

Machine Structure

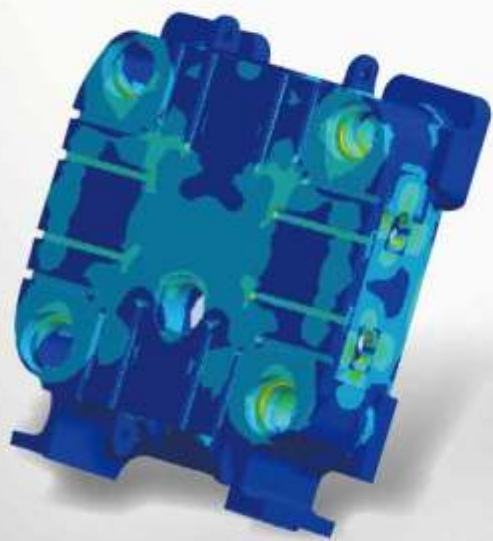
High Rigidity, Deformation Free and
Maximum Load Resistance

機體結構 高剛性，不變形 / 耐重負荷

The structure of the full series of Evergreat die casting machines is carefully analyzed and designed to achieve optimal structural strength, maximum load resistance, while remaining deformation-free year after year.

永大全系列壓鑄機之機體結構均經過精心分析，設計，以達到最佳結構強度，耐重負荷，且多年不變形。

- Increased die platen thickness maximizes die clamping stability and rigidity, while keeping deformation to a minimum.
- One-piece fabricated front platen and C-frame assures consistent injection center.
- Oversized tie bar is stress relieved for extra durability and long service life.
- 模板加厚，提升鎖模穩定性及剛性，最低變形量。
- 前機壁與C型架一體成型，射出中心一致。
- 超大尺寸之大柱經應力消除，強度高，使用壽命長。



The Ultimate in Structural Design

● Advanced Control System

● 電器系統

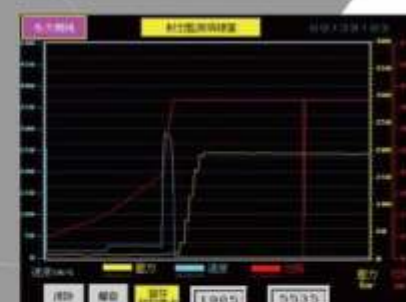
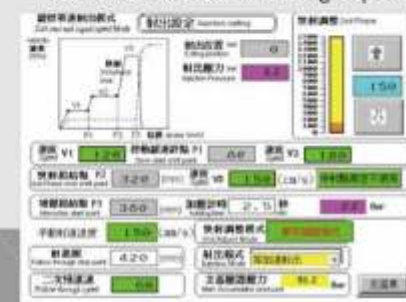
Wireless Wi-Fi (Optional)
無線Wi-Fi (選配)

Double Controls (Optional)
雙主機 (選配)



● Injection Mold (Optional) ● 射出模式 (選配)

緩啓單速 Soft Start with Single Speed



多段速 Multi-stage Speed



等加速 Constant Acceleration



● Full Test Mold Flow Analysis

1. In the cold chamber die casting process, the barrel is an open space, in which melt flow will swell lots of gas that is then forced into the mold cavities. This may influence product quality. A proper selection of critical low injection speed can ensure the melt flows smoothly in the barrel without generation of swelling gas.
2. As there is a temperature difference between the melt and the barrel-wall once the melt is poured into the barrel, a cold layer with solid state will be formed on the barrel wall. It causes swelling gas or wrapped gas during feeding, and is visible through the simulation function. By adjusting temperature and injection speed a fully filled barrel condition can be achieved before the melt reaches the quick injection point.
3. With the use of the multi-stage speed function, the operation can simulate the melt flowing into the mold cavity condition, and make a corresponding solution.

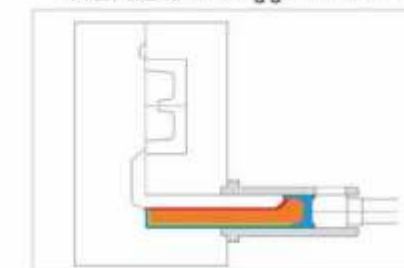
鑄造物 Die casting product



鑄造物 Die casting product



料管內捲氣 Swelling gas in the barrel



● 實機模流分析

1. 在冷室壓鑄製程中，料管屬於開放空間，熔湯流動過程中，可能捲入大量氣體而將空氣擠入模腔內，嚴重影響鑄件品質。有效選擇射出低速之臨界速度，使熔湯在料管內流動平順而無捲氣產生。
2. 由於熔湯與料管壁的溫度差，熔湯倒入料管後，會在料管壁形成凝冷層而呈固態，在推進的過程中形成捲氣，包氣的情形，經由模擬功能變成可視，進而調整溫度及射速，使熔湯於快射點以前，呈成無捲氣飽管狀態。
3. 可使用多段速功能，模擬熔湯進入模腔內流動情形，從中觀察，做出對應解決方案。

● Information in Die Casting Factory and Far-end Monitoring (Optional)

All information during the die casting process can be transferred through internet or Wi-Fi to managers' computers at the near-end or far-end for real-time display, saving and printing.

● 壓鑄工場信息化及遠端監控 (選配)

壓鑄製程進行中的所有信息，都可透過網路或Wi-Fi傳送到近端或遠端管理人員電腦中，做實時顯示，儲存與列印。

- Choice of three injection modes such as soft start with single speed, multi-stage speed and constant acceleration.
- Fully P/Q controlled machine motions.
- Touch screen panel features easy and convenient operations.
- The Full Test function provides mold—flow analysis.
- Wireless Wi-Fi enables information in die casting factory and far-end control.
- A combination of servo control and hydraulic system leads to significant energy-saving.
- Double controls provide control and data generation simultaneously for dramatically improving the machine accuracy.
- Allows for simultaneously monitoring injection curve, pressure, speed and displacement.
- Production history record function.
- Available to be on-line with the cupola temperature or mold temperature.

