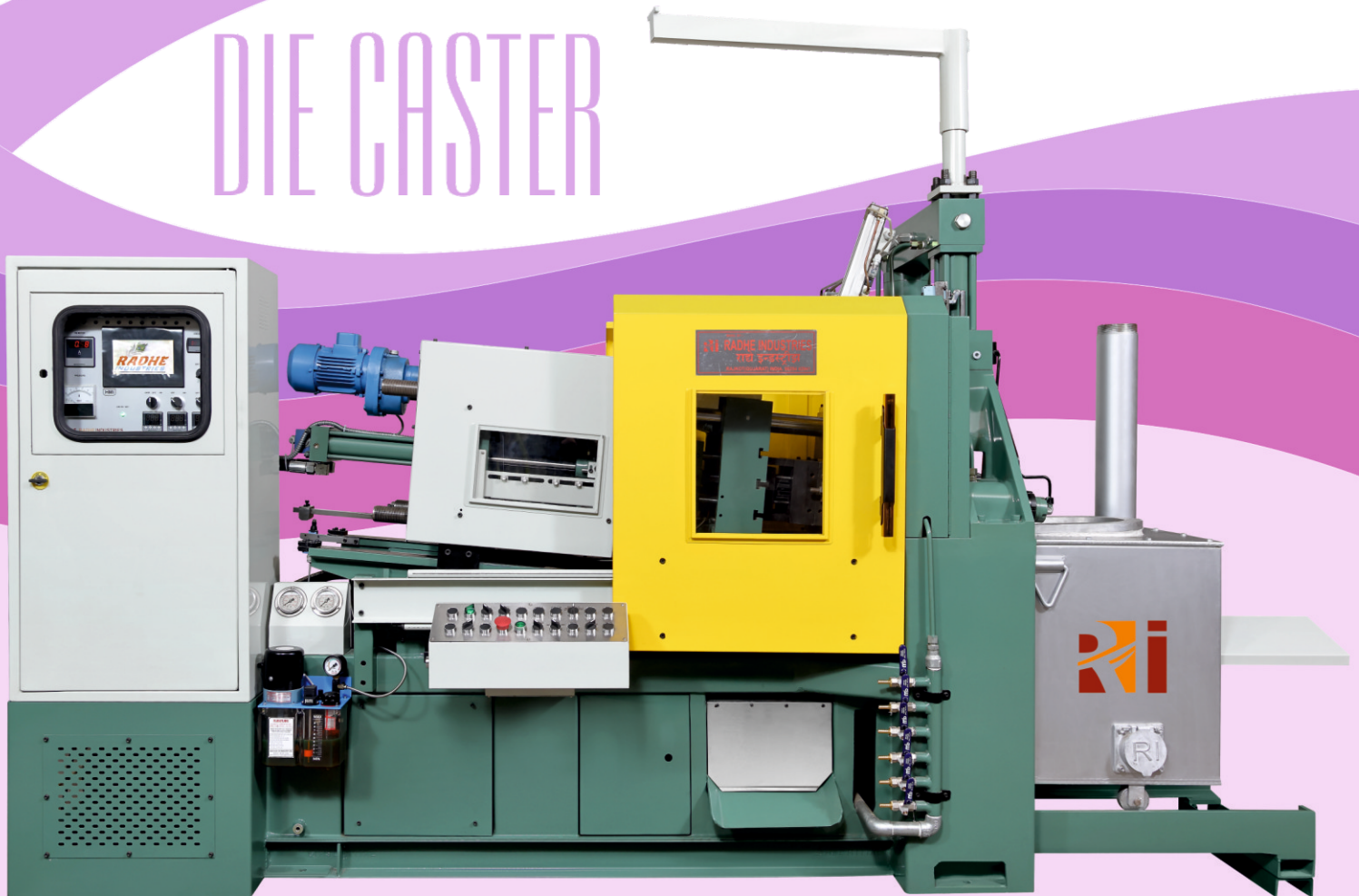




Hot & Cold Chamber Die Casting
Machines With Automation Equipment

DIE CASTER



Solution for fully automated production (optional)

RADHE machine, with optional items of spraying nozzle and pneumatic sweeper, can achieve fully automatic production.



