

DR. FRITSCH

SONDERMASCHINEN

Gravimetric Cold Press KPG 400



Dr. Fritsch Sondermaschinen GmbH, D-70736 Fellbach, Germany

Technical Specification

Gravimetric Cold Press KPG 400

- for compacting
- single-layer diamond segments with/without backing
 - sandwich segments without backing

Essential characteristics

- Short cycle times thanks to an optimized hydraulic system, improved powder transport system and a novel motor-driven segment push-off device.
- Fast change-over and a easy cleaning thanks to a good accessibility
- Easy handling due to a touch screen with symbols only
- Constant powder feeding thanks to intermediate powder hoppers
- Weighing is effected by means of two self-optimizing weighing systems
- Two independent filling funnels in order to avoid that powders with diamond and powders without diamond get mixed.
- Newly developed electromotive system for a reproducible powder transport.
- Robust and precise construction of the press with an improved, faster hydraulic system
- Little space required thanks to the compact machine design
- Possibility to use the dies of the KP 35, CCP 100 and in combination with an adapter also the die of the KPV 218.
- Option: possibility of connecting an automatic stacking magazine for an unmanned production
- Option: IPA NT (PC-connection for quality control, quality documentation and quality analysis)

Operational procedure

The sintering metal powder or rather the metal powder/diamond mixture is filled from two different storage hoppers via a conveying channel in intermediate powder hoppers and from there transported in damping scales by means of a further conveyer channel.

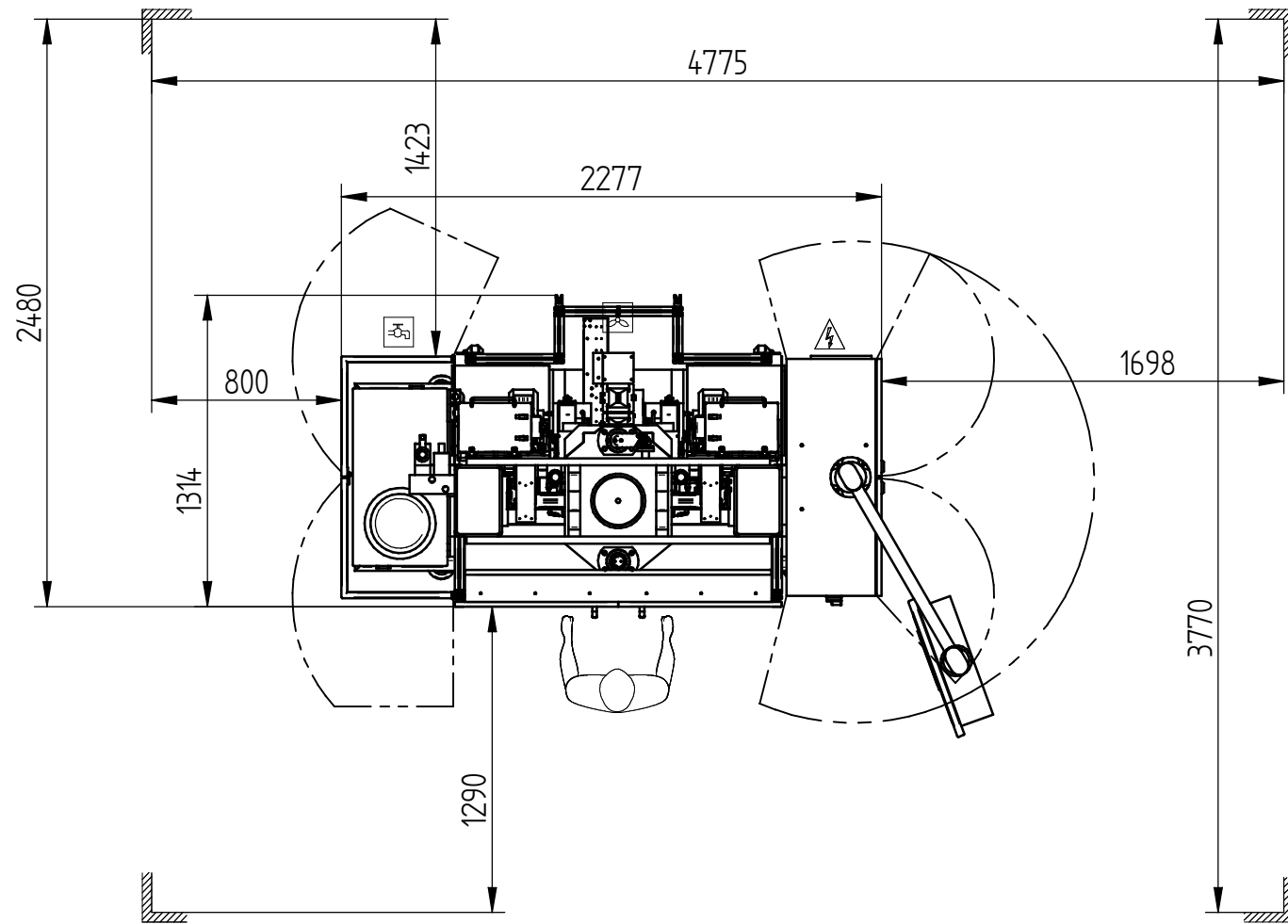
By achieving the specified weight the powder is filled from the transporting scales into the die via separate filling funnels. According to the selected programme it is possible to press single- or multilayer segments.

The segments are ejected by the lower pressing cylinder and transported out of the machine by means of the motor controlled push-off device.

