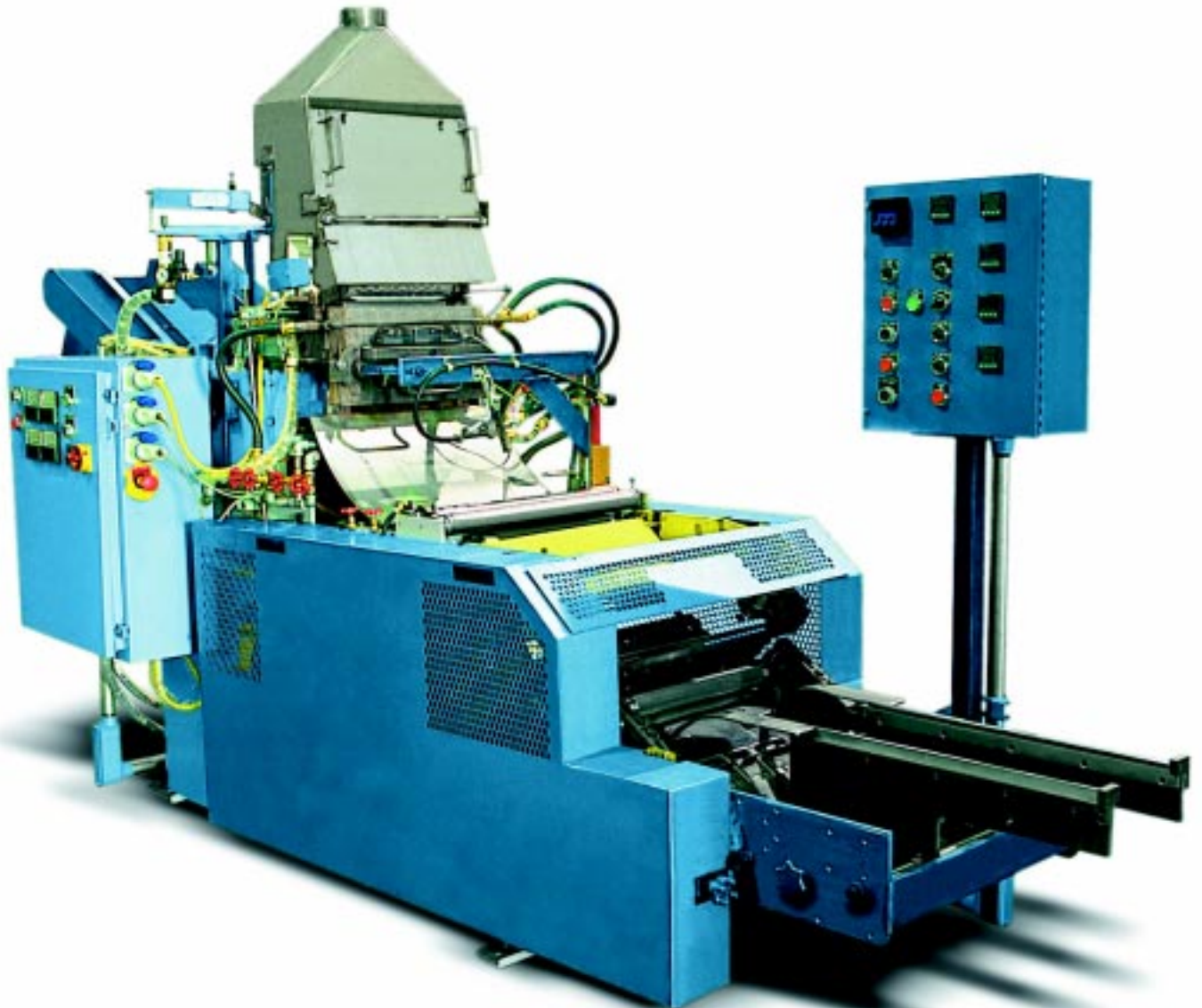




## AUTOMOTIVE GRID CASTING MACHINE MODEL 40/40C

### WIRTZ MODEL 40/40C MECHANICALLY OPERATED GRAVITY GRID CASTING MACHINES.

The Wirtz Model 40/40C are high speed gravity grid casters designed with state of the art technical enhancements. Efficient casting is provided by electric mold heat, greatly improved temperature controls and our non-recirculating lead delivery system (LDS). Electric Mold Heat is applied to both the moveable and stationary halves of the mold by two cartridge heaters. Automatic Indicating Temperature controllers, instead of indicators alone, monitor the temperature settings of the mold, ladle and feedline. Any fluctuation in these temperatures are automatically corrected. An indicating read-out is used in the mold gate area. The lead delivery system (LDS) has been drastically improved because the LDS does away with the return lead trough. This system flows from the lead furnace to a dispensing valve where an adjustable amount of lead is allowed to enter the ladle after each pour. As opposed to lead feed systems with a continuous, recirculating flow this method serves to minimize agitation and substantially reduces crossing in the lead furnace.



