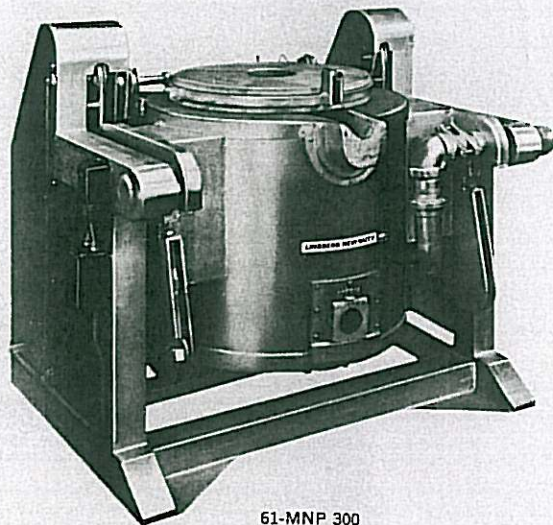
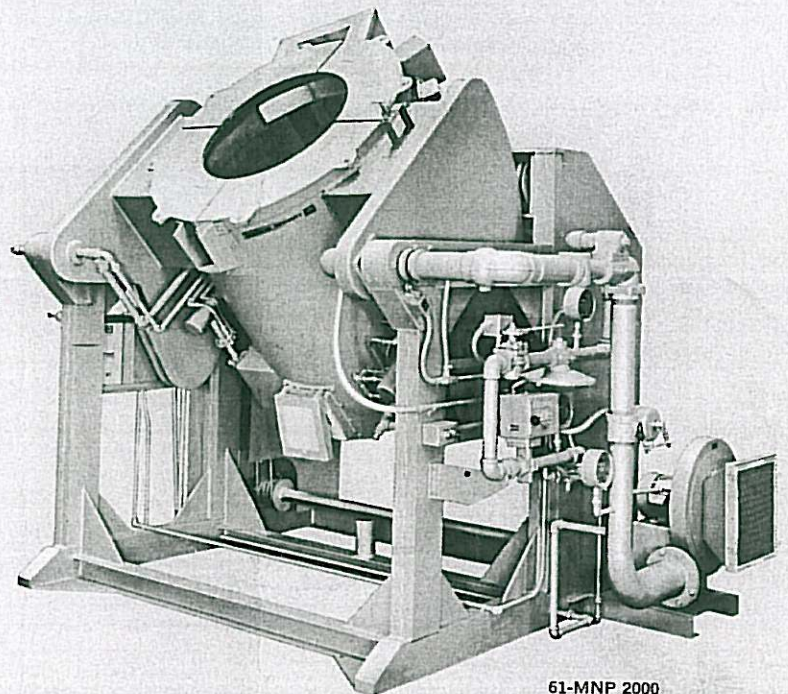


MOTORIZED NOSE POUR MELTING FURNACE



61-MNP 300
for brass



61-MNP 2000
for aluminum (less crucible)

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The economies of mechanized pouring now are available in a single tilting furnace of larger capacity than is practical in a stationary type

Bringing positive finger-tip control to the entire mechanized pouring operation, and with the pouring lip located to minimize shifting of transfer ladles or molds during pouring, these motorized nose pouring non-ferrous melting furnaces are ideal for melt down, remelt and hot-charge into holding furnaces for permanent mold or die casting, and melting and pouring directly into transfer ladles for sand castings.

Features Constant firing during pouring ■ High melt rates ■ Automatic limit switches prevent tilting beyond extreme positions ■ Special trunnion mounting permits charging from relatively low heights (compared to hand-tilting furnaces) ■ Standard capacities: Up to 2,800 lbs. Brass; 2,000 lbs. Aluminum; 2,000 lbs. Magnesium; 5,500 lbs. Zinc ■

General construction

TILTING MECHANISM The tilting mechanism of the motorized nose pour non-ferrous melting furnaces consists of built-in quadrants welded to the furnace shell, with heavy cable on each side connected to cable drums driven by an electric motor and gear reduction unit with heavy chain and sprockets. The tilting switch has forward, neutral and reverse positions, and automatic limit switches prevent furnace from tilting beyond extreme positions.

CHARGING CONVENIENCE A special trunnion mounting permits charging from relatively low heights, as compared to hand-tilting furnaces.

UNINTERRUPTED FIRING Burner equipment is attached to the drum and swings with the furnace, permitting the furnace to continue firing at any angle of the pouring operation. Single or multiple burners, depending on the fuel used and the application involved, are set tangentially to the inside circumference of the furnace lining, and arranged so as to fire in a spiral motion within the combustion chamber. Burners are "sealed-in" to prevent entry of free air and to allow the furnace to develop a slight back pressure for quiet operation.

