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Green Sand Molding Machine

Foundry Vertical Flaskless Sand Casting Molding Machine for Manhole Cover



Foundry Vertical Flaskless Sand Casting Molding Machine for Manhole cover : Vertical parting, no sand box, full automatic, continuous high speed, sand shot pre-compacting, hydraulic compaction forming, suitable for large-scale production of coreless coreless small and medium castings in various

Foundry Vertical Flaskless Sand Casting Molding Machine for Manhole cover : Vertical parting, no sand box, full automatic, continuous high speed, sand shot pre-compacting, hydraulic compaction forming, suitable for large-scale production of coreless coreless small and medium castings in various industries.

- The new generation of molding machine has the functions of front and back surface compaction and automatic cavity adjustment.
- Within the defined scope of use, various technical parameters of the machine can be adjusted and set on the computer screen.
- The molding line is controlled by microcomputer, using PLC, position sensor element, pressure sensor element, LCD screen and other imported advanced components to realize the automatic and stable operation of the process and the dynamic input / output animation monitoring, fault query and alarm functions

Type	Size of sand mold(mm)	Productivity(mold/h)	Hardness of sand mold(N/cm2)	Total power
Z417	700*535*(120~250)	220~350	≥85	20
Z418	800*600*(120~250)	220~350	≥85	54
Z4110	1000*1000*(120~250)	220~350	≥85	70

Hydraulic Green Sand Molding Machine



ZD Hydraulic green sand molding machine belongs to a semi-automatic molding machine. Is through a number of hydraulic cylinder thrust compaction sand sand in the sand box, so that the sand get uniform uniform strength requirements

ZD Hydraulic green sand molding machine belongs to a semi-automatic molding machine. Is through a number of hydraulic cylinder thrust compaction sand sand in the sand box, so that the sand get uniform uniform strength requirements, the use of jacking rod jacking sand box, to achieve the effect of the mold. This equipment is generally used in pairs. One machine is used for loading and the other machine is used for unloading. The hydraulic system adopts double pump control. When the contact is rapidly extended, the two pumps supply oil at the same time, and the high pressure pump is used for oil supply in real time.

Features/Equipment characteristics

- *Suitable for produce bigger size pieces
- *Hydraulic working method is better than pneumatic

Model	ZD1009	ZD1210	ZD1310	ZD1407
Sand flask inner size(mm)	900*800	1200*1000	1300*1000	1400*750
Worktable size(mm)	1100*900	1450*1070	1550*1170	1650*900
Compaction pressure(kg/cm ²)	10	10	10	10
Working method	Hydraulic			

We can design and produce different sizes according to customers' requirement.

We manufacture and design full scope of green sand casting equipment. including Green Sand Mixer, Sand Feeder and Conveyor, Sand Moulding machine and Sand Reclamation Machine. We also design custom production line of green sand casting production.

Horizontal Automatic Green Sand Molding Machine



Horizontal automatic green sand molding machine is for automatic mass production of small and medium green sand castings.

Horizontal automatic green sand molding machine is for automatic mass production of small and medium green sand castings. Especially for casting weight is below 50kg and without sand core or simple core. Such as machinery parts, auto and motorcycle parts, valves, bearings, cylinder head, flywheel housing and brake caliper, but also pipe fitting, shaft and cover, like T joint, elbow and clampetc . More competitive for those products require inner sand core

Advantages of horizontal automatic green sand molding machine:

*Horizontal parting convenient to put down core :The mode of horizontal parting can convenience of put down core, especially for core complex artifacts, solved more disk artifacts problem of uneven weight distribution of vertical parting, which adapt to a wider range.

*Mold hardness: Using continuous position detection device instead of stroke switch, can make the mold hardness according to the requirements of different casting simple free adjustment, only need to adjust several parameters to complete, very convenient and quickly. Mold hardness can top 85-85 degrees.

*Can make use of the existing template, save investment:

Existing double template only four screws, 5 minutes completed not only save investment and adapt to the frequent replacement of the model work.

