

HARDENING TECHNIQUES/MEASUREMENTS

Bochum	Brackenheim	Chemnitz	Weimar
ANNEALING (VERTICAL - IN PIT FURNACE)			
max. \varnothing 5,000 mm	\varnothing 1,500 x 4,500 mm	\varnothing 2,000 x 4,500 mm	\varnothing 1,500 x 2,000 mm
max. l = 5,000 mm			
ANNEALING (CHAMBER FURNACE)			
1,200 x 900 x 960 mm	1,200 x 900 x 1,200 mm	5,000 x 4,000 x 2,500 mm	1,200 x 900 x 950 mm
INERT GAS HARDENING AND TEMPERING (VERTICAL - IN PIT FURNACE)			
max. \varnothing 5,000 x 5,000 mm	\varnothing 1,500 x 4,500 mm	\varnothing 2,000 x 4,500 mm	\varnothing 1,500 x 2,000 mm
CARBURIZING, HARDENING, QUENCHING, TEMPERING, CARBONITRIDING (VERTICAL - IN PIT FURNACE)			
max. \varnothing 5,000 mm	\varnothing 1,300 x 3,000 mm	\varnothing 780 x 1,500 mm	
max. l = 5,000 mm			
CARBURIZING, HARDENING, QUENCHING, TEMPERING, CARBONITRIDING (CHAMBER FURNACE)			
1,00 x 900 x 960 mm	1,200 x 900 x 1,200 mm	1,200 x 880 x 1,020 mm	1,200 x 900 x 950 mm
		1,200 x 690 x 900 mm	1,100 x 550 x 550 mm
LOW PRESSURE CARBURIZING			
		1,000 x 600 x 700 mm (oil)	
		1,000 x 600 x 650 mm (gas)	
GAS NITRIDING - NITROCARBURIZING (CHAMBER FURNACE)			
1,800 x 1,200 x 1,000 mm	1,800 x 1,200 x 1,000 mm	1,800 x 1,200 x 1,000 mm	1,800 x 1,200 x 1,000 mm
GAS NITRIDING - NITROCARBURIZING (PIT FURNACE)			
\varnothing 2,900 x 5,500 mm	\varnothing 1,500 x 4,500 mm	\varnothing 2,000 x 4,500 mm	\varnothing 1,500 x 2,000 mm
PLASMANITRIDING			
	\varnothing 1,500 x 3,400 mm		
VACUUM HARDENING			
800 x 800 x 1,200 mm	1,300 x 800 x 900 mm	1,800 x 1,000 x 950 (1,150) mm	
Blast Cleaning			
2,500 x 2,500 x 2,500 mm	\varnothing 1,000 x 1,400 mm	\varnothing 1,600 x 2,600 mm	\varnothing 1,200 x 1,500 mm
	\varnothing 4,500 x 10,000 mm (request)	larger dimensions on request	
STRAIGHTENING			
\varnothing 500 x 10,000 mm	\varnothing 150 x 3,000 mm	\varnothing 400 x 4,000 mm	\varnothing 100 x 1,000 mm
			\varnothing 250 x 5,000 mm
BROWNING			
	1,250 x 600 x 430 mm	350 x 550 x 1,750 mm	
	1,250 x 800 x 670 mm		
	larger sizes on request		
SURFACE HARDENING			
\varnothing 1,000 x 12,000 mm	on request	\varnothing 380 x 3,000 mm	MF \varnothing 300 x 1,800 mm
bis \varnothing 1,650 mm (spin)		\varnothing 1,250 x 2,500 mm (spin)	HF \varnothing 160 x 1,200 mm
\varnothing 5,500 mm (individual teeth)		1,500 x 600 x 800 mm (laser)	