



Maschinenspezifikation

Spécification de machine

Specifica macchina

Machine specification

Especificación de máquina

Kundenname	Alumetco Technologies
Nom du client	
Name of customer	CDN <u>Brantford /Ontario</u>
Nome del cliente	
Nombre del cliente	

Bühler-Vertretung	Bühler Inc.
Buhler-Représentation	Hr.Mac.Patterson
Buhler-Representative	<u>Toronto / Kanada</u>
Rappresentante Buhler	
Buhler-Representación	

Maschinentyp	
Type de machine	
Type of machineGDS H-630B DC Version 4.0*
Tipo macchina	
Tipo de máquina	

Zuhaltekraft	kN	
Force de fermeture	kN	
Locking force	kN7250
Forza di chiusura	kN	
Fuerza de cierre	kN	

Baujahr	
Année de construction	
Year of construction1990
Anno di costruzione	
Ano de construcción	

Bestell-Nr	
No. de commande	
Order No.592 499
No. di ordine	
No. de pedido	

Maschinen-Nr. (auf Firmenschild)	
No. de machine (sur plaque de constructeur)	
Machine No. (on name plate)10 198 928
No. macchina (sulla piastrina)	
No. de máquina (sobre placa del fabricante)	

Horizontal Cold-Chamber Die Casting Machine H-630B

Locking force (strain gauge tested).....	kN	7250
Injection force, consolidation phase (adjustable).....	kN	650 x 265
Plunger stroke.....	mm	580
Shot positions (standard).....	mm	0, -50, -300, -350
Ejection force.....	kN	340
Ejector stroke (adjustable).....	mm	175
Dimensions of fixed die platen (H x V).....	mm	1210 x 1410
Dimensions of moving die platen (H x V).....	mm	1210 x 1210
Clearance between the tie bars.....	mm	780 x 780
Diameter of tie bars.....	mm	150
Die height min.	mm	300
Die height max.	mm	950
Stroke of moving die platen.....	mm	780
Rated installed power.....	kW	45
Machine area L x W (incl. safety gate).....	m	9.0 x 2.9
Machine height.....	m	3.2
Machine weight, ready for production.....	kg	27200
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	120
Theoretical shot volume (DIN 24480)	cm ³	1093	1488	1944	2460	3035	3674	4373
Max. shot weight for Al*	kg	3.0	4.2	5.5	6.9	8.5	10.3	12.3
Max. specific injection pressure	bar	2300	1690	1293	1021	828	684	574
Max. projected area**	cm ²	315	429	560	710	875	1060	1263

