85 designed as table-top model
- Controller B400/B410 (5 programs with each 4 segments), alternative controllers see page 75

Additional Equipment (not for Model NAT 15/65 and NAT 30/85)

- Optimization of the temperature uniformity up to +/− 3 °C according to DIN 17052-1 in the empty work space see page 71
- Air inlet and exhaust air flaps when used for drying
- Controlled fan assisted cooling
- Manual lift door (up to model NA 120/..)
- Pneumatic lift door
- Air circulation with speed control, recommendable for processes with light or sensitive charge
- Additional frame sheet
- Gas supply boxes different charging methods
- Feed and charging aids
- Charge control with documentation of the charge thermocouple
<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax in °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions in mm</th>
<th>Connected load in kW</th>
<th>Electrical connection</th>
<th>Weight in kg</th>
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<tr>
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<td>290 420 260</td>
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<td>1290 2100 1820</td>
<td>28.0</td>
<td>3-phase</td>
<td>900</td>
</tr>
</tbody>
</table>

1Table-top model
2Heating only between two phases
3External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

Forced convection chamber furnace NA 120/45
Forced convection chamber furnace NA 250/85

Port for thermocouple
Tray
Roller conveyor in furnace chamber

*Please see page 75 for more information about supply voltage
Muffle furnaces are the reliable and long-lasting all-rounders in the laboratory and are ideally suited for a large number of processes in the field of material research and heat treatment.

- Dual shell housing made of textured stainless steel sheets with additional fan cooling for low surface temperature
- Solid state relays provide for low noise operation
- Only fiber materials are used which are not classified as carcinogenic according to TRGS 905, class 1 or 2
- NTLog Basic for Nabertherm controller: recording of process data with USB-flash drive
- Defined application within the constraints of the operating instructions
- As additional equipment: Process control and documentation via VCD software package for monitoring, documentation and control
<table>
<thead>
<tr>
<th>Furnace Group</th>
<th>Model</th>
<th>Page</th>
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<tr>
<td>Muffle furnaces up to 1100 °C or 1200 °C</td>
<td>L(T)</td>
<td>14</td>
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<tr>
<td>Economy muffle furnaces up to 1100 °C</td>
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<td>16</td>
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<td>Muffle furnaces with brick insulation up to 1300 °C</td>
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<tr>
<td>Muffle furnaces up to 1400 °C</td>
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<td>Muffle furnaces with embedded heating elements in the ceramic muffle up to 1100 °C</td>
<td>L(T) ../SKM</td>
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<td>Ashing furnaces up to 1100 °C with integrated exhaust gas cleaning</td>
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<tr>
<td>Weighing furnaces up to 1200 °C</td>
<td>L(T) ../SW</td>
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<tr>
<td>Exhaust systems/accessories for muffle furnaces</td>
<td></td>
<td>24</td>
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</table>
Muffle Furnaces up to 1100 °C or 1200 °C

The muffle furnaces L 1/12 - LT 40/12 have been proven for daily laboratory use. These models stand out for their excellent workmanship, advanced and attractive design, and high level of reliability. The muffle furnaces come equipped with either a flap door or lift door at no extra charge.

Standard Equipment

- Tmax 1100 °C or 1200 °C
- Heating from two sides by ceramic heating plates (heating from three sides for muffle furnaces L 24/11 - LT 40/12) for an optimal temperature uniformity
- Temperature uniformity of +/- 5 K with closed fresh-air inlet in empty work space according to DIN 17052-1 at working temperatures above 800 °C see page 71
- Thermocouple type N (1100 °C) or type S (1200 °C)
- Ceramic heating plates with integral heating element which is safeguarded and easy to replace
- Optional flap door (L) which can be used as work platform or lift door (LT) with hot surface facing away from the operator
- Adjustable air inlet integrated in door (see illustration)
- Exhaust air outlet in rear wall of furnace
- Controller B410 resp. R7 for L 1/12 (5 programs with each 4 segments), alternative controllers see page 75

Additional Equipment

- Chimney, chimney with fan or catalytic converter (not for L 1 and L 15) see page 24
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Protective gas connection to purge with non-flammable protective or reaction gases (not available in combination with chimney, chimney with fan or catalytic converter) not gas tight
- Manual or automatic gas supply system
- Port for thermocouple in the rear wall or in the furnace door
- Please see page 25 for more accessories
### Muffle furnace L 3/12

**Adjustable air inlet integrated in the door**

**Gas supply system for non-flammable protective or reactive gas**

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax</th>
<th>Inner dimensions in mm</th>
<th>Volume</th>
<th>Outer dimensions² in mm</th>
<th>Temperature uniformity of +/− 5K in the empty workspace</th>
<th>Connected load</th>
<th>Electrical</th>
<th>Weight</th>
<th>Heating time</th>
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<td>W</td>
<td>D</td>
<td>H²</td>
<td>w</td>
<td>d</td>
<td>h</td>
<td>in kW</td>
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<td>515+240</td>
</tr>
<tr>
<td>L(T)</td>
<td>24/11</td>
<td>1100</td>
<td>280</td>
<td>340</td>
<td>250</td>
<td>24</td>
<td>490</td>
<td>555</td>
<td>580+320</td>
</tr>
<tr>
<td>L(T)</td>
<td>40/11</td>
<td>1100</td>
<td>320</td>
<td>490</td>
<td>250</td>
<td>40</td>
<td>530</td>
<td>705</td>
<td>580+320</td>
</tr>
</tbody>
</table>

1. Recommended working temperature for processes with longer dwell times is 1000 °C (L../11) resp. 1100 °C (L../12)
2. External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
3. Including opened lift door (LT models)
4. Heating time of the empty and closed furnace up to Tmax − 100 K (connected to 220 V 1/N/PE resp. 400 V 3/N/PE)

---

1. Please see page 75 for more information about supply voltage
Economy Muffle Furnaces up to 1100 °C

With their convincing price/performance ratio and the fast heat-up rates, these compact muffle furnaces are perfect for many applications in the laboratory. Quality features like the dual shell furnace housing of rust-free stainless steel, their compact, lightweight constructions, or the heating elements encased in quartz glass tubes make these models reliable partners for your application.

**Standard Equipment**

- Tmax 1100 °C
- Heating from two sides from heating elements protected in quartz glass tubes
- Fast heating times (see table)
- Maintenance-friendly replacement of heating elements and insulation
- Housing powder-coated in industrial quality
- Flap door which can also be used as a work platform
- Exhaust air outlet in rear wall
- Compact dimensions and light weight
- Controller mounted under the door to save space
- Controller R7, controls description see page 75

**Additional Equipment**

- Chimney, chimney with fan or catalytic converter (not for LE 1) see page 24
- Please see page 25 for more accessories

---

**Muffle furnace LE 6/11**

**Model**

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax in °C</th>
<th>Inner dimensions in mm</th>
<th>Volume</th>
<th>Outer dimensions2 in mm</th>
<th>Temperature uniformity of +/− 5K in the empty workspace</th>
<th>Connected load in kW</th>
<th>Electrical connection*</th>
<th>Weight in kg</th>
<th>Heating time in min3</th>
</tr>
</thead>
<tbody>
<tr>
<td>LE 1/11</td>
<td>1100</td>
<td>90 115 110</td>
<td>1</td>
<td>290 280 410</td>
<td>40 45 60</td>
<td>1.5</td>
<td>1-phase</td>
<td>10</td>
<td>10</td>
</tr>
<tr>
<td>LE 2/11</td>
<td>1100</td>
<td>110 180 110</td>
<td>2</td>
<td>330 390 410</td>
<td>60 110 60</td>
<td>1.8</td>
<td>1-phase</td>
<td>10</td>
<td>25</td>
</tr>
<tr>
<td>LE 6/11</td>
<td>1100</td>
<td>170 200 170</td>
<td>6</td>
<td>390 440 470</td>
<td>120 130 120</td>
<td>1.8</td>
<td>1-phase</td>
<td>18</td>
<td>30</td>
</tr>
<tr>
<td>LE 14/11</td>
<td>1100</td>
<td>220 300 220</td>
<td>14</td>
<td>440 540 520</td>
<td>170 220 170</td>
<td>2.9</td>
<td>1-phase</td>
<td>25</td>
<td>35</td>
</tr>
</tbody>
</table>

1Recommended working temperature for processes with longer dwell times is 1050 °C
2External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
3Heating time of the empty and closed furnace up to Tmax −100 K (connected to 230 V 1/N/PE)

*Please see page 75 for more information about supply voltage
Muffle Furnaces with Brick Insulation up to 1300 °C

Heating elements on support tubes radiating freely into the furnace chamber provide for particularly short heating times for these muffle furnaces. Thanks to their robust lightweight refractory brick insulation, they can reach a maximum working temperature of 1300 °C. These muffle furnaces thus represent an interesting alternative to the familiar L(T)../12 models, when you need a higher application temperature.

Standard Equipment

- Tmax 1300 °C
- Heating from two sides
- Heating elements on support tubes ensure free heat radiation and a long service life
- Multi-layer insulation with robust lightweight refractory bricks in the furnace chamber
- Optional flap door (L) which can be used as work platform or lift door (LT) with hot surface facing away from the operator
- Adjustable air inlet in the furnace door
- Exhaust air outlet in rear wall of furnace
- Controller B410 (5 programs with each 4 segments), alternative controllers see page 75

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax</th>
<th>Inner dimensions in mm</th>
<th>Volume</th>
<th>Outer dimensions in mm</th>
<th>Temperature uniformity of +/−5K in the empty workspace</th>
<th>Connected load</th>
<th>Electrical</th>
<th>Weight</th>
<th>Heating time</th>
</tr>
</thead>
<tbody>
<tr>
<td>L, LT 5/13</td>
<td>1300</td>
<td>200 170 130</td>
<td>5</td>
<td>490 450 580+320</td>
<td>w 150 150 80 2.4 1-phase 42</td>
<td>in kW</td>
<td>in kg</td>
<td>in min</td>
<td></td>
</tr>
<tr>
<td>L, LT 9/13</td>
<td>1300</td>
<td>230 240 170</td>
<td>9</td>
<td>530 525 630+350</td>
<td>d 180 220 120 3.0 1-phase 60</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>L, LT 15/13</td>
<td>1300</td>
<td>230 340 170</td>
<td>15</td>
<td>530 625 630+350</td>
<td>h 180 320 120 3.5 1-phase 70</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

1Recommended working temperature for processes with longer dwell times is 1200 °C
2External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
3Including opened lift door (LT models)
4Heating time of the empty and closed furnace up to Tmax −100 K (connected to 230 V 1/N/PE)

*Please see page 75 for more information about supply voltage

Additional Equipment

- Chimney, chimney with fan or catalytic converter see page 24
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Protective gas connection to purge with non-flammable protective or reaction gases (not available in combination with chimney, chimney with fan or catalytic converter) not gas tight
- Manual or automatic gas supply system
- Port for thermocouple in the rear wall or in the furnace door

Please see page 25 for more accessories
Muffle Furnaces up to 1400 °C

These models stand out for their excellent workmanship, advanced and attractive design, and high level of reliability. Heating elements on support tubes radiating freely into the furnace chamber provide for particularly short heating times and a maximum temperature of 1400 °C. These muffle furnaces are a good alternative to the familiar L(T)../12 series when higher application temperatures are needed.

Standard Equipment

- Tmax 1400 °C
- Heating from two sides
- Heating elements on support tubes ensure free heat radiation and a long service life
- Adjustable air inlet integrated in door
- Exhaust air outlet in rear wall of furnace
- Controller B410 (5 programs with each 4 segments), alternative controllers see page 75

Additional Equipment

- Chimney, chimney with fan or catalytic converter see page 24
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Protective gas connection to purge with non-flammable protective or reaction gases (not available in combination with chimney, chimney with fan or catalytic converter), not gas tight
- Manual or automatic gas supply system
- Please see page 25 for more accessories

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax</th>
<th>Inner dimensions in mm</th>
<th>Volume</th>
<th>Outer dimensions2 in mm</th>
<th>Temperature uniformity of +/− 5K in the empty workspace</th>
<th>Connected load</th>
<th>Electrical</th>
<th>Weight</th>
<th>Heating time</th>
</tr>
</thead>
<tbody>
<tr>
<td>L, LT  5/14</td>
<td>1400</td>
<td>200 170 130</td>
<td>5 in l</td>
<td>490 450 580+320</td>
<td>150 170 80</td>
<td>2.6 in kW</td>
<td>1-phase</td>
<td>42 kg</td>
<td>50 min*</td>
</tr>
<tr>
<td>L, LT  9/14</td>
<td>1400</td>
<td>250 250 170</td>
<td>9 in l</td>
<td>530 525 630+350</td>
<td>200 250 120</td>
<td>3.5 in kW</td>
<td>1-phase</td>
<td>55 kg</td>
<td>50 min*</td>
</tr>
<tr>
<td>L, LT 15/14</td>
<td>1400</td>
<td>250 350 170</td>
<td>15 in l</td>
<td>530 625 630+350</td>
<td>200 350 120</td>
<td>3.5 in kW</td>
<td>1-phase</td>
<td>63 kg</td>
<td>70 min*</td>
</tr>
</tbody>
</table>

1Recommended working temperature for processes with longer dwell times is 1200 °C
2External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
3Including opened lift door
4Heating time of the empty and closed furnace up to Tmax −100 K (connected to 230 V 1/N/PE)

*Please see page 75 for more information about supply voltage
Muffle Furnaces with Embedded Heating Elements in the Ceramic Muffle up to 1100 °C

We particularly recommend the muffle furnace L 9/11/SKM for heat treatment of aggressive substances. The furnace has a ceramic muffle with embedded heating from four sides. The muffle furnace thus combines a very good temperature uniformity with excellent protection of the heating elements from aggressive atmospheres. Another aspect is the smooth, nearly particle free muffle (furnace door made of fiber insulation), an important quality feature.

**Standard Equipment**

- Tmax 1100 °C
- Muffle heated from four sides
- Furnace chamber with embedded ceramic muffle, high resistance to aggressive gasses and vapours
- Optional flap door (L) which can be used as work platform or lift door (LT) with hot surface facing away from the operator
- Adjustable working air inlet in the door
- Exhaust air outlet in rear wall of furnace
- Controller B410 (5 programs with each 4 segments), alternative controllers see page 75

**Additional Equipment**

- Chimney, chimney with fan or catalytic converter see page 24
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Protective gas connection to purge with non-flammable protective or reaction gases (not available in combination with chimney, chimney with fan or catalytic converter) not gas tight
- Manual or automation gas supply system
- Port for thermocouple in the rear wall or in the furnace door
- Please see page 25 for more accessories

**Modell Tmax Inner dimensions in mm Volume Outer dimensions in mm Connected load in kW Electrical connection* Weight in kg Heating time in min**

<table>
<thead>
<tr>
<th>Modell</th>
<th>Tmax in °C</th>
<th>w</th>
<th>d</th>
<th>h</th>
<th>Volume in l</th>
<th>W</th>
<th>D</th>
<th>H</th>
<th>Connected load in kW</th>
<th>Electrical connection*</th>
<th>Weight in kg</th>
<th>Heating time in min</th>
</tr>
</thead>
<tbody>
<tr>
<td>L 9/11/SKM</td>
<td>1100</td>
<td>230</td>
<td>240</td>
<td>170</td>
<td>9</td>
<td>490</td>
<td>505</td>
<td>580</td>
<td>3.4</td>
<td>1-phase</td>
<td>50</td>
<td>75</td>
</tr>
<tr>
<td>LT 9/11/SKM</td>
<td>1100</td>
<td>230</td>
<td>240</td>
<td>170</td>
<td>9</td>
<td>490</td>
<td>505</td>
<td>580+320</td>
<td>3.4</td>
<td>1-phase</td>
<td>50</td>
<td>75</td>
</tr>
</tbody>
</table>

1Recommended working temperature for processes with longer dwell times is 1000 °C
2External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
3Including opened lift door
4Heating time of the empty and closed furnace up to Tmax ~ 100 K (connected to 230 V 1/N/PE)

*Please see page 75 for more information about supply voltage
Ashing Furnaces up to 1100 °C

Ashing furnace LV ../11 is designed especially for ashing processes to 1050 °C in the laboratory. Applications include determining loss on ignition, ashing food and plastics for subsequent substance analysis. A special fresh-air and exhaust air system ensures that the air is replaced 6 times per minute so that there is always sufficient oxygen for the ashing process. Incoming air passes the furnace heating and is pre-heated to ensure good temperature uniformity.

