



**MET-TECH | Product Data Sheet**  
**AUTOMOTIVE HOUSINGS LINE - 660 - 5000 CC**

**Ref. No.:** CASTERAUTOMOTIVE201001

**Year:** 2016-2018

**Brand:** FUJI, LAEMPE, SINTO, TOKIWA ETC.

**Qty.** 1 Second-hand Casting Plant for Automotive Turbocharger Housings

**Mfc.:** Fuji, Laempe, Sinto, Tokiwa, Dafuku, Alpha Germany / Japan

**Built:** 2016 - 2018 Stopped

**Product:** Turbocharger housings for 660 cc ? 5000 cc automotive engine

**Consisting of:** Induction furnaces (x2) Core shooters (x6) Main molding machine External peripheral coating devices Automatic warehouse

Core dipping device Resin tank Conveyors Rotary kiln Crop equipment Dust collector Air transporter Electric equipment Runner breaker Sintering furnace Mixer Shot blasting unit Tower type drying furnace Chemical dispenser Rack master Bucket elevator Lifter Robots

**SPECIFICATION**

**Qty.** 2 x High frequency induction furnaces

**Mfc.:** Fuji (Japan) Built

**Power:** 3000 kW Frequency

**Temperature:** 1600°C Inside diameter

**Body size:** 1600 mm (dia.) x 1554 mm (H)

**Main Transformer:** 6600 V/940 V-940 V, 3900 kVA, 60 Hz

**Qty.** 1 x Dust collector for induction furnace

**Mfc.:** Sinto (Japan) Size

**Qty.** 2 x Automatic core shooters

**Mfc.:** Laempe (Germany) Built

**Shooting capacity:** 50 litres Hydraulic force exerted by table cylinder

**Capacity of vacuum pump:** 25 m<sup>3</sup>/h Stroke carriage

**Stroke gassing carriage:** 1400 mm Stroke of machine table

**Maximum stroke of ejector:** 255 mm

**Distance between upper edge carriage to lower edge shooting head:**

1300 mm

**Distance between the guide shafts:** 2154 mm

**Weight of heaviest single component:** 9 tonnes

**Corebox measurements and weights:**

**Max.:** width

Maximum gassing area with gassing hood and integrated cope eject

**Plate:** width x depth

**Max. length of shoot nozzle:** 110 mm

**Maximum weight of core box (incl. shoot plate + ejector plate):** 3500 kg

**Machine cycle time:** 17 sec

**Core box change:** horizontal tooling including shooting plate with automatic tool changer

**without automatic tool changer:** ~8 min

**Power consumption:**

**Necessary exhaust capacity of cabin:** ~4500 m<sup>3</sup>/hour

**Air consumption at constant use with 6 bar, without gas generator & without periphery:** ~20 m<sup>3</sup>/h

**Power at 400 V, 50 Hz:** average consumption = 20~25 kWh

**without gas generator & without periphery:** 50 kW

**Hydraulic:** Maximum rated pressure

Qty. 4 x Automatic core shooters

**Mfc.:** Laempe (Germany) Year

**Shooting capacity:** 20 liters Hydraulic pre-load (clamping force) of table cylinder

**Capacity of vacuum pump:** 16 m<sup>3</sup>/h

**Stroke carriage:** 700 mm Stroke gassing carriage

**Stroke of machine table:** 400 mm Max. stroke of vertical ejector

**Distance between upper edge carriage to lower edge shooting head:** 720 mm

**Total weight of machine with control system, hydraulic system and enclosure:** 6400 kg

**Corebox measurements and weights:**

**Max. width, horizontally parted:** 900 mm Max. depth

**Max. height:** 630 mm Min. height horizontal partition

**Max. height top part:** 230 mm Max. weight of bottom part

**Max. weight cope:** 200 kg Max. core box weight

**Max. gassing area, width x depth:** 71 mm x 550 mm

**Times (without gassing, shoot, exhaust times):**

**Machine cycle time, using horizontally parted core box:** 18 sec.

**Core box change of horizontally parted tools, including shooting plate:**

~6 min.

**Power consumption:**

**Necessary exhaust capacity of cabin:** ~3000 m<sup>3</sup>/hour

Air consumption at constant use with 5 bar, 90 cycles/h without gas generator, without

**periphery:** 12 m<sup>3</sup>/h

**Power at 400 V, 60 Hz, without gas generator, without periphery:** 8.7 kW

**Total power with integrated gas generator (Amin vapouriser) 3 kW:** 11.7 kW

**Hydraulic:**

**Max. rated pressure:** 200 bar Volume of oil tank

Qty. 1 Mixer

**Mfc.:** Laempe (Germany) Model

**Sand dosing volume:** 36 litres Number of sand outlets

**Additive connection (solids):** dia. 55 mm Pneumatic operating pressure

**Cycle time:** 35 sec. Air consumption at constant operation with 5 bar

**Installed load at 440 V, 60 Hz:** 8.6 kW

**Total weight without additive:** 1000 kg Total weight with additive and sand

Qty. 1 Core dipping machine

**Mfc.:** Tokiwa (Japan) Body internal material

**Heater:** 2.5 kW x 25 = 62.5 kW Normal temperature

**Temperature control:** SCR proportional control

Qty. 1 Lifter

**Mfc.:** Sinto (Japan) Size

Qty. 1 Rack master

**Mfc.:** Dafuku (Japan)

**Load size:** W x L x H = 900 mm x 1830 mm x 505mm Load weight

**Pallet size:** W x L x H = 900 mm x 1830 mm x 75 mm

**Horizontal travel speed:** 100 m/min ~ 3 m/min Vertical travel speed

**Shuttle fork:** 31.5 m/min ~ 5 m/min

Qty. 1 Rotary kiln

**Mfc.:** Alpha (Japan) Model

**Body Size:** 1000 mm x 1900 mm x 1700 mm (H)

**Cell size:** 450 mm (dia.) x 550 mm (L) Cell materials

**Cell revolution:** 18 RPM / 60 Hz Sensors attached

**Dust collector attached Heater:** 2.8 kW x 3 = 8.40 kW

**Input:** 16 litres Weight of kiln

**Normal temperature:** 500°C Coil type feeder

**Tank volume:** 26 litres