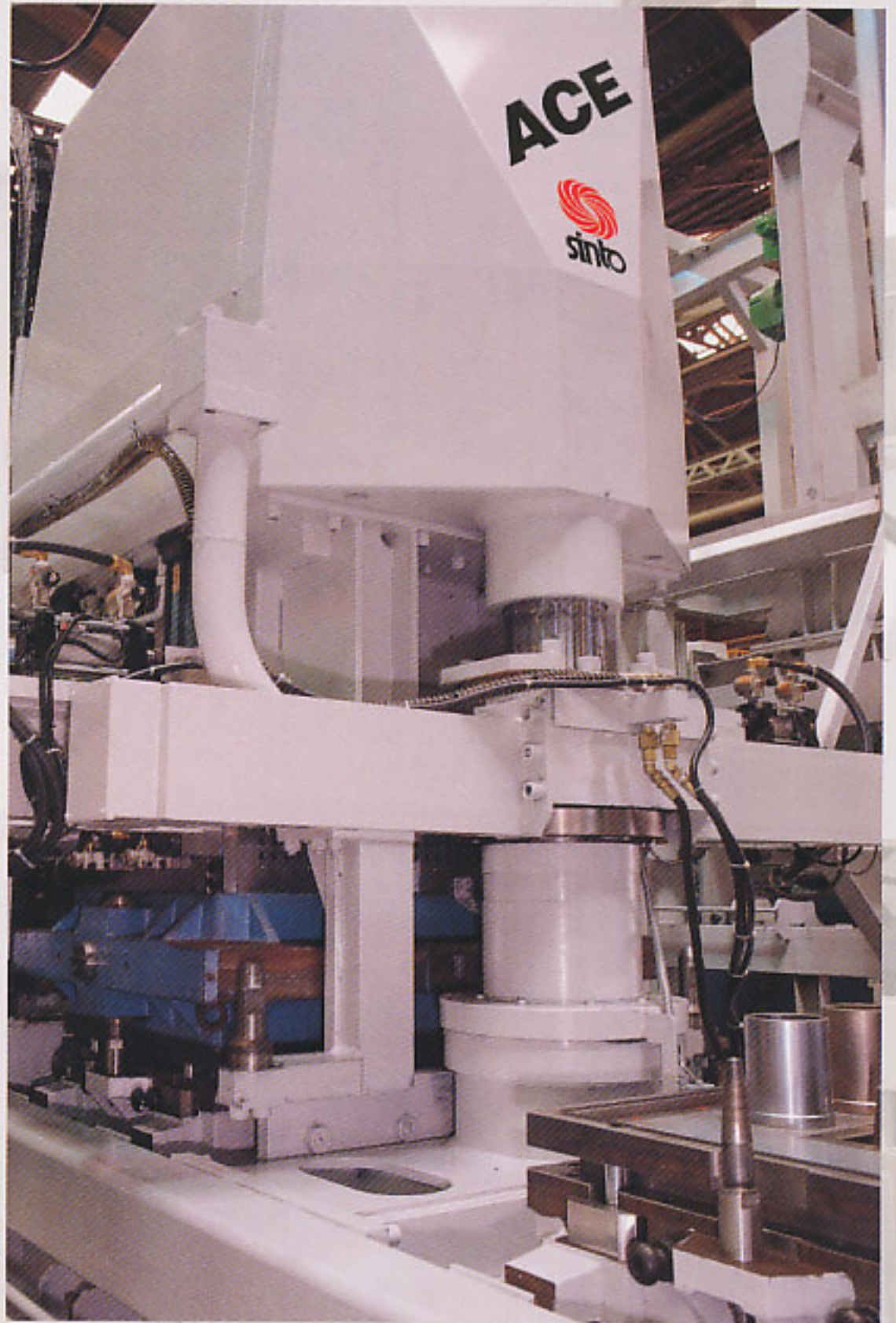


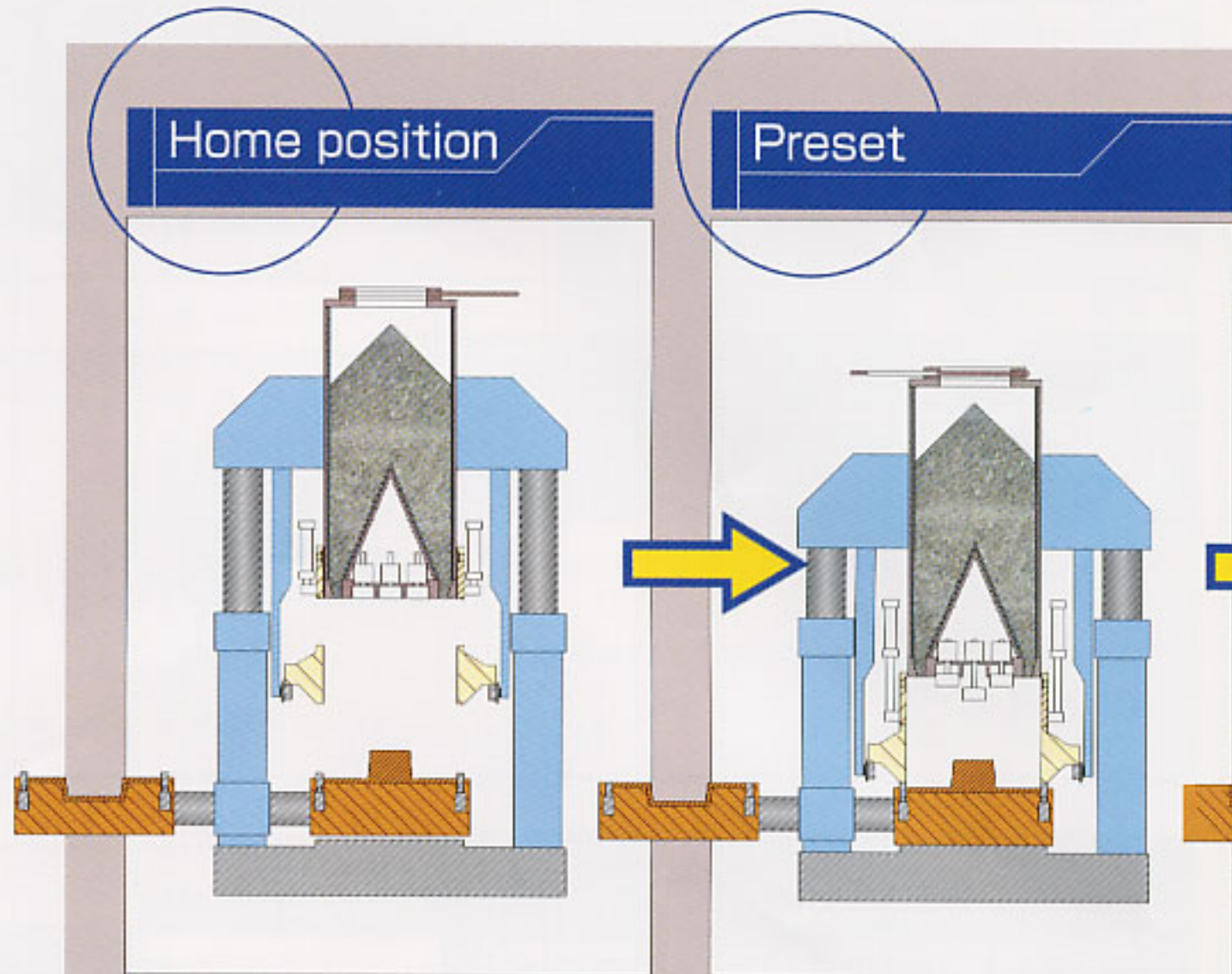
CASTING TECHNOLOGY

Seiatsu Molding Machine
ACE Series



The technology that brings forth many advantages of ACE.

Molding operation is performed under the optimum conditions matching to the shape of pattern.



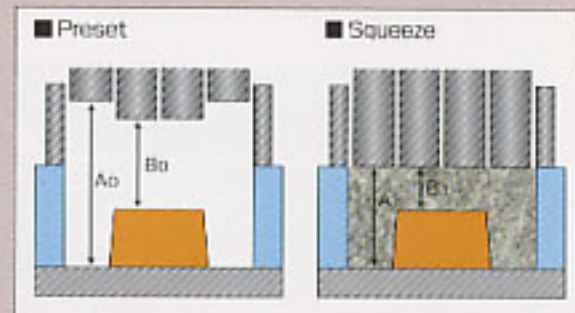
Compact design with a single work station

Sand filling unit and squeezing unit of the machine are combined as one-piece construction to realize the compactness and rigidity, making ACE well durable for high speed molding.