**Standard Equipment**

- Tmax 1100 °C
- Heating from two sides
- Ceramic heating plates with integral heating element which is safeguarded, and easy to replace
- Air exchange of more than 6 times per minute
- Good temperature uniformity due to preheating of incoming air, temperature uniformity according to DIN 17052-1 to +/- 10 °C in the defined empty work area (from 550 °C) see page 71
- Suitable for many standardized ashing processes according to ISO, ASTM, EN, and DIN
- Optional flap door (LV) which can be used as work platform or lift door (LVT) with hot surface facing away from the operator
- Controller B410 (5 programs with each 4 segments), alternative controllers see page 75

**Additional Equipment**

- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Port for thermocouple in the rear wall or in the furnace door
- Charging trolley with solid or perforated trays to load the furnace in different levels, including holders to insert/remove the trays
- Please see page 25 for more accessories
<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax</th>
<th>Inner dimensions in mm</th>
<th>Volume</th>
<th>Outer dimensions2 in mm</th>
<th>Max. weight of hydrocarbons in g</th>
<th>Max. evaporation rate g/min</th>
<th>Connected load in kW</th>
<th>Electrical connection* in kg</th>
<th>Weight in kg</th>
<th>Heating time in min4</th>
</tr>
</thead>
<tbody>
<tr>
<td>LV 3/11</td>
<td>1100</td>
<td>160 140 100</td>
<td>3</td>
<td>385 360 735</td>
<td>5</td>
<td>0.1</td>
<td>1.2</td>
<td>1-phase</td>
<td>20</td>
<td>45</td>
</tr>
<tr>
<td>LV 5/11</td>
<td>1100</td>
<td>200 170 130</td>
<td>5</td>
<td>385 420 790</td>
<td>10</td>
<td>0.2</td>
<td>2.4</td>
<td>1-phase</td>
<td>35</td>
<td>55</td>
</tr>
<tr>
<td>LV 9/11</td>
<td>1100</td>
<td>230 240 170</td>
<td>9</td>
<td>415 485 845</td>
<td>15</td>
<td>0.3</td>
<td>3.0</td>
<td>1-phase</td>
<td>45</td>
<td>70</td>
</tr>
<tr>
<td>LV 15/11</td>
<td>1100</td>
<td>230 340 170</td>
<td>15</td>
<td>415 585 845</td>
<td>25</td>
<td>0.3</td>
<td>3.5</td>
<td>1-phase</td>
<td>55</td>
<td>80</td>
</tr>
</tbody>
</table>

1Recommended working temperature for processes with longer dwell times is 1000 °C
2External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
3Including exhaust tube (Ø 80 mm)
4Approx. heating time of the empty and closed furnace up to Tmax – 100 K (connected to 230 V 1/N/PE)

*Please see page 75 for more information about supply voltage

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Ceramic collecting pan

Ashing furnace LV 5/11 with port for thermocouple in the rear wall of furnace

Charging trolley to load the furnace in different levels

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Air inlet and exhaust flow principle in ashing furnaces

- **Hot air**
- **Cold air**

---

1. **Lift door in °C**:
   - LV 3/11: 1100
   - LV 5/11: 1100
   - LV 9/11: 1100
   - LV 15/11: 1100

2. **Volume in l**:
   - LV 3/11: 3
   - LV 5/11: 5
   - LV 9/11: 9
   - LV 15/11: 15

3. **Outer dimensions ± in mm**:
   - Width (W)
   - Depth (D)
   - Height (H)
   - LV 3/11: 385 360 735
   - LV 5/11: 385 420 790
   - LV 9/11: 415 485 845
   - LV 15/11: 415 585 845

4. **Max. weight of hydrocarbons in g**:
   - LV 3/11: 5
   - LV 5/11: 10
   - LV 9/11: 15
   - LV 15/11: 25

5. **Max. evaporation rate g/min**:
   - LV 3/11: 0.1
   - LV 5/11: 0.2
   - LV 9/11: 0.3
   - LV 15/11: 0.3

6. **Connected load in kW**:
   - LV 3/11: 1.2
   - LV 5/11: 2.4
   - LV 9/11: 3.0
   - LV 15/11: 3.5

7. **Electrical connection* in kg**:
   - LV 3/11: 1-phase
   - LV 5/11: 1-phase
   - LV 9/11: 1-phase
   - LV 15/11: 1-phase

8. **Weight in kg**:
   - LV 3/11: 20
   - LV 5/11: 35
   - LV 9/11: 45
   - LV 15/11: 55

9. **Heating time in min4**:
   - LV 3/11: 45
   - LV 5/11: 55
   - LV 9/11: 70
   - LV 15/11: 80
Ashing Furnaces with Integrated Exhaust Gas Cleaning up to 1100 °C

The ashing furnace L ×/11 BO is specially designed for processes in which larger sample quantities have to be incinerated. Fields of application are e.g. the ashing of food, thermal cleaning of injection molding tools or the determination of annealing loss. Another application is the debinding of ceramic products, e.g. after additive production.

The ashing furnaces have a passive safety system and integrated exhaust gas post combustion. An exhaust gas fan extracts flue gases from the furnace and simultaneously supplies fresh air to the furnace atmosphere with the result that sufficient oxygen is always available for the incineration process. The incoming air is guided behind the furnace heating and preheated to ensure good temperature uniformity. Exhaust gases are led from the furnace chamber to the integrated post combustion system, where they are postburned and catalytically cleaned. Directly after the incineration process (up to max. 600 °C) a subsequent process up to max. 1100 °C can take place.

**Standard Equipment**

- Tmax 600 °C for the incineration process
- Tmax 1100 °C for the subsequent process
- Three-side heating (both sides and bottom)
- Ceramic heating plates with embedded heating wire
- Steel collecting pan protects the bottom insulation
- Spring-assisted closing of the furnace door (flap door) with mechanical locking against unintentional opening
- Thermal/catalytic post combustion, integrated in the exhaust channel, up to 600 °C in function
- Temperature control of post combustion can be set up to 850 °C
- Monitored exhaust air
- Inlet-air preheated through the bottom heating plate
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Controller C450 (10 programs with each 20 segments), alternative controllers see page 75

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax (°C)</th>
<th>Inner Dimensions in mm</th>
<th>Volume in l</th>
<th>Outer Dimensions (mm)</th>
<th>Max. Weight of Hydrocarbons (g)</th>
<th>Max. Evaporation Rate (g/min)</th>
<th>Connected Load (kW)</th>
<th>Electrical Connection</th>
<th>Weight (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>L 9/11 BO</td>
<td>1100</td>
<td>230 × 240 × 170</td>
<td>9</td>
<td>415 × 575 × 750</td>
<td>75</td>
<td>1.0</td>
<td>7.0</td>
<td>3-phase</td>
<td>60</td>
</tr>
<tr>
<td>L 24/11 BO</td>
<td>1100</td>
<td>280 × 340 × 250</td>
<td>24</td>
<td>490 × 675 × 800</td>
<td>150</td>
<td>2.0</td>
<td>9.0</td>
<td>3-phase</td>
<td>90</td>
</tr>
<tr>
<td>L 40/11 BO</td>
<td>1100</td>
<td>320 × 490 × 250</td>
<td>40</td>
<td>530 × 825 × 800</td>
<td>200</td>
<td>2.1</td>
<td>11.5</td>
<td>3-phase</td>
<td>110</td>
</tr>
</tbody>
</table>

1. Recommended working temperature for processes with longer dwell times is 1000 °C.
2. External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
3. Including exhaust tube (Ø 80 mm)

*Please see page 75 for more information about supply voltage.
Muffle Furnace incl. Scale and Software for Determination of Combustion Loss

This weighing furnace with integrated precision scale and software, was designed especially for combustion loss determination in the laboratory. The determination of combustion loss is necessary, for instance, when analyzing sludges and household garbage, and is also used in a variety of other processes for the evaluation of results. The difference between the charged total mass and the combustion residue is the combustion loss. During the process, the software included records both the temperature and the weight loss.

Standard Equipment

Like muffle furnaces L(T), except:
- Delivery includes base, ceramic plunger with base plate in the furnace lining, precision scale and software package
- 4 scales available for different maximum weights and scaling ranges
- Process control and documentation for temperature and combustion loss via VCD software package for monitoring, documentation and control see page 74
- Controller B410 (5 programs with each 4 segments), alternative controllers see page 75

Additional Equipment

- Chimney, chimney with fan or catalytic converter
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Port for thermocouple in the rear wall or in the furnace door
- Please see page 24 for more accessories

| Model | Tmax in °C | Inner dimensions in mm | Volume in l | Outer dimensions² in mm | Connected load in kW | Electrical connection* | Weight in kg | Heating time in min
|-------|-----------|------------------------|------------|------------------------|----------------------|-----------------------|-------------|---------------------|
| L(T) 9/11/SW | 1100 | 230 240 170 9 | 415 455 740+240⁰ | 3.0 | 1-phase | 50 | 65
| L(T) 9/12/SW | 1200 | 230 240 170 9 | 415 455 740+240⁰ | 3.0 | 1-phase | 50 | 75

¹Recommended working temperature for processes with longer dwell times is 1000 °C (L 9/11) resp. 1100 °C (L 9/12)
²External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
³Including opened lift door (Model LT...)
⁴Heating time of the empty and closed furnace up to Tmax - 100 K (connected to 230 V 1,N,PE)

Scale type | Readability in g | Maximum weighing range in g | Weight of plunger in g | Calibration value in g | Minimum load in g
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>EW-2200</td>
<td>0.01</td>
<td>2200 incl. plunger</td>
<td>850</td>
<td>0.1</td>
<td>0.5</td>
</tr>
<tr>
<td>EW-4200</td>
<td>0.01</td>
<td>4200 incl. plunger</td>
<td>850</td>
<td>0.1</td>
<td>0.5</td>
</tr>
<tr>
<td>EW-6200</td>
<td>0.01</td>
<td>6200 incl. plunger</td>
<td>850</td>
<td>-</td>
<td>1.0</td>
</tr>
<tr>
<td>EW-12000</td>
<td>0.10</td>
<td>12200 incl. plunger</td>
<td>850</td>
<td>1.0</td>
<td>5.0</td>
</tr>
</tbody>
</table>

4 scales available for different maximum weights and scaling ranges
Example of an over-temperature limiter
Software for documentation of the temperature curve and combustion loss using a PC
Exhaust Vent

Exhaust vent for collection and upstream direction of escaping gases

Chimney with Fan

Exhaust gases are better removed from the furnace and discharged. The B400 - P480 controllers can be used to activate the fan automatically (not for models L(T) 15.., L 1/12, LE 1/11, LE 2/11).*

Catalytic Converter with Fan

Organic components are catalytically cleaned at about 600 °C, broken into carbon dioxide and water vapour. Irritating odors are thus largely eliminated. The B400 - P480 controllers can be used to switch the catalytic converter automatically (not for models L(T) 15.., L 1/12, LE 1/11, LE 2/11).*

* Note: If other controller types are used an adapter cable for connection to mains supply has to be ordered separately. The device will be activated by plugging in the socket.

Exhaust Air Extraction

When exhaust gases are generated during the process it is mandatory to guide them outside in an adequate way. The relevant operating instructions must be always taken into consideration. When exhaust gas pipings are installed it is always necessary that a local ventilation technician lays out the system in accordance to the real environment.

There are different possibilities to guide the exhaust gases out. In many cases the furnace is positioned under a laboratory extraction provided by the customer. In these cases the use of an exhaust vent is recommended just to guide the gases upwards.

For this purpose metal exhaust gas pipes with NW 80 to NW 120 can be used. They must be installed continuously rising and fastened to the wall or ceiling. Center the pipe over the furnace vent (for models with vent fan or catalytic converter, NW 120 is necessary. The exhaust gas pipe must not be installed with a tight fit to the furnace vent pipe since this would prevent any bypass effect. This is necessary so that not too much fresh air is sucked in by the furnace. An exception are models LV(T) and L ../11 BOs: Here the exhaust gas pipe NW 80 will be connected directly onto the furnace vent pipe.
Select between different bottom plates and collecting pans for protection of the furnace and easy loading (for models L, LT, LE, LV and LVT on pages 14 - 23).
Chamber Furnaces up to 1400 °C

Furnaces with sturdy insulation made from lightweight refractory bricks for rough use in the laboratory.

- Dual shell housing made of textured stainless steel sheets with additional fan cooling for low surface temperature
- Solid state relays provide for low noise operation
- Only fiber materials are used which are not classified as carcinogenic according to TRGS 905, class 1 or 2
- NTLog Basic for Nabertherm controller: recording of process data with USB-flash drive
- Defined application within the constraints of the operating instructions
- As additional equipment: Process control and documentation via VCD software package for monitoring, documentation and control
<table>
<thead>
<tr>
<th>Furnace Group</th>
<th>Model</th>
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</tr>
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<tbody>
<tr>
<td>Chamber furnaces up to 1400 °C</td>
<td>LH, LF</td>
<td>28</td>
</tr>
<tr>
<td>Chamber furnaces up to 1280 °C</td>
<td>N .../H</td>
<td>30</td>
</tr>
<tr>
<td>Accessories for the heat treatment of metals</td>
<td></td>
<td>31</td>
</tr>
</tbody>
</table>
Chamber Furnaces with Brick Insulation or Fiber Insulation up to 1400 °C

These big chamber furnaces LH 15/12 - LF 120/14 have been trusted for many years as professional chamber furnaces for the laboratory. These furnaces are available with either a robust insulation of light refractory bricks (LH models) or with a combination insulation of refractory bricks in the corners and low heat storage, quickly cooling fiber material (LF models). With a wide variety of optional equipment, these chamber furnaces can be optimally adapted to your processes.

