

HIGH TEMPERATURE FURNACES

Full power



Over the past few years, customers have come to place more stringent demands on modern high temperature furnaces. Today, safety, economic viability and reliability are just as important as the quality of overall performance.

A broad spectrum of applications, extensive and practical accessories, and the potential to quickly and flexibly meet the diverse requirements of quality conscious users – these are the principles underlying Kendro's product philosophy. As a result, we manufacture powerful, sturdy furnaces that require little energy and operate with low outside surface temperatures.

Heraeus® High Temperature Furnaces are optimally equipped for many demanding applications. They operate at rated temperatures between 750 and 1300 °C and have work space volumes between 3.5 and 55 litres.

Emphasis is placed on safety: work space doors are designed so that the hot interior surface of the door always faces away from the user. All poles of the heating system are disconnected when the door is opened. Furnaces are equipped with an upper limit cut-out which automatically switches off heating in the case of overtemperature.

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M 104 Muffle Furnace 03

Rated temperature up to 1000 °C, 3.5 litre work space.
Unit is equipped with an abrasion resistant annealing chamber and requires a minimum of space.
Common applications: incineration, baking, annealing and analysis. For analytical processes requiring extreme purity, the unit can be fitted with a glazed annealing muffle.

K 114 Chamber Furnace 03

Rated temperature up to 1100 °C, 3.5 litre work space.
Compact unit with short heating-up times.
Common applications: heat treatment of metals, material testing, baking and incineration.

M 110 Muffle Furnace 05

Rated temperature up to 1100 °C, 9 litre work space.
Common applications: incineration and annealing processes, test baking, heat treatment of metals, material testing.

Tube furnaces and controllers 07

Rated temperatures from 1100 to 1300 °C,
cylindrical work space, available in 5 sizes.
Common applications: analytical incineration, annealing, work with protective gas.

K 750 Air Circulation Furnace 09

Rated temperature to 750 °C, available in 2 sizes.
Applications: tempering, sintering and annealing of metals.
Tempering processes requiring utmost temperature accuracy.

K 1250 Chamber Furnace 10

Rated temperature: 1150 or 1250 °C, available in 2 sizes.
Applications: heat treatment of metals, material testing.

K 1253 Kat Chamber Furnace 11

Rated temperature: 1250 °C.
High temperature furnace with catalytic post-combustion:
e.g. incineration of organic materials.
Vapours and gases generated during processing are delivered to a catalytic converter.

M 104 MUFFLE AND K 114 CHAMBER FURNACE



◀ M 104 Muffle Furnace with Thermicon P temperature controller and upper limit cut-out

The Heraeus® M 104 Muffle Furnace and the Heraeus® K 114 Chamber Furnace are ideal for routine high temperature laboratory applications such as incinerating, annealing, baking, pre-heating and drying.

The right furnace for your particular needs.

The M 104 Muffle Furnace operates at a rated temperature of 1000 °C and is ideal for analysis purposes and annealing loss determination. Thanks to its sturdy annealing chamber made of abrasion resistant ceramic, the M 104 provides excellent protection against contamination for your valuable samples.

The M 104 G with glazed annealing muffle is ideally suited to analytical processes which demand extreme purity. Not only does this muffle furnace protect your valuable samples from impurities, but it also safeguards the oven's heating elements from aggressive media resulting from combustion processes.

The K 114 Chamber Furnace operates at a rated temperature of 1100 °C. Its annealing chamber is made of ceramic fibre material. This ensures rapid heating-up and recovery times and outstanding temperature distribution, making the K 114 the ideal choice for burning, rapid heating processes and materials testing.

Application orientated design

M 104 Muffle Furnace and K 114 Chamber Furnace standard models are equipped with electronic controller, a digital display and an upper limit cut-out.

Several comfort models are also available with 24 hour timer, exhaust fan and/or the program controller. The door handle is located on the left side like on the standard model. It can be mounted on the right side upon request.

Trays and exhaust flue are available as accessories.



▲ The pivoting door can be used as a sample shelf; the hot surface always faces away from the user

Tilting door mechanism: the outside surface of the door can be used as a sample shelf ▶



Program controller

The Thermicon® P digital program controller, equipped with a microprocessor, permits free programming of up to 9 program steps. It also offers a set-actual-value indicator and an integrated timer for activating and deactivating heating (max. 99 hrs 59 min. per program step).