Uniform squeeze becomes possible by Preset process

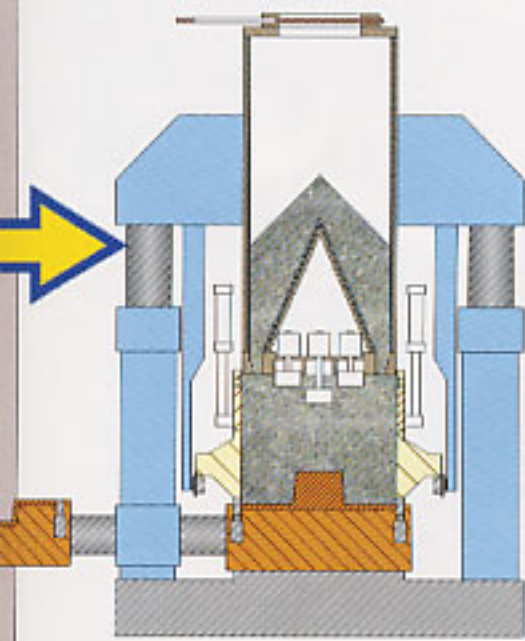
It is possible to preset the arrangement of segment cylinders in accordance with the configuration of pattern to obtain a uniform compaction ratio of sand in a mold, and therefore, the mold strength distribution after squeezing becomes uniform.



Registration of molding mode for each pattern

Each molding mode such as function of segment cylinders, aerating pressure, squeeze pressure, etc. is possible to preset and register on the touch screen panel.

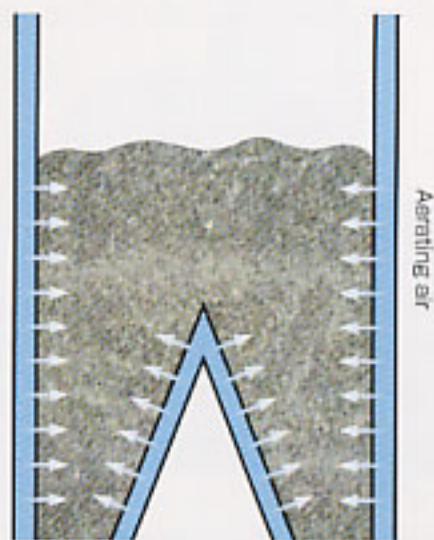
Aeration-Sand filling



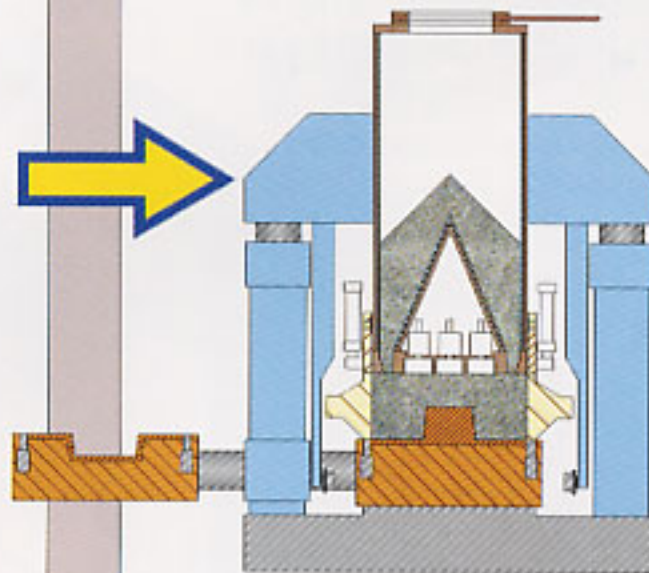
Fluidizing the sand during filling

As the green sand in sand tank is fluidized by aerating air during the sand filling operation, it is possible to fill the deep and narrow pockets of pattern with sand thoroughly.

