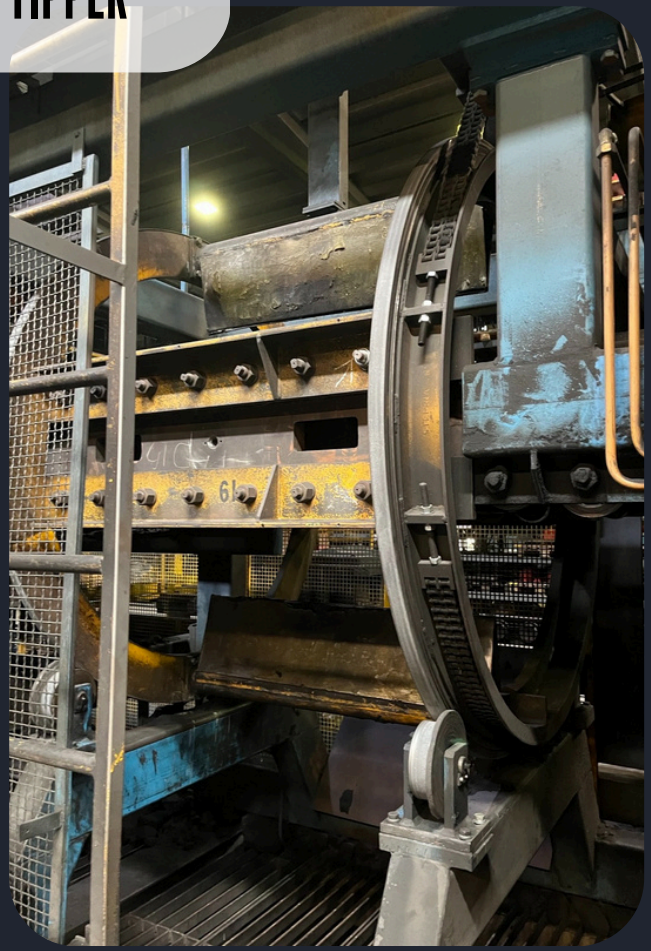
TIPPER

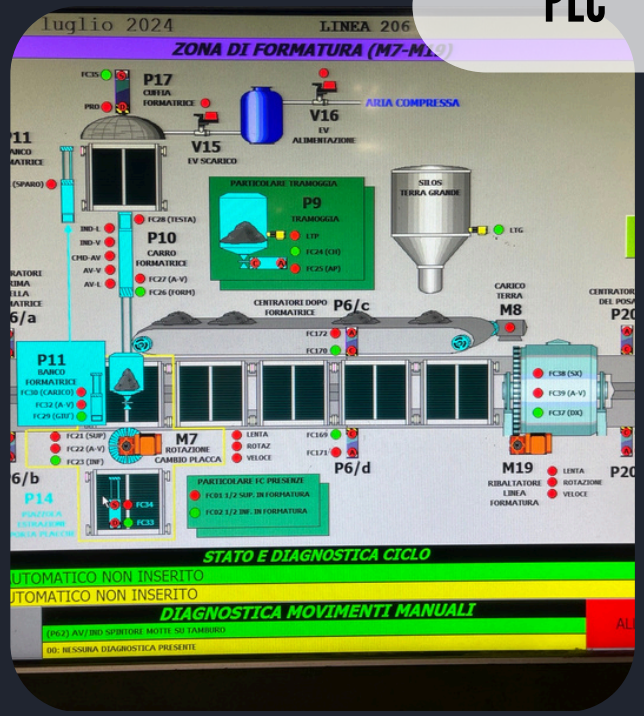


AUTOMATIC MOLDING AND GREEN SAND PREPARATION PLANT

COMPLETE PLANT AND

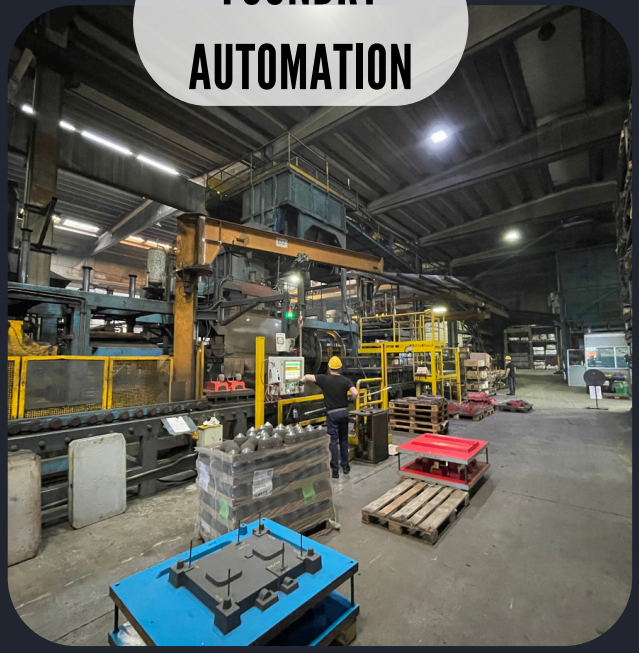
INDIVIDUAL MACHINES

PLC





FOUNDRY AUTOMATION



1987

Plant of a leading Italian foundry that over the years has undertaken continuous improvements and digitalization, aiming to enhance