

<b>Manufacturer</b>	Ipsen	
<b>Model No</b>	VTC 424	
<b>Serial No</b>		
<b>Year</b>	1985 (new vessel 2000)	
<b>1. Space required</b>		
Width	6	m
Height	4	m
Depth	8	m
<b>2. Working space</b>		
Width	610	mm
Height	500	mm
Depth	910	mm
<b>3. Temperature</b>		
Maximum temperature	1250	°C
Temperature uniformity	+ / - 10	°C
Vacuum 600°C to 1200°C	+ / - 10	°C
<b>4. Charge</b>		
Max gross weight	600	kg
<b>5. Energy</b>		
Rating of heating	132	kw
Connected load	154	kva
Rated voltage (3 phase 50hz)	415	V
<b>6. Vacuum</b>		
Ultimate vacuum	10 <sup>-2</sup>	mbar
Operating vacuum	10 <sup>-2</sup>	mbar
Partial pressure nitrogen / argon	0.1 to 10	mbar
<b>7. Pumping group</b>		
Mechanical pump	Edwards	
Model No	EH1200	
Capacity	1420	l/min
Power	5.5	kw
Booster pump	Edwards	
Model No	DP180	
Capacity	3300	l/min
Power	7.5	kw
<b>8. Gas</b>		
Nitrogen / Argon	Nitrogen	
Quenching gas pressure	5	bar
Gas consumption at max pressure	8	Nm <sup>3</sup> /cycle
Internal / external fan	Internal	
Power	132	Kw
<b>9. Cycle features</b>		

Pumping time to 10 <sup>-2</sup> mbar range	<30	Min
Cooling time from 1200°C – 200°C	<10	Min
Heating time from 100°C – 1200°C	<40	Min
<b>10. Control system</b>		
Controller	Eurotherm	
PLC	NA	
Temperature / vacuum recorder	Honeywell	
Over temperature controller	Ipsen	
Pirani vacuum controller	Alcatel	
Control thermocouples	Type N	
Overtemperature thermocouple	Type N	
Load thermocouples	Type K	
<b>11. Water</b>		
Min / Max water pressure	3.5	bar
Furnace water flow	10	m <sup>3</sup> /h
Quench water flow	40	m <sup>3</sup> /h
<b>12. Hot zone</b>		
Insulation	Graphite	
Heating element type	Graphite	
<b>13. Plant gross weight</b>		
Gross weight	12	T