

# KUNARK HITECH MACHINING & SALES PVT.LTD.

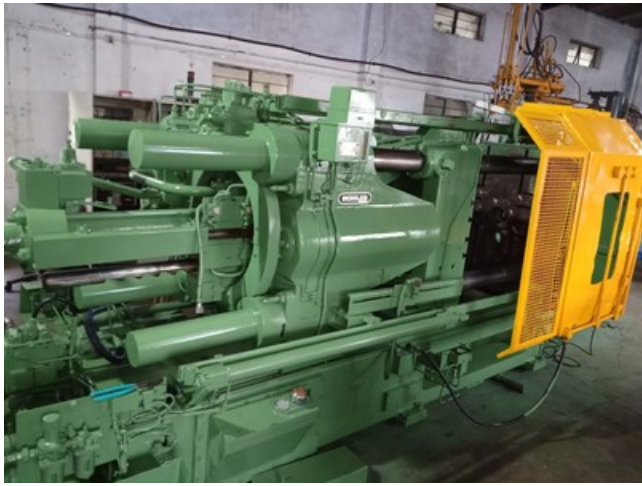
Kunark House, 269, Kunark Marg, Kaman Bhiwandi Road, Kaman,

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

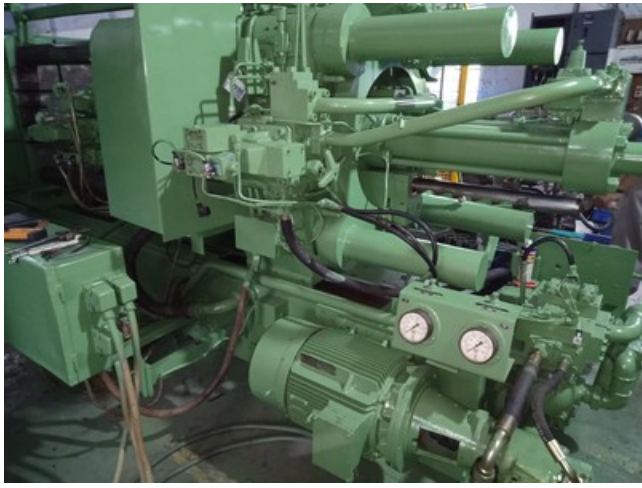
Mobile: (+91) 9867973046 Factory: 0250-6454895

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

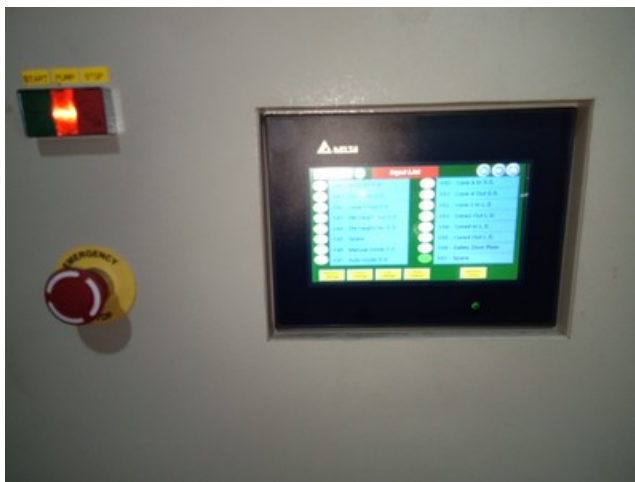












Machine Id	:- 1147	Serial No	:- 10068259
Category	:- Rebuilt Pressure Die Casting Machine	Model	:- H 400 D2
Country	:- Switzerland	Make	:- Buhler
Type of Machine	:- Rebuilt Horizontal Cold Chamber Die Casting Machine	Year	:- 0
Weight	:- 0.0	Dimensions	:-
Power	:-	Location	:- Mumbai Warehouse,India

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 capacity 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 <sup>2</sup> 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/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.