

CATALYTIC DEBINDING OVEN FOR BASF POLYACETAL BINDER SYSTEM

CM Furnaces offers a complete line of debinding ovens specifically designed to process components containing BASF polyacetal binder. Whether your requirement is for small research quantities or large scale production, one of the four standard size batch ovens is sure to fit your need. The systems come complete with all temperature, atmosphere and safety controls contained in a common frame.

All stainless steel construction is used for the 100 Series including the inner chamber and removable racks. Inside the chamber is a stainless steel fan for the controlled recirculation that is so critical to the process. The front door is swing away style with

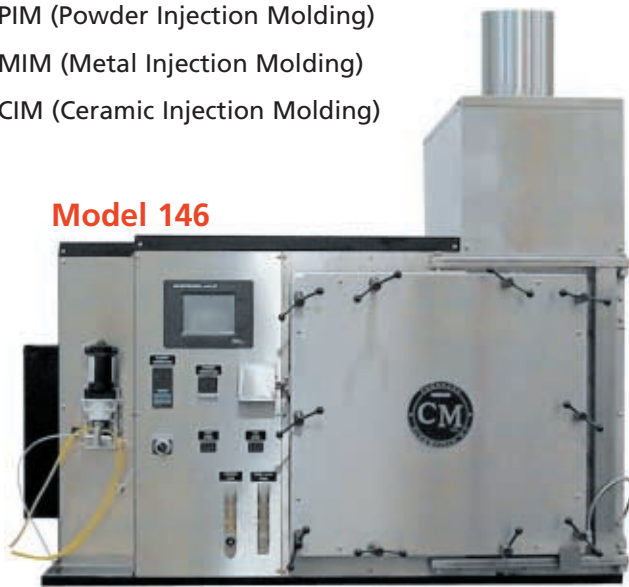
safety interlocking. At the top of the oven is a natural gas burn-off stack with automatic spark ignitors. The system includes nitrogen flow meters for purging and process control, as well as a preheat for the process gas. Complete acid controls for nitric acid are built into the system.

Control of the oven includes an Allen Bradley PLC process controller, programmable microprocessor controller, SCR power controller and a touch screen for operation and diagnostics. Other features include independent overtemperature instrumentation and process timer.

USED FOR THESE AND OTHER APPLICATIONS:

- PIM (Powder Injection Molding)
- MIM (Metal Injection Molding)
- CIM (Ceramic Injection Molding)

Model 146



FULL SYSTEM INCLUDES:

- Total system packaged in common, compact frame
- Stainless Steel Construction
- Multiple Removable Racks
- PLC Process Controller
- Digital Temperature Indicator
- Independent Overtemperature Control
- Adjustable Process Timer
- Nitrogen Flow Meter and Preheater
- Nitric / Oxalic Acid Pump with Controller
- Ceramic Drip Dish with Heater
- Guaranteed Purges
- Recirculating Fan
- Natural Gas Burn-off Stack
- Spark Ignitor System
- Safety Door Interlock
- Diagnostic Touch Screen

MODEL	120	125	146	1100
Maximum Operating Temperature	175°C (350°F)	175°C (350°F)	175°C (350°F)	175°C (350°F)
Chamber Dimensions W x H x D	15" x 11.5" x 10"	20" x 18" x 15"	20" x 20" x 20"	26" x 26" x 26"
Number of Racks	5	8	6	8
Outside Dimensions W x H x D	47" x 51" x 36"	60" x 70" x 46"	47" x 110" x 53"	53" x 117" x 61"
Power Requirement (Max) KVA	6.5	9	9	10
Standard Voltage Requirement	208/240 1-Phase	208/240 1-Phase	230 3-Phase	230 3-Phase
Service Entrance Current Requirement at 208	35	50	50	50