

Spécification de machine

Machine specification

Kundenname Nom du client Name of customer	Alumetco <u>Brantford</u> / Kanada
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Bühler-Vertretung Buhler-Représentation Buhler-Representative	Buhler - Miag <u>Toronto</u> / Kanada
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Maschinentyp Type de machine Type of machine	GDS-H-630B DC Version 4.00
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Zuhältekraft kN Force de fermeture kN Locking force kN	7250
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Baujahr Année de construction Year of construction	1989
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Bestell-Nr. No. de commande Order No.	565'170
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Maschinen-Nr. (auf Firmaschild) No. de machine (sur plaque de constructeur) Machine No. (on name plate)	10'178'564
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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

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.

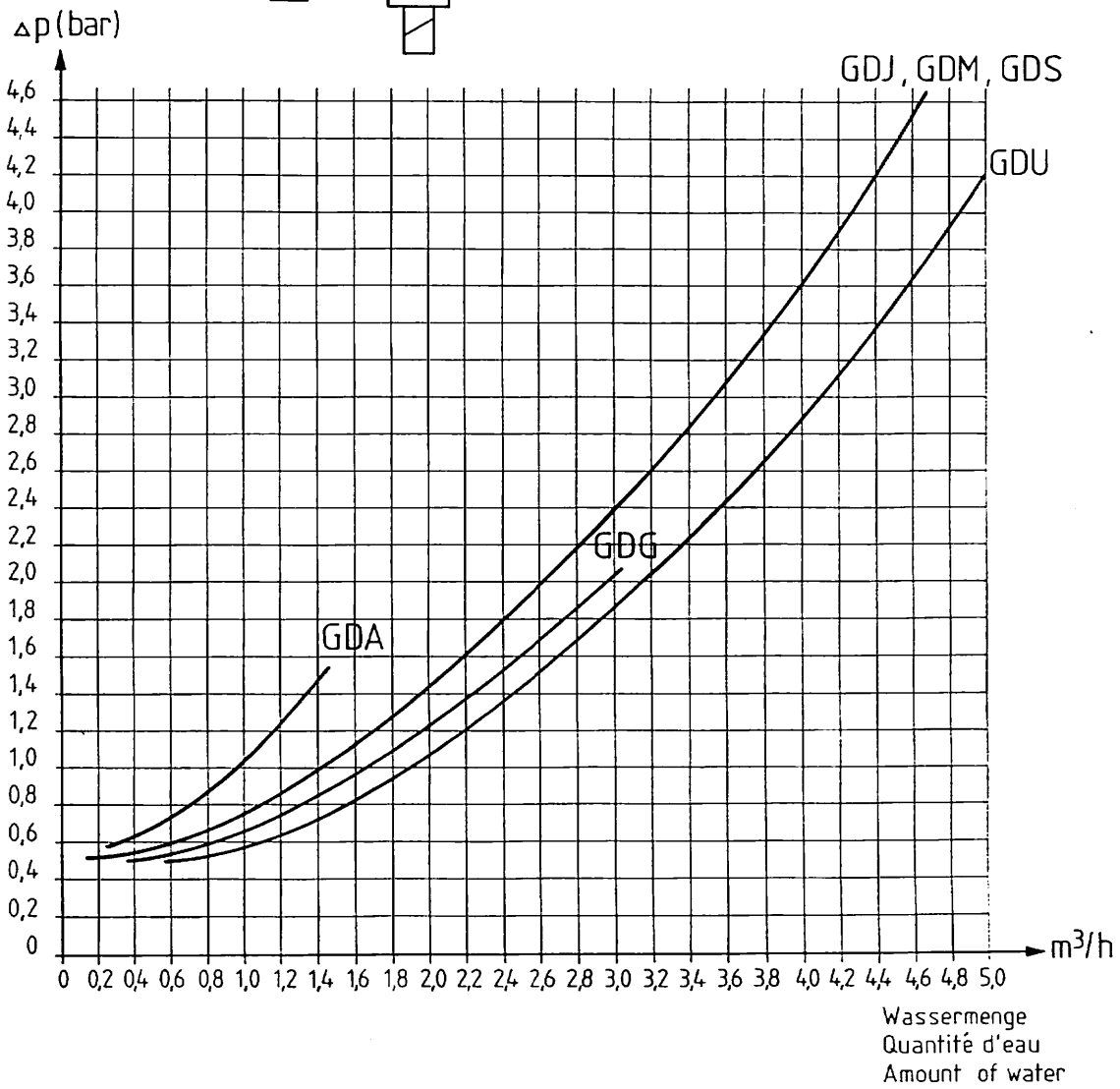
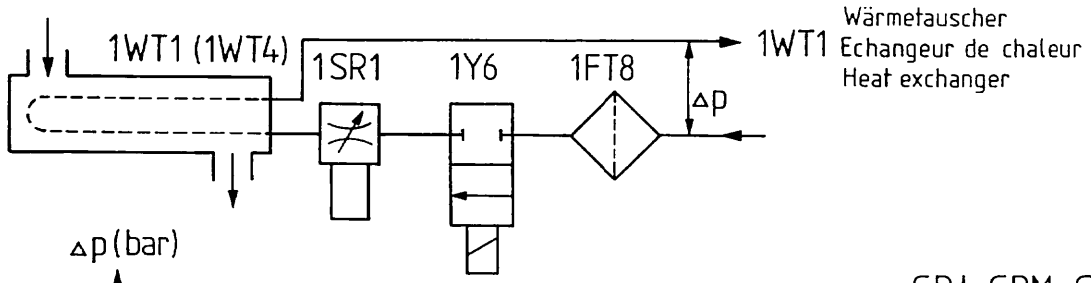
TECHNISCHE DATEN DONNEES TECHNIQUES TECHNICAL DATA	Maschinentyp Type de machine Type of machine	Hydraulikflüssigkeit: Einfüllmenge Fluide hydraulique: Volume de remplissage Hydraulic fluid: Filling volume	Inhalt: Stickstoff Capacité: Azote Capacity: Nitrogen		Hydraulik- flüssigkeit Fluide hyd. Hydr. 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 TYPE:	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	HF = Hydraulikflüssigkeit Fluide hydraulique Hydraulic fluid			Tiegelinhalt Capacité du creuset Capacity of crucible		Z-100B 851	Z-160B 851



