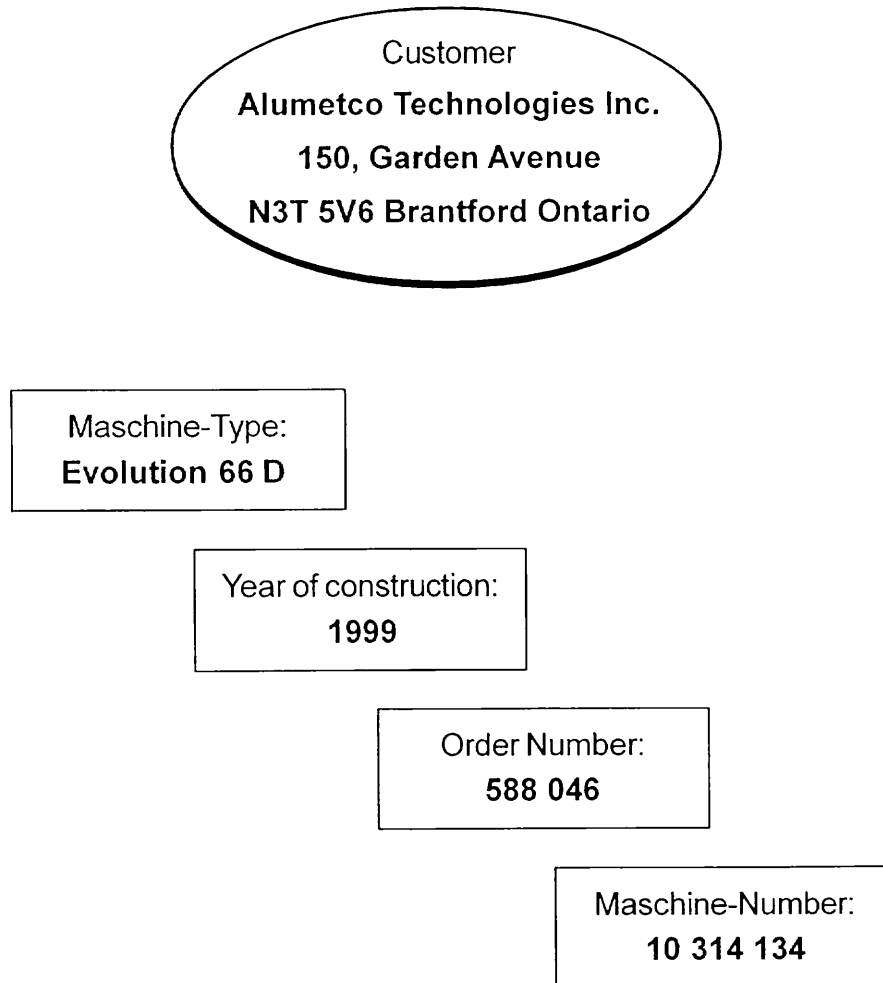
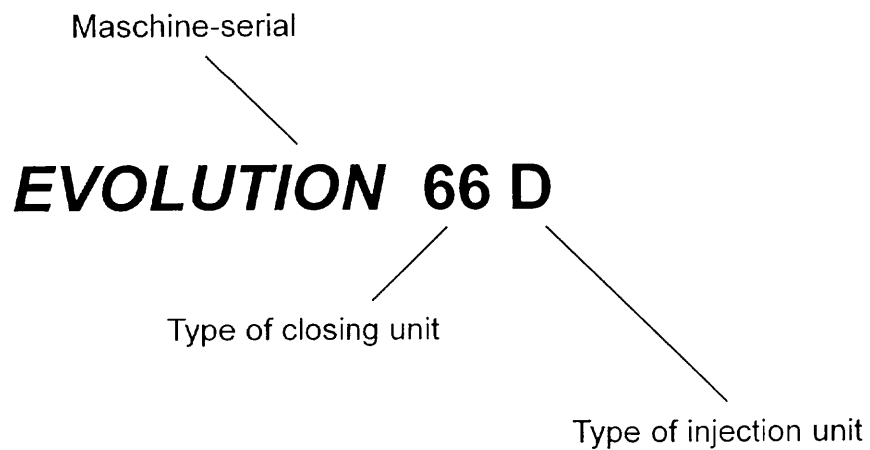


2.1 Identification data



2.2 Machine type designation



2.3 Directed use

Buhler horizontal die-casting machines are designed exclusively for the pressure die-casting of aluminium, magnesium, zinc and copper alloys. Any use beyond this scope is regarded as non-directed.

The manufacturer can **not** be made liable for any damages that are a result of non-directed use. The user is the sole bearer of the risk for such damage

