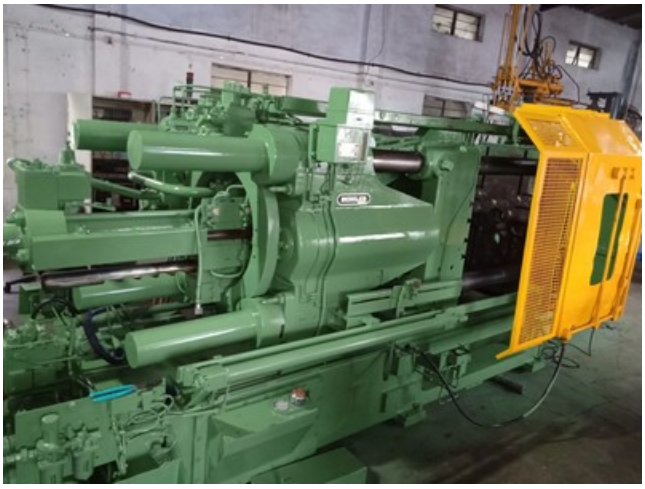

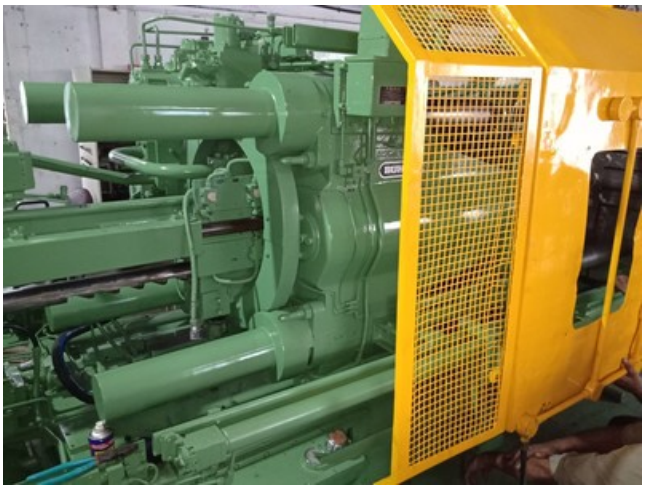

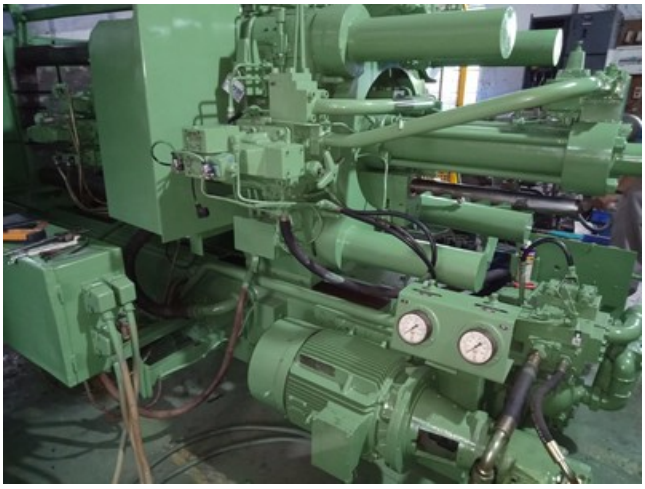

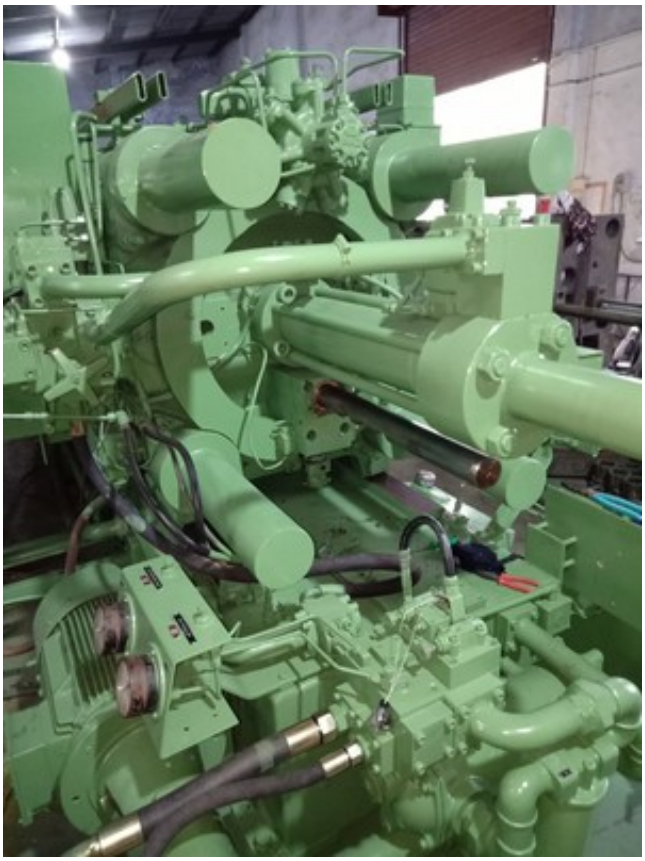

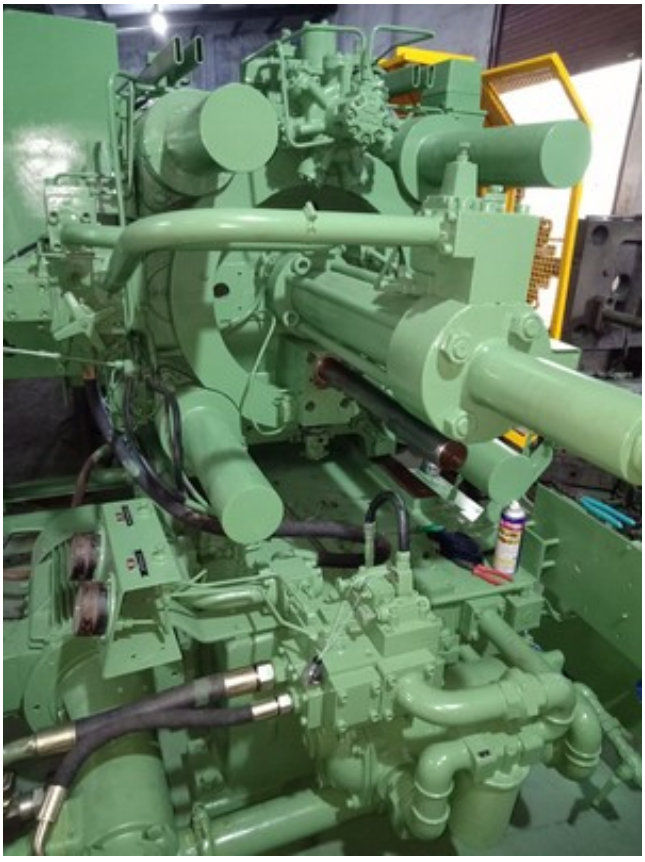

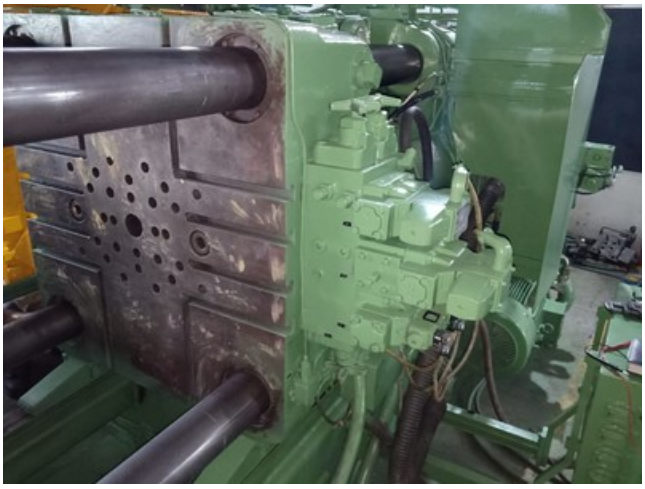

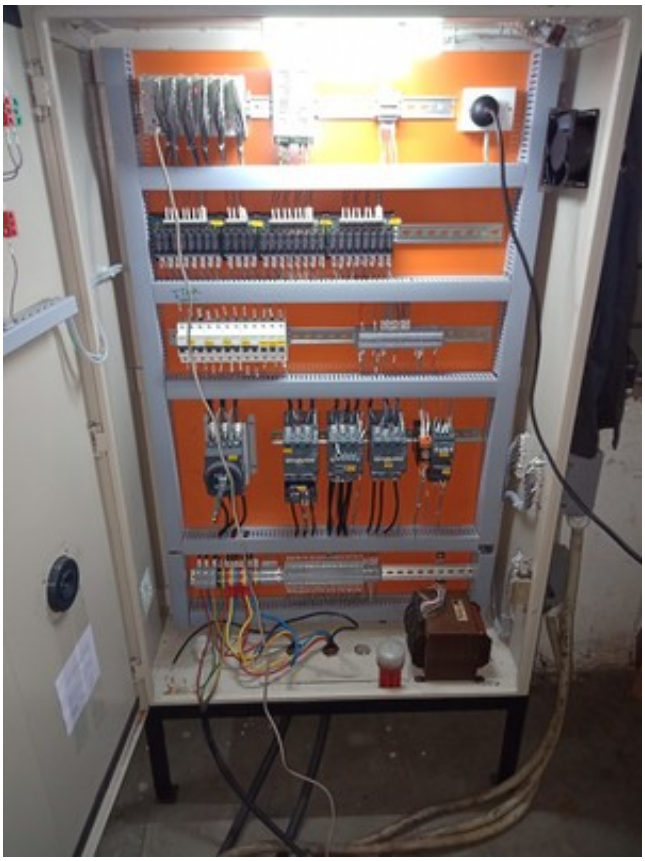

Machine Id	***:-***	***1147***	**Serial No**	**:-**	**10068259**
Category	**:-**	**Rebuilt Pressure Die Casting Machine**	**Model**	**:-**	**H 400 D2**
Country	**:-**	**Switzerland**	**Make**	**:-**	**Buhler**
Type of Machine	**:-**	**Rebuilt Horizontal Cold Chamber Die Casting Machine**	**Year**	**:-**	
Weight	**:-**	**0.0**	**Dimensions**	**:-**	
Power	**:-**		**Location**	**:-**	**Mumbai Warehouse,India**

Specification :-

Scope of work carried out:-

Machine was completely stripped down and built from base :

The tank was thoroughly cleaned and drained off old debris accumulated over the years.All fittings/ pipes were flushed out thoroughly and seals replaced. The machine parts were repainted.

Mechanical Work : Toggle system checked and found within tolerance. Tie Bars &Bushes found satisfactory , no scratches on bars working area. Moving Platen &Fixed Platen geometry checked and skimmed where needed. Bed plates were reground and old shoes replaced with new ones.

