



SUBJECT FIRING IN FORMING GAS

SUPERSEDED DATE

1. EQUIPMENT

- a. Bell type furnace is used with electric heater in the outer shell. Inner shell serves as a container for the forming gas which is the protective atmosphere to prevent parts from oxidizing.
- b. Trays for firing parts are made of chrome iron or nichrome.
- c. The furnace is equipped with an automatic temperature controller and recorder.

2. MATERIAL

10:90 Forming gas is supplied from cylinder.

3. PROCEDURE

- a. Place parts in position on trays which are placed in furnace.
- b. Lower inner shell over trays and lower outer shell over inner shell.
- c. Start flow of forming gas and set at 35-40 cubic ft./hour.
Precaution: There must be at least 900 lbs. gas/sq.in. pressure in tank to insure flow during process of 6 hour duration.
- d. Set temperature controller to the required temperature and turn on heating power.
- e. After the furnace is up to temperature for the required time, turn power off.
- f. Do not raise furnace until temperature is down to 150°C. For quick cooling outer shell may be raised 15 minutes after turning power off.
- g. Remove parts and turn off forming gas.