quality, process control, and safety while consistently complying with current regulations.

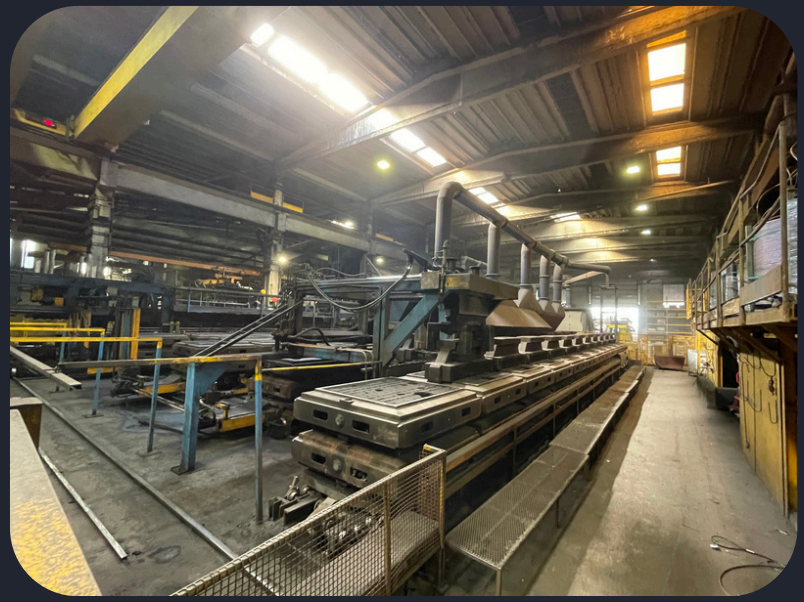






GENERAL PLANT FEATURES

INTERNAL DIMENSIONS OF MOLDS: 1000x1200x400+400
HOURLY PRODUCTION: 20 complete molds
MOLDS IN CYCLE: 90 complete molds
PALLETS IN CYCLE: 95
MOLDS IN CORE SETTING: 6 lower + 5 upper
MINIMUM COOLING TIME: 1.5 hours
SAND CONSUMPTION: 70 tons/h



