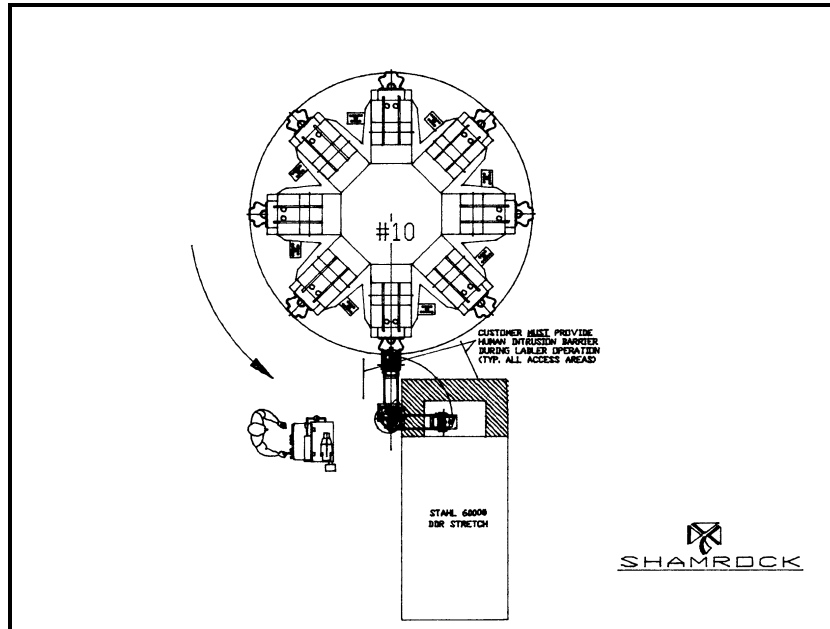


## TYPICAL LAYOUT FOR MODEL HD AUTOMATIC LADLER AND SPEC SHEET



Maximum Pour Weight: 60 pounds @ 36 inches (Arm Length)

Power Required: 440/220 volts  
5/10 amps  
2200 KVA

External Heater: 120 volts  
5 amps

Controls: PLC Type: SLC-500  
Enclosure Size: 24"H x 24"W x 10"D  
HMI Type: PanelView 300  
Metal Sensing: Transducer

Hydraulics: Pressure: 600  
GPM: 1.6  
Cooling: Water

AXIS	MAX. MOVEMENT	POSITION CONTROL	SPEED CONTROL	OPTIONS
ROTATION	140°	Timer/Limit Switch	Manual Flow Control	
REACH	Fixed	Manual Adjust.	NONE	Shuttle Available
HEIGHT	+20° / -20°	Timer	Manual Flow Control	Multi-Speed
TILT	75°	Timer/Hard Stop	Manual Flow Control	Multi-Speed

## MODEL HD AUTOMATIC LADLER



Spec # XFFFF-40-90-00-00-38-HD

The Model HD Automatic Ladler is designed to pour up to 60 pounds of aluminum on a fixed radius of 36 inches. The unit uses a fixed mechanical rotation of up to 140 degrees designed to your exact application requirements. A manual reach adjustment allows  $\pm 4$  inches of ladle movement. Speeds are set by manually adjusted hydraulic flow controls. An optional Multi-speed function is available for both the height and tilt to allow software controlled speeds throughout the automatic cycle. All actuators are located behind protective heat shielding and all bearings used on the ladle end are heat treated, nitrided, H-13 tool steel. The unit uses Shamrock's exclusive "NO PROBES" feature to sense metal level in the furnace. This unit is ideally suited for permanent mold and high-pressure die casting applications with a single furnace and single pour location. Pour weight is extremely consistent and adjusted manually. An optional shuttle base is available for reaching recessed pour locations. Please refer to the Discreet Control section for details of the electrical controls used on this unit.