

# BuhlSpray. Linear die spray unit.

Complete.  
Buhler Cell.

Peripheral  
equipment.



## **The fully integrated two-axis die spray unit in three versions**

Its rugged construction based on a simple design contributes to achieving a high uptime of the casting cell. Available with tools with up to 8 spray and blow circuits, the unit is highly suited also to very demanding die cavities.

## **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.
- A hand unit with display screen is available for programming. It is applied as a second mobile screen of the Dat@net. It allows the caster to carry out programming and to obtain information anywhere in the cell.
- Proportional control technology allows programming of spray and air pressures in the time sequence of the core spray program.
- The core spray programs can be loaded onto the Dat@net together with the die program.
- The diagnostic options of the Dat@net are available also for the die spray unit.
- The absolute encoders eliminate the need for referencing during starts, making the installation ready for operation within a shorter time and therefore at lower cost.
- Both axes can be moved simultaneously, allowing linear diagonal motions.

The Flextool or Deltacast spray tool from Acheson is a highly proven technical solution and – thanks to its clear design – very resistant to trouble, resulting in increased uptimes.

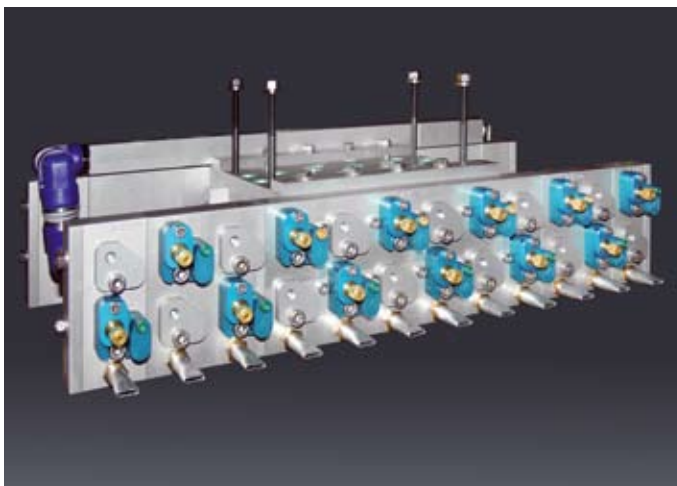
Depending on the field of application, different mixing and tank units can be selected.



### Features of BuHlSpray linear

- Application of two liquid die release agents at controlled rates
- Atomization of the release agent by air using four, six or eight spray and blow circuits
- Cleaning of the die surface using two high-pressure blow circuits
- Cycle time minimizing by high dynamics
- Tracing of the die contour, also diagonally
- Acheson Flextool and Deltacast\* die spray tools can be attached
- Wide selection of mixing and tank units

\*optional



## Technical data – BuHlSpray. Linear die spray unit – model 1M 4/2.

Model 1M 4/2	V1000 H800	V1000 H1000	V1200 H1000	V1400 H1200	V1600 H1400
Vertical stroke	1000 mm	1000 mm	1200 mm	1400 mm	1600 mm
Horizontal stroke	800 mm	1000 mm	1000 mm	1200 mm	1400 mm
Number of spray-blow circuits	4	4	4	4	4
Number of die release agents	2	2	2	2	2
No. of high-pressure blow circuits	2	2	2	2	2
Spray head	Flextool/Deltacast*	Flextool/Deltacast*	Flextool/Deltacast*	Flextool/Deltacast*	Flextool/Deltacast*
Drive type	AC-Servo	AC-Servo	AC-Servo	AC-Servo	AC-Servo
Connected power	8 kW	8 kW	8 kW	8 kW	8 kW
Dimensions of sprayer (LWH)	1780 × 1060 × 1987 mm	1980 × 1060 × 1987 mm	1980 × 1060 × 2188 mm	2180 × 1060 × 2387 mm	2380 × 1060 × 2587 mm
Weight of die spray unit	650 kg	650 kg	650 kg	700 kg	700 kg

\* optional

### Application of BuHlSpray 1M 4/2 – linear

Model	26	34	42	53	66	84	84L	90	90L	105	105L
1M 4/2 V1000 H800											
1M 4/2 V1000 H1000											
1M 4/2 V1200 H1000											
1M 4/2 V1400 H1200											
1M 4/2 V1600 H1400											

Suitable

Suitable under certain conditions

Technical design and data subject to change without notice.

