

Dewaxing Furnaces Electrically Heated



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

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

- Tmax 850 °C
- Chamber furnace with wide-opening swinging door
- Four side heating with freely radiating heating elements on ceramic carrier tubes

N 300/WAX



Grid bottom



Drain pan in floor



Drawer for collection of liquid wax

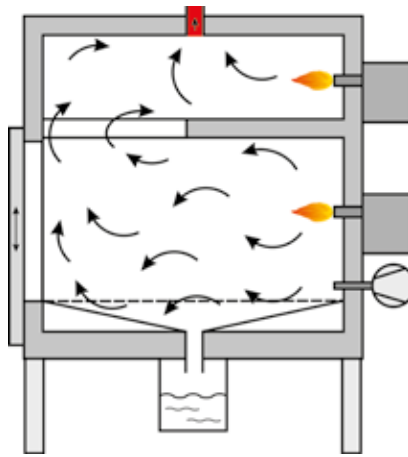
- Heated drainage in floor, controlled by a separate controller up to a maximum of 200 °C, to reliably prevent freezing of the draining wax - Release of furnace heating only possible after drain temperature is reached, to prevent clogging
- Stainless steel floor pan with grid bottom for level loading
- Rugged self-supporting, vaulted arch construction
- Exhaust gas vent in furnace ceiling for connection with ductwork
- Air inlet openings for reliable air exchange
- Dual shell furnace housing for low exterior temperatures
- Removable base included in delivery (fixed base for models N 440 and larger)
- First over-temperature limiter which must be set below the ignition point of the wax and prevents the wax from igniting during dewaxing. It is customers responsibility to set the required time interval for dewaxing. After this time has elapsed the over-temperature limiter will be deactivated to make sure that the furnace can continue with the sintering process.
- Second over-temperature limiter with adjustable cutout temperature for thermal protection class 2 in accordance with EN 60519-2 as temperature limiter to protect the furnace and load
- Defined application within the constraints of the operating instructions
- NTLog Basic for Nabertherm Controller: Recording of process data with USB-flash drive
- Controls description see page 76

Model	Tmax °C	Inner dimensions in mm			Volume in l	Outer dimensions in mm			Max. drain- off volume in l	Heating power in kW ¹	Electrical connection*	Weight in kg
		w	d	h		W	D	H				
N 100/WAX	850	400	530	460	100	720	1130	1440	5	7.5	3-phase	340
N 150/WAX	850	450	530	590	150	770	1130	1570	8	9.5	3-phase	360
N 200/WAX	850	500	530	720	200	820	1130	1700	10	11.5	3-phase	440
N 300/WAX	850	550	700	780	300	870	1300	1760	15	15.5	3-phase	480
N 440/WAX	850	600	750	1000	450	1020	1460	1875	17	20.5	3-phase	885
N 660/WAX	850	700	850	1100	650	1120	1560	1975	20	26.5	3-phase	1000
N 1000/WAX	850	800	1000	1250	1000	1580	1800	2400	25	40.5	3-phase	1870
N 1500/WAX	850	900	1200	1400	1500	1680	2000	2550	35	57.5	3-phase	2570
N 2200/WAX	850	1000	1400	1600	2200	1780	2200	2750	50	75.5	3-phase	3170

¹Depending on furnace design connected load might be higher

*Please see page 77 for more information about supply voltage

Dewaxing Furnaces Gas-Fired



NB 300/BOWAX with Gas-Fired

The chamber furnace of NB .. BOWAX series is suitable for Flash Fire processes in which the hot furnace is charged with rapping castings.

For a quick loading and unloading, the furnace is equipped with a pneumatic lift door, which is controlled via a footswitch.

After charging, the wax liquefies in short time. The first part of the wax flows-out through the integrated pan directly into a catch basin under the furnace and is collected safely in a water tank.

The remainder of the wax evaporates in the furnace chamber and is burned safely in the downstream thermal afterburning. The resulting exhaust air is conducted via an exhaust chimney and a secondary customer side piping out of the hall.

In the event of a flame failure of the burner or gas shortage takes place a process termination.

- Tmax 1000 °C
- Standard size with 300 l furnace volume, other sizes on request
- Fully automatic temperature control
- Integrated thermal afterburner incl. Exhaust hood (250 mm)
- Gas burner for operation with natural or LPG gas with permanent monitoring via a PLC
- Multilayer insulation with light-weight refractory bricks and special backing insulation
- Pneumatic lift-door with foot-switch and electromagnetic locking
- Withdrawable wax collecting pan under the furnace
- Optical indication when charging temperature has been reached
- Detailed description of safety functions see page 11
- Defined application within the constraints of the operating instructions
- Controls description see page 80



NB 300/BOWAX



NB 300/BOWAX

Model	Tmax °C	Inner dimensions in mm			Volume in l	Outer dimensions in mm			Max. drain- off volume in l	Heating power in kW ¹	Electrical connection*
		w	d	h		W	D	H			
NB 300/BOWAX	1000	550	700	780	300	1010	1700	3030	2	100,0	3-phase

¹Depending on furnace design connected load might be higher

*Please see page 77 for more information about supply voltage