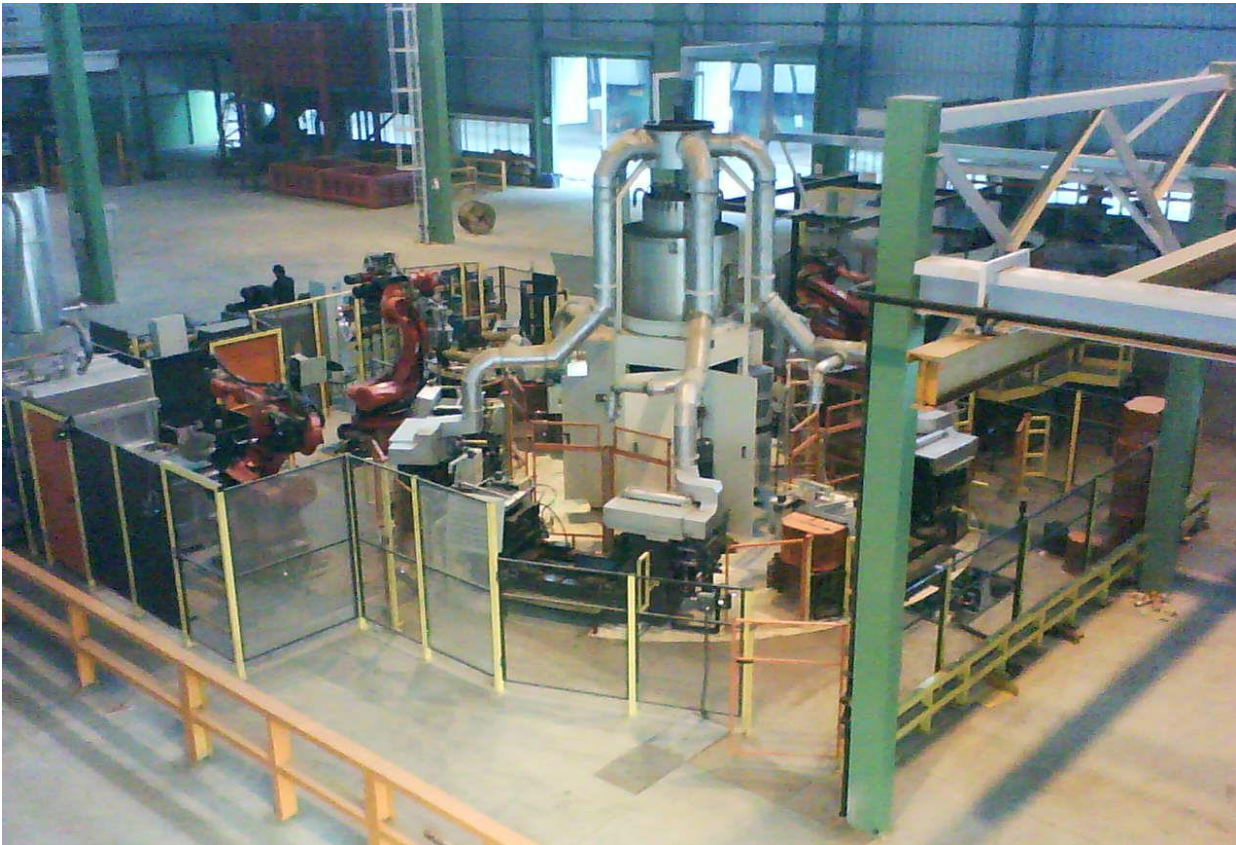


Case History: Five bench cylinder head casting carousel (INDIA)



Project Requirement:

The customer had a yearly production requirement of approximately 200,000 cylinder heads.

Our Solution:

The system proposed using a five (5) bench casting carousel to produce approximately 200,000 good cylinder heads yearly when operating over three (3) shifts per day.

The carousel Scope of Supply includes core pack preparation equipment to automatically weave the top core onto the base cores, a coresetter device to position the cores in the mold, a pouring robot and a casting unloading robot.

Scope of work:

A special storage buffer, managed by the casting unload robot and able to hold approximately five (5) minutes of production, divides the casting area from the pre-finishing area.

At the end of the FIFO buffer, the unloading robot moves the castings onto a fixed knife device that breaks off the external core butts. Then the pouring sprue and casting runners are cut off by dedicated and hydraulically-powered knives.

After a final visual check, the castings are loaded into special bins and carried to a compartmentalized cooling station where the casting bin is forced-air cooled by a special fan.

The castings, once cooled and still in their bins, are sent on for finishing operations.