



Matchplate Machine Type	MATCH 20/24	MATCH 24/28	MATCH 28/32	MATCH 32/32
Mould dimensions				
Length (mm)	610	711	813	813
Width (mm)	508	610	711	813
Heigh. min.-max of drag (mm)	150-200	180-255	225-300	225-300
Heigh. min.-max of cope (mm)	150-200	180-255	225-350	225-350
Mismatch, max.	0.25	0.20	0.25	0.25
Length (inches)	24	28	32	32
Width (inches)	20	24	28	32
Height, min.-max of drag (inches)	5.9-7.9	7-10	8.9-11.8	8.9-11.8
Height, min.-max of cope (inches)	5.9-7.9	7-10	8.9-13.8	8.9-13.8
Mismatch, max.	0.01	0.01	0.01	0.01
Machine dimensions				
Length (mm)	3843	4620	5560	5560
Width (mm)	2522	2180	2450	2450
Height, top of sand inlet (mm)	3311	4290	4730	4780
Height, manual core setting (mm)	790	925	925	925
Length (inches)	151	182	219	219
Width (inches)	99	86	96	96
Height, top of sand inlet (inches)	130	169	186	188
Height, manual core setting (inches)	31	36	36	36
Machine capacity				
Uncored (moulds/h)	160	120	100	100
Automatically cored (moulds/h)	120	100	80	80
Squeeze pressure (kp/cm²)				
Squeeze pressure (psi)	1.2-10	3-10	3-10	3-10
Shot pressure (kp/cm²)				
Shot pressure (psi)	0 - 4.5	0 - 4.5	0 - 4.5	0 - 4.5
Electrical requirements				
Average power consumption (kW)	21	42	60	60
Connected load (KVA)	32	80	100	100
Mould sand requirements				
Sand consumption max. (metric tons/h)	31	40	58	67
Sand consumption max. (US tons/h)	34	44	62	72
Pneumatic requirements				
Air pressure min (bar)	5	5	5	5
Air pressure min (psi)	71	71	71	71
Hydraulic fluid (litres)				
Hydraulic fluid (US gallons)	250	800	400	400

On DISA, DISA Industries A/S holds patents and patents pending.

Sand Mixers Type	SAM-3			SAM-6			SAM-10			SAM-16			
	20	30	40	50	60	70	85	100	120	140	160	180	180S
Mixing throughput max*													
Excl. SMC/incl. SMC (metric tonnes/h)	18/15	27/22.5	36/30	45/38	54/45	63/53	77/64	90/75	108/90	126/105	144/120	162/135	180/150
Excl. SMC/incl. SMC (US tons/h)	20/17	30/25	40/33	50/42	60/50	69/58	85/71	99/83	119/99	139/116	159/132	179/149	198/165
Charge (kg)													
Charge (lbs)	500	750	1000	1250	1500	1750	2125	2500	3000	3500	4000	4500	5000
Motor performance (kW)													
Turbine	30	45	55	75	90	110	110	132	160	200	200	250	250
Gear Bridge	18.5	22	30	37	45	55	55	75	90	110	132	200	200
Dimensions													
Mixer height without hopper (mm)	1650	1650	1650	1850	1850	1850	2225	2225	2225	2475	2475	2475	2580
Sand weigh hopper height (mm)	1900	1900	1900	2125	2125	2125	2320	2320	2320	2515	2515	2515	2620
Mixer length incl. discharge door (mm)	2300	2300	2300	2850	2850	2850	3400	3400	3400	3850	3850	3850	3850
Mixer diameter (mm)	1600	1600	1600	2000	2000	2000	2400	2400	2400	2700	2700	2700	2700
Weight (kg)													
Weight (lbs)	5000	5000	5000	8000	8000	8000	11000	11000	11000	18000	18000	18000	18000

* Depending on the water content and sand properties.