Standard Equipment
- Tmax 1200 °C, 1300 °C, or 1400 °C
- High furnace chamber with five-sided heating for very good temperature uniformity
- Heating elements on support tubes ensure free heat radiation and a long service life
- Controller mounted on furnace door and removable for comfortable operation
- Protection of bottom heating and flat stacking surface provided by embedded SiC plate in the floor
- LH models: multi-layered insulation of light refractory bricks and special backup insulation
- LF models: high-quality fiber insulation with corner bricks for shorter heating and cooling times
- Door with brick-on-brick seal, hand fitted
- Gegenerously dimensioned heating provides for short heating times
- Self-supporting arch for high stability and greatest possible protection against dust
- Motor driven exhaust air flap
- Freely adjustable air inlet integrated in furnace floor
- Base included
- Controller B400 (5 programs with each 4 segments), alternative controllers see page 75

Additional Equipment
- Parallel swinging door for opening when hot with hot surface facing away from the operator
- Lift door with electro-mechanic linear drive
- Separate wall-mounting or floor standing cabinet for switchgear
- Cooling system to cool the furnace with a defined temperature gradient or with a preset fresh air volume. Both operating modes can be switched on and off for different segments by means of the extra function of the controller.
- Protective gas connection to purge with non-flammable protective or reaction gases
- Manual or automatic gas supply system
- Scale to measure weight reduction during annealing
LF furnace design provides for shorter heating and cooling times.

Chamber furnace LH 30/12 SW with scale to measure weight reduction during annealing.

Chamber furnace LH 30/12 with manual lift door.

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax in °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions in mm</th>
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</table>

1External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

2Heating only between two phases.

*Please see page 75 for more information about supply voltage.
Chamber Furnaces for Annealing, Hardening and Brazing up to 1280 °C

To withstand harsh use in the laboratory, e.g. when heat-treating metals, robust insulation with light refractory bricks is necessary. The chamber furnaces N 7/H - N 87/H are a perfect fit to solve this problem. The furnaces can be extended with a variety of accessories, like annealing boxes for operation under protective gas, roller guides, or a cooling station with a quench tank. Even high-performance applications like the annealing of titanium in medical applications can be implemented without the use of expensive and complicated annealing systems.

Standard Equipment

- Tmax 1280 °C
- Deep furnace chamber with three-sides heating: from both side walls and bottom
- Heating elements on support tubes ensure free heat radiation and a long service life
- Bottom heating protected by heat-resistant SiC plate
- Temperature uniformity up to ±/− 10 °C according to DIN 17052-1 see page 71
- Low energy consumption due to multi-layer insulation
- Base frame included in the delivery, N 7/H - N 17/HR designed as table-top model
- Parallel guided downward swinging door (user protected from heat radiation)
- Door movement cushioned with gas dampers/struts
- Controller B400 (5 programs with each 4 segments), alternative controllers see page 75

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax in °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions1 in mm</th>
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1External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
2Heating time of the empty and closed furnace up to Tmax −100 K (connected to 230 V 1/N/PE r.sp. 400 V 3/N/PE)
3Heating only between two phases

*Please see page 75 for more information about supply voltage

Working with protective gas boxes for a protective gas atmosphere using a charging cart
Chamber furnace N 7/H as table-top model
Deep furnace chamber with three-sides heating
Accessories for the Heat Treatment of Metals

Our wide range of furnaces for heat treatment of metals can be extended with a large selection of accessories to suit the specific application.

Protective Gas Boxes for Heat Treatment in Protective Gas

By using protective gas boxes, annealing furnaces, forced convection furnaces and pit-type furnaces can be upgraded for heat treatment processes under non-flammable protective and reactive gases.

Annealing Boxes

Annealing boxes are filled with powder or granules into which the charge is placed. Processes like soldering can be carried out in an inexpensive manner.

Complete Workshop Hardening Systems

The Nabertherm compact hardening systems consist of a hardening furnace, a tempering furnace, a quenching and cleaning bath. They can be used for various heat treatment processes in the workshop.

Quenching and Cleaning Baths

Baths for quenching in oil or water as well as for cleaning and degreasing are available as single or double baths and are made of stainless steel.

Auxiliary Materials for Better Charge Results

Hardening foils, annealing bags, granulate

Protective Equipment

Gloves, face and body protection

For more information about our extensive range of heat treatment accessories, please request our catalog "Thermal Process Technology II"
High-temperature furnaces as table or stand models for maximum temperatures between 1400 °C and 1800 °C, for example for sintering ceramics or for melting small glass samples.

- Dual shell housing made of textured stainless steel sheets with additional fan cooling for low surface temperature
- Stainless steel exhaust hood as interface to customer’s exhaust system for all standing models
- Only fiber materials are used which are not classified as carcinogenic according to TRGS 905, class 1 or 2
- NTLog Basic for Nabertherm controller: recording of process data with USB-flash drive
- Defined application within the constraints of the operating instructions
- As additional equipment: Process control and documentation via VCD software package for monitoring, documentation and control
Furnace Group

<table>
<thead>
<tr>
<th>Model</th>
<th>Page</th>
</tr>
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<tr>
<td>LHT</td>
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<td>LHT../LB</td>
<td>36</td>
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<tr>
<td>LHT../SW</td>
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<td>HTC</td>
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<tr>
<td>HFL</td>
<td>41</td>
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</tbody>
</table>
High-Temperature Furnaces with SiC Rod Heating up to 1600 °C

These powerful laboratory muffle furnaces are available for temperatures up to 1400 °C, 1500 °C, 1550 °C or 1600 °C. The durability of the SiC rods in periodic use, in combination with their high heating speed, make these high-temperature furnaces to all-rounders in the laboratory. Heating times of 20 - 25 minutes to 1400 °C can be achieved, depending on the furnace model and the conditions of use.

### Standard Equipment

- Tmax 1400 °C, 1500 °C, 1550 °C or 1600 °C
- Working temperature 1500 °C (for high-temperature furnaces LHTC..16), increased wear and tear must be expected in case of working at higher temperatures
- Optional flap door (LHTC) which can be used as work platform or lift door (LHTCT) with hot surface facing away from the operator (High-temperature furnace LHTCT 01/16 only with lift door)
- Switching system with solid-state-relays, power tuned to the SiC rods
- Easy replacement of heating rods
- Adjustable air inlet opening, exhaust air opening in the roof
- Controller C450 (10 programs with each 20 segments), alternative controllers see page 75

### Additional Equipment

- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Protective gas connection to purge with non-flammable protective or reaction gases, not gas tight
- Manual or automatic gas supply system

### Model Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax in °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions in mm</th>
<th>Connected load in kW</th>
<th>Electrical connection</th>
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<th>Heating time in min</th>
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</table>

*External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

1Plus maximum 240 mm for models LHTCT when open

2Heating time of the empty and closed furnace up to Tmax –100 K (connected to 230 V 1/N/PE rsp. 400 V 3/N/PE)

*Please see page 75 for more information about supply voltage

*Heating only between two phases
High-Temperature Furnaces with MoSi₂ Heating Elements up to 1800 °C

Designed as tabletop models, these compact high-temperature furnaces have a variety of advantages. The first-class workmanship using high-quality materials, combined with ease of operation, make these furnaces all-rounders in research and the laboratory. These high-temperature furnaces are also perfectly suited for the sintering of technical ceramics, such as zirconium oxide dental bridges.

### Standard Equipment

- Tmax 1600 °C, 1750 °C, or 1800 °C
- Recommended working temperature 1750 °C (for models LHT ../18), increased wear and tear must be expected in case of working at higher temperatures
- High-quality molybdenum disilicide heating elements
- Adjustable air inlet opening, exhaust air opening in the roof
- Type B thermocouple
- Controller P470 (50 programs with each 40 segments), controls description see page 75

### Additional Equipment

- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Protective gas connection to purge with non-flammable protective or reaction gases, not gas tight
- Manual or automatic gas supply system

### Specifications

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<th>Heating time in min</th>
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<td>150 150 150</td>
<td>4</td>
<td>470 630 760+260</td>
<td>5.2</td>
<td>3-phase⁴</td>
<td>85</td>
<td>40</td>
</tr>
<tr>
<td>LHT 08/18</td>
<td>1800</td>
<td>150 300 150</td>
<td>8</td>
<td>470 810 760+260</td>
<td>9.0</td>
<td>3-phase⁴</td>
<td>100</td>
<td>40</td>
</tr>
</tbody>
</table>

1External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
2Including opened lift door
3Heating time of the empty and closed furnace up to Tmax –100 K (connected to 230 V 1/N/PE resp. 400 V 3/N/PE)
4Please see page 75 for more information about supply voltage

Example of an over-temperature limiter
High-Temperature Bottom Loading Furnaces up to 1700 °C

The motor-driven lifting table significantly simplifies the charging of the high-temperature furnaces LHT ./. LB (Speed). The heating all around the cylindrical furnace chamber provides for an optimal temperature uniformity. For the tabletop models LHT 01/17 LB Speed and LHT 02/17 LB Speed the charge can be placed in charge saggars made of technical ceramics. Up to three charge saggars can be stacked on top of each other resulting in a high productivity.

Model | Tmax in °C | Inner dimensions in mm | Volume in l | Outer dimensions in mm | Connected load in kW | Electrical connection | Weight in kg
--- | --- | --- | --- | --- | --- | --- | ---
LHT 01/17 LB Speed | 1650 | 165 180 180 185 185 | 1 2 | 350 390 590 765 | 2.9 3.4 | 1-phase 1-phase | 40 50
LHT 02/17 LB Speed | 1650 | 165 180 180 185 185 | 1 2 | 350 390 590 765 | 2.9 3.4 | 1-phase 1-phase | 40 50
LHT 16/17 LB | 1700 | Ø 260 260 260 16 | 16 | 650 1250 1980 | 12.0 | 3-phase | 410

Standard Equipment
- Tmax 1650 °C, 1700 °C (LHT 16/17 LB)
- High-quality heating elements made of molybdenum disilicide offer very good protection against chemical interaction between charge and heating elements
- Excellent temperature uniformity thanks to three (LHT 02/17 LB Speed) or four-sided (LHT 01/17 LB Speed) heating of the furnace chamber
- Furnace chamber with a volume of 1, 2 or 16 liters, table with large floor space
- Precise, motorized toothed belt drive of the table with button operation
- Exhaust air vent in the roof
- Type S thermocouple
- Controller P470 (50 programs with each 40 segments), controls description see page 75

Additional Equipment
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Stackable saggars for loading in up to two or three levels, depending on model, see page 25
- Adjustable air inlet through the floor

*External dimensions vary when furnace is equipped with additional equipment. Dimensions on request. *Please see page 75 for more information about supply voltage
High-Temperature Furnaces with Scale for Determination of Combustion Loss and Thermogravimetric Analysis (TGA) up to 1750 °C

These high-temperature furnaces were specially developed to determine combustion loss during annealing and for thermogravimetric analysis (TGA) in the lab. The complete system consists of the high-temperature furnace for 1600 °C or 1750 °C, a table frame, precision scale with feedthroughs into the furnace and powerful software for recording both the temperature curve and the weight loss over time.

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax in °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions1 in mm</th>
<th>Connected load in kW</th>
<th>Electrical connection*</th>
<th>Weight in kg</th>
<th>Heating time in min²</th>
</tr>
</thead>
<tbody>
<tr>
<td>LHT 04/16 SW</td>
<td>1600</td>
<td>150 150 150</td>
<td>4</td>
<td>655 370 890</td>
<td>5.0</td>
<td>3-phase³</td>
<td>85</td>
<td>25</td>
</tr>
<tr>
<td>LHT 04/17 SW</td>
<td>1750</td>
<td>150 150 150</td>
<td>4</td>
<td>655 370 890</td>
<td>5.0</td>
<td>3-phase³</td>
<td>85</td>
<td>30</td>
</tr>
</tbody>
</table>

1External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
2Heating time of the empty and closed furnace up to Tmax − 100 K (connected to 230 V 1/N/PE resp. 400 V 3/N/PE)
3Heating only between two phases

*Please see page 75 for more information about supply voltage

<table>
<thead>
<tr>
<th>Scale</th>
<th>Readability</th>
<th>Maximum weighing range</th>
<th>Weight of plunger</th>
<th>Calibration value</th>
<th>Minimum load</th>
</tr>
</thead>
<tbody>
<tr>
<td>EW-2200</td>
<td>0.01</td>
<td>2200 incl. plunger</td>
<td>850</td>
<td>0.1</td>
<td>0.5</td>
</tr>
<tr>
<td>EW-4200</td>
<td>0.01</td>
<td>4200 incl. plunger</td>
<td>850</td>
<td>0.1</td>
<td>0.5</td>
</tr>
<tr>
<td>EW-6200</td>
<td>0.01</td>
<td>6200 incl. plunger</td>
<td>850</td>
<td>-</td>
<td>1.0</td>
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<tr>
<td>EW-12000</td>
<td>0.10</td>
<td>12000 incl. plunger</td>
<td>850</td>
<td>1.0</td>
<td>5.0</td>
</tr>
</tbody>
</table>

4 scales available for different maximum weights and scaling ranges

Software for documentation of the temperature curve and combustion loss using a PC

High-quality molybdenum disilicide heating elements
Due to their solid construction and compact stand-alone design, these high-temperature furnaces are perfect for processes in the laboratory where the highest precision is needed. Outstanding temperature uniformity and practical details set very high quality benchmarks. For configuration for your processes, these furnaces can be extended with extras from our extensive option list.

High-Temperature Furnaces with Molybdenum Disilicide Heating Elements with Fiber Insulation up to 1800 °C

**Standard Equipment**
- Tmax 1600 °C, 1750 °C, or 1800 °C
- Recommended working temperature 1750 °C (for models HT ../18), increased wear and tear must be expected in case of working at higher temperatures
- Dual shell housing with fan cooling for low shell temperatures
- Heating from both sides via molybdenum disilicide heating elements
- High-quality fiber insulation backed by special insulation
- Side insulation constructed with tongue and groove blocks provides for low heat loss to the outside
- Long-life roof insulation with special suspension
- Chain-guided parallel swivel door for defined opening and closing of the door
- Two-door design (front/back) for high-temperature furnaces from HT 276/..
- Labyrinth sealing ensures the least possible temperature loss in the door area
- Reinforced floor as protection for bottom insulation as standard from models HT 16/16 upwards (distributed load 5 kg/dm²)
- Vapor vent in the furnace roof with motor-driven exhaust air flap, controlled via the extra function of the controller
- Heating elements switched via thyristors

**Additional Equipment**
- Cooling system to cool the furnace with a defined temperature gradient or with a preset fresh air volume. Both operating modes can be switched on and off for different segments by means of the extra function of the controller.
- Safety package for debinding in air. Debinding technical ceramics is a critical process because of the hydrocarbons that are released. Hydrocarbons are flammable and there is a risk that a flammable mixture could form inside the furnace. Nabertherm offers tailored safety packages with respect to the process and the volume of binder that allow the furnace to be operated safely.
- Special heating elements for zirconia sintering
- Protective gas connection to purge with non-flammable protective or reaction gases
- Automatic gas supply system with solenoid valve and rotameter, controlled by the extra function of the controller
- Inner process box to improve the gas tightness and to protect the furnace chamber against contamination
- Refractory brick floor insulation for a higher floor load (Tmax 1700 °C)
- Lift door
- Automatic door lock incl. door contact switch
- Ethernet interface
**High-temperature furnace HT 160/17 with gas supply system**

