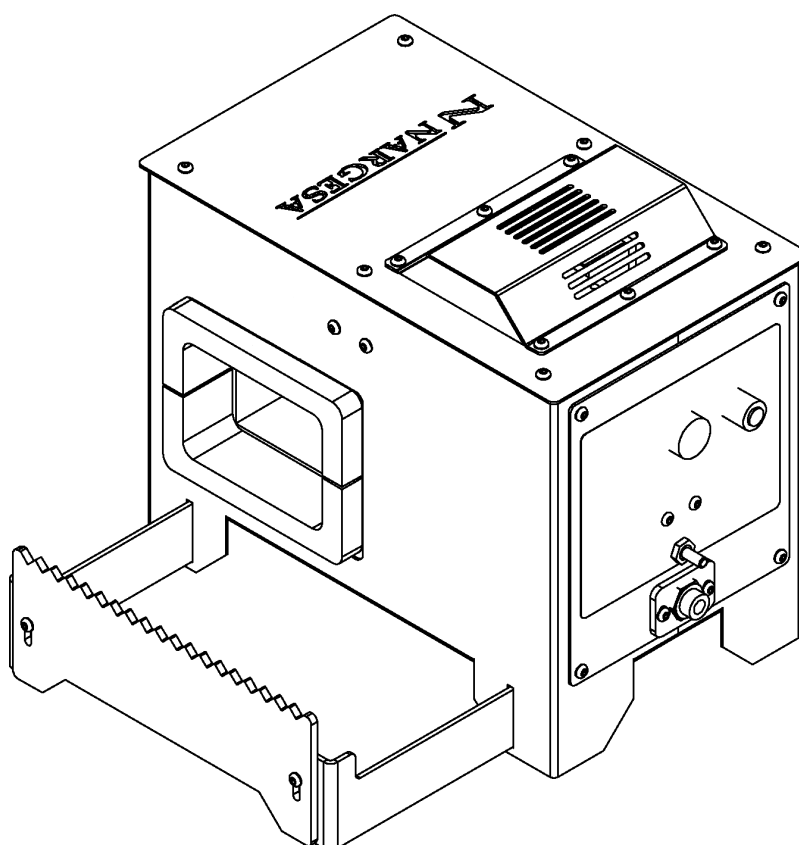


GAS FORGE

H1

NS: 2021-159



INSTRUCTIONS BOOK

PRADA NARGESA, S.L

Ctra. de Garrigàs a Sant Miquel s/n · 17476 Palau de Santa Eulàlia (Girona) Spain
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NARGESA CLIENTS

Prada Nargesa has more than 8,000 customers around the world. Some of our clients, those who offer service to third parties with the Nargesa machinery in their workshops, have been pleased to be part of this network that aims to connect them with possible future clients. In this way, all those people or companies that have a need for any part or tool that can be manufactured by using the Nargesa range of machinery, will be able to find a solution in their area to be able to satisfy their production requirements by hiring their services.



DO YOU WANT TO PARTICIPATE?

Send an email to nargesa@nargesa.com, include the following information and we will add you to this list.

We want to encourage all those who haven't participated yet in this great commercial network!

Company name

CIF/Tax Code

City

Country

Machine or machines

PRADA NARGESA

Prada Nargesa S.L. is a family business founded in 1970 located near Barcelona, Spain, with more than 50 years of experience in the sector of manufacturing of industrial machinery, and more than 10.000m² of facilities. Nargesa is a symbol of quality, reliability, warranty and innovation.

Our whole range of machines and accessories is manufactured entirely in Nargesa. We have a constant stock of 400 machines, and we have more than 16.800 machines sold all over the world.



OUR RANGE OF MACHINERY

Ironworker Machines

Ring Roller Bender and Pipe Bender

Non-mandrel Tube and Pipe Bender

Twisting / Scroll Bending Machines

Horizontal Press Brakes

End Wrought Iron Machines

Gas Forges

Iron Embossing Machines

Hydraulic Shear Machines

Hydraulic Press Brakes

Presses for Locks

Broaching Machines

Power Hammers

CERTIFICATES

Prada Nargesa has several certifications that backup both, the design and manufacturing processes, as well as the journey through exporting our products around the world and the quality of the manufacturing components we use for our machines. These facts turn into real advantages for our customers:



AUTHORIZED EXPORTER

- Faster customs procedures
- Reduction of tariff documentation
- Tariff preferences according to geographical location



INNOVATIVE SME

- Development in innovation, design and manufacturing technologies
- Certification and audit of efficiency in product and service
- Ability to foresee customer needs



R+D+I MANAGEMENT

- Manufacturing based on the R+D+I process
- Technological surveillance system

SUCCESS STORIES

At Prada Nargesa we believe that the testimony of our clients is our best guarantee, and that is why we like to expose some of the success stories that we have witnessed around the world:

PORTUGAL

Capela & Filhos



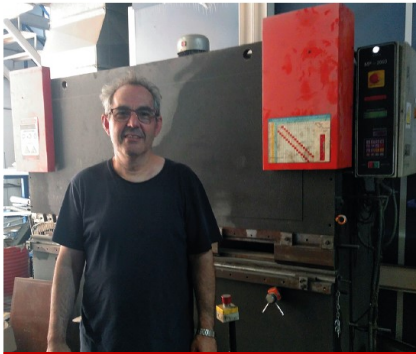
AUSTRALIA

Manufactured Alloy Xtras



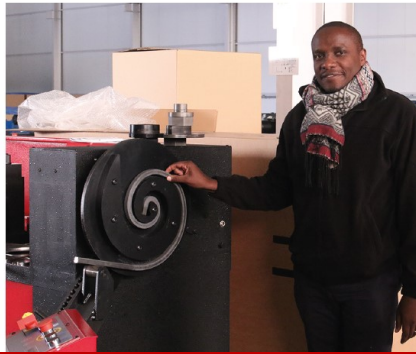
ESTADOS UNIDOS

Madison Environmental Resources



ESPAÑA

CBET Decoración SL



UGANDA

Steel Limited



RUMANIA

Gala Metal & Design SRL

DO YOU WANT TO PARTICIPATE?

Send an email to nargesa@nargesa.com including the following information and we will add you to our website

Company name

Testimonial name

Post in the Company

Country

Descriptive text

Photography with the machine

INDEX

1. MACHINE INFORMATION	3
1.1. Identification of the machine	3
1.2. Dimensions	3
1.3. Description of the machine	3
1.4. Fuel for the furnace	4
1.5. Identification of elements	5
1.6. Description of elements	6
1.6.1. Openings	6
1.6.2. Burners	6
1.6.3. Thermocouple	7
1.7. General Features	8
2. TRANSPORT AND STORAGE	9
2.1. Transport	9
2.2. Storage conditions	9
3. MAINTENANCE	10
3.1. General maintenance	10
3.2. Change of the insulating material of the furnace	11
4. HANDLING BOOK	16
4.1. Gas valve	16
4.2. Pushbuttons	16
4.3. Pressure controller and manometer	16
5. INSTALLATION AND SET UP	17
5.1. Location of th machine	17
5.2. Dimensions and work área	17
5.3. Admissible external conditions	17
5.4. Set up	18
5.5. Openings	18
5.6. Adjustment of the material support position	19
5.7. First set up of furnace	20
5.8. Lighting up the furnace	22
5.9. Shutdown of the furnace	22
6. POSSIBLE BREAKDOWNS	23
7. WARNINGS	24
7.1. Hazard wastes	24
7.2. Protection elements for the operator	24

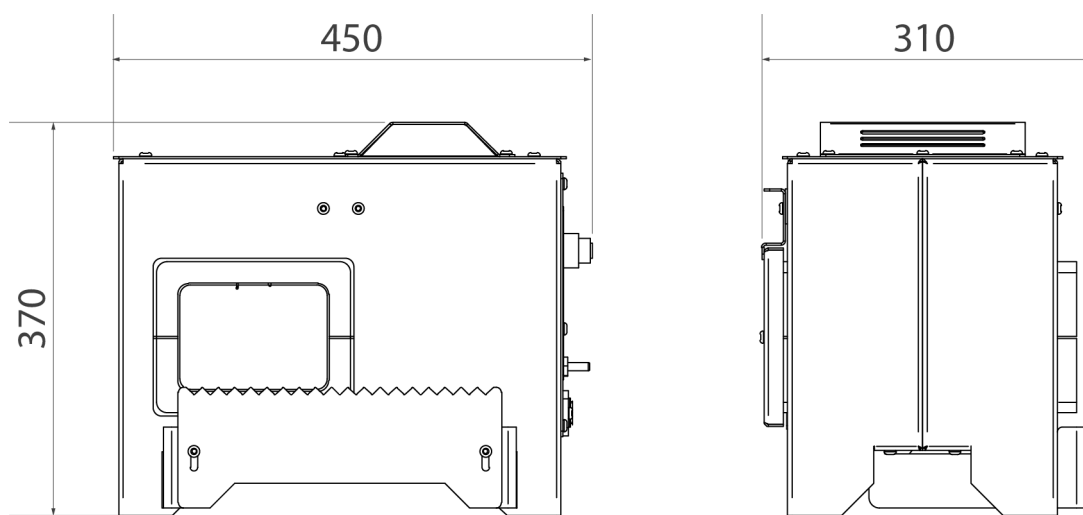
TECHNICAL ANNEX

1. MACHINE INFORMATION

1.1. Identification of the machine

Brand	NARGESA
Type	Furnace
Model	H1

1.2. Dimensions



Picture 1. External dimensions of the Furnace H1

1.3. Machine description.

The H1 Furnace is an oven designed to heat metal profiles of different thicknesses and shapes. The furnace H1 allows us to heat parts up to a temperature of 1300°C.

