

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.

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.

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.

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.

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.

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.

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.

Machine type	FS-II-5
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BMM Weston

2 Pieces, Type CT 3 range automatic moulding machine.

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.

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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