- 緩啓單速、多段速、等加速，三種射出模式可供選擇。
- 全P/Q控制機械動作。
- 觸控彩色屏幕，操作方便。
- Full test 功能，實機模流分析。
- 無線Wi-Fi實現壓鑄工場信息化及遠端監控功能。
- 伺服-液壓系統有效節能。
- 雙主機運行，控制與資料擷取同時進行，機器精度大幅改進。
- 射出曲線功能、壓力、速度、位移量同時監看。
- 生產履歷記錄功能。
- 可接入熔爐之溫度或模溫。

Features

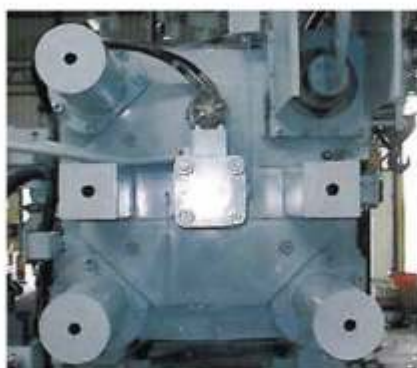


One-piece Fabricated C-frame

The front platen and C-shaped frame are a one-piece construction ensuring proper alignment of the injection center. This allows the machine to exhibit excellent injection performance.

一體式射出C型結構

獨特設計的前機壁與C型架為一體鑄造成型，可確保射出中心的一致性，更可徹底發揮優異的射出性能。



Automatic Tie Bar Pull Out Device (optional)

- The device provides added convenience in die mounting and dismounting, and is especially ideal for dies with hydraulic cores.
- The upper die bar can be pulled out from the front platen.
- The picture shows a tie bar pull out device applied for upper tie bar at the operator's side of the machine.

自動大柱抽取裝置 (選配)

- 對於具有油壓中子之模具，提供裝卸之方便性。
- 上側之大柱可抽離前機壁。
- 照片所示為操作側上方大柱之抽取裝置。



Hydraulic System

- The hydraulic system features energy saving.
- Main pressure control employs variable proportional valves to achieve higher efficiency and long service life.
- Operational power is supplied by an advanced servo-hydraulic combination system which precisely controls the flow rate and pressure of the oil.

液壓系統

- 液壓系統，具節能省電特性。
- 總壓控制採用無段式比例閥，具高效率且使用壽命長。
- 裝先進伺服-液壓結合液壓系統精準地對機器作動流量與壓力，提供必須動力，可節省電力20%以上。



節能液壓(選配)
Energy Saving Hydraulic Device (Optional)



Safety Door

When the safety door is opened, all motions of the machine stop immediately for protecting personnel safety. The entire machine is safely guarded, reducing the machine's impact on environment and increasing its reliability.

安全門

當安全門打開時，本機所有動作立刻停止，以確保人員之安全。全機器各部位都安全包覆，減少環境對機器污染並有效降低機器故障率。



Automatic Lubricator

- Each toggle point is well lubricated by high pressure grease.
- Lubrication pressure reaches 50 kg/cm² without insufficient lubrication problems (grease no. 0.00).

自動注油器

- 機器各部曲手活動點，都施以高壓黃油潤滑。
- 注油壓力高達50 kg/cm²以上，無潤滑不足之慮(黃油番號0.00)。



Self-lubricating Bushings

The toggle mechanism of each model is equipped with self-lubricating bushings to maintain high accuracy year after year. This not only reduces oil consumption, but is also environmentally friendly.

自潤型銅套

全系列機種之曲手使用自潤型銅套。除了可確保長久精度，而且可減少潤滑油之注油頻率。既經濟又環保。



Rigid Toggle Mechanism

The toggle mechanism is specially designed with increased thickness of the mold platen, resulting in greater rigidity and die clamping stability. This also ensures outstanding parallelism accuracy between the mold platens.

高剛性曲手機構

特殊設計的曲手機構，機板厚度加厚，除了大幅增加鎖模時之剛性與穩定性。而且確保機壁面的平行精度。



Piston-type Accumulator

- The full series of machines are equipped with piston type accumulators, which can store high pressure up to 210 kg/cm² for direct output of pressure.
- Effectively shortens the pressure accumulating time, increases work piece's density, and reduces maintenance costs. The accumulator also features better performance with impure oil.

活塞形蓄壓器

- 全系列機種採用活塞形蓄壓器，可積蓄壓力高達210 kg/cm²，並且直接作高壓輸出，縮短增壓建壓時間。
- 射出的建壓時間可以有效縮短，提升產品密度，日後維修成本低，對於油壓油雜質容忍度高。





EVERGREAT YOTA
DIE CASTING MACHINE

DC-150V3C

Compact Construction!
Space Saving!

永大壓鑄機

結構紮實！省空間！

- Max. shot speed: 7m/sec.
- Casting capacity increased by over 20%
- Shortened machine structure for 15% savings in space
- 20% shorter cycle time than on previous models

- 最大射速7米/秒。
- 鑄造能力提升20%以上。
- 機身短，節省空間15%。
- 循環時間比舊機型快20%。

Clamping force	鎖模力	150 Ton
Die height	夾模厚度	200-500 mm
Tie bar distance	柱內尺寸	465 x 465 mm
Max. weight of shot	最大實射出重量	1.64 kg
Max. casting area	最大鑄造面積	426 cm ²
Electricity	所需馬力	15 kw

The EVERGREAT YOTA DC-105V3C Die Casting Machine is a small model, yet features compact, high speed response and production. The DC-150V3C provides 150 tons of clamping force 730 x 730 mm die platen sizes. Its injection speed reaches 7 M/sec. The front platen and C-shaped frame are one-piece fabricated to ensure accurate alignment of the injection center. High performance hydraulic system also features energy savings. The machine is equipped with a personified controller, that is easy to learn and operate. Also, it allows the operator to check the operation status at any time.

永大 DC-150V3C 壓鑄機是屬於小型機種，精巧快捷、產速快。本機具有 150 噸的鎖模力，機壁尺寸為 730 x 730 mm。高速射出可達7米/秒。DC-150V3C 之前機壁與C型架為一體鑄造成型，確保射出中心一致。高性能液壓系統，更具有節能省電特性。本機搭載人性化控制器，易學易操作，並可隨時監控機器作業情況。

EVERGREAT YOTA DIE CASTING MACHINE DC-250 V3C

永大壓鑄機

- Dry injection speed over : 6 m/sec.
- Injection stability 30% up.
- 空打射速6米/秒以上。
- 射出穩定性提升30%以上。

Clamping force 鎖模力	250 Ton
Die height 夾模厚度	250-600 mm
Tie bar distance 柱內尺寸	585 x 585 mm
Max. weight of shot 最大實射出重量	2.75 kg
Max. casting area 最大鑄造面積	714 cm ²
Electricity 所需馬力	22.5 kw



The V3C models are the most mature machines with the widest application range. They are also the most reliable and automated machines. Features:

- One piece design for the injection system. The most efficient oil circuit with excellent injection performance.
- Integrated structural rigidity with self-lubrication design for long service time.
- Easy to install peripheral equipment for automation, which increases efficiency and saves man power.
- User-friendly Man-Machine Interface (MMI) with alarm device.
- Multi-stop injection adjustment provides a reduction of swelling gas in the barrel, while upgrading die casting product quality.
- There are three injection models including soft start with constant speed injection, constant acceleration injection and multi-stage injection for flexible production.
- The use of a P/F valve helps to increase convenience of operation while reducing electricity consumption up to over 15%.
- Available to be equipped with a servo controlled energy-saving electrical system for saving electricity consumption up to 50%.
- The Full Test function provides a simulation of die casting process that allows the operator to realize the aluminum liquid flow condition during a molding cycle.

