

2. DIE CASTING MACHINE

2.1 Specification and dimensions of UB 2250G DIE CASTING MACHINE

2.1.1 General

This machine is suitable for cold chamber type die casting machine of aluminium alloy.

2.1.2 Specification

(1) Machine size

Outline dimension	mm	*1 Length	16,648
		*2 Width	15,980
		*2 Height	7,337
Center height from floor	mm	2,270	
Machine weight	ton	150	

*1 Include tie bar removal stroke

*2 Include automatic equipments

(2) Die clamping unit

Die clamping force	M ton	2,250
Size of die mount platen (stationary side) (V x H)	mm	2,520 x 2,500
Size of die mount platen (moving side) (V x H)	mm	2,370 x 2,500
Spase between tie bars (V x H)	mm	1,500 x 1,400
Tie bar diameter	mm	300
Die stroke	mm	1,180
Die space	mm	max. 1,700
		min. 750

(3) Injection unit

Injection force	M ton	75 - 150 / 200 kgf/cm²
Plunger stroke	mm	1,120
Tip projection	mm	470
Max. tip diameter	mm	140
Shot position (From machine center)	mm	-350
High shot speed	m/s	max. 5.0
Low shot speed	m/s	max. 1.0
The third speed	m/s	max.
Adjustable stroke of declearation position	mm	820 - 1,070 -50 - -300

(4) Ejection unit

Ejection force	M ton	80
Ejection stroke	mm	180
Dimension between ejector plate and moving platen die mounting surface	mm	1,200

(5) Core unit

Quantity of core valve	Moving platen
	3/4 ^B x 3 pcs.
	Stationary platen
	3/4 ^B x 2 pcs.
Quantity and location of core connection ports	Moving platen side
	3/4 ^B x 3 pcs. x 2 sets
	Stationary platen side
	3/4 ^B x 2 pcs. x 2 sets
Working pressure	Max. 200 kgf/cm ² Adjustable by reducing valve

(6) Electric

Power circuit	AC 415 V, 50 Hz
Control circuit	AC 100 V, 50 Hz
Total motor power (include lubrication pump)	112.4 kw
Controller	MITSUBISHI A3H

(7) Others

Hydraulic reservoir capacity	2,330 liters	
Lubrication reservoir capacity	12 liters	
Water volume for oil cooler	125 lit./min. x 30 °C	
Hydraulic fluid	Water-glycol system oil	
Viscosity grade of lubricaiton	General lubrication	ISO VG 220
	Manual	Grease No. 0