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions1 in mm</th>
<th>Connected load kW</th>
<th>Electrical connection*</th>
<th>Weight in kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>HT 08/16</td>
<td>1600</td>
<td>150 300 150</td>
<td>8</td>
<td>W D H</td>
<td></td>
<td>8.5</td>
<td>3-phase 2</td>
</tr>
<tr>
<td>HT 16/16</td>
<td>1600</td>
<td>200 300 260</td>
<td>16</td>
<td>W D H</td>
<td></td>
<td>12.5</td>
<td>3-phase 2</td>
</tr>
<tr>
<td>HT 29/16</td>
<td>1600</td>
<td>275 300 350</td>
<td>29</td>
<td>W D H</td>
<td></td>
<td>9.8</td>
<td>3-phase 2</td>
</tr>
<tr>
<td>HT 40/16</td>
<td>1600</td>
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<td>40</td>
<td>W D H</td>
<td></td>
<td>12.5</td>
<td>3-phase 420</td>
</tr>
<tr>
<td>HT 64/16</td>
<td>1600</td>
<td>400 400 400</td>
<td>64</td>
<td>W D H</td>
<td></td>
<td>18.5</td>
<td>3-phase 555</td>
</tr>
<tr>
<td>HT 128/16</td>
<td>1600</td>
<td>800 400 128</td>
<td>128</td>
<td>W D H</td>
<td></td>
<td>26.5</td>
<td>3-phase 820</td>
</tr>
<tr>
<td>HT 160/16</td>
<td>1600</td>
<td>500 550 550</td>
<td>160</td>
<td>W D H</td>
<td></td>
<td>21.5</td>
<td>3-phase 880</td>
</tr>
<tr>
<td>HT 276/16</td>
<td>1600</td>
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<td>1310</td>
<td>W D H</td>
<td></td>
<td>36.5</td>
<td>3-phase 1300</td>
</tr>
<tr>
<td>HT 450/16</td>
<td>1600</td>
<td>1150 780 450</td>
<td>1360</td>
<td>W D H</td>
<td></td>
<td>65.0</td>
<td>3-phase 1450</td>
</tr>
</tbody>
</table>

**Model Tmax Inner dimensions in mm Volume Outer dimensions1 in mm Connected Electrical Weight**

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions1 in mm</th>
<th>Connected load kW</th>
<th>Electrical connection*</th>
<th>Weight in kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>HT 08/17</td>
<td>1750</td>
<td>150 300 150</td>
<td>8</td>
<td>W D H</td>
<td></td>
<td>8.5</td>
<td>3-phase 2</td>
</tr>
<tr>
<td>HT 16/17</td>
<td>1750</td>
<td>200 300 260</td>
<td>16</td>
<td>W D H</td>
<td></td>
<td>12.5</td>
<td>3-phase 2</td>
</tr>
<tr>
<td>HT 29/17</td>
<td>1750</td>
<td>275 300 350</td>
<td>29</td>
<td>W D H</td>
<td></td>
<td>9.8</td>
<td>3-phase 2</td>
</tr>
<tr>
<td>HT 40/17</td>
<td>1750</td>
<td>300 350 350</td>
<td>40</td>
<td>W D H</td>
<td></td>
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<td>3-phase 420</td>
</tr>
<tr>
<td>HT 64/17</td>
<td>1750</td>
<td>400 400 400</td>
<td>64</td>
<td>W D H</td>
<td></td>
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<td>3-phase 555</td>
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<tr>
<td>HT 128/17</td>
<td>1750</td>
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<td>128</td>
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<td></td>
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<td>3-phase 820</td>
</tr>
<tr>
<td>HT 160/17</td>
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<td>550 550 550</td>
<td>160</td>
<td>W D H</td>
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<td>21.5</td>
<td>3-phase 880</td>
</tr>
<tr>
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<td>W D H</td>
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<td>3-phase 1300</td>
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<tr>
<td>HT 450/17</td>
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<td>1150 780 450</td>
<td>1360</td>
<td>W D H</td>
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<td>65.0</td>
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</tbody>
</table>

**Model Tmax Inner dimensions in mm Volume Outer dimensions1 in mm Connected Electrical Weight**

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions1 in mm</th>
<th>Connected load kW</th>
<th>Electrical connection*</th>
<th>Weight in kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>HT 08/18</td>
<td>1800</td>
<td>150 300 150</td>
<td>8</td>
<td>W D H</td>
<td></td>
<td>8.5</td>
<td>3-phase 2</td>
</tr>
<tr>
<td>HT 16/18</td>
<td>1800</td>
<td>200 300 260</td>
<td>16</td>
<td>W D H</td>
<td></td>
<td>12.5</td>
<td>3-phase 2</td>
</tr>
<tr>
<td>HT 29/18</td>
<td>1800</td>
<td>275 300 350</td>
<td>29</td>
<td>W D H</td>
<td></td>
<td>9.8</td>
<td>3-phase 2</td>
</tr>
<tr>
<td>HT 40/18</td>
<td>1800</td>
<td>300 350 350</td>
<td>40</td>
<td>W D H</td>
<td></td>
<td>12.5</td>
<td>3-phase 420</td>
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<tr>
<td>HT 64/18</td>
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<td>400 400 400</td>
<td>64</td>
<td>W D H</td>
<td></td>
<td>18.5</td>
<td>3-phase 555</td>
</tr>
<tr>
<td>HT 128/18</td>
<td>1800</td>
<td>800 400 128</td>
<td>128</td>
<td>W D H</td>
<td></td>
<td>26.5</td>
<td>3-phase 820</td>
</tr>
<tr>
<td>HT 160/18</td>
<td>1800</td>
<td>550 550 550</td>
<td>160</td>
<td>W D H</td>
<td></td>
<td>21.5</td>
<td>3-phase 880</td>
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<td>1800</td>
<td>1000 550 276</td>
<td>1310</td>
<td>W D H</td>
<td></td>
<td>36.5</td>
<td>3-phase 1300</td>
</tr>
<tr>
<td>HT 450/18</td>
<td>1800</td>
<td>1150 780 450</td>
<td>1360</td>
<td>W D H</td>
<td></td>
<td>65.0</td>
<td>3-phase 1450</td>
</tr>
</tbody>
</table>

*External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.*

*Heating only between two phases*

---

- Automatic gas supply system with solenoid valve and rotameter
- Reinforced floor as protection for bottom insulation for high-temperature furnace HT 16/16 and higher
- Two-door design for high-temperature furnaces > HT 276/..
High-Temperature Furnaces with SiC Rod Heating up to 1550 °C

The high-temperature furnaces HTC 16/16 - HTC 450/16 are heated by vertically hung SiC rods, which makes them especially suitable for sintering processes up to a maximum operating temperature of 1550 °C. For some processes, e.g. for sintering zirconium oxide, the absence of interactivity between the charge and the SiC rods, these models are more suitable than the alternatives heated with molybdenum disilicide elements. The basic construction of these furnaces make them comparable with the already familiar models in the HT product line and they can be upgraded with the same additional equipment.

### Standard Equipment

- Tmax 1550 °C
- Dual shell housing with fan cooling for low shell temperatures
- Heating from both sides via vertically mounted SiC rods
- High-quality fiber insulation backed by special insulation
- Side insulation constructed with tongue and groove blocks provides for low heat loss to the outside
- Long-life roof insulation with special suspension
- Chain-guided parallel swivel door for defined opening and closing of the door without destroying the insulation
- Two-door design (front/back) for high-temperature furnaces > HTC 276/..
- Labyrinth sealing ensures the least possible temperature loss in the door area
- Reinforced floor as protection for bottom insulation
- Vapor vent in the furnace roof with motor-driven exhaust air flap, controlled via the extra function of the controller
- Heating elements switched via SCR’s
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load

### Additional Equipment

Like HT models see page 39

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax in °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions1 in mm</th>
<th>Heating Power in kW</th>
<th>Connected load in kW</th>
<th>Electrical connection*</th>
<th>Weight in kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>HTC 16/16</td>
<td>1550</td>
<td>200 300 260</td>
<td>16</td>
<td>810 700 1500</td>
<td>12.0</td>
<td>16.0</td>
<td>3-phase</td>
<td>270</td>
</tr>
<tr>
<td>HTC 40/16</td>
<td>1550</td>
<td>300 350 350</td>
<td>40</td>
<td>1000 800 1620</td>
<td>12.0</td>
<td>16.1</td>
<td>3-phase</td>
<td>380</td>
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<tr>
<td>HTC 64/16</td>
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<td>64</td>
<td>1130 900 1670</td>
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<td>41.1</td>
<td>3-phase</td>
<td>550</td>
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<tr>
<td>HTC 128/16</td>
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<td>128</td>
<td>1130 1290 1670</td>
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<td>1300 1600 1900</td>
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<td>3-phase</td>
<td>1100</td>
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<td>1350 1740 2120</td>
<td>64.0</td>
<td>118.0</td>
<td>3-phase</td>
<td>1500</td>
</tr>
</tbody>
</table>

*External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

*Heating only between two phases

---

Vertically mounted SiC rods and optional perforated air inlet tubes of the debinding system in a high-temperature furnace

Automatic gas supply system

Two-door design for high-temperature furnaces > HT 276/..
High Temperature Furnaces with Molybdenum Disilicide Heating Elements with Refractory Brick Insulation up to 1700 °C

The high-temperature furnaces HFL 16/16 HFL 160/17 are characterized by their lining with robust light refractory bricks. This version is recommended for processes producing aggressive gases or acids, such as under glass melting.

### Standard Equipment

Like high-temperature furnaces HT (see page 39), except:
- Tmax 1600 °C or 1700 °C
- Robust refractory brick insulation and special backing insulation
- Furnace floor made of lightweight refractory bricks accommodates high charge weights
- Chain-guided parallel swivel door for defined opening and closing of the door without destroying the insulation
- Labyrinth sealing ensures the least possible temperature loss in the door area

### Additional Equipment

Like high-temperature furnaces HT see page 39
- Protective gas connection to purge with non-flammable protective or reaction gases
- Automatic gas supply system with solenoid valve and rotameter, controlled by the extra function of the controller
- Lift door

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax in °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions in mm</th>
<th>Connected load in kW</th>
<th>Electrical connection</th>
<th>Weight in kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>HFL 16/16</td>
<td>1600</td>
<td>200 300 260</td>
<td>16</td>
<td>1000 890 1620</td>
<td>12</td>
<td>3-phase</td>
<td>500</td>
</tr>
<tr>
<td>HFL 40/16</td>
<td>1600</td>
<td>300 350 350</td>
<td>40</td>
<td>1130 915 1890</td>
<td>12</td>
<td>3-phase</td>
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<td>400 400 400</td>
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<td>1230 980 1940</td>
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<td>1000 890 1620</td>
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<td>1130 915 1890</td>
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<td>1400 1250 2100</td>
<td>21</td>
<td>3-phase</td>
<td>1190</td>
<td></td>
</tr>
</tbody>
</table>

1External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

*Heating only between two phases

*Please see page 75 for more information about supply voltage

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Gas supply system for non-flammable protective or reaction gases

Thermocouple port in the ceiling with tripod

Light-weight refractory bricks and heating elements made from molybdenum disilicide
An extensive range of accessories for flexible and universal use for different processes is available for these tube furnaces.

- Dual shell housing made of textured stainless steel sheets with additional fan cooling for low surface temperature
- Only fiber materials are used which are not classified as carcinogenic according to TRGS 905, class 1 or 2
- NTLog Basic for Nabertherm controller: recording of process data with USB-flash drive
- Defined application within the constraints of the operating instructions
- As additional equipment: Process control and documentation via VCD software package for monitoring, documentation and control
<table>
<thead>
<tr>
<th>Furnace Group</th>
<th>Model</th>
<th>Page</th>
</tr>
</thead>
<tbody>
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<td>RD, R</td>
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<tr>
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<td>RSRB</td>
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<tr>
<td>Rotary tube furnaces for processes with continuous movement up to 1300 °C</td>
<td>RSRC</td>
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</tr>
<tr>
<td>Tube furnaces with stand for horizontal and vertical operation up to 1500 °C</td>
<td>RT</td>
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<td>High-temperature tube furnaces with SiC rod heating up to 1500 °C</td>
<td>RHTC</td>
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</tr>
<tr>
<td>High-temperature tube furnaces for horizontal or vertical operation up to 1800 °C</td>
<td>RHTH, RHTV</td>
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<tr>
<td>Working tubes</td>
<td></td>
<td>56</td>
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<tr>
<td>Gas supply systems/vacuum operation</td>
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<td>58</td>
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<tr>
<td>Control alternatives for tube furnaces</td>
<td></td>
<td>62</td>
</tr>
<tr>
<td>Customized tube furnaces</td>
<td></td>
<td>63</td>
</tr>
</tbody>
</table>
Compact Tube Furnaces up to 1100 °C

The RD 30/200/11 tube furnace impresses with its very good price-performance ratio, particularly compact external dimensions and its low weight. This all-rounder is equipped with a working tube, which also serves as support for the heating wires. The working tube is therefore part of the furnace heating, with the advantage that the tube furnace reaches very high heating speeds. The furnace is designed for horizontal use up to 1100 °C.

### Standard Equipment

- **Tmax** 1100 °C
- Inner diameter of the tube: 30 mm, heated length: 200 mm
- Ceramic working tube C 530 including two fiber plugs for operation under air
- Thermocouple type K (1100 °C)
- Heating wires wound directly around the working tube resulting in very fast heat-up rates
- Controller R7, alternative controllers see page 75

### Additional Equipment

- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Gas supply system 1 for non-flammable protective or reactive gas see page 58

---

**Model**  
RD 30/200/11  
**Tmax** (°C)  
1100  
**Outer dimensions** (in mm)  
350 200 350  
**Inner tube Ø** (in mm)  
30  
**Heated length** (in mm)  
200  
**Length constant temperature** (°C)  
+/- 5  
**Connected load** (in kW)  
1.5  
**Heating time** (min)  
20  
**Electrical connection**  
1-phase  
**Weight** (in kg)  
12

*Values outside the tube. Difference to temperature inside the tube up to + 50 K  
*External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.  
*Heating time of the empty and closed furnace up to Tmax –100 K (connected to 230 V 1/N/PE)

---

Controller R7  
Gas panel for one non-flammable protective or reactive gas (N₂, Ar, He, CO₂, air, forming gas)  
Example of an over-temperature limiter
These compact tube furnaces with integrated control systems can be used universally for many processes. Equipped with a standard working tube of C 530 ceramic and two fiber plugs, these tube furnaces have a very good price/performance ratio.

### Standard Equipment

- Tmax 1200 °C or 1300 °C
- Single-zoned design
- Outer tube diameter of 50 mm to 170 mm, heated length from 250 mm to 1000 mm
- Ceramic working tube C 530 including two fiber plugs for operation under air see page 56
- Thermocouple type N (1200 °C) or type S (1300 °C)
- Heating elements on support tubes provide for free radiation see page 62
- Controller B410 (5 programs with each 4 segments), alternative controllers see page 75

### Additional Equipment

- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Charge control with temperature measurement in the working tube see page 62
- Three-zoned design (heated length from 500 mm) for optimization of temperature uniformity
- Alternative working tubes see page 56
- Gas supply systems 1, 15, 2, 3 or 4 see page 58

### Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax in °C</th>
<th>Outer dimensions in mm</th>
<th>Outer tube Ø</th>
<th>Heated length in mm</th>
<th>Length constant temperature °C/ K</th>
<th>Tube length in mm</th>
<th>Connected load in kW</th>
<th>Electrical connection</th>
<th>Weight in kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>R 50/250/12</td>
<td>1200</td>
<td>434 340 508</td>
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<td>R 50/500/12</td>
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<td>670 340 508</td>
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<td>500</td>
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<tr>
<td>R 120/500/12</td>
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<td>920 460 628</td>
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<td>250</td>
<td>500</td>
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<td>1200</td>
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<td>750</td>
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<td>1400</td>
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<tr>
<td>R 170/1000/12</td>
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<td>170</td>
<td>1000</td>
<td>500</td>
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<td>11.5</td>
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<td>R 50/500/13</td>
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<td>670 340 508</td>
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<td>250</td>
<td>700</td>
<td>6.5</td>
<td>3-phase</td>
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<td>3-phase</td>
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<tr>
<td>R 170/750/13</td>
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<td>500</td>
<td>1400</td>
<td>11.5</td>
<td>3-phase</td>
<td>89</td>
</tr>
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</table>

1Values outside the tube. Difference to temperature inside the tube up to + 50
2Without tube
3External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

*Please see page 75 for more information about supply voltage
*Only valid for single-zone version
Split-Type Tube Furnaces for Horizontal or Vertical Operation up to 1300 °C

These tube furnaces can be used for horizontal (RSH) or vertical (RSV) operation. The split-type design makes it easy to change the working tube. It allows for a comfortable exchange of various working tubes (e.g. working tubes made of different materials).

