Full Automatic Ipsen P7 Pusher Furnace
Set up in “U” Configuration with Full Manual Control
30” Wide x 30” Long x 30” High, 480V / 3-phase
Overall Pusher Line Foot Print ~ 22’ wide x 80’ long
Hardening Furnace Side ~54’ - Draw Furnace Side ~ 80’

Line is in excellent condition.
It will be taken out of service the end of November 2019.

Powered scissor cart to long roller rail (not powered)
to lift table with power rollers
“Dog” transfer forward, then “dog” transfer 90 degrees to vestibule with alligator door.

Hardening section (1750°F - 3 Zones) 7 trays in heat plus one section with an alligator door used for carburizing.
Hardening section is loaded with a push ram which pushes all 8 trays at same time

Agitated and heated oil quench with roller chains
Roller chain and “dog” transfer from oil tank

90 Degree “dog” side transfer to parts washer side

“Dog” transfer to parts washer
“Dog” transfer out of washer to 1200°F draw

“Dog” transfer from parts washer to 14 tray (1200°F 3 Zones) draw. Draw has all rollers with “dog” transfer inside which moves all trays at once with spacing between trays.
“Dog” transfer from draw Furnace to mister station

Power roller discharge from mister to scissor lift unload area
Furnace Line Fully Automatic - PLC Control

Pusher Line Manual Control
Pusher Line Temperature Control