

## Core machines Z84 series - for middle size and large cores

## Cold Box Amin

The machines have been developed by SUZHU for production of middle size and large cores, with shooting head volume between 25 litre up to 160 litre and using Cold Box Amin technology.

The machines are easily operated in automatic mode and are widely used for core production at automotive foundries, for passenger and diesel engine blocks, for construction machine and waggon castings and others.



### no foundation pit underneath the machine

The design of Z84 core machines allows work without foundation pit underneath the machine. The machine table is not lifting up; instead, the shooting head is moving down.

### easy and free access

All the important parts for maintenance (hydraulic cylinders, pneumatic valves and electric control parts) are easy and freely accessible. The shooting head is indexing to filling position with free access for easy sand cleaning.

### continuous 24-hour work

The machine frame is extra strong and the machines are suited for continuous 24-hour work.

### horizontal and vertical core boxes of solid execution in steel or lighter

The Z84 machines use horizontally parted core boxes. The use of vertically parted core boxes is possible with special clamping system. The shooting is single or multiple per cycle.

The strong design allows use of solid steel core boxes as well as lighter core boxes from aluminium, plastic, wood.

### full automatic work

The Z84 machines work full automatic with sand shooting and gas injection, core removal ejection.

### additions

The Z84 machines may be equipped on customer request with automatic core box cleaning, automatic core box parting agent injection, fast pattern exchange etc.

## Technical characteristic of Cold Box core machines Z8425 to Z84160

Parameter	Model /Unit	25	40	65	80	160
Shooting head volume	liter	25	40	65	80	160
Maximum external size of core box	mm	750×600×420	1190×1080×900	1300×1000×800	1400×1200×800	2200×800×800
Shooting area size	mm	700×600	1000×800	1100×900	1200×1000	2000×760
Blowing area size	mm	700×600	1000×800	1100×900	1180×980	1980×720
Stroke of upwards core ejection cylinder	mm	25	25	35	35	115
Stroke of downwards core ejection cylinder	mm	150	250	250	260	300
Maximum clamping force of core box	KN	120	150	200	300	500
Maximum upwards core ejection force	KN	50	50	80	80	120
Maximum downwards core ejection force	KN	50	50	80	80	200
Oil pressure	MPa	10~12.5	10~12.5	10~12.5	10~12.5	10~12.5
Supercharge oil pressure	MPa	16	16	16	16	16
Compressed air pressure	MPa	0.5~0.6	0.5~0.6	0.5~0.6	0.5~0.6	0.5~0.6
Electrical power connection	KW	27	35	35	35	57
Productivity*, up to	cycles /h	45	45	45	45	40
Machine weight	tons	≈18	≈20	≈22	≈24	≈27

\* Productivity is a maximal number shown and is not guaranteed. It is dependent of the real used time for core removal (manually or by robot) and other manual works, as well as time selected by the customer for sand shooting, gassing and degassing of core.