*Closed mold accuracy:Modeling and fitting are carried out in the formwork and sand box system with high precision guide column positioning, and no longer rely on the box pin sleeve. High repeat positioning accuracy greatly improved, reduce the error box rate.

Parameter	XGA-01	XGA-02
Sand Mould Size (LxWxH)	500x400x(120~150)	610x508x(130~180)
Mould Way	Injection and Compaction	Injection and Compaction
Power Mode	Hydraulic pressure	Hydraulic pressure
Max productivity	40s/mould(Excluding core setting time)	40s/mould(Excluding core setting time)

High Performance Automatic Matchplate Molding Machines

Green Sand Automatic Foundry Casting Horizontal Parting Flaskless Molding Machine -This is an automatic molding machine to replace traditional manual hand molding method. It has compact structure and high safety performance, easy to operate, cover small floor space and make low noise.



High Performance Automatic Matchplate Molding Machines

Our Automatic Matchplate Molding Machines are designed to deliver consistent mold quality, high production speeds, and maintenance friendly features help keep your investment running smooth. The innovative design includes these unique features:

1. Heavy duty six piece frame utilizing heavy duty fully accessible guide rods with linear bearings
2. Unique cope lift allows a greater variety of pattern plates and improved guidance for the guide rods
3. Unique squeeze head that transfers force into the machine frame, not the hopper car
4. Innovative upper cope mold ejection system reduces cycle times and improves mold stability
5. Centrally located HMI mounted on an articulating arm allowing the operator to work from either side and an open design concept allows ease of access and maintenance
6. Other features include; removable pattern spray storage tank, hardened one-piece rails with yoke rollers, hopper car, fillerator, rotary driven rolover, and board feeder improvements

All of these design features work together to eliminate drag shift and improve casting quality.

Parameter/Model	XGA-Z425	XGA-Z426	XGA-Z427
Sand Mold Dimension (mm)	500*400*120-150 550*450*120-150	610*508*130-180 660*508*130-180	700*600*130-180 600*600*130-180
Productivity (Second/Mould)	36-40	40-45	40-45
Air pressure (Mpa)	0.7-0.9	0.7-0.9	0.7-0.9
Air consumption (m ³ /Min)	1.6	2	2.2
Oil pressure (Mpa)	8.5	10.6	9.2
Total power (Kw)	15	18.5	22
Sand consumption (T/h)	8.6-12	10.5-17	12-22

MOULDING MACHINE JOLT SQUEEZ



Micro-vibration sand molding machine foundry/Squeeze jolt moulding machine,designed according to cope and drag. 40-60 molds / hour

SPECIAL FEATURES MOULDING MACHINE JOLT SQUEEZ

- 1.Sturdy construction
- 2.Simultaneous jolt squeeze for high mould strength
- 3.Engineered for easy maintenance Centralised auto lubrication during each cycle
- 4.Feather touch push buttons for controls
- 5.Hard chrome plated guide rods and lifting rods
- 6.Gradual lifting and simultaneous vibration for improved separation of the mould from the pattern
- 7.Automatic operation - Complete pneumatic or electropneumatic controls

Model		Z143W	Z145W	Z146W	Z148W
Sand flask Maximum size	Unit	500*400*140	500*450*200	600*500*200	800*630*300
Worktable size	mm	600*420	600*460	700*560	900*800
Shock load	mm	200	300	400	600
Compacting force	kgf	4200	5500	7500	10000
Compacting distance	kgf	140	160	160	220
Drawing distance	mm	160	200	200	280
Air consumption	mm	0.25	0.4	0.4	0.5
Working air pressure		0.55			
Productivity		40-60 box/h			

Automatic Sand Molding Machine



Automatic flaskless horizontal parting type green sand molding machine don't need flask.it's an improved version of sand molding machine,Patterns are moved to the middle and two half iron molds will close.Green sands are injected into molds and hydraulic power of two half molds will compact the sand molds.