V3C 型機是最成熟，應用範圍最廣泛的機型，也是穩定性與自動化應用最佳機型之一，具有以下特點：

- 一體式射出缸設計，油路效率最佳化，射出性能優越。
- 整體的機械結構剛性佳，並且都有自潤滑的功能，機械使用期限長。
- 整體週邊自動化搭配容易，提升效率及省力化效果明顯。
- 人機界面容易使用，有設置警報。
- 射出多階段射出調整，可減少料管內捲氣，提高壓鑄件品質。
- 射出模式有三種：緩起動等速射出，等加速射出，多階段射速，產品的適用性更廣泛。
- P/F閥的應用，可有效提升操作方便性，及降低電能的消耗達15%以上。
- 可搭載伺服節能電機，省電最高達50%。
- Full test 功能實機模擬壓鑄過程，清楚了解鋁水在成形過程中如何流動。



HIGH SPEED PRODUCTION, CONSISTENT QUALITY

All this and more can be found in Evergreat's V4N series

快速生產 / 品質穩定 盡在永大V4N系列

Carefully manufactured by Evergreat, the V4N die casting machine series features fully automatic operation and shortened cycle time. This machine series will dramatically boost productivity, while lowering production costs.

永大精心打造的V4N系列壓鑄機，以全自動化的生產模式，以及較短的循環時間，為客戶大幅提升產能，降低生產成本。



Fully Automatic Operation, Increased Productivity and Lower Production Costs

Die casting automation is the only competitive edge in today's competitive environment. The Evergreat V4N series is available to equip with various peripheral equipment, allowing the machine to achieve highly automated die casting operations.

全自動化生產
提升產能 / 降低成本

壓鑄自動化是當今企業競爭的有效利器。永大V4N系列壓鑄機可配備全系列週邊設備，展現高度自動化的壓鑄作業。

DC-420V4N

- Max. shot speed: 7 m/sec.
- Casting capacity increased by over 20%
- Accommodates extra large die
- Ultra-powerful motor drive
- 最大射速7米/秒。
- 鑄造能力提升20%以上。
- 可裝置超大模具。
- 強勁馬力。

Clamping force	鎖模力	420 Ton
Die height	夾模厚度	300-700 mm
Tie bar distance	柱內尺寸	650 x 650 mm
Max. weight of shot	最大實射出重量	4.18 kg
Max. casting area	最大鑄造面積	1036 cm ²
Electricity	所需馬力	22.5 kw

FEATURES OF DC 250/420 V4N

特性介紹



Manual adjustment (standard)
手動調整 (標準配備)



Automatic adjustment (optional)
自動調整 (選配)

E.I.V. Electric Injection Valve (optional)

- The first and second steps of injection speed and pressure boosting are individually controlled by 3 E.I.V. valves which feature automatic correction and memory functions.
- Injection positioning is controlled by a transducer that ensures high accuracy positioning.

E.I.V.射出電控閥 (選配)

- 第1段與第2段射出速度與增壓速度分別由3個E.I.V.閥控制，具有自動修正與記憶功能。
- 射出位置採用電子尺控制，確保射出位置之精準控制。

Two Sets of Independent Accumulators

The injection circuit employs two sets of independent accumulators, providing the first and second stage injection and intensifying injection functions. With the independent intensifying accumulators, more stable intensified pressure can be achieved.

Accurate Injection

The injection unit allows for various parameter adjustments, such as pressure buildup time at the first and second stage, intensified pressure value and injection pressure value. Each part is equipped with a sensor for feeding back the injection speed and pressure to the controller. The controller will compare the difference between the actual injection value and the setting value, then the operator makes fine tuning according to the comparison result. In addition, the operator may understand the current injection condition through the displayed curve. This greatly upgrades injection accuracy.

Choice of Fine Tuning Methods:

- Manual tuning (standard)
- Automatic tuning (optional)

二組獨立蓄壓器

射出迴路採用二組獨立的蓄壓器，提供第一段與第二段射出及增壓射出。由於增壓蓄壓器為獨立設計，因此可以達到更穩定的增壓壓力，以及更短的增壓建壓時間。

精密射出

射出部份可調整參數包括：一段速、二段速，增壓建壓時間，增壓壓力值，射出壓力值。各部均配有感知器，可精準的將射出速度、壓力傳回至控制器。經由控制器比對實射值與設定值之誤差，再進行微調。操作人員可由顯示曲線瞭解射出狀況，可大幅提昇射出的準確性。

微調方式：

- 手動調整 (標準配備)
- 自動調整 (選擇配備)

Comprehensive Control Functions

- First stage injection speed / manual / auto speed adjustment according to feedback value.
- Second stage injection speed / manual / auto speed adjustment according to feedback value.
- Intensifying pressure buildup time / manual / auto speed adjustment according to feedback value.
- Main accumulator pressure detection / setting / safety device.
- Intensifying accumulator pressure detection / setting / safety device.
- Pressure relief valve for safety.
- FL speed reduction injection.
- Digital position feedback / injection speed detect / display.

完善的控制功能

- 一段射速 / 手動 / 自動反饋調速
- 二段射速 / 手動 / 自動反饋調速
- 增壓建壓時間 / 手動 / 自動反饋調速
- 主蓄壓器壓力檢知 / 設置 / 安全裝置
- 增壓蓄壓器壓力檢知 / 設置 / 安全裝置
- 安全洩壓閥
- FL 減速射出
- 數位位置反饋 / 射速檢測 / 顯示



Specially Designed Integrated Injection Circuit

The series of machines is specially designed with an integrated injection circuit. The special manifold minimizes hysteresis of hydraulic response, increases injection response and is easy to maintain. With this outstanding design, you get higher qualification percentages of die casting parts and stability.