Hydraulics : All base valves cleaned and replace old seals with new one. All Solenoid Valves &top valve replaced Cylinder and intensification unit cleaned and seals replaced. New Pump and Motor , Suction filter &Oil filter replaced base valves , top valves Intensification unit &cylinder resealed

Electrical : The machine has been rewired with New PLC Delta

Guarding : Guards are original Buhler and adjusted and mechanically secured. Operator side is pneumatic automatic &other side is manual. are all guards on machine , operator guard in automatic or manual

Rebuilt Buhler Horizontal Cold Chamber Die Casting Machine Model H-400-D2 with Direct Injection System

Specifications:

Locking force (nominal) Mp 400
Locking Force (strain gauge) Mp 400+ max.10%
Injection force (with intensifier) adj. Mp 38,5
Hyd. Ejection force Mp 22
Die Mounting Plates H X V mm 920 x 980 in 36 1/4 x 38 1/2
Space Between tie bars H X V mm 580 x 640 in. 22 7/8 x 25 1/4
Tie bar Diameter mm 120 in 4 3/4
Max. Die height mm 750 in 29 1/2
Max. Die height (With mot. Die height) mm 725 in 28 1/2
Min. die height mm 200 in 7 7/8
Die opening stroke mm 600 in 23 5/8
Injection Plunger stroke mm 400 in 15 3/4
