

TT-100 K-E

TT-100 KB-E

Conditioning bath

switchable from water to steam operation

TT-100 K-E with 150 l content

TT-100 KB-E with 300 l content



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 l or 300 l 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. The unit is equipped with automatic water refill.

Steam operation

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

Serial equipment

- Switchable from water to steam operation
- Self-optimising microprocessor controller
- Heating switchable in stages
- Automatic level control with warning light
- Tank made of stainless steel
- Perforated plate baskets made of stainless steel
- Tank and cover with thermal insulation
- Mounted on castors
- 24-hours switch clock or 7-days quartz switch clock with 100 h power reserve

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Technical data

	TT-100 K-E	TT-100 KB-E
System	switchable from water to steam operation	
Tank content	150 l	300 l
Heating power	6 kW in 2 stages	12 kW in 3 stages
Temperature control	self-optimising microprocessor controller with digital display	
Temperature range	up to max. 90°C	up to max. 90°C
Water refill	automatic	automatic
Number of perforated plate baskets	2	4
Size of basket	445 x 340 x 375 mm	445 x 340 x 375 mm
Size of tank	750 x 480 x 475 mm	1500 x 480 x 475 mm
Dimensions	1150 x 530 x 850 mm	1900 x 530 x 850 mm
Weight empty	approx. 130 kg	approx. 210 kg
Colour	silver grey 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 Type PA 6.6 / PA 6

Water temp. in °C	Conditioning time indicated in hours									
	20		40		60		80		100	
Thickness in mm	PA 6.6	PA 6	PA 6.6	PA 6	PA 6.6	PA 6	PA 6.6	PA 6	PA 6.6	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 more than 1000	290.0	300.0	90.0	80.0	28.0	18.0	8.5	3.8	2.9	
8 more than 1000	500.0	550.0	170.0	130.0	50.0	30.0	16.0	6.7	5.0	
10 more than 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.

TOOL-TEMP product range

Temperature Control Units	from 3 kW up to 150 kW heating capacity
Water Chillers	from 5000 kcal up to 600 000 kcal/h cooling capacity
Conditioning bath	for polyamide parts



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