When the power is switched off, all programmed data is saved for further use.



Exhaust fan for M 104
(optional)



Exhaust flue (accessory)

Strengths

■ Environmentally friendly and economical

High quality asbestos free insulation materials guarantee negligible energy loss.

■ Temperature accuracy

High temperature accuracy with regard to space and time thanks to optimised heating system layout. This ensures the most efficient utilisation of the work space.

■ Easy handling

Samples are loaded via the patented door. The outside surface of the door also serves as a sample shelf.

■ Minimum space requirements

Thanks to their compact design, the M 104 and K 114 Laboratory Furnaces require very little space. So they can be set up under a laboratory fume hood.

■ Safety

When opening the furnace, users are protected from the hot inside surface of the door by the guided tilting mechanism. All poles of the heating system are disconnected when the door is opened.

Highly effective insulation materials keep outside surface temperatures to a minimum.

The upper limit cut-out automatically switches off heating in the case of over-temperature.

TECHNICAL DATA – M 104/K 114

		M 104	K 114
Rated temperature	°C	1000	1100
Work space volume	l	3.5	3.5
Work space dimensions	(w/h/d) mm	170/130/160	170/130/160
External dimensions	(w/h/d) mm	456/646/570	456/646/570
Weight	kg	51	36
Connected load	kW	2.5	1.7
Rated voltage	(50/60 Hz) V	230	230
No-load consumption	W	1040	690
Heating-up time	min	110	35
Temperature distribution	at centre axis	± 10	± 6
	in acc. with DIN 17052	class C	class C
External surface temperature (except furnace front and door)	°C	< 60	< 50

ORDER NUMBERS – M 104/K 114

M 104 Muffle Furnace		
Basic version with Digicon® ¹⁾ and upper limit cut-out		50040485
Comfort version with Digicon® ¹⁾ , upper limit cut-out and 24 hour timer		50040486
Comfort version with Digicon® ¹⁾ , upper limit cut-out, 24 hour timer and exhaust fan		50040487
Comfort version with Thermicon® P ²⁾ and upper limit cut-out		50040488
Comfort version with Thermicon® P ²⁾ , upper limit cut-out and exhaust fan		50040489
Economy version with Digicon® ¹⁾ , excluding upper limit cut-out		50040903
M 104 G, Digicon® ¹⁾ , 24 hour timer, glazed muffle		50047438
M 104 G, Digicon® ¹⁾ , 24 hour timer, exhaust fan, glazed muffle		50047439
M 104 G, Digicon® ¹⁾ , with adjustable fresh air supply		50051429
M 104 G, Thermicon® P ²⁾ , glazed muffle		50047440
M 104 G, Thermicon® P ²⁾ , exhaust fan, glazed muffle		50047441
M 104 G, Thermicon® P ²⁾ , with adjustable fresh air supply		50057773
M 104 with adjustable fresh air supply (for incinerating processes)		50049820

