

TopVac

- one vacuum unit for two dies -



*Vacuum System For
High Pressure Die Casting*

TopVac

Vacuum tank

The vacuum tank is manufactured from hot-dip galvanized steel. The standard volume is 1000 Liter. The tank is approved for a positive pressure up to 4 bar and for vacuum.

Vacuum pump

The rotary piston vacuum pump is commissioned for ambient temperature +0°C to +45°C.

- oil free operation
- minimum maintenance required

Valve unit

All valves are metal diaphragm valves adapted for vacuum

- robust design, non sensitive to highly contaminated media
- minimum maintenance required

Cyclone separator / Fine filter

The filter unit consists of a cyclone separator for solids - gas separation with a high separation efficiency for solids and liquids. A maintenance free operation is possible because there are no drives and wear parts. The separated solids and liquids are discharged at the lower outlet. In front of the vacuum tank is a fine filter with filter cartridge to remove very small particles. With this filter combination a very high efficiency combined with minimum maintenance is achieved.

Control unit

Core of the control unit is a SIMATIC S7-300 SPS with connected visualisation system. With the machine signals "START-VACUUM" and "DIE-OPEN" it is possible to run the vacuum system linked to the casting cell fully automatic.

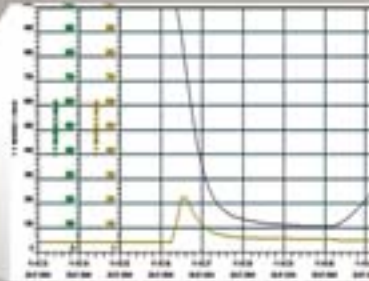
The OP command panel for handling and monitoring the vacuum system can be installed at the control cabinet or at the operation position.

With the visualisation system all relevant process parameters can be indicated and changed (e.g. set value for vacuum, evacuation time).

With a specially developed program it is possible to detect the leak tightness of the die and in the case of exceeding a defined nominal leakage to show a signal and to stop the casting cell.

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Process chart recorder



Control unit
Visualisation system



- 1 - OP command panel
maschine 1/2
- 2 - Valve unit
- 3 - Vacuum tank
- 4 - Cyclone separator
- 5 - Vacuum pump

Technical Data

Length * Width * Height	1850 mm * 1200 mm * 2500 mm	
Weight	~250 kg	
Vacuum tank	1000 Liter	
Vacuum	max. 20 mbar abs.	
Ambient temperatur limit	max. 40 °C	
Electrical connexion	400 V / 3Ph 50 Hz / N / PE // 5 pol. CEE 16A	
Pneumatical connexion	Compressed air dry and oil free 6 bar	
Suction capacity of vacuum pump	At 100 mbar abs.	110 m ³ /h
	At 50 mbar abs.	100 m ³ /h

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Vacuum system for high pressure die casting with leakage detection.

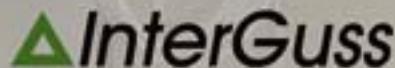
Suitable for two dies or one die with two vacuum valves, optionally up to 4 OptiVent Venting-Blocks can be operated with one vacuum system.

The SPS Siematic S7 control unit of the TopVac is user friendly programmed, that only known machine parameters have to be entered.

Advantages for the user

- Only one TopVac Vacuum unit for two high pressure die casting machines
- Operation of up to 4 OptiVent Venting-Blocks with 1 TopVac
- Valves or other vendors can easily be integrated
- Simultaneous operation of 2 valves on 2 high pressure die casting machines
- Large 1000 Liter vacuum tank as standard
- Display and dynamic storage of pressure progression
- Storage of the graphs on floppy-disk as standard
- Clearly structured control cabinet
- Minimum maintenance required
- Remote maintenance optionally
- Excellent price/performance ratio
- Flexible realisation of customer requirements

For further information:

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