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

Density of	Al	Zn	Mg	Cu
g/cm ³	2.5	6.25	1.63	8.0

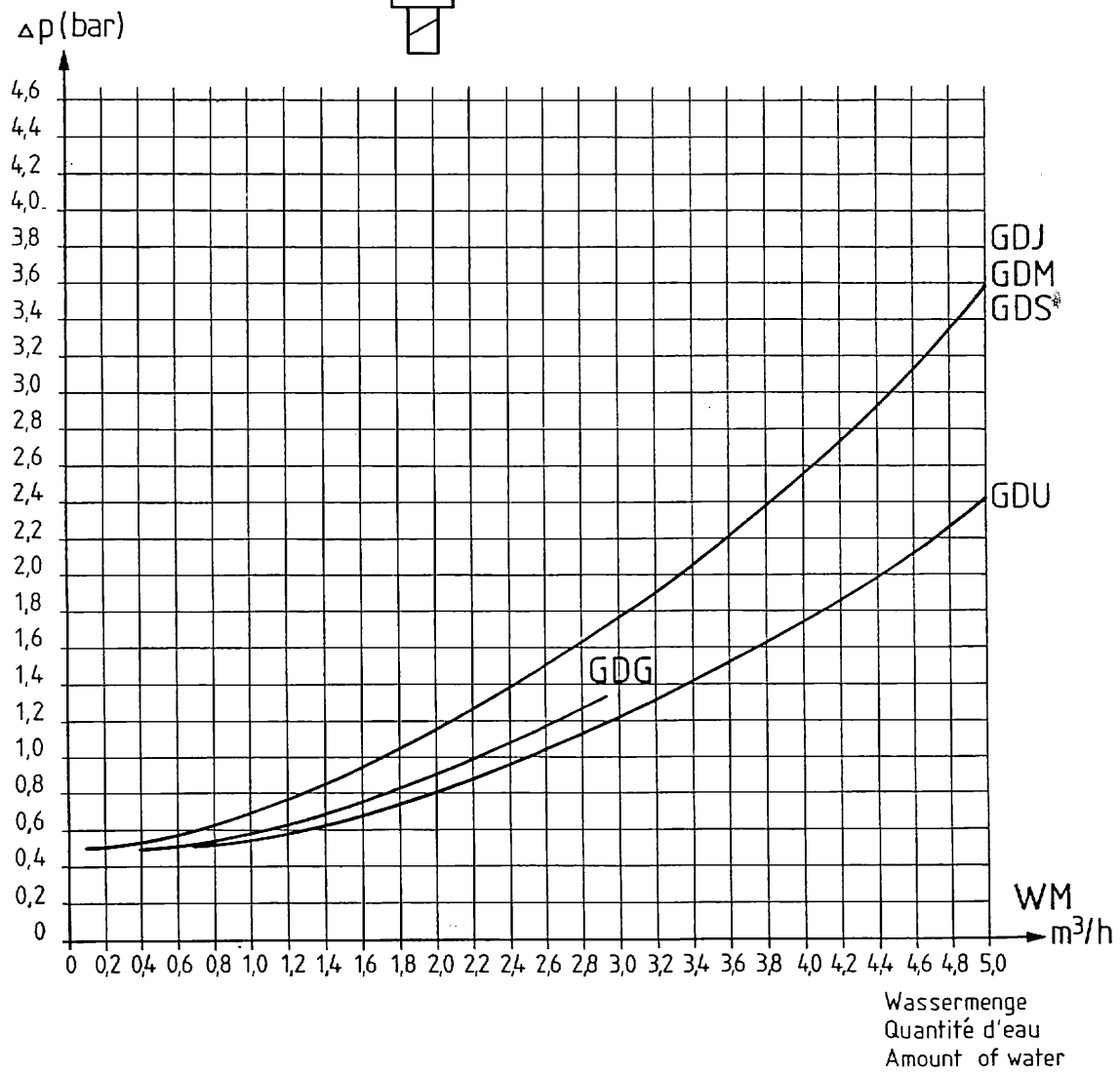
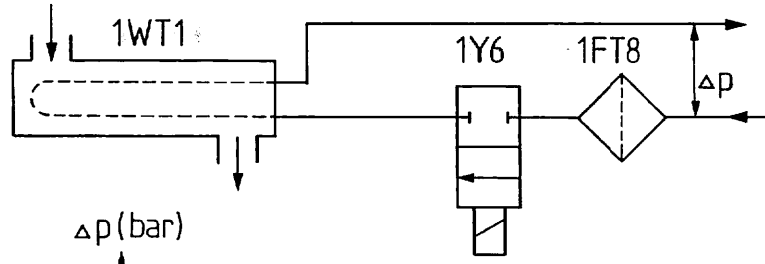
** Max. theoretical projected area at max. specific injection pressure, without consideration of core locking and dynamic part of injection process.

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
TYPE: 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 85l	Z-160B 85l

Systeme de refroidissement du fluide hydraulique: Pertes de pression Δp
 Water cooling system of the hydraulic fluid: Pressure drop

Maschinentyp Type de machine Machine type	Typ und Kühlfläche Type et surface de refroidissement Type and cooling surface			
1WT1:				
GDG H - 160B	UNS-46503-004	1000/23	1,4 m ²	
GDJ H - 250B	UNS-46503-002	1200/23	1,71 m ²	
GDM H - 400B	UNS-46503-003	1400/23	2,0 m ²	
GDS H - 630B	UNS-46503-005	1400/19	2,0 m ²	
GDU H - 800B	UNS-46503-006	1401/17	3,0 m ²	

- 1FT8 Kühlwasserfilter
Filtre de l'eau de refroidissement
Cooling water filter
- 1Y6 Magnetventil
Electro-vanne
Solenoid valve
- 1WT1 Wärmetauscher
Echangeur de chaleur
Heat exchanger



FORM NR. 303/7989
FORM NR. 307/7993

Technische Daten Données techniques Technical data	TYPE:	8707	BUHLER
	B-Reihe Datacess		GEA-95718
			3

