

COMPACTION TABLE FOR THE FURAN SAND PROCESS.



APPLICATION AND FUNCTION:

This compaction table / rollertrack system is installed underneath a 60 tph continuous whirl mixer in a foundry manufacturing the rearend weights for fork lift trucks.

The drive units are frequency inverter controlled. The frequency of the drive units increases automatically (depending on the deck load) until an acceleration of approx. 1 g is reached.

The green device is the compaction table itself; it is placed on four pneumatic rubber pillow cylinders. The yellow device is the stationary rollertrack.

The vibration starts after the vibrating table has lifted the pattern carrier plate approx. 20mm from the rollertrack.

TECHNICAL DATA AND FACT:

Rollertrack:	Width 1000mm, Length 2700mm
Weight:	approx. 3300 kg vibration machine mass
Load :	4000 up to 10000 kg
Pattern carrier:	Wood/Multiplex 60mm, 2000x2700
Drive units:	2 unbalance motors JV 274
Frequency:	Closed loop controlled, 960 - 1450 RPM
Vibration stroke:	1 - 2 mm
Acceleration detector:	J SEN g-Sensor
Control system:	Siemens S7 / OP 270