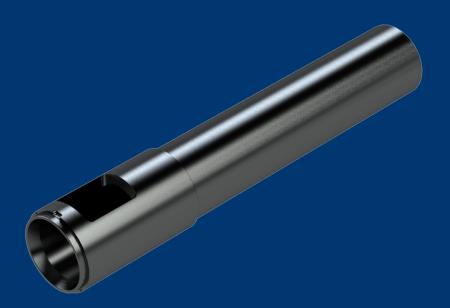


DATA SHEET

Integral insert / liner





DATA SHEET Products & Services > Die Casting > Integral insert / liner

Integral insert / liner



DESCRIPTION

Integral insert is designed to improve cost effectiveness in the casting process. It is delivered either with a specific-design shot sleeve or as a replacement part. Integral insert is simply mounted into the sleeve body and designed for replacement directly on I the casting machine when its working surface is worn out.

MAIN ADVANTAGES

- Cost effectiveness
- Fast replacement, directly in the casting machine

MATERIAL

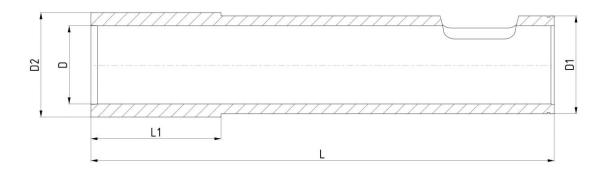
Integral insert is manufactured from hot-work tool steel, hardened and tempered to 44-46HRc. It comes with surface nitriding.

DATA SHEET Products & Services > Die Casting > Integral insert / liner

Integral insert / liner

DEFINITION OF GENERAL PARAMETERS

Selection of D is available between 50 mm and 180 mm. Selection of length (L) is available between 400 mm and 1350 mm. According to D and L, parameters D1, D2 are defined, value of parameter L1 is always 200 mm regardless selection of parameters above.



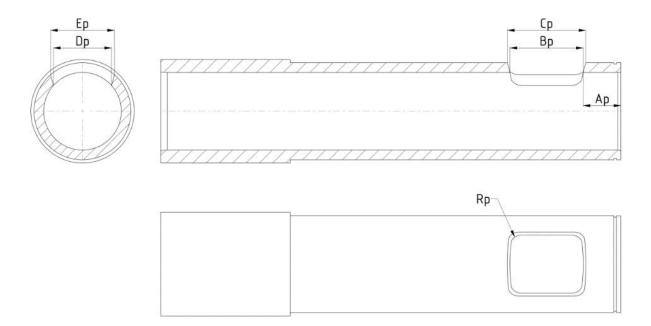
	L ≤ 1000	1000 < L ≤ 1200	1200 < L ≤ 1350
D ≤ Ø140			
D1	D+20	D+20	D+30
D2	D+30	D+30	D+40
Ø140 ≤ D < Ø160			
D1	D+30	D+30	D+40
D2	D+40	D+40	D+50
D > Ø160			
D1	D+30	D+40	D+40
D2	D+40	D+50	D+50

All dimensions are in mm

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DEFINITION OF POURING HOLE PARAMETERS

The pouring hole parameters are defined to ensure a perfect fit of integral insert into the Shot Sleeve.



Dimensions	Limits	
Ар	20 - 200	
Вр	20 - 200	
Ср	Bp - (Bp + 30)	
Dp	20 - 100	
Ер	Dp - (Dp + 30)	
Rp	1 - 50	

All dimensions are in mm



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Contact our die casting professionals and we will do our best to match your requirements. You can count on us to support you through each step of preformance improvement.

sales@hts-ic.com