

Automatic metaldosing systems

For accurate, fast and reliable metal feeding
to pressure and gravity casting machines



Pomac Automation

Ladler

These Pomac automatic ladlers are simple and robust built. The unique linkage system combined with highly efficient AC- servo drives offers an optimal arm and dipper movement, in this way providing the most accurate and fastest ladling and dosing possibilities.

The units fit to all types of die casting machines and shot weights can vary from 50 grams up to a maximum of 20 kg for model 305 and from 2 kg up to 50 kg for model 306.

The units are supplied with maximum programmable stroke lengths of 1842, 2094 or 2194 mm for model 305 and 2000, 2500 or 3000 mm for model 306.

Model 305



- Fast
- Space saving
- Shotweights from 50 gram up to 20 kg
- For diecasting machines up to 10000 kN closing force
- Special options for brasscasting available

Fast, accurate and smooth

Min cycle time:

model 305: 9 sec.

model 306: 19 sec.

Accuracy 0.5%

The units have also standard the possibility of automatic shot weight correction, during auto cycle; when outputs of a D.C.M. are available for this. **With this system it is possible to be even more accurate (0.1%).**

All units offer the following benefits:

- Fully programmable (no adjustments of limit switches)
- Straightforward simple programming
- Special programmable pouring contour to avoid turbulence
- Sensor wiring checking every cycle
- Direct pour in shot hole
- 2 axes movement at same time
- Free standing on own heavy-duty pedestal
- Large draw down in furnace
- Common for both sides of DCM

Model 306

The solution for the bigger Diecasting machine



- Strong
- Reliable
- Shotweights up to 50 kg

Linear or Rotating Dosing Devices
Based upon the standard models 305 or 306

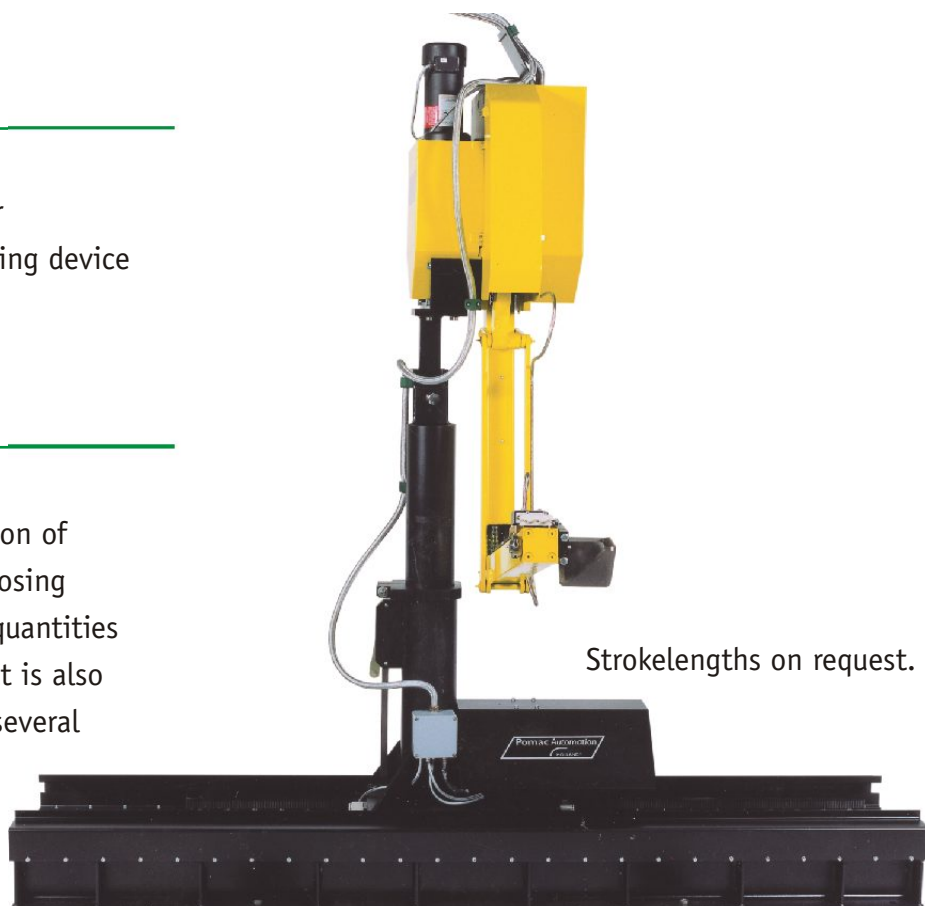
Concept

Automatic feeding of 2 or more gravity, or sandmolds with one linear or rotating dosing device from one or more holding furnaces.

