

FETTLING AUTOMATIONTM

Casting Grinder



www.fettlingautomation.com

FETTLING AUTOMATION



Introduction

Weijing 2 axis grinding machine with 2 grinding station is designed to fettle the ingates, parting lines and flashes on the round surface of round castings.

Grinding sparks are covered for better safely.

Diamond wheel saves time cost of grinding wheel replacement.

Repeatable grinding accuracy is controlled by 4 position sensors.

Safer, faster, more repeatable and controllable than manual grinding.

Casting Requirements

Material: iron castings

Shape: round castings

Casting Diameter: 95-380mm

Casting Height: <170mm, grinding areas/parting lines height<70mm

Casting Weight: <30kg

Gate areas: up to 1000 sqmm (could be removed once by two grinding station in total)

Typical examples: brake disc castings, auto flywheel casting

If your casting diameter is down to 80mm or up to 460mm, please tell Weijing in advance, Weijing can customise the machine for you without any extra cost.

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GV120



Items	Parameters
Casting size requirements	Turning radius: up to 175mm Part height: up to 200mm
Casting weight requirements	Part weight: up to 20 kg (Total loading capacity is up to 25 kg)
Big / small grinding wheel driving motor	3.7KW(AC servomotor drive) / 3.5KW high speed
Big wheel tilt angle up to	105° (NC control drive)
Axis quantity of NC control driving motor	6 axes AC servo
Total power capacity	14KVA
Machine size/weight	L2141 W1864 H2340mm / 2085KG
Features & benefits	<ol style="list-style-type: none"> 1. Suitable to fettle small size parts. 2. Complete CNC Programing system and manual teaching mode, quite easy to learn and operate. 3. One people can operate two machines to improve productivity.

GV230



Items	Parameters
Casting size requirements	Turning radius: up to 250mm Part height: up to 300mm
Casting weight requirements	Part weight: up to 30 kg (Total loading capacity is up to 40 kg)
Big / small grinding wheel driving motor	7.5KW(AC servomotor drive) / 3.5KW highspeed
Big wheel tilt angle up to	120° (NC control drive)
Axis quantity of NC control driving motor	7 axes AC servo
Total power capacity	21KVA
Machine size/weight	L3030 W2122 H2545mm / 3840KG
Features & benefits	<ol style="list-style-type: none"> 1. Suitable to fettle middle size parts. 2. Complete CNC Programing system and manual teaching mode, quite easy to learn and operate. 3. AB two pallets could be used for fettling two different parts.

GV270



Items	Parameters
Casting size requirements	Turning radius: up to 350mm Part height: up to 400mm
Casting weight requirements	Part weight: up to 70 kg (Total loading capacity is up to 90 kg)
Big / small grinding wheel driving motor	7.5KW(AC servomotor drive) / 6KW highspeed
Big wheel tilt angle up to	120° (NC control drive)
Axis quantity of NC control driving motor	7 axes AC servo
Total power capacity	31KVA
Machine size/weight	L3948 W2223 H2953mm / 6210KG
Features & benefits	<ol style="list-style-type: none"> 1. Suitable to fettle big size parts. 2. Complete CNC Programing system and manual teaching mode, quite easy to learn and operate. 3. AB two pallets could be used for fettling two different parts. 4. Equipped with hoisting to move heavy parts for workload saving and high productivity

FETTLING AUTOMATION

GV2100



Items	Parameters
Casting size requirements	Turning radius: up to 500mm Part height: up to 400mm
Casting weight requirements	Part weight: up to 100 kg (Total loading capacity is up to 120 kg)
Big / small grinding wheel driving motor	7.5KW(AC servomotor drive) / 6KW highspeed
Big wheel tilt angle up to	120° (NC control drive)
Axis quantity of NC control driving motor	7 axes AC servo
Total power capacity	31KVA
Machine size/weight	L4528 W2590 H2920mm / 6420KG
Features & benefits	<ol style="list-style-type: none"> 1. Suitable to fettle big size parts. 2. Complete CNC Programing system and manual teaching mode, quite easy to learn and operate. 3. AB two pallets could be used for fettling two different parts. 4. Equipped with hoisting to move heavy parts for workload saving and high productivity

