HANARO

Super Die Casting of the Most Powerful Kind

HNR-HP200

HANARO ENGINEERING

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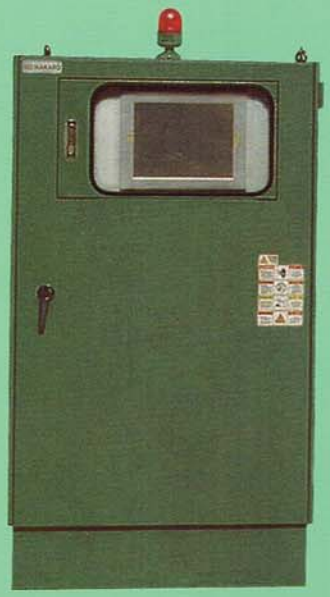
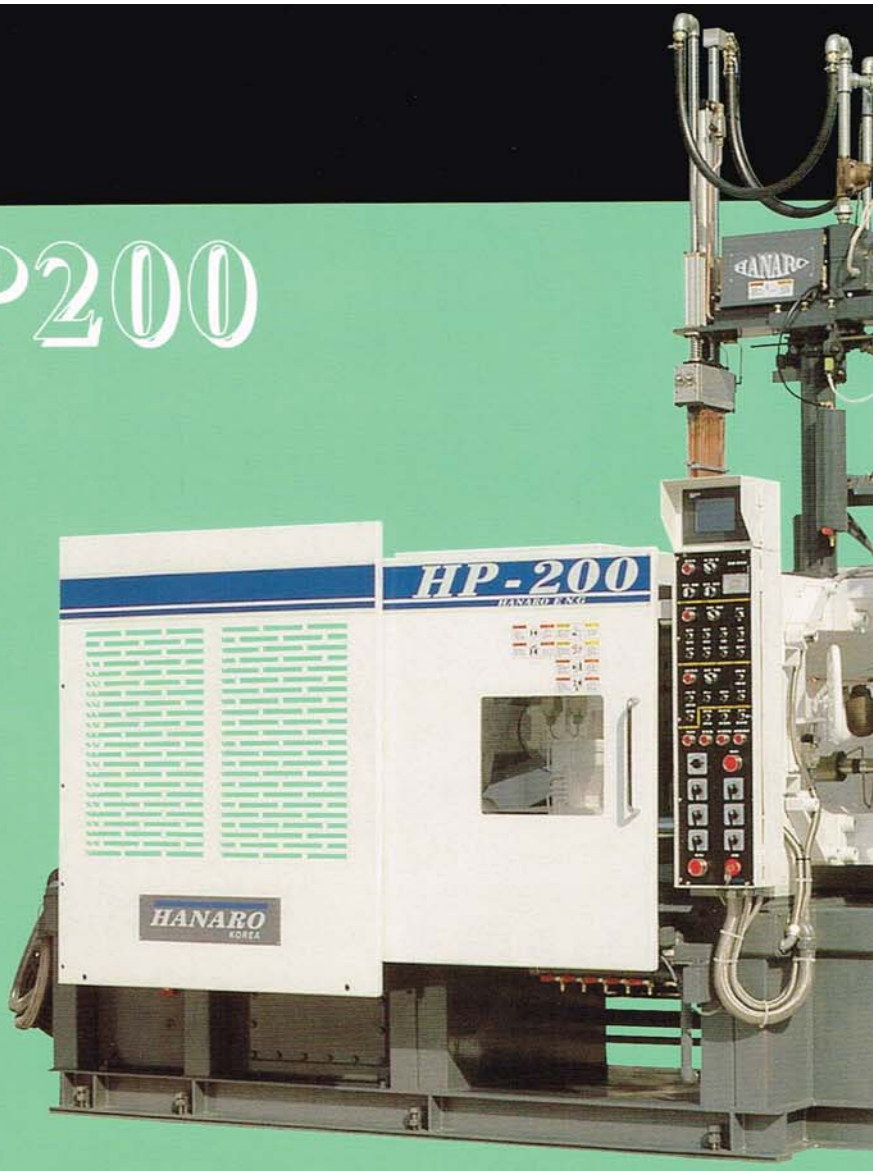
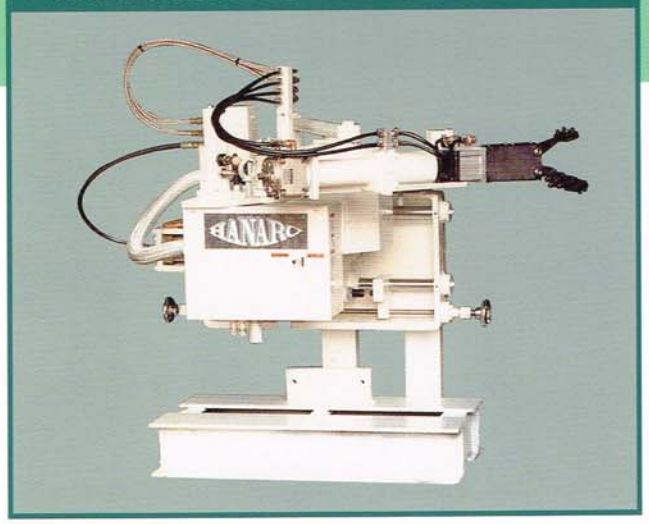
HNR-HP200





