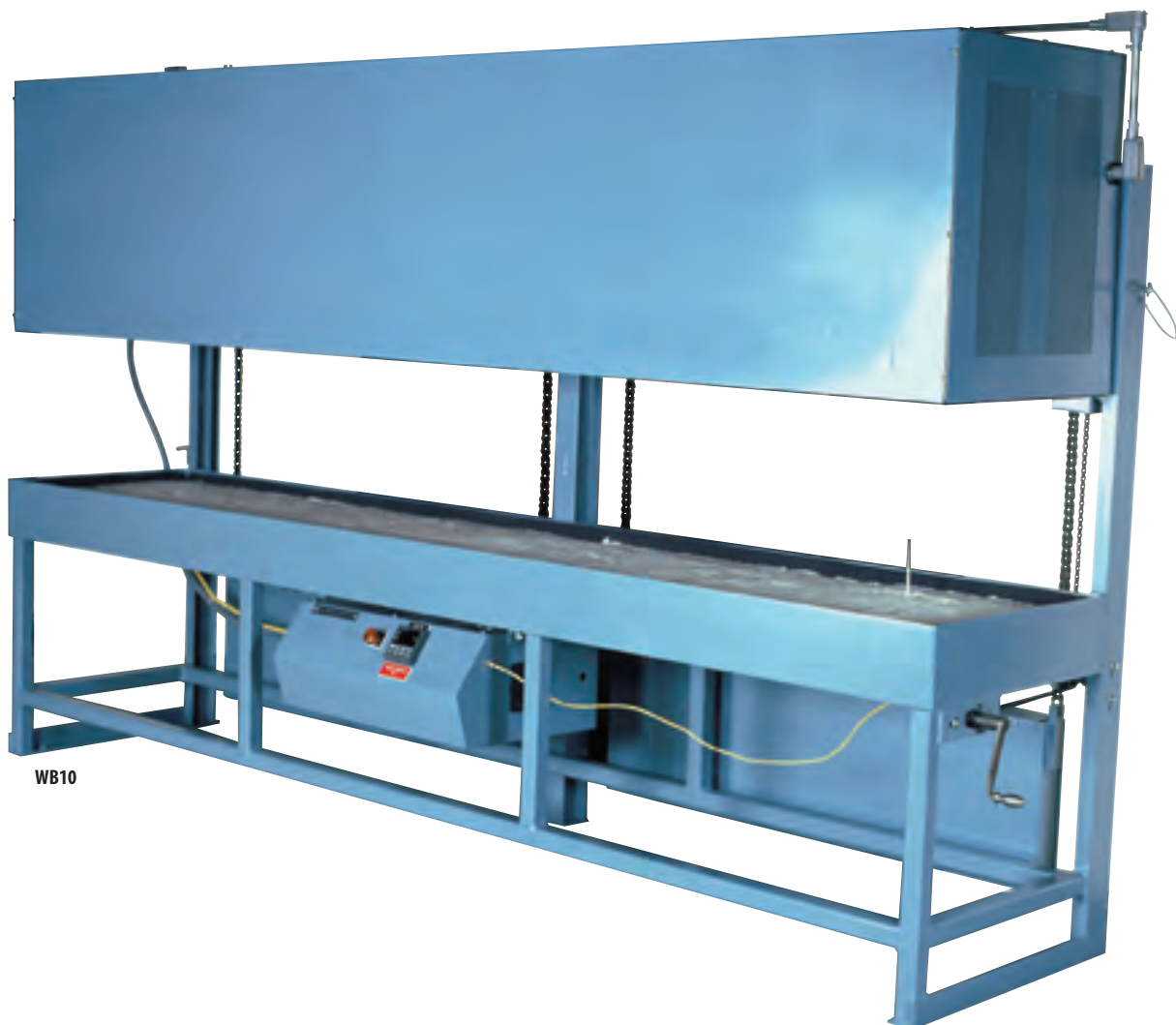


## BELL LIFT ANNEALING / PREHEAT OVENS FOR GLASS AND STEEL 1,500°F (815°C)

### APPLICATIONS

The WB Series furnace is designed for the purpose of annealing borosilicate glass, although it may be used for other applications such as weld preheating and annealing. The heated furnace portion is a counterbalanced rectangular "bell" that lifts entirely out of the way when loading the furnace. The furnace features proprietary ceramic element holders for easy, low cost replacement of elements and maximum element life. Insulation is all low density ceramic fiber and mineral wool. A completely digital programmable temperature control is included for automated cycling. Maximum temperature is 1,500°F (815°C).



# FEATURES

## NICKEL-CHROME ELEMENTS

The elements are coiled nickel-chrome 80-20 alloy. A high watt density is used for long element life. Elements are rated to 2,100°F (1,100°C).