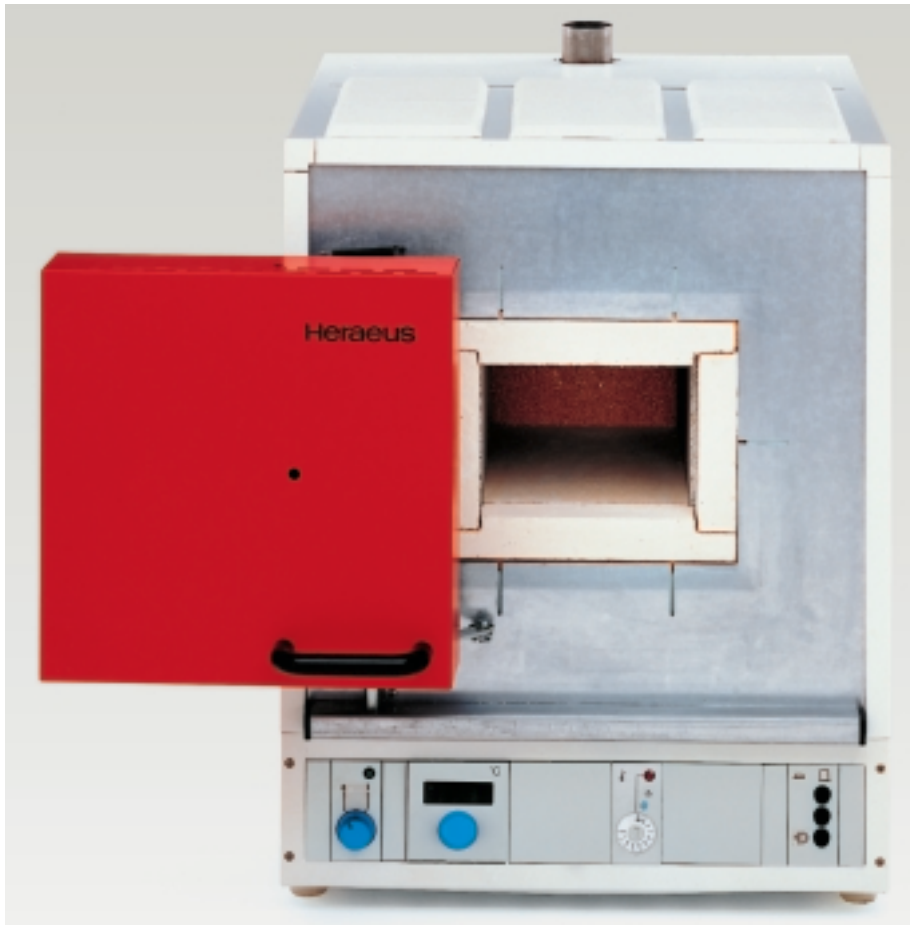
K 114 Chamber Furnace		
Basic version with Digicon® ¹⁾ and upper limit cut-out		50040491
Comfort version with Thermicon® P ²⁾ and upper limit cut-out		50040493
Comfort version with Digicon® ¹⁾ , upper limit cut-out and 24 hour timer		50040492
Economy version with Digicon® ¹⁾ , excluding upper limit cut-out		50040902
K 114 with adjustable fresh air supply (for incinerating processes)		50049812
K 114 with Digicon® ¹⁾ and exhaust fan		50047063
K 114 with Thermicon® P ²⁾ and exhaust fan		50051059

Accessories		
Exhaust flue		50040537
Tray		50040950

¹⁾ electronic controller

²⁾ digital program controller

M 110 LABORATORY MUFFLE FURNACE



M 110 Muffle Furnace with upper limit cut-out

Safety package

The M 110 is designed with a number of safety features for protection. Even at work space temperatures of 1100 °C, exterior wall temperatures in areas which are within reach of the user do not exceed 80 °C. The hinged door is designed with a parallel forced guidance system so that its hot surface always faces away from the user when the door is open.

A door safety switch with forced interruption makes sure that all poles of the heating system are disconnected when the door is opened. The adjustable upper limit cut-out offers outstanding protection for your samples and equipment. It is designed with a separate thermocouple which is independent of the main controller. This makes the furnace safe to use even during unattended operation.

The pull-out control insert makes the M 110 extremely easy to service



The general purpose M 110 Laboratory Furnace is ideally suited for incinerating, annealing and thermal analysis. It is the ideal furnace for heat treatment of metals and drying at high temperatures.

Optimal engineering

The Heraeus® M 110 Muffle Furnace has a two-shell design with an air pocket between the annealing box and the outside walls. The furnace is insulated with multiple layers of high quality, asbestos free ceramic fibre insulation. This design ensures a maximum insulation effect, economic operation and short heating-up times.

Heating elements are safely positioned in grooved blocks on the side walls of the work space and are covered with ceramic plates. The sturdy annealing chamber is therefore also suitable for demanding laboratory applications.



Flexible design

The standard version of the M 110 is equipped with an electronic PID controller and an integrated digital display. An upper limit cut-out is included as standard to protect your samples and equipment. A solid state relay (optical relay) prevents disturbing operating noises and guarantees a long service life. As an option, a variety of different programmable controllers are available.