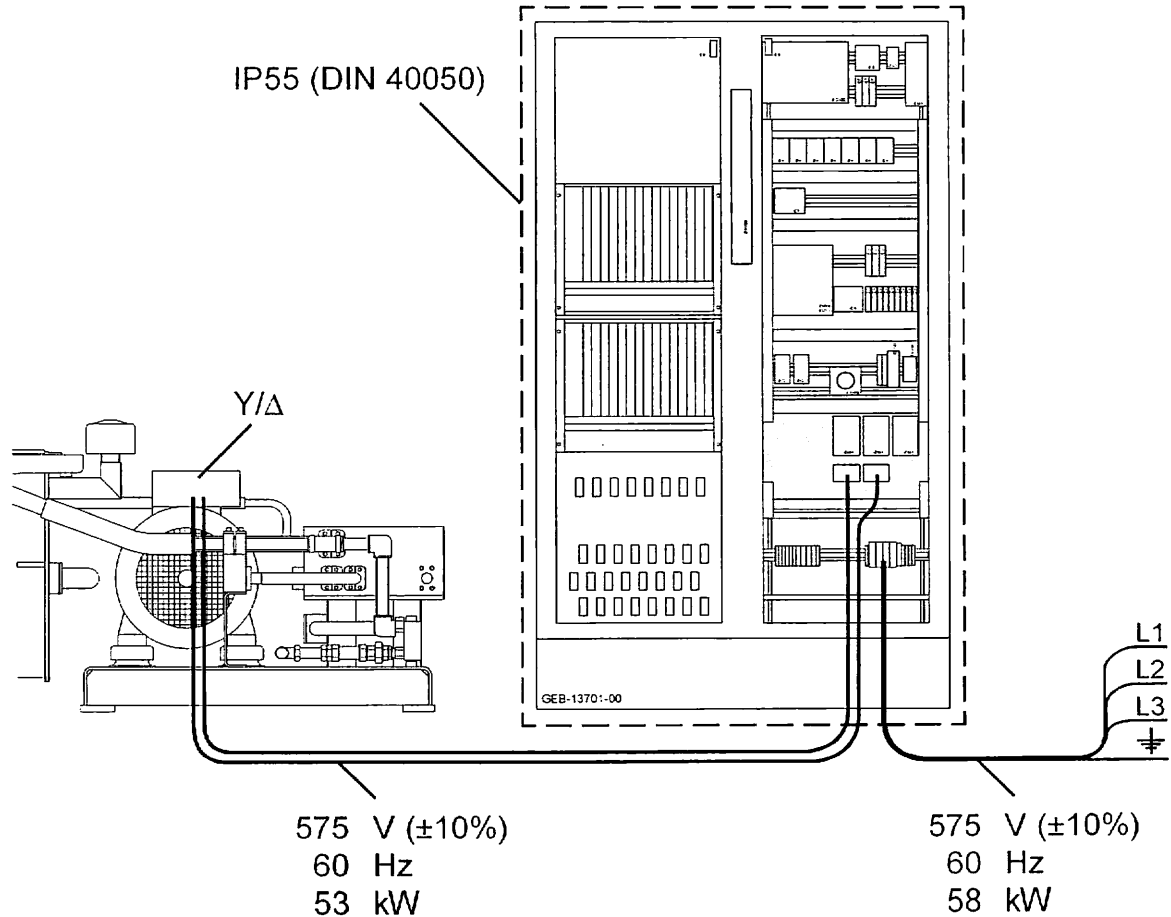
The observance of the conditions for installation, start-up, operation and maintenance as instructed by the manufacturer are inherent with the directed use.

2.4 Ambience

In order to determine a suitable location for the DCM or DCI a number of important aspects will have to be taken into account.

See chapter „Preparing the site of installation“.

