

SPK-WC CENTRIFUGAL CASTING MACHINE



Centrifugal Casting Machine Company, Inc.

The world leader in centrifugal casting and permanent mold technology

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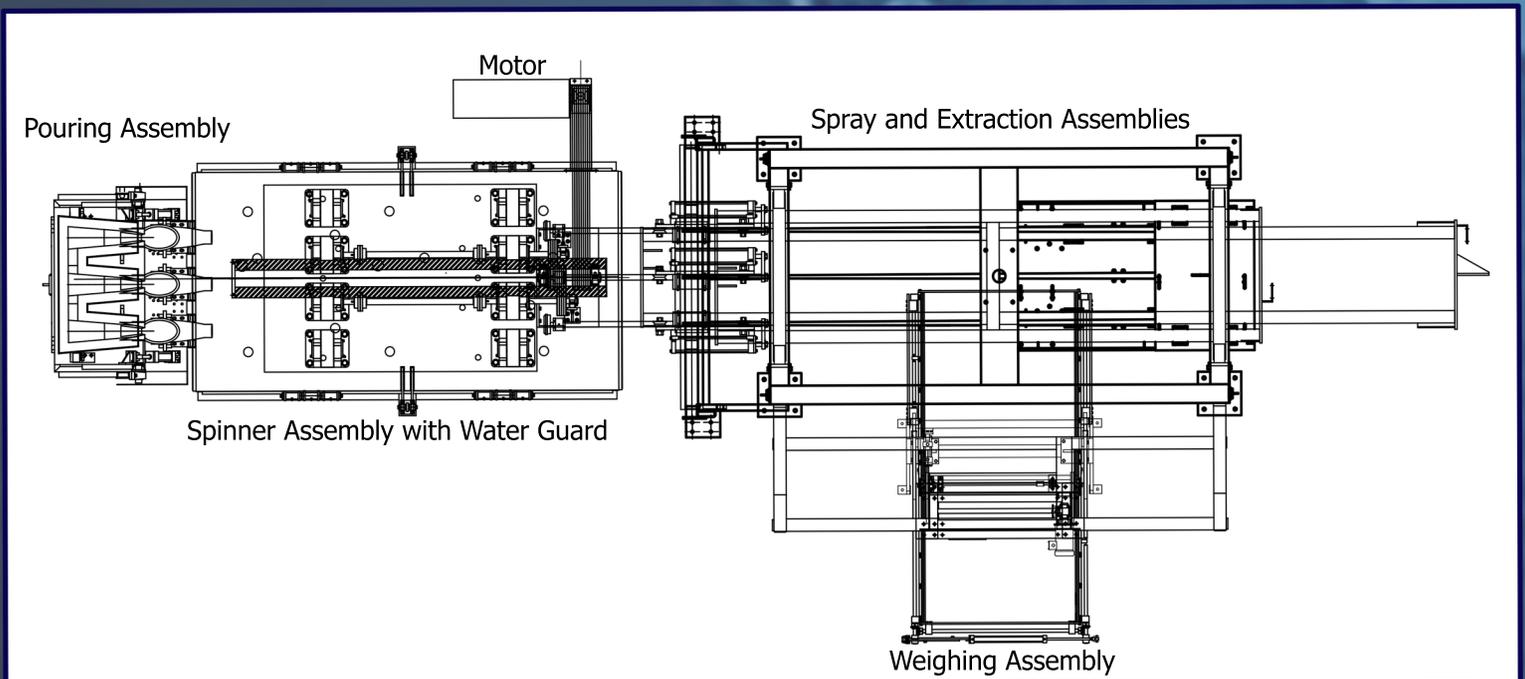
SPK-WC CENTRIFUGAL CASTING MACHINES

The Model SPK-WC Horizontal Soil Pipe Casting Machine is designed to accommodate permanent steel molds to product standard pipe at the low side of the diameter tolerance. This permits the molds to be rebored at least once and still produce pipe within the specifications for the same pipe size. The pipe has a gray cast iron structure "as cast" and does NOT require annealing. Normal metal analyses are used.

TYPICAL FLOOR SPACE REQUIREMENTS

Pipe Length	Area Width	Area Length	Floor Space	Concrete Cu Yards
1 Meter	10 feet	30 feet	300 Sq. Feet	15
1.5 Meters	10 feet	33 feet	330 Sq. Feet	20
6 Feet	10 feet	38 feet	380 Sq. Feet	23
2 Meters	10 feet	38 feet	380 Sq. Feet	23
10 Feet	10 feet	50 feet	500 Sq. Feet	32

NOTE: Above for single mold operation, dual mold operation available.



SPK Pipe Machine Operation

Molds are preheated before operation with Heating system. After operator starts the cycle, the Lance Cart moves forward to spray mold wash into the molds. When the lances have fully coated the molds, the Lance Cart will move back out of the mold and the Core is placed for production. Pouring Car will move towards Spinner after being loaded with metal to be poured into the molds. Since the system is fully automated, the Pouring Car will reverse automatically when metal is poured.

When the molds have spun the appropriate amount of time, Water Cooling System will automatically turn on during the Mold Spin Cycle. When Spinner stops, Cores are automatically removed and moved out of position so the pipe can be extracted.

Extraction Cart will move into place and remove pipe which will be supported by automatic arms that are extended simultaneously as the Extractor is moving in reverse. This pipe will then be pulled by the machine's Rake System onto the Ejector and Weighing System which will weigh the pipe and determine proper weight is achieved. Pipe is then ready to be removed to finishing line of the foundry.

SPK SERVICES REQUIRED

Machine Model	Motor HP	Gas/LPG		Compressed Air		Water		Estimated Production Rate
		.4-.6 PSI	.034 ATM	80-100 PSI	6 ATM	40-50 PSI	2.7 ATM	
		CFM	CCS	CFM	CCS	GPM	LS	
SPK-WC-5A	15	3	1400	20	9400	165	11	30-45
SPK-WC-6A	20	4	14	20	9400	165	11	30-45
SPK-WC-2MA	25	5	2400	250	11800	220	14	30-45
SPK-WC-10A	25	6	2800	30	14200	310	20	25-40

NOTE: Other sizes available for both "bell end" and "no-hub" soil pipe production.



Standard Features

- Electronically controlled variable speed drive
- Brake and torque control
- Remote speed control
- Operator's control console
- Automatic spray and puller car
- Automatic pouring
- Hydraulic traverse for spray and extract
- Automatic mold water cooling
- Sample drum of premixed centrifugal mold coating

Technology and Services

(Supplied as Required)

- Centrifugal Casting "Works" Manual
- Operational parameters for specific customer applications
- Mold wash formulations
- 12 month equipment warranty
- Machine startup and/or field training



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