# Technical data – BuhlSpray.

## Linear die spray unit – model 2M 6/2.

Model 2M 6/2	V1200 H1200	V1400 H1200	V1600 H1200	V1600 H1600
Vertical stroke	1200 mm	1400 mm	1600 mm	1600 mm
Horizontal stroke	1200 mm	1200 mm	1200 mm	1600 mm
Number of spray-blow circuits	6	6	6	6
Number of die release agents	2	2	2	2
No. of high-pressure blow circuits	2	2	2	2
Spray head	Flextool/Deltacast*	Flextool/Deltacast*	Flextool/Deltacast*	Flextool/Deltacast*
Drive type	AC-Servo	AC-Servo	AC-Servo	AC-Servo
Connected power	11 kW	11 kW	11 kW	11 kW
Dimensions of sprayer (LWH)	2284 × 1332 × 2400 mm	2284 × 1332 × 2600 mm	2284 × 1332 × 2800 mm	2684 × 1332 × 2800 mm
Weight of die spray unit	1050 kg	1050 kg	1050 kg	1100 kg

Model 2M 6/2	V1800 H1800	V2000 H1600	V2000 H1800	V2000 H2000
Vertical stroke	1800 mm	2000 mm	2000 mm	2000 mm
Horizontal stroke	1800 mm	1600 mm	1800 mm	2000 mm
Number of spray-blow circuits	6	6	6	6
Number of die release agents	2	2	2	2
No. of high-pressure blow circuits	2	2	2	2
Spray head	Flextool/Deltacast*	Flextool/Deltacast*	Flextool/Deltacast*	Flextool/Deltacast*
Drive type	AC-Servo	AC-Servo	AC-Servo	AC-Servo
Connected power	11 kW	11 kW	11 kW	11 kW
Dimensions of sprayer (LWH)	2884 × 1332 × 3000 mm	2684 × 1332 × 3200 mm	2884 × 1332 × 3200 mm	3084 × 1332 × 3200 mm
Weight of die spray unit	1100 kg	1150 kg	1150 kg	1150 kg

\* optional

### Application of BuhlSpray 2M 6/2 – linear

Model	66	84	84L	90	90L	105	105L	130	130L	140	140L	160	160L	180	180L	200	200L	220	220L
2M 6/2 V1200 H1200	■																		
2M 6/2 V1400 H1200	■	■	■	■	■														
2M 6/2 V1600 H1200	■	■	■	■	■														
2M 6/2 V1600 H1600						■	■	■	■	■	■								
2M 6/2 V1800 H1800						■	■	■	■	■	■	■	■	■	■	■	■	■	■
2M 6/2 V2000 H1600						■	■	■	■	■	■	■	■	■	■	■			
2M 6/2 V2000 H1800								■	■	■	■	■	■	■	■	■	■	■	■
2M 6/2 V2000 H2000												■	■	■	■	■	■	■	■

■ Suitable    ■ Suitable under certain conditions

Technical design and data subject to change without notice.

# Technical data – BuhlSpray.

## Linear die spray unit – model 3M 8/4.

Model 3M 8/4	V1800 H1600	V2000 H1600	V2000 H2000	V2500 H2000
Vertical stroke	1800 mm	2000 mm	2000 mm	2500 mm
Horizontal stroke	1600 mm	1600 mm	2000 mm	2000 mm
Number of spray-blow circuits	8	8	8	8
Number of die release agents	4	4	4	4
No. of high-pressure blow circuits	2	2	2	2
Spray head	Flextool/Deltacast*	Flextool/Deltacast*	Flextool/Deltacast*	Flextool/Deltacast*
Drive type	AC-Servo	AC-Servo	AC-Servo	AC-Servo
Connected power	22 kW	22 kW	22 kW	22 kW
Dimensions of sprayer (LWH)	2968 × 1350 × 3233 mm	2968 × 1350 × 3433 mm	3368 × 1350 × 3433 mm	3368 × 1350 × 3933 mm
Weight of die spray unit	1700 kg	1750 kg	1800 kg	1800 kg

Model 3M 8/4	V2500 H2500	VT2000 H1600	VT2500 H2000	VT2500 H2500
Vertical stroke	2500 mm	2000 mm	2500 mm	2500 mm
Horizontal stroke	2500 mm	1600 mm	2000 mm	2500 mm
Number of spray-blow circuits	8	8	8	8
Number of die release agents	4	4	4	4
No. of high-pressure blow circuits	2	2	2	2
Spray head	Flextool/Deltacast*	Flextool/Deltacast*	Flextool/Deltacast*	Flextool/Deltacast*
Drive type	AC-Servo	AC-Servo	AC-Servo	AC-Servo
Connected power	22 kW	22 kW	22 kW	22 kW
Dimensions of sprayer (LWH)	3868 × 1350 × 3933 mm	2968 × 1350 × 3433 mm	3368 × 1350 × 3933 mm	3868 × 1350 × 3933 mm
Weight of die spray unit	1850 kg	1750 kg	1800 kg	1850 kg

\* optional

### Application of BuhlSpray 3M 8/4 – linear

Model	105	105L	130	130L	140	140L	160	160L	180	180L	200	200L	220	220L	250	250L	280	280L	320	320L	350	350L	400	440	
3M 8/4 V1800 H1600	■	■	■	■	■	■	■	■	■	■															
3M 8/4 V2000 H1600							■	■	■	■															
3M 8/4 V2000 H2000							■	■	■	■	■	■	■	■											
3M 8/4 V2500 H2000											■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
3M 8/4 V2500 H2500																									
3M 8/4 VT2000 H1600							■	■	■	■															
3M 8/4 VT2500 H2000											■	■	■	■	■	■	■	■	■	■	■	■	■	■	■
3M 8/4 VT2500 H2500																									

■ Suitable      ■ Suitable under certain conditions

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