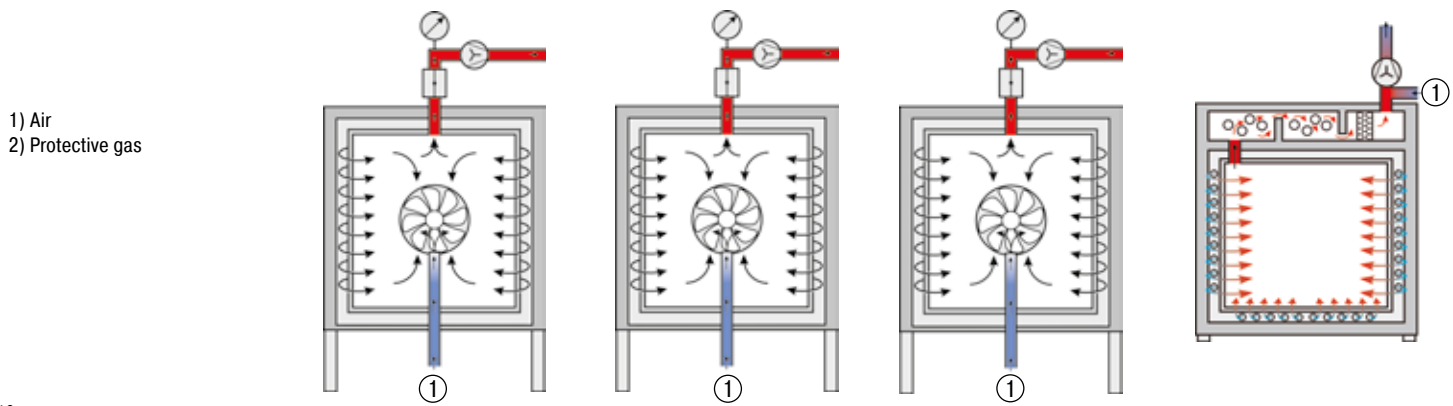


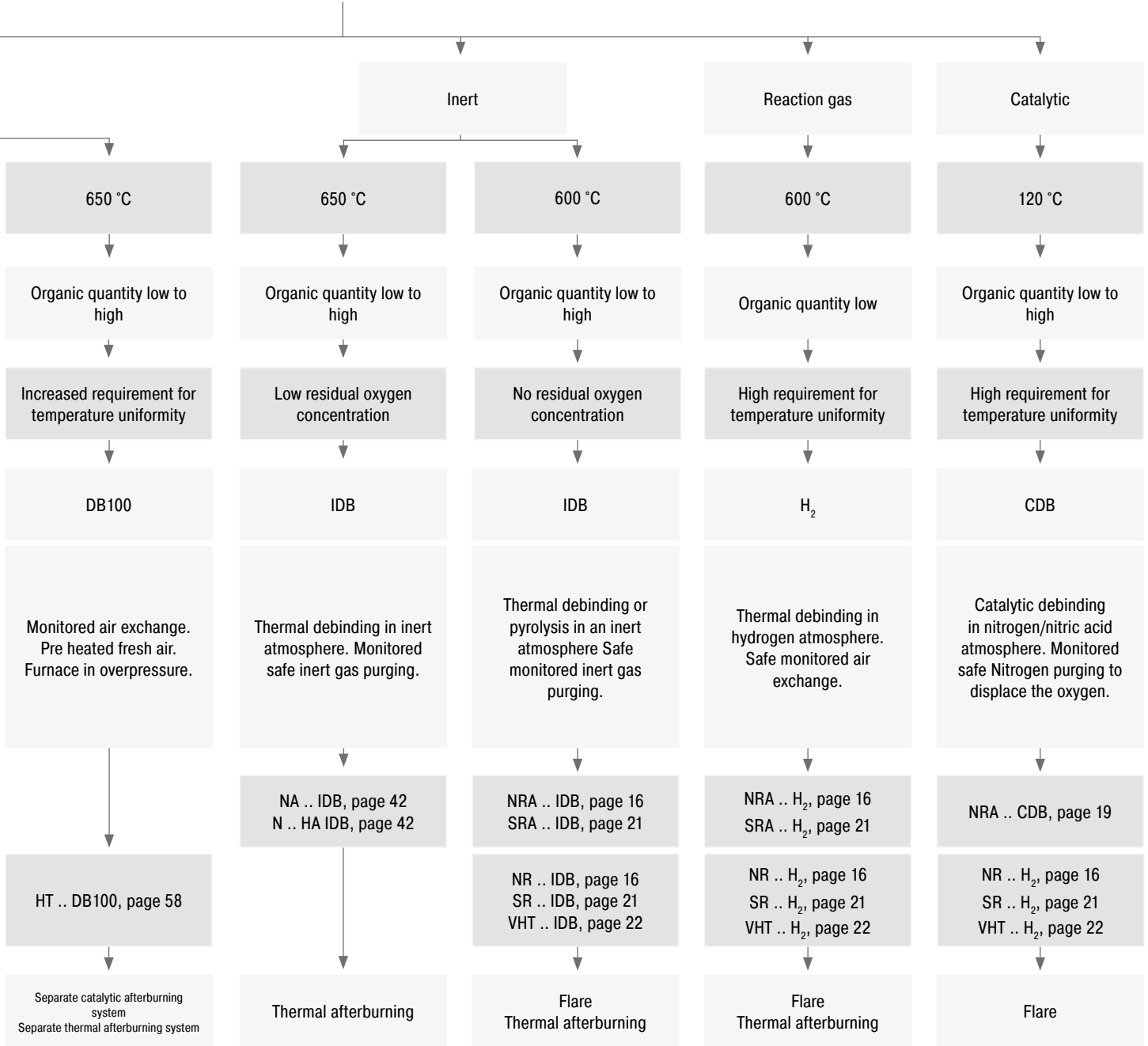
Concepts for Drying, Debinding and Sintering of Parts with Binder Content

Process	Drying Solvents			
Atmosphere	Air		Air	
Maximum Temperature for Debinding	300 °C	450 °C	450 °C	600 °C
Organic Quantity	Organic quantity low	Organic quantity low	Organic quantity low	Organic quantity medium
Requirement	Low requirement for temperature uniformity	Increased requirement for temperature uniformity	Increased requirement for temperature uniformity	Low requirement for temperature uniformity
Concept	LS	LS	DB10	BO
	Acc. to EN 1539 Type A. Monitored air exchange. Exhaust gas venting via nozzles in the on-site extraction system.	Acc. to EN 1539 Type A (NFPA 86 Class A). Monitored air exchange. Active venting of the exhaust gas via integrated exhaust gas fan.	Monitored air exchange. Active venting of the exhaust gas via integrated exhaust gas fan. Uncontrolled furnace underpressure.	Debinding process with control difficulties of heating ramp (exothermic reaction).
Furnace Type	KTR, page 62 TR .. LS, page 60		NA .. LS, page 42	
			NA .. 45 DB10, page 42	
				L .. BO, page 56 HT .. DB, page 58
Post-Treatment of Exhaust Gases				Integrated thermal afterburning/catalytic afterburning

Furnace Heating: Electric (top bar), Gas (middle bar)



Debinding



Electric