Using a wide range of accessories, these professional tube furnaces can be optimally tailored for your process. By adding different gas supply packages, you can work in a protective gas atmosphere, with gases or in a vacuum. In addition to the convenient standard controllers, modern PLC controls can also be used to control the process.

Standard Equipment

- Tmax 1100 °C or 1300 °C
- Single-zoned design
- RSV models with frame for vertical operation
- Split-type design for simple insertion of the working tube (opening temperature < 180 °C)
- Ceramic working tube C 530 including two fiber plugs for operation under air see page 56
- Thermocouple type N (1100 °C) or type S (1300 °C)
- Heating elements on support tubes provide for free radiation see page 62
- RSH: switchgear and control unit integrated in furnace housing
- RSV: switchgear and control unit separate from furnace in own wall or standing cabinet
- Controller B410, alternative controllers see page 75

Additional Equipment

- Charge control with temperature measurement in the working tube see page 62
- Three-zone control for optimization of temperature uniformity see page 62
- Alternative working tubes see chart page 56
- Cooling systems for accelerated cooling of the working tube and charge
- Gas supply systems 1, 15 or 2 for non-flammable protective or reactive gas operation see page 58
- Gas supply packages 3 or 4 for hydrogen operation see page 60
- Vacuum package to evacuate the working tube see page 61
Tube furnace RSH 120/750/13 with gas supply system 4 for hydrogen applications

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax¹</th>
<th>Outer dimensions² in mm</th>
<th>Max. outer tube Ø</th>
<th>Heated length</th>
<th>Length constant temperature¹ +/− 5 K in mm</th>
<th>Tube length</th>
<th>Connected load ⁴ in kW</th>
<th>Electrical Weight in kg</th>
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<tr>
<td>RSH 50/250/..</td>
<td>420 375 510</td>
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<tr>
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<td>170 750</td>
<td>250 375</td>
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<td>665 590 1475 170 1000 330 500 1350 6.75 6.6 6.6 3-phase 46</td>
<td>RSV 170/1000/..</td>
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</table>

¹Values outside the tube. Difference to temperature inside the tube up to + 50 K
²External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
³Without tube
⁴At 415 volt
⁵At 3-phase execution an N conductor ist required (3/N/PE)

*Please see page 75 for more information about supply voltage.
Rotary Tube Furnaces for Batch Operation up to 1100 °C

The rotary tube furnaces of the RSRB series are suited for batch operation. The rotation of the working tube ensures that the charge is in motion. Due to the shape of the quartz reactor with the tapered pipe ends the batch is kept in the rotary tube furnace and can be heat-treated an arbitrarily long time period. A controlled heating to the temperature profiles is also possible.

Standard Equipment

- **Tmax 1100 °C**
- Single-zoned design
- Thermocouple type N
- Heating elements on support tubes provide for free radiation see page 62
- Tube furnace designed as table-top model with quartz glass reactor which opens on both sides, tapered ends
- Reactor is removed for emptying out of the rotary tube furnace. Beltless drive and hinged furnace housing (opening temperature < 180 °C) provide for very easy removal through
- Adjustable drive of approx. 1-40 rpm
- Controller B410 (5 programs with each 4 segments), alternative controllers see page 75

Additional Equipment

- Charge control with temperature measurement in the working tube see page 62
- Three-zone control for optimization of temperature uniformity see page 62
- Reactor open on both sides, made of quartz glass with knobs for better mixing of the charge in the tube
- Gas supply package 25 for operation under non-flammable protective or reaction gases with a gas-tight rotating outlet see page 59
- Gas supply packages 3 or 4 for hydrogen operation see page 60
- Vacuum package for evacuating the working tube, depending on the pump used up to \(10^{-2}\) mbar see page 61
- Left/right tilting device for easier loading and unloading of the work tube
  - For filling, the furnace is tilted to the right to convey the batch into the furnace. After the heat treatment, the furnace is swiveled to the opposite side for emptying, in order to convey the product out of the reactor again. It is not necessary to remove the reactor.
  - Mixing reactor made of quartz glass with integrated blade for better mixing of the batch, closed on one side, large opening on the opposite side
  - Rotary tube furnace assembled on base with integrated switchgear and controller, incl. transport casters
RSRB 170/1000/11 $H_2$ with gas supply package 4 for hydrogen application

<table>
<thead>
<tr>
<th>Model</th>
<th>$T_{\text{max}}$°C</th>
<th>Outer dimensions(^2) in mm</th>
<th>Max. outer tube Ø</th>
<th>Ø Terminal end</th>
<th>Heated length</th>
<th>Length constant Temperature(^1)/(\pm 5) K</th>
<th>Terminal Heated Length</th>
<th>Connected load</th>
<th>Electrical</th>
<th>Weight kg</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>(Table-top model)</td>
<td></td>
<td></td>
<td></td>
<td>in mm single zoned three zoned</td>
<td>mm</td>
<td>kW</td>
<td>kW</td>
<td>kg</td>
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<tr>
<td>RSRB 80/500/11</td>
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<td>1145</td>
<td>475</td>
<td>390</td>
<td>76</td>
<td>28 500</td>
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<td>475</td>
<td>390</td>
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<td>28 750</td>
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<td>525</td>
<td>440</td>
<td>106</td>
<td>28 1000</td>
<td>330</td>
<td>500</td>
<td>1640</td>
<td>9.3</td>
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</table>

\(^1\)Values outside the tube. Difference to temperature inside the tube up to $\pm 50$ K
\(^2\)External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
\(^3\)Heating only between phase 1 and neutral
\(^4\)Heating only between two phases

---

Gas tight closing plug for tubes made of quartz glass closed at one side as additional equipment

Gas tight rotating union with gas cooler and charge thermocouple

Connection set for vacuum operation

*Please see page 75 for more information about supply voltage.*
The rotary tube furnaces of the RSRC series are particularly suitable for processes in which continuously running batch material is heated short-time. These rotary furnaces can be used very flexibly for various purposes. The rotary tube furnace is slightly inclined and brought to the target temperature. The material is then fed continuously at the top of the pipe. It passes through the heated zone of the tube and falls out of the pipe at the lower end. The time of the heat treatment depends on the angle of inclination, the speed of rotation and the length of the working tube, as well as from the flow properties of the batch material. Equipped with the optionally available closed feeding system, the rotary tube furnace can also be used for processes in a defined atmosphere or in a vacuum. Depending on the process, batch and required maximum temperature, work tubes made of different materials are used.

### Standard Equipment
- Tmax 1100 °C
  - Working tube made of quartz glass open at both sides
  - Thermocouple type N
- Tmax 1300 °C
  - Open ceramic tube C 530
  - Thermocouple type S
- Heating elements on support tubes provide for free radiation see page 62
- Adjustable drive of approx. 0.5-20 rpm
- Digital display unit for the tilting angle of the rotary tube furnace
- Split-type furnace housing (opening temperature < 180 °C) provide for easy tube change
- Compact system, rotary tube furnace positioned on a base frame with
  - Manual spindle drive with crank to set the tilting angle
  - Switchgear and controls integrated
  - Castors
- Controller B400 (5 programs with each 4 segments), alternative controllers see page 75

### Additional Equipment
- Charge control with temperature measurement in the working tube see page 62
- Three-zone control for optimization of temperature uniformity see page 62
- Alternative work tubes for different process requirements see page 56
- Quartz glass batch reactors (Tmax 1100 °C)
- Higher temperatures up to 1500 °C available on request
- Vibrating channel on the rotary tube for convenient material supply, suitable for processes in air
- Powder discharge tube for easy material discharge, suitable for processes in air
- Feeding system for the continuous delivery of 5 liters of material under a defined atmosphere or vacuum, consisting of:
  - Stainless steel funnel incl. electric vibration unit to optimize the material feeding into the working tube
  - Electrically driven screw-conveyor at the inlet of the working tube with 10, 20 or 40 mm pitch and adjustable speed between 0.25 and 20 rpm
  - Collecting bottle made of laboratory glass at the outlet of the working tube
- Gas supply package 26 for operation under non-flammable protective or reaction gases (only in connection with the feeding system) see page 59
- Gas supply packages 3 or 4 for hydrogen applications (only in connection with feeding system) see page 60
- Vacuum package for evacuating the working pipe, depending on the pump used up to 10⁻² mbar see page 61
### Rotary Tube Furnace RSRC 80/500/11 with Feeding System and Gas Supply System 26 for Processes Under Protective Gas

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax¹ in °C</th>
<th>Outer dimensions² in mm</th>
<th>Max. outer tube Ø in mm</th>
<th>Heated length in mm</th>
<th>Length constant Temperature¹ +/- 5 K in mm</th>
<th>Tube length in mm</th>
<th>Connected load in kW</th>
<th>Electrical connection*</th>
<th>Weight in kg</th>
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<tbody>
<tr>
<td>RSRC 80/500/11</td>
<td>110</td>
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<td>3005 1045 1715</td>
<td>110 1000</td>
<td>330 500</td>
<td></td>
<td>2040</td>
<td>9.3</td>
<td>3-phase</td>
<td>605</td>
</tr>
<tr>
<td>RSRC 80/500/13</td>
<td>1300</td>
<td>2505 1045 1655</td>
<td>80 500</td>
<td>170 250</td>
<td></td>
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<td>6.3</td>
<td>3-phase</td>
<td>555</td>
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<tr>
<td>RSRC 80/750/13</td>
<td>1300</td>
<td>2755 1045 1655</td>
<td>80 750</td>
<td>250 375</td>
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<td>3-phase</td>
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<td>2505 1045 1715</td>
<td>110 500</td>
<td>170 250</td>
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<td>585</td>
</tr>
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<td>RSRC 120/750/13</td>
<td>1300</td>
<td>2755 1045 1715</td>
<td>110 750</td>
<td>250 375</td>
<td></td>
<td>1790</td>
<td>12.9</td>
<td>3-phase</td>
<td>600</td>
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<tr>
<td>RSRC 120/1000/13</td>
<td>1300</td>
<td>3005 1045 1715</td>
<td>110 1000</td>
<td>330 500</td>
<td></td>
<td>2040</td>
<td>12.9</td>
<td>3-phase</td>
<td>605</td>
</tr>
</tbody>
</table>

¹Values outside the tube. Difference to temperature inside the tube up to +50 K
²External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
³Heating only between two phases

---

1 Values outside the tube. Difference to temperature inside the tube up to +50 K.
2 External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
3 Heating only between phase 1 and neutral.

*Please see page 75 for more information about supply voltage.

---

**Vibrating channel on the rotary tube for convenient material feeding**

**Screw-conveyors with different pitches**

**Screw-conveyor with variable speed**
These compact tube furnaces are used when laboratory experiments must be performed horizontally, vertically, or at specific angles. The ability to configure the angle of tilt and the working height, and their compact design, also make these tube furnaces suitable for integration into existing process systems.

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax (°C)</th>
<th>Outer dimensions (mm)</th>
<th>Inner tube Ø</th>
<th>Heated length (mm)</th>
<th>Length constant temperature (+/- 5 K)</th>
<th>Tube length (mm)</th>
<th>Connected load (kW)</th>
<th>Electrical connection</th>
<th>Weight (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>RT 50/250/11</td>
<td>1100</td>
<td>350 x 380 x 740</td>
<td>50</td>
<td>250</td>
<td>80</td>
<td>360</td>
<td>1.8</td>
<td>1-phase</td>
<td>25</td>
</tr>
<tr>
<td>RT 50/250/13</td>
<td>1300</td>
<td>350 x 380 x 740</td>
<td>50</td>
<td>250</td>
<td>80</td>
<td>360</td>
<td>1.8</td>
<td>1-phase</td>
<td>25</td>
</tr>
<tr>
<td>RT 30/200/15</td>
<td>1500</td>
<td>445 x 475 x 740</td>
<td>30</td>
<td>200</td>
<td>70</td>
<td>360</td>
<td>1.8</td>
<td>1-phase</td>
<td>45</td>
</tr>
</tbody>
</table>

1 Values outside the tube. Difference to temperature inside the tube up to + 50 K
2 External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

Additional Equipment

- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Gas supply system 1 for non-flammable protective or reactive gas see page 58
High-Temperature Tube Furnaces with SiC Rod Heating up to 1500 °C

These compact tube furnaces with SiC rod heating and integrated switchgear with controller can be used universally for many processes. They represent an inexpensive variant in the high-temperature range. The standard mounting options for accessories make them flexible in use for a wide range of applications. The SiC heating elements arranged parallel to the working tube provide for an excellent temperature uniformity.

### Standard Equipment

- Tmax 1500 °C
- Active cooling of housing for low surface temperatures
- Ceramic working tube C 799 including two fiber plugs for operation under air see page 56
- Type S thermocouple
- SiC heating elements, easy to replace
- Controller B410 (5 programs with each 4 segments), alternative controllers see page 75

### Additional Equipment

- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Charge control with temperature measurement in the working tube see page 62
- Alternative working tubes see page 56
- Gas supply systems 1, 2, 3 or 4 see page 58

### Model Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax in °C</th>
<th>Outer dimensions¹ in mm</th>
<th>Outer tube Ø in mm</th>
<th>Heated length in mm</th>
<th>Length constant temperature² +/− 5 K in mm</th>
<th>Tube length in mm</th>
<th>Connected load in kW</th>
<th>Electrical connection*</th>
<th>Weight in kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>RHTC 80/230/15</td>
<td>1500</td>
<td>600 440 585</td>
<td>80</td>
<td>230</td>
<td>80</td>
<td>600</td>
<td>7.5</td>
<td>3-phase²</td>
<td>50</td>
</tr>
<tr>
<td>RHTC 80/450/15</td>
<td>1500</td>
<td>820 440 585</td>
<td>80</td>
<td>450</td>
<td>150</td>
<td>850</td>
<td>11.3</td>
<td>3-phase¹</td>
<td>70</td>
</tr>
<tr>
<td>RHTC 80/710/15</td>
<td>1500</td>
<td>1075 440 585</td>
<td>80</td>
<td>710</td>
<td>235</td>
<td>1080</td>
<td>13.8</td>
<td>3-phase¹</td>
<td>90</td>
</tr>
</tbody>
</table>

¹Values outside the tube. Difference to temperature inside the tube up to + 50 K
²External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
³Heating only between phase 1 and neutral
⁴Heating only between two phases

*Please see page 75 for more information about supply voltage
High-Temperature Tube Furnaces for Horizontal or Vertical Operation up to 1800 °C

The high-temperature tube furnaces are available in either horizontal (type RHTH) or vertical (type RHTV) designs. High-quality insulation materials made of vacuum-formed fiber plates enable energy-saving operation due to low heat storage and heat conductivity. By using different gas supply systems, operations can be performed under non-flammable or flammable protective or reactive gases or under vacuum.

