



The trade name Recco Furnaces is the property of Keith Co.

Dual Chamber Heat Treating Furnaces

These popular high quality furnaces have been industry's choice since 1960. The many design updates ensure that you get the most current, proven, refractory and electrical design features that modern technology can provide. When you compare there will be no question that Keith's dual furnaces represent the best value available for high quality industrial production.

Two independently operated furnaces are assembled into a single attractive floor space saving package. Several models even have room in the base for an optional pull-out quench tank. A single control cabinet puts all the controls in one convenience location.

The usual configuration is a 2250°F top furnace and a 1250°F lower furnace with a circulating fan for tempering or drawing. Thus, there is no waiting for the heat treat furnace to cool down. Alternatively both furnaces can be either high temperature or low temperature.

STANDARD FURNACE SPECIFICATIONS

MODEL	RATING	CHAMBER SIZE			OUTSIDE DIMENSIONS			STANDARD	CONNECTED
		W	H	D	W	H	D	VOLTAGE	POWER
R-120820-D	2250°F/1250°F	12"	8"	20"	25"	57"	33"	208/240 1 PH	8.0 kW
R-121220-D	2250°F/1250°F	12"	12"	20"	26"	61"	33"	208/240 1 PH	8.0 kW
R-120832-D	2250°F/1250°F	12"	8"	32"	25"	57"	45"	208/240 1 PH	8.0 kW
R-120840-D	2250°F/1250°F	12"	8"	40"	25"	57"	53"	208/240 1 PH	12.8 kW

All specifications are subject to change without notice.

SPECIAL FEATURES

- Saves floor space – two furnaces in one.
- A high quality unit for reliable production.
- Highly accurate control system.
- Unattended start up and/or shutdown.
- Ability to protect parts from oxidation.
- Easy maintenance and installation.

OPTIONS

- Independent over temperature protection
- Inert atmosphere package for upper furnace chamber
- 2000°F Rated fan package (Standard is 1200°F)
- Programmable controls (Setpoint controls are standard)
- Voltages: 3 Phase, 208V, 230V or 460V
- Quench tanks on rolling wheels
- Alloy hearth plates

HEATING ELEMENTS

In the smaller models, heavy coiled wire heating elements are installed in grooved refractory plates, which slip into grooves in the refractory lining. The plates protect the heating elements from damage while loading and unloading the furnace and provide exceptional support for the elements for long element life. In larger furnaces, the heating elements are installed in grooves within the ceramic fiber lining.

CONTROLS

All furnace controls for both chambers are conveniently located in a side mounted control cabinet at a level where they are easy to view and operate. Solid-state digital indicating PID temperature controllers are used for the most precise control of temperature. All controllers are equipped with broken thermocouple protection.

PROTECTION FROM OXIDATION

Several approaches are available when parts need to be protected from oxygen in the upper chamber. The easiest method is to wrap your parts in stainless steel heat-treating foil. A small amount of paper or charcoal can be included to consume the oxygen in the package. Likewise, you can place your parts into an alloy box containing paper or charcoal. Another approach is to insert an atmosphere of argon or nitrogen into the furnace with our optional inert atmosphere package. This eliminates most of the oxygen in the furnace, and is suitable for processing many grades of alloy.



Alloy heat-treating boxes for use in the upper heating chamber

SAFE AND SIMPLE OPERATION

Door limit switches turn off the heating elements when the door is opened. The controller safety features make these units ideal for unattended operation. With a timer or programmable controller, unattended startup and/or shutdown can be scheduled.

EASY INSTALLATION

Simply position the furnace where desired on a good level surface and ensure that the circuit breaker is suitable for the electrical load. A single electrical connection is made from your circuit breaker to the furnace.

EASY MAINTENANCE

The only maintenance your dual furnace should require for many years is occasional replacement of heating elements, thermocouples and perhaps some small electrical parts and fan components. These furnaces have been designed to make all maintenance simple and fast.

The plates containing the heating elements are easily replaced from the front of the furnace. You can purchase the assembled plates or just the heating elements themselves.

All electrical parts are easily accessible in the control cabinet. A wiring diagram is provided to assist in troubleshooting.

Repair parts for your furnace are always available – even a complete refractory lining kit should you need one after many years of satisfactory operation. ***We suggest you include spare heating element plate assemblies and thermocouples with your furnace order.***

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