The oven is composed of three elements (supplied by Nargesa): the oven, the **Gas hose** and the **Pressure regulator**. This type of installation will never be modified, in No Case.

The oven is equipped with one **Burner** for propane gas (LPG), independent.

The ignition of the oven is electronic.

The ovens designed and manufactured in Nargesa comply with the regulations in force in Spain, concerning to the Regulation of appliances that use gas as fuel RD919 / 2006.

1.4. Fuel to be used with this foerge

COMPOSITION AND INFORMATION: PROPANE GAS G.L.P.

Chemical nature	Blend of Hydrocarbones
Synonyms	Gas de cocina - Gas licuado de petróleo
Ingredients	Propane Butane Ethane Penthane

IDENTIFICATION OF HAZARDS

Main hazards

Physical and chemical hazards	Flammable gas
Specific hazards	Suffocating and flammable gas

Product effects

Adverse effects on human health	Suffocating product
Major Synthoms	Inhalation may cause dizziness.

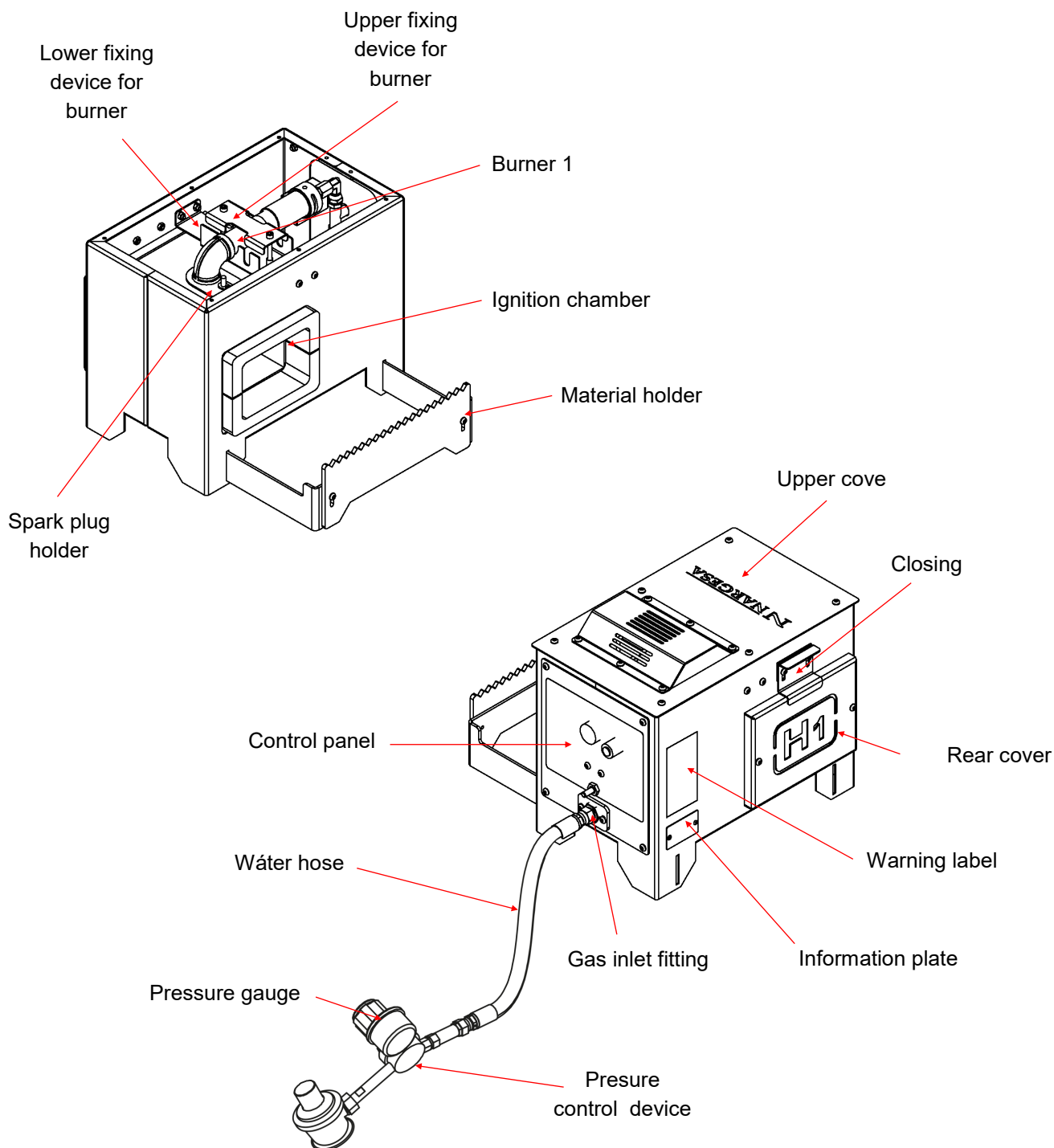
MEASURES TO FIGHT FIRES

Proper fire extinction means	Water mist, chemical dust and carbón dioxide (CO2).
Specific hazards	It could be lit with heat, sparks or flsmess. Steams could travel up to the ignition source and return like flames. Keep out of container tanks.
Special methods	Remove containers from the fire zone, if this could be a riskless fact. Spray with wáter mist the containers exposed to fire. This devide should be remotely controlled, and so after the fire extinction. Fight the fire aains the wind direction, whenever it is posible. Do not extin-guish fire before stopping the leak. In case the fire is intense in loa-ded areas, use hoses with holders to be used remotedly. Then if thi could not be done, just leave the área and let it burn.
Special Protection to fight against fires.	In closed places, use complete protection against fire and auto-nomous equipment to protect the respiratory tract.

WARNING!

**Consult your supplier's gas safety data card, before its use.
Strictly follow your supplier's safety protocols.**

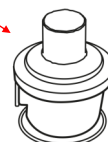
1.5. Identification of elements



The **Adapter** for the gas bottle is NOT provided along with the furnace because of the major differences according to each country.

The Adapter must be equipped with a male thread 21,8 left.

Adapter

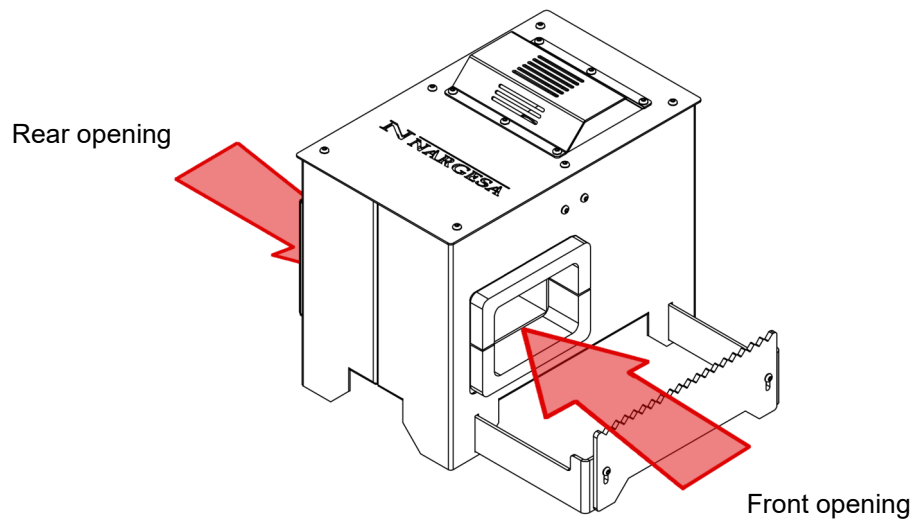


1.6. Description of elements

1.6.1. Openings

The furnace has two openings:

- The front opening is the one usually used.
- Rear opening is used to heat longer bars. If we want to heat a larger length of bar we will open only a rear opening. If we want to heat an intermediate part of the bar we will open the two lateral openings of the oven so that the bar can pass through the inside of the oven and thus be able to heat the desired part

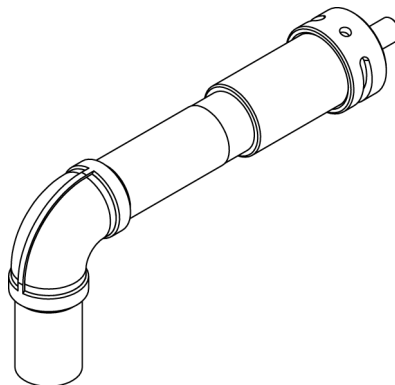


Picture 2. Furnace openings

1.6.2. Burners

The burners of Nargesa's Furnaces has been manufactured by Nargesa and designed exclusively to be used on the furnaces H1, H2 and H3.