Wassermenge
Quantité d'eau en m³/h
Amount of water

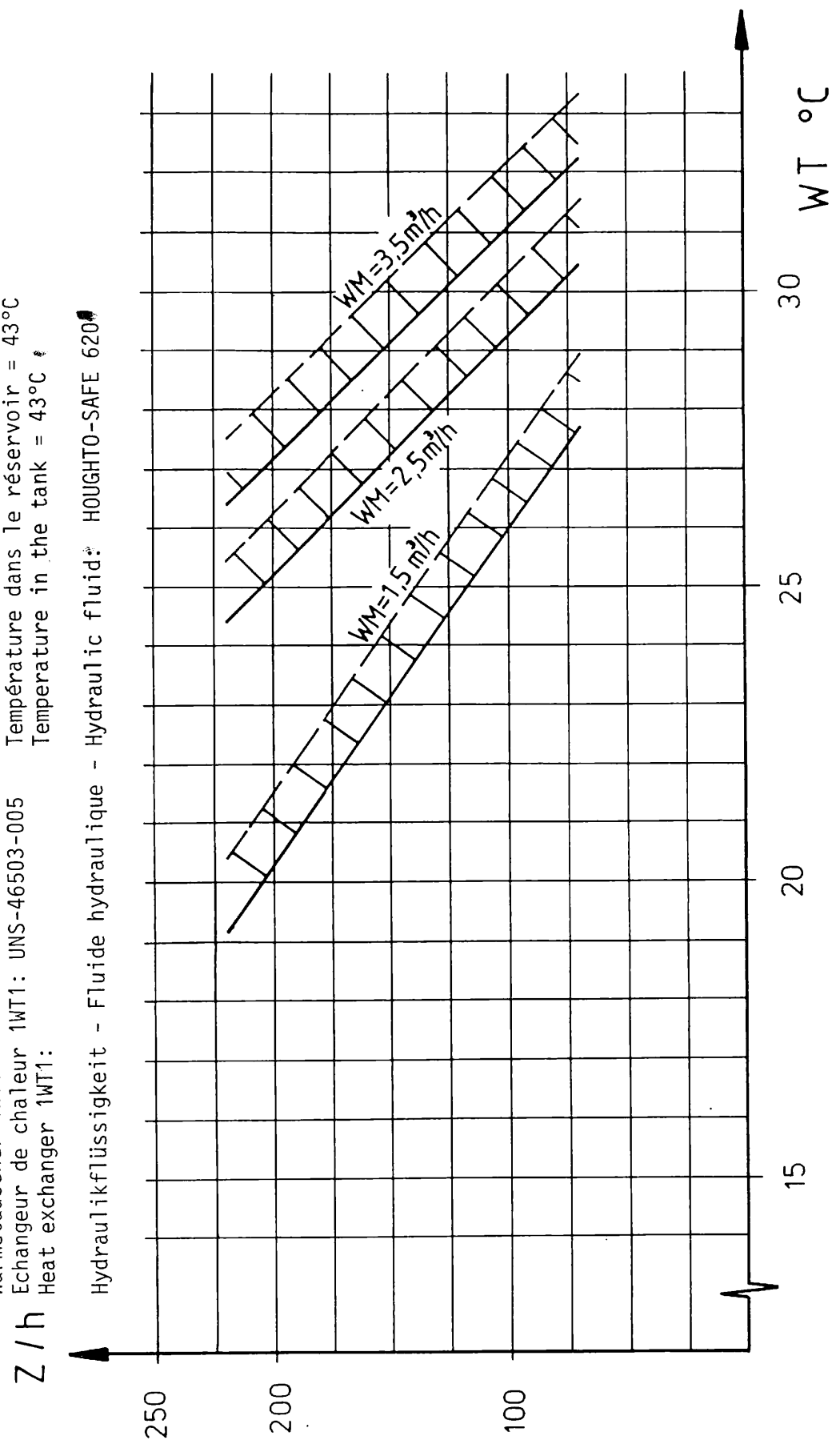
Wassereintrittstemperatur
Température d'entrée de l'eau °C
Water inlet temperature

Zyklen/h der Maschine
Cycles/h de la machine
Cycles/h of the machine

Tanktemperatur = 43°C
Température dans le réservoir = 43°C
Temperature in the tank = 43°C

Wärmetauscher 1WT1:
Echangeur de chaleur 1WT1: UNS-46503-005
Heat exchanger 1WT1:

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

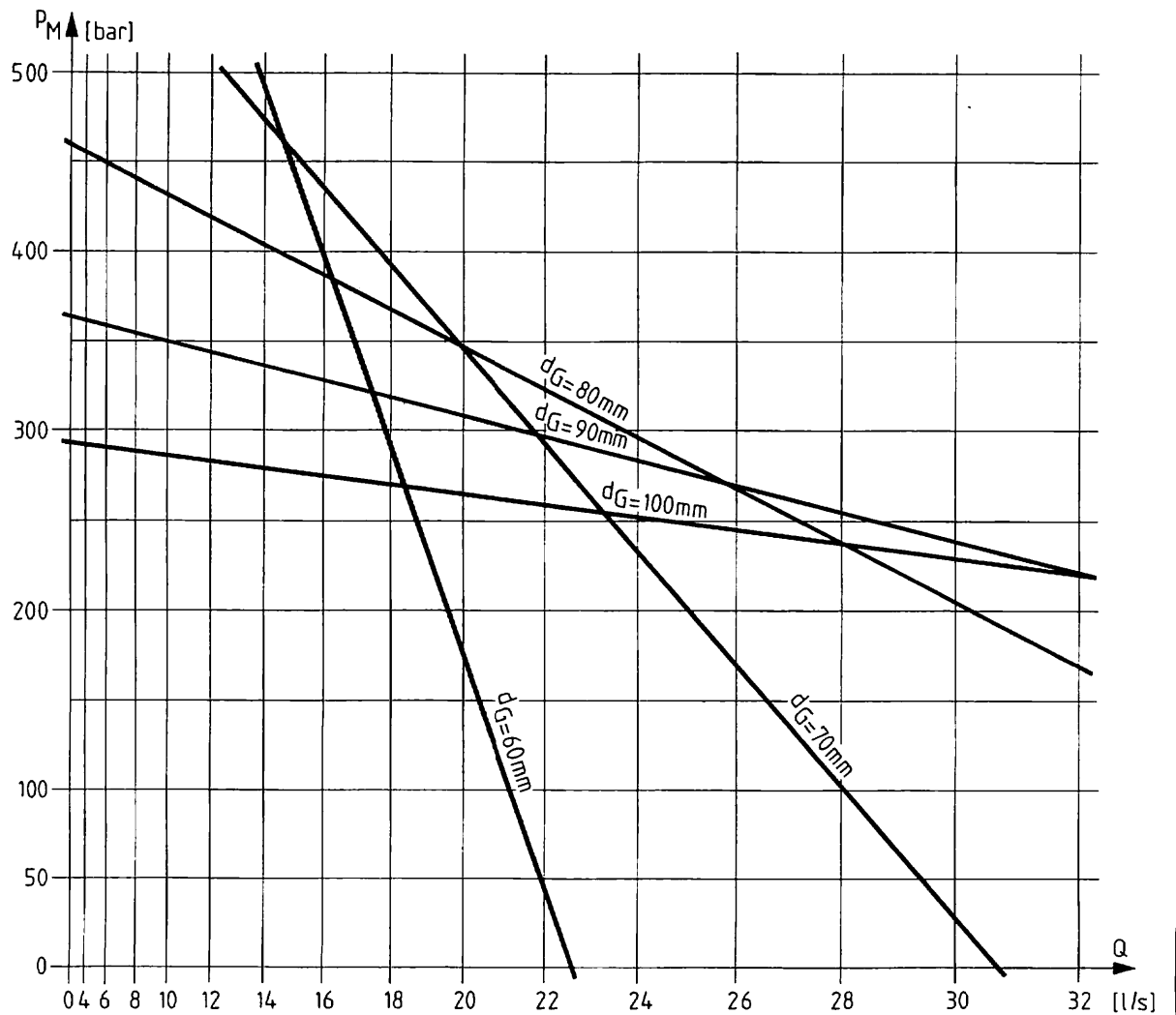
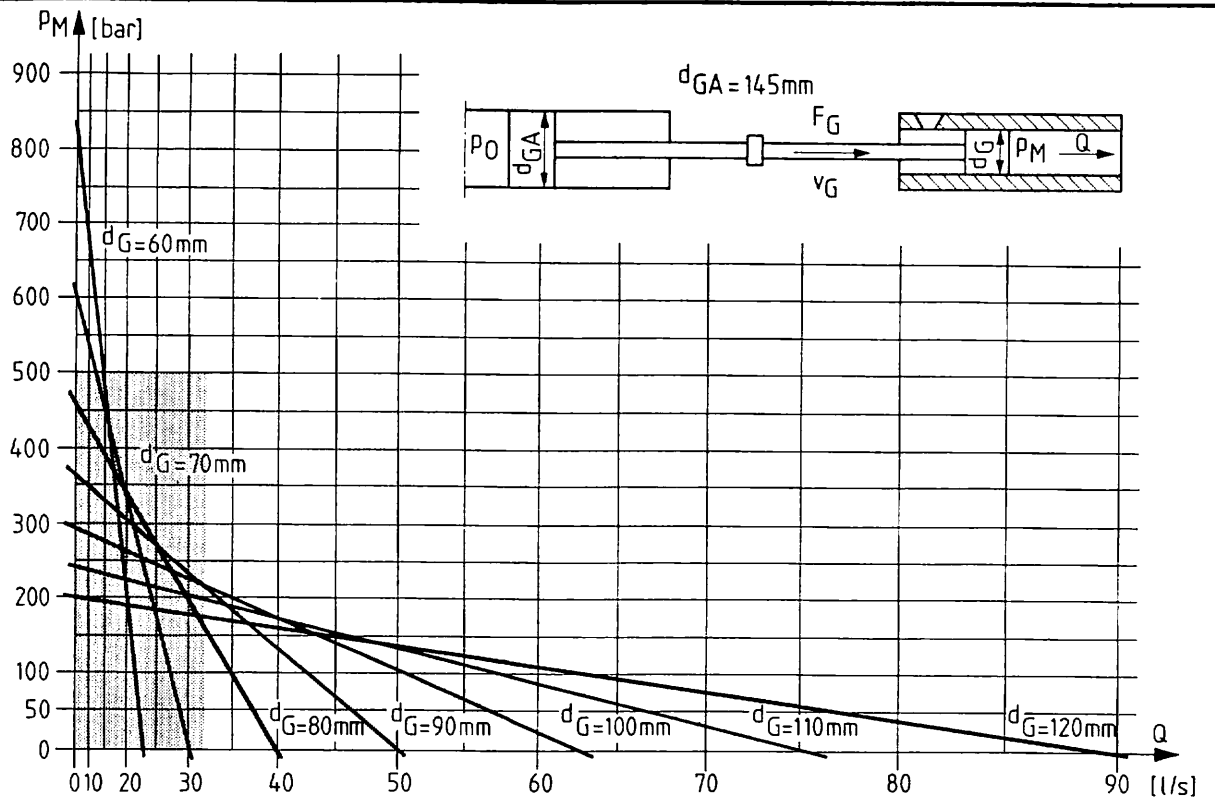