2.5 Electrical connections

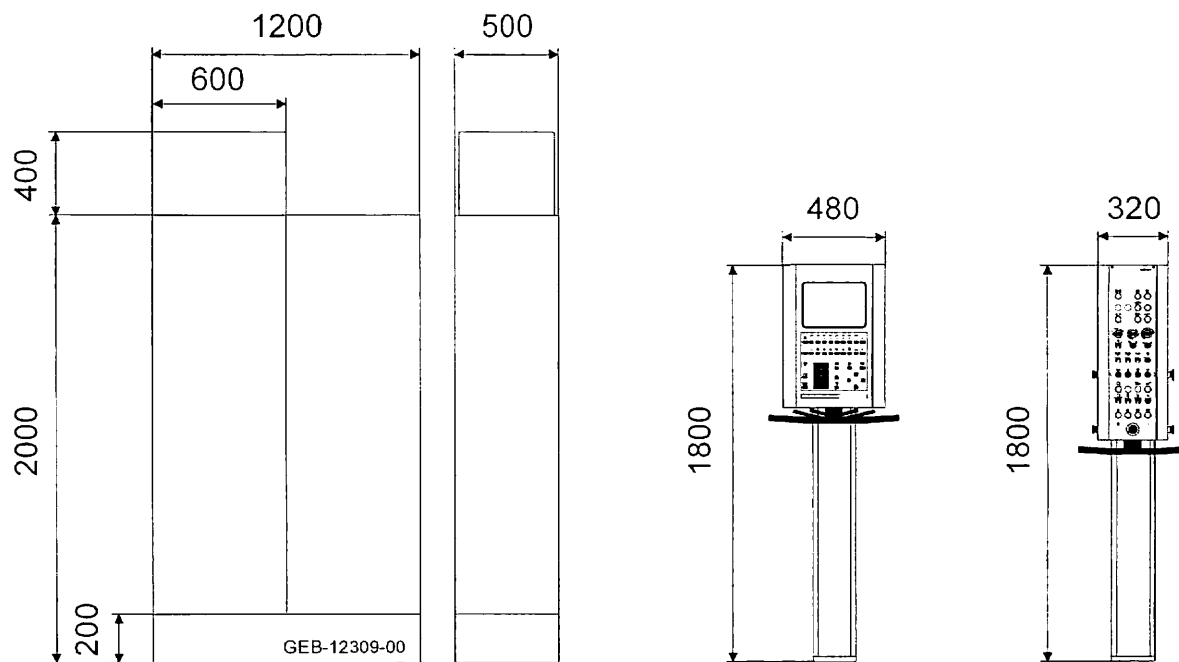


2.6 Dimension / Weight

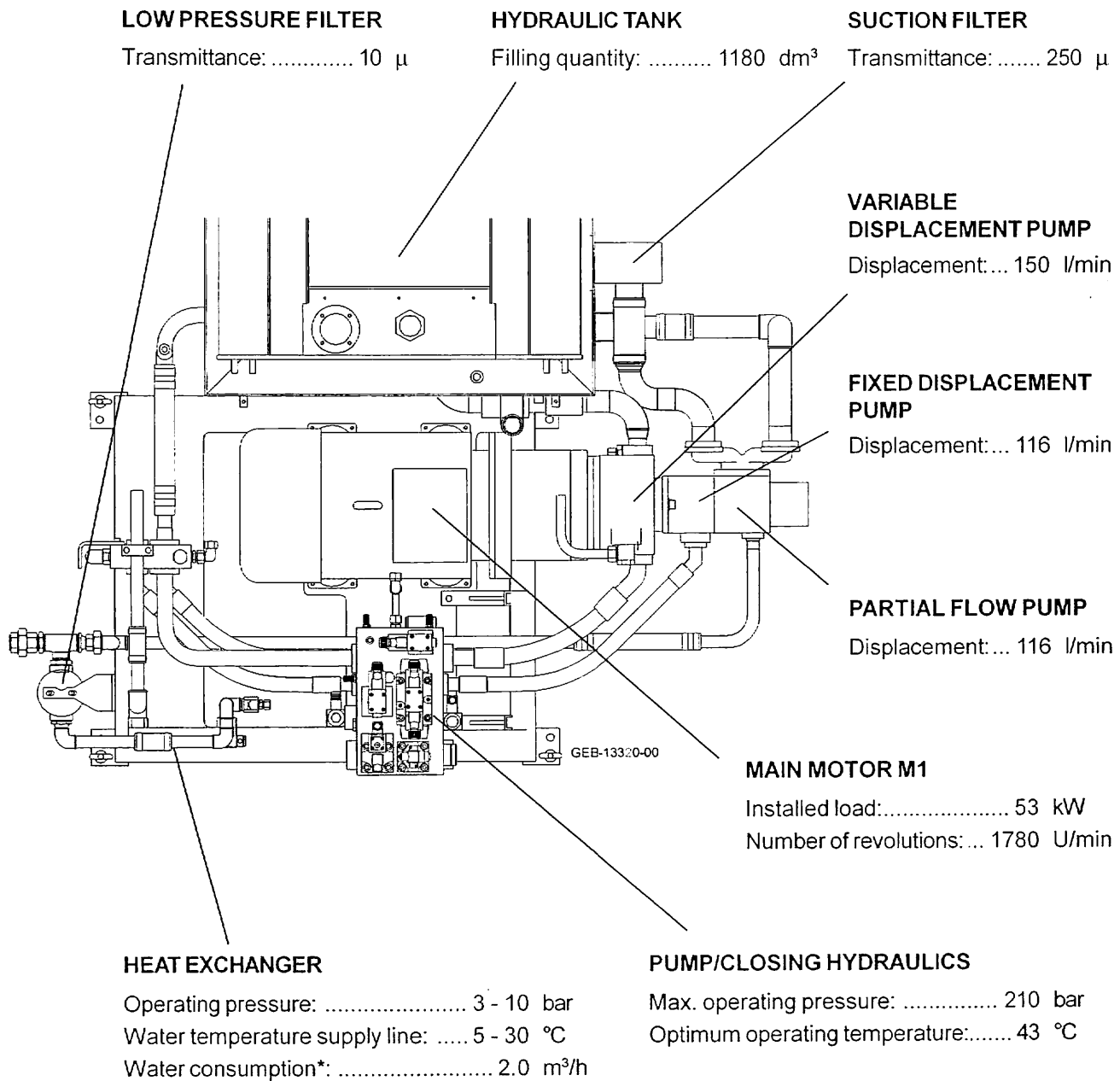
Machine ready for production:..... 28'000 kg

