



# **FMF Series**

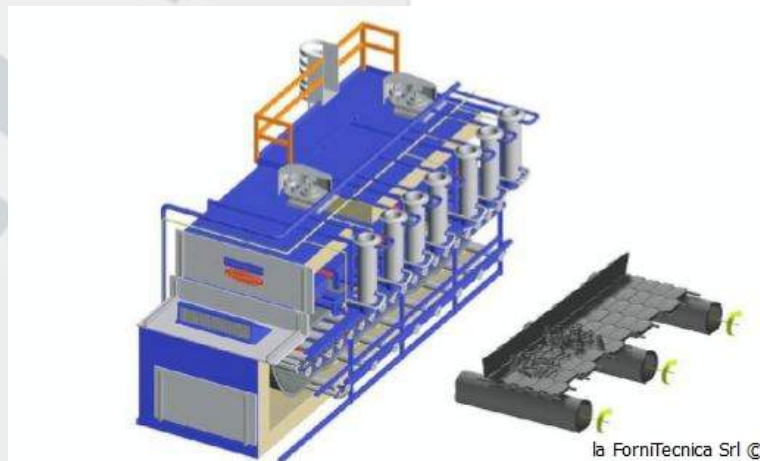
Mesh belt continuous furnaces

Main Features:

- Fully automated lines
- No need of thooted rollers
- Oil layer separation system, working without any leakage
- Effective heating system with U-shaped radiant tubes and external heat recuperators
- Quality treatments, according to customer's need, achievable through a supervising system
- The tempering furnace, equipped with a re-circulated gas direct flame heating system, allows a very high energetic efficiency while producing a protective atmosphere that is able to burnish the treated pieces

General Purpose:

- Suitable for Fasteners
- Carbonitriding
- Hardening



The plant is set up as follows:

- An automated loading system including a case elevator, a vibrating Hopper, a dosing and weighting system
- A washing system for degreasing, dephosphating and drying
- A conveyor belt that feeds the furnace loading system
- A vibrating loading system for the hardening furnace that achieves uniform piece distribution on the conveyor belt (with such a system, loading happens with no danger for threads, since bolts suffer no shocks)
- A hardening furnace with a conveyor belt especially suited for fasteners with a minimum diameter of 3 mm
- An oil quenching pit equipped with a conveyor belt and oil stirring and cooling systems
- An intermediate gas-heated washer with alkaline detergent
- A further vibrator for the tempering furnace, similar to the one feeding the hardening furnace
- A continuous tempering furnace with direct flame heating
- A pit for cooling in soluble oil, equipped with a conveyor belt
- A control board for managing the whole line
- A supervising system including a Siemens PLC and a Holo-View station, housed in external PC
- An oxygen probe and the Holo-Carb regulator to control and regulate the carbon potential

Model	Conveyor width	Heating Power	Heating	Temperature C°	N. of zones
FMF-250	600	180 Kw	Electric	870/927	3
FMF-500	914	327.000 Kcal/h	Gas	870/927	3
FMF-750	914	396.000 Kcal/h	Gas	870/927	2
FMF-1000	1524	730.000 Kcal/h	Gas	870/927	3
FMF-1250	1524	825.000 Kcal/h	Gas	870/927	4
FMF-1500	1524	1.120.000 Kcal/h	Gas	900/950	4
FMF-2000	1524	1.125.000 Kcal/h	Gas	565/650	5

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