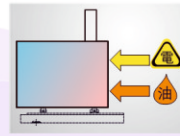
Fixed spraying nozzle



Pneumatic sweeper

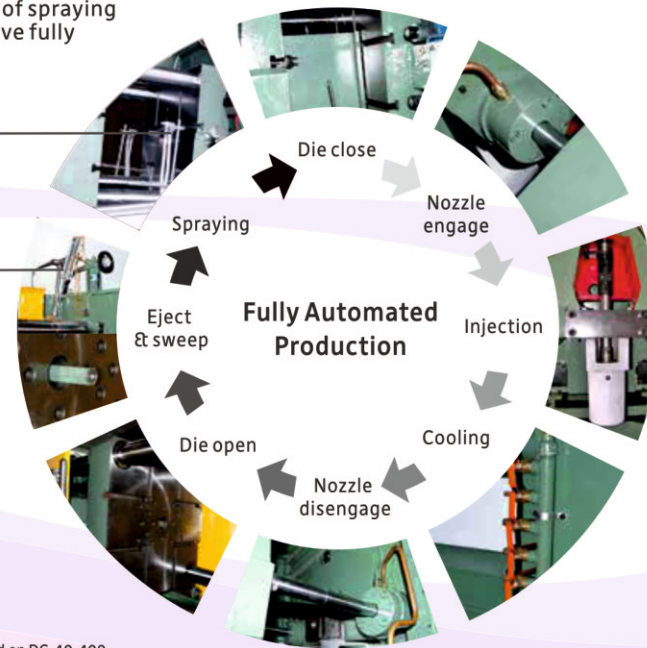


Electric furnace



Hybrid electric furnace

- Extra core-pull device (standard 1 set on DC 40-400)
- Hydraulic platform for multiple injection positions (standard on DC 40-400)



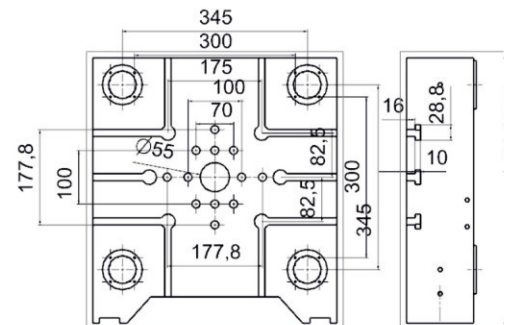
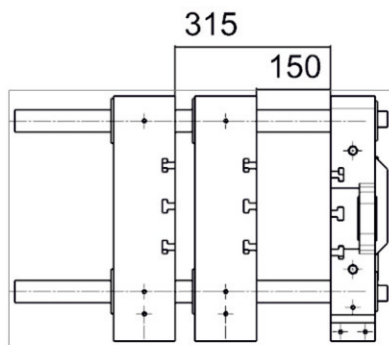
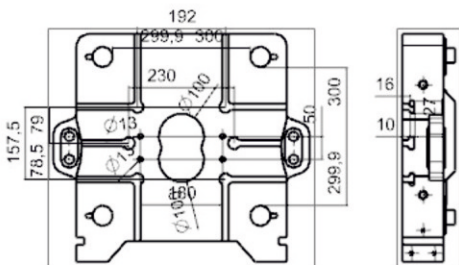
Series Specification

