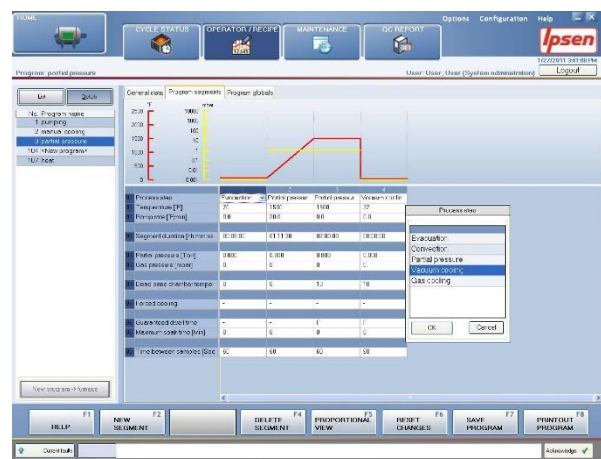
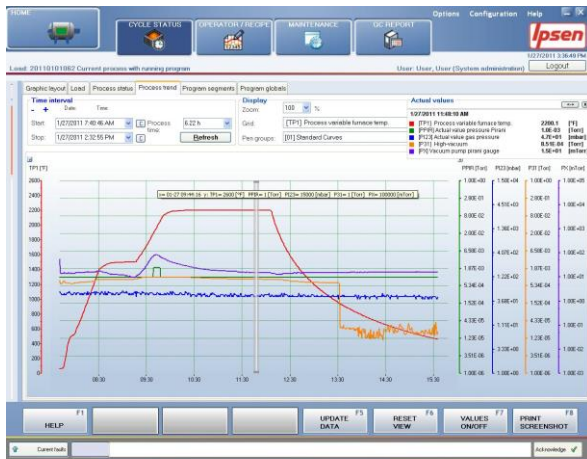


REFURBISHED TOP LOADING VACUUM FURNACE

MODEL No. IPSEN VVFC 40x67 (hv)



ALITY
FROM EXPERIENCE



Agents for:



Unit 30 Park Rose Ind Est, Middlemore Road, West Bromwich, B66 2DZ
 Tel: 0121 544 4385 Fax: 0121 544 3874
 www.vacat.co.uk

VAS Group of companies:



TECHNICAL DATA

DIMENSIONS

Floor space required

Width 6 m
Height 4.0 m
Depth 6.0 m

Plant gross weight 20,000 kgs

Work zone

Diameter 1050 mm
Depth 1700 mm

Max gross charge 2000 kg

TEMPERATURE

Max. Temperature 1300 °C

Vacuum 600°C to 1200°C ±5 °C

ENERGY

Rating of heating 225Kw

Connected load 360Kva

Rated voltage (3 phase – 50Hz) 400 V

VACUUM

Ultimate vacuum (conditioned furnace) 1.0×10^{-5} mbar

Operating vacuum 5.0×10^{-5} mbar

Partial Pressure Nitrogen/Argon 0.1 to 10 mbar

Leak rate mbar/sec 5×10^{-2} mbar l / sec or < 4 microns

PUMPING GROUP

MECHANICAL PUMP –

Model No. – Leybold SV300

Capacity 300m³/h

BOOSTER PUMP –

Model No. – Leybold WAU 1000

Capacity 1000 m³/h

DIFFUSION PUMP –

Model – Leybold DIP 20,000

Capacity 20,000 l/sec

HOLDING PUMP –

Model – Leybold DB 8B

Capacity 8 m³/h

COOLING FAN

Rated power

18.5 / 55 Kw

INERT GAS

Nitrogen quenching gas max pressure

1 bar abs

Gas consumption at max pressure

12m³

Quenching gas purity

99,999 %

CYCLE FEATURES – CONDITIONED, EMPTY FURNACE

Pumping time to 10⁻² mbar range

< 20 min

Cooling time of furnace
from 800°C to 150°C

< 15 min

Heating time of the hot zone
from 150°C. to 1300°C.