MAIN COMPONENTS

Automation and control system
Vibrating shake-out unit type GSV 22/80
Support structure for conveyors above silos
Hopper with extractor belt for molding machine feed
Conveyor feeding hopper above the molding machine
Pe-kay
3 feed conveyors
1 conveyor for collecting mixed sand
3 screw conveyors
Conveyor for feeding the muller
2 extractor conveyors
2 sand silos
2 silo feed conveyors
Bucket elevator
Fluidized bed cooler type GRF 12-750
Conveyor under the cooler
Sieve
Hopper with extractor belt for cooler feed
Screen feed conveyor
Permanent magnet separator
Magnetic pulley
2 intermediate return conveyors
Conveyor for collecting sand from the drum
Hydraulic power unit
Flask sorting and recovery lines
Weight group
Casting line feed trolley
JOST TWFE 1600 x 8000 shake-out unit
Complete and updated electrical schematics

FLASK STORAGE



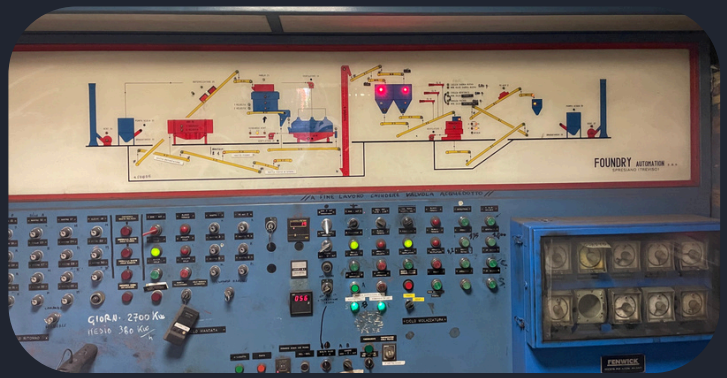


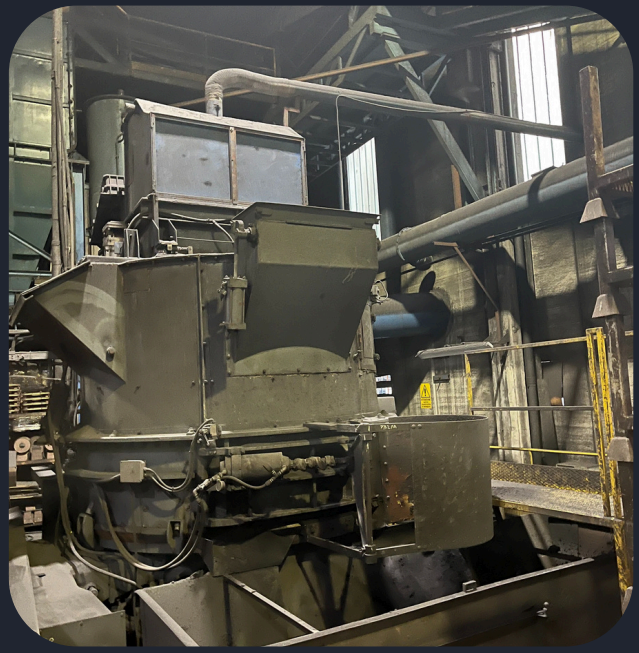
FLUIDIZED BED

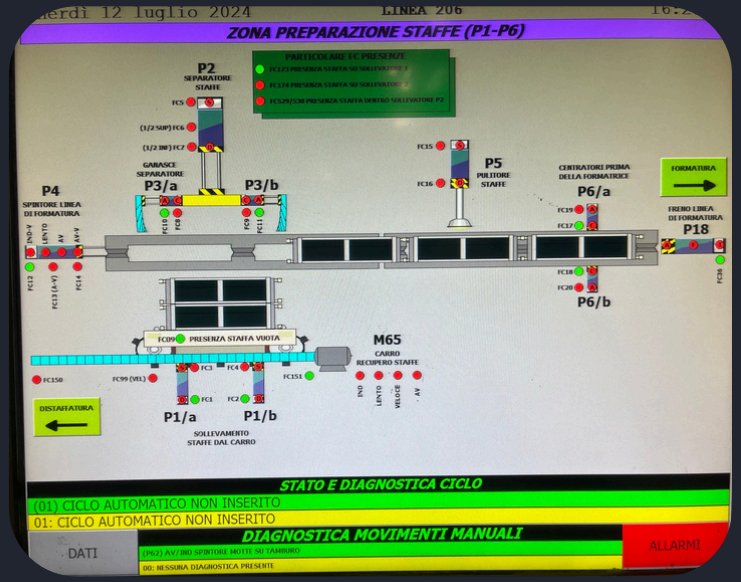


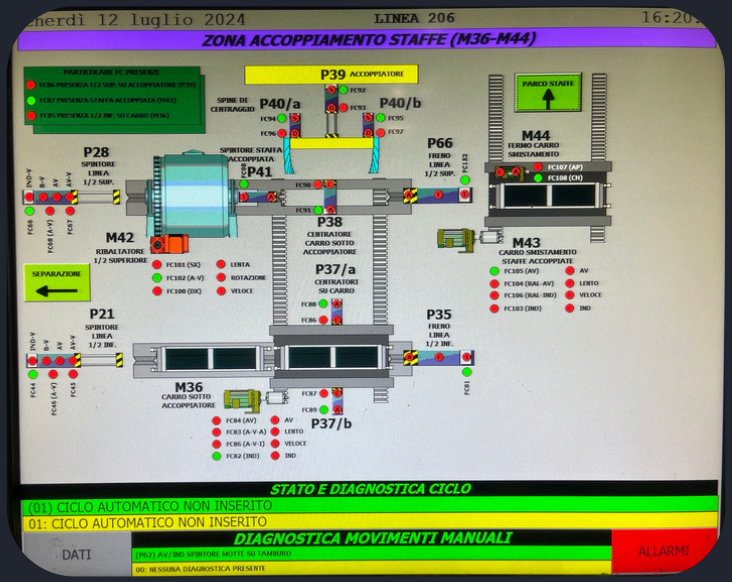
FOUNDRY AUTOMATION

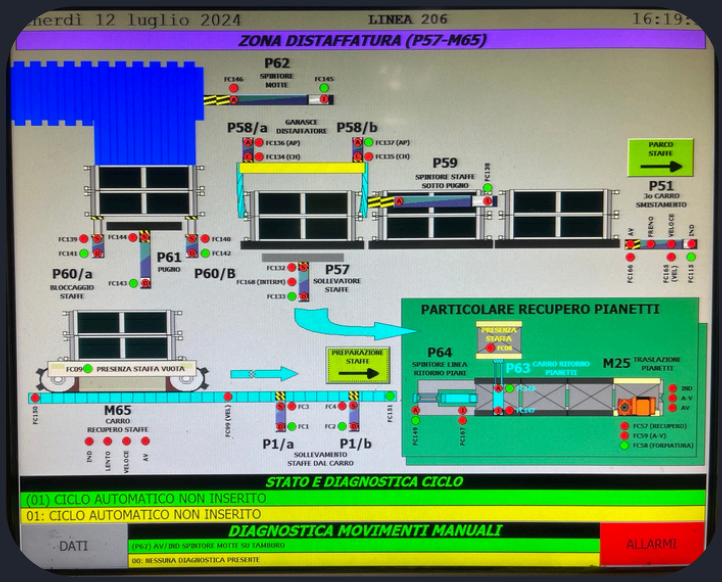
- Shot head type: "Adiabatic" shock wave forming machine
- Muller: Speed Muller type 100B, with production capacity up to 120 tons/h
- Fluidized bed: Fluidized bed cooler complete with temperature and humidity sensors
- Shake-out unit: Continuous discharge vibrating shake-out unit (Manufacturer: Jost)
- Sand system: Including belt conveyors, storage silos, and a DISA in-line control system for continuous adjustments

