

Integral Insert

PRODUCT DESCRIPTION

1 DESCRIPTION

Integral insert is designed to improve cost effectiveness in casting process. It is delivered either with a specific-design shot sleeve or as a replacement part. Integral insert is simply mounted into the sleeve body and designed for replacement directly on the casting machine when its working surface is worn out.



2 MAIN ADVANTAGES

- Cost effectiveness
- Fast replacement, directly in casting machine

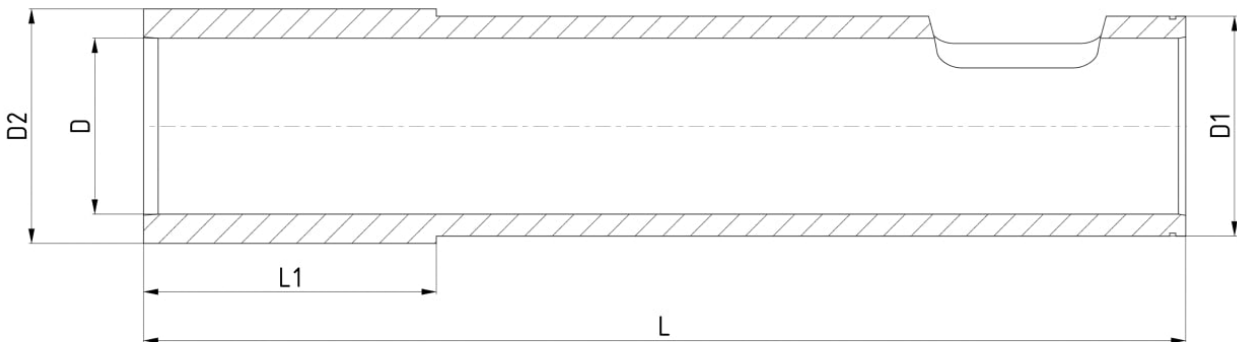
Integral Insert

TECHNICAL SPECIFICATIONS

Integral insert is manufactured from hot-work tool steel, hardened and tempered to 44-46HRC. It comes with surface nitriding.

3 DEFINITION OF GENERAL PARAMETERS

Selection of D is available between 50 mm and 180 mm. Selection of length (L) is available between 400 mm and 1350 mm. According to D and L, parameters D1, D2 are defined, value of parameter L1 is always 200 mm regardless selection of parameters above. Please consider that insert is must be at least 12mm longer than sleeve.



	$L \leq 1000$	$1000 < L \leq 1200$	$1200 < L \leq 1350$
$D \leq \varnothing 140$			
D1	D+20	D+20	D+30
D2	D+30	D+30	D+40
$\varnothing 140 \leq D < \varnothing 160$			
D1	D+30	D+30	D+40
D2	D+40	D+40	D+50
$D > \varnothing 160$			
D1	D+30	D+40	D+40
D2	D+40	D+50	D+50

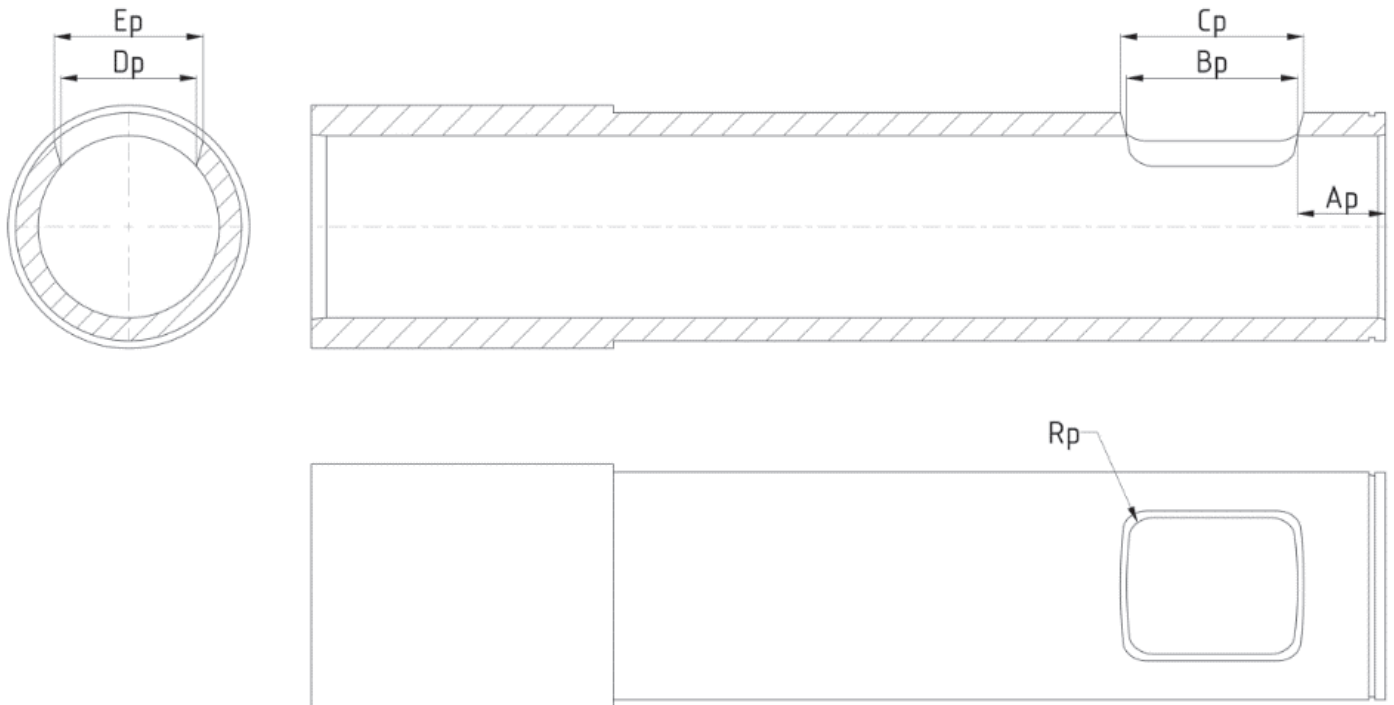
All dimensions are in mm

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TECHNICAL SPECIFICATIONS

1 DEFINITION OF POURING HOLE PARAMETERS

Pouring hole parameters are defined to ensure a perfect fit of integral insert into Shot Sleeve.



Dimension	Limits
Ap	20 - 200
Bp	20 - 200
Cp	$Bp - (Bp + 30)$
Dp	20 - 100
Ep	$Dp - (Dp + 30)$
Rp	1 - 50

All dimensions are in mm

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