

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

F1 Plot Last Shot F2 Plot Master F3 Erase F4 Profile Utilities F5 Previous Menu

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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US Patents: 3,911,419, 3,878,375, 4,094,490, 4,249,186 4,383,449, 4,504,920, 4,734,869 Canadian Patent: 1-234-902 European Patent: 0 126 174

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