Sand Mixers Type	TM-160	TM-190			TM-240		TM-285	
	45	55	75	90	110	160	200	
Nominal capacity								
At 100/120 sec cyclus (metric tonnes/h)	18/15	25/21	36/30	50/42	66/55	90/75	115/96	
At 100/120 sec cyclus (US tons/h)	20/17	28/23	40/33	55/46	73/61	100/83	127/106	
Charge (kg)								
Charge (lbs)	500	700	1000	1400	1850	2500	3200	
Motor performance (kW)								
Agitator	45	55	75	90	110	160	200	
Turbines (number/drive power)	1/22.5	1/30	1/37	1/45	2/45	2/45	2/55	
Dimensions								
Mixer height without hopper (mm)	1990	2080	2080	2405	2405	2480	2480	
Sand weigh hopper height (mm)	1400	1350	1750	1600	1900	1950	2250	
Mixer diameter (mm)	1650	1950	1950	2460	2460	2900	2900	
Weight (kg)								
Weight (lbs)	4400	6500	6700	12400	13200	16900	17000	

* Depending on the water content and sand properties.

DISA* and DISAMATIC* are registered trademarks by DISA Industries A/S. The technical data are not binding and are subject to change.

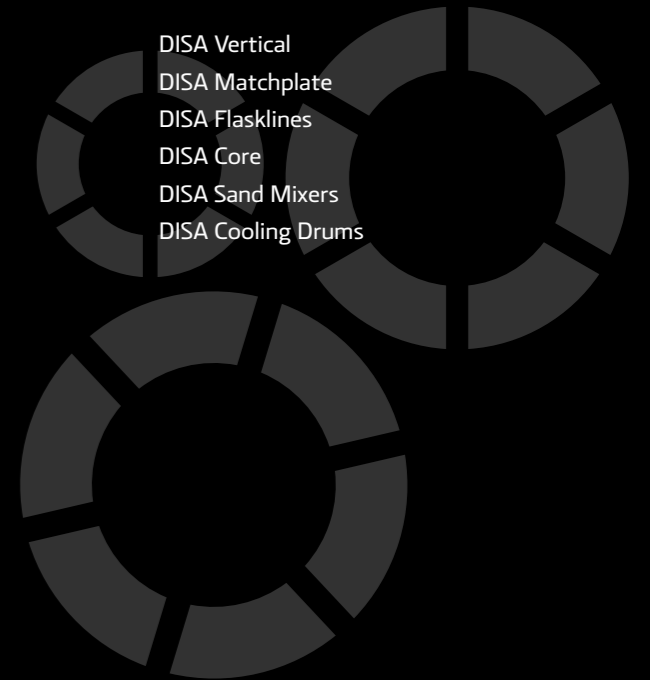
DISA Flask lines Type	DISA FLEX		
	70	80	90*
Flask size			
Height of cope/drag flask, min-max (mm)	200-325	250-350	300-400
Width min-max (mm)	700	800	900
Length min-max (mm)	800-1000	900-1050	1200-1250
Machine output in complete moulds/h			
Squeeze pressure (max.kgf/cm ²)	10	10	10
Sand consumption (metric tonnes/h)			
Sand consumption (US tons/h)	20-65	40-125	45-160
Power consumption (kW)			
Air consumption (m ³ /min) at 4 bar	165-340	300-600	240-600
Air consumption (cu ft/min) at 4 bar	5830-12000	10595-21190	8475-21190
Water consumption			
At 25 °C inlet temperature (litres/min)	70	140	160
At 25 °C inlet temperature (US gallons/min)	19	37	43

Above data is preliminary and indicative. *DISA FLEX 90 is only available in India.

DISACOOOL	2400	2900	3200	3400	3800	4300
Sand/metal capacity max						
Metric tonnes/h	25	50	60	90	140	200
US tons/h	27.6	55.1	66.1	99.2	154.3	220.5
Dimensions						
Diameter (mm)	2400	2900	3200	3400	3800	4300
Length (mm)	9400	12500	12500	15250	19180	22400
Distance centerline-floor (mm)	1660	2280	2425	2560	3120	3375
Weight - empty (metric tonnes)						
Weight - empty (US tons)	11	23	26	45	57	70
Ventilation requirements (m³/min)						
Ventilation requirements (cu ft/min)	250	383	500	750	1167	15833
Rated speed (rpm)						
Installed power (kW)	3.8	3.0	2.7	2.5	2.5	2.2

Max recommended inlet temperatures for ferrous castings is usually 700°C
 Casting discharge temperatures are typically 70-90°C
 Sand discharge temperatures are 45-55°C with moisture contents of about 1.5% (max. 1.8%)
 With a SCR system the final sand temperature will be less than 45°C
 Noise levels are less than 85 dB(A)

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General Specifications

