

# Hot Chamber Velocity Control

## THIN-WALL POWDER COATED AUTOMOTIVE CASTING

### 650-ton SuperShot Retrofit:

- Production rates increased 34% to 142/hour
- 18% Scrap rates decreased 75%
- \$50,000 yearly die maintenance decreased 90%
- Die tool life extended 50%

## HIGH PRECISION PLATED COMPUTER CONNECTORS

### 200-ton SuperShot Retrofit:

- Metal temperature decreased 54 degrees
- Flash eliminated, shot weight reduced 5%
- Surface finish improved dramatically

## TOP OF THE LINE POWDER COATED STAPLERS

### 150-ton SuperShot Shot End:

- Overflows eliminated  
Sprue, Runner and Overflow weight, originally 65% of shot, reduced to 35%
- Production rate increased 33% to 227/hour
- 35% scrap rates reduced to under 0.1%
- Required locking tonnage reduced 33% to 100 tons, eliminating tie-bar breakage
- Surface finish dramatically improved
- Blisters eliminated
- Metal temperature lowered 33 degrees

## Hot Chamber Real-Time Velocity Control

150HC OEM Status: S Tymac MTU-9000 Ver: 3.41 150 HC OEM 17-Sep-01 10:29:30 Job: **Display Profile**

CONTINUOUS  
#8588  
07/07/93  
14:36:00

6468591  
#8591  
07/07/93  
14:36:42

ZOOM X 4 (US)

| PARAM. | L_VELO | L_P1 | L_P2 | L_TIME | L_POS |
|--------|--------|------|------|--------|-------|
| RIGHT  | -5.60  | 1586 | 62   | 146.1  | 3.50  |
| LEFT   | 45.40  | 1094 | 166  | 114.5  | 2.35  |
| DIFF.  | -51.00 | 492  | -104 | 31.5   | 1.15  |

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150HC SS111 HYDRAULIC Tymac MTU-9000 Ver: 3.41 TYMAC SUPERSHOT 150 17-Sep-01 10:31:43 Job: **Display Profile**

CONTINUOUS  
#220907  
04/13/94  
09:38:52

747-BACE/2  
#174357  
03/11/94  
10:03:46

ZOOM X 4 (US)

| PARAM. | L_VELO | L_P1 | L_P2  | L_TIME | L_POS |
|--------|--------|------|-------|--------|-------|
| RIGHT  | 43.60  | 858  | 386   | 254.2  | 2.70  |
| LEFT   | 16.20  | 908  | 1460  | 200.8  | 1.50  |
| DIFF.  | 27.40  | -50  | -1074 | 53.4   | 1.20  |

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... buffing, painting, and inspection costs have decreased because the machine is producing flash and porosity-free castings with excellent surface finish.

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## Tymac Controls Corp.

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