AUTOMATIC EXTRACTION

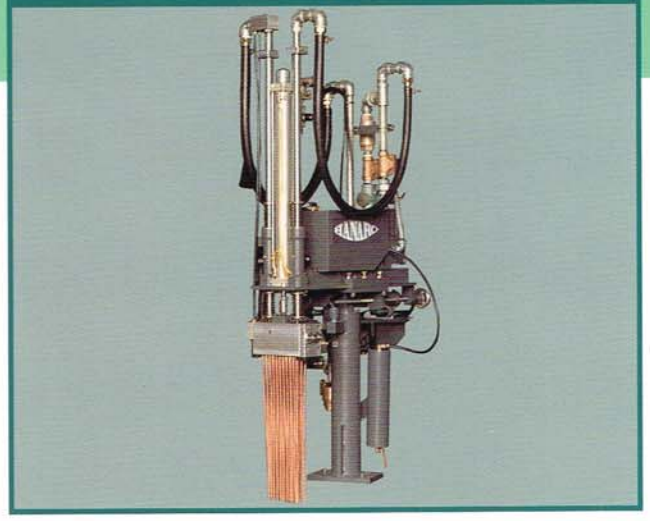


TAKE-OUT DEVICE

The take-out time for products is very fast and powerful clamping force is performed with stability.

ITEM	HNE-200
Applicable die casting machine	HNE-200
Follow up withdraw stroke	100
Tensile power	50Kgf
Air pressure	5~7 Kgf
Arm swivel angle	90
Chuck swivel angle	90
Clamp diameter	40,45,50,55,60
Extract stroke	1000
Sensing	LS-2EA