# AUTOMOTIVE GRID CASTING MACHINE MODEL 40/40C

Model 40 is used to cast lead antimonial alloys while the Model 40C includes temperature controls and a cooling system designed specifically to handle lead alloys with high solidification temperatures such as calcium as well as with lead antimonial alloys.

## Production

Speeds up to 18 casts per minute.  
One operator, (3) machines, up to 35,000 grids per (8) hour shift.

## Grid Size Capacity

Trim Width: 4.250" (108mm) min to 6.375" (161mm) max  
O.A.L. lug to lug: 7.375" (187mm) min to 13.625" (346mm) max  
Thickness: .040" (1.02mm) min to .188" (4.77mm) max

## General Specifications

- Right or left hand installation.
- Variable speed drive, 8 to 18 cycles per minute.
- Motors totally enclosed and fan cooled.
- Main drive motor 3/4 hp.
- Standard electrics 240 volt, 3 phase, 60 hertz.
- "Nema 12" electric control panel with 60 amps disconnect, 110-volt control circuit.
- "Nema 12" electric control console with push button and selector controls, running lights, temperature controllers and lead dispense timer.
- Electric solenoid control of mold and ladle. Mold remains in last (open or closed) position when machine stop button is pressed and ladle tipping linkage is automatically disengaged returning ladle to no pour position regardless of ladle cam position.
- Air filter, regulator and lubricator for air system.
- All internal piping is complete for gas, air and water.
- Swing out mold corking bracket.
- Quick connect air fittings for cork spray gun.
- Separate air regulator and quick connect hose for molds with air flow vent bars.
- Internal trim scrap conveyor.
- Can be arranged in banks of 2, 3, or 4 casters as well as a single caster.
- Includes one standard automotive sized trim die.
- Wirtz patented heavy duty low dross lead pump.

## Options Model 40 Only

- Precision grid ejector system.
- Die entry gate support.
- Die exit rollers.
- Electric mold heaters - double zone
- Air spin assembly.
- Ladle cover and gas shielding for electric ladle.

## Options Model 40 and 40C

- Grid counter.
- Grid inspection table.
- Tool holder.
- Castmaster 2000 automated temperature control and machine speed control.
- Die lube system including a 1 gallon reservoir.
- Machine speed indicator.
- Manifold piping for multiple casters.
- Ammeters to monitor electric heater circuits.
- Electric interlocks to shut down any individual caster in a grouping.
- Grid planish system including hydraulic power supply, one planish type automotive sized trim die and all piping, solenoids, and associated hardware.
- Oversize mold back for producing golf car and scrubber batteries.
- Autofill system for improved castability and quality.

## Utility Requirements

### Cooling Water

Supply Temperature: Max 75 deg F (24 deg C)  
Volume: 60 GPH (225 Liters/Hr)  
Pressure: 80 PSI (5520 m bar) max  
20 PSI (1380 m bar) min

### Air

Volume: Optimum 14 CFM (.4 m Cu/Min)  
Peak 48 CFM (1.4 m Cu/Min)  
Pressure: 100 PSI (6900 m bar) max  
80 PSI (5520 m bar) min

### Fuel

Pressure: 14" WC (350mmWC) max  
5" WC (127mmWC) min  
Natural Gas 1000 BTU/CuFt (8,900 Kcal/M Cu)  
Volume: 25 CFH (.7 M Cu/Hr)  
Propane 2500 BTU/CuFt (22,250 Kcal/M Cu)  
Volume: 10 CFH (.3 M Cu/Hr)

### Ventilation

(Note figure may also be included in the ventilation requirements for the furnace)

Volume: 760 CFM (21.4 M Cu/Hr)

### Electrical

460v, 60hz, 3-phase standard  
200v to 575v, 50hz or 60hz, 3-phase  
available upon request

