

Maschinenspezifikation

Spécification de machine

Specifica macchina

Machine specification

Especificación de máquina

Kundenname	Burlington Die Casting Co
Nom du client	
Name of customer	CDN <u>Burlington / Ontario</u>
Nome del cliente	
Nombre del cliente	

Bühler-Vertretng	Bühler Ltd.
Buhler-Représentation	Hr.Mc. Patterson
Buhler-Representative	
Rappresentante Buhler	CDN <u>Don Mills / Toronto</u>
Buhler-Representación	

Maschinentyp	
Type de machine	
Type of machine.....	GDM-H-400B DC Version 4.00
Tipo macchina	
Tipo de máquina	

Zuhaltekraft	kN	
Force de fermeture	kN	
Locking force	kN.....	4600
Forza di chiusura	kN	
Fuerza de cierre	kN	

Baujahr	
Année de construction	
Year of construction.....	1989
Anno di costruzione	
Ano de construcción	

Bestell-Nr	
No. de commande	
Order No.	565 472
No. di ordine	
No. de pedido	

Maschinen-Nr. (auf Firmenschild)	
No. de machine (sur plaque de constructeur)	
Machine No. (on name plate).....	10 188 403
No. macchina (sulla piastrina)	
No. de máquina (sobre placa del fabricante)	

Horizontal Cold-Chamber Die Casting Machine H-400B

Locking force (strain gauge tested).....	kN	4600
Injection force, consolidation phase (adjustable).....	kN	420 - 180
Plunger stroke.....	mm	480
Shot positions (standard).....	mm	0, -250
Ejection force.....	kN	240
Ejector stroke (adjustable).....	mm	145
Dimensions of fixed die platen (H x V).....	mm	990 x 1165
Dimensions of moving die platen (H x V).....	mm	990 x 990
Clearance between the tie bars.....	mm	640 x 640
Diameter of tie bars.....	mm	120
Die height min.	mm	250
Die height max.	mm	780
Stroke of moving die platen.....	mm	640
Rated installed power.....	kW	30
Machine area L x W (incl. safety gate).....	m	7,5 x 2,5
Machine height.....	m	2,3
Machine weight, ready for production.....	kg	16000
INTERCIRC control cabinet L x W x H.....	m	1,4 x 0,4 x 1,65
DATACESS control cabinet L x W x H (Standard).....	m	1,2 x 0,5 x 2,23
and DATACESS power cabinet L x W x H (Extended).....	m	0,8 x 0,5 x 1,8

Production data

Plunger diameter	mm	60	70	80	90	100	110
Theoretical shot volume (DIN 24480)	cm ³	905	1231	1608	2035	2512	3040
Max. shot weight for Al*	kg	2,5	3,4	4,5	5,7	7,1	8,5
Max. specific injection pressure	bar	1485	1090	835	660	535	442
Max. projected area**	cm ²	309	422	550	696	859	1040

* The max. shot weight is calculated as follows:
plunger stroke x plunger area x 0.75 x density

Alloy density of:	Al	Zn	Mg	Cu
g/cm ³	2.5	6.25	1.63	8.0

** Max. theoretical projected area at max. specific injection pressure, without consideration of core locking and dynamic part of injection process.

