

# 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  $5 \times 10^{-4}$  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               | $5 \times 10^{-4}$ 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 $5 \times 10^{-4}$ 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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