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 1WT1: Type et surface de refroidissement Type and cooling surface		
GDA H/Z-100B	UNS-46501-005	LOK T8	2,4m ²
GDG H/Z-160B	UNS-46503-004	1000/23	1,4m ²
GDJ H-250B	UNS-46503-002	1200/23	1,71m ²
GDM H-400B	UNS-46503-003	1400/23	2,0m ²
GDS H-630B	UNS-46503-005	1400/19	2,0m ²
GDU H-800B	UNS-46503-006	1401/17	3,0m ²

- 1FT8 Kühlwasserfilter
Filtre de l'eau de refroidissement
Cooling water filter
- 1S6 Magnetventil
Electro-vanne
Solenoid valve
- 1SR1 Kühlwasserregelventil
Valve de réglage de l'eau de refroid.
Cooling water regulating valve



Technische Daten
 Données techniques
 Technical data

TYPE:
 B-Reihe
 IC

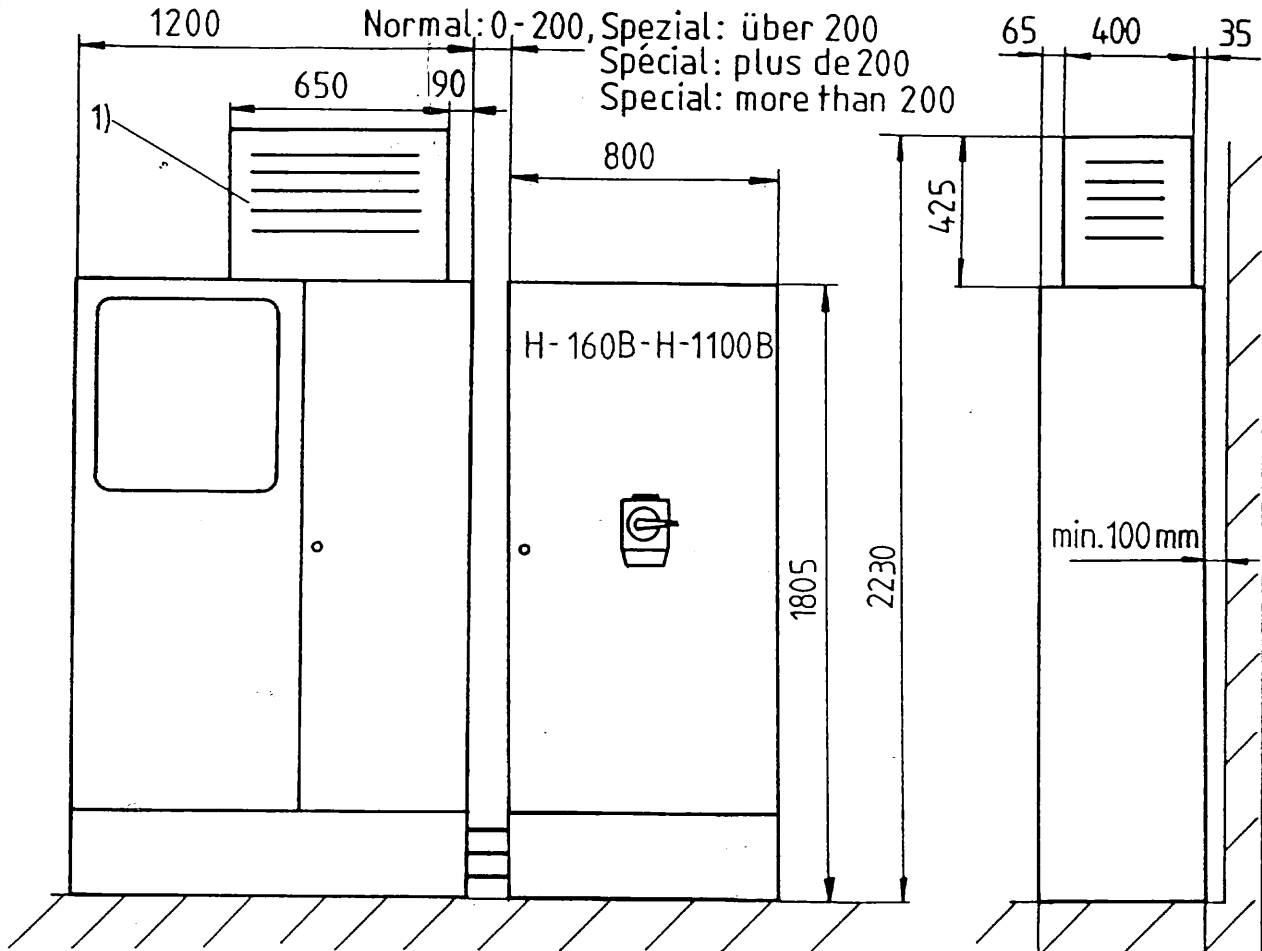
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GEA-95668

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Kühlgerät (Zusatz)
 1) Réfrigérant (accessoires)
 Refrigerator (accessory equipment)



Steuerschrank Armoire de commande Control cabinet	TYPE:	8610	BUHLER
	DATACESS extended		GEA-95714

Vergleichstabelle der kleinsten Formaufspanflächen

Tableau comparatif des surfaces d'appui minimum des moules

Table for comparison of minimum areas of dies

Tabla de comparación para áreas mínimas de moldes

Maschinentyp Type de la machine Type of machine Tipo de la máquina		Kleinste Formaufspanflächen Surfaces d'appui minimum des moules Minimum areas of dies Areas mínimas de moldes	
		mm	inches
GSE	A-5B	100 x 100	4 x 4
GSU	A-40B	210 x 210	8 1/4 x 8 1/4
GDA	H-100B, Z-100B	270 x 270	8 11/16 x 8 11/16
GDF GDG	H-160B, Z-160B H-160B, Z-160B	340 x 340 340 x 340	13 3/8 x 13 3/8 13 3/8 x 13 3/8
GDJ	H-250B	430 x 430	17 x 17
GDM	H-400B	500 x 500	19 3/4 x 19 3/4
GDS	H-630B	620 x 620	24 7/16 x 24 7/16
GDU	H-800B	720 x 720	28 3/8 x 28 3/8
GDV	H-1100B	800 x 800	31 1/2 x 31 1/2
GPR	H-2000B	1050 x 1050	41 3/8 x 41 3/8

Kleinste Formaufspanflächen
Surfaces d'appui minimum des moules
Minimum areas of dies
Areas mínimas de moldes