特殊設計的集成化 一體式射出油路

此系列機種採用獨特設計的集成化一體式射出油路。可降低液壓反應遲滯現象，射速響應快，且維護容易等諸多優點。可有效提升壓鑄產品良率及穩定性。



DC-500 / 650 V3C

Designed and Built
for High Production Demands

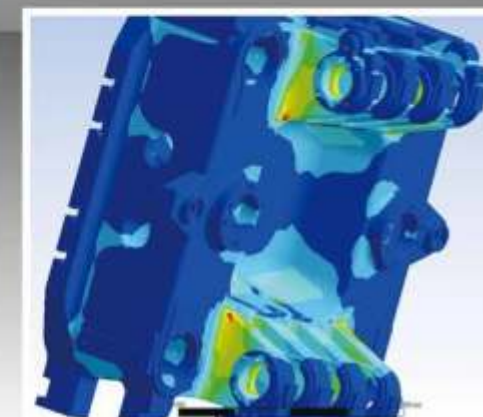
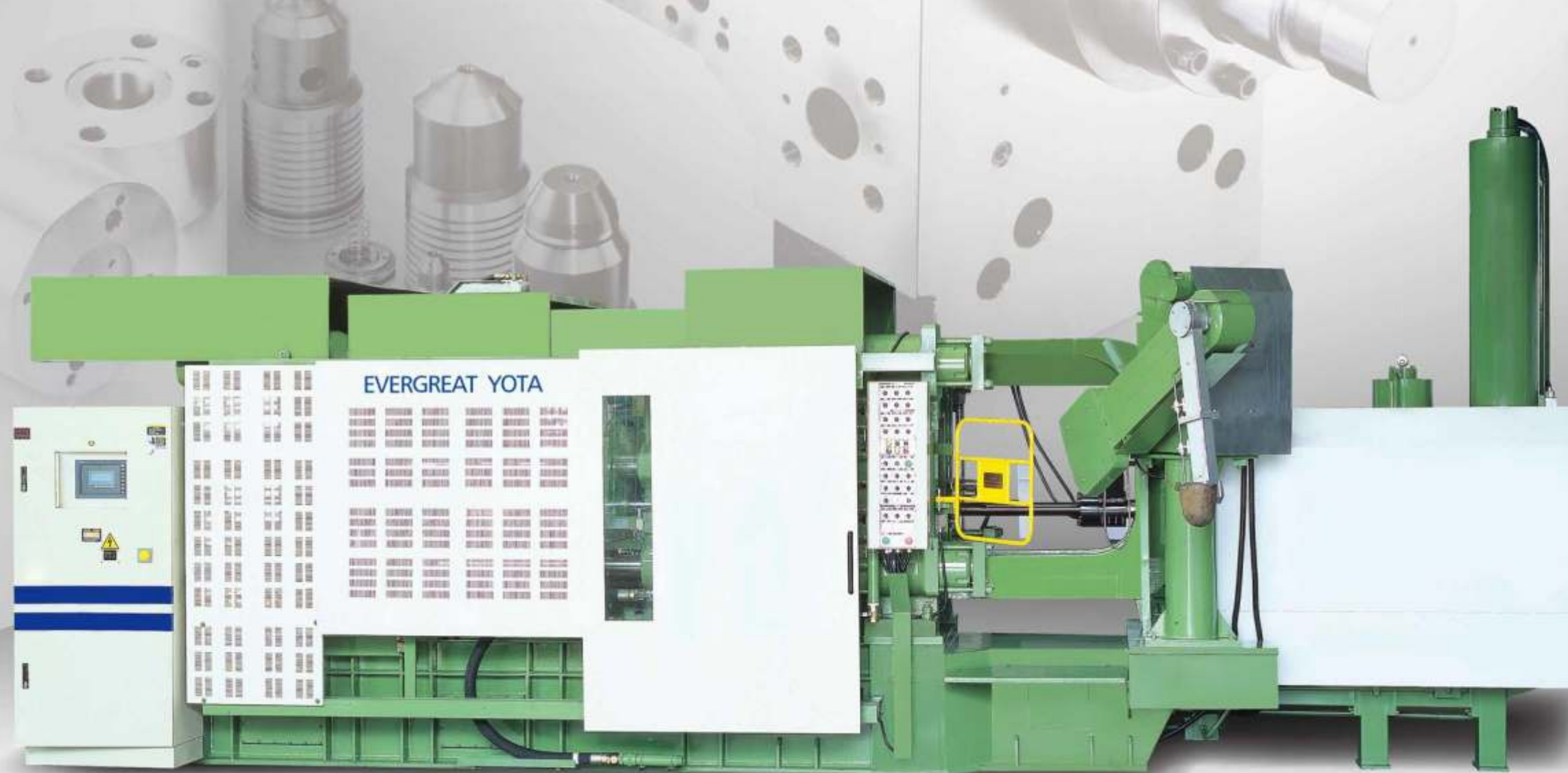
永大V3C系列壓鑄機 專為高產能需求量身打造

DC-500 / 650 V3C

Clamping force	鎖模力	500 Ton / 650 Ton
Die height	夾模厚度	350~900 mm
Tie bar distance	柱內尺寸	750x750 mm / 850x850 mm
Max. weight of shot	最大實射出重量	7.68 kg
Max. casting area	最大鑄造面積	1522 cm ²
Electricity	所需馬力	37.5 kw

The 500 / 650 / 800 machines are state-of-the-art models that feature optimum mechanical structure, oversized die platen and surpass the limitation of small platen size on other machines. The high speed solenoid valve is standard equipment - a powerful device to boost molding techniques. The user friendly parameter settings allow complicated parts to be made easily. The automatic sprayer extractor and ladle can be conveniently connected. In addition, the automatic sprayer features multi-point spray - the mold surface is sprayed evenly.

