

# Conditioning bath

# TT-100 K-E, KB-E

switchable from water to steam operation

TT-100 K-E                   with 150 litre content  
TT-100 KB-E                 with 300 litre content



## Features included

- Switchable from water to steam operation.
- Self-optimising microprocessor controller.
- Heating switchable in stages.
- Automatic level control with warning light.
- Automatic or manual refill.
- All components in contact with water are made of stainless steel.
- Tank and cover with thermal insulation.
- 24-hours switch clock, 7-days quartz switch clock with 100 hours power reserve or digital switch clock.
- Unit on castors.

## Operating principle

When working with polyamid water has to be enriched to get parts of dimensional stability and impact resistance. The TOOL-TEMP conditioning bath allows water and steam operation up to 90°C. The electronic temperature control system guarantees an exact and constant water temperature. The heating time can be programmed in advance (e.g. for the duration of 7 days). All components touching water are made of stainless steel. The water tank is easily to be cleaned. An automatic level control prevents heating in case of an empty tank. The TOOL-TEMP conditioning bath is available with 150 litre or 300 litre content. Both units are switchable from water to steam operation.

### Water operation

The tank is filled completely with water and all parts are contained in the water. This allows conditioning in short time.

### Steam operation

The parts are contained in steam (max. 90°C) instead of water. This procedure prevents water spots. Additional conditioning time of approx. 50 - 100% is required.



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Technical data:	TT-100 K-E	TT-100 KB-E
<b>System</b>	switchable from water to steam operation	
<b>Tank content</b>	150 litre	300 litre
<b>Heating power</b>	6 kW	12 kW
<i>Switchable in stages</i>	3/3	6/6
<b>Temperature control</b>	self-optimizing, electronic microprocessor controller MP-888 with digital displays of the set and actual value. Automatic temperature monitoring.	
<b>Temperature range</b>	max. 90°C	max. 90°C
<b>Filling</b>	automatic	automatic
<b>Perforate plate baskets</b>		
<i>Number of</i>	2	4
<b>Size of basket</b>	445 x 340 x 375 mm	445 x 340 x 375 mm
<b>Size of tank</b>	750 x 480 x 475 mm	1500 x 480 x 475 mm
<b>Dimensions (LxBxH)</b>	1150 x 530 x 850 mm, incl. castors	1900 x 530 x 850 mm, incl. castors
<b>Weight</b>	approx. 130 kg	approx. 210 kg
<b>Colour</b>	silvergrey RAL 7001	

## Conditioning times

Fresh-shot plastics made of polyamid, especially PA 6.6, are very brittle and dry. Such parts require a content of moisture of approx. 2,5% to get dimensional stability and impact resistance.

This humidity will be absorbed by air. By keeping the plastic parts in hot water this process can be accelerated. Absorption of humidity is possible with water or with steam.

Following a list with standard data. For detailed information please contact the corresponding supplier of raw material.

## Polyamid Typ PA 6.6 / PA 6

Water temp. in °C	Conditioning time indicated in hours									
	20		40		60		80		100	
Thickness in mm	PA 66	PA 6	PA 66	PA 6	PA 66	PA 6	PA 66	PA 6	PA 66	PA 6
1	34	8.0	7.5	2.4	1.8	0.7	0.4	0.3	0.2	0.1
2	150	30.0	32.0	10.0	7.3	3.0	1.8	1.0	0.4	0.3
3	350	75.0	81.0	21.0	18.0	7.0	3.8	2.2	0.9	0.7
4	600	130.0	137.0	37.0	30.0	12.0	7.0	3.7	1.7	1.3
6	> 1000	290.0	300.0	90.0	80.0	28.0	18.0	8.5	3.8	2.9
8	> 1000	500.0	550.0	170.0	130.0	50.0	30.0	16.0	6.7	5.0
10	> 1000	875.0	850.0	250.0	200.0	75.0	56.0	23.0	10.0	7.5

This information refers to water operation. Steam operation takes approx. 50-100% more time.



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