TYPE:
B-Reihe

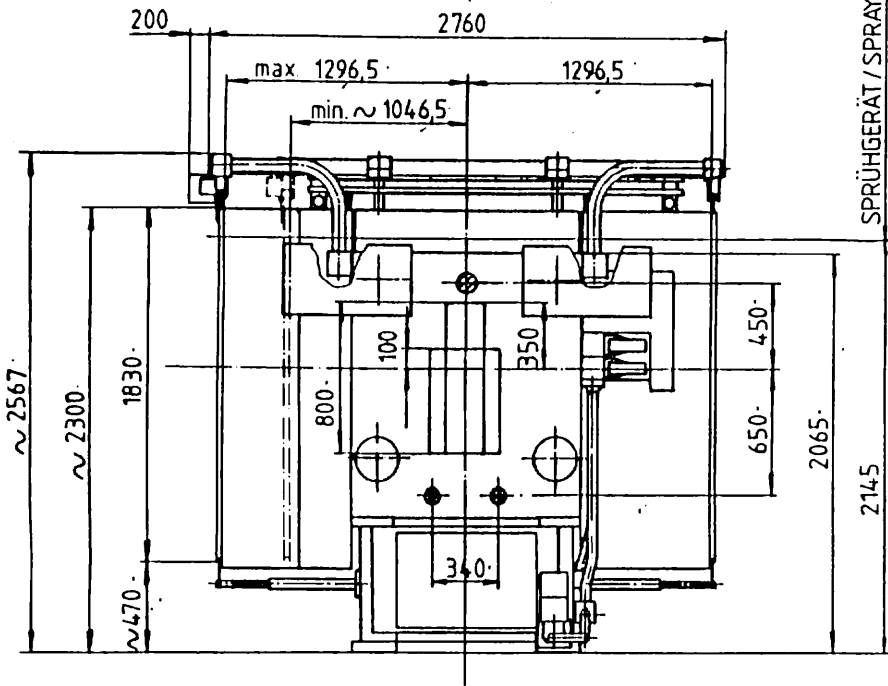
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BUHLER