### Standard Equipment

- Tmax 1600 °C, 1700 °C, or 1800 °C
- Single-zoned design
- Insulation with vacuum-formed ceramic fiber plates
- Tube furnaces RHTV with frame for vertical operation
- Type B thermocouple
- Ceramic working tube C 799 including two fiber plugs for operation under air see page 56
- Hanging and easy to change MoSi2 heating elements
- Power unit with low-voltage transformer and thyristor
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load and with selectable maximum temperature gradient as tube protection
- Switchgear and control unit separate from furnace in separate floor standing cabinet
- Controller P470 (50 programs with each 40 segments), alternative controllers see page 75

### Additional Equipment

- Charge control with temperature measurement in the working tube see page 62
- Three-zone control for optimization of temperature uniformity (only horizontal tube furnaces RHTH) see page 62
- Alternative working tubes see page 56
- Gas supply system 2 for non-flammable protective or reactive gas operation see page 58
- Gas supply packages 3 or 4 for hydrogen operation see page 60
- Vacuum package to evacuate the working tube see page 61
<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax¹</th>
<th>Outer dimensions² in mm</th>
<th>Max. outer tube Ø in mm</th>
<th>Heated length in mm</th>
<th>Length constant temperature¹ +/− 5 K in mm</th>
<th>Tube length Connected load in mm</th>
<th>Electrical load in kW</th>
<th>Weight in kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Horizontal</td>
<td>in °C</td>
<td>W</td>
<td>D</td>
<td>H</td>
<td>in mm</td>
<td>in mm</td>
<td>in mm</td>
<td>single zoned</td>
</tr>
<tr>
<td>RHTH 50/150/..</td>
<td>1600</td>
<td>470</td>
<td>480</td>
<td>640</td>
<td>50</td>
<td>150</td>
<td>50</td>
<td>70</td>
</tr>
<tr>
<td>RHTH 80/300/..</td>
<td>1700</td>
<td>620</td>
<td>550</td>
<td>640</td>
<td>80</td>
<td>300</td>
<td>100</td>
<td>150</td>
</tr>
<tr>
<td>RHTH 120/600/..</td>
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<td>550</td>
<td>640</td>
<td>120</td>
<td>600</td>
<td>200</td>
<td>300</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax¹</th>
<th>Outer dimensions² in mm</th>
<th>Max. outer tube Ø in mm</th>
<th>Heated length in mm</th>
<th>Length constant temperature¹ +/− 5 K in mm</th>
<th>Tube length Connected load in mm</th>
<th>Electrical load in kW</th>
<th>Weight in kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vertical</td>
<td>in °C</td>
<td>W</td>
<td>D</td>
<td>H ²</td>
<td>in mm</td>
<td>in mm</td>
<td>in mm</td>
<td>single zoned</td>
</tr>
<tr>
<td>RHTV 50/150/..</td>
<td>1600</td>
<td>500</td>
<td>650</td>
<td>510</td>
<td>50</td>
<td>150</td>
<td>30</td>
<td>380</td>
</tr>
<tr>
<td>RHTV 80/300/..</td>
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<td>580</td>
<td>650</td>
<td>660</td>
<td>80</td>
<td>300</td>
<td>80</td>
<td>530</td>
</tr>
<tr>
<td>RHTV 120/600/..</td>
<td>1800</td>
<td>580</td>
<td>650</td>
<td>960</td>
<td>120</td>
<td>600</td>
<td>170</td>
<td>830</td>
</tr>
</tbody>
</table>

¹Values outside the tube. Difference to temperature inside the tube up to + 50 K
²Without tube
³External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.
⁴Heating only between two phases

*Please see page 75 for more information about supply voltage

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Tube furnace RHTH 120/600/17

Sintering under hydrogen in a tube furnace of RHTH product line

Example of over-temperature limiter
## Working Tubes

There are various working tubes available, depending on application and temperatures. The technical specifications of the different working tubes are presented in the following table:

### Measurements

<table>
<thead>
<tr>
<th>Outer Ø x Inner Ø x Length</th>
<th>Work Tube</th>
<th>Article No.</th>
<th>Spare Tube</th>
<th>Abstract Text</th>
</tr>
</thead>
<tbody>
<tr>
<td>80 x 65 x 1540 mm</td>
<td>Ceramic C 530</td>
<td>601405318</td>
<td>691404536</td>
<td>○</td>
</tr>
<tr>
<td>80 x 65 x 1790 mm</td>
<td>Ceramic C 530</td>
<td>601405319</td>
<td>691404537</td>
<td>○</td>
</tr>
<tr>
<td>80 x 65 x 2040 mm</td>
<td>Ceramic C 530</td>
<td>601404701</td>
<td>691404538</td>
<td>○</td>
</tr>
<tr>
<td>110 x 95 x 1540 mm</td>
<td>Ceramic C 530</td>
<td>601405320</td>
<td>691404539</td>
<td>○</td>
</tr>
<tr>
<td>110 x 95 x 1790 mm</td>
<td>Ceramic C 530</td>
<td>601405321</td>
<td>6914045376</td>
<td>○</td>
</tr>
<tr>
<td>110 x 95 x 2040 mm</td>
<td>Ceramic C 530</td>
<td>601405322</td>
<td>691404540</td>
<td>○</td>
</tr>
<tr>
<td>80 x 65 x 1540 mm</td>
<td>Ceramic C 610</td>
<td>601405315</td>
<td>691404541</td>
<td>○</td>
</tr>
<tr>
<td>80 x 65 x 1790 mm</td>
<td>Ceramic C 610</td>
<td>601405314</td>
<td>691404542</td>
<td>○</td>
</tr>
<tr>
<td>80 x 65 x 2040 mm</td>
<td>Ceramic C 610</td>
<td>601404707</td>
<td>691404543</td>
<td>○</td>
</tr>
<tr>
<td>110 x 95 x 1540 mm</td>
<td>Ceramic C 610</td>
<td>601405315</td>
<td>691404544</td>
<td>○</td>
</tr>
<tr>
<td>110 x 95 x 1790 mm</td>
<td>Ceramic C 610</td>
<td>601405316</td>
<td>691404546</td>
<td>○</td>
</tr>
<tr>
<td>110 x 95 x 2040 mm</td>
<td>Ceramic C 610</td>
<td>601405317</td>
<td>691404537</td>
<td>○</td>
</tr>
<tr>
<td>76 x 70 x 1540 mm</td>
<td>Quartz glass</td>
<td>601405308</td>
<td>691404545</td>
<td>○</td>
</tr>
<tr>
<td>76 x 70 x 1790 mm</td>
<td>Quartz glass</td>
<td>601405309</td>
<td>691404546</td>
<td>○</td>
</tr>
<tr>
<td>76 x 70 x 2040 mm</td>
<td>Quartz glass</td>
<td>601404713</td>
<td>691404547</td>
<td>○</td>
</tr>
<tr>
<td>106 x 100 x 1540 mm</td>
<td>Quartz glass</td>
<td>601405310</td>
<td>691404539</td>
<td>○</td>
</tr>
<tr>
<td>106 x 100 x 1790 mm</td>
<td>Quartz glass</td>
<td>601405311</td>
<td>6914043305</td>
<td>○</td>
</tr>
<tr>
<td>106 x 100 x 2040 mm</td>
<td>Quartz glass</td>
<td>601405312</td>
<td>691404548</td>
<td>○</td>
</tr>
<tr>
<td>76 x 70 x 1540 mm</td>
<td>Quartz glass with pimple</td>
<td>601405301</td>
<td>691404549</td>
<td>○</td>
</tr>
<tr>
<td>76 x 70 x 1790 mm</td>
<td>Quartz glass with pimple</td>
<td>601405304</td>
<td>691404550</td>
<td>○</td>
</tr>
<tr>
<td>76 x 70 x 2040 mm</td>
<td>Quartz glass with pimple</td>
<td>601404719</td>
<td>691404551</td>
<td>○</td>
</tr>
<tr>
<td>106 x 100 x 1540 mm</td>
<td>Quartz glass with pimple</td>
<td>601405305</td>
<td>691404552</td>
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</tr>
<tr>
<td>106 x 100 x 1790 mm</td>
<td>Quartz glass with pimple</td>
<td>601405306</td>
<td>6914043442</td>
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</tr>
<tr>
<td>106 x 100 x 2040 mm</td>
<td>Quartz glass with pimple</td>
<td>601405307</td>
<td>691404553</td>
<td>○</td>
</tr>
<tr>
<td>75 x 66 x 1540 mm</td>
<td>FeCrAl-Alloy</td>
<td>601405296</td>
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</tr>
<tr>
<td>75 x 66 x 1790 mm</td>
<td>FeCrAl-Alloy</td>
<td>601405297</td>
<td>691405231</td>
<td>○</td>
</tr>
<tr>
<td>109 x 99 x 1540 mm</td>
<td>FeCrAl-Alloy</td>
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<td>691403682</td>
<td>○</td>
</tr>
<tr>
<td>109 x 99 x 1790 mm</td>
<td>FeCrAl-Alloy</td>
<td>601405299</td>
<td>691403607</td>
<td>○</td>
</tr>
<tr>
<td>109 x 99 x 2040 mm</td>
<td>FeCrAl-Alloy</td>
<td>601405300</td>
<td>691405122</td>
<td>○</td>
</tr>
<tr>
<td>76 x 70 x 1140 mm</td>
<td>Quartz glass reactor</td>
<td>601402746</td>
<td>691402548</td>
<td>○</td>
</tr>
<tr>
<td>76 x 70 x 1390 mm</td>
<td>Quartz glass reactor</td>
<td>601402747</td>
<td>691402272</td>
<td>○</td>
</tr>
<tr>
<td>106 x 100 x 1140 mm</td>
<td>Quartz glass reactor</td>
<td>601402748</td>
<td>691402629</td>
<td>○</td>
</tr>
<tr>
<td>106 x 100 x 1390 mm</td>
<td>Quartz glass reactor</td>
<td>601402749</td>
<td>691402638</td>
<td>○</td>
</tr>
<tr>
<td>106 x 100 x 1640 mm</td>
<td>Quartz glass reactor</td>
<td>600048571</td>
<td>600032705</td>
<td>○</td>
</tr>
<tr>
<td>76 x 70 x 1140 mm</td>
<td>Quartz glass reactor with pimples</td>
<td>601404723</td>
<td>691402804</td>
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</tr>
<tr>
<td>76 x 70 x 1390 mm</td>
<td>Quartz glass reactor with pimples</td>
<td>601404724</td>
<td>691403429</td>
<td>○</td>
</tr>
<tr>
<td>106 x 100 x 1140 mm</td>
<td>Quartz glass reactor with pimples</td>
<td>601404725</td>
<td>6914042355</td>
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</tr>
<tr>
<td>106 x 100 x 1390 mm</td>
<td>Quartz glass reactor with pimples</td>
<td>601404726</td>
<td>691403296</td>
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</tr>
<tr>
<td>76 x 70 x 1140 mm</td>
<td>Quartz glass mixing reactor</td>
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<td>6914053407</td>
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</tr>
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<td>106 x 100 x 1390 mm</td>
<td>Quartz glass mixing reactor</td>
<td>601404730</td>
<td>691404558</td>
<td>○</td>
</tr>
</tbody>
</table>

---

Tubes/reactors incl. mounted sleeves for connection to the rotary drive. Spare tubes come without sleeves.
<table>
<thead>
<tr>
<th>Working tube</th>
<th>Article No.</th>
<th>Model</th>
</tr>
</thead>
<tbody>
<tr>
<td>outer Ø x inner Ø x length</td>
<td></td>
<td>R</td>
</tr>
<tr>
<td>40 x 30 x 450 mm</td>
<td>692070274</td>
<td>○</td>
</tr>
<tr>
<td>40 x 30 x 700 mm</td>
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<td>50 x 40 x 450 mm</td>
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<td>○</td>
</tr>
<tr>
<td>50 x 40 x 700 mm</td>
<td>692070277</td>
<td>○</td>
</tr>
<tr>
<td>60 x 50 x 850 mm</td>
<td>692070305</td>
<td>○</td>
</tr>
<tr>
<td>60 x 50 x 1100 mm</td>
<td>692070101</td>
<td>○</td>
</tr>
<tr>
<td>80 x 70 x 850 mm</td>
<td>692070106</td>
<td>○</td>
</tr>
<tr>
<td>80 x 70 x 1100 mm</td>
<td>692070100</td>
<td>○</td>
</tr>
<tr>
<td>120 x 100 x 850 mm</td>
<td>692070105</td>
<td>○</td>
</tr>
<tr>
<td>120 x 100 x 1100 mm</td>
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<td>○</td>
</tr>
<tr>
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<td>692070131</td>
<td>○</td>
</tr>
<tr>
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<td>692071660</td>
<td>○</td>
</tr>
<tr>
<td>50 x 40 x 650 mm</td>
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</tr>
<tr>
<td>50 x 40 x 900 mm</td>
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<td>60 x 50 x 1480 mm</td>
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<tr>
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<td>120 x 100 x 1230 mm</td>
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</table>

* Standard working tube
* Working tube available as an option
* With ground tube ends for connection of water-cooled flanges
* With attached holder for gas tight flange
Gas Supply Systems/Vacuum Package for Tube Furnaces

When equipped with different gas supply systems, most tube furnace product lines can be adapted for operation with non-flammable or flammable gases or for vacuum operation.

**Gas Supply System 1**
For Non-Flammable Protective or Reactive Gases in Static Tube Furnaces, not Gas-Tight

Gas supply system 1 is a basic version for static tube furnaces, for operation with non-flammable protective or reactive gases. This system is not completely gas-tight and can therefore not be used for vacuum operation.

**Standard Equipment**
- Available for RD, R, RT, RHTC, RSH and RSV tube furnaces
- Two plugs made of porous, non-classified ceramic fiber incl. protective gas connections
- The standard working tube supplied with the furnace can be used
- Gas panel for one non-flammable protective or reactive gas (N₂, Ar, He, CO₂, air, forming gas*)
- Shut-off valve and flow meter with manual valve
- Supply of gas with 300 mbar required

**Additional Equipment**
- Additional gas panels for further non-flammable gases
- Automatic segment-related switching on/off by a magnetic valve
- Bottle pressure reducer for use with bottled gas

**Gas Supply Systems 15 and 2**
for Non-Flammable Protective or Reactive Gases in Static Tube Furnaces, Gas-Tight

For increased atmospheric purity requirements in the working tube in static tube furnaces we recommend one of these gas-tight gas supply systems with stainless steel flanges on the end of the tube is recommended.

The less expensive gas supply system 15 for furnaces up to 1300 °C and working tubes to 120 mm diameter is available for R, RSH and RSV tube furnaces. It includes contact protection on the flange and a stainless steel type 1.4301 heat radiation protection insert for the tube ends to protect the seals. A heat radiation protection package cools the flanges and a water connection is thus not required. With this variant, the tube must not be opened while it is hot. It is also not suitable for applications with a turbomolecular pump to achieve high vacuum. Gas supply system 2 is the correct choice for this type of application.