| ITEM | UNIT | DC 40 | | | DC 88 | | | DC 130 | | | DC 160 | | | | |
|----------------------------|-------------------------|--------------------|------|--------|--------------------|---------|---------|--------------------|-----|-----|--------------------|-----|------|---------|--|
| Clamping force | kN | 400 | | | 880 | | | 1300 | | | 1600 | | | | |
| Clamping stroke | mm | 180 | | | 250 | | | 300 | | | 350 | | | | |
| Ejector force | kN | 40 | | | 50 | | | 80 | | | 108 | | | | |
| Ejector stroke | mm | 55 | | | 65 | | | 75 | | | 85 | | | | |
| Die height (min-max) | mm | 110 - 315 | | | 150 - 350 | | | 190 x 495 | | | 205 - 550 | | | | |
| Platen size (HxV) | mm | 450 x 450 | | | 570 x 570 | | | 650 x 650 | | | 770 x 770 | | | | |
| Space between tie bars | mm | 300 x 300 | | | 357 x 357 | | | 405 x 405 | | | 510 x 510 | | | | |
| Tie bar diameter | mm | 45 | | | 70 | | | 80 | | | 80 | | | | |
| Shot position | mm | 0 | - 40 | | 0 | - 60 | | 0 | -80 | | 0 | -80 | | | |
| Casting force | kN | 40 | | | 65 | | | 50 | | | 75 | | | | |
| Casting stroke | mm | 130 | | | 130 | | | 140 | | | 200 | | | | |
| Nozzle disengage | mm | 170 | | | 190 | | | 180 | | | 255 | | | | |
| Plunger diameter | mm | 45 | - | 50 | 50 | 55 | 58 | 60 | 65 | 70 | 60 | 65 | 70 | | |
| Shot weight | kg (Zn) | 700 gm | - | 850 gm | 1.25 kg | 1.53 kg | 1.70 kg | 1.85 | 2.1 | 2.4 | 2.1 | 2.4 | 2.86 | | |
| Crucible capacity | dm ³ (kg/Zn) | 250 | | | 55 (360) | | | 300 | | | 60 (400) | | | | |
| Motor driving | kW | 3.75 | | | 7.5 | | | 15 | | | 20 | | | | |
| Hydraulic Working pressure | kg | 70 to 100 | | | 10.5 | | | 10.5 | | | 14 | | | | |
| Furnace heating | Diesel fuel | kg/h | | | 4.8 | | | 4.8 | | | 4.8 | | | | |
| | Electrical | kW | | | 20 | | | 28 | | | 30 x 32 | | | 30 x 42 | |
| Hydraulic oil tank | L | 225 | | | 250 | | | 300 | | | 410 | | | | |
| Nozzle heating | kW | 2 | | | 2 | | | 2.5 | | | 2.5 | | | | |
| Machine weight | kg | 2700 | | | 3850 | | | 5300 | | | 6100 | | | | |
| Machine dimensions | mm (LxWxH) | 3800 x 1410 x 2100 | | | 4350 x 1450 x 2125 | | | 5450 x 1275 x 1850 | | | 4830 x 1700 x 2300 | | | | |

■ Option

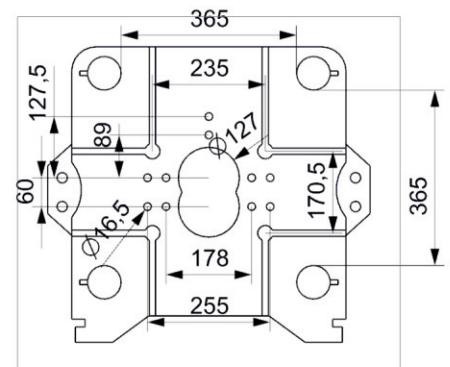
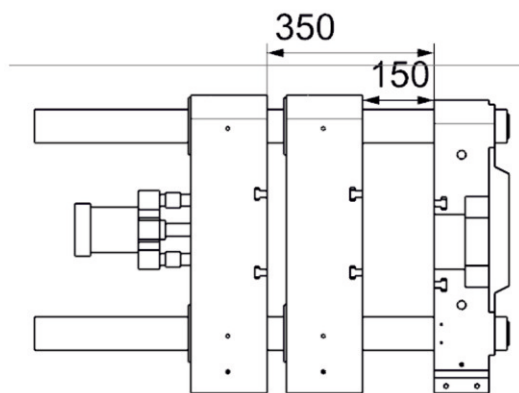
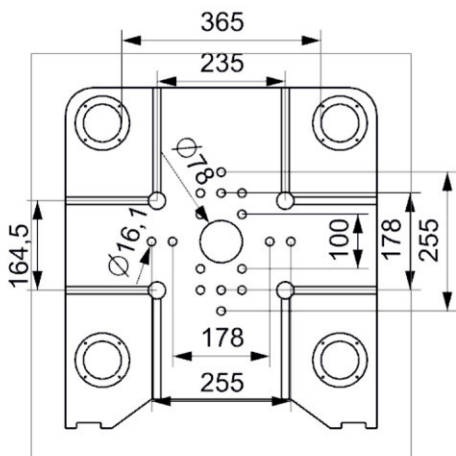
- We reserve the right to make any technical improvement without further notice.

