



*Horizontal Cold Chamber
Pressure Die Casting Machines*



Technical Specifications

Model		TDC - 80	TDC - 120	TDC - 180	TDC - 250	TDC - 400
Locking Force	Tonnes	80	120	180	250	400
Injection Force with Intensifier	Tonnes	11.5	20	30	38	45
Hydraulic Ejection Force	Tonnes	4	9	15	15	22
Die Mounting Plates (HxV)	mm	520x520	650x650	760x740	930x930	1040x1040
Space Between Tie Bars (HxV)	mm	330x330	428x428	470x470	580x580	665x665
Max. Die Height	mm	400	450	600	750	750
Min. Die Height	mm	200	200	200	250	250
Tiebar Diameter	mm	60	82	90	110	125
Die Opening Stroke	mm	200	300	450	500	600
Injection Stroke	mm	250	275	300	450	450
Ejection Stroke	mm	50	75	100	100	145
Distance between centre and bottom Injection	mm	0,85	0,120	0,150	0,150	0,175
Electric Motor Capacity	kw	7.5	11	15	22.4	22.4
Working Pressure	kg./cm ²	70	100/35	150/35	150/35	150/35
Hydraulic Pump (Vane Type)	Lit/min	45	39/60	39/90	45/150	45/150
Capacity of Oil Tank	Litres	300	350	500	600	700
Machine Weight	Tonne	3.5	4.6	8.0	12.5	17.0
Shot Capacity (Max. Injection Weight)	GM	950	1500	3000	3690	6800

Constructional Features

Base Frame, Platens & Toggle Links

Carefully fabricated from selected steel and stress relieved. Steel Casting platens and toggle links are precision machined on Horizontal Boring machine equipped with digital read out and VMC machines.

Tie Bars, Auxillary Guide Bars & Piston Rods

Manufacture from high tensile steel, hard chrome plated and precision ground, aluminium Bronze guide bushes of liberal dimension have been used on sliding surfaces.

Hydraulic Cylinders

Made out of extra heavy seamless pipes. These cylinders are carefully machined and honed on imported honing machines. "V" shaped Hydraulic packing of NITRILE RUBBER with provisions for adjustment have been used on Hydraulic Cylinders.

Hydraulic Mono Block

All hydraulic valves are mounted on Hydraulic Blocks to eliminate Cumbersome Hydraulic Piping. Hydraulic equipment is of renowned YUKEN INDIA LTD.

Electrical Controls

The switch box houses all electrical controls and mounted on the fixed Platen for ease of operation. The switch box is operated through a control cabinet which houses contactors, relays, timers, PLC

Accumulator

To provide fast and large quantities of Hydraulic oil to injection cylinders for high velocity of molten metal, a NITROGEN filled ACCUMULATOR is incorporated.

Operation

Machines manufactured by us are ideally suitable for BRASS, ALUMINIUM, ZINC and Tin Alloys. Depending on the gate geometry, the machine can be adjusted for centre and bottom feeding without tempering with any of the hydraulic fittings.

Production Data

Model		TDC - 80			TDC - 120		
Plunger Dia	mm	40	45	50	40	50	60
Shot Capacity	kg	0.56	0.71	0.88	0.60	1.00	1.40
Max. Injection Pressure	kg/cm ²	920	730	590	1602	1025	717
Nom. Casting Area at above Injection Pressure	cm	87	110	135	75	117	168

Model		TDC - 180				TDC - 250			
Plunger Dia	mm	50	60	70	80	60	70	80	85
Shot Capacity	kg	1.10	1.60	2.10	2.70	1.70	2.40	3.10	3.50
Max. Injection Pressure	kg/cm ²	1538	1071	785	600	1318	968	741	652
Nom. Casting Area at above Injection Pressure	cm	117	168	229	300	200	275	355	383

Model		TDC - 400				
Plunger Dia	mm	70	80	90	100	110
Shot Capacity	kg	2.70	3.60	4.50	5.60	6.80
Max. Injection Pressure	kg/cm ²	1125	861	681	551	456
Nom. Casting Area at above Injection Pressure	cm	400	520	660	815	985

Illustrations, Specifications are not binding and are subject to modifications without notice.

Optional Accessories



AUTO GEAR



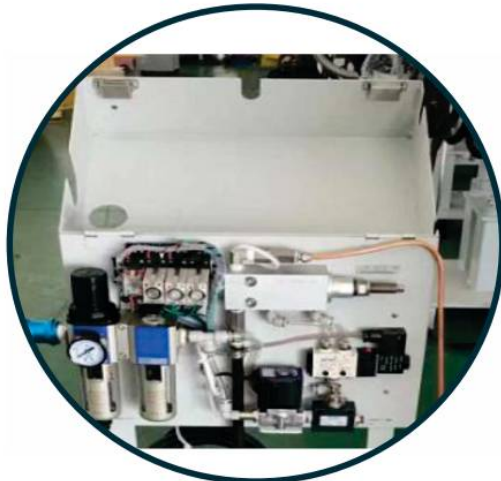
AUTO LADDLE



AUTO SPRAY



AUTO EXTRACTOR



PLUNGER LUBRICATION

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