- Type of burner: Atmospheric
- Maximum supply pressure: 1,5 Bar
- Fuel: Propane gas GLP
- Power: 4 Kw



Picture 3. Furnace burner

1.6.3. Thermocouple

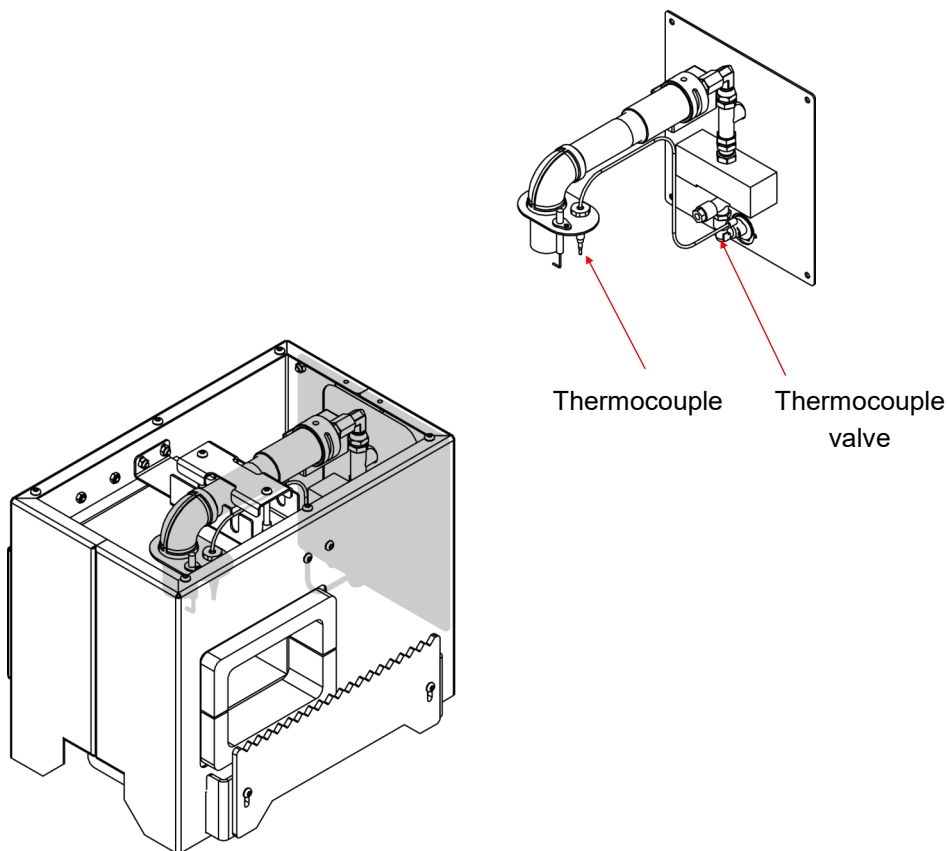
The thermocouple is the sensor to measure the temperature. It consists of two different metals, joined at one end. When the union of the two metals is heated or cooled, it produces a voltage proportional to the temperature which causes the safety valve to open or close.

The thermocouple safety valve consists of two parts: The valve and the thermocouple

The valve is equipped with the **Thermocouple pushbutton** for ignition of the furnace.

In the process of ignition of the furnace we press this button to allow the passage of gas. When the thermocouple gets enough temperature, we will release this pushbutton and the gas will continue to pass through the valve. This valve will remain open while the oven is in operation and the thermocouple will keep the working temperature.

Once the oven is switched off, and in a time interval of less than 2 minutes, the thermocouple cools and stops acting on the closing safety valve, thus preventing the passage of gas



Picture 3. Thermocouple set

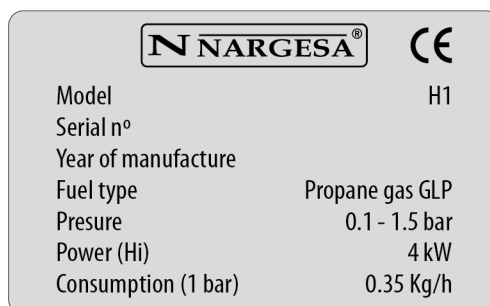


Figura 4. Placa de características

1.7. Main features

Dimensions of combustion chamber	140x236x100 mm
Maximum temperature	1300 °C
Nr of burners	1
Type of fuel	Propane gas (GLP)
Adjustable working pressure	0,1-1,5 bar
Power (Hi)	4 kW
Gas intake as 1 per bar	0,35 Kg/h
External dimensions	310x450x370 mm
Weight	27 Kg

2. TRANSPORT AND STORAGE

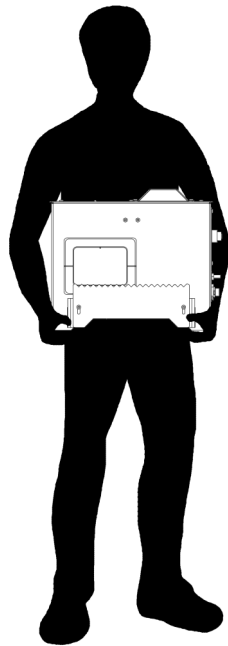
2.1. Transport

The transport of the furnace must be done by its lower side. Lifting it upwards with both hands.

Do not transport the furnace in any other way since it could be damaged.

WARNING:

In order to move the gadget it is necessary that burner are OFF and wait 24 hours to make sure the isolating material is at room temperature.



Picture 5. Transport of the machine

2.2. Storage conditions

The furnace cannot be stowed in a place that does not meet the following requirements:

- Humidity between 30% and 95%
- Temperature from -25 to 55°C or 75°C for periods not exceeding 24 hours 24h (keep in mind these temperatures are for storage conditions)
- Do not pile machines or any other objects on top of it.
- Do not dismantle for stowing

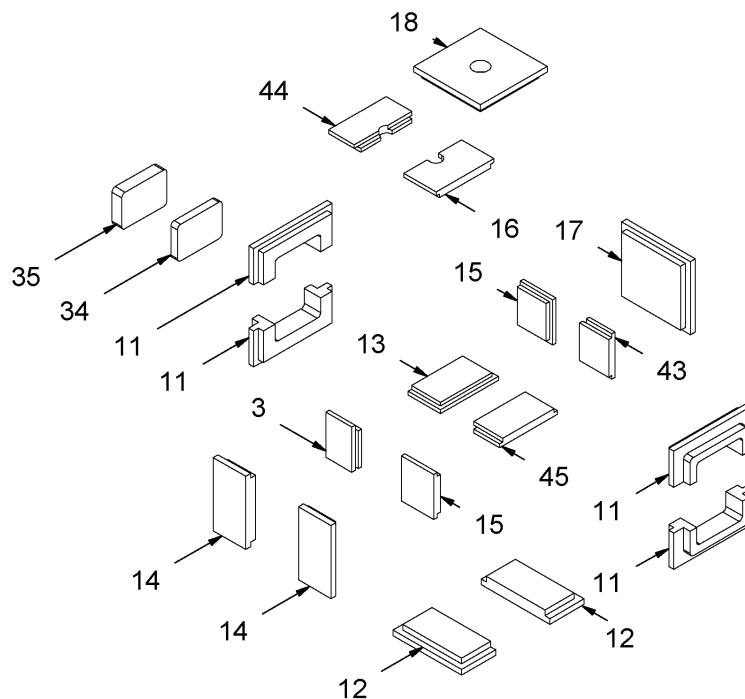
3. MAINTENANCE

3.1. General Maintenance

- It is recommended to keep the **Combustion chamber** clean, as far as possible, to ensure proper operation and thus prolong the useful life of the insulating material.
- It is recommended to check the status of the thermocouple, the ignition device, the gas valve, the regulator and the non-return valve. If any of these elements suffers any type of deterioration, contact the Nargesa technical service.
- It is required the replacement of the thermocouple, the ignition device, the gas valve, the regulator and the non-return valve every 5 years.
- It is recommended to replace the insulating material every 2000 hours of operation.

WARNING:

To proceed with the maintenance of the oven it is necessary to turn off the **Burner** and wait 24 hours to ensure that all the components are at ambient temperature.