< 60 min

CONTROL SYSTEM

Controller	Ipsen Vacuprof
PLC	Siemens S7
Temperature/Vacuum Recorder	Ipsen Vacuprof
Over temperature safety controller	Eurotherm
Pirani Vacuum Gauge	Edwards
Penning Vacuum Gauge	Edwards
Thermocouples (Control O/Temp)	Type 'S'
Load thermocouples (12 off)	Type 'S'

WATER (To be confirmed)

Min/Max pressure cooling water	3.5 bar abs
Water consumption during cooling	20 m3/h
Average consumption cooling water	7.5 m3/h
Water inlet max. Temp.	25 °C

GRAPHITE HOT ZONE

Insulation	Graphite
Heating Elements	Graphite

The work cycle of the Model No. Ipsen VVFC40x 67 (hv) is completely automatic.

Gas fan cooling is included @ 1 bar abs

Gas Quenching is included:-

- Cooling bottom through to top

The gas pressure flowing through the gas quench system is operated at up to 1 bar abs

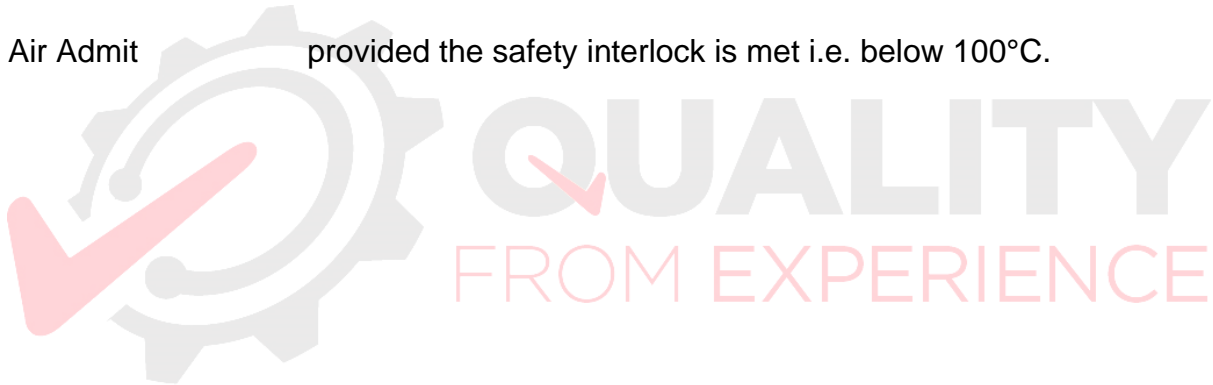
The following items are switched from the control panel.

Pumping booster pump introduced at pre-set vacuum levels.

Heating can be activated automatically provided the pre-set vacuum levels are achieved and water is available.

Cooling under vacuum, static or gas fan quench.

Air Admit provided the safety interlock is met i.e. below 100°C.



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PROPOSAL

PRICE SCHEDULE

One (1) Vacuum Heat Treatment & Brazing Furnace Model No. Ipsen VVFC40x67 (hv) as generally as described within the attached technical summary.

The following is included

- Furnace as described in technical specification

Price: POA

(This offer is made Subject to Prior Sale)

Delivery, installation, commissioning and training will be quoted separately

DELIVERY:

To be determined at time of order

WARRANTY:

The Seller will offer a warranty period of 3 months, effective from the date of acceptance or 1 month after delivery, whichever is the sooner. Wearing parts, consumables and operator damage are excluded. Warranty conditions apply. The Seller does not accept any liability for consequential damages and losses. Full terms and conditions available upon request

TERMS OF PAYMENT:

60% with order

30% on delivery

10% on formal acceptance at the customers works or 30 days from delivery whichever is the soonest.

TAXES:

The aforementioned quotation is exclusive of VAT or any other taxes / import duties that may apply.