DC-40

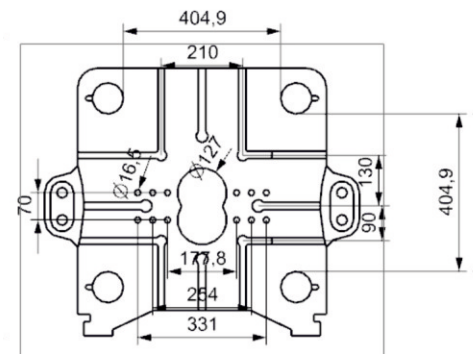
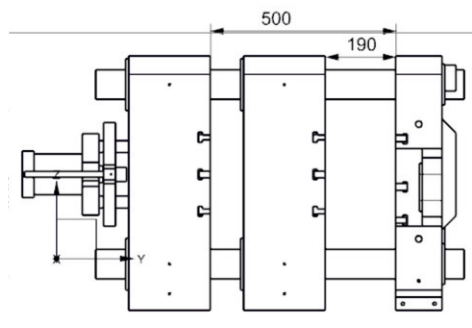
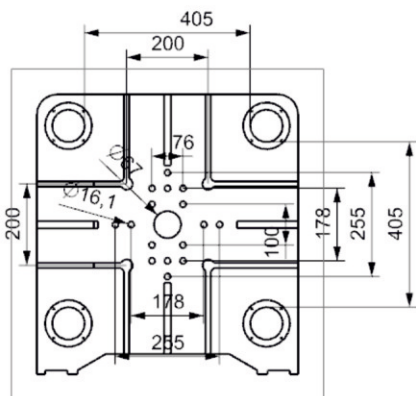
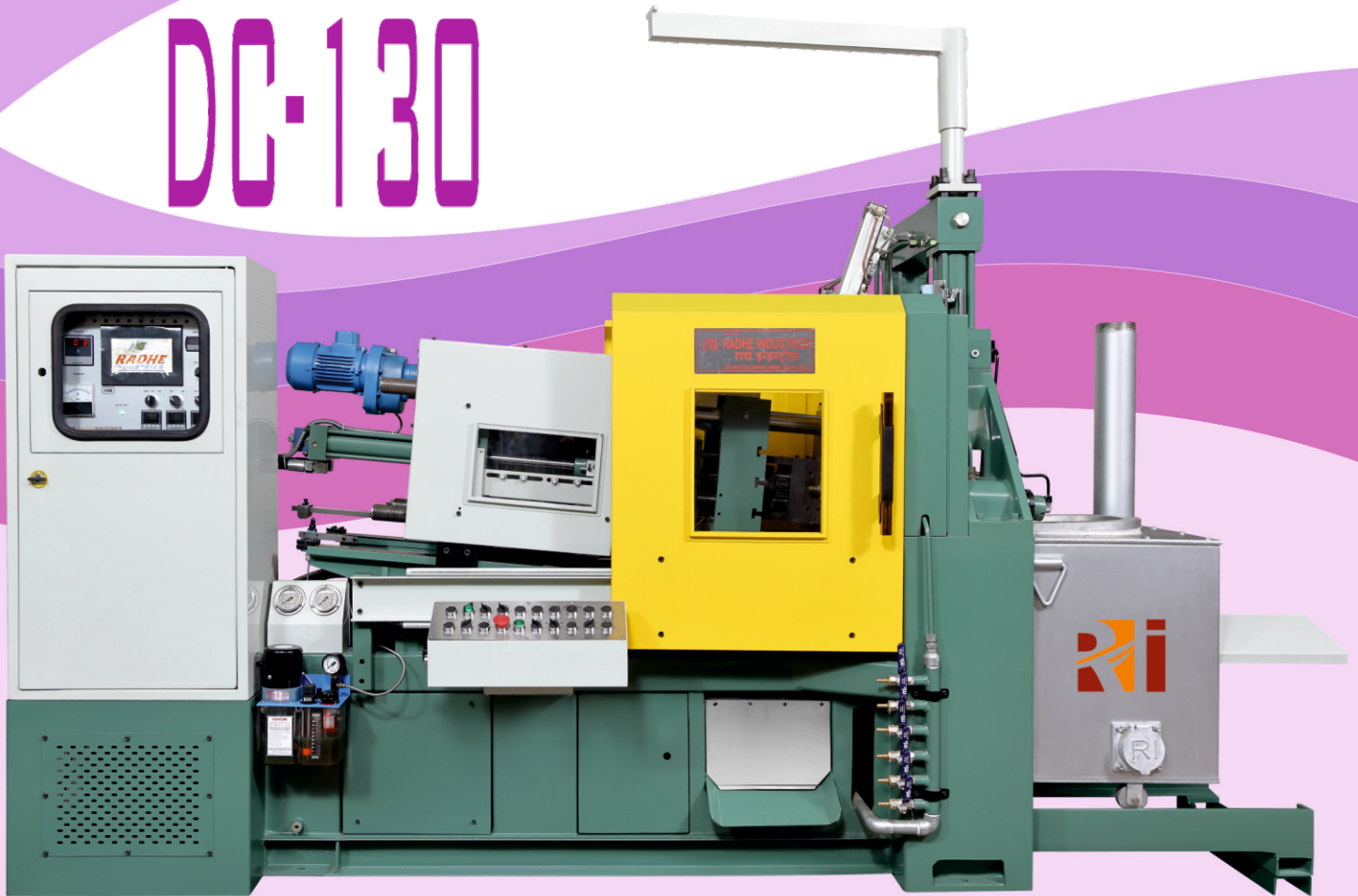