Picture 6. Insulating kit

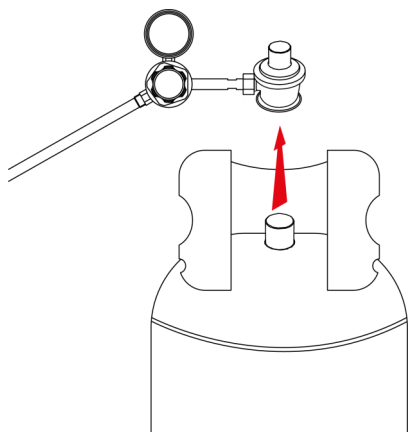
3.2. Change of the insulating material of the oven

To remove the insulating material from the oven we will follow the following instructions:

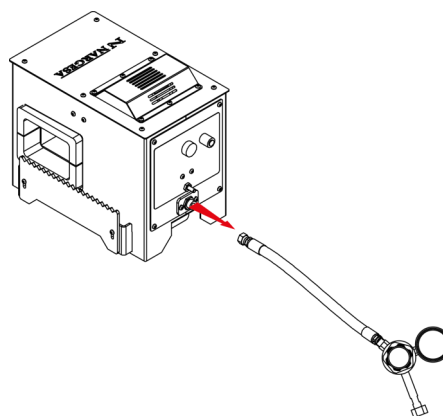
WARNING:

To proceed with the change of insulating material it is necessary to turn off the **Burner** and wait 24 hours to ensure that the insulating material is at room temperature

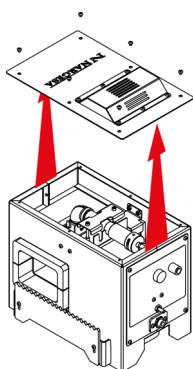
1. Disconnect the gas bottle from the oven.



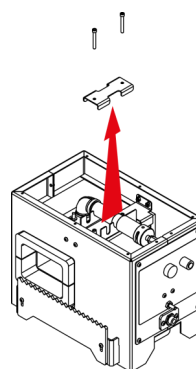
2. Disconnect the **Gas hose** from the **Inlet fitting**



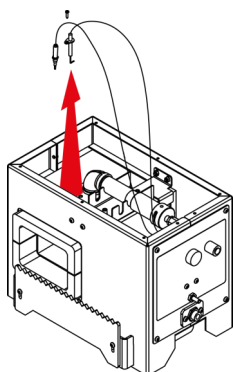
3. Remove the **Upper cover** by unscrewing the six bolts.



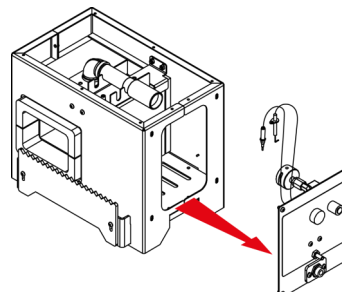
4. Remove the **Upper setting** of the burner



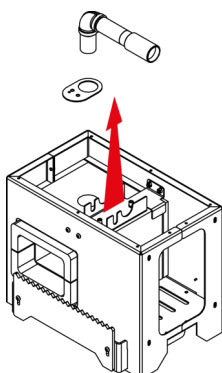
5. Remove the thermocouple and the spark plug by pull away the bolt



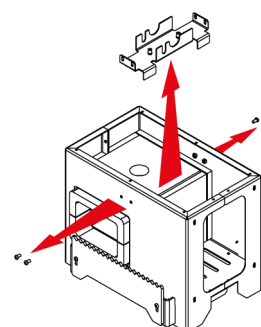
6. Take off the 4 bolts and nuts that hold the **Control Panel**. Remove the **Control panel**, the thermocouple and the spark plug



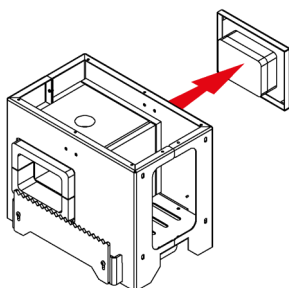
7. Remove the **Burner** and the **Spark plug holder**



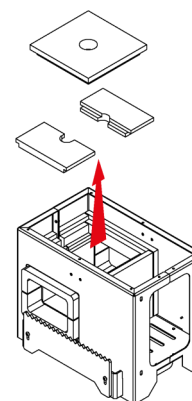
8. Dismantle the **Lower fixing of the burner** by unscrewing the four bolts and the four nuts that hold it.



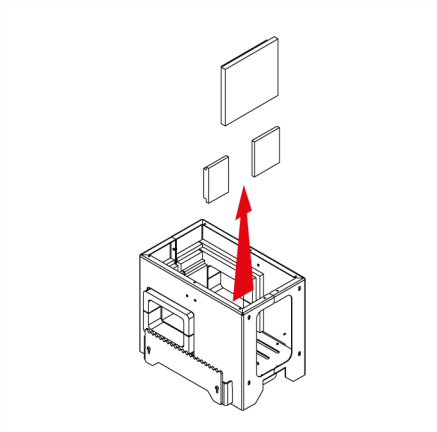
9. Remove the **Rear cover** following the instructions on Section 5.5



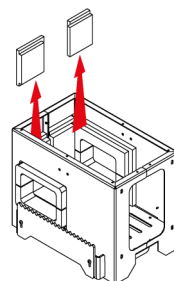
10. Take off the insulation upper plates.



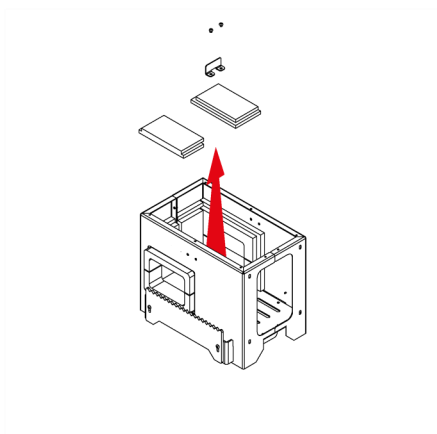
11. Remove the side insulation panels



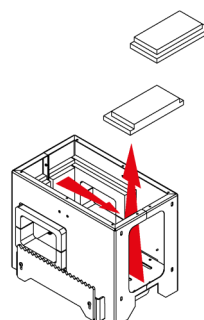
12. Remove the holders



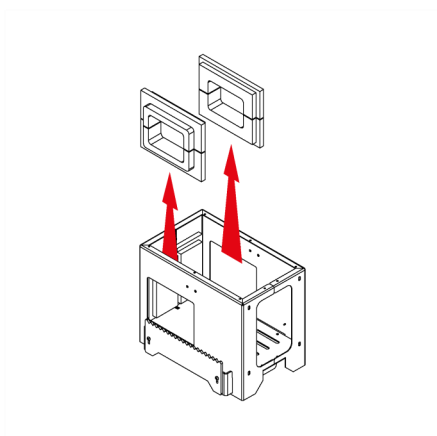
13. Remove the lower insulation and the holder of right side insulations



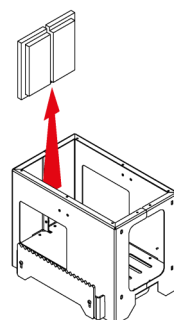
14. Slide the lower insulation towards the back part of the furnace and remove them by the upper side.



15. Remove the front and rear insulations

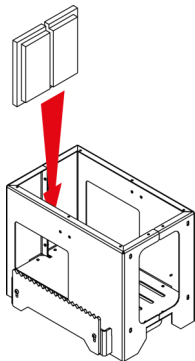


16. Remove the side insulations

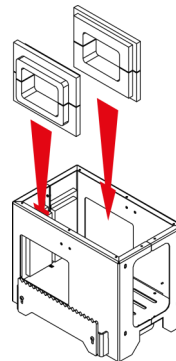


We will use this process in reverse order to do the placement of the insulation:

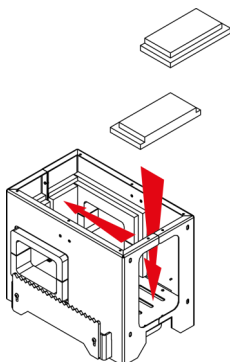
1. Place the side insulation



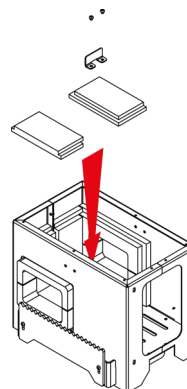
2. Place the front and rear insulations



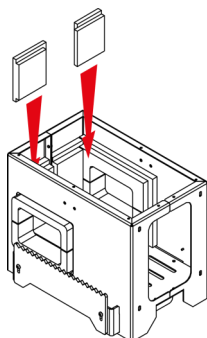
3. Place the lower insulation by the upper/ right side of the furnace and slide them towards the front part.



