TECHNICAL DATA SHEETS FOR THE SHUTTLE KILN

2.1 Technical data sheet for the shuttle kiln, type HWO 1/11-4.0

Design:	one-track shuttle kiln for 11 kiln cars	
Type of ware to be fired:	pipes:	DN400 - DN600 x 2000 mm
	fittings:	DN200 - DN400
Kiln dimension:	length (steel housing):	22.1 m
	width (steel housing):	7.7 m
	height (top of waste gas channel):	6.4 m
Kiln car dimension:	length:	3,000 mm
	setting length:	2,960 mm
	setting width:	4,000 mm
	setting height:	2,400 mm
	setting surface:	11,84 m²
	setting volume:	28.42 m³
Setting per kiln car:	pipes (DN400 - DN600 x 2000), loading on 1 deck	
	ware (for example: DN400)	= 4,930 kg
	+ kiln car superstructure	= 2,800 kg
	= gross charge	= 7,730 kg
	fittings (DN200 - DN400), loading on 2 decks	
	ware (for example: DN200)	= 1,410 kg
	+ kiln car superstructure	= approx. 4,000 kg
	= gross charge	= 5,410 kg
Firing cycle:	pipes:	60 - 70 hours
	fittings:	40 - 60 hours
Firing temperature:	1,180 °C	
Kiln output / cycle:	pipes.	max. 54,230 kg ware (= 85,030 charge)
	or fittings:	max. 15,510 kg ware (= 59,540 charge)
Kiln output / year (350 days):	pipes:	**5,400 to ware**
	or fittings:	**2,700 to ware**
Kiln setting volume:	313 m³	
Fuel:	LPG	
Fuel consumption:	pipes: 860 kcal/kg charge (= 1,318 kcal/kg ware), ± 10 %,	
	moisture content of ware to be less than 1 % at kiln entrance	