Automatic Sand Molding Machine Description

The XGA Automatic Molding Machine is designed as the first step from switching from manual molding to automatic molding without compromising quality. This compact design allows a foundry to replace their existing manual molding line within one day. The design of the XGA Automatic Sand Molding Machine does not require a pit. The XGA automatic molding machine installation is a simple process of connecting to a 110-volt power supply and system air pressure of 80- psi. The XGA molding machine utilizes an Air over Oil compressed air system instead of the traditional hydraulic system. The Air over Oil system allows the XGA's Automatic Sand molding machine cylinders to generate smooth, hesitation free and consistent movement without the use of hydraulic system and pump. Aeration technology is the key design that allows for exceptional molds making. Patterns that have deep pockets and minimal draft become less challenging with Aeration technology.

AUTOMATIC MOLDING MACHINE FEATURES:

1. Accommodates any dimension pattern
- 2.Average Maximum Mold rate of 90 molds/hour
- 3.Ideal for switching from manual molding to automatic molding
- 4.Aeration Sand Filling Technology for producing high quality castings
- 5.Ready to use by connecting power, compressed air, and sand supply
- 6.Low Noise and Energy
- 7.Replace multiple jolt squeezers!

AIR OVER OIL OPERATION

When the air valve is shifted, air flows down one airline to the air/oil tank that line is connected to.

The compressed air first fills the empty space in the top of the air / oil pressure tank, and then, as air pressure builds, exerts force on the oil in that tank.

That oil then flows through the line to the cylinder port, causing the cylinder rod or carriage to extend or retract depending on which port it flows to.

The flow controls, one installed on each of the cylinder lines, will operate by restricting the flow of oil out of the cylinder, thereby dampening the flow of the oil resulting in a smooth, consistent stroking of the cylinder rod.

When the air valve is shifted in the other direction, the air flows down the other valve line to the other air / oil tank, and the cycle repeats.

Each time the valve shifts, the oil being driven into the cylinder from one tank pushes the cylinder piston towards the other end of the cylinder, and that piston drives the oil on the other side back up the line to the other air / oil tank.

A properly installed air over oil system as described will provide the cylinder stroke speed and consistency that you desire for your application.

Technical parameter	XGA-01	XGA-02	XGA-03
Sand Mould Dimension (LxWxH)	500x400x(120~150)	610x508x(130~180)	700*600*(130*180)
Moulding method	Injection and Compaction	Injection and Compaction	Injection and compaction
Compaction specific pressure	~1.0Mpa	~1.0Mpa	1.0Mpa
Power Mode	Hydraulic pressure	Hydraulic pressure	Hydraulic pressure
Max productivity	40s/mould(Excluding core setting time)	40s/mould(Excluding core setting time)	40s/mold (excluding core setting time)

Z1410 Sand Molding Machine For Casting Manhole Cover



Z1410 Micro-vibration sand molding machine foundry/Squeeze jolt moulding machine,designed according to cope and drag. 20-30 molds / hour

Z1410 Sand Molding Machine for Casting Manhole Cover

Z1410 sand molding machine for casting manhole cover with worktable dimension 1400*1030mm is suitable for large casting Parts production.

The worktable fall and collide with floating shock-iron, and the sand was tighted slightly, and then to compaction, get the top and bottom of sand mould are tight. The slightly shock is high frequency (500-1000 times/min), small amplitude (5-25 mm) vibration instead of low frequency (60-120 times/min), the large amplitude vibration. This kind of moulding machine made of sand mold are good quality, the basic requirement is also lower.

Z1410 Sand Molding Machine for Casting Manhole Cover

China Foundry Sand Casting Flask Jolt Squeeze Moulding Machine for Manhole Cover

Cost effective sand molding machine of small ,medium and large castings: eg. manhole cover, manhole grid, plumbing pipe fitting, valves, pumps, brake pads, automobile parts, etc.

SPECIFICATIONS of China Foundry Sand Casting Flask Jolt Squeeze Moulding Machine for Manhole Cover

Qingdao Bestech Machinery Co.,Ltd is a leading company in designing,manufacturing and selling foundry machines and sand production line projects etc.

Bestech provides total solutions for customers and focus on improving efficiency and maximizing price-performance cost ratio of products. Bestech has its own R&D team,innovation and quality are two very critical factors to meet customer demand and create higher value for customer.