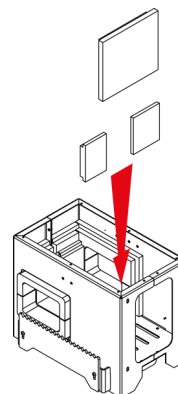
4. Place the lower insulation and the holder of right side insulations



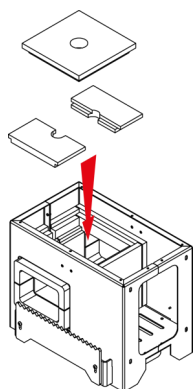
5. Place the side insulation



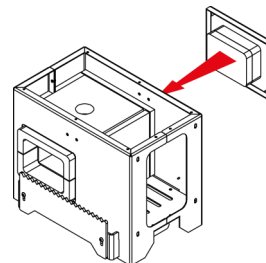
6. Place the side insulation



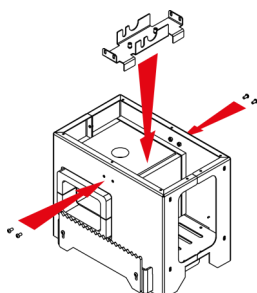
7. Place the side insulation



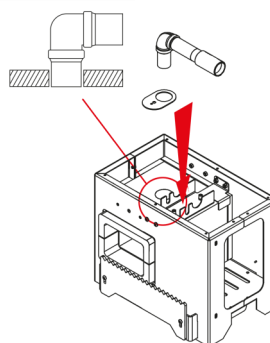
8. Place the **Rear cover**



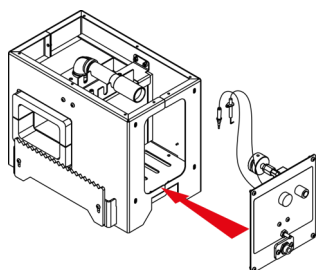
9. Assemble the **Lower fastener of the burner** by tightening the four screws and the four nuts that hold it



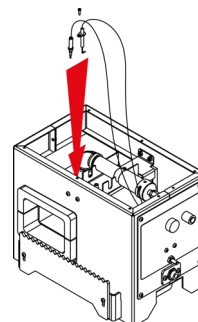
10. Place the **Spark plug holder** and the **burner** adjusting the **Lower burner fixer** so that the end of the **Burner** is aligned with the lower part of the insulator



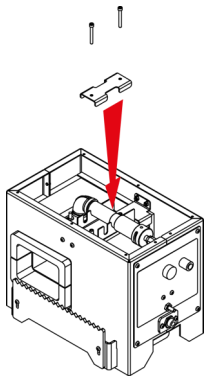
11. Place the **Control panel** by fixing the bolts and nuts.



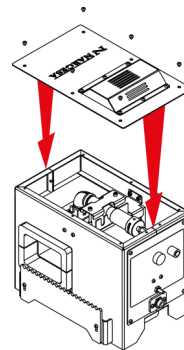
12. Place the spark plugs and the thermocouple



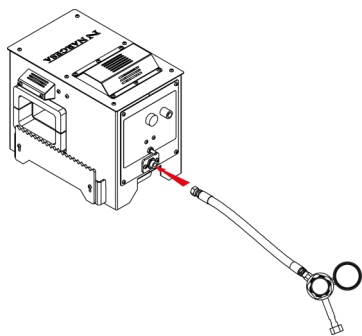
13. Mount the **Upper fixer of the burners**



14. Place the **Upper cover** by fixing the 6 bolts

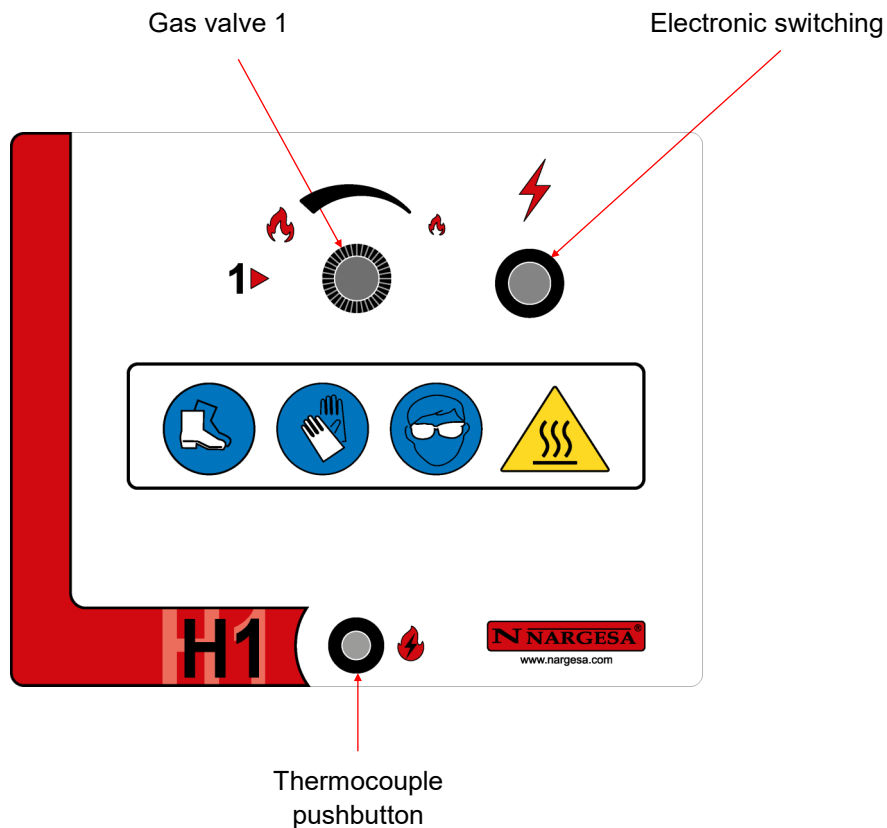


15. Connect the **Gas Hose** to the **Inlet racor**



4. HANDLING MANUAL

We have a **Control panel** which will allow us to control the performance of the furnace H1 and which will enable us to maintain complete control of the machine in a simple and intuitive way.



4.1. Gas valve

The **Control panel** has got one valve for the opening of the gas entrance to the **Burner**. This valve is marked with number 1. The operator controls them in order to obtain more or less gas flow.

4.2. Pushbuttons

There are two pushbuttons in the **Control panel**:

- The pushbutton for **Electronic switching** is the one that activates the spark plug and generates the spark to light up the **Burner**.
- The **Thermocouple pushbutton** is the one that opens the valve to get the thermocouple activated. This valve opens the path to the **Gas valve 1**

4.3. Pressure regulator and manometer

The **Pressure regulator** allows us to control the working pressure between 0,1 and 1,5 bar, Nargesa suggests to work at a pressure from 0,2 to 1 bar. The **Manometer** will indicate the pressure value on the furnace circuit.

5. INSTALLATION AND SET UP

5.1. Machine location

The aim is to locate the furnace properly to avoid having to move it; otherwise, the user must follow the guidelines described in the transport section (n°2). It should be placed on a smooth and levelled surface to avoid any movement of it during the positioning of the profiles.

5.2. Dimensions y work area

5.2. Dimensions and work area

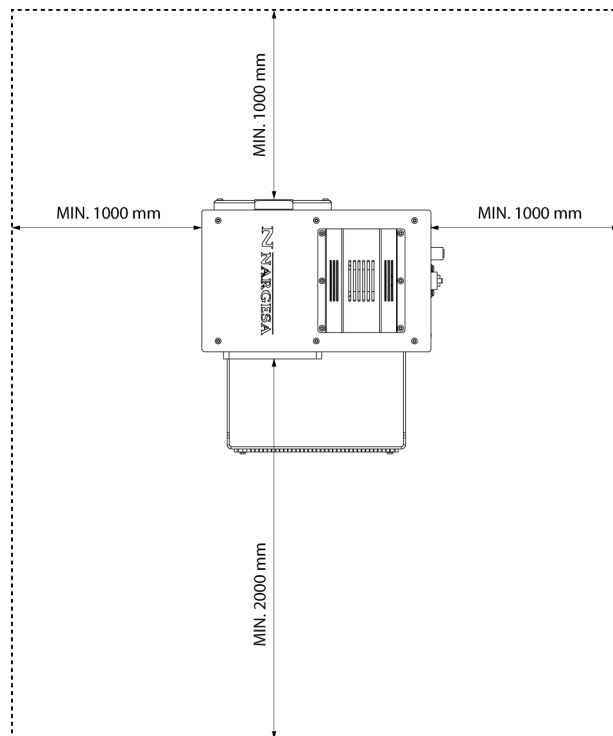
When the furnace is placed, its dimensions, the safety zone, the work area of the operator and the possible lengths of the workpiece will be taken into account.

Safety zone: We will place the furnace in a zone free of elements and objects, following the indications of the following figure.

The oven will be installed in accordance with the regulations in force and will be used only in sufficiently ventilated places.

The oven can be used by a single operator, which must be work frontally or laterally to the machine to be able to handle the piece safely.

Before starting the heating of the pieces, with the **Burner** off, the operator will adjust the **material support**, adapting it to the material profile and its length, as indicated in section 5.6.



Picture 7. Safety zone

5.3. Admissible outside conditions

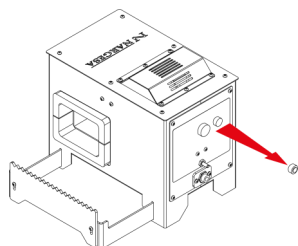
- Normal temperatura between +5 and +40°C without exceeding an average temperature of +35°C during 24h.
- Relative humidity between 30% and 95% without condensation.

5.4. Setting up

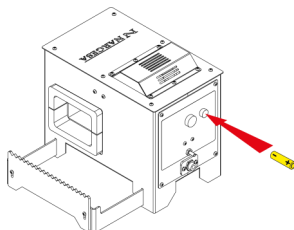
Before putting the furnace into operation:

- Inserting the automatic ignition battery.

