

1000X1000 AUTOMATIC GREEN SAND MOLDING MACHINE



MACHINE FEATURES	VALUES
Total Sand Height	300 mm-400 mm / 300 mm-500 mm
Machine Dimensions (Excluding Elevator)	2400mm x 5600mm x 4500 mm
Elevator System	Hydraulic
Capacity	80 Pieces (Cycle 45 sec)
Model Cleaning System	Manual (Air Gun)
Model Heating System	Infrared Bulbs (Auto-Manual)
HMI	9 inch SIEMENS or 15 inch EXOR
Software	Compatible with Industry 4.0
Software Language	Turkish-English
PLC	SIEMENS S7-1200 or MITSUBISHI FX5U
Switchgear Automation Products	SIEMENS or EATON
Hydraulic Unit	BOSCH REXORT
Machine Blowing System	Separate Blowing for Upper and Lower Degree
Working Mode	Auto -SemiAutomatic - Manual
Machine Failure Status	Fault Information and Light Warning
Machine Total Power	60 kw
Machine Movements	Speed and Direction Proportional Control
Hydraulic Oil Volume	1400 lt
Maximum Press Force	82 tons (under)-82 tons (upper)
Machine Column Shafts	Induction Chrome Shaft
Machine Tables	Sfero Molding
Machine Table Bearings	14 Tinned Yellow
Machine Lubrication System	Auto-Manual
Machine Working Way	Spades ve Without Spades
Mold Hardnesses	90 Shore
Blowing Pressure	4-7 Bar
Work safety	Light Barrier-Double Hand Button
Mold Plate Thickness	27-33 cm- Standard 30 cm
Machine Net Weight	23 Ton
Machine Location Information	Lower Press, Lower Grade, Model Push, Upper Grade, Upper Ram Head, In-Cylinder Linear Ruler
Sand mold weight	600 kg (Max Sand Height)

PANEL PLACEMENT



(1)



(2)



(3)



(4)

(1) SIEMENS SINAMIC V20 DRIVER GROUP

(2) HUBBOX REMOTE ACCESS DEVICE

SIEMENS ETHERNET SWITCH

SIEMENS SECURITY PLC

SIEMENS POWER SUPPLY

SIEMENS S7-1200

ADDITIONAL MODULES

(3) SIEMENS INSURANCE GROUP

SIEMENS ENGINE PROTECTION SWITCHES

SIEMENS SOFT STARTERS

(4) MOSFET CARDS

(5) CAM FUSES - DC 24 V RELAYS - PHASE PROTECTION RELAY



(5)

HYDRAULIC UNIT



(1)



(2)



(3)



(4)



- (1) HYDRAULIC UNIT LABEL
- (2) PRESSURE BAR HOURS
- (3) PUMP MOTORS
- (4) DISTRIBUTOR BLOCK
- (5) LINEAR RULER
- (6) REXROTH HYDRAULIC UNIT TOP VIEW