Products included steel plate shot blasting machine, H beam shot blasting machine, hook shot blasting machine, tumble belt shot blasting machine etc.;resin sand processing line,clay sand processing line etc., all using CAD and 3D computer-aided design, high production technology. Bestech, your ideal one-station foundry business supplier!

Technical Details:

Model	Z1410
Worktable dimension	1400*1030mm
Molding stripping Stroke	350mm
Compaction Stroke	300mm
Compacting force	19900kgf
productivity	20-30 mold/hour

1400*1030 Sand Moulding Machine For Foundry



Z1410 Micro-vibration sand molding machine foundry/Squeeze jolt moulding machine,designed according to cope and drag. 20-30 molds / hour

1400*1030 Sand Moulding Machine for Foundry

Advantages of 1400*1030 Sand Moulding Machine for Foundry

1. Pneumatic components, long service life and convenient operation, effectively improves production efficiency.
2. Optimized structure design. The square box frame structure greatly improves the rigidity of machine body.
3. Micro vibration compaction process can greatly improve compaction strength and surface roughness to stabilize product quality. The hardness of sand molding can reach above HB90.
4. The shock part is equipped with a buffer spring to effectively reduce the impact of the machine on the foundation.
5. The pattern stripping mechanism adopts the cylinder, the crank, the connecting rod and the synchronous shaft to realize the synchronous lifting.
6. Fully adopt pneumatic parts to achieve overall function of the control part, easy operation and convenient maintenance.

Technical Details:

Model	Z1410
Worktable dimension	1400*1030mm
Molding stripping Stroke	350mm
Compaction Stroke	300mm
Compacting force	19900kgf
productivity	20-30 mold/hour

Z1410 Large Worktable Sand Molding Machine



Z1410 Micro-vibration sand molding machine foundry/Squeeze jolt moulding machine,designed according to cope and drag. 20-30 molds / hour

Z1410 Large Worktable Sand Moulding Machine Work principle

The worktable fall and collide with floating shock-iron,and the sand was tighted slightly, and then to compaction,get the top and bottom of sand mould are tight. The slightly shock is high frequency

(500-1000 times/min), small amplitude (5-25 mm) vibration instead of low frequency (60-120 times/min), the large amplitude vibration. This kind of moulding machine made of sand mold are good quality, the basic requirement is also lower.

Z1410 Large Worktable Sand Moulding Machine Feature

- 1.Z1410 Jolt Squeeze Moulding Machine Noise Controlled
- 2.Z1410 Jolt Squeeze Moulding Machine Combined Jolt Squeeze
- 3.Z1410 Jolt Squeeze Moulding Machine Accurate Centreline Draw
- 4.Z1410 Jolt Squeeze Moulding Machine Variable Jolt Timers
- 5.Z1410 Jolt Squeeze Moulding Machine Operational Roller on Pin Lift Draw
- 6.Z1410 Jolt Squeeze Moulding Machine Operational Safety Guards

Technical Details:

Model	Z1410
Worktable dimension	1400*1030mm
Molding stripping Stroke	350mm
Compaction Stroke	300mm
Compacting force	19900kgf
productivity	20-30 mold/hour

Multi Ram Hydraulic Sand Molding Machine



hydraulic multi-contact molding machine belongs to a semi-automatic molding machine. It is through a number of hydraulic cylinder thrust compaction sand in the sand box, so that the sand get uniform strength requirements, the use of jacking rod jacking sand box, to achieve the effect of the mold.

Hydraulic Pressure Multi Ram Sand Molding Machine

hydraulic multi ram molding machine belongs to a semi-automatic molding machine. It is through a number of hydraulic cylinder thrust compaction sand in the sand box, so that the sand get uniform strength requirements, the use of jacking rod jacking sand box, to achieve the effect of the mold. This equipment is generally used in pairs. One machine is used for loading and the other machine is used for unloading. The hydraulic system adopts double pump control. When the contact is rapidly extended, the two pumps supply oil at the same time, and the high pressure pump is used for oil supply in real time.

