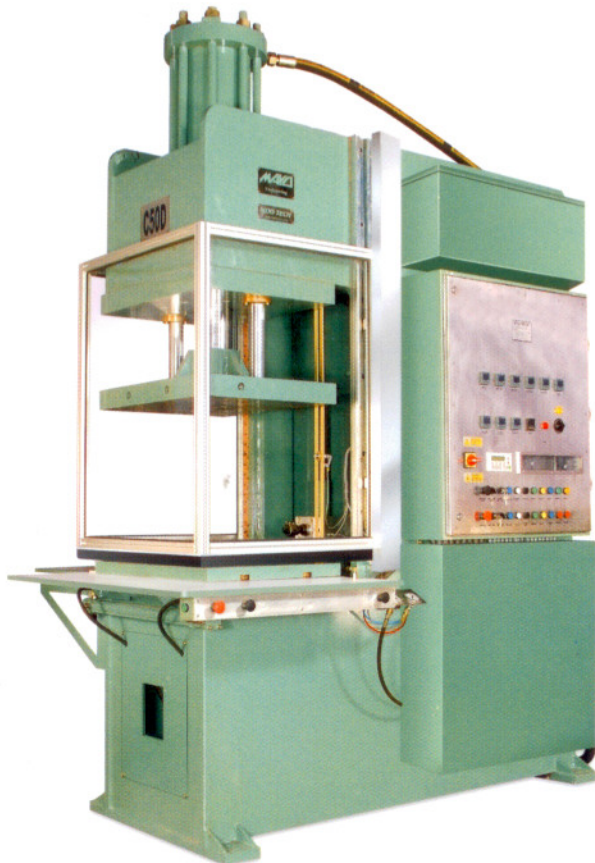


# MODTECH WAX INJECTION MACHINE

## 50 TON, 'C' - FRAME DUAL INJECTION WAX INJECTION MACHINE



### SPECIFICATIONS

DESCRIPTION	50 Ton Vertical Downward Clamping, C Frame Semi Automatic, Hydraulic Wax Injection Machine
DUAL NOZZLES	The machine will be fitted with the following injection nozzle configuration:- Nozzle 1 Horizontal Injection with Horizontal & Vertical Axis. In-Out 300 mm, Up-Down 350mm (Hydraulic Push Button) Nozzle 2 Bottom Injection. Fixed Nozzle Injecting Upwards. Nozzle 1 & 2 Panel Mounted Change over switch from Nozzle 1 to Nozzle 2.
NOZZLE TIP	10 mm Spherical Radius for both Horizontal and Bottom Nozzles
DAYLIGHT	750 mm
CLAMP CYLINDER STROKE	650 mm
SINGLE SHOT	8000 cc
CLAMP PLATEN	600 mm wide x 750 mm deep
CLAMP PRESSURE	Adjustable via Key Pad
TABLE	1 Meter from Floor. Service Table Projection 350 mm deep in U-shape.
DWELL TIME	Solid State Digital Display 0-999 seconds.
WAX TANK	100 Lit. Capacity with motorized stirrer, slip coupling, heated drain valve, annular tube type reservoir and tripple band heater. Paddle will be of Stainless Steel
TEMP. CONTROL	Independent Solid State Digital Display of Block temperatures, Tank Top and Bottom, Nozzle 1 & 2 and Hose for Nozzle 1 & 2. Twin timer based on / off control for Nozzle heater & Thermostat Type Control for Drain heater.
INJECTION PRES.	5-50 BAR Variable through Keypad.
INJECTION FLOW	Variable through Keypad. The machine is fitted with a 5 stage wax injection facility. All time, pressure and flow values for each stage can be pre-set through the control panel mounted keypad. This arrangement has the ability to ramp up at 5 pre-set points during the injection cycle. The purpose of this facility is to help to control flow and pressure values at different stages of the die filling process, and thus to assist in the prevention of the cracking of delicate ceramic cores during the initial injection cycle
SHUTTLE TABLE	Machine fitted with Hydraulic die shuttle table with two stations Table slides from left to right when viewed from the front of the Machine (Below main C50D name plate). The Shuttle Table is sized according to the platen size, namely 600 mm deep x 750 mm wide. The table moves out of the platen area of the machine and travels for a distance of 850 mm via a hydraulic ram.
SAFETY	Machine provided with Harmonized European Standard EN 954-1, Category 3 safety control system. Fitted with Fail Safe Safety Relay, which monitors integrity of all safety devices used in machine through dual channel logic. CE Marked with Dual Push Button for Cycle Start, Tank & Block Over-Temperature Alarm. Nozzle Strike Safety for Horizontal Nozzle, Pneumatically Operated Guard in Platen Movement Area and Emergency Stop Push Button.
AUTO-SEQUENCE	Push to Start - Guard Down - Clamp Down - Suction of Wax - Nozzle Forward - Injection - Nozzle Return - Clamp Up - Guard Up - Surplus Wax to Tank.
ELECTRIC LOAD	15 KVA, 415 Volts 3Phase 50 Hz with neutral and ground.
PUMP	Variable Displacement 31 lit. per minute
PUMP H.P.	10 h.p.
DIE MOUNTING	M12 Holes in both Moving & Bottom Platens.
PLATEN COOLING	2 Cooling Passages in Moving and Bottom Platens.
OIL RESERVOIR	100 Lit.
SLAB MELTER	30 Lit./Hour through put rate, mounted on wax tank with level control switch.

Note : Whilst every care has been taken in the preparation of this brochure, Modtech reserves the right to change or alter the specifications as may be necessitated without prior notice.