



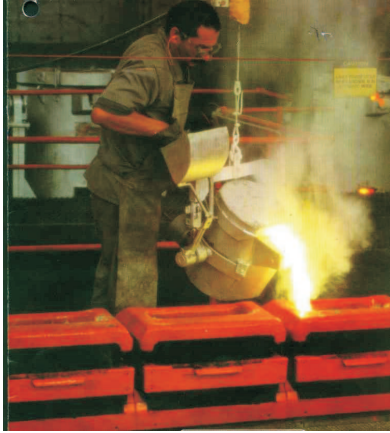
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***LINEAR MOLD
HANDLING
SYSTEMS***

Linear Mold Handling Systems



HLH Type I

The Type I Linear Mold Handling System offers a single row pouring line with cooling times of up to 30 minutes.

HLH Type II

The Type II Linear Mold Handling System offers double rows combining pouring and cooling lines with cooling times of up to 45 minutes.

The Type II allows molds without weights and jackets to pass through the system a second time extending cooling times before discharging.

HLH Type III

The Type III Linear Mold Handling System offers three processing rows combining pouring and cooling lines with cooling times of up to 60 minutes.

The Type III permits molds without weights and jackets to pass through the system a second or third time further extending cooling times before discharging shakeouts or conveyors.

HLH Type IV SL

The Type IV SL Linear Mold Handling System offers four processing rows combining pouring and cooling lines with cooling times of up to 60 minutes.

The Type IV permits molds without weights and jackets to pass through the system a second or third time further extending cooling times before discharging shakeouts or conveyors.



Mold Handling Systems

Designed for precision casting and mold processing

Automation providing control

Hunter Automated Machinery Corporation manufactures the very best in mold handling systems providing individual foundries the flexibility to match the system to the equipment, production, and foundry floor requirements. Each Hunter Linear Mold Handling system (HL) provides the necessary control over production pouring and mold cooling for the production of superior castings.

Sequence of Operations

After the mold has been completed, the mold is pushed out of the squeeze station of the molding machine onto an automated mold conveyor where the individual molds are temporarily stored while waiting for the pouring operation. The conveyor system quickly transports the unpoured molds on demand to the pouring line. Each completed mold is gently pushed off the aluminum bottom board used during squeeze station operations onto a graphite-lined cast iron pouring pallet. The bottom board is automatically returned to the molding machine for repeated use.

After the unpoured molds are on the pouring line the weight and jacket are automatically set. First the weight is set followed by the jacket insuring that no mold shift occurs.



After the weight and jacket have been set, the ready molds are gently indexed forward to the pouring zone. At this point molds can be automatically indexed to pour from a single pouring station. Or, the pourer can move up the line to pour from multiple positions.

Once poured, the molds continue to be conveyed while each mold cools under weights and jackets until they reach the end of the pouring line. To extend mold cooling time the mold, with weight and jacket, is lowered and transferred to a bottom level where each mold continues to cool.

As the transfer occurs from the pouring line to the cooling level, molds are indexed under the pouring line in the opposite direction of the pouring line travel. When each mold reaches the end of the cooling line, the pallet and mold are lifted up and the weight and jacket are stripped. The cooled mold is pushed laterally and discharged onto a vibrating pan or shakeout conveyor for continued processing of the finished casting.

The stripped weights and jackets are set on the empty pouring pallet and indexed forward to the mold loading station. The weight and jacket are then automatically lifted and readied for the continuation of the sequence as new unpoured molds are positioned for the pouring line.

Many foundries required additional time for cooling of molds. Hunter provides additional cooling time through the use of multiple cooling lines where necessary.

Mold Storage:

Storage of unpoured molds - High speed automatic accumulating conveyor

Molding machine can continue operating during normal metal delays

Pouring can continue during pattern changes or other brief interruptions

Conveyor length can vary in one mold increments to suit individual requirements

Elevated automatic bottom board return - Unrestricted molding machine access

Pouring Section:



Molds are indexed forward and poured at rest when using single station pouring

The multiple station pouring mode offers maximum speed and flexibility

Faster and more accurate pouring reduces related scrap

Heavy cast iron weights and jackets - Set automatically and precisely

Two levels of cooling under weights and jackets

Additional modules can easily be added for an expanded pouring zone

Cooling Section: (Types II, III, & IV)

Two levels of cooling with up to 3 additional molds per cooling tray

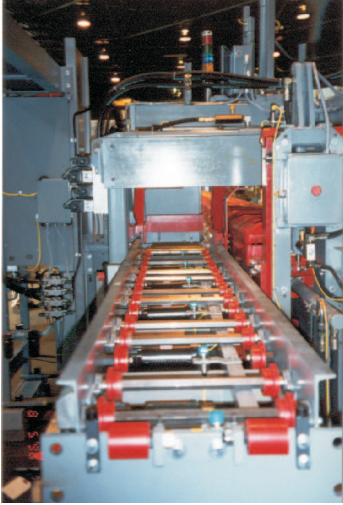
Additional modules can easily be added to meet future cooling requirements

Molds are transferred or discharged without pushing mold against mold

Pourer can select the desired amount of cooling based on the job requirements



What Hunter offers...

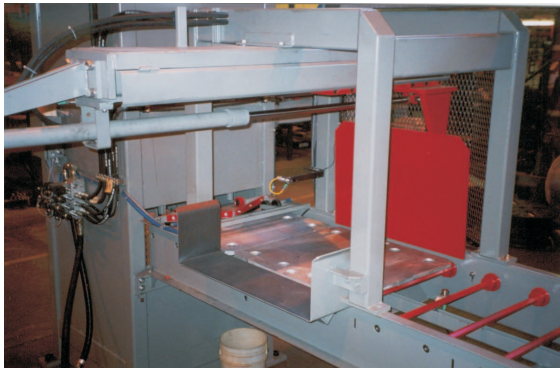


High quality molding and mold handling systems at an economical price

The concept is simple, yet the system is very clean and efficient in operation



Easy to install - All systems are assembled and tested for rapid start-up



Low operating cost - Hydraulically powered for smooth and reliable operation

Low manpower requirements - One molding machine operator and one pourer

Very compact double deck design - Uses half the space of most other systems

Expandable - Additional pouring or cooling modules can easily be added

Clean working environment - Optional fume containment hoods available

Flexible design - Systems for aluminum, brass, gray, or ductile iron

Standard and mirror image arrangements available to suite your requirements