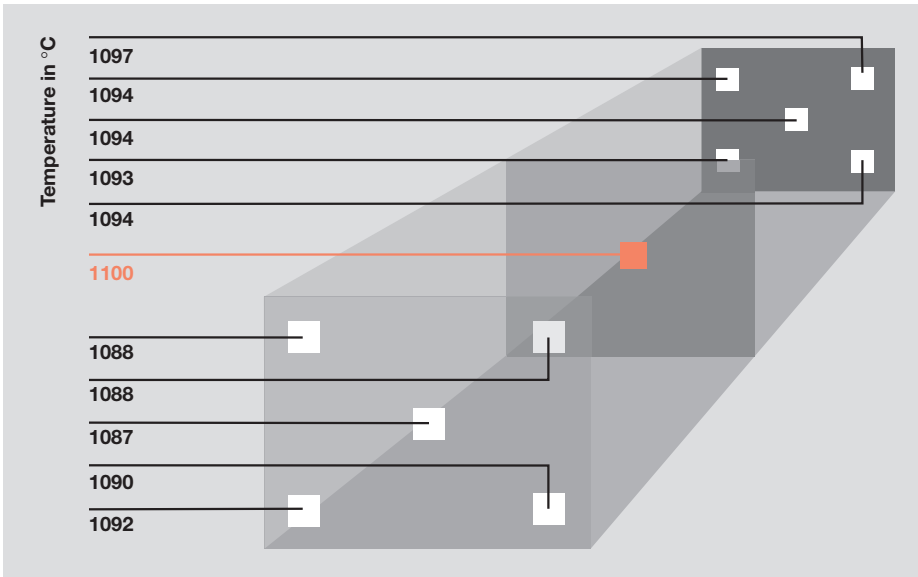
A comfort version is also available, equipped with an exhaust fan and flue. Accessories include a tray and exhaust flue.

Even heat distribution and minimum control fluctuations

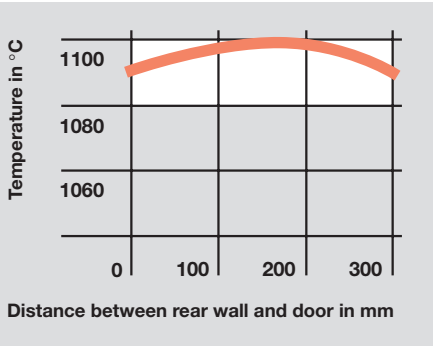
Thanks to its outstanding insulation, highly effective arrangement of the heating elements and door insulation design, the M 110 offers extremely even heat distribution in the furnace chamber.

The flexibly mounted insulation on the door ensures effective sealing of the work space.

A total of 11 measurements taken in compliance with DIN 17 052 at 1100 °C on three levels resulted in a maximum temperature deviation of 13 K (see diagram). The furnace falls well below the maximum allowable temperature deviation (20 K in Class C) of the top quality class in accordance with DIN 17 052.



▲ Spatial temperature distribution of M 110 in accordance with DIN 17 052 measuring points to door and rear wall: 30 mm, to the side walls: 20 mm



► Temperature profile of furnace's centre axis

Strengths

- Economical operation and low outside surface temperatures thanks to high quality fibre insulation.
- Excellent safety standards through parallel-guided hinged door, door safety switch, low outside surface temperatures and upper limit cut-out as standard.
- Low space requirement.
- Highly effective arrangement of heating elements for even heat distribution in the work space. Tightly sealing door with movable door insulation.
- Pull-out insert permits easy access to switching and control elements. Individual replacement of heating modules from the front of the furnace.

TECHNICAL DATA – M 110

Rated temperature		°C	1100
Total volume		l	9
Work space dimensions	(w/h/d)	mm	200/150/300
External dimensions	(w/h/d)	mm	576/752/720
Footprint area	(w/d)	mm	576/585
Weight	(ca.)	kg	78
Connected load		kW	2.9
Rated voltage	(50/60 Hz)	V	230
No-load consumption	at 1100 °C	kW	1.4
Heating-up time	to 1000 °C	min	100

ORDER NUMBERS – M 110

Model	
Basic version with Digicon ¹⁾ and upper limit cut-out	51010272
Basic version with Digicon ¹⁾ and upper limit cut-out, exhaust fan and flue	51010808
Comfort version with Thermicon ²⁾ and upper limit cut-out	51000802
Comfort version with Thermicon ²⁾ , upper limit cut-out and exhaust fan and flue	51000808
M 110 with Digicon ¹⁾ , upper limit cut-out and 24 hour timer	50057440
M 110 with Digicon ¹⁾ , upper limit cut-out, 24 hour timer and exhaust fan	50056360
Accessories	
Exhaust flue	50006394
Tray	50006408

¹⁾ electronic controller

²⁾ digital program controller

RO/ROF TUBE FURNACE AND CONTROLLERS



Heraeus® RO and ROF General Purpose Furnaces are suitable for thermal processes at temperatures up to 1300 °C – including materials testing, calibrating thermocouples and chemical and physical analysis.