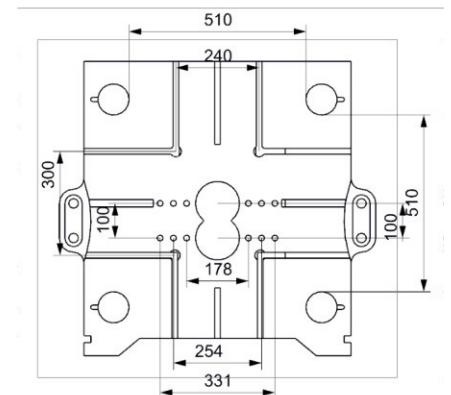
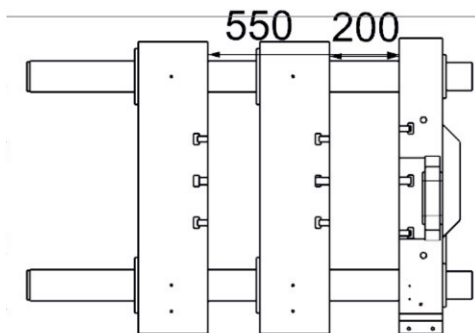
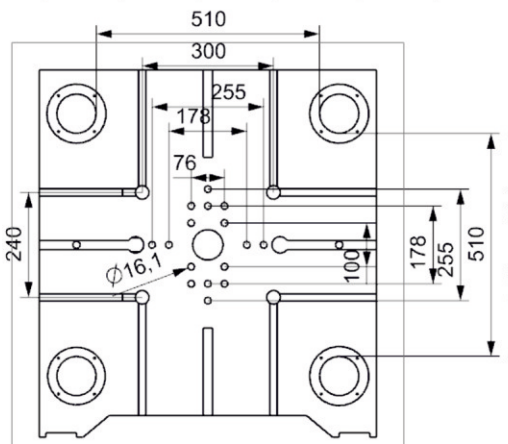
DC-88