500 / 650 / 800 三款中型機都是具備優良的機械結構，超大的機壁尺寸，突破舊型機模面小的限制。快射電控閥為標準配備，對於鑄造技術，參數調整都有很大的助益，也有助於完成高難度鑄件。自動化設備噴霧機、取出機、給湯機都可達到完美連接，噴霧機有定位多點噴霧功能，更可有效均勻化模面噴塗。



Stress analysis on mold plate.
機器模壁應力分析

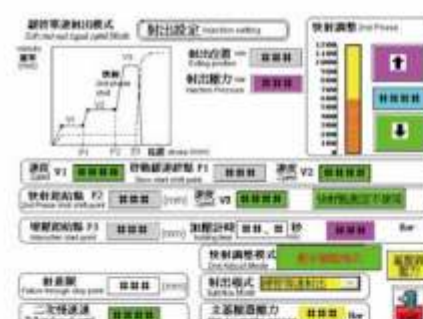
DC-800V3C

先進電控 / 高性能油壓

創造利潤的首選機種

Advanced Control System -
High Performance Hydraulic System
The No.1 Choice for Creating Profits!

Clamping force	鎖模力	800 Ton
Die height	夾模厚度	400-950 mm
Tie bar distance	柱內尺寸	950 x 950 mm
Max. weight of shot	最大實射出重量	10.7 kg
Max. casting area	最大鑄造面積	2088 cm ²
Electricity	所需馬力	45 kw



Multi-stage Injection Control (optional)

- The multi-stage injection control provides 8-stage injection speed with digital control, and effectively exhausts air from the barrel and die cavity.
- Especially ideal for a large machine for improving product quality.

多段射出控制(選配)

- 多段射出控制可提供8段位的射出速度數值化控制模式。可有效排除料管及模腔內之空氣。
- 特別適用於大型機器，以改善產品品質。



Multi-step injection.
多階段射出

Fully Automatic Operations Provide a Competitive Casting Mode

The DC-800V3C die casting machine is available to equip with various peripheral equipment. This allows the machine to achieve fully automatic operations, greatly upgrading the competitive edge, while creating more profits.

全自動化作業 打造最具競爭優勢的壓鑄模式

DC-800V3C壓鑄機，可配合使用各種自動化週邊設備，達成全自動化生產，提升競爭力，創造利潤。



EXJ Auto Extractor
EXJ 型自動取出機

EXJ

EXJ Auto Extractor EXJ 型自動取出機	EXJ-15	EXJ-25	EXJ-42
Component weight kg 鑄件重量	1.5	2.5	3.5
Plunger diameter mm 夾取直徑	45.50.60	50-70	60-80
Arm driving motor kw 手臂驅動馬達	0.4	0.4	0.4
Air source 空壓源	pneumatic 4-6kg/cm ² 1"port		
Suitable machine 適用機器	DC-150	DC-250	DC-420
Overall dimensions L×W×H : 1100 * 850 * 900			



EX Auto Extractor
EX 型自動取出機

EX

EX Auto Extractor EX 型自動取出機	EX-15	EX-25	EX-42
Component weight kg 鑄件重量	1.5	2.5	3.5
Plunger diameter mm 夾取直徑	45.50.60	50-70	60-80
Air source 空壓源	pneumatic 4-6kg/cm ² 1"port		
Suitable machine 適用機器	DC-150	DC-250	DC-420
Overall dimensions L×W×H : 1100 * 920 * 1000			

Peripheral Equipment

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週邊配備



AL Type Automatic Ladle

- Smooth and stable motion
- Reciprocation can be accomplished within 4.5 seconds.
- Digitized melt amount for high accuracy

AL 型自動給湯機

- 動作快速平穩。
- 往返時間可在4.5秒內完成。
- 湯量數字化，給湯量精準。

AL Type Automatic Ladle AL	AL-15	AL-25	AL-42
Maximum weight (AL) kg 最大汲湯量	1.5	2.5	3.5
Ladle weight adjustable range kg 可汲湯量	0.2-1.5	0.4-2.5	0.4-3.5
Metal weight tolerance 取湯差	±2%	±2%	±2%
Suitable machine 適用機器	DC-150	DC-250	DC-420
Drive electric motor kw 驅動電機	0.75/0.4	0.75/0.4	0.75/0.4

The suitable cup ladle specifications : 0.5,0.8,1.5,2.0,2.5,3.5kg(AL)
可用湯勺規格 : 0.5,0.8,1.5,2.0,2.5,3.5kg(鋁)
Overall box dimensions L×W×H : 730 * 920 * 1150



CL Type Automatic Ladle

- Specially designed for medium and large die casting machines
- Applicable for over 500 Ton models
- Maximum ladling capacity is 8 kg.
- Stable motion—high speed

CL 型自動給湯機

- 專為中大型壓鑄機而設計。
- 適用500噸以上機型。
- 最大汲湯量8公斤。
- 動作穩定，速度快。

CL Type Automatic Ladle CL型自動給湯機	CL-650	CL-800
Maximum weight (AL) kg 最大汲湯量	6	8
Ladle weight adjustable range kg 可汲湯量	0.5-6	0.5-8
Metal weight tolerance 取湯差	±2%	±2%
Suitable machine 適用機器	DC 500-DC 650	DC800-DC1250
Drive electric motor kw 驅動電機	1.5/0.4	1.5/0.4

CL大型給湯機
Suitable cup ladle : 5,7,8kg
可用湯勺規格 : 5,7,8kg



SP Type Automatic Sprayer (Pneumatically operated)

- Fast movement
- Especially ideal for high speed running conditions
- Water/air spray for moving and fixed molds can be adjusted independently.

SP 型自動噴霧機(氣動)

- 移動快速。
- 特別適用於高速運轉之場合。
- 活動模與固定模之噴水/氣量可分別調整。

SP Type Automatic Sprayer	SP 型自動噴霧機	SP-15	SP-25	SP-42
Spraying tube No 噴霧管		28	28	28
Blowing tube No 吹氣管		14	14	14
Air consumption 空氣消耗量	140NL/min (An equivalent to 15HP compressor 相當於15HP空氣壓縮機)			
Air reserve tank 儲氣桶		250-300Liter	250-300Liter	250-300Liter
Die coat adjustment (separate control) 離型劑控制方式		Moving side and fixed side 活動模與固定模分別調整		
Traveling stroke mm 上下行程		600	700	750
Air source 空壓源		pneumatic 4-6kg/cm ² 1"port		
Suitable machine 適用機器		DC-150	DC-250	DC-420
Overall dimensions L×W×H : 660 * 900 * 1250 weight : 180kgs				



SPV Type Automatic Sprayer (Motor drive)

- Multi-point, multi-position spray and air blast functions
- Designed for accurate spray
- It can be positioned as desired and is capable of vertical oscillation to achieve outstanding performance.

