



## Die spray equipment DAG1000 MCT1

The die spray equipment DAG1000 MCT1 was designed for press sizes between 400 and 1300 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 strokes 800/1000/1200/1400/1600mm and horizontal strokes 800/1000/1200/1400mm. 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.



## Technical design

Feature	Data
Drive	Siemens SIMODRIVE three-phase servo motors Nominal torque 6 Nm horizontal and 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 blast air as well as media pressures can be programmed manually or steplessly using the control unit. Option: Package 1, package 2 or package 3
Tank finish (other finishes available on request)	Die spray equipment Installation base/service panel Control cabinet
	RAL 5005 signal blue Aluminium parts anodised silver RAL 7038 agate grey RAL 7035 light grey

## Technical data

Feature	Data
Spraying circuits	4 spraying circuits, individually programmable
Blasting circuits	2 blasting circuits, individually programmable
Release agents	2
Horizontal strokes	800/1000/1200/1400
Vertical strokes	800/1000/1200/1400/1600
Weight of spraying tool	max. 40kg

## Technical data, control unit

Feature	Data
Control unit	Siemens S7-300
Converter	Sinamics S120
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	Data
Compressed air	1 x DIN 2553 G 1 1/2" D42 NW38
	5 - 8 bar
Air consumption	500 Nm <sup>3</sup> /h at 6 bar
Release agent	2 x DIN 2553 G 1 1/2" D15 NW13
	4 - 7 bar
Release agent consumption (max.)	30 l/min at 6 bar
Connected load	approx. 5 kVA
Mains voltage	3 x 400V PE +/- 10 %
Mains frequency	50-60 Hz
Ambient temperature	+5°C to 40°C without cooling unit