Two versatile models

RO models attain a rated temperature of 1100 °C. They are equipped with heating elements on a ceramic bracing tube. The heating coils are more tightly packed at the end of the tubes to achieve an even temperature profile. A separate working tube is included.

ROF models achieve a rated temperature of 1300 °C. They are equipped with heating elements in a vacuum formed component made of high quality insulation materials. The work space is designed as a built-in ceramic tube.

Both versions are available in five sizes. The furnaces are insulated with high quality materials for short heating-up and cooling-down times.

Flexible controllers

The tube furnaces are equipped with separate high performance controllers which are perfectly suited to the special requirements of these types of furnaces. The controllers come with a Class 2 upper limit cut-out as standard. The cut-out is connected to a second thermocouple. Thermicon P, which is also included as standard, is designed with a microprocessor controlled program controller and permits users to freely program temperature processes with up to nine program steps.

The REF controllers for the ROF Furnaces come with transformers to supply the furnace with low voltage.

Versatile accessories

Accessories are available for both tube furnace versions to permit wall-mounted and vertical operation. Special types of tubes are also available, for example, for inert and flammable protective gases.

Strengths

- Minimum energy consumption, short heating-up times and low outside surface temperatures thanks to high quality insulation materials.
- Types of thermocouples:
RO models: NiCr-Ni
ROF models: PtRh 10%-Pt
- Heating elements are protected by ceramic working tubes.
- Extremely low space requirements through wall-mounted/vertical operation.
- All controllers are equipped with a Thermicon P digital program controller as standard. Eurotherm 2404/P4 and interface for data recording is available on request.
- The upper limit cut-out, included as standard, guarantees high safety for samples, equipment, operator and surroundings.



RE and REF (with transformer) controllers

TECHNICAL DATA – RO/ROF AND CONTROLLERS

Tube furnaces			RO 4/25	RO 4/50	RO 7/50	RO 7/75	RO 10/100
Rated temperature	°C		1100	1100	1100	1100	1100
External dimensions	(w/h/d)	mm	270/420/420	270/420/670	320/495/670	320/495/920	370/570/1170
Working height		mm	285	285	335	335	385
Nominal dimensions of furnace							
Nominal diameter		mm	40	40	70	70	100
Heated length		mm	250	500	500	750	1000
Nominal dimensions ¹⁾ of ceramic working tubes (enclosed)							
Inside diameter		mm	27	27	50	50	75
Length		mm	420	670	670	920	1170
Weight		kg (approx.)	17	25	33	43	80
Connected load		kW	1.0	2.0	3.0	4.5	9.0
Rated voltage	(50/60 Hz)	V	230 ~	230 ~	230 ~	400 ~ ²⁾	400 ~ ²⁾
No-load consumption at rated temperature		kWh/h	0.35	0.62	0.80	1.15	2.25

Tube furnaces			ROF 4/25	ROF 4/50	ROF 7/50	ROF 7/75	ROF 10/100
Rated temperature	°C		1300	1300	1300	1300	1300
External dimensions	(w/h/d)	mm	270/425/425	270/425/675	320/500/675	320/500/925	370/575/1175
Working height		mm	285	285	335	335	385
Nominal dimensions of furnace							
Nominal diameter		mm	40	40	70	70	100
Heated length		mm	250	500	500	750	1000
Nominal dimensions ¹⁾ of ceramic working tubes (built-in)							
Inside diameter		mm	40	40	70	70	100
Length		mm	420	670	670	920	1170
Weight		kg (approx.)	18	25	32	42	60
Connected load		kW	0.95	1.85	2.50	3.80	6.60
Rated voltage	(50/60 Hz)	V	20	40	57	86	153
No-load consumption at rated temperature		kWh/h	0.50	0.96	1.10	1.56	2.70

¹⁾ Ceramic components are subject to unavoidable production tolerances, dimensions may deviate up to +/- 5% from the nominal dimensions

²⁾ Connection between two phases

Controllers			RE 1.1. and 2.1	REF 1.1. and 2.1
External dimensions	(w/h/d)	mm	491/150/300	491/470/400
Weight		kg	13/15	52/85