Technical Data:

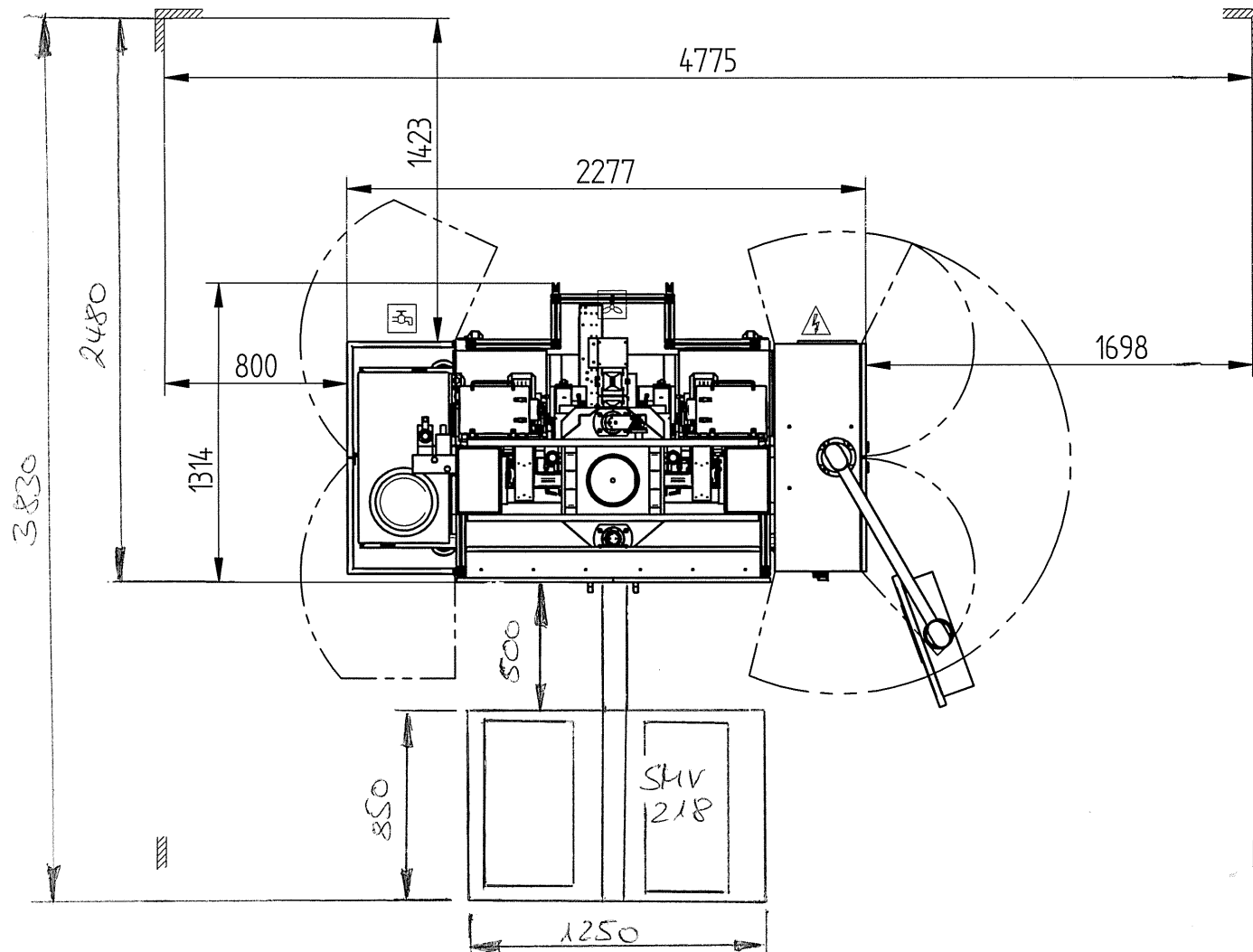
Total electric power:	15 kVA
Supply voltage:	3 x 400 V, 50/60 Hz layout for other voltages possible.
Nominal current:	3 x 20 A
Fuses (to be provided by the customer):	3 x 35 A
Cooling water:	
- pressure:	3 – 5 bar
- consumption:	approx. 35 l/min.
- temperature:	15 – 25 °C
Compressed air:	
- consumption:	approx. 25 l/min
- pressure:	5 bar
Suction:	to be provided by the customer
- connection:	two connecting pieces \varnothing 40 mm
Main press bodies:	2 pieces
- min./max. pressing force:	approx. 10 – 300 kN (option: 20 – 500 kN)
Die-clamping cylinders:	2 pieces
- max. clamping force	approx. 80 kN
Weighing units:	2 pieces
- type:	electronic, self-optimizing
- weighing range:	1 - 100 g
- weight tolerance per weighing:	\pm 0,05 g
Dimensions of machine:	length: approx. 2.250 mm width: approx. 1.250 mm height: approx. 2.250 mm
Weight:	approx. 3000 kg

- Subject to modifications of technical data and design -



max. Maschinenhöhe: 2260 mm
(max. machine height)
erforderliche Raumhöhe: 2600 mm
(required clear height)

Symbol	Bedeutung (meaning)	Symbol	Bedeutung (meaning)	300 cm — —	DFT012121.dft ASM008538.asm	Aufstellplan floor plan
	Elektrik (electrics)		Gas (gas)			
	Pneumatik (pneumatics)		Wand (wall)			
	Kuehlwasser (cooling water)		Arbeiter (operator)			Maschinen Typ : Kaltpresse machine type :
	Absaugung (suction)				DR. FRITSCH Sondermaschinen GmbH D-70722 Fellbach	Zeichnungs Nr.: 2M



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	Kuehlwasser (cooling water)		Arbeiter (operator)	DR. FRITSCH Sondermaschinen GmbH D-70722 Fellbach		
	Absaugung (suction)			300 cm		