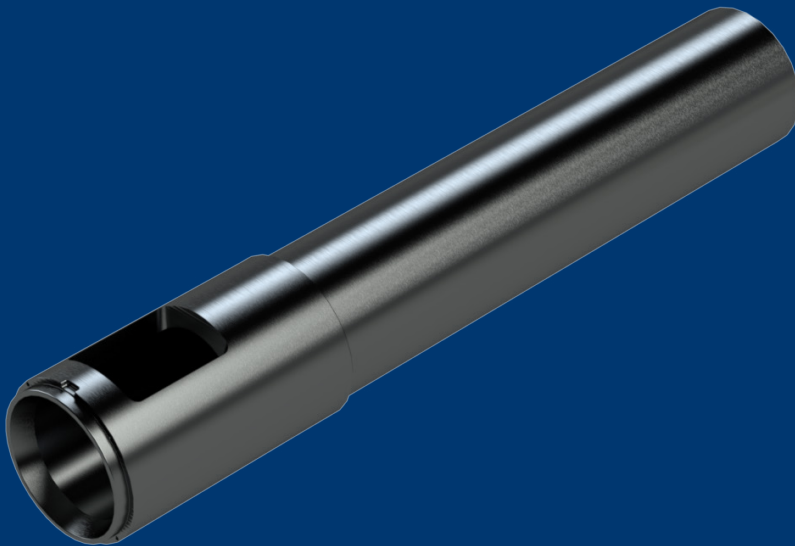


DATA SHEET

Integral insert / liner



Integral insert / liner



DESCRIPTION

Integral insert is designed to improve cost effectiveness in the 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.

MAIN ADVANTAGES

- Cost effectiveness
- Fast replacement, directly in the casting machine

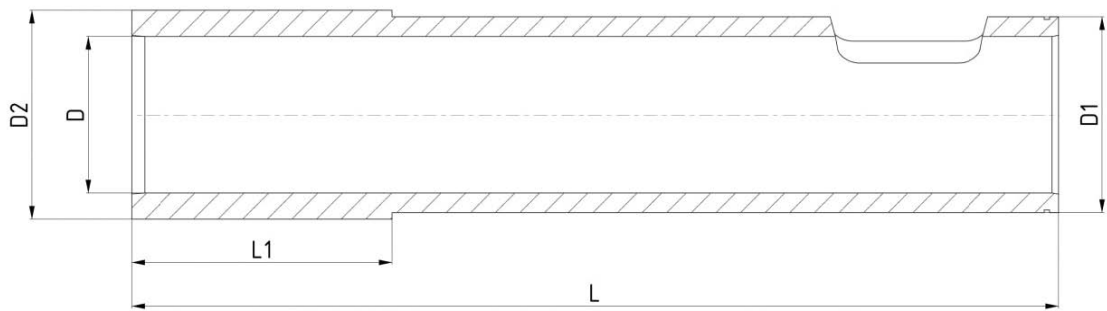
MATERIAL

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

Integral insert / liner

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.



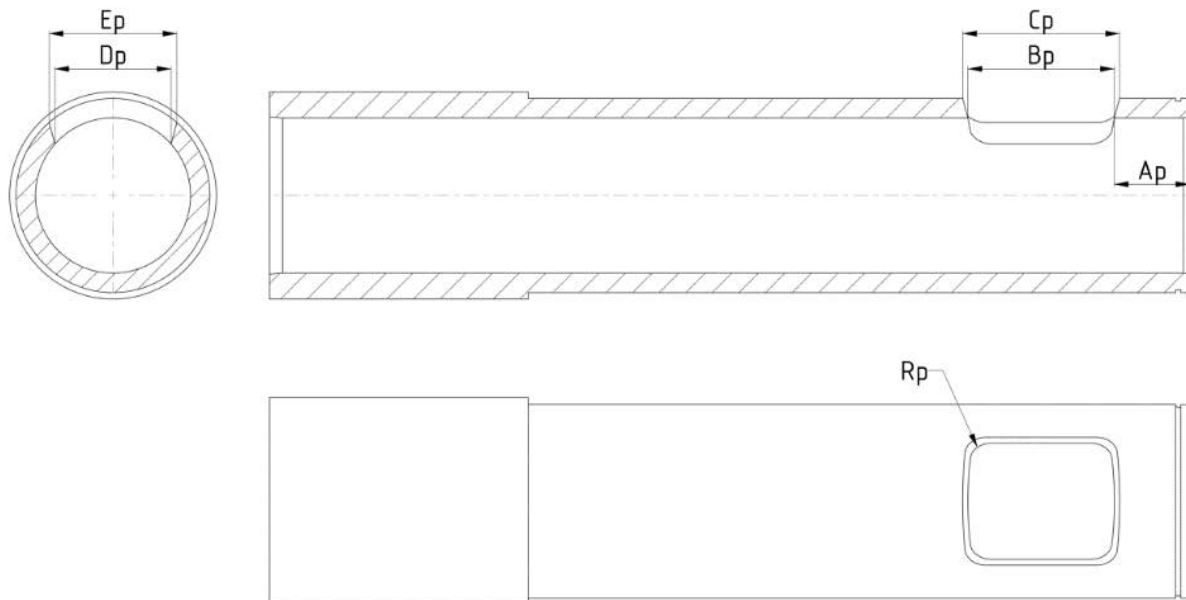
	$L \leq 1000$	$1000 < L \leq 1200$	$1200 < L \leq 1350$
$D \leq \varnothing 140$			
D1	D+20	D+20	D+30
D2	D+30	D+30	D+40
$\varnothing 140 \leq D < \varnothing 160$			
D1	D+30	D+30	D+40
D2	D+40	D+40	D+50
$D > \varnothing 160$			
D1	D+30	D+40	D+40
D2	D+40	D+50	D+50

All dimensions are in mm

Integral insert / liner

DEFINITION OF POURING HOLE PARAMETERS

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



Dimensions	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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