DC-130



DC-160



Machine Characteristics

Clamping Unit

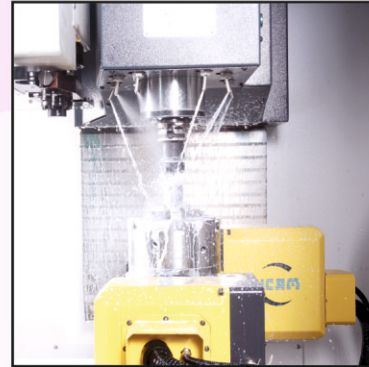
- S.G. iron mould platens and casted toggles are fabricated by CNC machining center assuring a high precision clamping unit.
- Large opening stroke and space between tie bars provide large mould capacity.
- High tensile chrome tie bars.
- Low die closing pressure for mould protection.
- The clamping unit can be moved away from the nozzle, fixed spurt breaking method can be applied.
- Inclined clamping unit is especially designed to help products drop down easily from mould and avoid subsequent material stuck in nozzle during fully automatic operation.

Injection Unit

- Piston rings are made by good quality hot work steel assuring long working life.
- Nozzle, gooseneck and melting pot are specially durable by using heat-treatment and hot work steel.
- Fully automatic pressure jet oil burner is used, stable adjustment and high extent to safely can be maintained.
- Two stage injection adjustment can produce high quality casting.
- Reliable electric nozzle heaters keep the temperature constant which avoid overheat or low-heat in nozzle thus causing no inferior castings.

Hydraulic Unit

- High quality hydraulic valves and components are used to ensure stable hydraulic pressure and flow rate during operation.
- Accumulator is connected to the injection unit to achieve a fast and smooth operation.



Control Unit

- Advance Programmable Logic Controller guarantees continuous and smooth operation under high temperature working condition.
- Control unit by using DC 24 volts supply ensure safely operation and eliminate damages.
- Faults detection between electric circuit and hydraulic system can easily be done from the indicators of microprocessor.
- The temperature of nozzle, gooseneck and furnace is digital controlled.
- No-Contact Proximity Switch are used in machines to eliminate the chance of break down.

Feature 1

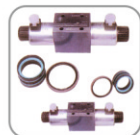


Advance and stable programmable logic controller is stable and easy to operate.



Feature 2

High quality hydraulic components ensure the hydraulic system works smoothly and avoids oil leak.



Feature 3

High quality and maintenance free burner is used as standard in the furnace for safe and with high performance.



Feature 4

Auto sprayer makes automatic production possible.



Feature 7

Two stages injection and pneumatic knock off device.



Feature 8

Piston ring, gooseneck and shot plunger etc. Are all made by good quality hot work steel for heat resistance, antifriction, anticorrosion and long life.