Gas supply system 2 with water-cooled flanges is available for R, RHTC, RHTH, RHTV, RSH and RSV furnaces. Cooling water supply with NW9 hose connector to be provided by the customer.

**Standard Equipment**
- Extended gas-tight working tube made of C 610 for furnaces up to 1300 °C or C 799 for temperatures above 1300 °C
- Two vacuum-tight stainless steel flanges with KF flange on the outlet side
- Mounting system on furnace for the flanges

* Country-specific regulations for permissible mixture ratios must be observed.
- Gas panel for one non-flammable protective or reactive gas (N₂, Ar, He, CO₂, air, forming gas*)
- Shut-off valve and flow meter with manual valve
- Supply of gas with 300 mbar required
- Check valve in the gas outlet to prevent air entering

**Additional Equipment for Gas Supply Systems 15 and 2**

- Additional gas panels for further non-flammable gases
- Automatic segment-related switching on/off by a magnetic valve
- Bottle pressure reducer for use with bottled gas
- Vacuum package for a maximum final pressure of up to 5 \times 10^{-5} \text{ mbar}

**Other Additional Equipment only for Gas Supply System 2**

- Quick-locks for water-cooled flanges
- Air-water heat exchanger for closed loop water circuit
- Window for charge observation

---

**Gas Supply Systems 25 and 26**

for Non-Flammable Protective or Reactive Gases in Rotary Tube Furnaces, Gas-Tight

Gas supply systems for non-flammable protective and reactive gases are also available for RSRB and RSRC rotary tube furnaces.

**Standard Equipment**

- Gas panel for one non-flammable protective or reactive gas (N₂, Ar, He, CO₂, air, forming gas*)
- Shut-off valve and flow meter with manual valve
- Supply of gas with 300 mbar required

Gas supply system 25 for rotary tube furnaces for batch operation (RSRB) also includes gas-tight rotary lead-outs on the gas inlet and outlet as well as a gas cooler at the outlet. A check valve is also installed at the gas outlet to prevent air entering the tube.

For gas supply system 26 for rotary tube furnaces for continuous processes (RSRC) the furnace must also be equipped with a feeding system.

**Additional Equipment**

- Additional gas panels for further non-flammable gases
- Automatic segment-related switching on/off by a magnetic valve
- Bottle pressure reducer for use with bottled gas
- Vacuum package for a maximum final pressure of up to 5 \times 10^{-5} \text{ mbar}

* Country-specific regulations for permissible mixture ratios must be observed.
Gas Supply System 3
for Hydrogen Applications in Tube Furnaces above 750 °C

Gas supply system 3 allows for the operation in a hydrogen atmosphere at temperatures above 750 °C. From 750 °C, hydrogen can be introduced into the working tube. At program end or when the temperature falls below 750 °C, the working tube is purged with nitrogen to prevent the formation of an explosive hydrogen/oxygen atmosphere. The purging volume is at least five times the volume of the tube. Surplus hydrogen is burnt off in an exhaust gas torch.

Standard Equipment

- Available for R, RHTC, RHTH, RHTV, RSH, RSV, RSRB and RSRC tube furnaces
- Gas panel for hydrogen and nitrogen
- Automatic segment-related switching on/off by a magnetic valve
- Nabertherm Controller to regulate the temperature curve and switch the gas supply system
- Additional safety controls with touch panel to monitor hydrogen gassing only above 750 °C
- Exhaust gas torch with temperature monitoring
- Over-temperature limiter with digital display as over-temperature protection for the furnace and charge
- Temperature monitoring at the gas inlet
- Emergency purge container for nitrogen

Gas Supply System 4
for Hydrogen Applications in Tube Furnaces from Room Temperature

Gas supply system 4 allows operation with a hydrogen atmosphere starting at ambient temperature. During hydrogen operation, a pressure of approx. 30 mbar is ensured in the working tube. At the gas outlet the hydrogen is burnt off in an exhaust gas torch. Equipped with a safety PLC control system, pre-purging, hydrogen inlet, operation, fault monitoring and purging at the end of the process are carried out automatically (with at least five times the volume of the tube). If a malfunction occurs, the tube is immediately purged with nitrogen and the system is automatically switched to a safe status.

Standard Equipment

- Available for R, RHTC, RHTH, RHTV, RSH, RSV, RSRB and RSRC tube furnaces
- Gas panel for hydrogen and nitrogen
- Automatic segment-related switching on/off by a magnetic valve
- Control via safety PLC control system with touch panel
- Exhaust gas torch with temperature monitoring
- Over-temperature limiter with digital display as over-temperature protection for the furnace and charge
- Excess pressure monitoring
- Emergency purge container for nitrogen
Additional Equipment

- Additional gas panels for further non-flammable gases
- Operation with other flammable gases
- Gassing via program-related controllable mass flow controllers
- Bottle pressure reducer for use with bottled gas
- Air-water heat exchanger for closed loop water circuit (apart from RSRB and RSRC)

Assignment of Gas Supply Systems to Furnace Models

<table>
<thead>
<tr>
<th>Model</th>
<th>1</th>
<th>15</th>
<th>2</th>
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Vacuum Package

The vacuum package enables the working tube to be evacuated for vacuum operation in tube furnaces. It consists of an intermediate component for the gas outlet, a ball valve, a pressure gauge and a manually operated vacuum pump that is connected to the gas outlet by a corrugated stainless steel hose. A gas-tight furnace system is required for the use of a vacuum package, e.g. with the gas-supply packages 15, 2, 25 or 26. To protect the vacuum pump, only cold stage evacuation is allowed. The pump can then remain switched during the running program. The maximum ultimate pressure in the working tube depends on the type of pump.

- Single-stage rotary vane pump for an achievable ultimate pressure of approx. 20 mbar
- Two-stage rotary vane pump for an achievable ultimate pressure of approx. $5 \times 10^{-2}$ mbar
- Turbomolecular pump system, consisting of a diaphragm pump with downstream turbomolecular pump for an achievable ultimate pressure of up to approx. $5 \times 10^{-5}$ mbar (not for models RSRB and RSRC and not in combination with gas supply package 15)
Controls for Tube Furnaces

Furnace Chamber and Charge Controls

With the furnace chamber control, the temperature is only measured in the furnace chamber outside the working tube. This protects the thermocouples from damage and aggressive batch. The control is slow to avoid overshoots. Since the temperature inside the working tube is not measured in this mode, a significant temperature difference can occur between the batch temperature inside the tube and the furnace chamber temperature displayed in the controller.

With an additional charge thermocouple, the "charge control" mode can measure the temperature in the furnace as well as the temperature inside the working tube. This enables the batch temperature to be controlled very precisely and quickly. Charge control can be used with all tube furnaces, with the exception of the RD and RT series.

Three-Zone Furnace Chamber Controls

The heated length is divided into three heating zones. The temperature is measured via one thermocouple per zone, which is positioned outside the working tube between the heating wires. The side zones are controlled via a setpoint offset in relation to the middle zone. In this way, the heat loss at the tube ends can be compensated in order to achieve an extended zone of constant temperature (+/− 5 K).

Freely Radiating Heating Elements

A very good temperature uniformity is achieved with the freely radiating heating elements on support tubes.
Customized Tube Furnaces

With their high level of flexibility and innovation, Nabertherm offers the optimal solution for customer-specific applications. Based on our standard models, we develop individual solutions also for integration in overriding process systems. The solutions shown on this page are just a few examples of delivered furnaces. From processes working under vacuum or protective gas via innovative control and automation technology for a wide selection of temperatures, sizes, lengths and other properties of tube furnace systems – we will find the appropriate solution for a suitable process optimization.

Tube furnace RS 200/4500/08 with lift door for heat treatment of bars

RHTV 120/600/17 H₂ with gas supply system 4 for flammable gases, swiveling hook for hanging the batch and safety door in front of the lower flange

Hinged flange

RSH 320/2000/09 H₂ with three-zone control for heat treatment of precious metals

RS 120/1000/115 with bogie for different inclination angles
Dual shell housing made of textured stainless steel sheets with additional fan cooling for low surface temperature

Solid state relays provide for low noise operation

Only fiber materials are used which are not classified as carcinogenic according to TRGS 905, class 1 or 2

NTLog Basic for Nabertherm controller: recording of process data with USB-flash drive

Defined application within the constraints of the operating instructions

As additional equipment: Process control and documentation via VCD software package for monitoring, documentation and control
<table>
<thead>
<tr>
<th>Furnace Group</th>
<th>Model</th>
<th>Page</th>
</tr>
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<tbody>
<tr>
<td>Fire assay/cupellation furnaces up to 1300 °C</td>
<td>N ../CUP</td>
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<tr>
<td>Gradient or lab strand annealing furnaces up to 1300 °C</td>
<td>GR</td>
<td>68</td>
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<tr>
<td>Fast-firing furnaces up to 1300 °C</td>
<td>LS</td>
<td>69</td>
</tr>
<tr>
<td>Laboratory melting furnaces up to 1400 °C</td>
<td>K, KC</td>
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Cupellation is a process to separate precious metals, such as gold or silver, from alloys with base metals. During the process, aggressive gases that attack the insulation and the heating are released. Cupellation furnaces N ./13 CUP are especially designed for the very demanding process requirements.

The furnace chamber consists of a ceramic muffle, which offers very good protection for the heating elements and insulation against the vapors. A special fresh-air and exhaust air system guides exhaust gases directly into the exhaust hood of the cupellation furnace. At the same time, fresh air is led into the furnace atmosphere. The integrated exhaust hood on top of the furnace and above the door is the interface to the customer’s required exhaust air system. The design is very-maintenance friendly; all wear and tear parts on the furnace, which are f.i. the ceramic muffle and the heating elements, can be replaced easily.

Cupellation furnaces N 4/13 CUP as a tabletop model and N 10/13 CUP are designed especially for cupellation. Due of its high chamber design, model N 30/13 CUP can also be used for crucible melting. Pit-type furnace S 73/HS is especially designed for crucible melting.

<table>
<thead>
<tr>
<th>Fire Assay/Cupellation Furnaces up to 1300 °C</th>
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<tbody>
<tr>
<td>Cupellation furnace N 4/13 CUP as a tabletop model</td>
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<tr>
<td>Cupellation furnace N 10/13 CUP with closing brick and base on castors</td>
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</tbody>
</table>

**Standard Equipment of Cupellation Furnace N 4/13 CUP**
- Compact tabletop model
- Ceramic muffle to protect the heating elements and insulation
- Furnace chamber is heated from three sides (floor and sides) with heating elements on support tubes
- Extraction system with integrated exhaust hood on top of the furnace and above the door to connect to the customer’s exhaust air system
- Manual lift door

**Additional Equipment for Cupellation Furnace N 4/13 CUP**
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and charge

**Standard Equipment of Cupellation Furnaces N 10/13 CUP and N 30/13 CUP**
- Ceramic muffle to protect the heating elements and insulation
- Furnace chamber is heated from 4 sides with heating elements on support tubes
- The heating elements can be easily replaced as one unit
- Furnace chamber ventilated as additional protection for the heating elements
- Precise temperature control with control thermocouple directly in the muffle
- Closing brick for the muffle with handle for N 10/13 CUP
- Electro-mechanic lift door for N 30/13 CUP
- Bench/surface in front of muffle
- Special fresh-air and exhaust air system for the ceramic muffle. Exhaust gases are directly guided into the exhaust hood via a ceramic tube at the back of the muffle. The air exchange rate is adjustable.
- Extraction system with integrated exhaust hood on top of the furnace and above the door to connect to the customer’s exhaust air system
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and charge
<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions in mm</th>
<th>Connected load kW</th>
<th>Electrical connection</th>
<th>Weight in kg</th>
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<tr>
<td>S 73/HS</td>
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<td>1050 1530 900</td>
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</table>

\*External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

\*Please see page 75 for more information about supply voltage

### Additional Equipment for Cupellation Furnaces N 10/13 CUP and N 30/13 CUP
- Electro-mechanic lift door for N 10/13 CUP
- Electric lift door
- Swiveling inspection window as heat protection
- Timer to program switching on and off times (preset temperature)
- Base mounted on castors

### Standard Equipment of Pit-Type Furnace S 73/HS
- Compact pit-type furnace for crucible melting
- Split lid, opened manually by swiveling
- Heating from four sides
- Heating elements and floor protected against friction and aggressive substances with silicon carbide tiles
- Furnace chamber ventilated as additional protection for the heating elements
- Exhaust air box with insulated tube to the rear. Facilities for connection to customer’s necessary extraction system.

### Additional Equipment for Pit-Type Furnace S 73/HS
- Manual rolling lid
- Pneumatic rolling lid
- Over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and charge
- Timer to program switching on and off times (preset temperature)
Gradient or Lab Strand Annealing Furnaces up to 1300 °C

The furnace chamber of the gradient furnace GR 1300/13 is divided in six control zones of equal length. The temperature in each of the six heating zones is separately controlled. The gradient furnace is usually charged from the side through the parallel swivel door. A maximum temperature gradient of 400 °C can then be stabilized over the heated length of 1300 mm. On request the furnace also is designed as a lab strand annealing furnace with a second door on the opposite side. If the included fiber separator are used charging is carried-out from the top.

### Standard Equipment
- Tmax 1300 °C
- Heated length: 1300 mm
- Heating elements on support tubes providing for free heat radiation in the kiln chamber
- Charging from the top or through the right side door
- Gas damper suspension of the lid
- Separate control of heating zones (each 160 mm long)
- Temperature gradient of 400 °C over the entire length of the kiln chamber, each zone can individually be controlled
- Fiber separators dividing the chamber in six equally sized chambers
- Controller H1700, alternative controllers see page 75

### Additional Equipment
- Up to ten control zones
- Second parallel swing door for use as lab strand annealing furnace
- Vertical instead of horizontal strand furnace
- 1400 °C model

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax °C</th>
<th>Inner dimensions in mm</th>
<th>Outer dimensions1 in mm</th>
<th>Connected load kW</th>
<th>Electrical connection*</th>
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1*External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

*Please see page 75 for more information about supply voltage.
Fast-Firing Furnaces up to 1300 °C

These fast-firing furnaces are ideal for simulation of typical fast-firing processes up to a maximum firing temperature of 1300 °C. The combination of high performance, low thermal mass and powerful cooling fans provides for cycle times from cold to cold up to 35 minutes with an opening temperature of approx. 300 °C.

### Standard Equipment

- Tmax 1300 °C
- Ceramic grid tubes as charge support
- Floor and lid heating, two-zone control
- Special arrangement of the heating elements for optimum temperature uniformity
- Rapid switching cycles result in precise temperature control
- Integrated cooling fans, programmable to speed up charge cooling including housing cooling
- Programmable lid opening of approximately 60 mm for faster cooling without activating the fan
- Thermocouple type S for top and bottom zone
- Castors for easy furnace moving
- Controller P470 (50 programs with each 40 segments), alternative controllers see page 75

### Model Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax °C</th>
<th>Inner dimensions in mm</th>
<th>Volume in l</th>
<th>Outer dimensions² in mm</th>
<th>Connected load kW</th>
<th>Electrical connection*</th>
<th>Weight in kg</th>
</tr>
</thead>
</table>

¹Heating only between two phases
²External dimensions vary when furnace is equipped with additional equipment. Dimensions on request.