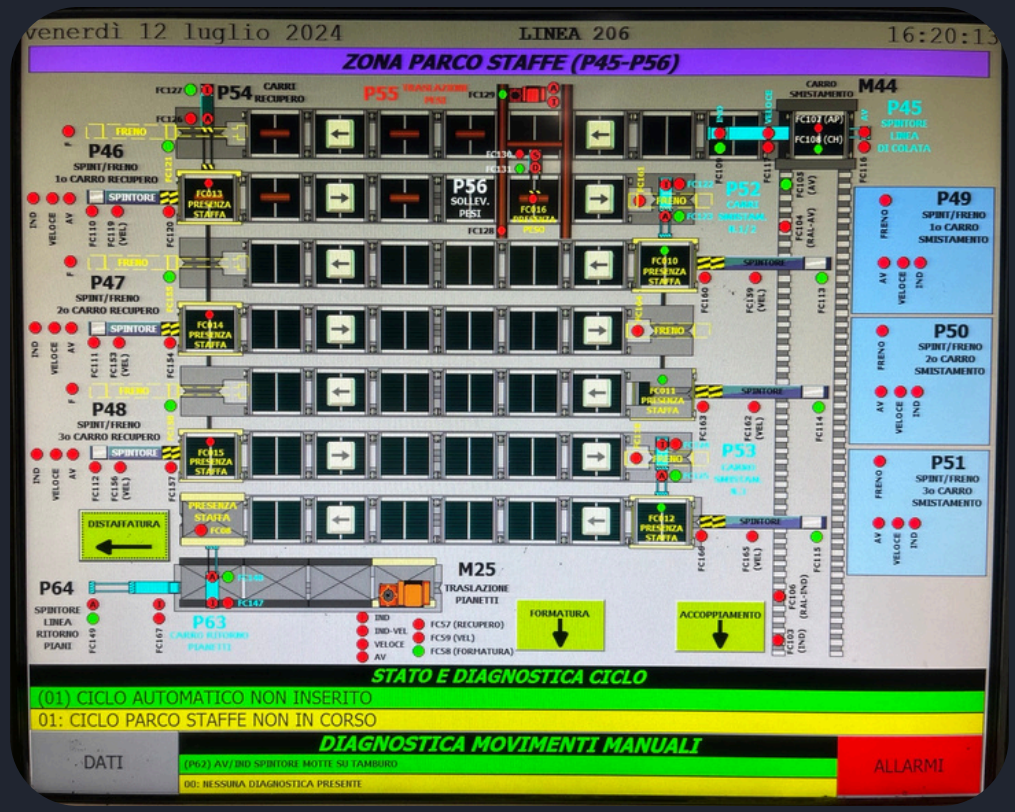


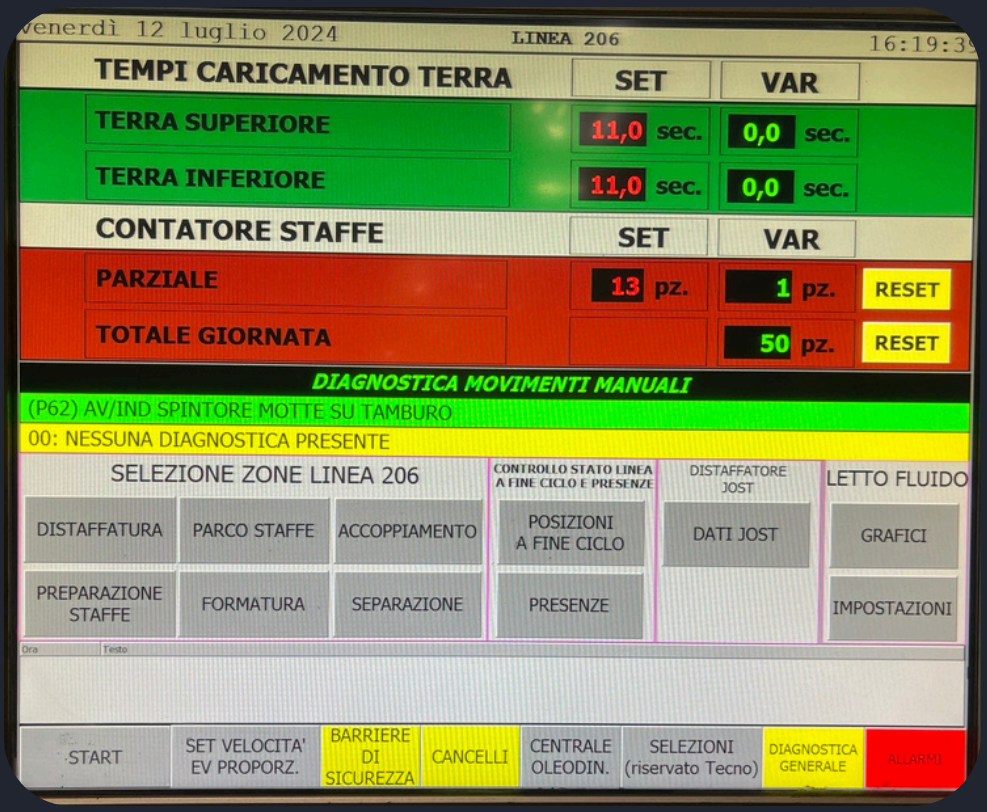



LINEA 206
ZONA PREPARAZIONE STAFFE (P1-P6)
STATO E DIAGNOSTICA CICLO
(01) CICLO AUTOMATICO NON INSERITO
01: CICLO AUTOMATICO NON INSERITO
DIAGNOSTICA MOVIMENTI MANUALI
DATI
ALLARMI


LINEA 206
ZONA ACCOPPIAMENTO STAFFE (M36-M44)
STATO E DIAGNOSTICA CICLO
(01) CICLO AUTOMATICO NON INSERITO
01: CICLO AUTOMATICO NON INSERITO
DIAGNOSTICA MOVIMENTI MANUALI
DATI
ALLARMI


LINEA 206
ZONA DISTAFFATURA (P57-M65)
PARTICOLARE RECUPERO PIANETTI
STATO E DIAGNOSTICA CICLO
(01) CICLO AUTOMATICO NON INSERITO
01: CICLO AUTOMATICO NON INSERITO
DIAGNOSTICA MOVIMENTI MANUALI
DATI
ALLARMI


LINEA 206
ZONA PARCO STAFFE (P45-P56)
STATO E DIAGNOSTICA CICLO
(01) CICLO AUTOMATICO NON INSERITO
01: CICLO PARCO STAFFE NON IN CORSO
