The C300H Holton Conform

Guards

Guards of the fixed steel sheet type enclose the rotating components consisting of the main drive gearbox input and output couplings. A mesh guard is provided over the rotating shaft end.

Overview Of Electrical Specification

The electrical control system is based around a PLC system which controls all aspects of the line with control voltages of 115V AC and 24V DC.

Programming is carried out on IBM or most compatible computers.

All systems are interlocked to prevent incorrect status on the line.

Each system without Line Monitoring has a built-in fault-finding mimic, each fault level being displayed by an LED. When Line Monitoring is supplied these readings will be displayed on a VDU.

Faults displayed are, for example, motor overloads, over-temperature, flow loss etc.

Local push buttons are located on the machine and take-up for functions executed within their vicinity - for example Inch forward, Inch reverse.
All other push buttons - Line Run, Product Coolant Stop-Start, for example - are mounted on a control desk together with all instrumentation (volt meter, wheel speed meter) and the fault mimic.

An audible alarm is supplied for machine running faults.

Emergency Stop push-buttons are provided at all moving parts of the line.

For detailed information, see General Electrical Specification.

SERVICES REQUIRED

Air Services (Control)	5.5 Bar, 1.03m³/min peak demand (during shoe loading)
Cooling Water	75l/min for Machine Heat Exchangers
Electrical Supply	380/400/415V, 3-Phase+E, 50/60Hz 420Amp
Air Supply	6 Bar/min continuous consumption, 0.6m³/min peak for 1 minute during shoe clamping
Compacting Roller (if fitted) & Blow Gun:	
Air Supply	4 Bar, 0.2m³/min continuous

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TECHNICAL DATA

Extrusion Wheel Diameter	300mm
Extrusion Wheel Mass	32kg
Extrusion Wheel Material	AISI H13 Tool Steel
Main Drive Motor Type	DC Infinitely Variable
Main Drive Motor Power	0/132/132kW
Main Drive Motor Speed	0/1225/1800
Main Drive Gearbox	Bevel/Helical 3-Stage
Main Drive Gearbox Mechanical Rating	156kW @ 1225rpm
Main Drive Gearbox Lubrication	Oil Splash
Main Drive Gearbox Cooling	Internal Water Cooling Oil
Main Drive Gearbox Thermal Rating	>300kW with Water Cooling
Max. Continuous Torque at Wheel	47213 Nm
Starting Torque at Wheel	47213 Nm
Couplings Output	Double Engagement Gear Type
Main Shaft Preload (at 2300 bar)	4.0MN
Top Clamp Preload (at 500 bar)	5.65KN
Rear Clamp Preload (at 500 bar)	2.26MN
L.P. Hydraulic System	200 bar Flame-Resistant Fluid
L.P. Hydraulic Pump	Gear Type
L.P. Hydraulic Fitted Power	4.0kW
L.P. Hydraulic Flow Rate	7.5 Lit/Min
H.P. Hydraulic System	630 bar Maximum
H.P. Hydraulic Pumps	Air/Hydraulic Intensifiers
H.P. Hydraulic Operating Pressure	500 bar Nominal
Hydraulic Nut Loading Pressure	2300 bar
Main Bearings	Cylindrical Roller Type
Main Bearings Capacity (Dynamic)	1840 kN
Main Bearings Lubrication	Recirculating Oil
Main Bearings Lubrication Flow	8 Lit/Min
Main Bearings Lubrication Pressure	3 bar Maximum
Machine Coolant	Recirculating water with additives
Machine Coolant Delivery	1.0m³/hr
Inlet Feedstock Max. (99.7% pure Al)	15mm Diameter Rod
Output Max	600kg/hr continuous (99.7%Al) - lower output for alloys

Max Aluminium Die Circle Profiles:	
With Expansion Shoe	90mm
Without Expansion Shoe	50mm

Max Aluminium Tube Diameter:	
With Expansion Shoe	50mm
Without Expansion	30mm

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