Dimensions: see Encosures

Weight of the control cabinet:..... 275 kg



2.7 Driving unit / Hydraulics



* Water consumption with a supply line temperature of 30°C

2.8 Closing unit

CENTRAL LUBRICATION

Filling quantity: 2.7 dm³

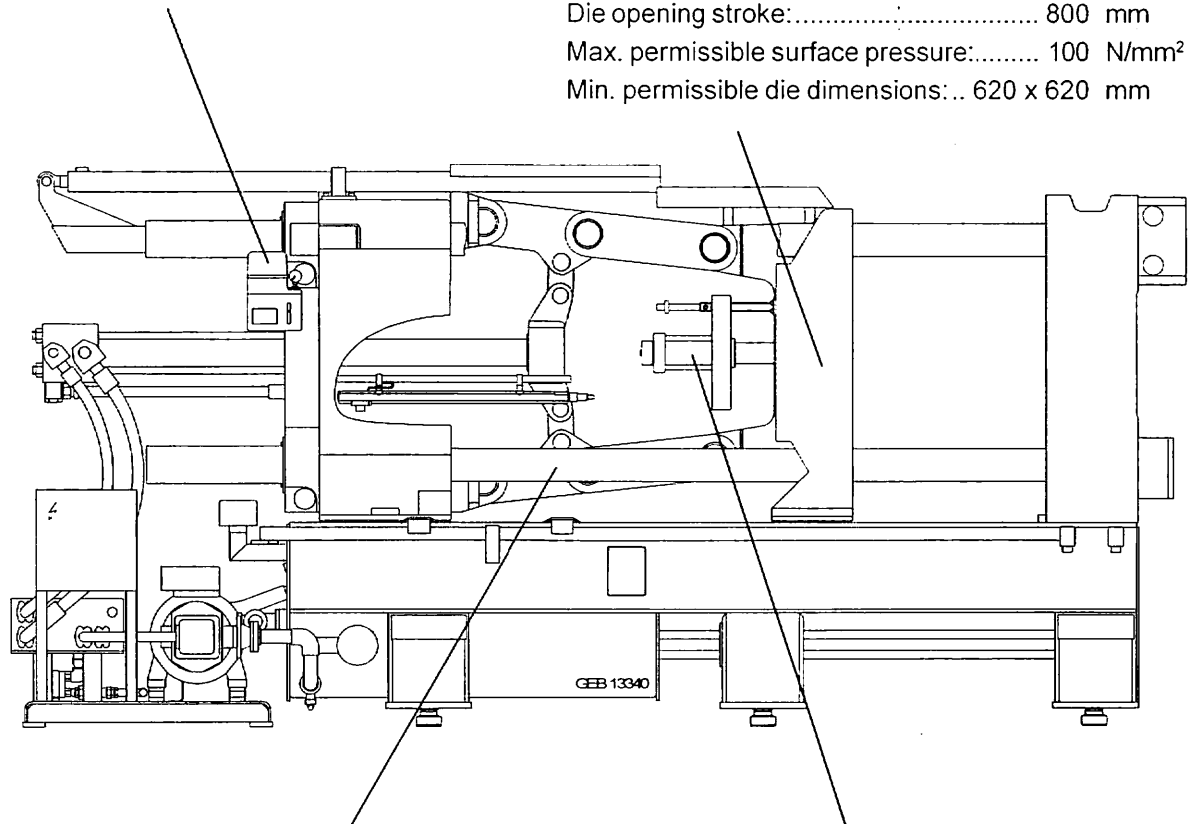
DIE

Die height: 360 - 900 mm

Die opening stroke: 800 mm

Max. permissible surface pressure: 100 N/mm²

Min. permissible die dimensions: .. 620 x 620 mm



TIE BARS

Tie bar spacing: 780 x 780 mm

Tie bar diameter: 150 mm

Tie bar pulling from 0-Linie: 6750 mm

Tie bar removal from 0-Linie: 6750 mm

EJECTOR

Ejector stroke: 175 mm

Ejector force: 225 kN

LOCKING FORCE

Max. locking force: 6615 kN

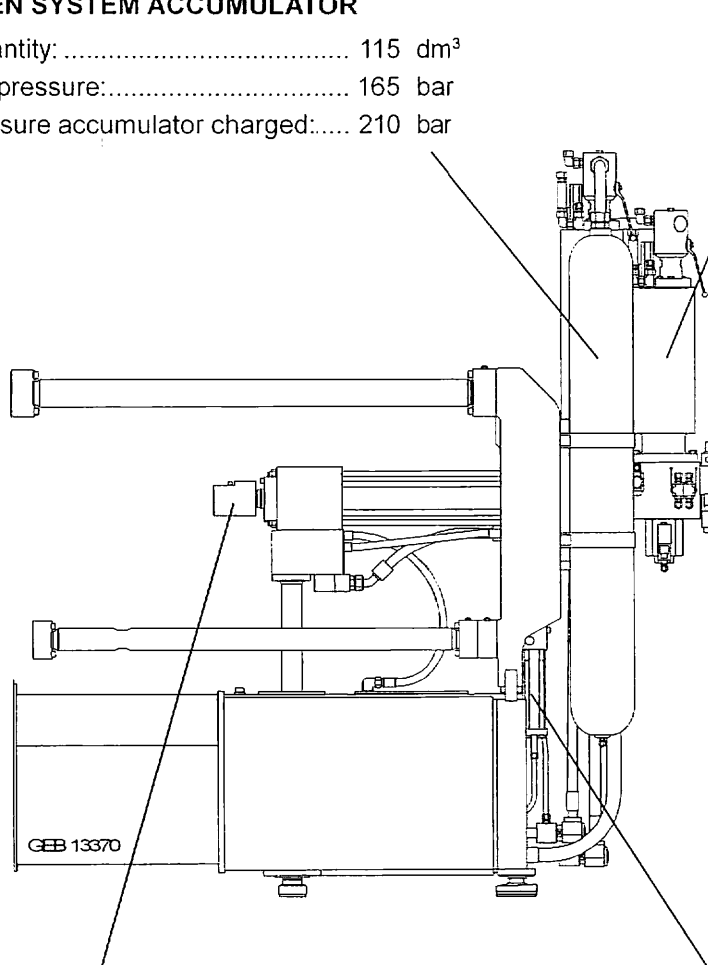
2.9 Shot unit

NITROGEN SYSTEM ACCUMULATOR

Filling quantity: 115 dm³
Max. idle pressure: 165 bar
Max. pressure accumulator charged: 210 bar