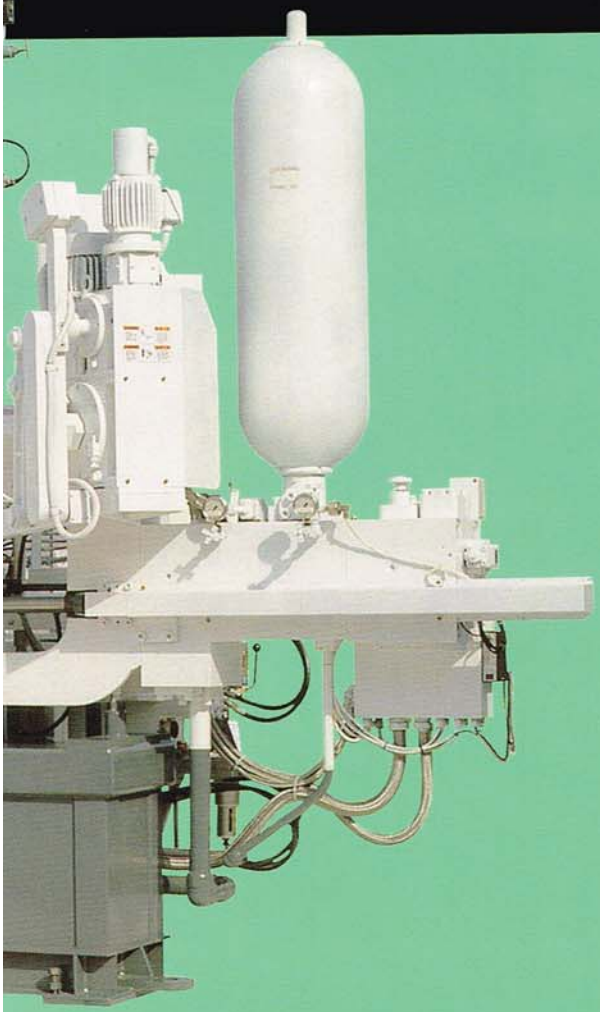
AUTOMATIC SPRAY

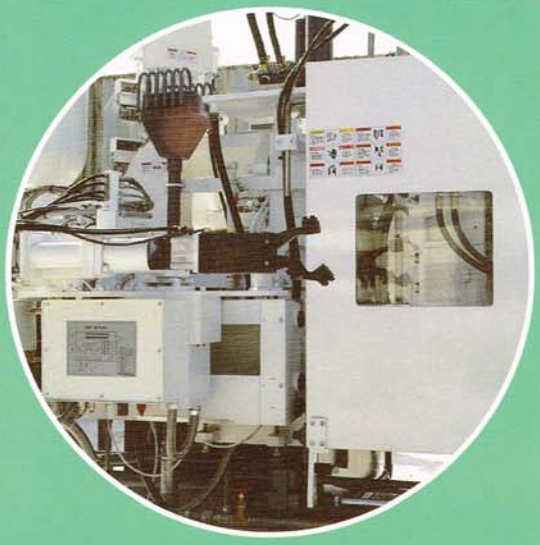


SPRAY DEVICE

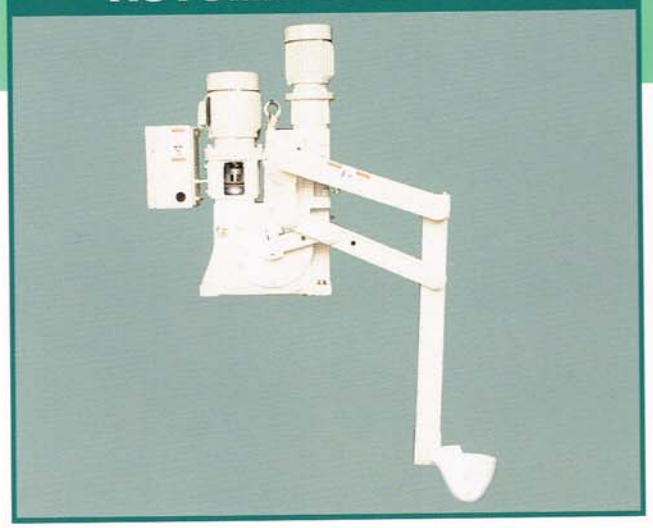
Dielube and air spray is ejected in regular order, so it can shorten the setting-time of mold.

ITEM	HNS-200
Applicable die casting machine	HNS-200
Raising/Lowering. stroke of spray head	650mm
No of spray head nozzles	42
Die lubricant feeding pressure	3~5Kg/m
Size of fittings	PT1
Required air sourse(compressor)	11KW(15HP)





AUTOMATIC LADLER



ITEM		HNL-200
Applicable die casting machine		HNL-200
Ladling quantity		2.5Kg
Ladling quantity variation		±2%
Travel stroke (from Furnace standard crucible)		1.380mm
Out-Ladling capacity (from standard crucible)		Appro x 2/3 of crucible's capacity
Pouring hole position		Must be below machine center
Motor	For travel operation	0.75KW
	For pouring operation	0.4KW
Power supply	Power circuit	3-Phase AC220V
	Control circuit	Single-Phase AC220V
Standard accessories		2 Ladles
Weight of ladling unit		200Kg

LADLE DEVICE

Increase and decrease of speed is smoothly and the volume of repid heating is stable due to its high performances.

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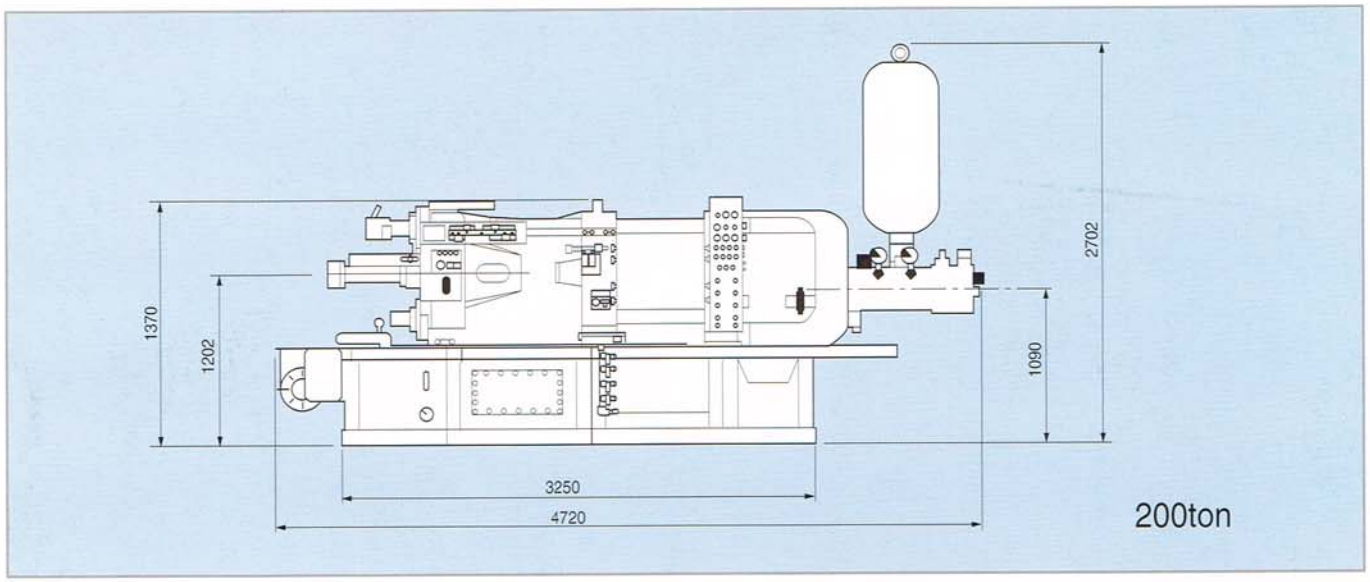

