

FOUNDRY

10000 TONS GREY IRON – GG20 – GG25

FULLY AUTOMATED FOUNDRY PLANT OF GERMAN AND DUTCH HIGH TECHNOLOGY. IT IS EXTREMELY WELL MAINTAINED AND ALL MAINTENANCE RECORDS ARE PROPERLY KEPT AND WELL DOCUMENTED. ALL ORIGINAL DRAWINGS AND MANUALS ARE ALSO AVAILABLE. THE FOUNDRY PLANT HAS BEEN OPERATED ONLY ONE SHIFT OF ITS DESIGNED CAPACITY OF 10000 TON AND IT IS FULLY OPERATIONAL, PRODUCING HIGH QUALITY ENGINEERING CASTINGS WHICH ARE CURRENTLY SOLD WORLDWIDE.

SEIATSU Moulding Machine EFA-SD, made by Heinrich Wagner Sinto (H.W.S) German.-1987

The EFA-SD is a flexible machine that can be used for all normal flask sizes. The machine is equipped with a turntable and moulds cope and drag boxes in rapid sequence. The mould boxes pass through the machine in a line. A lifting table lifts the pattern plate, mould box and the filling frame underneath the opening of the sand dosing device that fills the mould area with a controlled quantity of sand. The dosing device makes a shuttle movement on the sand loading unit and the crown of the press moves over the mould box. After compacting, the pattern is lowered. All functions for the manufacture of the mould are controlled by a preset programme.

The single moulding automatic EFA-SD is used exclusively in automatic moulding lines.

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|--------------------------|---------------|
| Machine type | EFA-SD4 |
| Flask size (mm) | 660 x 660x660 |
| Throughput (moulds/hour) | 60-70 |
| SOFTWARE PROGRAM | ALS STEP 5 |
| Capacity (tons/year) | 10000 |

Core Department.--2001

Two Laempe core shooters made in Germany volume 16 and 20 liters. Average machine cycle time from 10 sec. (without gassing, shoot, exhaust). Tooling change-over time approx. 3 min. The Ashland process uses an organic-based binder capable of producing cured cores in a matter of seconds at room temperature. Gray and ductile iron, aluminum, brass all display excellent casting results.

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| CORE SHOOTERS | LAEMPE SERIES LL16 & LL20 |
| SIBELCO SILICAN SAND | M32 AFS 55 |
| ASHLAND CHEMICALS | COLD BOX NO- BAKE |

Melting Plant- Cold blast cupolas.-1987

3-Tons per hour cupola with 2-tons metal holder receiver and electrically driven pouring ladle. Dust Collectors offer excellent filtration efficiency for product recovery systems, large bin venting applications and general nuisance dust collection.

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| Cold Blast Cupolas | 2 |
| Weighing platform | Type DKF UHDE |
| Electromagnet, Coke and Limestone supply | YES |
| Electro-pneumatic positioner | SR1 982 |
| Software Digital Weight indicator | PR1555 Philips |
| Dust collector system | TUV HELLAS MEMBER OF RWTUVGROUP |

Produced Metals

AISI/SAE/ASTM
DIN
France

Gray
cast iron
A48, Class 30B, 35B, 40B
GG20 up to GG25
Ft20D up to Ft25D

Tin Bronze Group

Brass

Testing Equipment.--1987

Since July 2000 certified to BS EN ISO 9001:2000. Our quality department monitors a variety of procedures to ensure product quality. These include purchased material control, materials testing, product assessment, conformance audits, corrective action, personnel training, statistical process control. Our metallurgical laboratory capabilities include optical emission spectrometer, carbon analyzer, brinell hardness testers, and mechanical properties testing.

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| ARL METAL ANALYZER | MODEL 3460 |
| METAL ANALYZER II | QUIK-LAB II |
| METAL TEST | CHILL TEST-TENSILE STRENGTH-HARDNESS. |

ACTIVE CLAY-DEAD CLAY-VOLATILES-SIEVE
ANALYSIS-MOISTURE-GREEN STRENGTH-

SAND TEST

SHATTER INDEX-
PERMEABILITY-
COMPACTABILITY.

Patternmaking.--1987

The pattern shop is an integral part of the business, providing periodical repairs and alterations to customers' patterns as well as designing and fabricating new pattern equipment. Only quality materials are used in the pattern shop, principally pine and resin, and aluminum patterns have also been made. The modeling of casting forming (filling, hardening, formation of shrinkage defects, forecasting of structure) with the use of systems is widely applied.

SOFTWARE

CAD2000-ProEngineer-ProCAST

Automatic Hook Blasting Machine "ALJU" Made in Spain.-1987

Designed for treatment of parts hanging from rotating hooks. Very easy operation for small and large jobs, with high outputs. Wholly automatic operation, programmed in cycles, reduces manual work to charge and discharge of parts from hooks.

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|-----------------------------|-----------|
| Machine type | REGINA-08 |
| Hook Capacity Diameter (mm) | |
| Height (mm) | 1550 |
| 1800 | |
| Aspirator Extractor Model | BFB-33/2 |

Sand Plant-Eirich Intensive Mixer made in Germany-1987

Forced mixing action with mixing pan rotation clockwise and rotating mixing tools rotating clockwise or counterclockwise. The mixing tools are mounted eccentrically inside the pan.

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|-------------------------|--------------------------|
| Machine type | DE-22 |
| Batch capacity (liters) | 1500 |
| Max batch weight (kgs) | 2400 |
| Mode of operation | Batch wise or continuous |

Motor capacity (kw)
(hp) 40

55

Sand Plant-Lippke FS-II-5 Sandmaster Made in Holland.-1987

Moisture measuring and control equipment for molding sand on batch mixers. Residual moisture and temperature of returned sand are determined for each batch by suitable measuring elements prior to mixer inlet. The measuring moisture values are evaluated to determine the necessary water addition, taking into account the sand quantity per batch. The required water quantity is added automatically by means of suitable dosing valves and meters.

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|--------------|---------|
| Machine type | FS-II-5 |
|--------------|---------|

BMM Weston

2 Pieces, Type CT 3 range automatic moulding machine.

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|------------------|-----------------|
| Jolt Capacity | 680 kg. |
| Squeeze pressure | 7210 kg |
| Squeeze storke | 230mm |
| Pattern draw | 230 mm |
| Table size | 914 x 457 mm |
| Table size pin | 1016 x 762 mm |
| Air consumption | 0.45m3 free air |
| Gross weight | 3410 kg |
| Volume | 5.25 m3 |

BMM Weston

2 Pieces, Type CT 1 range automatic moulding machine.

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|------------------|------------------|
| Jolt Capacity | 340 kg. |
| Squeeze pressure | 3925 kg |
| Squeeze storke | 145 mm |
| Pattern draw | 230 mm |
| Table size | 749 x 419 mm |
| Table size pin | 749 x 457 mm |
| Air consumption | 0.32 m3 free air |
| Gross weight | 2110 kg |
| Volume | 3.6 m3 |



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