ALD Vacuum Technologies
High Tech is our Business

NiH-Vacuum Purged Nitriding Furnaces
The Equipment Customized to all Nitriding Requirements
Process Control at any Stage

The Vacuum purged Furnace offers Higher Flexibility and more Productivity for Gas Nitriding

Processes

- Nitriding
- Nitro-carburizing
- Oxynitriding
- Post-oxidation
- Tempering

Nitriding Process

- Air or water pre-oxidation
- Nitrogen enrichment of the surface layer
- Compound (white) layer 0 to 50 μm
- Diffusion layer 0.025 to 0.8 mm
- Treatment temperature 480 to 580 °C
- Water post oxidation

Nitro-carburizing Process

- Air or water pre-oxidation
- Surface enrichment in nitrogen and carbon
- Compound (white) layer 5 to 25 μm [e]
- Diffusion layer 0.05 to 0.25 mm
- Processing temperature of 560 to 590 °C
- Water post oxidation

Controlling the nitriding process is achieved by controlling the nitriding potential $K_n = p(NH_3)/p(H_2)^{3/2}$ or $NH_3$ dissociation rate of the furnace atmosphere to predict the conditions for obtaining:

- the composition and thickness of the compound layer
- the depth of the diffusion layer.

To obtain the requested specification, the main parameters are:

- Temperature
- The gas flow rates, and composition
- Regulating $K_n$ for nitriding
- Regulating $K_n^i-K_n$ for oxynitriding

VACUUM VACUUM

N $\text{N}_2$ $\text{NH}_3$ $\text{N}_2$ $\text{CO}_2$

Dense charge

500 - 590 °C

Nitriding Time [h]
Field of Application

Nitriding and nitro-carburizing are thermochemical treatment of the surface layers. Tribological properties – which include abrasion, adhesion and surface fatigue, mechanical properties such as endurance limit - and improved resistance to corrosion is increased. These methods are used for machine parts and gears, tools, molds, dies, etc. They are also widely used when it is not possible to make a grinding operation or if only a small distortion is allowed.

In a vacuum purged furnace, pressure temperature and process gas composition can be controlled at any stage of the process to achieve expected nitrides and diffusion depth.

The vacuum purged furnace offers higher flexibility and more productivity for gas nitriding:
- Semi bulk treatment in baskets
- Dense loads
- Excellent repeatability
- Control of layers type
- Compact white layer
- Cleanness of parts
- Friendly for environment
Technology at a Glance

The main characteristics are listed as follows:

**Hot-Wall Design**
- Vacuum purge up to $10^{-2}$ mbar
- Accurate temperature uniformity (less than +/- 5 ºC)
- Convective heating up to 750 ºC
- Very short cooling time/cycles as a result of ALD France' efficient heat exchanger
- Long service life retort 8 mm thickness
- Low maintenance costs as a result of the long service life of heating elements and simple cleaning
- Gas control by MFC
- Excellent process repeatability
- Very dense bulk load

**Further Options**
- \( K, K_e, K_o \) Control
- Inconel 600 retort
- AMS 2750, 2759/6/10/12
- \( \text{NH}_3 \) dissociator
- Gas exhaust cracking
- Analyzer \( \text{NH}_3 \)

**Applications**
- Nitriding
- Nitro-carburizing
- Oxinitriding
- Post-oxidation
- Pre-oxidation with air, water vapor
- Annealing
- Tempering

**Technical Data**

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<td>Width (mm)</td>
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<td>600</td>
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For detailed information and price proposal please contact us:

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