SPV 型自動噴霧機(馬達驅動)

- 多點多位置噴霧與吹氣功能。
- 適用於精密噴霧之需求。
- 可在任何位置定位，搭配上下擺動，展現優異的噴霧吹氣效果。



SPV Type Automatic Sprayer	SPV 型自動噴霧機	SPV-15	SPV-25	SPV-42
Spraying tube No 噴霧管		17+17	17+17	17+17
Blowing tube No 吹氣管		14	14	14
Air consumption 空氣消耗量	140NL/min (An equivalent to 15HP compressor 相當於15HP空氣壓縮機)			
Air reserve tank 儲氣桶		250-300Liter	250-300Liter	250-300Liter
Die coat adjustment (separate control) 離型劑控制方式		Moving side and fixed side 活動模與固定模分別調整		
Traveling stroke mm 上下行程		1000	1200	1320
Air source 空壓源		pneumatic 4-6kg/cm ² 1"port		
Suitable machine 適用機器		DC-150	DC-250	DC-420
Driving power source 驅動源		0.75KW	0.75KW	0.75KW



Peripheral Equipment

<http://www.yota-diecasting.com.tw>

週邊配備



SPV-800 Automatic Sprayer

- Multi-point, multi-position spray and air blast functions
- Designed for accurate spray
- It can be positioned as desired and is capable of vertical oscillation to achieve outstanding performance.
- Applicable for medium and large machines.

SPV-800 自動噴霧機

- 多點多位置噴霧與吹氣功能。
- 適用於精密噴霧之需求。
- 可在任何位置定位，搭配上下擺動，展現優異的噴霧吹氣效果。
- 適用於中大型機器。

SPV-800 Automatic Sprayer	SPV-800 自動噴霧機	SPV-800
Spraying tube No 噴霧鋼管		25+25
Blowing tube No 吹氣鋼管		23
Air consumption 空氣消耗量	140NL/min (An equivalent to 15HP compressor 相當於15HP空氣壓縮機)	
Air reserve tank 儲氣桶		400Liters
Die coat adjustment (separate control) 離型劑控制方式		Moving side and fixed side 活動模與固定模分別調整
Traveling stroke mm 上下行程		1320
Air source 空壓源		pneumatic 4-6kg/cm ² 1"port
Suitable machine 適用機器		DC500-DC1650
Driving power source 驅動源		1.5 KW



