

# KUNARK HITECH MACHINING & SALES PVT.LTD.



Kunark House, 269, Kunark Marg, Kaman Bhiwandi Road, Kaman,

Vasai Road (East), Dist: Thane -401208, Maharashtra, India.

Mobile&Whatsapp: +91 9867973046, Mobile 2:- +91 7977043901

Goggle Map:- <https://maps.google.com/maps?q=19.372000+72.902095>

Email: [info@jkgears.com](mailto:info@jkgears.com), [dalbirbright@gmail.com](mailto:dalbirbright@gmail.com) website: [www.jkgears.com](http://www.jkgears.com)





<b>Machine Id</b>	<b>:- 1172</b>	<b>Serial No</b>	<b>:- 253643</b>
<b>Category</b>	<b>:- Pressure Die Casting Machines (PDC)</b>	<b>Model</b>	<b>:- H 400 D2</b>
<b>Country</b>	<b>:- Switzerland</b>	<b>Make</b>	<b>:- Buhler</b>
<b>Type of Machine</b>	<b>:- Horizontal Cold Chamber Die Casting Machine</b>	<b>Year</b>	<b>:-</b>
<b>Weight</b>	<b>:- 0.0</b>	<b>Dimensions</b>	<b>:-</b>
<b>Power</b>	<b>:-</b>	<b>Location</b>	<b>:- Mumbai Warehouse,India</b>

### Specification :-

#### **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**

<b>Plunger Diameter</b>	<b>60mm 2.36 in.</b>	<b>70mm 2.76 in.</b>	<b>80mm 3.15in.</b>	<b>90mm 3.54 in.</b>	<b>100mm 3.94 in</b>	<b>110mm 4.33 in</b>
<b>Short capacity for Aluminum</b>	<b>2 kp 4.4 lbs.</b>	<b>2.7 kp 5.9 lbs.</b>	<b>3.6 kp 7.9 lbs.</b>	<b>4.5 kp 9.9 lbs</b>	<b>5.6 kp 12.3 lbs</b>	<b>6.8 kp 15 lbs</b>
<b>Max. injection pressure</b>	<b>1360 Kp/cm<sup>2</sup> 19300 lbs/sq.in</b>	<b>1000 Kp/cm2 14200 lbs/sq.in</b>	<b>765 Kp/cm2 10870 lbs/sq.in</b>	<b>605 Kp/cm2 8700 lbs/sq.in</b>	<b>490 Kp/cm2 6950 lbs/sq.in</b>	<b>405 Kp/cm2 5750 lbs/sq.in</b>
<b>Nom. Casting area at above injection pressure</b>	<b>290 cm2 45 sq.in.</b>	<b>400 cm2 62 sq.in.</b>	<b>520 cm2 80.5 sq.in.</b>	<b>660 cm2 102 sq.in.</b>	<b>815 cm2 126 sq.in.</b>	<b>985 cm2 155 sq.in.</b>

\* 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/sq.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.