■ Aeration



Squeeze

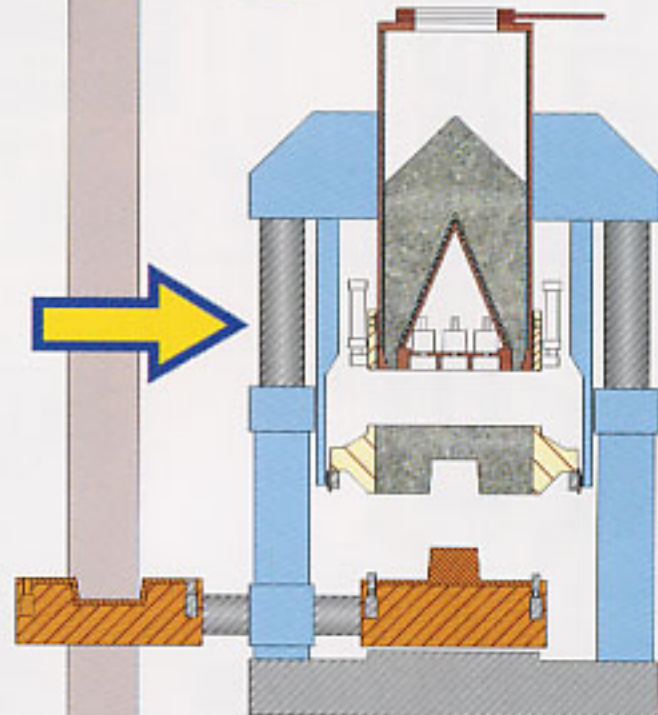


Height of mold is controlled by "Feed back" system

Hydraulic power cylinders of large diameter which serve commonly as the column of the machine, are possible to develop three steps of output-low, medium and high pressure, and a delicate feed back control of sand filling during aerating process is performed to keep the height of flat back surface of mold after segmented squeeze operation slightly higher than the brim of flask. Thus, the excess sand to be cut off by sand cutter is remarkably reduced.

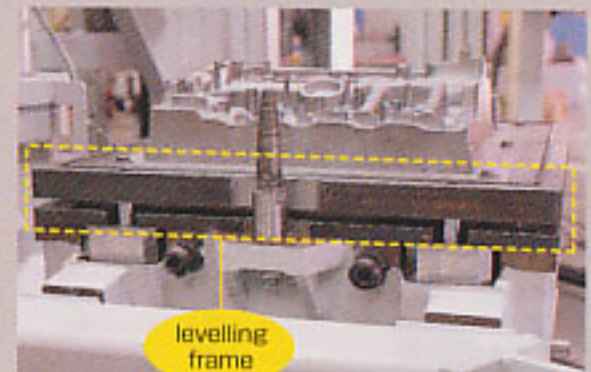


Stripping

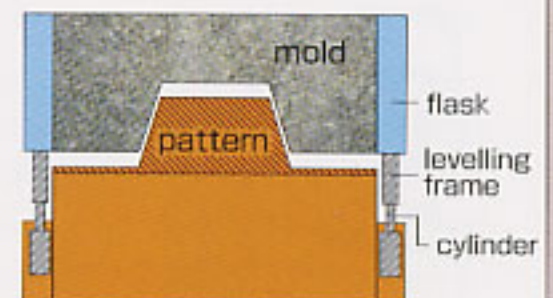


Superior mold stripping property by adopting the levelling frame

Mold stripping of extra-precision is a common practise for ACE as the mold is lifted up with a delicately slow speed keeping a perfect level by means of a levelling frame mechanism.