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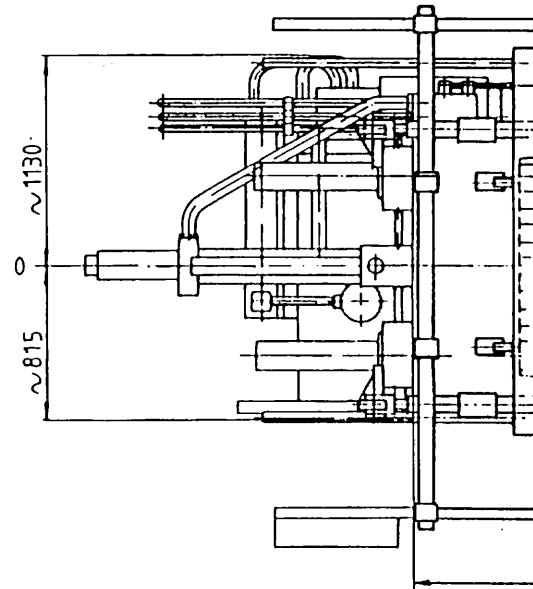
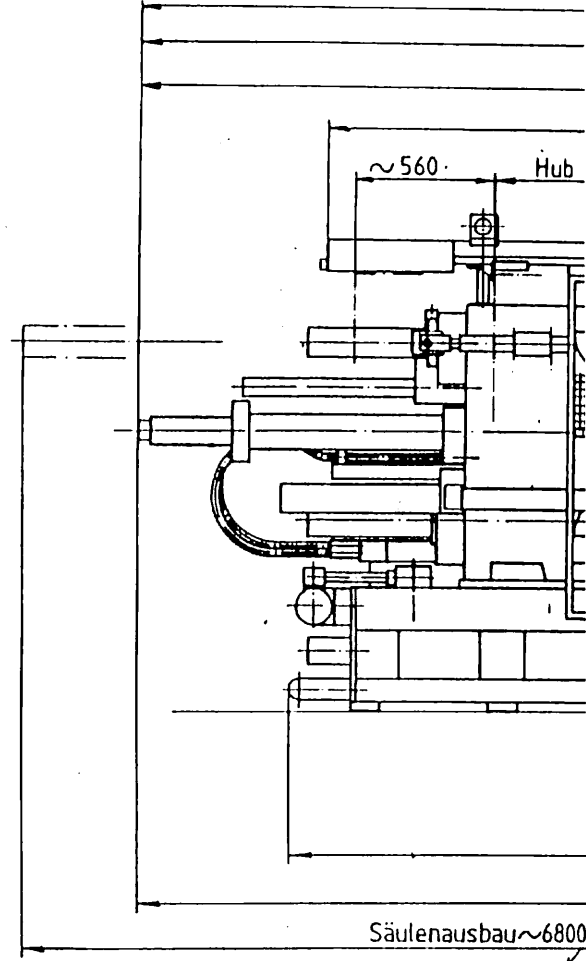