Mode of Operation

Each casting station is fed after notification of readiness. The sequence is at will. The dosing device is freely adjustable with different quantities to filling holes within it's working area. It is also possible to "pour in portions", pour into several filling holes from a single spoon charge.

Linear Dosing Device



Strokelengths on request.

Rotating Dosing Device



Rotation max. 300 degrees

The Controls

Reliable Siemens S7 control in combination with digital AC servo drives in wall mounted cabinet with own cooling.

Programming

- From keypad with a 4 line lighted text display or as option graphic touch panel, mounted in the operator panel.
- Programming in easy to understand menu structure.
- Teach mode is standard
- Die memory
- Own diagnostic



Technical data

Panel

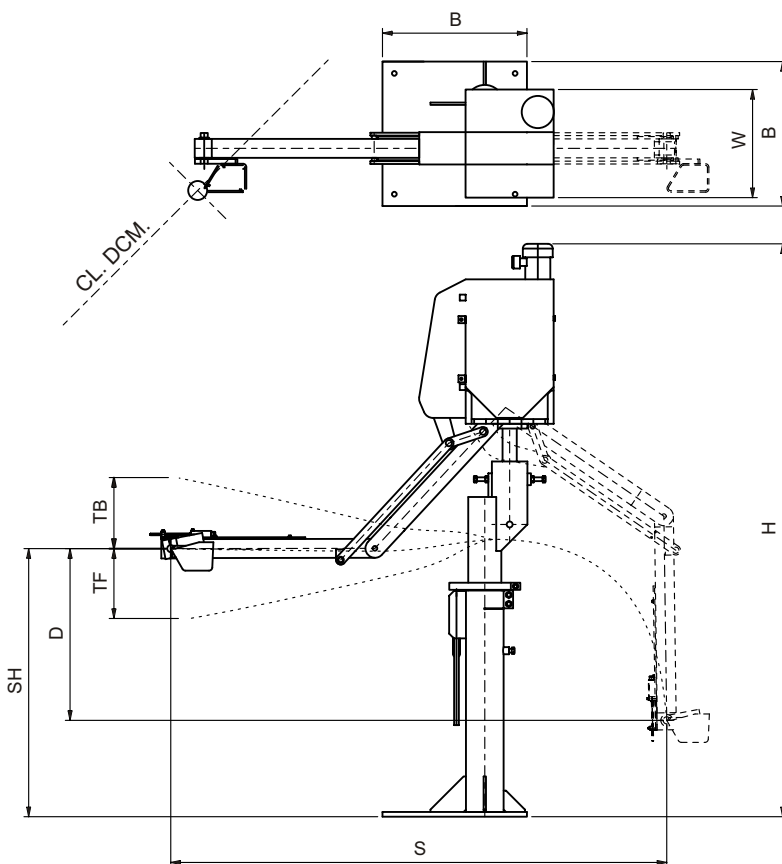
Model 305: Abm. 760 x 760 x 300 mm wall mounted

Power connection

Model 305: 230V single phase 16 Amp.

Dimensions

	base width	depth	height	stroke	shot height	tilt forw	tilt backww	width
	B	D	H	S	SH	TF	TB	W
Model 305 KK	610	642	2420	1842	1263 - 2768	261	263	457
Model 305 MM	610	725	bis	2094	1337 - 2842	295	300	457
Model 305 ML	610	825	3925	2194	1337 - 2842	316	322	457
Model 306 KK	1000	935	4010	2000	2410 - 3160	154	307	910
Model 306 MM	1000	1130	bis	2500	2230 - 2980	192	388	910
Modell 306 ML	1000	1365	4760	3000	2075 - 2825	231	470	910



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