AUTOMATIC TEMPERATURE CONTROL consisting of pilot lights, motorized air valve, thermocouple assemblies and choice of controlling instruments is optional for aluminum or magnesium furnaces.

RUGGED STEEL SHELL has welded seams reinforced with flat stock bands to eliminate distortion. The shell is mounted on roller bearing trunnions and supported on sturdy structural steel legs.

COVERS of most furnaces for brass applications are of silicon carbide material mounted on roll-back assembly. Flue products flow between the top of the crucible and the furnace cover before passing through the cover hole. Crucible-type furnaces for aluminum applications are equipped with a recessed cover held in place by a cast iron top plate. Combustion products exhaust through a flue at the rear of the furnace. Pot-type furnaces for aluminum, zinc or magnesium applications are equipped with a rear flue, but without a cover. When iron or steel pots are used, they are held in place and prevented from shifting during pouring by a clamping arrangement bolted to the furnace shell.

FURNACE LININGS Most furnaces for brass applications are available with either a rammed-out-to-shell plastic refractory or silicon carbide ring shapes backed up with suitable insulation. Furnaces for aluminum, zinc or magnesium are lined with firebrick shapes backed up with heavy insulation.

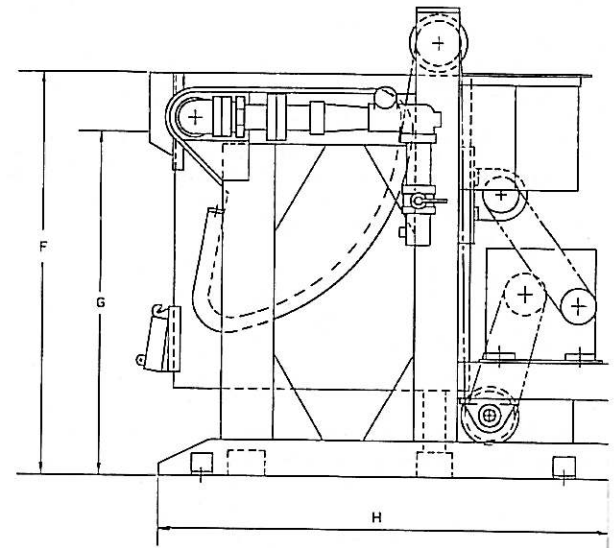
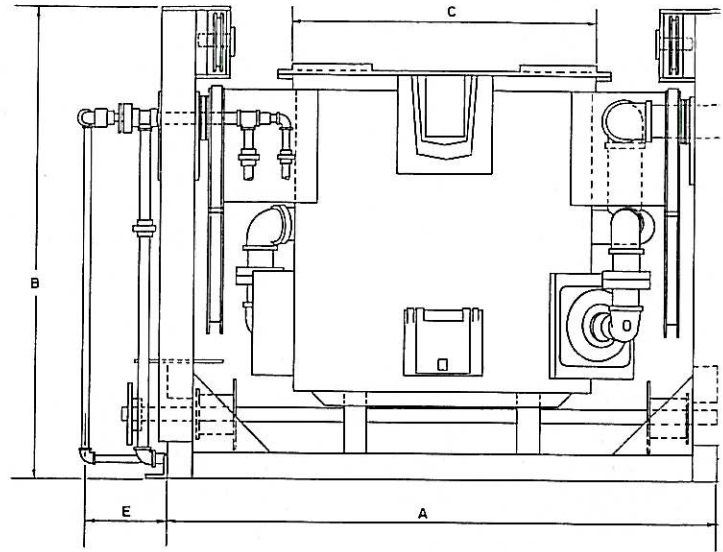
CRUCIBLE REST (Base block) is installed in crucible type furnaces prior to shipment.

SLAG PORT is provided on all furnaces for cleaning slag accumulation and as a drain for metal in the event of a crucible or pot failure.

SAFETY EQUIPMENT Safety equipment to meet insurance specifications is optional.

(Standard furnaces can be modified to provide constant arc pouring where the pouring lip is located on the axis of tilting, to completely eliminate the shifting of transfer ladles or molds during pouring operation.)

(Standard furnaces are supplied for manual operation for use with natural or manufactured gas, butane or propane. Optional accessories are available including crucibles, cast iron or fabricated steel pots, combustion air blowers and control panels. Oil-fired furnaces and special sizes are available upon request. Most standards are also available with a hydraulically-operated tilting mechanism.)



