

Vacuum Soldering and Brazing Unit

VSU 28



Max. Temp: 650°C
Area: 260x210mm

Optional
dual heating
pressure up to 4.5bar

Overview

Oven with bottom (and optionally top) infrared heating.

Tooling plate made of graphite or any other suitable material.

Thermocouples freely positional, fixed in tooling plate or fixed in chamber lid.

Chamber pressure from 5×10^{-4} mbar vacuum to 4.5 bar abs.

Ebedded controller with 7" touch display and PC windows based application.

Specifications

Process environment	nitrogen, inert gas, formic acid
Heated area	260 x 210 mm
Clearance above heater plate	45 mm
Maximum temperature	650°C continuous operation
Ramp heat up / cool down	250°C/min
Control deviation	+/- 0.5°C
Heating / cooling type	infrared heating / nitrogen gas cooling
Temperature measurement	4x K-Type freely positional on probe and plate
Vacuum measurement	integrated absolute vacuum gauge down to 5 mbar
Maximum vacuum	5×10^{-4} mbar
Leak test of entire system	$< 5 \times 10^{-8}$ mbar.l/s Helium
Formic acid bubbler	40 ml container, integrated in front panel
Chamber lid	manual closing/opening with lid lock, weight balanced
Gas supply	nitrogen 2-3bar(abs) at line 1-3, compr. air 5-8bar(abs)
Chamber cooling	water cooling 4-6 l/min @ max. 28°C inlet, 2 bar min.
Dimensions	550 mm(W) x 615 mm(D) x 400 mm(H) with closed lid
Weight	42 kg
Power supply	200-240V, 50/60 Hz

Optional

Positive pressure	down to 5×10^{-4} vacuum measurement
bottom + top heating	independent overheat protection
higher clearance above heating plate	3-color signalization
auto refill for formic acid	mounting rack with chiller and place for pump
additional gas line	vacuum pumps

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