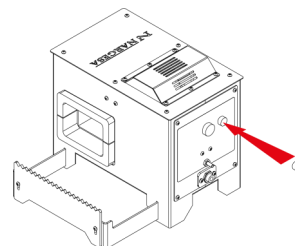
1. Unscrew the Automatic ignition button (⚡) located on the control panel.



2. Insert the battery into the hole so that its positive end is on the outside.



3. Tap tight the Automatic ignition button.



- Connect the **Pressure regulator** to an **Adapter** for the gas cylinder. This adapter is not supplied with the furnace , as this element is different in each country.
- Verify that the maximum gas inlet pressure is less than 25 bars.
- Connect the Adapter to a LPG propane gas cylinder

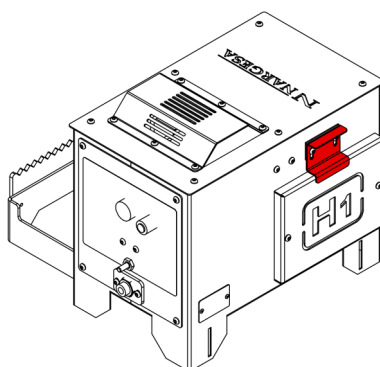
The **Pressure Regulator** and **Gas Hose** supplied by Nargesa will always be used

5.5. Opening

There are one rear opening to work with longer materials.

To remove the **Door**, move the **Lock up** and pull the **Door** out of position. Leave the Closure in its original position.

To place the **Rear door**, move the **Latch upwards** and place the **Door** in the rear opening, press until it stops and lower the **Latch** to its original position.



WARNING:

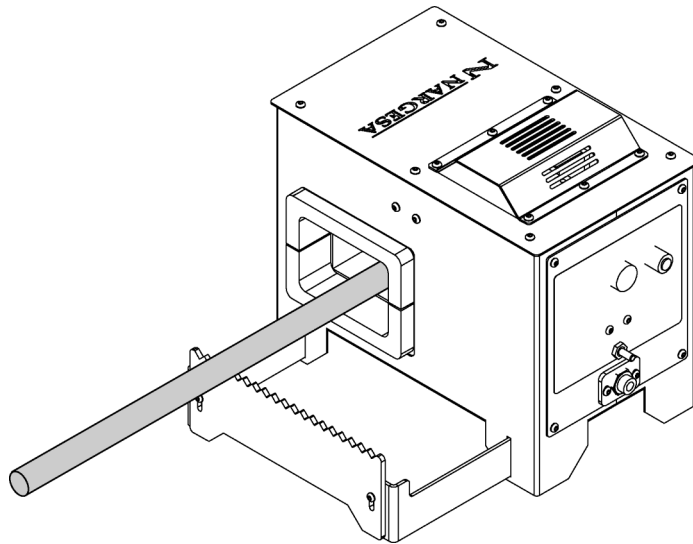
To manipulate the **Side doors** it is necessary to turn off the **Burners** and wait 24 hours to make sure that the insulating material is at room temperature

5.6. Adjustment of the material support position

The oven is equipped with a **Material holder**, this support serves to hold the material while warming up.

The support point of the material can be regulated by moving the support. The point of support must be adjusted according to the length of the material. For material lengths bigger than 800mm, use an external support.

The **Material holder** can be placed in any of the two **Openings**.



Picture 8. Support of material

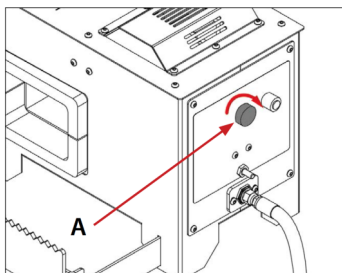
5.7. First set up of furnace

For the first start-up of Nargesa gas furnaces, the automatic ignition provided is not used. We will use an external device to light the burner flame. For example a long lighter or a blowtorch.

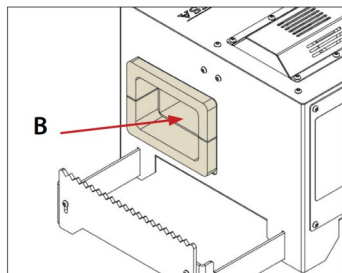
*** The Adapter (C) for the gas bottle is not supplied with this furnace, since each country uses different adapters. The Adapter will have to be equipped with a left 21.8 male thread. (L)**

To proceed to the propane furnace ignition we will follow the following steps:

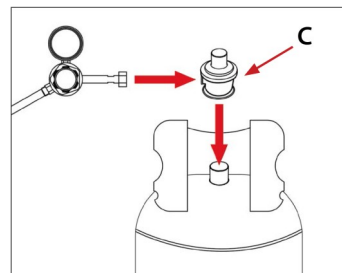
1. Check that the **Gas Valves (A)** are completely closed.



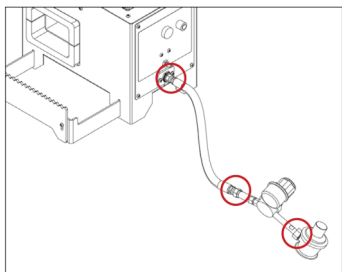
2. Check that the **combustion chamber (B)** is cleared off from any element.



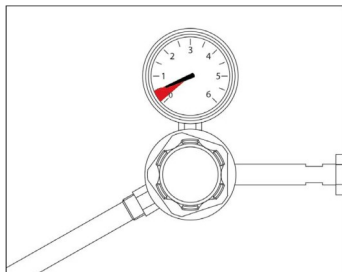
3. Connect the pressure regulator to the ***Adapter (C)**, and this to the gas bottle.



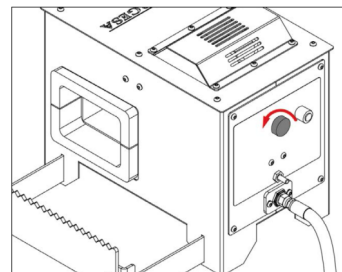
4. Verify that all gas connections between the bottle and the oven are connected correctly and that there are no leaks.



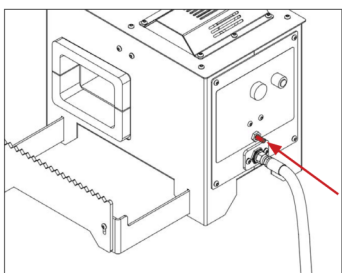
5. Check that the working pressure of the gas is between 0.2 and 0.5 bar.



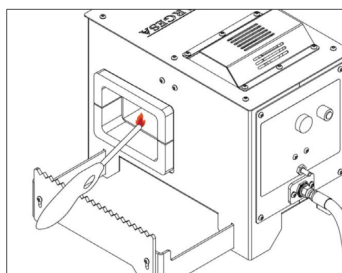
6. Open Gas Valve 1, a few degrees.



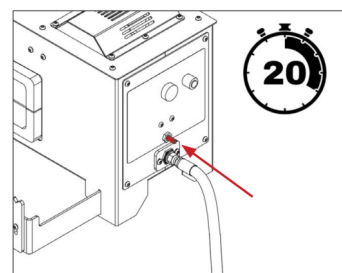
7. Press the **thermocouple button (⚡)**



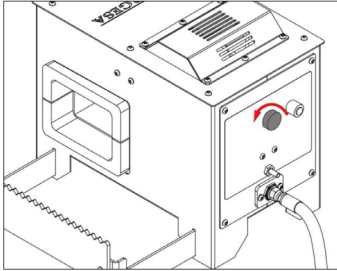
8. Turn on the gas that comes out of the burner. **Important:** never put your hands in the combustion chamber to ignite the gas.



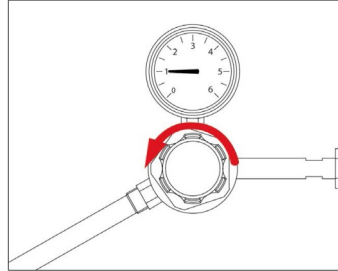
9. When the burner ignites, wait 20 seconds and stop pressing the Thermocouple button.



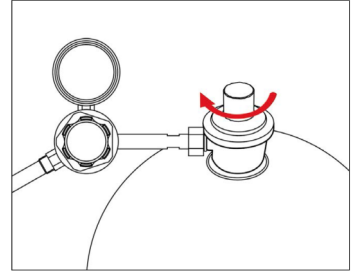
10. Open Gas Valve 1 progressively to the maximum.



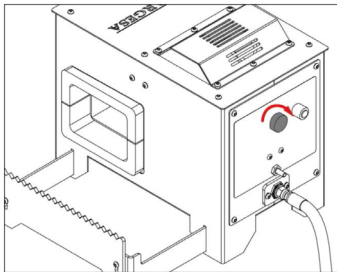
11. Increase the gas pressure progressively up to 1 bar.



