



2.5 TECHNICAL DATA (subject to modification without notice)

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)	cm3	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**	cm2	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/cm3	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.

2.6 OPERATING DATA (subject to modification)

10 Die mounting platens



-	Smallest permissible die mounting dimensions	mm	620 x 620
-	Maximum permissible surface pressure.....	N/mm ²	100
11	Effective plunger stroke	mm	555

12 Electrical data

-	Total connected load of die-casting machine with control system	kW	45
-	Voltage fluctuation max.	%	± 10
-	Protection class (DIN 40050)	IP	55
-	Maximum permissible ambient temperature for control cabinet with cooler	°C	55

Note: The lower the temperature is in the control cabinet, the smaller the probability of failure of electronic components.

20 Hydraulic system

21	Maximum system pressure	bar	160
22	Hydraulic fluid according to GEA-95633 (HFC-Hydraulic fluid) or GEA-95632 (HLP-Mineral oil) Filling quantity	dm ³	1240

30 Pneumatic system

31	Maximum operating pressure	bar	5
32	Data for a pneumatically actuated safety gate:		
-	Maximum compressed air requirement	Nl/min	43
-	Adjusted operating pressure	bar	4
33	Maximum compressed air requirement for mechanical die scotch	Nl/min	1.06
34	Lubricating oil acc. to GEA-95623. Contents of tank for each pneumatically actuated safety gate approx....	dm ³	0.5

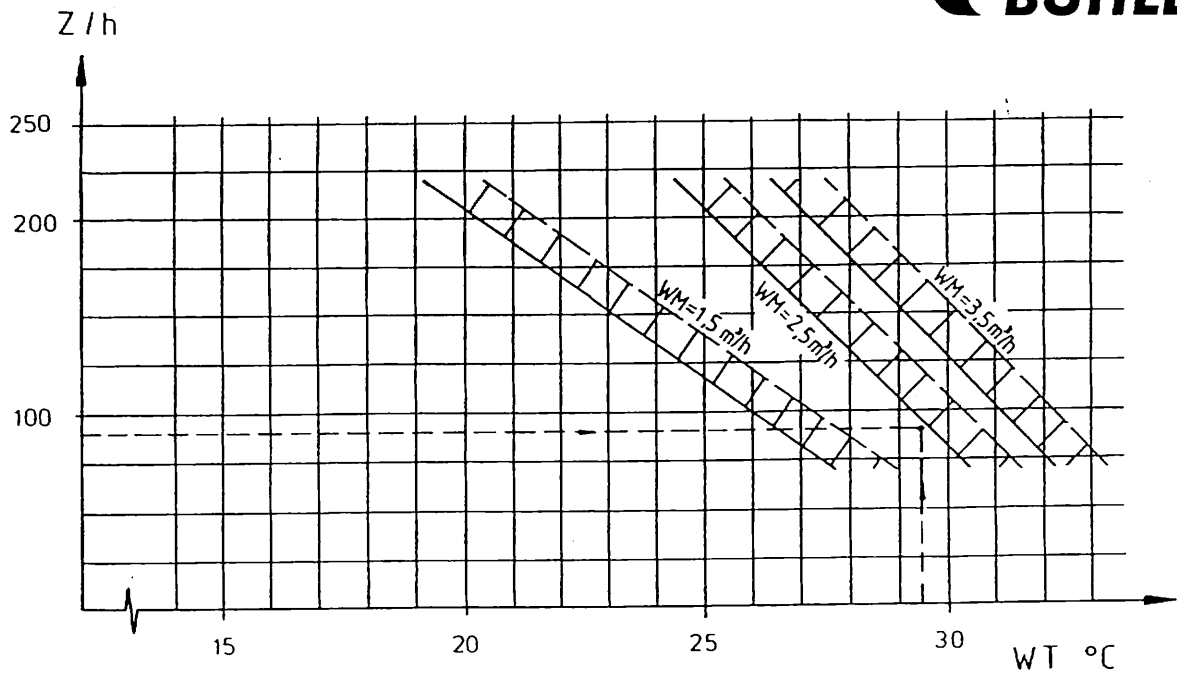


Fig. 2.1.2