Specifications

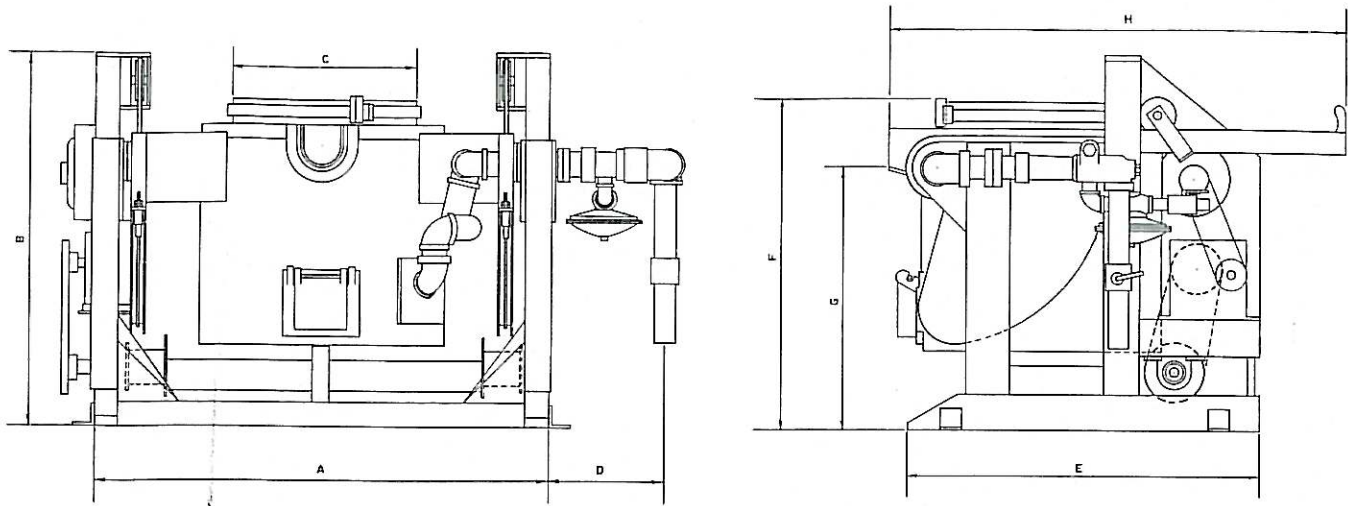
ALUMINUM OR ZINC — CRUCIBLE OR CAST IRON POT

Furnace Type	Approx. Hold Cap. - Lbs.		Approximate Dimensions — Inches							
	Alum.	Zinc	A	B	C	D	E	F	G	H
61-MNP600	600	1500	76	65	42	15	17	56	50	62
61-MNP1000	950	2817	83	83	47	20	17	67	61	71
61-MNP2000	1820	5460	97	93	56	21	17	76	70	88

MAGNESIUM — FABRICATED STEEL POT

Furnace Type	Approx. Hold Cap. - Lbs.	Approximate Dimensions — Inches							
		A	B	C	D	E	F	G	H
61-MNP1200	1200	97	88	54	16	17	71	66	82
61-MNP2000	2000	104	94	60	24	17	78	72	85

Specifications



BRASS, BRONZE, COPPER — CRUCIBLE

Furnace Type	Approx. Hold Cap. - Lbs.	Approximate Dimensions — Inches							
		A	B	C	D	E	F	G	H
61-MNP150	420	63	51	26	18	49	45	36	63
61-MNP175	480	63	51	26	18	49	45	36	63
61-MNP200	530	67	52	28	18	49	47	37	68
61-MNP225	620	67	52	28	18	49	47	37	68
61-MNP250	675	67	53	28	18	49	48	38	68
61-MNP275	775	67	53	28	18	49	48	38	68
61-MNP300	830	69	53	32	18	49	48	38	73
61-MNP400	1150	69	56	32	18	49	51	41	73
61-MNP600	1885	70	60	36	21	62	55	45	84
61-MNP1000	2800	83	85	46	21	72	66	56	74

All specifications subject to change without notice.

Lindberg Hevi-Duty supplies the most comprehensive line of ferrous and non-ferrous heat processing equipment that is available to the foundry and die casting industry. Included are metal melting furnaces (induction channel, induction coreless, medium frequency, electric resistance, electric arc, fuel-fired crucible or pot); vacuum and atmosphere heat treating furnaces for production and research/development; and ovens.

Other equipment available includes kilns, microelectronic production equipment, and induction heating equipment.

For more information call our office nearest you, or write: Melting Department, 304 Hart Street, Watertown, Wisconsin 53094.

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