12. After 30 minutes, stop the furnace by closing the gas supply of the Adapter until the flame goes out.



13. Close the gas valve.



5.8. Lighting up the furnace

To proceed with the ignition of the furnace, we'll follow the steps below:





1. Make sure all gas valves are completely closed.
2. Make sure the **Combustión chamber** is empty and free from any other element.
3. Connect the **Adaptor** to the gas bottle.
4. Verify that all gas connections between the bottle and the furnace are correctly connected and that there is no leak.
5. Checkup that the gas work pressure is between 0,1 and 1,5 bars. (Pressure recommended by Nargesa: 0,2 to 1 bar).
6. Open the **Gas valve 1**, a few degrees.
7. Press the **Thermocouple pushbutton** and the **Electronic ignition pushbutton**.
8. When the Burner lits up, reléase the **Electronic ignition button**.
9. Wait 20 seconds and reléase the **Thermocouple pushbutton**.
10. Open the **Gas valve 1** progressively 'til its limit.
11. Progressively increase the gas pressure up to 1 bar. (Pressure recommended by Nargesa: 1 bar).

5.9. Shutdown the Furnace

To proceed with the shutdown of the furnace:

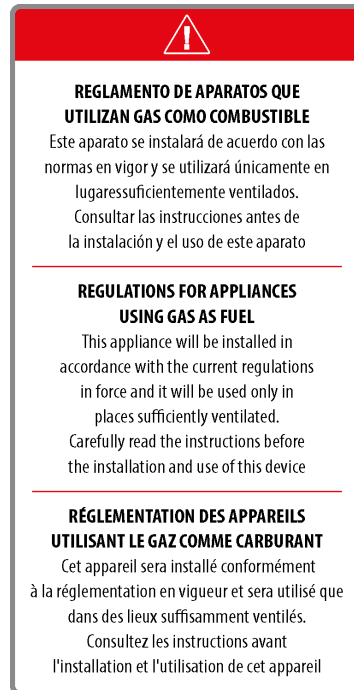
1. Turn the **Gas valve 2** clockwise until it is completely closed.
2. Disconnect the Adapter from the gas bottle.

6. POSSIBLE BREAKDOWNS

BREAKDOWN	CAUSE	SOLUTION
The furnace might not ignite	Unproper gas connections	To connect correctly the gas plug and make sure that the Adaptor of the gas bottle is properly fit. See section 5.4
	The Manometer of the Pressure Regulator shows 0	Open the Pressure regulator and the flow of the Adaptor in the gas bottle
	Gas valve 1 is closed	Open Gas Valve 1 just some degrees.
	Gas Valve 1 is way too open	Close a Gas Valve 1 a few degrees
Electronic switching does not generate the ignition spark	The spar plug is touching Burner 1	Place the spark plug 4mm away from the Burner 1
	The spark plug is more tan 4mm away from Burner 1	Place the spark plug 4mm from Burner 1
	Inner battery has been exhausted e ha agotado la pila interior	Change the inner battery (AA, 1,5v)
The flame turns to be turbulent.	Excesss of fuel in the blend of air and gas.	Reduce the amount of fuel by closing gradually the Gas Valve 1 .
		Reduce the job pressure
	The gas injector is stuck or dirty	Replace the injector
The flame turns orange	Lack of fuel in the bland of air and fuel.	Increase the amount of fuel by opening the Gas Valve 1 gradually.
	The gas injector is stuck or dirty	Replace the injector
	The air inlet is dirty	Clean up the furnace air inlet.
The flame goes out of the combustion chamber	Excessive gas pressure	Reduce the gas pressure
<p>If the problem goes on, please contact our technical assistance in Nargesa</p> <p>  +34 972568085  +34 620446827  sat2@nargesa.com  sat2.nargesa </p>		

7. WARNINGS

The H1 furnace is designed so that the operator can adjust the machine and heat the necessary parts with total safety. Any modification of the machine will alter the security that it offers, breaching the certificate of conformity and being able to generate irreparable personal and material damages. Carefully read the **Warning label** on the rear side of the furnace.



7.1. Waste hazards

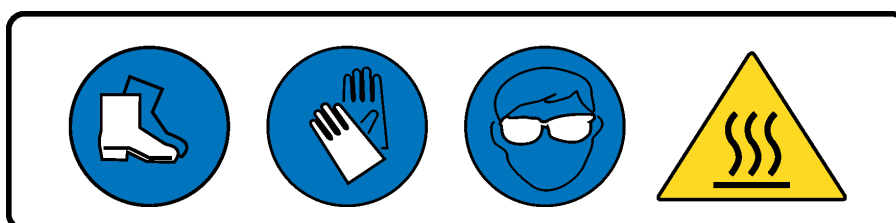
During the heating of materials some danger situations might occur, which need to be analyzed and prevented.

- Be carefull while introducing and removing material in the machine, in order to prevent any burnt or injury.
- Firmly hold the piece to be inserted or removed to avoid unwanted movements due to the weight of the piece.
- Hold the material by the cold end, never by the hot zone
- Maintain a safe distance between the machine and the operator

7.2. Protection elements for the operator

Like elemnts of personal protection, it is mandatory:

- Utilizar gafas y botas de protección homologadas
- To wear thermal gloves for handling the machine and all along the heating processes.
- To wear homologated and approved protective googles and shoes.



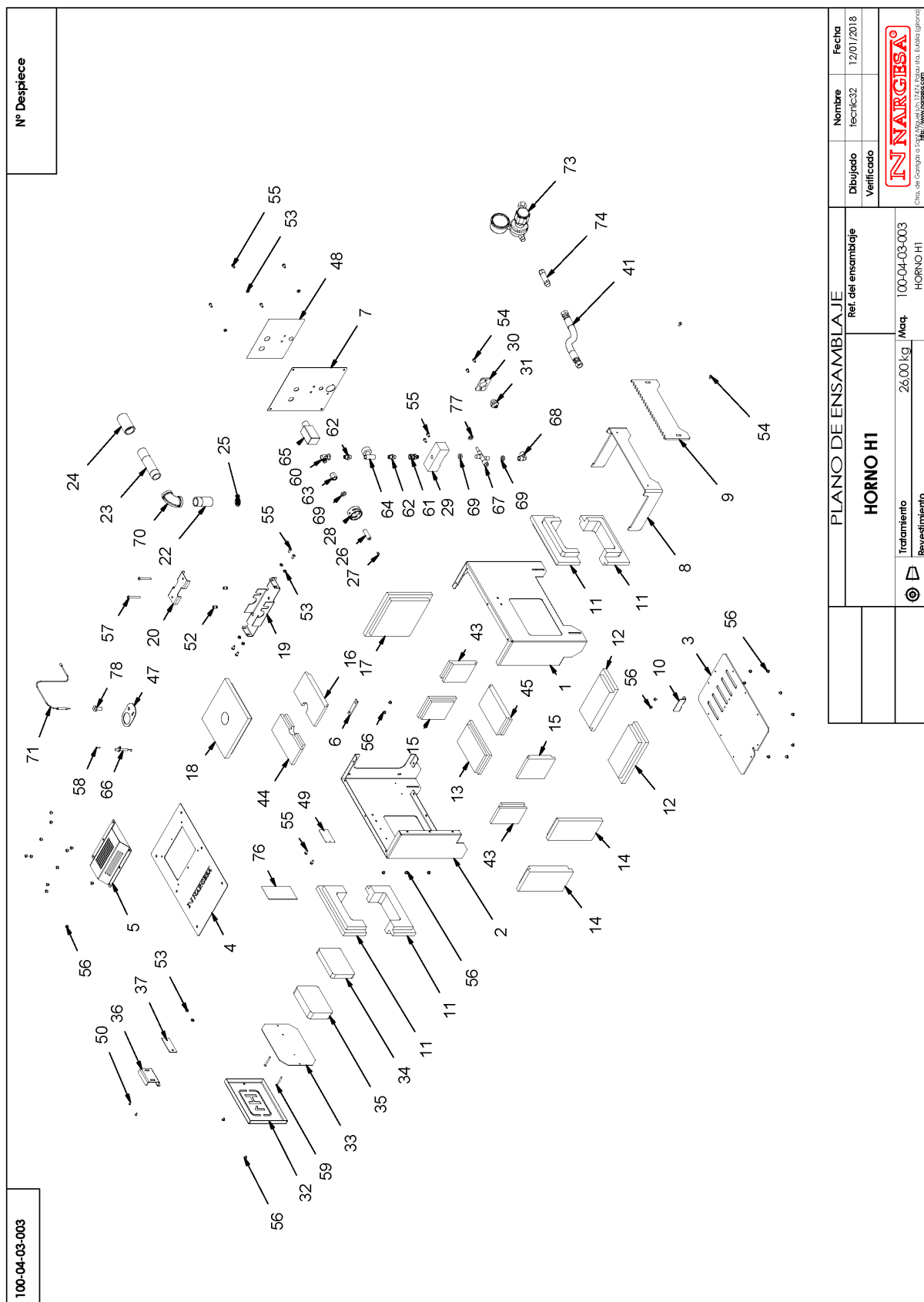
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

















