



GRAVITY AND LOW-PRESSURE DIE-CASTING OF ALUMINUM ALLOYS



Materials according to standards

ČSN	EN	DIN	others
42 4330	EN AC-44200	GK-ALSi12	DIN 230 A
42 4331	EN AC-43000	GK-ALSi10Mg	DIN 239 A
42 4339	EN AC-46200	GK-ALSi9Cu3	DIN 226 A
42 4334	EN AC-42100	GK-ALSi7Mg03	
	EN AC-42200	GK-ALSi7Mg06	
	EN AC-47000	GK-ALSi12(Cu)	DIN 231 A
	EN AC-45400	GK-ALSi5Cu3	
		AlZn10Si8Mg	UNIFONT 90

Machine park

- 12 x LPDC machine BaL
- 2 x LPDC machine gen 3 BaL
- 1 x LPDC machine gen 3.2 BaL
- 10 x gravity casting bench

Casting size

from 0,1 kg to 50 kg

Series

from 100 to 120 000 pcs/year

Other production possibilities

- Castings with sand cores (COLD-BOX)
- Heat treatment T6 and T4

- Prototypes (COLD-BOX sand molds)
- Prototypes (3D printed sand molds)

Before and after casting

- SW MAGMA simulation
- Deburring machines
- CNC machining
- Variety of surface finish
- subcontracted locally
- Leak test [air/water; ATEQ; Helium]
- Assembly (combination with parts from other technologies)
- 3D CMM dimensional inspection
- CT scan
- TEM Deburring