2.1 Main structure of the equipment

The main structure of the equipment adopts 18-25mm iron plate welded structure, and the internal stress of the welding is removed by heat treatment, and then processed by the milling machine and bolted to form a one-piece structure. The upper part of the fuselage is equipped with a contact and a traveling mechanism, and the lower part is connected with a micro-shock cylinder and a flat shaft for pulling the mold, and all the air lines and control elements are fixedly installed in the whole body. A well-designed, high-strength, high-precision fuselage structure is the basis for the durability and ease of use of a mechanical device.

2.2 Contact compaction and walking device

As the core functional component of this type of equipment, contact quality, accuracy and stability are the first factors that directly determine the use of the equipment. The pneumatic contacts used by our company are all made of 45# round steel. It is not a universal cylinder purchased from the market. The hydraulic multi-contact is a special hydraulic cylinder. The contact box is welded to the plate, and then the internal stress of the weld is removed by heat treatment, and is processed at one time to ensure the mounting accuracy and structural stability of the contact. In real time, the contacts of different parts are given different pressing strength according to the tightness of the sand type of the pressed part, so that all parts of the sand type can be uniformly compacted.

Contact compaction working principle:

1. After opening the "contact input" switch of the device, the cylinder/hydraulic cylinder pushes the contact walking trolley forward and stops at the top of the workbench. At this point, the center of the contact surface is aligned with the center of the table.

2. Open the "compacting" switch of the device, the contact protrudes, contact the upper surface of the sand and apply pressure to the molding sand in the sand box; at this time, the square box as the contact base slides upward under the reaction force and is fixed in the square. The hooks on the box rise together until the lower surface of the table is hooked, thereby forming the internal force compaction effect of the contact pair sand.

In real time, the fuselage structure is not affected. Continue to a certain compaction time to achieve a satisfactory compaction effect. Or when the microseismic switch is turned on at the same time of compaction, the instantaneous pressure generated can effectively enhance the compaction strength.

Item	Unit	ZD1210
Foundry Flacsk Dimension	mm	1000*800*350
Work table Dimension	mm	1400*1030
Compressive Stress	t	0-100
Moulding Process	mm	300
Compress Process	mm	300
Distance of Compacting Plate to Worktable	mm	750
Productivity	case/per hour	20-40
Outline Dimension	mm	3430*2000*3250

Horizontal Flaskless Molding Machine



Green Sand Automatic Foundry Casting Horizontal Parting Flaskless Molding Machine -This is an automatic molding machine to replace traditional manual hand molding method. It has compact structure and high safety performance, easy to operate, cover small floor space and make low noise.

1. Automatic one-button operation, without professional workers, each complete modeling only need to press the start button once (under the core working state), such as the need for the core of the workpiece, the program selection, automatic stop, after the core is completed, press the button to close the mold, the program will be completed automatically.
 - 2, horizontal parting, convenient core.
 3. The equipment uses ordinary pulverized coal sand, clay sand and red sand. The sand used by general molding machine can be used, and the requirements for sand are not high.
 - 4, template installation: eight screws fixed, replacement within five minutes, adapt to frequent replacement of abrasive tools.
 - 5, mold hardness: mold hardness can be freely adjusted according to the requirements of different castings, only need to adjust a few parameters, very convenient and fast, the highest can reach 85-90 degrees.
 - 6, mold height adjustable, save sand mold: the upper and lower compaction plate can be adjusted, resulting in different mold height.
 - 7, combination precision: modeling, combination type are carried out in the template and sandbox system of unified positioning, repeated precision is very high.
 - 8, casting quality constant and uniform: this machine adopts high-precision mechanical positioning system, microcomputer, position detection linkage, the whole molding process automatic control, no human factors interference, so the molding quality is stable, uniform, efficient and reliable.
 - 9, Equipped with safety protection device: advanced light screen protection, to ensure the operator's personal safety.
 - 10, molding speed: about 40 seconds per box, touch screen parameter setting, very convenient.
 - 11, Casting size: 500*400mm, 600*500mm, 620*720mm, 650*650mm, 800*800mm, 1000*1000mm, and other specifications, can be customized according to customer requirements of large specifications models.
 - 12, can be set up automatic production line, can also be used alone;
- The machine can be produced without very complex wiring. Customers can use the original sand mixing machine and then add a conveyor belt to the sand port of the machine to realize automatic production.