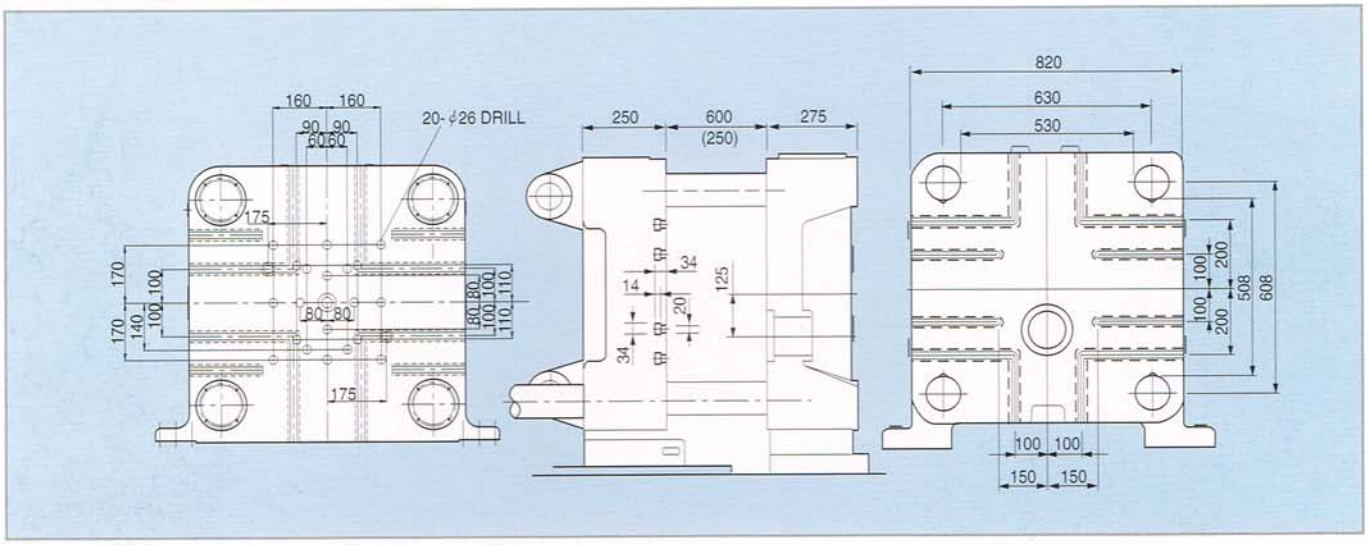

■ MAJOR SPECIFICATIONS

ITEM	Unit	HNR-HP200
Die-clamping force	Metric ton	200
Die-platen dimensions	mm	820×820
Space between tie-bar (vertical × horizentol)	mm	508×530
Tie-bar diameter	mm	100
Die stroke	mm	360
Max. die thickness	mm	600
Min. die thickness	mm	250
Die-adjustment speed (50/60Hz)	mm/min	64/78
Injection force(Pressure increase rations as calculated when maximum accumulator operating pressure is 135Kg/㎠)	Metric ton	10.2~24.5
Plunger stroke	mm	370
Plunger-tip projection distance (from surface of stationary platen)	mm	150
Injection port position (distance downward from machine center)	mm	125
Low speed Dry shot)	m/sec.	0.1~0.9
High speed (Dry shot)	m/sec.	0.1~4.5
Ejection force	Metric ton	10.7
Ejection stroke	mm	0~80

ITEM	Unit	HNR-HP200
Corse(Upper section of movable platen)	-	1 set
Hydraulic~Pump motor(200v)	KW	15KW
Die-thickness adjustment motor(200v)	KW	0.75
Power-supply capacity	KVA	22
Machine weight	Metric ton	6.3

■ CASTING CAPABILITIES

Model	HNR-HP200		
Plunger-tip diameter(mm)	50	60	65
Casting pressure(Kg/㎠)	(520)-1060	(361)-736	(308)-627
Casting area(㎠)	(348)-188	(554)-571	(649)-318
Injection volume(㎤)	543	782	917
Injection weight(㎤)	1.41	2.03	2.38

※NOTE : The injection volumes been calculated when the sleeve is 100% full of molten metal as plunger stroke calculated at 75% of its maximum stroke

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