



Anhui Qasim Grinding Ball Group

Automatic Casting Grinding Balls
Production Line Technical Specifications

Equipment For Casting Grinding Balls

Working method	<p>open type & flexible transport & multilevel supply drive operation mode.</p> <p>The production line and pouring system, working separately and cooperated steadily.</p>
Driving method	Hydraulic drive + pneumatic
Loading power capacity	100KW (not include air compressor)
Air compressor	air consumption:3m ³ /min or 5m ³ /min; working pressure:0.8Mpa
Unloading working tempo	50"/time
Control method	automation control & remote service
Operators for molding line	<p>4 operators:</p> <ul style="list-style-type: none"> *one is for sand molding(sand blowing part); *one is for pouring, operate the pouring system; *one is for cleaning molten iron slag on the mold after pouring; *one is for waste sand mold cleaning.
Metal molds online	Size:630mm*630mm & 840mm*840mm
Molding line function	two different sizes of balls producing at the same time

Productivity per Hour (For Different Size of Balls)

Model : QLS-840-4F:

SIZE	Φ40	Φ50	Φ60	Φ70	Φ80	Φ90	Φ100	Φ110	Φ120
Q'TY per mold	68	40	32	24	16	16	10	6	5
Productivity (kg/h) 60"/mold	1050	1200	1662	1973	1920	2784	2400	1908	2040
Productivity (kg/h) 70"/mold	900	1029	1425	1691	1646	2386	2057	1635	1749

Model : QLS-630-4F:

SIZE	Φ40	Φ50	Φ60	Φ70	Φ80	Φ90	Φ100	Φ110	Φ120
Q'TY per mold	150	80	48	40	32	24	20	16	16
Productivity (kg/h) 60"/mold	2313	2400	2500	3288	3936	4176	4800	5088	6528
Productivity (kg/h) 70"/mold	1983	2057	2140	2818	3373	3579	4114	4361	5595

Technological Yield

Model : QLS-840-4F:

Size	Φ40	Φ50	Φ60	Φ70	Φ80	Φ90	Φ100	Φ110	Φ120
Balls weight per mold (kg)	38.55	40	41.62	54.80	65.6	69.6	80	84.8	108.8
Molten iron's weight per mold (kg)	59.31	61.07	60.32	76.64	90.48	96	106.67	116.48	146.04
yield (%)	65%	65.5%	69%	71.5%	72.5%	72.5%	75%	72.8%	74.5%

Model : QLS-630-4F:

Size	Φ40	Φ50	Φ60	Φ70	Φ80	Φ90	Φ100	Φ110	Φ120
Balls weight per mold (kg)	17.5	20	27.7	32.88	32	46.4	40	31.8	34
Molten iron's weight per mold (kg)	29.17	28.1	37.9	43.84	42.1	59.49	51.9	40.77	45
yield (%)	60%	71.2%	73%	75%	76%	77.9%	77%	77.9%	75.5%

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