

BuhlEx. Extractors.

Complete.
Buhler Cell.

Peripheral
equipment.



The fully integrated, simple extractor in two sizes.

This rugged version with its simple design contributes to maximizing casting cell uptime. With its adjustable overall height for installation and its servo-technology, it allows high-accuracy gripping of die cast components.

Also of very high benefit to customers is the integration of the control system in the dat@net of the die casting machine:

- Set-up is therefore based on the same operating philosophy, eliminating additional training expenses. Programming of the movements is through the humanmachine interface.
- The extensive diagnostics options are also available for the BuhlEx.
- The absolute stroke encoders eliminate the need for any referencing during starting; as a result, the system is up and running again within a shorter period of time after production changes, i.e. ready for operation again at lower cost.
- The servo-technology allows free programming of the velocities, helping minimize cycle times.
- The waiting position is freely programmable and supplements the three basic control programs.
- Gripping of the die cast component, transverse travel, and swiveling are effected pneumatically and allow positioned depositing.
- The servo-technology, which is the same in all Buhl-pe-ripherals, aims at lowering the cost of keeping spare parts.

A casting detector can be added to the basic equipment, provided with up to eight sensors.

BuhlEx device features

- Positioned depositing of die cast components
- Short extraction times
- Installation possible on operator or rear side of the die casting machine
- Three fixed control programs, with and without transverse travel



Technical data – BuhlEx. Extractor – Models 1 + 2.

| Technical data | BuhlEx 1 | BuhlEx 2 |
|---|------------------|------------------|
| Number of axes | 3 | 3 |
| Extraction weight (gripper and casting) kg | 3 | 6 |
| Extraction weight at reduced speed (gripper and casting) kg | 6 | 15 |
| Maximum range of action (mm) | 1260 | 1725 |
| Drive | Electropneumatic | Electropneumatic |
| Dimensions exclusive of gripper and casting | | |
| Length (mm) | 1060 | 1170 |
| Width (mm) | 1000 | 1300 |
| Height (mm) | 1270 – 1720 | 1830 – 2280 |
| Weight (kg) | 650 | 730 |

The control system is integrated and incorporated in the control panel of the die casting machine.

Applicability BuhlEx 1

| | | | | | | | | | | | |
|----|----|----|----|----|----|-----|-----|------|-----|-----|------|
| 26 | 34 | 42 | 53 | 66 | 84 | 84L | 105 | 105L | 120 | 140 | 140L |
| | | | | | | | | | | | |

Applicability BuhlEx 2

| | | | | | | | | | | | |
|----|----|----|----|----|----|-----|-----|------|-----|-----|------|
| 26 | 34 | 42 | 53 | 66 | 84 | 84L | 105 | 105L | 120 | 140 | 140L |
| | | | | | | | | | | | |

Suitable

Suitable under certain conditions

Technical design and data subject to change without notice.

Program steps of the three selectable pro-

| Program 1 | Program 2 | Program 3 |
|--|---|--|
| 1. Enter, close gripper 2. Ejector forward and transverse travel relieved – Ejector in forward position – Transverse travel with full power 3. Retract | 1. Enter 2. Transverse travel to casting, close gripper 3. Ejector forward and transverse travel relieved – Ejector in forward position – Transverse travel with full power 4. Retract | 1. Enter, ejector forward, ejector in forward position 2. Transverse travel to casting, close gripper 3. Transverse travel 4. Retract |