NITROGEN SYSTEM INTENSIFIER

Filling quantity: 38 dm³
Max. idle pressure: 185 bar
Area ratio: 1 : 2,25
Stroke: 115 mm



PLUNGER

Injection force dynamic: 290 kN
Injection force intensified: 700 kN
Plunger stroke: 600 mm
Plunger diameter: 70 - 110 mm

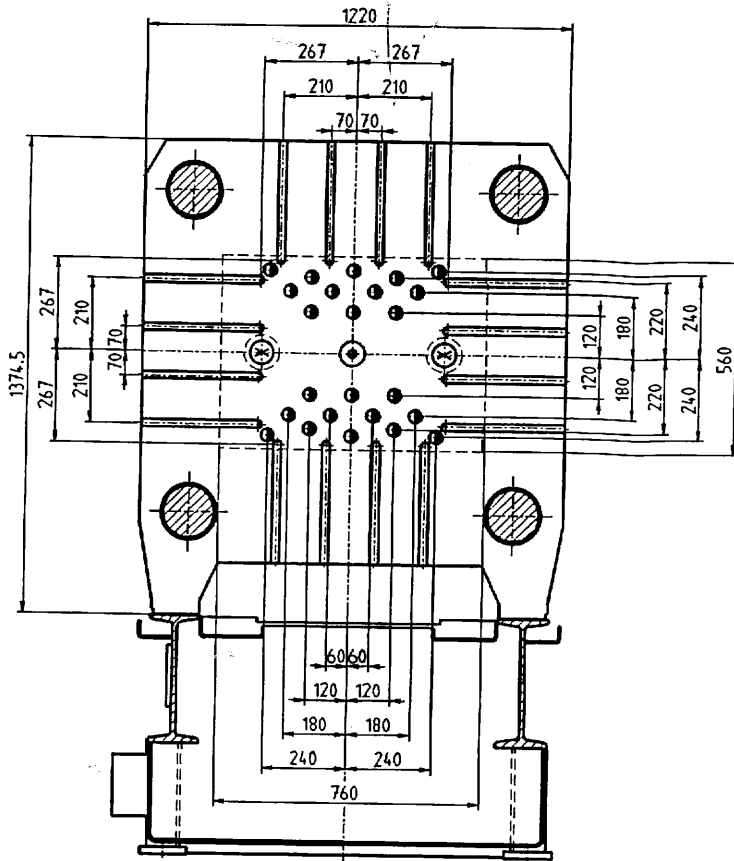
CASTING POSITION ADJUSTMENT

Casting positions: 0 / - 300 mm

PLUNGER LUBRICATION

Filling quantity: 10 dm³

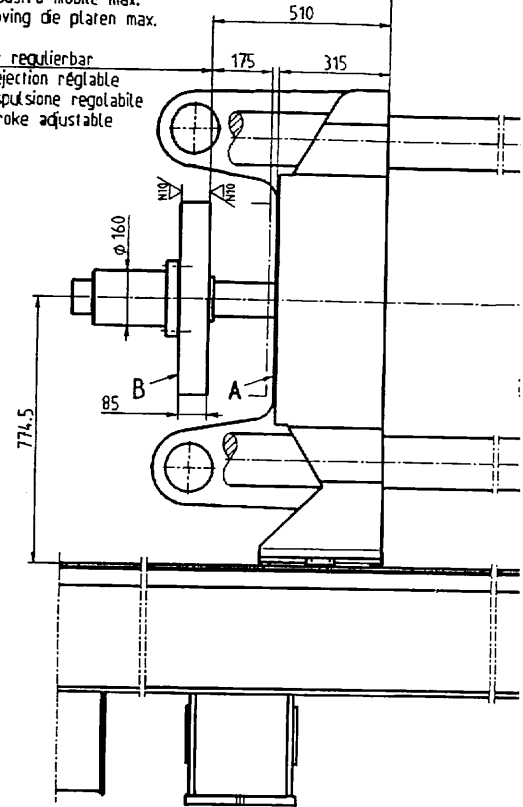
Bewegliche Aufspannplatte
 Plateau mobile
 Piastra mobile
 Moving die platen



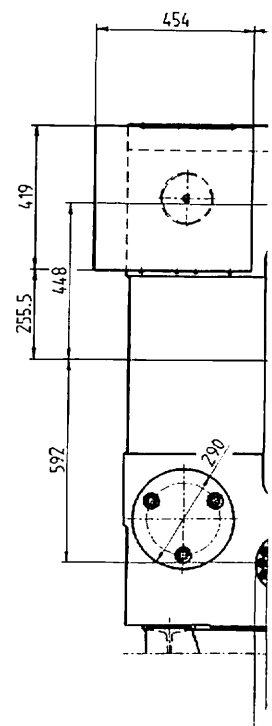
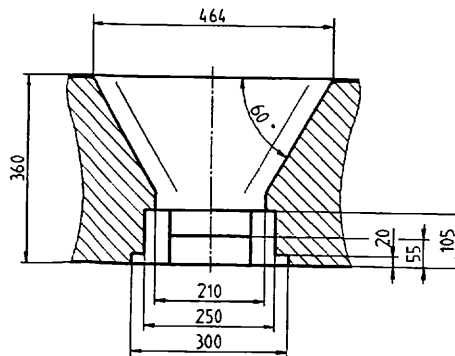
Hub der beweglichen Aufspannplatte max. 800
 Course du plateau mobile max.
 Corsa di piastra mobile max.
 Stroke moving die platen max.