Parameter	R400	R508
Sand Mould Size (LxWxH)	500x400x(120~150)	610x508x(130~180)

Mould Way	Injection and Compaction	Injection and Compaction
Compaction specific pressure	~1.0Mpa	~1.0Mpa
Power Mode	Hydraulic pressure	Hydraulic pressure
Max productivity	40s/mould(Excluding core setting time)	40s/mould(Excluding core setting time)

Vertical Flaskless Molding Machine



Vertical parting, no sand box, full automatic, continuous high speed, sand shot pre-compacting, hydraulic compaction forming, suitable for large-scale production of coreless small and medium castings in various industries

Vertical Flaskless Molding Machine Description

With the development of various industries at home and abroad, the demand for castings is increasing, and the accuracy requirements are getting higher and higher, accompanied by the lack of labor resources; traditional modeling methods can no longer meet production requirements. Faced with this situation, our company has developed a new type of vertical split boxless injection molding machine. Including double-sided compaction molding machine, clamping sand synchronous conveyor and belt synchronous cooling conveyor machine.

Characteristics of vertical flaskless molding machine:

The device uses a man-machine dialogue interface. All process and equipment operating parameters can be adjusted within the set applicable range through the touch screen. Touch screen adopts American EUROTHERM.

All the key parts of the hydraulic system adopt imported valves, with reliable performance and high safety.

The hydraulic cylinder adopts high-speed cylinder structure, which can greatly improve the molding efficiency.

Cavity linings are all made of high-hardness wear-resistant materials, with long service life

The imported high-precision displacement sensor can accurately feedback the real-time displacement of the positive and negative pressure plates

Model	Dimension of Sand Mould(mm)	Productivity(Mould/H)	Hardness of Sand Mould(N/CM ²)	Total Power(Kw)
	600*480(120~150)	220-350	≥85	16.5

ZZ416				
ZZ417	700*535(120~150)	220-350	≥85	20
ZZ418	800*600(120~150)	220-350	≥85	54
ZZ4110	1000*1000(120~150)	220-350	≥85	70

Green Sand Casting Molding Machine



Green Sand Casting Molding Machine is economic molding solution for manual and simply automatic clay sand casting production.

Jolt squeeze Green Sand Casting Molding Machine is economic molding solution for manual and simply automatic clay sand casting production. Jolt squeeze molding machine do not need big floor space. And it is flexible to increase molding machines when casting production increasing.

Name	UNIT	Z143W	Z145W	Z146W	Z148W	Z149W
The Max. dimension of Sand Box	mm	400*400*100	450*500*200	500*600*200	630*800*320	900*800*320
Worktable/ Workbench dimension	mm	560*420	600*460	550*700	900*730	1000*820
Compressive stress	kgf	4000	6300	7000	12000	18000
Compress process	mm	100	160	200	180	200
Drawing mould process	mm	160	200	200	320	320

Productivity	mold/h	40-60	40-60	40-60	40-60	40-60
Out line dimension L*W*H	mm	950*680*1280	1200*1000*1693	1380*850*1565	1600*1038*2200	2175x1600x2380

We manufacture and design full scope of green sand casting equipment. including Green Sand Mixer, Sand Feeder and Conveyor, Sand Moulding machine and Sand Reclamation Machine. We also design custom production line of green sand casting production.

Static Pressure Molding Machine horizontal flaskless



Static pressure molding machine is a commonly used green sand molding and compaction process on the automatic molding line, which is considered to be an ideal molding method.

Automatic Horizontal Parting Flaskless Molding Casting Machine

Product Detail description:

XGA Series Green Sand Automatic Foundry Casting Horizontal Parting Flaskless Molding Machine -This is an automatic molding machine to replace traditional manual hand molding method. It has compact structure and high safety performance, easy to operate, cover small floor space and make low noise.

