

**Case History: Six bench casting carousel for cylinder heads - (U.S.A.)**



**Project Requirement:**

The customer had a yearly production requirement of approximately 700,000-800,000 cylinder heads.

**Our Solution:**

The solution proposed using three (3) six (6) casting bench carousels, each able to produce approximately 250,000 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 specific buffer able to hold castings for approximately five (5) minutes of production is positioned at the unload station on the carousel, and divides the casting area from the pre-finishing area

At the outlet of the FIFO casting buffer, the external core butts are removed by a hydraulically actuated device, and then the sprue and runners are robotically removed by cut-off disc.

After a final visual check, the castings are loaded into special bins and sent 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.