*Please see page 75 for more information about supply voltage.
Laboratory Melting Furnaces up to 1400 °C

These compact melting furnaces for the melting of non-ferrous metals and alloys are one of a kind and have a number of technical advantages. Designed as tabletop models, they can be used for many laboratory applications. The practical counter balanced hinge with shock absorbers and the spout (not for KC 4/14) on the front of the furnace make exact dosing easy when pouring the melt. The melting furnaces are available for furnace chamber temperatures of 1000 °C, 1300 °C, or 1400 °C.

Standard Equipment

- Tmax 1000 °C, 1300 °C, or 1400 °C
- Crucible sizes of 0.75, 1.5 or 3 liters
- Crucible with integrated pouring spout of clay-graphite included with delivery
- Additional spout (not for KC 4/14), mounted at the furnace for exact pouring
- Compact bench-top design, simple emptying of crucible by tilting system with gas damper
- Crucible for heating up of melting furnace insulated with a hinged lid, lid opened when pouring
- Controller R7 (resp. 3508 for KC), alternative controllers see page 75

Additional Equipment

- Other crucible types available, e.g. steel
- Design as bale-out furnace without tilting device, e.g. for lead melting
- Over-temperature limiter for the furnace chamber with automatic reset to protect against overtemperature. The limit controller switches off the heating when the pre-set limit temperature has been reached and does not switch it on again until the temperature falls below the setting again.
- Observation hole for melt

### Model Specifications

<table>
<thead>
<tr>
<th>Model</th>
<th>Tmax furnace °C</th>
<th>Tmax melt bath °C</th>
<th>Crucible</th>
<th>Volume in l</th>
<th>Outer dimensions (W x D x H) in mm</th>
<th>Connected load kW</th>
<th>Weight in kg</th>
</tr>
</thead>
<tbody>
<tr>
<td>K 1/10</td>
<td>1000</td>
<td>850</td>
<td>A6</td>
<td>0.75</td>
<td>600 x 710 x 670</td>
<td>3.0</td>
<td>85</td>
</tr>
<tr>
<td>K 2/10</td>
<td>1000</td>
<td>850</td>
<td>A10</td>
<td>1.50</td>
<td>600 x 710 x 670</td>
<td>3.0</td>
<td>90</td>
</tr>
<tr>
<td>K 4/10</td>
<td>1000</td>
<td>850</td>
<td>A25</td>
<td>3.00</td>
<td>670 x 800 x 710</td>
<td>3.5</td>
<td>110</td>
</tr>
<tr>
<td>K 1/13³</td>
<td>1300</td>
<td>1150</td>
<td>A6</td>
<td>0.75</td>
<td>600 x 710 x 670</td>
<td>3.0</td>
<td>85</td>
</tr>
<tr>
<td>K 2/13³</td>
<td>1300</td>
<td>1150</td>
<td>A10</td>
<td>1.50</td>
<td>600 x 710 x 670</td>
<td>3.0</td>
<td>90</td>
</tr>
<tr>
<td>K 4/13³</td>
<td>1300</td>
<td>1150</td>
<td>A25</td>
<td>3.00</td>
<td>670 x 800 x 710</td>
<td>5.5</td>
<td>110</td>
</tr>
<tr>
<td>KC 1/14⁴</td>
<td>1400</td>
<td>1250</td>
<td>A6</td>
<td>0.75</td>
<td>570 x 630 x 580</td>
<td>11.0</td>
<td>90</td>
</tr>
<tr>
<td>KC 2/14⁴</td>
<td>1400</td>
<td>1250</td>
<td>A10</td>
<td>1.50</td>
<td>570 x 630 x 580</td>
<td>11.0</td>
<td>95</td>
</tr>
<tr>
<td>KC 4/14⁴</td>
<td>1400</td>
<td>1250</td>
<td>A25</td>
<td>3.00</td>
<td>670 x 870 x 590</td>
<td>22.0</td>
<td>110</td>
</tr>
</tbody>
</table>

³Outer dimensions of furnace, transformer in separate housing (500 x 570 x 300 mm)
⁴Switchgear and controller mounted in a floor standing cabinet

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Temperature Uniformity and System Accuracy

Temperature uniformity is defined as the maximum temperature deviation in the work space of the furnace. There is a general difference between the furnace chamber and the work space. The furnace chamber is the total volume available in the furnace. The work space is smaller than the furnace chamber and describes the volume which can be used for charging.

**Specification of Temperature Uniformity in +/- K in the Standard Furnace**

In the standard design the temperature uniformity is specified in +/- K at a defined set-temperature with the work space of the empty furnace during the dwell time. In order to make a temperature uniformity survey the furnace should be calibrated accordingly. As standard our furnaces are not calibrated upon delivery.

**Calibration of the Temperature Uniformity in +/- K**

If an absolute temperature uniformity at a reference temperature or at a defined reference temperature range is required, the furnace must be calibrated appropriately. If, for example, a temperature uniformity of +/- 5 K at a set temperature of 750 °C is required, it means that measured temperatures may range from a minimum of 745 °C to a maximum of 755 °C in the empty work space.

**System Accuracy**

Tolerances may occur not only in the work space, they also exist with respect to the thermocouple and in the controls. If an absolute temperature uniformity in +/- K at a defined set temperature or within a defined reference working temperature range is required, the following measures have to be taken:

- Measurement of total temperature deviation of the measurement line from the controls to the thermocouple
- Measurement of temperature uniformity within the work space at the reference temperature or within the reference temperature range
- If necessary, an offset is set at the controls to adjust the displayed temperature at the controller to the real temperature in the furnace
- Documentation of the measurement results in a protocol

**Temperature Uniformity in the Work Space incl. Protocol**

In standard furnaces, temperature uniformity is guaranteed as +/- K without measurement of temperature uniformity. However, as an additional feature, a temperature uniformity measurement at a target temperature in the work space compliant with DIN 17052-1 can be ordered. Depending on the furnace model, a holding frame which is equivalent in size to the work space is inserted into the furnace. This frame holds thermocouples at up to 11 defined measurement positions. The measurement of the temperature uniformity is performed at a target temperature specified by the customer after a static condition has been reached. If necessary, different target temperatures or a defined target working temperature range can also be calibrated.
Process Control and Documentation
<table>
<thead>
<tr>
<th>Topic</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard controllers, HiProSystems control and documentation</td>
<td>74</td>
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<tr>
<td>Assignment of standard controllers to furnace families</td>
<td>75</td>
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<tr>
<td>Functionality of the standard controllers</td>
<td>75</td>
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<td>Data storing and visualization</td>
<td>76</td>
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<tr>
<td>VCD-software</td>
<td>77</td>
</tr>
</tbody>
</table>
Process Control and Documentation

Nabertherm has many years of experience in the design and construction of both standard and custom control alternatives. All controls are remarkable for their ease of use and even in the basic version have a wide variety of functions.

Standard Controllers

Our extensive line of standard controllers satisfies most customer requirements. D60 Based on the specific furnace model, the controller regulates the furnace temperature reliably and is equipped with an integrated USB-interface for documentation of process data (NTLog/NTGraph).

The standard controllers are developed and fabricated within the Nabertherm group. When developing controllers, our focus is on ease of use. The user can choose between 23 languages. From a technical standpoint, these devices are custom-fit for each furnace model or the associated application. From the simple controller with an adjustable temperature to the control unit with freely configurable control parameters, stored programs and PID microprocessor control with self-diagnosis system, we have a solution to meet your requirements.

Optionally available: Communication module with Ethernet connection for Series 400 controllers with the following functions: Connection to higher-level systems with setpoint setting and display via a web server.

HiProSystems Control and Documentation

This professional process control with PLC controls for single and multi-zone furnaces is based on Siemens hardware and can be adapted and upgraded extensively. HiProSystems control is used when process-dependent functions, such as exhaust air flaps, cooling fans, automatic movements, etc., have to be handled during a cycle, when furnaces with more than one zone have to be controlled, when special documentation of each batch is required and when remote service is required. It is flexible and is easily tailored to your process or documentation needs.

Alternative User Interfaces for HiProSystems

Process control H500/H700

This basic panel accommodates most basic needs and is very easy to use. Firing cycle data and the extra functions activated are clearly displayed in a table. Messages appear as text. Data can be stored on a USB stick using the „NTLog Comfort“ option (not available for all H700).

Process control H1700

Customized versions can be realized in addition to the scope of services of the H500/H700. Display of basic data as online trend.

Process control H3700

Display of functions on a large 12'' display. Display of basic data as online trend or as a graphical system overview. Scope as H1700.

For more information on operating of the Nabertherm controllers, here are some tutorials:
Mains Voltages for Nabertherm Furnaces

1-phase: all furnaces are available for mains voltages from 110 V - 240 V at 50 or 60 Hz.

3-phase: all furnaces are available for mains voltages from 200 V - 240 V or 380 V - 480 V, at 50 or 60 Hz.

The connecting rates in the catalog refer to the standard furnace with 400 V (3/N/PE) respectively 230 V (1/N/PE).
Temperature Recorder

Besides the documentation via the software which is connected to the controls, Nabertherm offers different temperature recorders which can be used with respect to the application.

<table>
<thead>
<tr>
<th></th>
<th>Model 6100e</th>
<th>Model 6100a</th>
<th>Model 6180a</th>
</tr>
</thead>
<tbody>
<tr>
<td>Data input using touch panel</td>
<td>x</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>Size of colour display in inch</td>
<td>5.5&quot;</td>
<td>5.5&quot;</td>
<td>12.1&quot;</td>
</tr>
<tr>
<td>Number of thermocouple inputs</td>
<td>3</td>
<td>18</td>
<td>48</td>
</tr>
<tr>
<td>Data read-out via USB-stick</td>
<td>x</td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>Input of charge data</td>
<td></td>
<td></td>
<td>x</td>
</tr>
<tr>
<td>Evaluation software included</td>
<td></td>
<td>x</td>
<td>x</td>
</tr>
<tr>
<td>Applicable for TUS-measurements acc. to AMS 2750 E</td>
<td>x</td>
<td>x</td>
<td>x</td>
</tr>
</tbody>
</table>

Data Storing of Nabertherm Controllers with NTLog Basic

NTLog Basic allows for recording of process data of the connected Nabertherm Controller (B400, B410, C440, C450, P470, P480) on a USB stick.

The process documentation with NTLog Basic requires no additional thermocouples or sensors. Only data recorded which are available in the controller. The data stored on the USB stick (up to 80,000 data records, format CSV) can afterwards be evaluated on the PC either via NTGraph or a spreadsheet software used by the customer (e.g. MS Excel).

For protection against accidental data manipulation the generated data records contain checksums.

Data Storing of HiProSystems with NTLog Comfort

The extension module NTLog Comfort offers the same functionality of NTLog Basic module. Process data from a HiProSytems control are read out and stored in real time on a USB stick (not available for all H700 systems). The extension module NTLog Comfort can also be connected using an Ethernet connection to a computer in the same local network so that data can be written directly onto this computer.

Visualization with NTGraph for Single-Zone Controlled Furnaces

The process data from NTLog can be visualized either using the customer’s own spreadsheet program (e.g. MS-Excel) or NTGraph (Freeware). With NTGraph Nabertherm provides for an additional user-friendly tool free of charge for the visualization of the data generated by NTLog. Prerequisite for its use is the installation of the program MS-Excel for Windows (from version 2003). After data import presentation as diagram, table or report can be chosen. The design (color, scaling, reference labels) can be adapted by using prepared sets. NTGraph is available in seven languages (DE/EN/FR/ES/IT/CN/RU). In addition, selected texts can be generated in other languages.

Software NTEdit for Entering Programs on the PC

By using the software NTEdit (Freeware) the input of the programs becomes clearer and thus easier. The program can be entered on customers PC and then be imported into the controller (B400, B410, C440, C450, P470, P480) with a USB stick. The display of the set curve is tabular or graphical. The program import in NTEdit is also possible. With NTEdit Nabertherm provides a user-friendly free tool. A prerequisite for the use is the client installation of MS-Excel for Windows (from version 2007). NTEdit is available in eight languages (DE/EN/FR/ES/IT/CN/RU/PT).
Documentation and reproducibility are more and more important for quality assurance. The powerful VCD software represents an optimal solution for single multi furnace systems as well as charg documentation on the basis of Nabertherm controllers.

The VCD software is used to record process data from the controllers B400/B410, C440/C450 and P470/P480. Up to 400 different heat treatment programs can be stored. The controllers are started and stopped via the software at a PC. The process is documented and archived accordingly. The data display can be carried-out in a diagram or as data table. Even a transfer of process data to MS Excel (.csv format *) or the generation of reports in PDF format is possible.

Features
- Available for controllers B400/B410/C440/C450/P470/P480
- Suitable for operating system Microsoft Windows 10 (32/64 Bit)
- Simple installation
- Setting, Archiving and print of programs and graphics
- Operation of controllers via PC
- Archiving of process curves from up to 16 furnaces (also multi-zone controlled)
- Redundant saving of archives on a server drive
- Higher security level due to binary data storage
- Free input of charge date with comfortable search function
- Possibility to evaluate data, files can be converted to Excel
- Generation of a PDF-report
- 17 languages selectable

Extension Package 1 for Display of an Additional Temperature Measuring Point, Independant of the Furnace Controls
- Connection of an independant thermocouple, type S, N or K with temperature display on controller C6D, e.g. for documentation of charge temperature
- Conversion and transmission of measured values to the VCD software
- For data evaluation, please see VCD-software features
- Display of measured temperature directly on the extension package

Extension Package 2 for the Connection of up to Three, Six or Nine Measuring Point, Independant of the Furnace Controls
- Connection of three thermocouples, type K, S, N or B to the included connecting box
- Possible extension of up to two or three connecting boxes with up to nine measuring points
- Conversion and transmission of measured values to the VCD software
- Data evaluation, see VCD features
Spare Parts and Customer Service — Our Service Makes the Difference

For many years the name Nabertherm has been standing for top quality and durability in furnace manufacturing. To secure this position for the future as well, Nabertherm offers not only a first-class spare parts service, but also excellent customer service for our customers. Benefit from more than 70 years of experience in furnace construction.

In addition to our highly qualified service technicians on site, our service specialists in Lilienthal are also available to answer your questions about your furnace. We take care of your service needs to keep your furnace always up and running. In addition to spare parts and repairs, maintenance and safety checks as well as temperature uniformity measurements are part of our service portfolio. Our range of services also includes the modernization of older furnace systems or new linings.

The needs of our customers always have highest priority!

- Very fast spare parts supply, many standard spare parts in stock
- Worldwide customer service on site with its own service points in the largest markets
- International service network with long-term partners
- Highly qualified customer service team for quick and reliable repair of your furnace
- Commissioning of complex furnace systems
- Customer training in function and operation of the system
- Temperature uniformity measurements, also according to standards like AMS 2750 E (NADCAP)
- Competent service team for fast help on the phone
- Safe teleservice for systems with PLC controls via modem, ISDN or a secured VPN line
- Preventive maintenance to ensure that your furnace is ready for use
- Modernization or relining of older furnace systems

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Please visit our website [www.nabertherm.com](http://www.nabertherm.com) and find out all you want to know about us - and especially about our products.

In addition to current information and exhibition dates, there is of course the possibility of direct contact or an authorized dealer from our worldwide dealer network.

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- Fiber Optics/Glass
- Foundry
- Laboratory
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