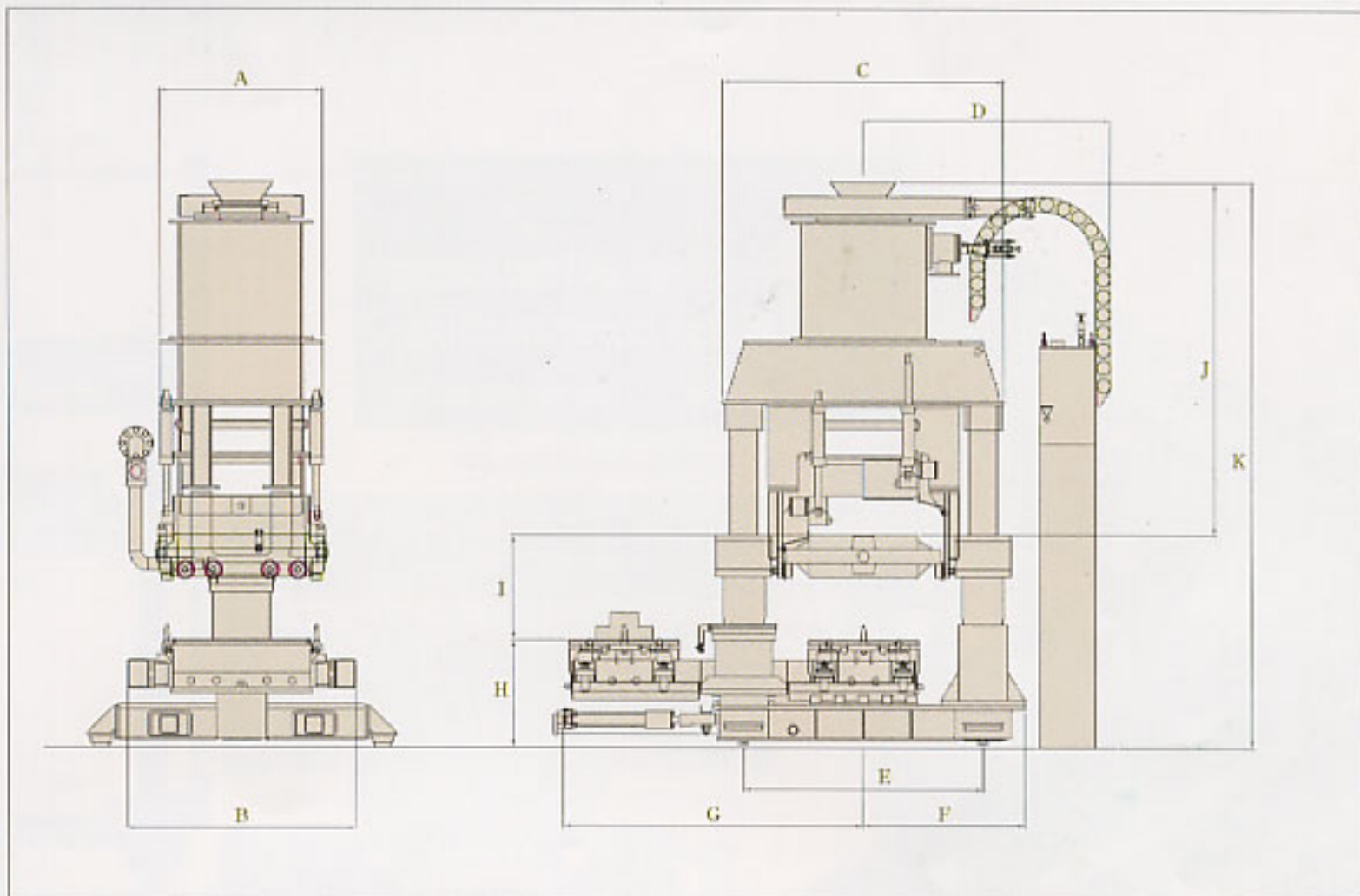
■ Levelling mechanism



ACE



Machine size



Model		ACE-3	ACE-4	ACE-5
dimension (mm)	A	950	1100	1300
	B	1400	1600	1800
	C	1750	1850	2050
	D	1650	1700	1800
	E	1450	1550	1750
	F	1050	1100	1200
	G	1250	1300	1400
	H	800	900	900
	I	700	800	800
	J	2100	2300	2300
	K	3600	4000	4000

Specifications

Model		ACE-3	ACE-4	ACE-5
Molding Speed(m/hr)	Alternate molding	150	150	150
	Simultaneous molding	300	300	300
Mold width(mm)		500~550	600~650	700~800
Mold length(mm)		600~700	750~850	900~1000
Mold height(mm)		150~250	200~300	200~300
Aeration pressure(MPa)		~0.2	~0.2	~0.2
Squeeze pressure(MPa)		~1.0	~1.0	~1.0



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