Feature 3

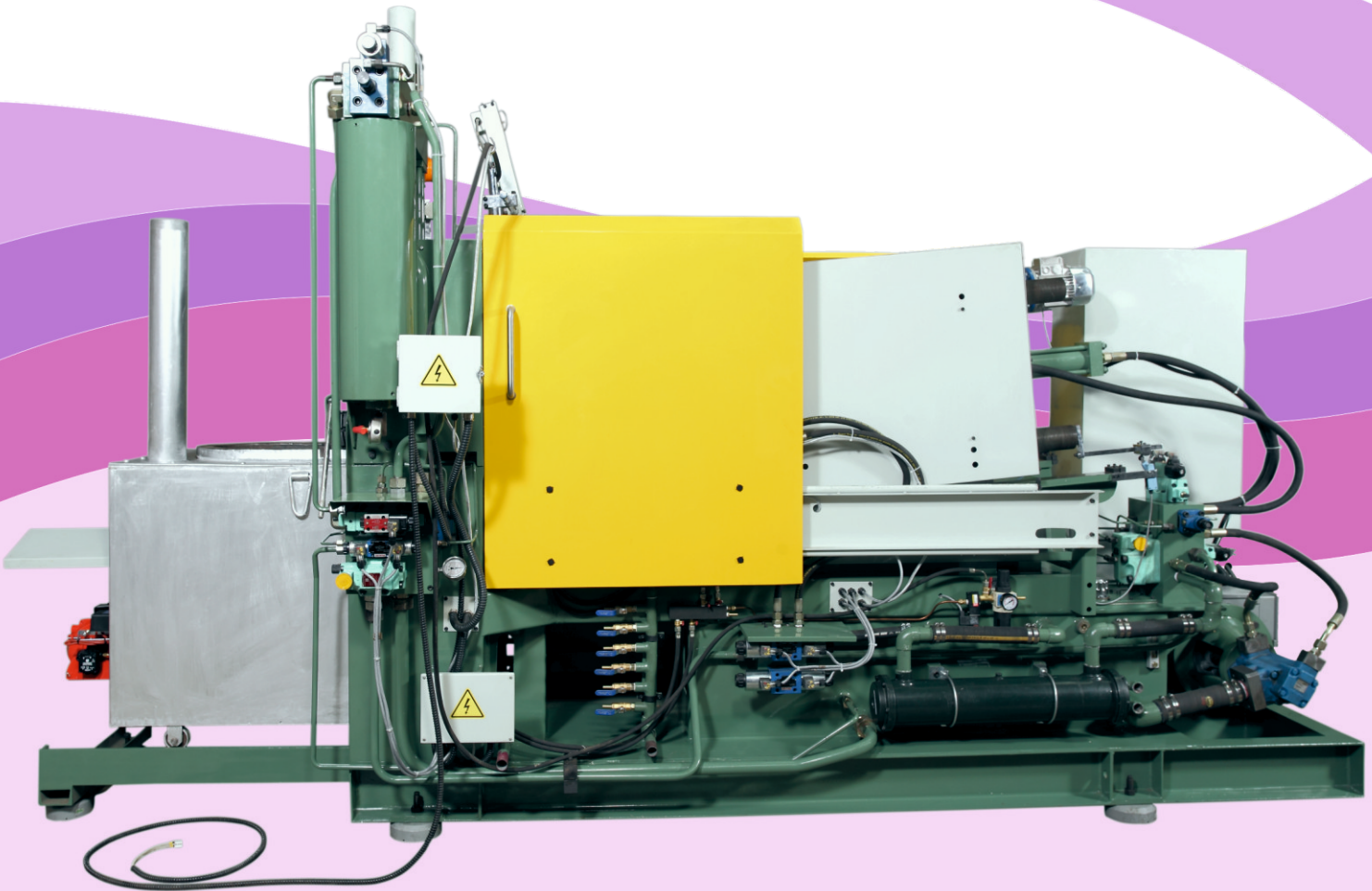
Strong and reliable pumps provides stable pressure and flow rate with low noise.



Feature 6

Strong toggle, spheroidal graphite platen, hard chrome plated tie bars.





Mfg. by

RADHE INDUSTRIES

Kothatiya Solvent Road, Nr. Narayan Weigh Bridge,
Kothariya, Rajkot - 360022. (Gujarat) INDIA. Cell : +91-98254 42941

www.radheindustriesindia.com

e-mail : info@radheindustriesindia.com, radhediemould9421@gmail.com