ORDER NUMBERS – RO/ROF, ACCESSORY SETS AND CONTROLLERS

Tube furnace	Compatible controller	Maximum temperature in °C	Tube furnace Order no.	Accessory set ¹⁾ Order no.
RO 4/25	RE 1.1	1100	50000066	50000059
RO 4/50	RE 1.1	1100	50000000	50000059
RO 7/50	RE 1.1	1100	50000095	50000133
RO 7/75	RE 2.1	1100	50000138	50000133
RO 10/100	RE 2.1	1100	50000168	50000209
ROF 4/25	REF 1.1	1300	50000218	50000164
ROF 4/50	REF 1.1	1300	50000241	50000164
ROF 7/50	REF 1.1	1300	50000251	50000165
ROF 7/75	REF 2.1	1300	50000265	50000165
ROF 10/100	REF 2.1	1300	50000277	50000166

Controllers	Order no.
RE 1.1 with Thermicon® P and upper limit cut-out	50025154
RE 2.1 with Thermicon® P and upper limit cut-out	50025155
REF 1.1 with Thermicon® P and upper limit cut-out	50025156
REF 2.1 with Thermicon® P and upper limit cut-out	50025157

¹⁾ for wall-mounted and vertical operation

K 750 AIR CIRCULATION FURNACE



Heraeus® K 750 Furnaces can reach operating temperatures up to 750 °C and are designed with intensive air circulation for rapid, even and controlled heat transfer to samples.

Application specialists

Thanks to their excellent spatial temperature accuracy, the high temperature air circulation furnaces are ideal for controlled heat treatment of metals, especially for annealing brass, copper and aluminium, sintering PTFE components and tempering steel.

Functional design

Work space insulation is asbestos free. Furnaces are equipped with removable shelves made of heat resistant steel and are loaded through a sturdy tilting door. The outside surface of the door can also be used as a sample shelf or work surface.

K 750 Furnaces come in two sizes, with work space volumes of 19 and 55 litres for a wide range of applications.

Simple and safe

A Class 2 upper limit cut-out is included as standard and ensures protection for both samples and equipment during unattended operation.

Digital program control

The Thermicon P digital program controller, permits free programming of up to 9 program steps. It also offers a set-actual-value indicator and an integrated timer for activating and deactivating heating (max. 99 hrs 59 min per program step).

Support frames are available as accessories.

TECHNICAL DATA – K 750

			K 750/1	K 750/2
Rated temperature	°C		750	750
Usable work space volume	l		19	55
Work space dimensions	(w/h/d)	mm	250/250/300	350/350/450
External dimensions	(w/h/d)	mm	705/595/650	780/670/800
Weight	(approx.)	kg	80	160
Connected load		kW	3.4	5.4
Connected voltage ¹⁾	(50/60 Hz)	V	230	400 V3/N~
Heating-up time	to 750 °C	min	90	105

¹⁾ Other voltages available on request

ORDER NUMBERS – K 750

Model			
K 750/1	230 V~, 50 Hz	with Thermicon P, upper limit cut-out and 2 shelves	50044500
	230 V~, 60 Hz	with Thermicon P, upper limit cut-out and 2 shelves	50044520
K 750/2	400 V3/N~, 50 Hz		50044528
	230 V3~, 50 Hz		50044529

Accessories	
Support frame for K 750/1	15152500
Support frame for K 750/2	15153500

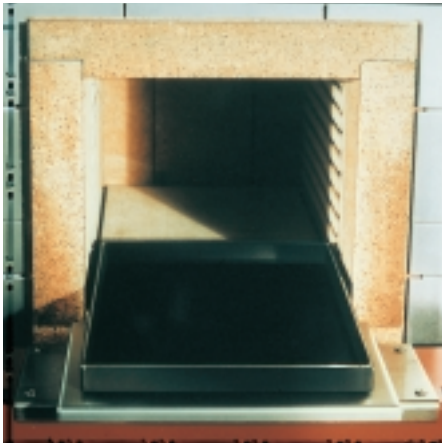
K 1250 CHAMBER FURNACE

The Heraeus® K 1250 Chamber Furnace from Kendro is optimally designed to meet stringent furnace requirements. This high performance heavy duty furnace requires very little energy and generates very low outside surface temperatures. K 1250 Chamber Furnaces are ideal for controlled heat treatment of metals, thermal analysis and high temperature drying.

