

Standard Core Shooters

KLANN core shooters have the following design features:

- short travelling distances to realize short cycle times by moving the machine table front to extract the core box at any level from the machine
- the sand bin, along with the shooting head, is moved sideways by means of a hydraulic cylinder, so that after shooting the bin is guided out of core box range to avoid hardening of the core sand in the shooting channels and the sand cylinder
- height adjustable clamping and stripping device to fix each core boxes at the optimum position to lower burr formation
- complete enclosure with large access doors for lost heat and exhaust air discharge and protection against sand blasting
- high core box clamping forces with exact core box guiding to lower burr formation and resulting rework operations on the core
- use of shooting screen cylinder free process, no cleaning of the screen cylinder is necessary



Core discharge on the machine table front

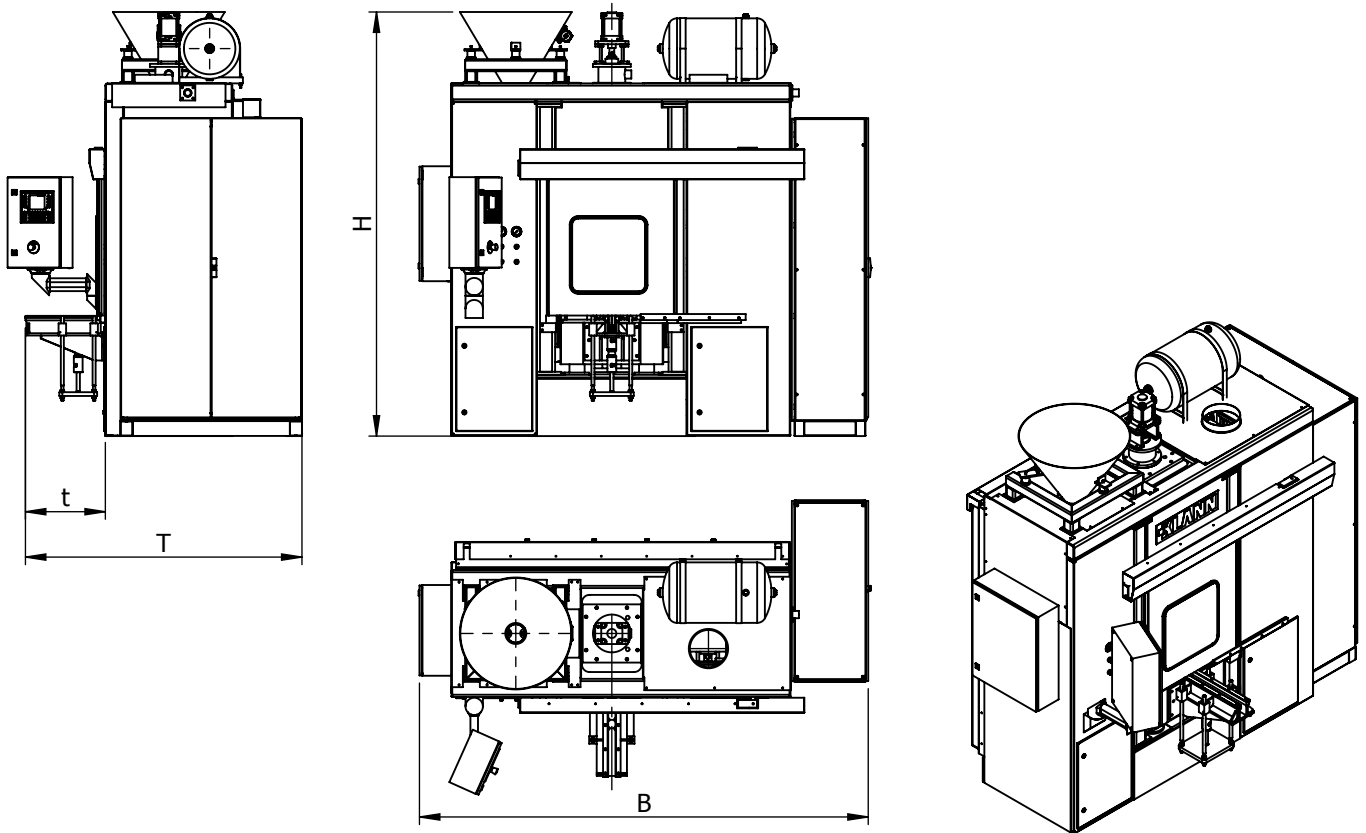
- easy core box change with optional lifting tools
- hydraulic control with proportional valves to lower the core fracture by smooth core boxes opening
- variable filling levels in shooting cylinder to avoid pre-curing of not shot core sand
- compact design with small installation space requirement

KLANN core shooters are designed for 3-shift operation and known for their reliability since decades. The core shooters are available for vertical and/or horizontal core box division. Beside pure Cold-, Hot-Box or CO₂-machines, combination machines, using heating-plates and a gassing head can also be supplied.



Core shooter P12 CB/hydr.-HV

Core Shooters



	Unit	P5 CB/CO ₂ -HV*	P12 CB/CO ₂ -HV*	P25 CB/CO ₂ -HV*	P40 CB/CO ₂ -HV*
shooting volume:	dm ³	5	12	25	40
feed bin volume:	dm ³	60	60	120	250
shooting pressure, variable:	bar	1 - 6	1 - 6	1 - 6	1 - 6
compressed air consumption per cycle:	dm ³	20	20	50	80
cycle time, without curring, shooting and aeration time:	Sec.	12	12	16	20
clamping strokes:					
machine table – shooting head (Y):	mm	550 - 190	550 - 190	715 - 295	750 - 250
in between clamping jaw (X):	mm	510 - 110	510 - 110	740 - 180	880 - 250
pressure forces:					
clamping claws:	N	13,000	23,500	37,000	60,000
machine table:	N	23,500	50,000	94,000	150,000
machine dimensions:					
height (H):	mm	2,500	2,800	3,150	3,500
width (B):	mm	2,850	3,350	3,650	4,000
depth (T):	mm	1,560	1,560	1,850	2,500
machine table front (t):	mm	350	350	550	900

* HV: for horizontal and vertical core boxes division