

BuhlLadle. Ladling units.

Complete.
Buhler Cell.

Peripheral
equipment.



The fully integrated ladling unit in two sizes

The rugged construction based on a simple design contributes to high uptimes of the casting cell. Height adjustability and simultaneous movement of both axes allow metal ladling into the port of the shot sleeve with pinpoint accuracy.

The large horizontal traveling distance allows a high degree of freedom in placing the unit and additionally offers appreciably better access to the filling port compared with gantry solutions.

High customer benefit is generated by the integration of the control system in the Dat@net of the die casting machine:

- Setup is based on the same operating philosophy, eliminating additional training costs.
- The comprehensive diagnostic solutions of the Dat@net are also available for the ladler.
- The application of absolute encoders eliminates the need for referencing during starts, making the installation ready for operation within a shorter time and therefore reducing costs.
- The servo-technology applied on the one hand allows free programming of speeds and ladle angle, and the excellent position accuracy on the other hand allows very high constant ladling rates, helping minimize the cycle times of the unit.
- The servo-technology selected for all Buhler peripheral equipment is designed to reduce spare parts inventory costs.

At least double the service life of RFM ceramic ladles translates into lower operating costs.

No coating of the ladle is needed, with appreciably lower temperature losses during ladling, both favoring the cast component quality.

BuhlLadle Features

- Liquid aluminum ladling at very constant rates
- Ladling into the shot sleeve with pinpoint accuracy
- Cast steel and durable ceramic ladles available
- Synchronized with the die casting machine



Technical data – BuhlLadle.

Ladling unit – Model 1/12 + Model 2/23.

Technical data	Model 1/12	Model 2/23
Ladling volume/cycle	0.5 – 12 kg (Al)	2 – 23 kg (Al)
Horizontal travel	1825 mm	2250 mm
Bath level descent	770 mm	820 mm
Connected power	3.7 kW	5.0 kW
Dimensions of ladling unit (LWH)	1200 × 664 × 1291 mm	1400 × 640 × 1700 mm
Weight of ladling unit	650 kg	800 kg
Dimensions of control cabinet (LWH)	Dat@net	Dat@net
Height adjustment of casting cell	350 mm	420 mm
Ladling accuracy	+/- 1.5%	+/- 2%

Application of BuhlLadle 1/12

26	34	42	53	66	84	84L	105	105L	120	140	140L	180	180L	220	220L	270	270L	320	320L	420	

Application of BuhlLadle 2/23

26	34	42	53	66	84	84L	105	105L	120	140	140L	180	180L	220	220L	270	270L	320	320L	420	

Suitable

Suitable under certain conditions

Technical design and data subject to change without notice.

Furnace dimensions

Required dimensions of the ladle in mm:

	BuhlLadle 1/12 up to 5 kg	BuhlLadle 1/12 up to 12 kg	BuhlLadle 2/23 up to 12 kg	BuhlLadle 2/23 up to 23 kg
Rectangular ladle, minimum length	495	615	740	795
Minimum width	345	350	380	470
Round ladle, minimum diameter	600	705	830	920
Minimum bath depth	300	300	400	400
Maximum furnace wall thickness	475	475	490	400

Furnace height

The furnace height must be adjusted to the type of installation of the die casting machine, the injection position, and the ladling unit.