Horno H1


List of parts















Gas layout
















List of parts



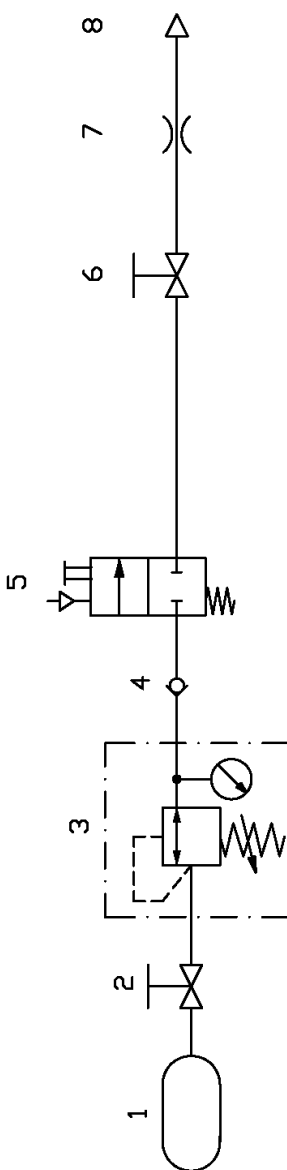



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1		LATERAL 1	120-04-03-00048	1
2		LATERAL 2	120-04-03-00002	1
3		BASE	120-04-03-00003	1
4		TAPA SUPERIOR	120-04-03-00004	1
5		CAPOTA	130-04-03-00001	1
6		POSICIONADOR	120-04-03-00006	1
7		TAPA REGULACION	120-04-03-00007	1
8		SOSTEN MATERIAL	120-04-03-00008	1
9		FRONTAL SOSTEN	120-04-03-00009	1
10		TOPE AISLANTE	120-04-03-00021	1
11		AISLANTE PUERTA	120-04-03-00011	4
12		AISLANTE INFERIOR 30	120-04-03-00012	2
13		AISLANTE INFERIOR 20 1	120-04-03-00013	1
14		AISLANTE FRONTAL 30	120-04-03-00014	2
15		AISLANTE FRONTAL 20 1	120-04-03-00015	2
16		AISLANTE SUPERIOR 20 1	120-04-03-00016	1
17		AISLANTE POSTERIOR 30	120-04-03-00017	1
18		AISLANTE SUPERIOR 30	120-04-03-00018	1

Nº ORDEN	DIBUJO	DESCRIPCION	Nº PLANO	PIEZAS POR MAQUINA
19		SOPORTE SUPERIOR	120-04-03-00019	1
20		TAPA SUPERIOR QUEMADOR	120-04-03-00020	1
22		TOBERA QUEMADOR	120-04-01-00122	1
23		TOBERA LARGA QUEMADOR	120-04-01-00123	1
24		TOBERA VENTURI	120-04-01-00124	1
25		DIFUSOR	120-04-01-00125	1
26		SOPORTE INYECTOR	120-04-01-00126	1
27		INYECTOR	120-04-01-00127	1
28		REGULADOR CAUDAL AIRE	120-04-01-00128	1
29		COLECTOR GAS	120-04-03-00029	1
30		ANTIROTACION ENTRADA GAS	120-04-01-00130	1
31		RACOR ENTRADA GAS	120-04-01-00131	1
32		PUERTA LATERAL	120-04-03-00032	1
33		CUBRE CHAPA PUERTA LATERAL	120-04-01-00133	1
34		AISLANTE PUERTA LATERAL 20	120-04-01-00134	1
35		AISLANTE PUERTA LATERAL 30	120-04-01-00135	1
36		FIJACION PUERTA LATERAL	120-04-01-00136	1
37		SEPARADOR FIJACION PUERTA	120-04-01-00137	1

Nº ORDEN	DIBUJO	DESCRIPCION	Nº PLANO	PIEZAS POR MAQUINA
41		MANGUERA GAS METALICA	120-04-01-00141	1
43		AISLANTE FRONTAL 20 2	120-04-03-00043	2
44		AISLANTE SUPERIOR 20 2	120-04-03-00044	1
45		AISLANTE INFERIOR 20 2	120-04-03-00045	1
47		SOPORTE BUGIA	120-04-03-00047	1
48		CALCA H1	122-04-03-001	1
49		PLACA CARACTERISTICAS	122-04-01-002	1
50		REMACHE DE CLAVO DIN 7337 De Al Ø3x8	020-D7337-3X8	2
52		TUERCA REMACHABLE RANURADA M6	020-D9316Z-M6	2
53		TUERCA DIN 934 M6	020-D934-M6	10
54		TORNILLO ISO 7380 M6X10	020-I7380-M6X10	4
55		TORNILLO ISO 7380 M6X12	020-I7380-M6X12	12
56		TORNILLO ISO 7380 M6X6	020-I7380-M6X6	31
57		TORNILLO ISO 7380 M6X50	020-I7380-M6X50	2
58		TORNILLO DIN 7981 Ø3.5X16 CABEZA ALOMADA PHILIPS	020-D7981-3C5X16	1
59		TORNILLO DIN 7505 Ø4x40 CABEZA AVELLANADA PHILIPS	020-D7505-4x40	2
60		CODO 90º MACHO HEMBRA TL 1/4"	040-CMH-00003	1
61		RACOR GIRATORIO MACHO HEMBRA 1/4"	040-RG-00002	1

Nº ORDEN	DIBUJO	DESCRIPCION	Nº PLANO	PIEZAS POR MAQUINA
62		RACOR 1/4" MACHO MACHO	040-RMM-00002	2
63		SUPLEMENTO HEMBRA FIJO 1/4	040-SHF-00002	1
64		VALVULA AGUJA H-H 1/4	041-GAS-00001	1
65		ENCENDIDO ELECTRONICO H1	041-GAS-00015	1
66		BUJIA DE ENCENDIDO	041-GAS-00003	1
67		VALVULA SEGURIDAD TERMOPAR M-M 1/4	041-GAS-00004	1
68		CODO H-H 1/4	041-GAS-00005	1
69		TUERCA ESTRECHA 1/4"	041-GAS-00006	3
70		CODO 90° INOX 316 H-H 1"	041-GAS-00007	1
71		TERMOPAR	041-GAS-00008	1
72		CABLE ENCENDIDO	041-GAS-00009	1
73		REGULADOR DE PROPANO	041-GAS-00010	1
74		VALVULA ANTIRRETORNO DE PROPANO	041-GAS-00011	1
75		TUERCA TERMOPAR M8X1	041-GAS-00012	1
76		CALCA ADVERTENCIAS	122-04-01-003	1
77		TUERCA SOPORTE TERMOPAR	041-GAS-00014	1
78		SEPARADOR TERMOPAR	120-04-01-00157	1

Gas layout

	Nº Despiece																																																		
<div></div> <div><p>1- Bombona de gas</p><p>2- Válvula adaptador bombona de gas</p><p>3- Regulador presión</p><p>4- Válvula antiretorno</p><p>5- Válvula seguridad termopar</p><p>6- Válvula regulación caudal</p><p>7- Inyector</p><p>8- Tobera salida gas</p></div>																																																			
<table border="1"><tr><td colspan="2">ESQUEMA GAS HORNO H1</td><td>Ref. Num.</td><td>Und.</td><td>Nº Desp.</td><td>Nombre</td><td>Fecha</td></tr><tr><td colspan="2"></td><td></td><td></td><td>Dibujado</td><td>Técnico 32</td><td>22/01/2018</td></tr><tr><td colspan="2"></td><td></td><td></td><td>Verificado</td><td></td><td></td></tr><tr><td colspan="2">Material</td><td colspan="2">Medida corte</td><td colspan="3">min</td></tr><tr><td colspan="2">Revestimiento</td><td colspan="2">Tratamiento</td><td colspan="3"></td></tr><tr><td colspan="2">Color</td><td colspan="2">Peso</td><td colspan="3">Tol. generoMaq.</td></tr><tr><td colspan="2"></td><td colspan="2">HORN H1</td><td colspan="3"></td></tr></table>			ESQUEMA GAS HORNO H1		Ref. Num.	Und.	Nº Desp.	Nombre	Fecha					Dibujado	Técnico 32	22/01/2018					Verificado			Material		Medida corte		min			Revestimiento		Tratamiento					Color		Peso		Tol. generoMaq.					HORN H1				
ESQUEMA GAS HORNO H1		Ref. Num.	Und.	Nº Desp.	Nombre	Fecha																																													
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		HORN H1																																																	
<p>Este plano es propiedad de Prada Nargesa SL. No podrá ser reproducido, comunicado o utilizado para otro fin que no sea el acordado sin su permiso escrito.</p>																																																			

OUR RANGE OF MACHINERY



IRON WORKERS



SECTION BENDING
MACHINES



NON-MANDREL
PIPE BENDER



HORIZONTAL PRESS
BRAKE



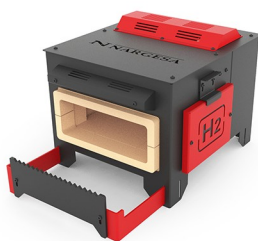
TWISTING/SCROLL
BENDING MACHINES



HYDRAULIC PRESS
BRAKES



HYDRAULIC SHEAR
MACHINES



GAS FORGES



IRON EMBOSSING
MACHINES



END WROUGHT IRON
MACHINES



BROACHING
MACHINES



POWER HAMMERS



PRESSES FOR LOCKS