



## Die spray equipment AED 1000 LST4

The die spray equipment AED 1000 LST4 was designed for press sizes above 3000 tons locking force. The harsh conditions that prevail in high pressure die casting operations were taken into consideration for the design.

The die spray equipment is available as a 2-axis machine with vertical and horizontal strokes of 2500 / 3000 mm. Other strokes are possible on request.

The S7 control system with Sinamics S120 converter was developed particularly for use in die casting plants. It ensures efficient use and function of the die spray equipment. Alternatively a KUKA Motion Control KMC4 is available. The IO-Link connection to sensors and actuators ensures best possible monitoring of your process.



## Technical design

Feature	Daten	
Drive	Siemens SIMODRIVE three-phase servo motors Nominal torque 27 Nm horizontal and 48 Nm vertical axes and safety holding brake, closed when currentless Protective rating IP 64	
Power transmission	Via pinion/toothed rack for both axes Cyclo gearbox	
Guides	Linear guides with corrosion-resistant coating Guide carriage with scraper on both sides and side seals. The design of the guides guarantees a long service life at maximum stroke.	
Lubrication	Automatic central lubrication for the toothed racks and guide elements of both axes	
Proportional technology (pressure regulation)	Depending on the option chosen, spraying and blow air as well as media pressures programmed manually or steplessly using the control unit. Option: Package 2 or package 3, flow control media / air	
Tank finish (other finishes available on request)	Die spray equipment	RAL 5005 signal blue
	Installation base/service panel	Aluminium parts anodised silver
	Control cabinet	RAL 7038 agate grey RAL 7035 light grey

## Technical data

Feature	Data
Spraying circuits	8 spraying circuits, individually programmable
Blasting circuits	2 blasting circuits, individually programmable
Release agents	4
Horizontal strokes	2500/3000
Vertical strokes	2500/3000
Weight of spraying tool	270kg max.

## Technical data, control unit

Feature	Daten
Control unit	Siemens S7-1500 / alternatively KUKA KMC 4
Converter	Sinamics S120 / alternatively KUKA KMC 4
Speed	0,01 – 1,5 m/s, freely programmable for both axes
Acceleration	3 m/s <sup>2</sup>
Positioning accuracy	< +/- 0,5 mm
Repeat accuracy	< +/- 0,25 mm
DCM interface	Profibus Dispo025, others on request

## Connection data

Feature	Daten
Compressed air	1 x DIN 2353 G 2" D56 NW50
	5 - 8 bar
Air consumption	1500 Nm <sup>3</sup> /h at 6 bar
Release agent	4 x DIN 2353 G ¾" D22 NW20
	4 - 7 bar
Release agent consumption (max.)	80 l/min at 6 bar
Water (rinsing)	1 x DIN 2553 G ½" D15 NW13, 4 bar
Connected load	approx. 15 kVA
Mains voltage	3 x 400V PE +/- 10 %
Mains frequency	50-60 Hz
Ambient temperature	+5°C to 40°C without cooling unit