DIAGNOSTICA MOVIMENTI MANUALI
DATI
ALLARMI


LINEA 206
TEMPI CARICAMENTO TERRA
SET
VAR
TERRA SUPERIORE
11,0 sec.
0,0 sec.
TERRA INFERIORE
11,0 sec.
0,0 sec.
CONTATORE STAFFE
PARZIALE
13 pz.
1 pz.
RESET
TOTALE GIORNATA
50 pz.
RESET
DIAGNOSTICA MOVIMENTI MANUALI
(P62) AV/IND SPINTORE MOTTE SU TAMBURO
00: NESSUNA DIAGNOSTICA PRESENTE
SELEZIONE ZONE LINEA 206
DISTAFFATURA
PARCO STAFFE
ACCOPPIAMENTO
PREPARAZIONE STAFFE
FORMATURA
SEPARAZIONE
CONTROLLO STATO LINEA A FINE CICLO E PRESENZE
POSIZIONI A FINE CICLO
PRESENZE
DISTAFFATORE JOST
DATI JOST
LETTO FLUIDO
GRAFICI
IMPOSTAZIONI
START
SET VELOCITA' EV PROPORZ.
BARRIERE DI SICUREZZA
CANCELLI
CENTRALE OLEODIN.
SELEZIONI (riservato Tecno)
DIAGNOSTICA GENERALE
ALLARMI

OPPORTUNITY TO OBSERVE THE PLANT IN OPERATION BY PRIOR ARRANGEMENT

