Aluminum cylinder head
Basketless heat treat furnace
Energy cost slashed! Space-saving, inlining!

■ Specification
Material: cast alloy JIS AC2B, AC4B
Process material: cylinder head
Unit weight: MAX.20kg
Processing throughput: 90/h
Processing capacity: 1800kg/h
Heat source: L.P.G. or L.N.G
Solution furnace: DHF-S type (2 furnaces)
Aging furnace: DHF-A type (1 furnace)
Number of quenching water tanks: 1
Core sand settlement tank, sand elimination conveyor: 1 set
Number of double lift devices: 1
Number of transfer robots: 2

Heat pattern

<table>
<thead>
<tr>
<th>Solution treatment 500±4℃</th>
<th>After-aging treatment 250±3℃</th>
</tr>
</thead>
<tbody>
<tr>
<td>Water quenching 80℃</td>
<td>Normalizing</td>
</tr>
<tr>
<td>Temperature rising 0.8h</td>
<td>Maintain 6.5h</td>
</tr>
<tr>
<td>In-furnace 7.3h</td>
<td>Maintain 3.5h</td>
</tr>
<tr>
<td>In-furnace 4.1h</td>
<td></td>
</tr>
</tbody>
</table>

Features

1) Circulating hot air technology --- Reduction in temperature variation in furnace -> Consistent quality ensured!
2) Saving energy, space --- Running costs slashed (fuel, electricity)!
3) Unmanned autonomous single-item feed --- Labor costs slashed, eliminates need for supplies such as tray, basket, etc.!

Single-item process furnaces for aluminum wheels, suspension parts, pump parts, compressor parts and so on are also available, please contact us.

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