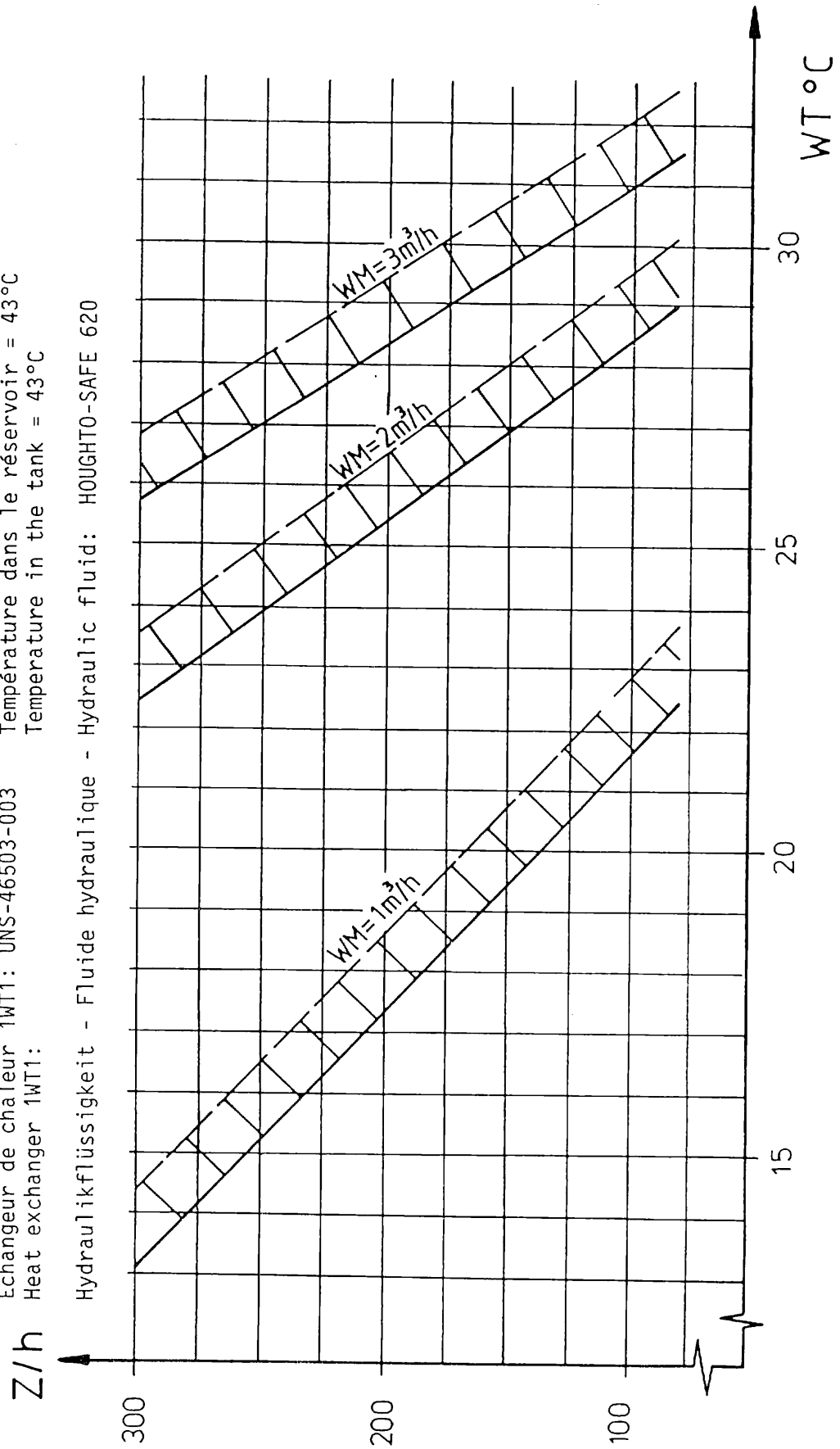
TECHNISCHE DATEN DONNEES TECHNIQUES TECHNICAL DATA	Maschinentyp Type de machine Type of machine	Hydraulikflüssigkeit: Einfüllmenge Fluide hydraulique: Volume de remplissage Hydraulic fluid: Filling volume	Inhalt: Stickstoff Capacité: Azote Capacity: Nitrogen		Hydraulik- flüssigkeit Fluide hyd. Hydr. fluid	Max. Druckluftverbrauch für eine Schutztüre Consommation d'air compr. max. d'une porte de séc. Max. compr. air consumption for one safety gate
			Flasche Bouteille Bottle	Kolbenspeicher Accumulateur à piston Piston accumulator		
	H-100B	250 l	2 x 10 l	3,0 l	2,5 l	15 dm ³ /Zyklus, Cycle
	Z-100B	250 l	1 x 10 l	0,94 l	0,9 l	15 dm ³ /Zyklus, Cycle
	H-160B	420 l	1 x 34,5 l	5,0 l	4,0 l	22 dm ³ /Zyklus, Cycle
	Z-160B	350 l	2 x 10 l	5,0 l	4,0 l	22 dm ³ /Zyklus, Cycle
	H-250B	510 l	2 x 34,5 l	11,0 l	10,0 l	22 dm ³ /Zyklus, Cycle
	H-400B	850 l	1 x 100 l	11,0 l	10,0 l	22 dm ³ /Zyklus, Cycle
B-Reihe	H-630B	1240 l	1 x 150 l	21,0 l	20,0 l	26 dm ³ /Zyklus, Cycle
	H-800B	1690 l	1 x 150 l	21,0 l	20,0 l	31 dm ³ /Zyklus, Cycle
8206 8505	Hydraulikflüssigkeit HF = Fluide hydraulique Hydraulic fluid		Tiegelinhalt Capacité du creuset Capacity of crucible		Z-100B	Z-160B
					851	851



Zyklen/h der Maschine
 Cycles/h of the machine
 Z/h = Cycles/h of the machine
 WT = Temperature of the inlet water
 Wassereintrittstemperatur
 Température d'entrée de l'eau °C
 Amount of water
 Quantité d'eau en m³/h

Wärmetauscher 1WT1:
 Echangeur de chaleur 1WT1: UNS-46503-003
 Heat exchanger 1WT1:
 Température dans le réservoir = 43°C
 Temperature in the tank = 43°C

Hydraulikflüssigkeit - Fluide hydraulique - Hydraulic fluid: HOUGHTO-SAFE 620



Kühlwasserverbrauch des Wärmetauschers
 Consommation d'eau de refroidissement de
 l'échangeur de chaleur

TYPE:
 GDM

DP - 5.1.8
 8209

BUHLER

GDM-95068