Kühlwasserverbrauch des Wärmetauschers
Consommation d'eau de refroidissement de
l'échangeur de chaleur
Cooling water consumption of heat exchanger

TYPE:
GDS
H-630B

DP-5.1.8
8209

BUHLER
GDS-95070
4



pQ-Diagramm
 Diagramme p Q
 pQ-diagram

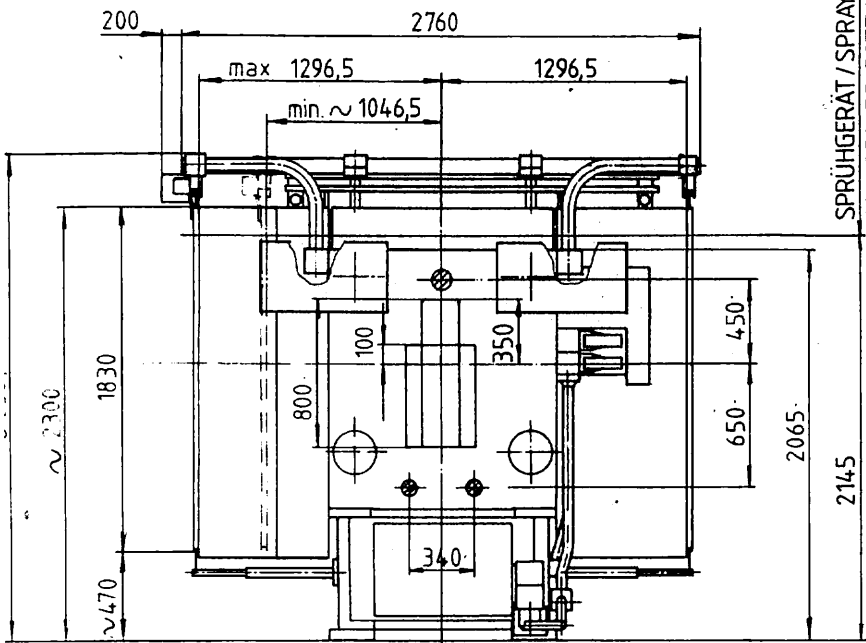
TYPE:
 GDS
 H-630B

DP - 5.1.8
 8203

BUHLER

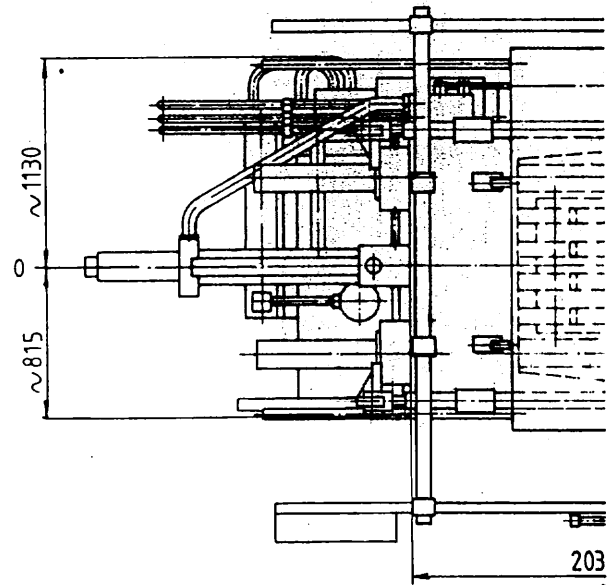
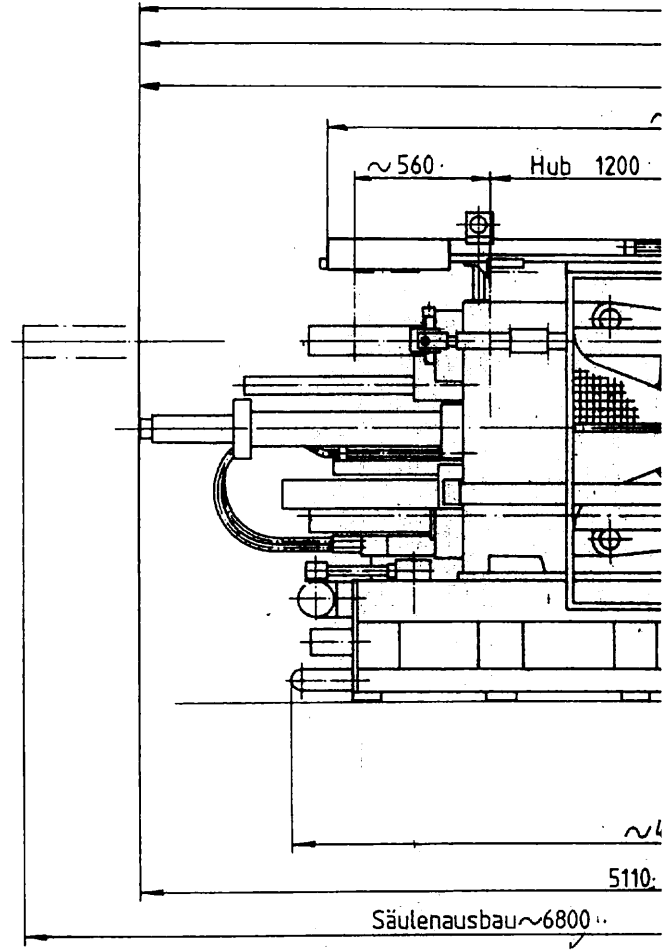
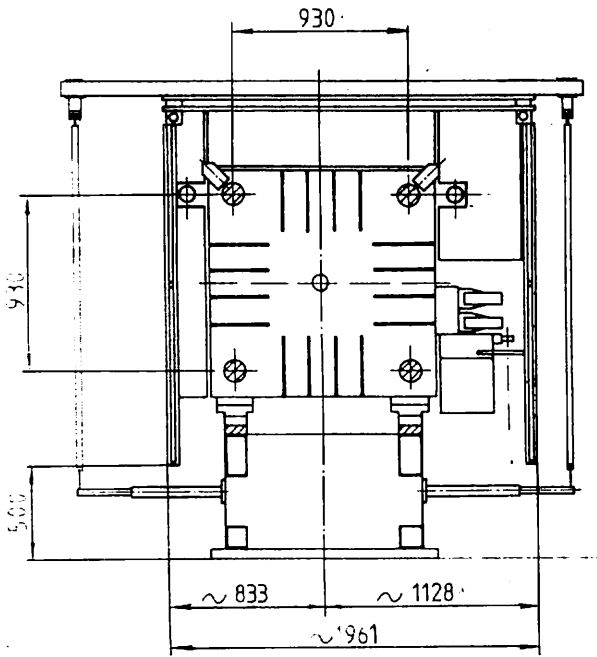
GDS-95059