360 - 5

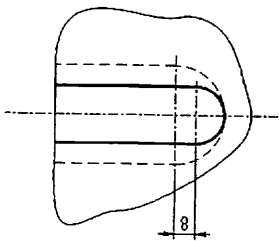
Auswerfer regulierbar
 Course d'ejection réglable
 Corsa d'espulsione regolabile
 Ejector stroke adjustable



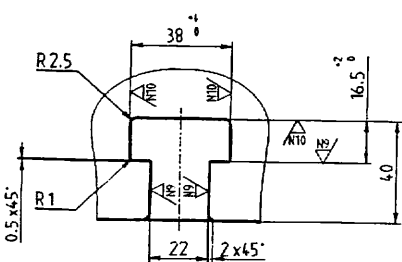
E - E M 15



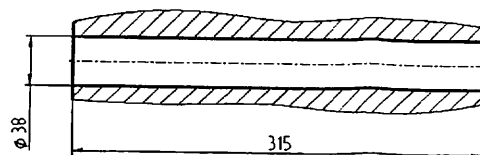
M 1:1



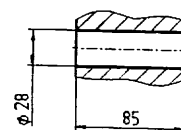
M 1:1

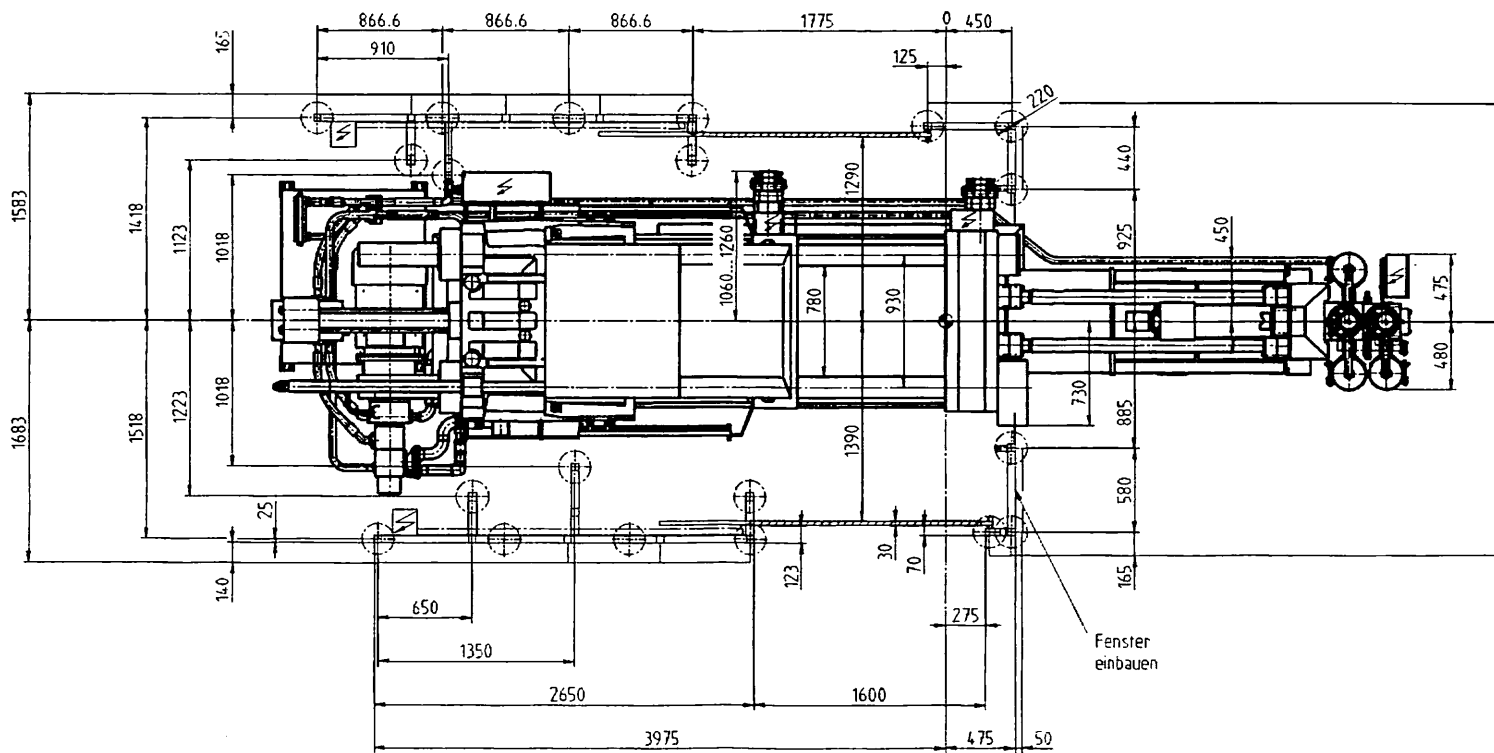
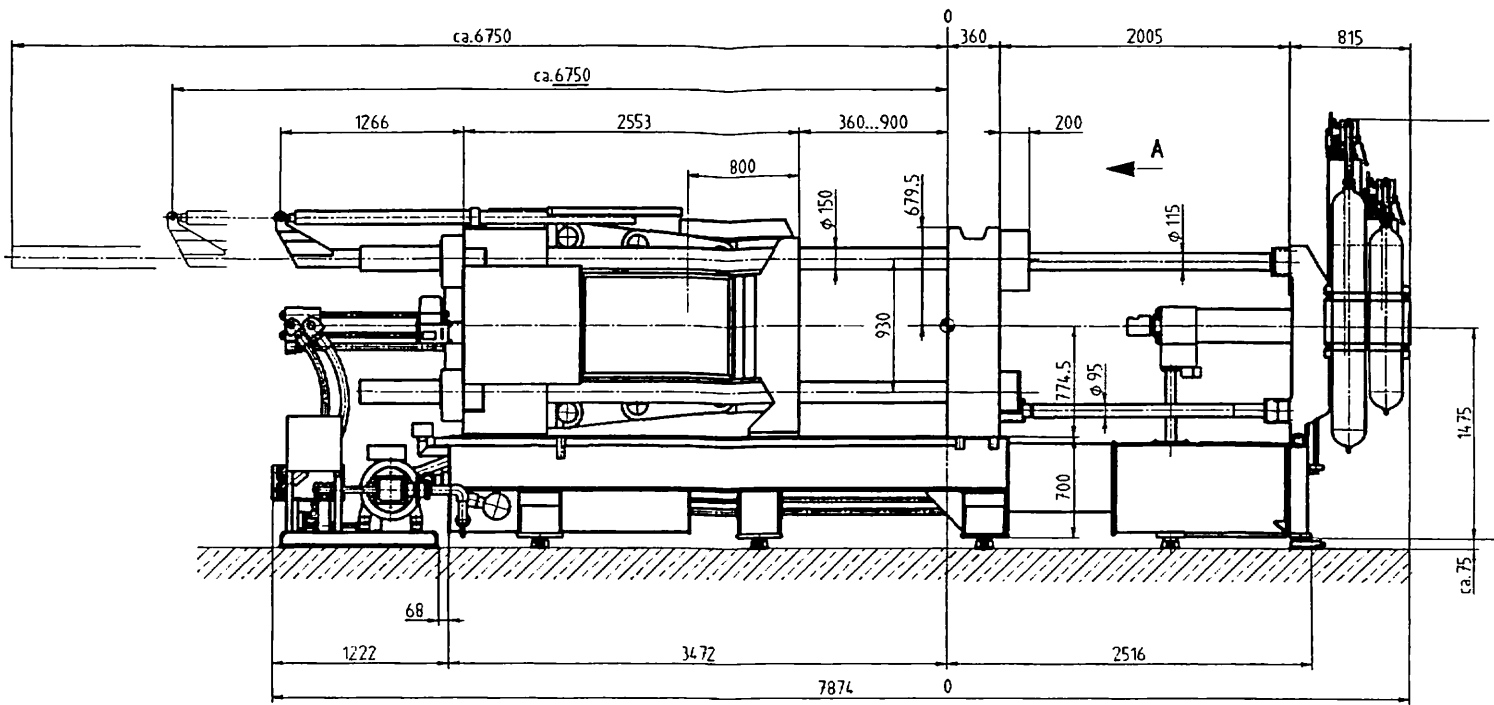