K 1250 Chamber Furnaces are available in 2 sizes as K 1252 with 10.8 l total volume (covered heating: 9.2 l) and as K 1253 with 36 l total volume (covered heating: 32 l)

Application orientated models

The F models operate at a rated temperature of 1250 °C, are equipped with freely radiating heating elements and offer even temperature distribution and extremely high temperature stability. The A models are equipped with covered heating elements to protect the heating system when proces-



The K 1250 Chamber Furnace for easy operation: Tray and sample shelf are positioned at the same height.

sing certain types of substances. They achieve a rated temperature of 1150 °C.

The annealing chamber is made of ceramic grooved blocks which contain the heating coils. The base plate is made of extremely heat resistant silicon carbide.

Flexible technology

All display and control elements are modular in design. This permits easy retrofitting of the system. The temperature control system with PID regulation ensures high spatial temperature stability.

The F models operate with an analogue controller. The A models are equipped with the Thermicon P digital controller, an LED display for temperature and process status, and a timer. Users can program up to nine program steps. Circular chart recorders

which can handle various operating periods available for recording temperature.

Excellent safety

The furnaces come with an upper limit cut-out as standard.

The work space of both versions is insulated with multiple layers of fibre material. This keeps the outside surfaces of the furnace cool and ensures low energy consumption.

The hinged door is designed with a parallel forced guidance system so that the hot surface always faces away from the user when the door is open.

TECHNICAL DATA – K 1250

			K 1252		K 1253	
Design of annealing chamber			Freely radiating heating	Covered heating	Freely radiating heating	Covered heating
Rated temperature	°C		1250	1150	1250	1150
Total volume	l		10.8	9.2	36	32
Work space dimensions	(w/h/d)	mm	200/180/300	180/170/300	300/240/500	280/230/500
External dimensions	(w/h/d)	mm	830/722/800	830/722/800	930/890/1030	930/890/1030
Net weight	(approx.)	kg	113	116	180	185
Connected load		kW	4.5	4.5	12	12
Rated voltage	(50/60 Hz)	V	400 V/3 N~	400 V/3 N~	400 V/3 N~	400 V/3 N~
Alternatively	(50/60 Hz)	V	–	230 V 3~	230 V 3~	230 V 3~

ORDER NUMBERS – K 1250

Models		
K 1252 F with analogue controller and analogue display		51000083
K 1252 A with Thermicon® P		51002190
K 1253 F with analogue controller and analogue display		51000085
K 1253 A with Thermicon® P		51000839

Options		
Thermicon® P for F models		51900082
Circular chart recorder		51900094
Exhaust fan and flue with on/off control		51900190
Daily program timer to be used with analogue controller		51999995

Accessories		
Exhaust flue		50024457
Sample shelf	for K 1252	50024520
	for K 1253	50024447
Tray	for K 1252	50024514
	for K 1253	50024516
Support frame	for K 1252	50024549
	for K 1253	50024548

K 1253 KAT CHAMBER FURNACE

The Heraeus® K 1253 Kat Chamber Furnace is specially designed for incinerating organic materials.

Typical areas of application are the detection of heavy metals in food, radiation contamination in plants, residual material utilisation and thermal enamel stripping.



K 1253 Kat Chamber Furnace

TECHNICAL DATA – K 1253 KAT

Rated temperature	(max.)	°C	1150
Work space dimensions	(w/h/d)	mm	280/230/500
External dimensions	(w/h/d)	mm	930/2250/1210
Weight		kg	350
Connected load		kW	17
Rated voltage	(50/60 Hz)	V 3/N~	400

ORDER NUMBERS – K 1253 KAT

K 1253 Kat	15715008
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MORE THAN YOU EXPECT – OUR SERVICE



Our service:
A reassuring feeling

Individual

Many people talk about service – Kendro Laboratory Products brings this to life. You will notice this in the quality of our advice, which is individually geared towards your needs. Our solutions are exactly tailored to your specific needs.

We will be there for you before, during and after your purchase.

You will find us as a partner who quickly and competently assists in all matters, to include:

- calibration
- reference measurement
- application advice
- repairs
- exchange of spare parts

Other services are available on request.

For more detailed information please contact your local partner. The Kendro Service Team: a good feeling to know that this partner is at your side.

Your Sales Contact

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