Application:

Widely used in castings, machinery parts, auto and motorcycle parts, valves, bearings, cylinder head, flywheel housing and brake caliper, but also pipe fitting, shaft and cover, like T joint, elbow and clamp etc .

More competitive for those products require inner sand core.

item	XGA-01	XGA-02
sand box inner size	500*400MM	610*508
moulding productivity	40-180	40-180
specific squeeze pressure(kg/cm ²)	6-10	6-10
compressed air(CFM)	<10	<15

Horizontal Flaskless Sand Molding Machine



XGA Series Horizontal Flaskless Sand Molding Machine .This is an automatic molding machine to replace traditional manual hand molding method.

XGA Series Horizontal Flaskless Sand Molding Machine .This is an automatic molding machine to replace traditional manual hand molding method. It has compact structure and high safety performance, easy to operate, cover small floor space and make low noise.

Parameter	XGA-02
Sand Mould Size (LxWxH)	610x508x(130~180)
Mould Way	Injection and Compaction
Compaction specific pressure	~1.0Mpa
Power Mode	Hydraulic pressure
Max productivity	40s/mould(Excluding core setting time)

Jolt Squeeze Sand Molding Machine



Microseismic Jolt Squeeze molding machine is suitable for mass production of small castings. The machine adopts microseismic squeeze mechanism, the squeeze force and compression strength design is relatively large, so it can meet the requirements of simple or complex type without presqueeze.

Sand casting, also known as sand molded casting, is a metal casting process characterized by using sand as the mold material. The term "sand casting" can also refer to an object produced via the sand casting process. Sand castings are produced in specialized factories called foundries. Over 60% of all metal castings are produced via sand casting process.

Molds made of sand are relatively cheap, and sufficiently refractory even for steel foundry use. In addition to the sand, a suitable bonding agent (usually clay) is mixed or occurs with the sand. The mixture is moistened, typically with water, but sometimes with other substances, to develop the strength and plasticity of the clay and to make the aggregate suitable for molding. The sand is typically contained in a system of frames or mold boxes known as a flask. The mold cavities and gate system are created by compacting the sand around models called patterns, by carving directly into the sand, or by 3D printing.

Technical Details:

type	foundry flask max dimension(mm)	worktable dimension(mm)	compressive stress (kgf)	jolting load (kgf)	compression process(mm)	molding process(mm)	diatance compacting plate with worktable(mm)	free air consumption(m ³ /box)	productivity(box/h)	outline dimensions(mm)
Z14 3W	500x400x100	560x420	4000	250	100	160	200-370	0.25	40-60	950x680x1280
Z14 4W	500x400x180	560x465	4200	260	120	150	300-400	0.35	40-60	1050x1100x1410
Z14 5W	600x600x150	610x515	6300	300	160	200	300-450	0.4	40-60	1200x1000x1693
Z14 5W B	550x450x200	600x550	6300	300	200	200	300-450	0.4	40-60	1200x800x1680
Z14 6W	600x500x200	700x550	7000	300	160	200	350-450	0.4	40-60	1380x850x1565
Z14 6W B	650x550x250	700x550	7500	400	200	200	450-600	0.4	40-60	1100x850x1800

Vertical Green Sand Moulding Machine



Vertical parting, no sand box, full automatic, continuous high speed, sand shot pre-compacting, hydraulic compaction forming, suitable for large-scale production of coreless coreless small and medium castings in various industries

Bestech vertical green sand moulding machines set the standard for speed, quality, reliability, cost effective production and work environment. Horizontal moulding technology takes up space and ties up manpower, it is slower and has a higher cost per casting, Bestech vertical moulding offers high-quality, higher-speed casting production together with a modern, safe working environment.