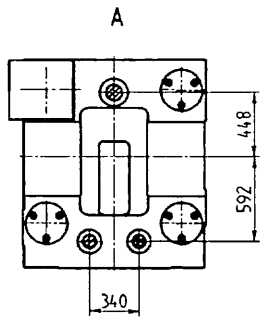
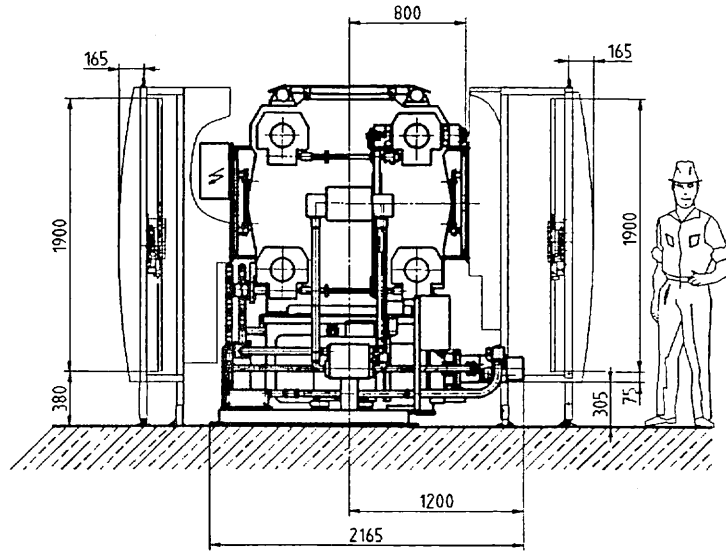
A M 1:2