GH260



Items	Parameters
Casting size requirements	Turning radius: up to 300mm Part height: up to 300mm
Casting weight requirements	Part weight: up to 150 kg (Total loading capacity is up to 200 kg)
Big / small grinding wheel driving motor	9.6KW (AC servomotor drive)
Big wheel tilt angle up to	180° (NC control drive)
Axis quantity of NC control driving motor	7 axes AC servo
Total power capacity	27KVA
Machine size/weight	L3210 W2440 H2800mm / 9600KG
Features & benefits	<ol style="list-style-type: none"> 1. Horizontal bed born for heavy grinding work. 2. Complete CNC Programing system and manual teaching mode, quite easy to learn and operate. 3. Equipped with hoisting to move heavy parts for workload saving and high productivity

GH280



Items	Parameters
Casting size requirements	Turning radius: up to 400mm Part height: up to 400mm
Casting weight requirements	Part weight: up to 220 kg (Total loading capacity is up to 300 kg)
Big / small grinding wheel driving motor	9.6KW (AC servomotor drive)
Big wheel tilt angle up to	180° (NC control drive)
Axis quantity of NC control driving motor	6 axes AC servo
Total power capacity	40KVA
Machine size/weight	L4350 W2900 H2800mm / 11000KG
Features & benefits	<ol style="list-style-type: none"> 1. Complete CNC programming Controller. Easy for staff who has CNC Knowledge to learn quickly. 2. Teach Pendant Programmer quite convenient to get the right coordinate values of each key point of grinding route and complete the program quickly.

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Model	Impacting power (Joules)	Neck-down (Ø diameter)	Riser Height (mm)	Net Weight (KG)
QC85	900	55mm / 2.16"	140	160
QC135	1800	85mm / 3.34"	260	345
QC155	3000	110mm / 4.33"	300	600
QC195	4000	130mm / 5.11"	350	815
QC295P	8500	180mm / 7.08"	480	1700
QC355	9500	210mm / 8.26"	480	2250
QC431	18000	250mm / 9.84"	610	2740
QC499	28000	350mm / 13.77"	680	6300

FETTLING AUTOMATION

Vertical Wedge



Horizontal Wedge



Runner Cutter



Model of WL Type	Force (T)	Section Area (mm*mm)	Weight (KG)	Wedge Dimensions : mm				
				L	A	B	C	D
9T-WL	9T	15*15	13	380	50	14	48	34/40
16T-WL	16T	35*40	27	495	75	24	71	53/65
30T-WL	30T	55*60	30	499	75	24	71	52/63
50T-WL	50T	60*65	43	584	75	24	71	59/62

Model of FLT Type	Force (T)	Section Area (mm*mm)	Weight (KG)	Wedge Dimensions : mm				
				L	A	B	C	D
GT55-RH+	16T	35*40	39	729	50	21	64	41
GT63-RH+	20T	50*55	25	513	50	19	60	39
GT80-RH+	35T	60*65	38	751	40	14	66	34

Type	Force (T)	Maximal runner size (Ø)	Circle time	Weight (KG)	Cutter Dimensions	Remarks
RC1650	16T	Ø40	12/min	55	725*378*390	For straight bars
RC1660	16T	Ø40	12/min	55	735*378*390	For curved bars
RC2580	25T	Ø40	8/min	66	767*683*428	

FETTLING AUTOMATION

Weijing Auto pouring machine is customized for the foundries who don't want to reinvent the foundries, save time cost and high limited space for pouring machine.

Since Weijing auto pouring machine does not need foundation to dig the groundwork for the machine and just need at most 2 meters distance for machine to move horizontally.

No matter horizontal or vertical moulding lines you have, Weijing Auto Pouring Machine can always can match your lines perfectly.



- **Wireless Control version**

Function: Wireless Control, Stream inoculation , X,Y,Z auto control, Synchronised.

Pour Requirements: Moulding line velocity should be less than 60 melds/hour.

- **Full Auto Control version**

Function: Weighing system, Moving and Lip pouring

Requirements: Can match Molding line speeds should be between 60 Molds/hour and 300 molds/hour.



FETTLING GRINDING MACHINE, YOUR WISE CHOICE

FETTLING AUTOMATIONTM

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