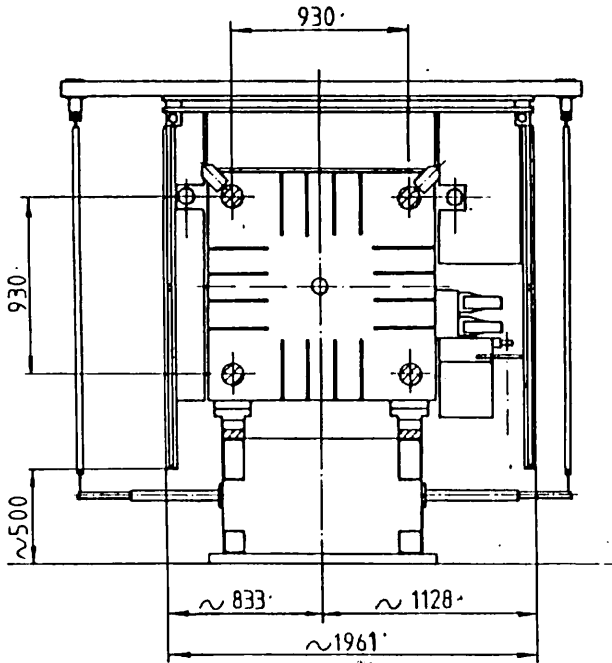
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