B M 1:2





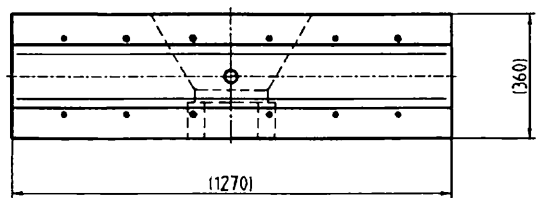
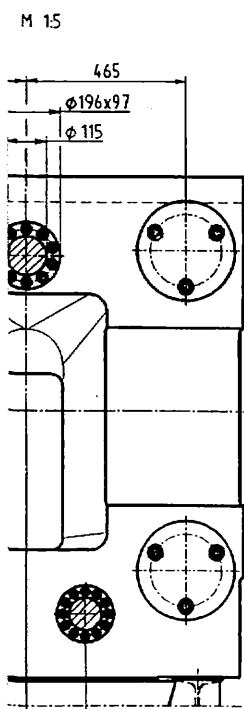
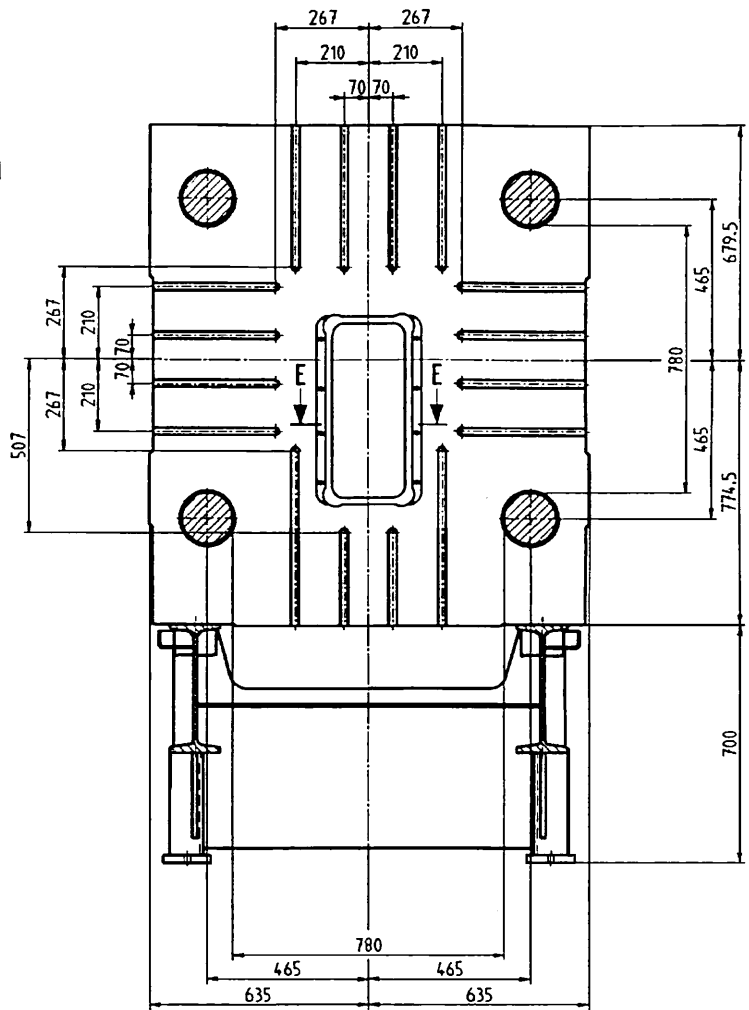
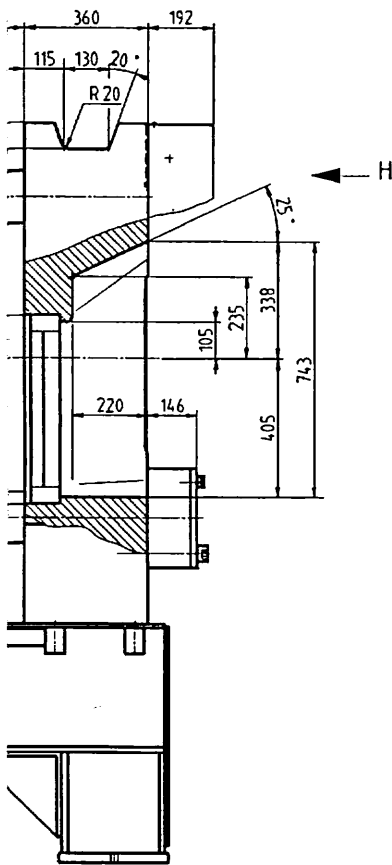


Distanz MM Innenkante Türe rechts: 1290
 links : standard
 Füsse Podesthöhe: 305mm
 Eckwand links: spez.

Evolution 66 D
 Maschinenmassbild
 Dimensioned Machine Drawing
 Plan des dimensions de la machine
 Medidas de la maquina

Druckgessmaschine SC 66/65		Date:	
MASSBILD		Blatt:	
Maschine		Blatt:	
Autoren	Blatt:	Blatt:	Blatt:
Blatt:	Blatt:	Blatt:	Blatt:
Blatt:	Blatt:	Blatt:	Blatt:

Feste Aufspannplatte
 Plateau fixe
 Piastra fissa
 Stationary die platen



- ① Für Auswerfer mit Rückzug
 Pour ejecteur avec rappel
 Per espulsore con ritorno
 For retractable ejector

Minimale Form-Aufspannfläche
 Surface d'appui minimale des moules
 Area minima di fissaggio per stampi
 Minimum area of die casting dies 620x620 mm

Classic
 Evolution 66 D
 Vision

Aufspannplatten
 Plateaux
 Piastra
 Die Platen

Druckgussmaschine SC D/66		Druckgussmaschine (D.S. 9103)	
MASSBLD			
er 58121 (D.S. 9103)			
Hersteller	Modell	Artikel	Preis
Druckguss	Druckguss	66	1111,99
Druckguss	Druckguss	66	1111,99
Druckguss	Druckguss	66	1111,99
Druckguss	Druckguss	66	1111,99

0,5x45
 95
 166x158
 170