柱塞油潤滑裝置

Plunger Lubrication Device



顆粒機

Granule Machine

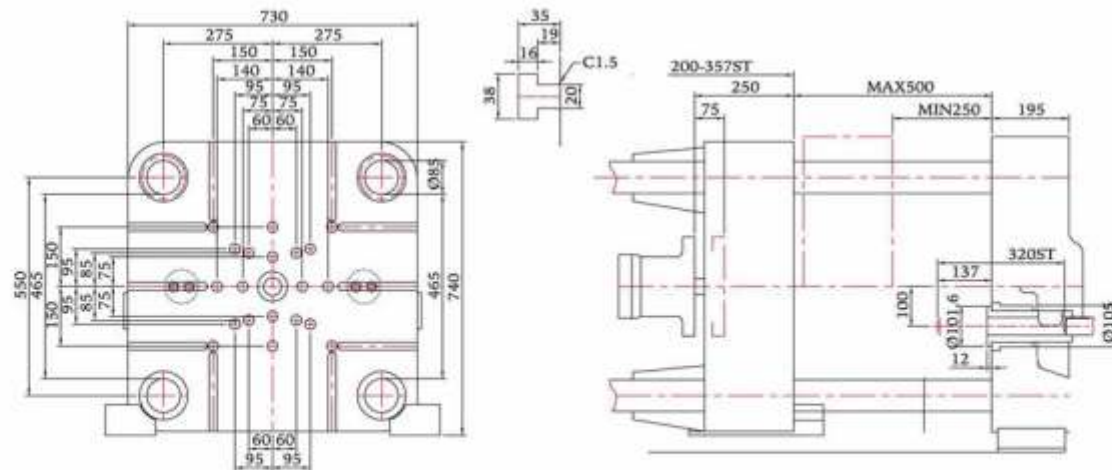


Dimensions of Platens

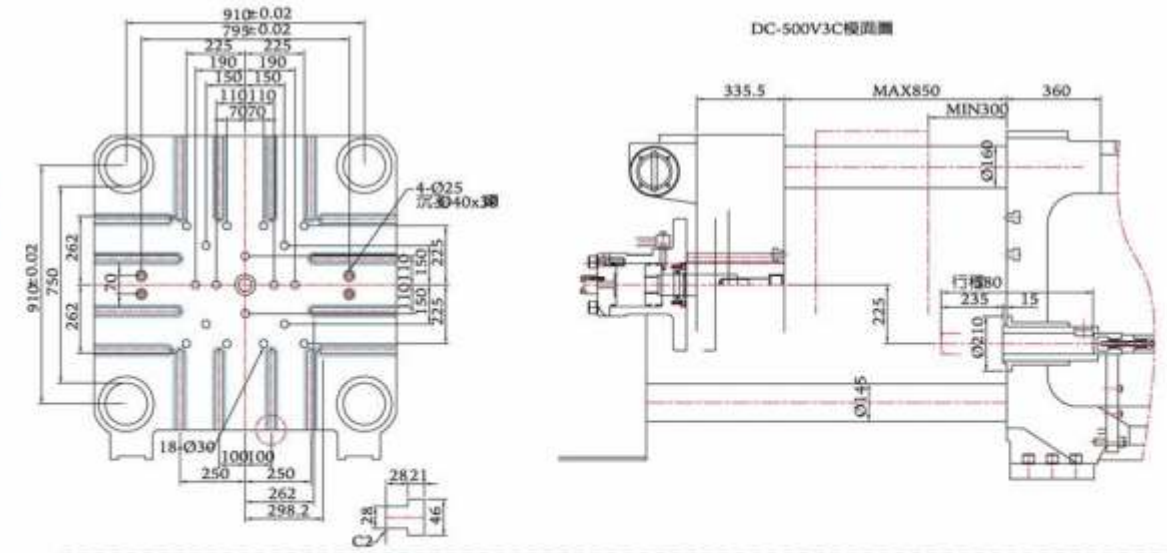
<http://www.yotamachine.com>

機板規格尺寸圖

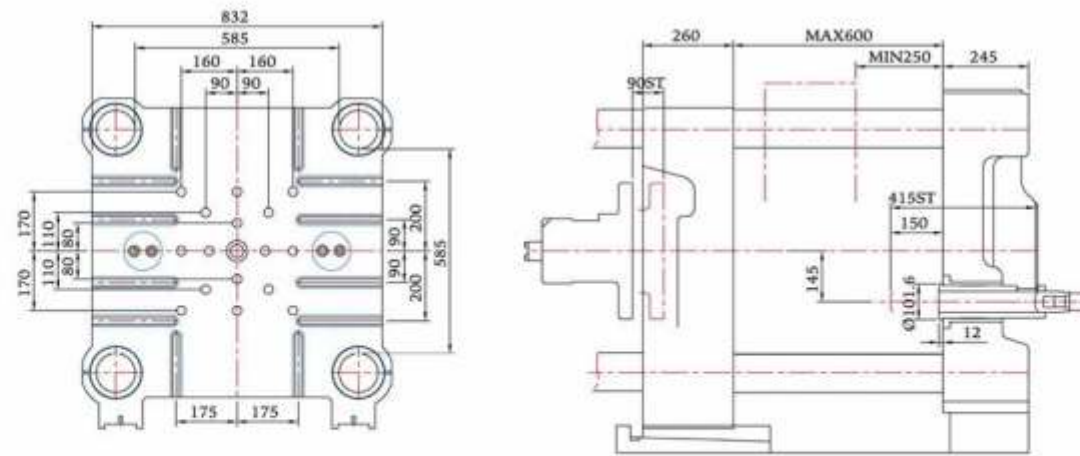
DC-150



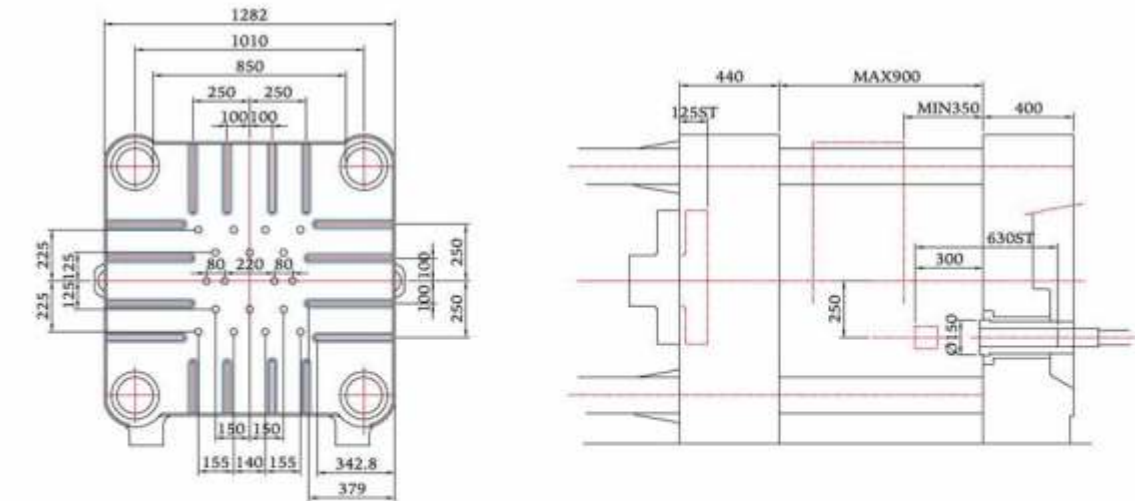
DC-500



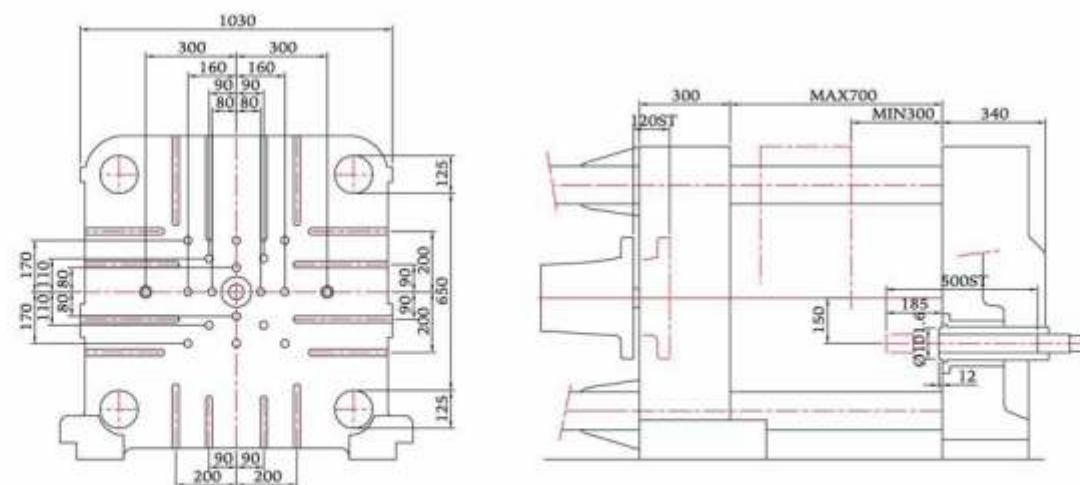
DC-250



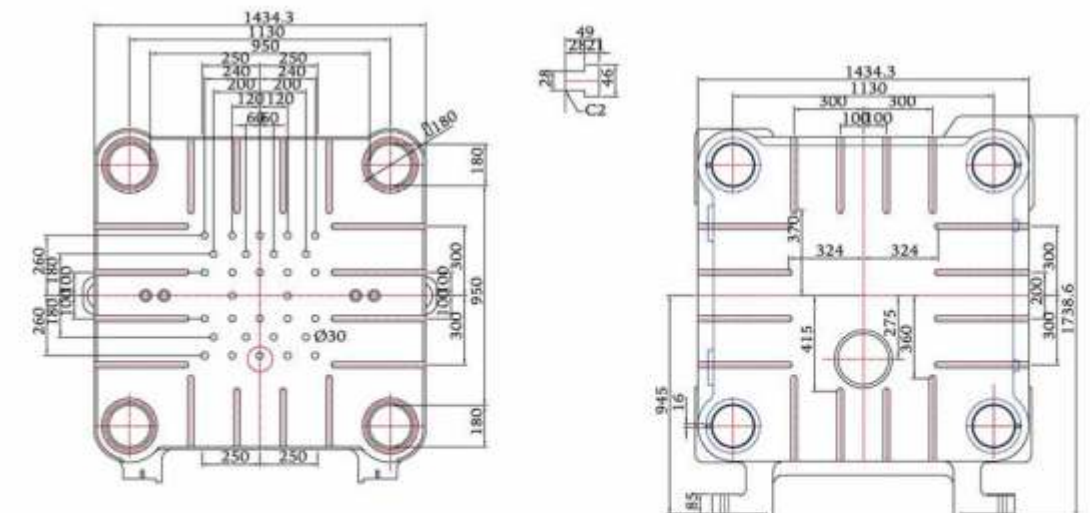
DC-650



DC-420



DC-800



Spec.

