



CORE MACHINE TYPE D-4, MODEL U-210



This machine produces cores and shell moulds by hot-box procedure.

Machine can work in manual, semiautomatic and automatic cycle.

Controlling electro box PLC control.

Starting by pedal, machine door closed and frame moves forward, when tool is closed, sand tank is lifted, machine turns for 180° and injects sand.

Keeping the machine in upper position (180°) wall depth of the core is timely regulated and machine goes to the basic position.

Machine moves left-right for 45°. It is timely regulated. If cores are simple and straight, it could be turned off.

After baking or gassing the tool is opened and the core remains in movable part of the tool. The movable part of the tool turns for 90 degrees over the lane for core reception and transport. With the knocker the core is automatically knocked out and it gets onto the lane, the lane moves for the core size towards the worker who overtakes the core from the lane and puts it away. Tilted half of the tool returns to vertical position, moves ahead, closes and continues the next cycles.

Advantages of this machine are

1. Completely automatic work cycle, cores are falling automatically on the line and machine starts a new cycle.
2. Robust and heavy cores can be produced on this machine.

TECHNICAL CHARACTERISTICS:

Heater plate size	750 x 800 mm
Daylight between mounting blocks	600 mm (max), 100 mm (min)
Core box thicknes	300 mm (max), 100 mm (min)
Ram cylinder stroke	508 mm
Core box weight (max)	450 kg each half
Dump box capacity	93 kg
Heat source	Gas or Electric
Compressed air	5 - 7 bar
Electricity requirements	
- supply	220 V, 50 Hz
- control circuit	24 VDC
Power consumption	
- gas heated machine	3 kW
- electrically heated machine	50 kW
Standard voltage	220 V, 50 Hz
Gas-pressure (PB or natural)	550 mbar (max), 100 mbar (min)
Approximate weight	3500 kg