

**SUPPLIER:**

Brochot

**EQUIPMENT TYPE:**

Casting Machines.

**ATTACHMENTS:**

- List of available data sheets.
- General Arrangement Drawing No Q2050-SA-010-004



**DETAILS:**

Each casting line consists of:

- Two (2) sets of molten metal transfer systems including metal transfer pumps, metal transfer tubes, lifting tables.
- Two (2) sets of casting conveyors and integrated casting carriages. The casting conveyor also includes ingot moulds, exhaust hoods, mould preheating, mould cooling and mould coating.
- Two (2) sets of ingot Discharge Systems
- One (1) transfer conveyor per casting line connecting the casting conveyors. Ingots from each casting conveyor discharge onto a common cooling conveyor.
- One (1) cooling conveyor. Ingots are cooled by water separated directly onto each ingot.

**BASIC DATA:**

The following data is the basis for the design of the equipment. The six (6) casting lines are identical (except for length) and capable of the following performance:

	<i>Pure Magnesium</i>	<i>Alloy Magnesium</i>	
Number of casting lines	2	4	
Ingot weight	8, 10, 12 and 23 kg	8, 10, 12 kg in the same ingot moulds	
Number of ingot moulds	122 (23 kg)	135	
Spacing of Ingot moulds	330 mm	220 mm	
Speed of chain (m/min)	8 kg 10 kg 12 kg 23 kg	- - - 0.877	1.237 1.100 0.978 -
Ingots per minute	8 kg 10 kg 12 kg 23 kg	- - - 2.58	5.62 5.00 4.44 -
Production Capacity	4 tonnes/hour for 10 kg ingots		
Metal Feed Temperature	650°C +/- 20°		
Ingot Temperature	350°C at casting conveyor outlet		