Model	Size of Sand Mould(mm)	Productivity(Mould/H)	Hardness of Sand Mould(N/CM2)	Total Power(Kw)
Z416	600*480(120~150)	220-350	≥85	16.5
Z417	700*535(120~150)	220-350	≥85	20
Z418	800*600(120~150)	220-350	≥85	54
Z4110	1000*1000(120~150)	220-350	≥85	70

Hydraulic Powered Foundry Molding Equipment



Hydraulic powered foundry molding equipment is suitable for mass production of large and medium-sized castings with single-sided single-board shape, which can be built into the box or the lower box.

Hydraulic powered foundry molding equipment is suitable for mass production of large and medium-sized castings with single-sided single-board shape, which can be built into the box or the lower box. The single machine can realize the compaction of the sand type and the function of the top box. The machine is compacted with multiple contacts, which can double the sand compaction. The compaction ability is scientifically calculated and designed, which can effectively meet the requirements of clay sand molding of the corresponding sand box size. It can be used in a single machine or composed of a mechanized assembly line, or it can be used as a semi-automatic line.

Hydraulic powered foundry molding equipment		
Model	ZD1210	ZD1310
Sand flask inner size(mm)	1200*1000	1300*1000
Worktable size(mm)	1450*1070	1550*1170
Working method	Hydraulic	
We can design and produce different sizes according to customers' requirement.		

Hydraulically Driven Sand Molding Machine



This machine can be used for modeling of clay sand in upper and lower boxes in various foundry workshops. It can be used as a single machine or as a mechanized assembly line or as a semi-automatic line.

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Using hydraulic multi-contact compaction, the sand surface is evenly compacted, suitable for the production of larger-sized workpieces. The green sand molding process has no pollution to the environment, the production cost is low, and the economic benefits brought to customers are considerable.

Hydraulically driven sand molding machine		
Model	ZD1009	ZD1210
Sand flask inner size(mm)	900*800	1200*1000
Worktable size(mm)	1200*980	1550*1280
Contact head number (pcs)	36	56
Compaction pressure(kg/cm ²)	10	10
Working method	Hydraulic	
We can design and produce different sizes according to customers' requirement.		

Jolt Squeeze Green Sand Molding Machine



This green sand molding machine consists of a table, a shock piston, a true iron compaction piston, a compaction cylinder, etc.

Jolt squeeze green sand molding machine also called compact table ,it is Z14 Series moulding machine for green sand casting production..

This green sand molding machine consists of a table, a shock piston, a true iron compaction piston, a compaction cylinder, etc.

Jolt Squeeze molding machine is full buffer, high frequency, low amplitude, pneumatic micro-vibration compaction molding machine, Using spring buffer, pneumatic micro-seismic mechanism can reduce the impact of shock on the foundation.

Item No.	Z143W	Z145W	Z146W	Z147W	Z148W	Z149W
working table size (mm)	560X420	600X550	700X550	800X575	900X730	1200X1030
Compressed air consumption	0.25M3	0.4M3	0.4M3	0.4M3	0.6M3	0.6M3

Double Work Station Foundry Molding Machine



This series of models is double-sided compacted. The difference between the double-sided compaction shape and the ordinary shape is only the difference in the mutual movement between the molding sand and the template

This series of models is double-sided compacted. The difference between the double-sided compaction shape and the ordinary shape is only the difference in the mutual movement between the molding sand and the template. Its styling process and process is to place the pre-filled frame between the sand box and the formwork. Adopting the template-type compaction process and the multi-contact compaction mechanism, the template can be moved freely up and down, and the molding sand in the pre-filled frame is pushed and pushed from the sand-type (sand box) parting surface, and the compactness is adopted. It is a parting surface and a high back, while the lower ideal ideal curve distribution achieves a perfect combination of high compaction and good breathability.

Advantage:

- High ability for compaction sand, rigid and dense mould, suitable to manufacture of complex castings.
- Good working condition and labour saving.
- Dimensional stability and better surface roughness.
- Mould plate with high rate of utilization.
- High efficiency of moulding.

item	FM-1	FM-2
sand box size	700*700MM	800*800
moulding productivity	40-80	20-50
specific squeeze pressure(kg/cm ²)	6-10	6-10
power	5.5-15	11-30
compressed air(CFM)	<10	<15

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