

TECHNICAL SPECIFICATION

ISOBARIC VAPOUR ALUMINISING TYPE IVA 4070

The IVA 4070 is designed for the vapour aluminising of nickel based gas turbine components. The out-of-pack process results in uniform and defect free coatings over the most complex shapes. Post coating heat treatments are also possible in the reactor. The total permitted weight of work and fittings is 900 Kgs.



Isobaric Vapour Aluminising is a form of out-of-pack aluminising operated at a low constant pressure to achieve good throwing power and uniformity of layer thickness. The process operates at temperatures between 900 and 1050°C and at pressures in the range 1 to 50 mbar. The aluminium content of the resulting layer can be adjusted by the process conditions and also by subsequent heat treatment, which can be carried out in the same furnace.

IVA has a number of advantages over pack aluminising :

- 1) More rapid cycle time because the parts are not surrounded by pack.
- 2) Better coating uniformity on each part.
- 3) Less variation in coating thickness from one place in the retort to another.
- 4) No coating defects caused by pack inclusions.
- 5) Lower cost of operation because less pack material is used.
- 6) Less pack material to be dumped safely.

The IVA 4070 consists of a double-pumped vacuum furnace and retort. The normal operating temperature range 900-1150°C. The normal operating pressure range is 1 to 50 mbar. The double pumping arrangement is necessary to ensure that the inner hot retort wall does not collapse.

The retort is loaded upwards into the base of the furnace. This arrangement makes it possible to load and unload the retort rapidly even when hot. In normal operation the furnace is kept close to the working temperature, and the retorts are loaded and unloaded whilst the furnace is hot. Several retorts and base units are required for continuous operation.

The furnace is supported on a steel frame which also provides a platform for maintenance work. The retort is lifted up into the furnace by a hydraulic system. The retort can be lowered away from furnace the while it is still hot. It is mounted on wheels so that it can be moved away to a cooling station, and replaced by another retort or an insulated plug when the furnace is not in use.

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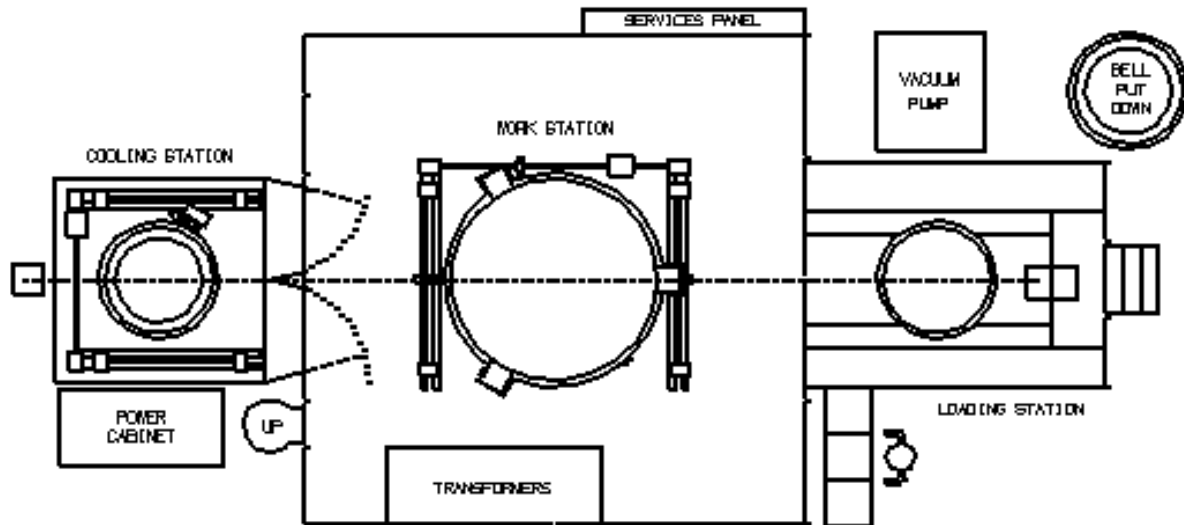
In association with:
IonBond AG,
Industriestrasse 211,
CH-4601 Olten,
Switzerland.
Tel. 00 41 62 2878787
Fax 00 41 62 2878791

ATL CVD.CO.UK

Archer Technicoat Ltd.

Progress Road, Sands Industrial Estate,
High Wycombe, Bucks. HP12 4JD
Tel. 00 44 1494 462101 Fax 00 44 1494 463049
www.cvd.co.uk

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Specification for IVA 4070

Retort overall dimensions	Ø39" x 118" (Ø1010 x 3000mm)
Retort working zone	Ø37" x 63" (Ø960 x 1600mm)
Temperature range	900°C - 1150°C (1650°F-2102°F)
Temperature control	3 zones with PID control
Temperature measurement	S-Type Pt/Rh thermocouples in each zone
Pressure range	1-50mbar (standard control range) Lowest operating pressure : 1mbar Highest operating pressure : 1000mbar
Pressure control	Motorised line valve
Pressure measurement	Absolute pressure transducer
Vacuum pump	Oil filled rotary piston pump Capacity : 500m ³ /Hr (300 cfm) approx.
Gas control	Argon purge by mass flow controller
Electricity	300KVA
Cooling water	30 US gallons/minute
Materials of construction	Furnace shell: Carbon steel Retort: Inconel 601 Heaters: Kanthal Vacuum lines: Stainless steel

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