Ejector Stroke, adj. mm 145 in 5 3/4
Free cycle time sec. 7
Motor Capacity (22 kw) Hp 30 (22KW)
Machine area m 6.1 x 1.65 ft. 20 1/4 x 5 1/2
Machine Weight * tons 12,5
Hydraulic fluid contents litres (+,-) 650 Imp. Gallons (+,-) 121
Production data

Plunger Diameter	60mm 2.36 in.	70mm 2.76 in.	80mm 3.15in.	90mm 3.54 in.	100mm 3.94 in	110mm 4.33 in
Short capcity for Aluminum	2 kp 4.4 lbs.	2.7 kp 5.9 lbs.	3.6 kp 7.9 lbs.	4.5 kp 9.9 lbs	5.6 kp 12.3 lbs	6.8 kp 15 lbs
Max. injection pressure	1360 Kp/cm^2 19300 lbs/sq.in	1000 Kp/cm2 14200 lbs/sq.in	765 Kp/cm2 10870 lbs/sq.in	605 Kp/cm2 8700 lbs/sq.in	490 Kp/cm2 6950 lbs/sq.in	405 Kp/cm2 5750 lbs/sq.in

Nom. Casting area at above injection pressure	290 cm2 45 sq.in.	400 cm2 62 sq.in.	520 cm2 80.5 sq.in.	660 cm2 102 sq.in.	815 cm2 126 sq.in.	985 cm2 155 sq.in.

* Metric tons at 2205 lbs.
* Shot capacity is calculated: plunger area x plunger stroke x 75% filling rating specific gravity for liquid Aluminum = 2,5 or 0,09lbs/sg.in.
For magnesium alloys multiply by 0.65 for zinc alloys multiple by 2.5
For copper base alloys multiply by 3.2
* Nom. Casting area at injection pressure of 250 kp/cm2 (3500 lbs/sq.in.) = 1600 cm2 (154 sq.in)
Specifications are subject to modifications with notice.