

# Which Furnace for Which Process?

The next two double pages give an overview of which furnaces can be used in additive manufacturing for which process. This double page describes furnaces which can be used for processes in which no combustible substances escape.

## Atmosphere

Air

## Maximum Temperature

300 °C

850 °C

1280 °C

## Requirement Oxygen Content

21 %

21 %

21 %

## Vacuum

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## Flammable Process Gas

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## Furnace Type

TR, page 40  
KTR, page 42

NA, page 32

LH, page 46  
NW, page 50  
N, page 52  
KTR, page 42

## Furnace Heating

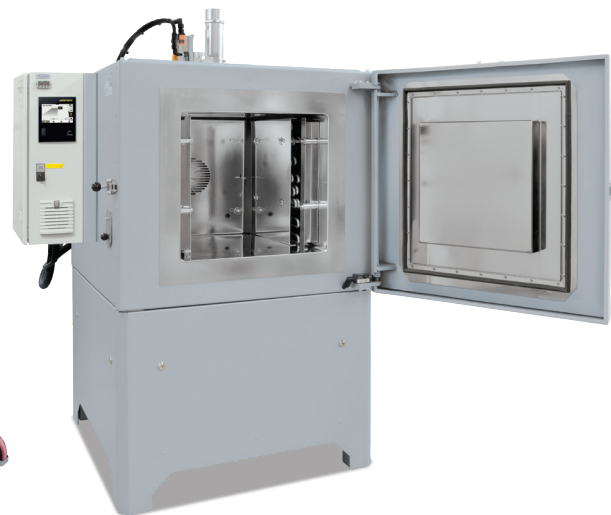
Electric



Chamber oven KTR 2000 for curing after 3D-printing

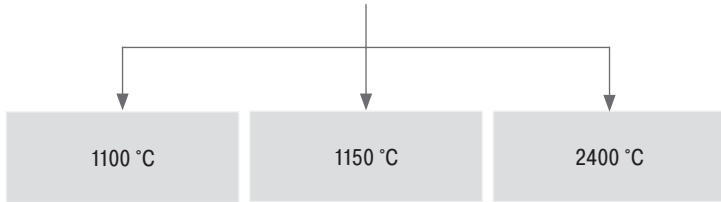


LH 216/12 with controlled cooling, gassing system and charging device



Forced convection chamber furnace NA 250/45 for heat treatment in air

## Process Gas



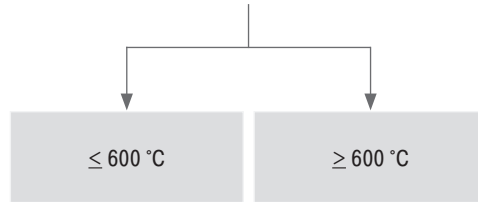
0,01 %	0,00 %	0,00 %
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-	-	$\leq 10^{-5}$ mbar
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-	x	x
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With protective gas box LH, page 46 NW, page 50 N, page 52 NA*, page 32	NR(A), page 18	VHT, page 24
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## Vacuum



0,00 %	0,00 %
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$\leq 10^{-5}$ mbar	$\leq 10^{-5}$ mbar
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x	x
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NR(A), page 18	VHT, page 24
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## Electric



Cold-wall retort furnace VHT 100/12-MO for processes in high vacuum



Semi-automatic annealing plant with retort furnace NR 50/11 and water quenching bath on rails