## CERAMIC ELEMENT HOLDERS

The elements are supported in proprietary ceramic element holders located on all four sides of the furnace. The holders are supported in grooved slots in the ceramic fiberboard hot face. These provide perfect support for the coiled element as well as excellent radiating characteristics. The elements are completely exposed to the air, which allows the element surface temperature to stay relatively cool (as opposed to embedded-type elements). The smooth surface prevents premature failure of the elements as they expand and contract. Element replacement is easy: they just lift out of the holders without affecting the fiber hot face.

## EFFICIENT MULTILAYERED INSULATION

The furnace is insulated with 1-1/2" of low K factor ceramic fiberboard as the primary insulation. This is backed up by 2" of very low K factor mineral wool board on the sides and 4" on top. This extremely efficient insulation will heat up and cool down quickly. The fiberboard sections are available completely shaped for easy replacement without cementing. No asbestos or vermiculite is used.

## COUNTERBALANCED BELL LIFT CONSTRUCTION

The furnace is a rectangular bell that lifts vertically from the rigid base. The bell is supported by two heavy channels from the back, leaving the entire hearth area exposed without obstruction for easy loading. The furnace section is counterbalanced in the rear. Eight roller bearings ensure smooth operation. On larger units (WB 5 and above), a hand crank is included as standard for easy raising and lowering. A counterbalance allows the top to be stopped in any position. A manual safety pin allows the furnace top to be fixed in the top position. The base is heavy-duty 10-gauge construction with square tube structural legs. The furnace casing is 14-gauge steel. The entire case is primed with 800°F silicone paint (which will prevent corrosion at high temperatures) and finished in machine enamel.

## CERAMIC FIBER HEARTH

The hearth is layered with two 1" layers of ceramic fiber blanket. This is soft and provides an excellent working surface for delicate glass. If damaged, the fiber blanket layers can be easily and economically replaced.

## EASY TO VIEW CONTROL PANEL

All contactors and controls are located in a NEMA 1 panel mounted under the furnace to save floor space. The panel is angled up so that the operator can view it while standing. It can be adjusted in and out to suit the customer. Power control is with solid-state contactors. The power circuits are fused. The customer must connect fused power supply to a single point on the panel.

## UDC 3200 PROGRAM CONTROL SYSTEM

The standard control is a Honeywell UDC 3200 program control with six ramps and six soaks. A Type K thermocouple is encased in an inconel sheath and mounted from underneath. This thermocouple will withstand mechanical abuse because of the alloy sheathing. It is rated to 2,200°F (1,200°C). A limit switch turns off power to the furnace when the top is up.

## TESTING AND INSTRUCTIONS

The furnace is power tested to ensure proper watt ratings. A complete instruction manual includes easy startup instructions, theory of operation, maintenance instructions, parts list and a detailed troubleshooting guide. A ladder logic wiring diagram and panel layout are prepared on CAD for easy readability.

## WARRANTY

The furnace is warranted for one year except for elements and thermocouples, which are warranted for six months.

## SHIPPING

The furnace is shipped completely assembled (including the counterbalance). This saves time when installing the unit. The unit can be disassembled to fit through a 32" by 6' door.

## OPTIONS

- **OVERTEMPERATURE SYSTEM:** Honeywell UDC 1200 digital high limit backup control with manual reset, backup contactors and separate thermocouple element. The backup contactors will prevent overfiring even if the primary contactors fail for any reason.
- **FIREBRICK BOTTOMS AND LOAD OPTIONS:** The bottom can be made from 4-1/2"-thick, 2,300°F firebrick for heavier hearth loading. Stands, racks and rollers can all be quoted.
- **POWER LIFT:** A gear motor lifts the furnace up and down. Limit switches are included. Works from switches on the control panel.
- **SCR POWER CONTROL:** For very even temperature control, longer element life, and totally quiet operation.

# SPECIFICATIONS

Model Number	Inside Dimensions			Outside Dimensions			K.W.	Load Weight With Firebrick	Ship Weight
	W	H	D	W	H	D		Bottom	
WB 2	24	24	19	37 ½	92 ¾	35 ¼	3.5	300	1,100
WB 5	60	24	19	73 ½	92 ¾	35 ¼	7.0	750	1,800
WB 6	72	24	19	85 ½	92 ¾	35 ¼	8.0	900	2,000
WB 8	96	24	19	109 ½	92 ¾	35 ¼	10.5	1,200	2,500
WB 10	120	24	19	133 ½	92 ¾	35 ¼	11.0	1,500	2,900

Dimensions are in inches. Weight is in pounds. Hearth height is 31". Special sizes are available. 240 or 480 volts is normal; 208, 380 or 575 are optional. Three-phase or single-phase hookup. Specifications are subject to change without notice.

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