

SSE-91011

(f) Others

- 1) Ejection can be made only when the core cylinder is located at the return end position.
- 2) Die locking and core in-out operation can be made only at the ejection return end position.

3. Specifications

(a) Die closing		
Die locking force	ton	1,650
Die platen dimensions (vertical by horizontal)	mm	2,260 x 2,060
Tie bar distance (vertical by horizontal)	mm	1,500 x 1,300
Tie bar diameter	mm	280
Die stroke	mm	1,000
Maximum die thickness	mm	1,700
Minimum die thickness	mm	700
Die adjusting speed	mm/ min	130
(b) Injection		
Injection force (boost ratio 1:26)	ton	(Maximum accumulator pressure 135kg/cm ²) 137 [~] 53
Plunger stroke	mm	1,100
Plunger tip protrusion	mm	(From stationary die platen) 450
Injection port position (1-stage only)	mm	(From machine center to lower side) 350

SSE-91011

Injection speed	m/sec	(Empty shot, low speed)	0.1~1.0
	m/sec	(Empty shot, high speed)	5.0
(c) Ejection			
Ejection force	ton		80
Ejection stroke	mm		0~200
(d) Cycle			
Die close stop, locking, opening, total of ejection and valve change time	sec	50Hz	14
	sec	60Hz	12
(e) Core			
Core 1 and core 2 (non-operation side of the moving die platen)		Solenoid valve 3/4	Each one
Core 3 (non-operation side of the stationary die platen)		Solenoid valve 3/4	One
Hydraulic port diameters of cores 1 and 2	in	(For each solenoid valve) PT 3/4	4 sets
Hydraulic port diameters of core 3	in	(For each solenoid valve) PT 3/4	2 sets
Plug receptacles IN-position 2P-25 reversed core OUT-position 2P-30 reversed core		(For each solenoid valve)	1 set

SSE-91011

(f) Cooling water		
Die cooling water supply port connection pipe diameter		PT1.1/2
Die cooling water drain port connection pipe diameter		PT3
Oil cooler cooling water supply/drain pipe diameter		PT1" (IN) PT1" (OUT)
Die cooling water rubber hose inner diameter	mm	12 ϕ
Number of die cooling water regulating valves		20 on the operation side of moving die platen
		20 on the stationary die platen
Required cooling water (for oil cooler)	l/min	At water temperature of 25°C 40
(g) Machine dimensions		
Required floor space	mm	2,950x12,700
Machine height	mm	4,500
Machine weight	ton	125

(h) Casting capacity

The shot volume in the following Table is based on the assumption that the plunger stroke is 850mm and the molten metal is fully changed into the sleeves. The actual shot weight is based on the assumption that the specific weight of the aluminum alloy is 2.6.

The values in parentheses in the following Table are obtained when the injection force is set at 53 tons (minimum injection force).

SSE-91011

Plunger tip diameter mm	Casting pressure kg/cm ²	Casting area cm ²	Actual shot volume cm ³	Actual shot weight kg
100	(675)~1745	(2440)~945	6670	17.3
115 (standard)	(510)~1320	(3235)~1250	8825	22.9
130	(400)~1030	(4125)~1600	11275	29.3

(i) Hydraulic pipe

Vane pump	150kg/cm ²	2
Vane pump	70kg/cm ²	1
Tank capacity		1,700ℓ
Required hydraulic oil quantity		2,000ℓ

(j) Electrical system

Three-phase induction motor	For hydraulic pump	6P 200V 22kW	
(Enclosed type drip-proof type)		50/60Hz continuous	1 set
Three-phase induction motor	For hydraulic pump	6P 200V 37kW	
(Enclosed drip-proof type)		50/60Hz continuous	1 set
Three-phase induction motor	For lubricating pump	4P 200V 100W	
(Totally enclosed type)		50/60Hz continuous	1 set
Three-phase induction motor	For lubricating pump	4P 200V 50W	

SSE-91011

(Totally enclosed type)	50/60Hz continuous	1 set
Electrical control equipment		1 set
Power capacity		90kVA
Power source	3 phases 200V±10% 50/60Hz	

4. Standard Accessories

- (a) Maintenance tools 1 set
- (b) Installation parts (anchor bolts, sole plates hexagonal nuts and levelling blocks) 1 set

5. Accessories

- (a) Plunger sleeve (Refer to the attached plunger drawing S-93486E) 1 piece

Standard sleeve (standard diameter 115mm)

Please specify the diameter.

- (b) Plunger tip (fitted to the plunger sleeve diameter) 1 piece
- (c) Other injection parts supplied on the machine are our standards. 1 set

(Plunger rod, coupling, rod coupling, spacer)

6. Other Specification Items

- (a) For the arrangement of the die mounting T-slot and ejection holes, refer to the attached drawings.