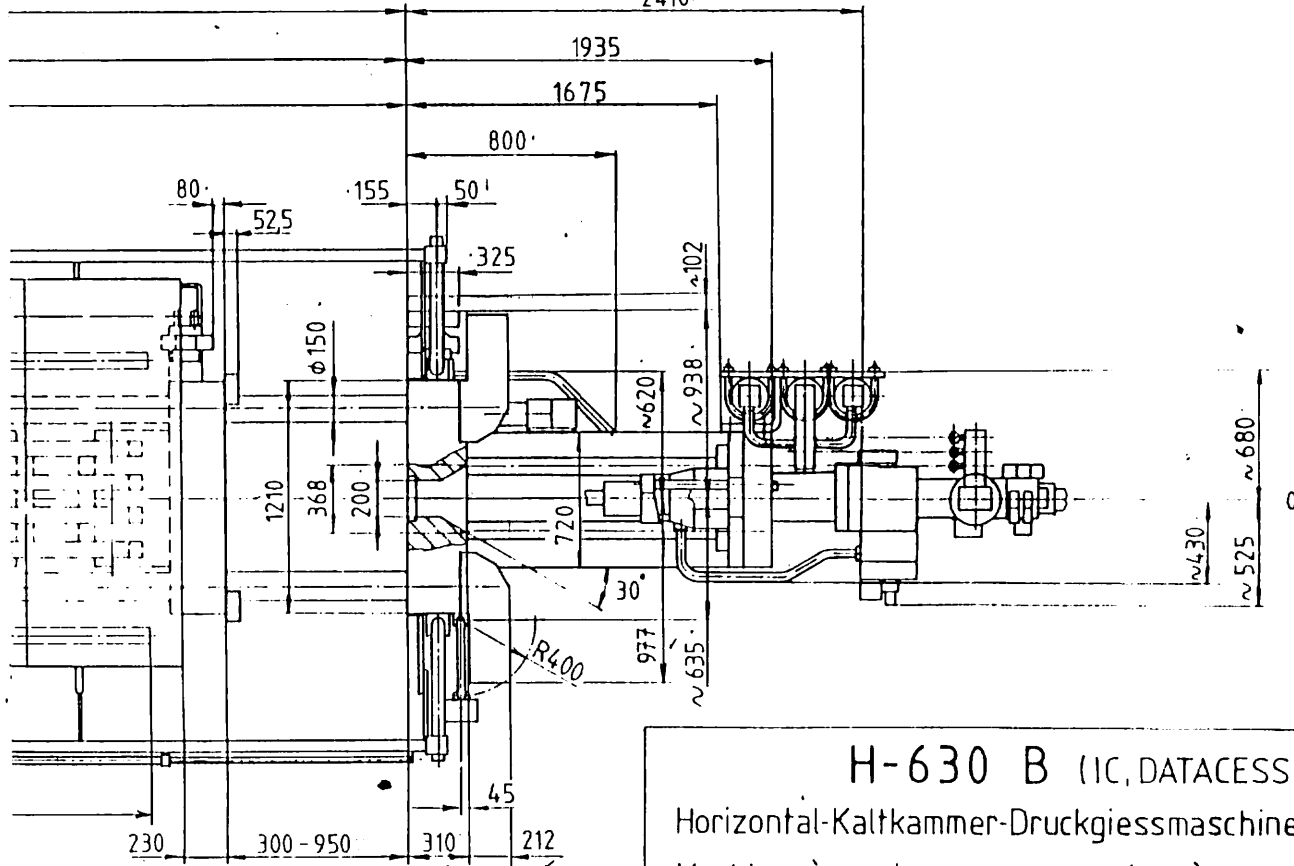
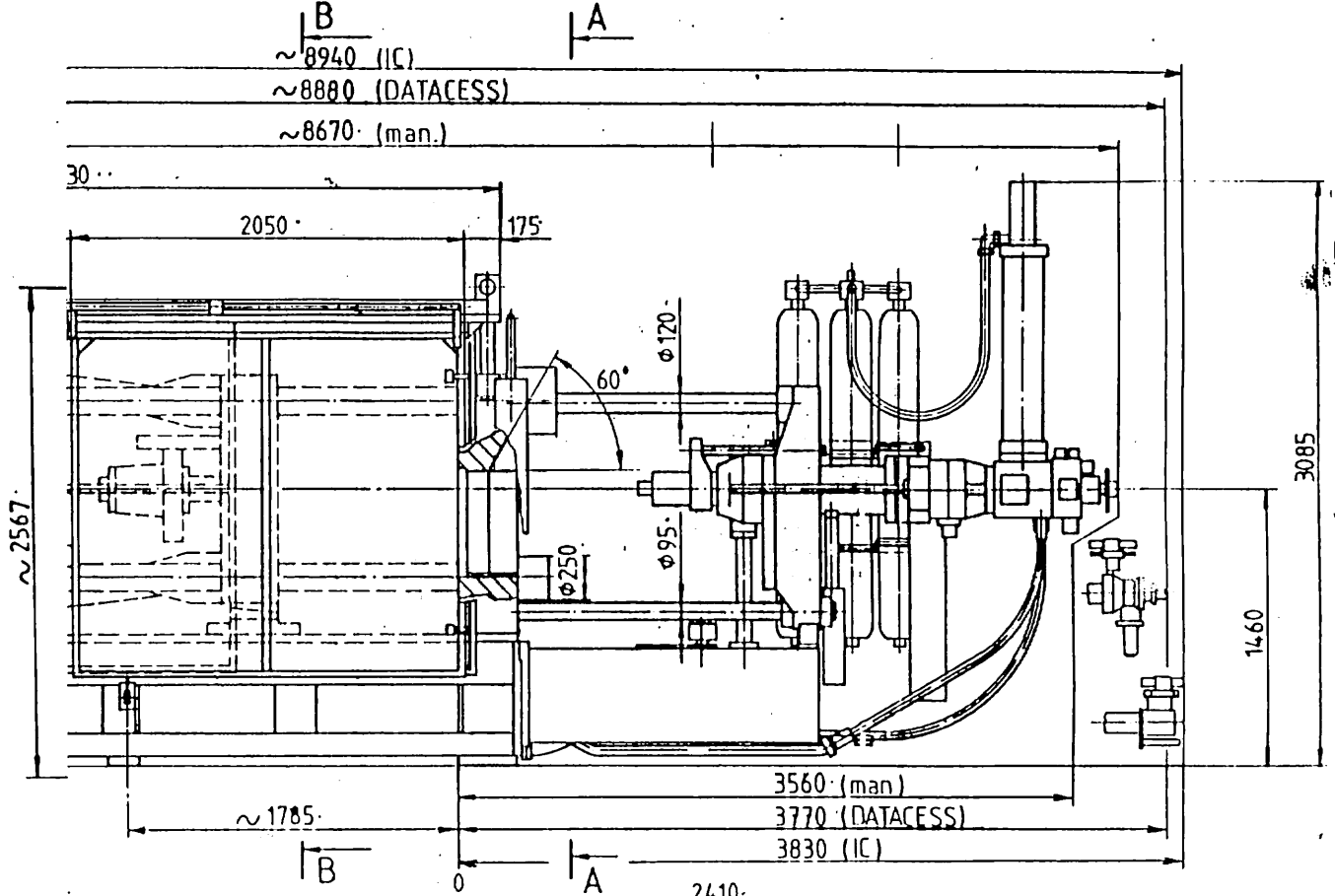
A - A



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