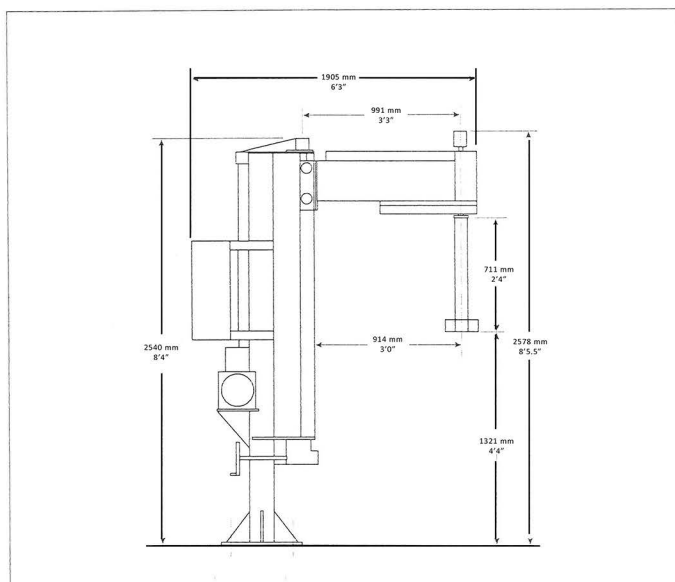


APPENDIX A



The theory of spinning rotor degassing for the PAL 3000 is the same as that offered in Pyrotek's other degassing systems. A metered amount of inert gas is injected into the molten aluminum through a rotating graphite shaft and rotor. The rotor shears the inert gas into tiny bubbles and disperses them evenly throughout the melt. Unwanted hydrogen gas and non-metallic inclusions are attracted to the inert gas bubbles and rise to the surface.

TECHNICAL DATA:

Mechanical

- 90° right or left arm movement for graphite removal
- Roller bearing guide carriage
- Bronze bushing wear plates
- Heavy duty hydraulic cylinders
- Insulated shroud

Electrical

- 2 HP electric motor - belt drive
- 220 volt, 60 cycle, three-phase
- Solid state controller to DC power
- Digital tachometer operated off voltage output from potentiometer setting
- Electric safety switch stops rotation on up movement
- Electric safety switch cuts power when cabinet door opens

Weight - 435 kg (960 lbs)

TYPICAL DEGASSING RESULTS:

Alloy	Melt Size	Degas Time (minutes)	Hydrogen Content		Efficiency
			Before	After	
355	363 kg	8	0.16	<0.06	69%
356	907 kg	13	0.12	<0.06	67%
357	635 kg	10	0.14	<0.06	71%

Advanced Metals Processing Technology

Pyrotek

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