規格表

	Model	機 型	UNIT	DC-150			DC-250			DC-420			DC-500			DC-650			DC-800		
	Control unit	電氣系統		PLC+MMI			PLC+MMI			PLC+MMI			PLC+MMI			PLC+MMI			PLC+MMI		
	Shot unit	射出方式		3 phases			3 phases			3 phases			3 phases			3 phases			3 phases		
	Multi stage / constant, Inj. sys	多段射出		三段射出			三段射出			三段射出			四段射出			四段射出			四段射出		
CLAMPING MECHANISM 鎖模機構	Clamping force	鎖 模	Ton	150			250			420			500			650			800		
	Die platen	機壁尺寸	mm	730 x 730			890 x 890			1000 x 1000			1245 x 1245			1280 x 1280			1432 x 1432		
	Tie-bar spacing	大柱內寬寸	mm	465 x 465			585 x 585			650 x 650			750 x 750			850 x 850			950 x 950		
	Die stroke	模面開度	mm	357			435			470			580			660			760		
	Die height	模 厚	mm	250-500			250-600			300-700			300-850			350-900			400-950		
	Clamping indicator	鎖模力負荷計		訂制(optional)			訂制(optional)			訂制(optional)			訂制(optional)			訂制(optional)			訂制(optional)		
INJECTION MECHANISM 射出	Injection force	射出力	Ton	18.2			27			35			50			54.5			63		
	Intensifier rate	增壓比		2.1			2.55			2.3			2.55			2.55			2.55		
	Injection storke	油壓缸行程	mm	355			420			500			630			630			680		
	Plunger tip penetration	沖頭突出量	mm	150			160			185			250			300			300		
	Shot position	射出位置		-100			-145			-150			-250			-250			-250		
	Injection pressure	壓缸射出壓力	kg/cm²	110-130			110-140			110-140			110-140			110-140			110-140		
	Max.Inj. Velocity (up)	最大射出速度(以上)	m/s	7			7			7			7			7			7		
	Available plunger dia.	標準柱塞頭直徑	mm	45.50.60			50.60.70			60.70.80			70.80.90			70.80.90			80.90.100		
EJECTING MECHANISM 押出	Ejecting force	押出力	Ton	7.9			12.3			20			31			31			36		
	Ejecting stroke	押出行程	mm	75			90			90			125			125			125		
CORE SYSTEM 中子	Core NO.1 outlet	中子NO.1取出口	pt	1/2" x 2			3/4 x 2			3/4" x 2			3/4" x 2			3/4" x 2			3/4" x 2		
	Core NO.2 outlet	中子NO.2取出口	pt	1/2" x 2(訂optional)			3/4 x 2(訂optional)			3/4 x 2(訂optional)			3/4" x 1			3/4" x 1			3/4" x 1		
	Core NO.3 outlet	中子NO.3取出口	pt	無(NO)			無(NO)			無(NO)			3/4" x 1			3/4" x 1			3/4" x 1		
CASTING CAPACITY 鑄造能力	Plunger dia.	射料推頭直徑	mm	45	50	60	50	60	70	60	70	80	70	80	90	70	80	90	80	90	100
	Injection pressure	射出壓力	kg/cm²	522/1056	422/856	293/594	687/1374	477/954	350/700	600/1200	441/882	337/674	707/1416	541/1084	427/857	707/1416	541/1084	427/857	600/1200	480/960	385/770
	Cast area	鑄造面積	cm²	239/118	296/146	426/210	363/181	524/262	714/357	584/292	794/397	1036/518	919/459	1201/599	1522/775	919/459	1201/599	1522/775	1320/660	1660/830	2088/1040
	Injecting volume	射出容量	cm³	362	447	644	540	777	1058	904	1230	1607	1788	2336	2956	1788	2336	2956	2635	3340	4120
	Injecting weight	射出重量	kgs	0.92	1.16	1.64	1.4	2.02	2.75	2.35	3.2	4.18	4.64	6.07	7.68	4.64	6.07	7.68	6.8	8.7	10.7
COOLER 冷卻水	Water inlet	冷卻水入口管徑	RcPT	1			1			2			1.1/4			1.1/4			1.1/4		
	Water outlet	冷卻水出口管徑	RcPT	2(x)			2(x)			2(x)			2.1/2			2.1/2			2.1/2		
	Hydraulic cooler in	油冷卻入口管徑	RcPT	1			1			1			1			1			1		
	Hydraulic cooler out	油冷卻出口管徑	RcPT	1			1			1			1			1			1		
	Die water valve (fix)	模具冷卻調整閥(定模)		3/8 x 5			3/8 x 7			3/8 x 7			3/8 x 11			3/8 x 11			3/8 x 11		
	Die water valve (mov)	模具冷卻調整閥(動模)		3/8 x 5			3/8 x 7			3/8 x 7			3/8 x 15			3/8 x 15			3/8 x 15		
	Hydraulic cooler flow	必要冷卻水(油冷卻器)	L/min	40			40			40			80			80			100		
	Die cooler flow	必要冷卻水(模具)	L/min	25-50			30-70			30-70			50-90			50-90			70-150		
MOTOR 馬達	Motor	馬達容量	kw	15			22.5			22.5			37.5			37.5			45		
	Power source	電 源	v	AC220/380			AC220/380			AC220/380			AC220/380			AC220/380			AC220/380		
MACHINE DIMENSIONS 機械	Size (L x W x H)	機械尺寸(長 x 寬 x 高)	mm	4600 x1740 x 2300			5030 x 1800 x 2040			6500 x 2200 x 2500			8800 x 2300 x 2780			8800 x 2300 x 2780			8580 x 2100 x 2660		
	Weight	機械重量	Ton	6			10.5			16			25			25			39		
	Hydraulic oil (optional)	液壓油(廠家自購)	L	600			800			800			1200			1200			1800		