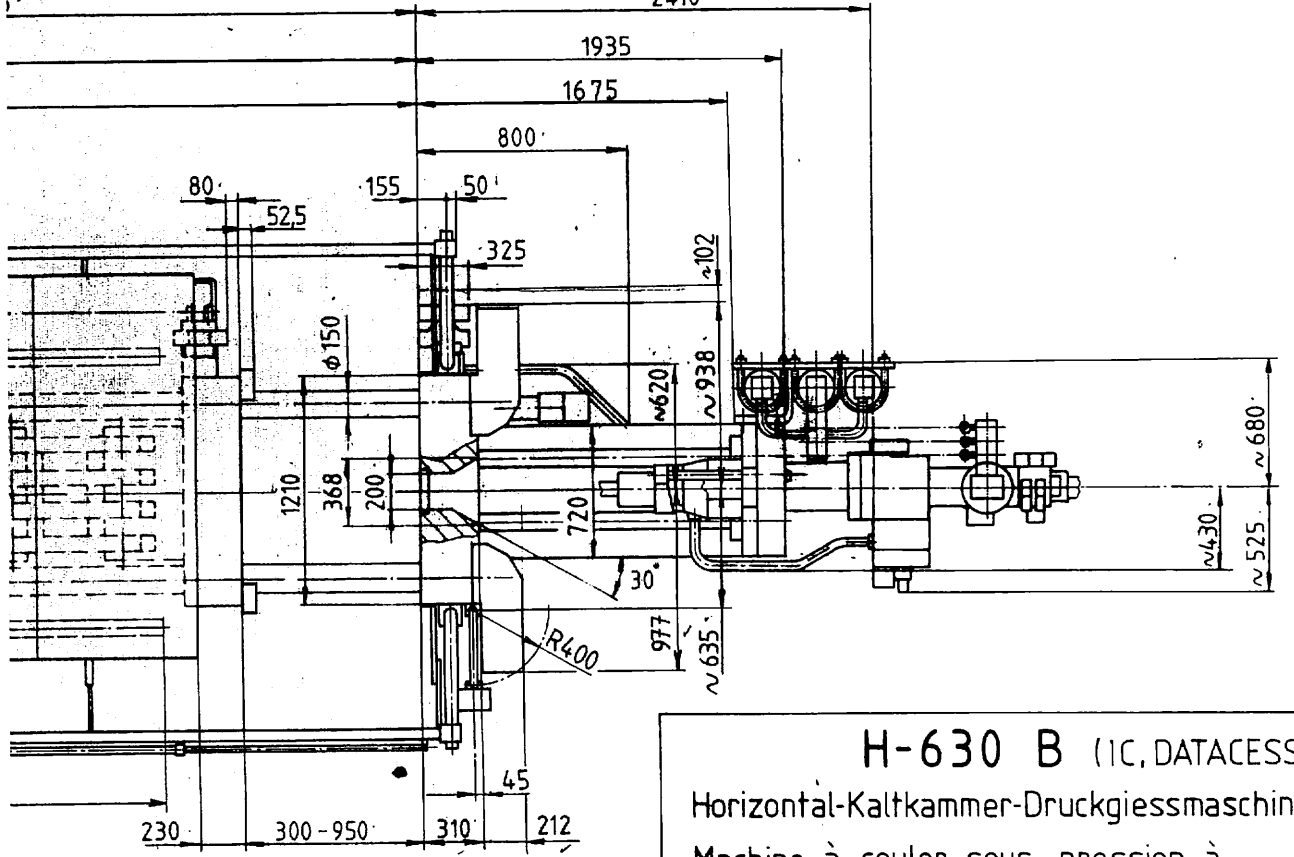
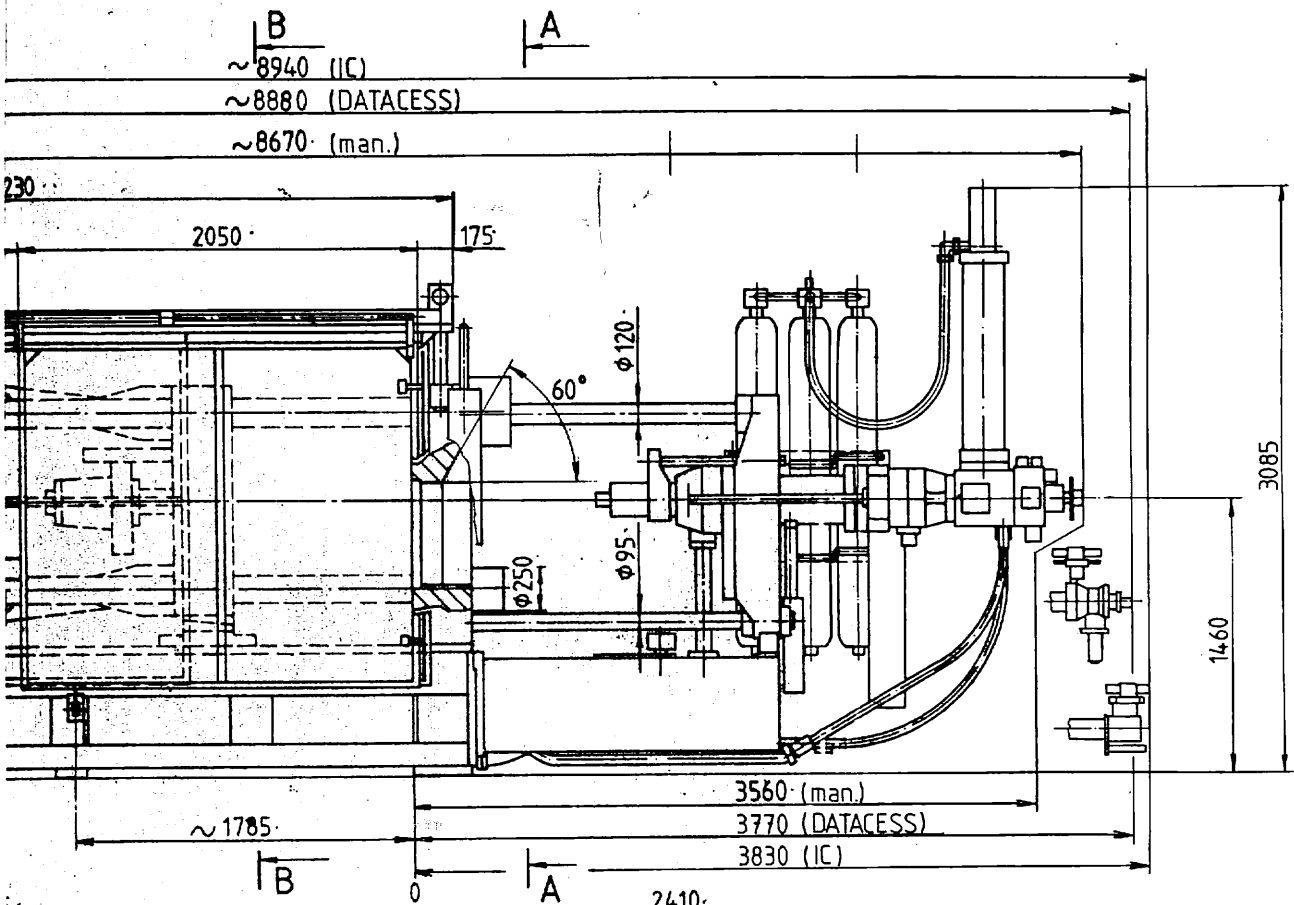
A - A



SPRÜHGERÄT / SPRAYING EQUIPMENT
APPAREIL DE POTEYAGE

B - B





Automatisches Säulenziehen
 Retrait automatique des colonnes
 Automatic drawing of tie bars

H-630 B (IC, DATACESS)
 Horizontal-Kaltkammer-Druckgießmaschine
 Machine à couler sous pression à
 chambre froide horizontale
 Horizontal cold chamber die casting machine
 Macchina per la pressofusione a
 camera fredda orizzontale

Änderungen	Datum	in Datum	in Datum	in Datum
BUHLER	Abt. DG 51	Datum 25.4.88	Konstruktions	

Steuer- und Starkstromschrank (DATACESS Extended)
 Armoire de pilotage et du courant fort (DATACESS extended)
 Control and power cabinet (DATACESS extended)'

- 1) Normal
- 2) Spezial: über 200 mm
- 2) Spécial: plus de 200 mm
- 2) Special: more than 200 mm

