

Rotation of castings

- Castings rotation control during decoring process improves sand removal and reduces cycle times.
- It achieves tolerances that cannot be achieved via conventional systems.

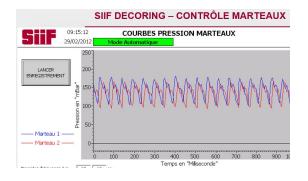
Decoring sequence settings

This SiiF standard feature enables the hammering/vibration/rotation/blowing phases to be repeated as many times as necessary, ensuring a sand-cleanliness level according to tolerances and reduces the cycle time.

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	SEQUENCES Nº 1								
EQUENCE Nº1	MARTELLAGE -	AVEC		ROTATIO	2N -	AVEC			
EQUENCE Nº2	Temps de martellage :	20,0	Sec.	Temps avant rotation : Nombre de position Position (°) :		5,0 Se	c. la	Soufflage pendant la rotation :	
QUENCE Nº3	Temps avant	Temps de				2	Temps avant	Temps de	
EQUENCE Nº4	soufflage 2,0 (Sec.):	(Sec.):	10,0			Temps d'attente en position (Sec.) :	soufflage	soufflage (Sec.):	
EQUENCE Nº5	VIBRATION -	AVEC		Position 1:	90	5,0	0,0	0,0	
-	Temps de vibration :	30,0	Sec.	Position 2 :	125	5,0	0,0	0,0	
QUENCE Nº6	Vitesse de vibration :	50 Hz 🗸	1	Position 3 :	175	5,0	0,0	0,0	
EQUENCE Nº7	Temps avant soufflage :	2.0	Sec.	Position 4 :	90	5,0	0,0	0,0	
OUENCE Nº8			Sec.	Position 5 :	125	5,0	0,0	0,0	
	Temps de stabilisation								
EQUENCE Nº9				avant seg suivant		1,0 Se	с.		
QUENCE Nº10				S	AUVEGAR	DE PARAM	ETRES	ACCUEIL	
ure Date	Texte							REARM	

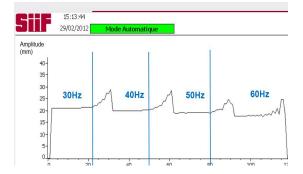


 This option provides optimum operation of the hammers and detecting hammer wear as well.



Amplitude control

This option controls the range of vibrating frame movement and optimises the frequencies to be programmed in each sequence.





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