



武汉建恒工业技术有限公司

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The differences between hot-box core and cold-box core		
	hot-box core shooter	cold box core shooter
1	Shoot coated sand into heated core box, sand harden into mold after heated. Heating method :coal gas;natural gas;electricity. Hot-box core shooter have two categories :1.Core shooter (vertical and horizontal parting) 2. shell core machine: has the function of pouring sand, can empty the sand mold.	Put dried original sand and a certain proportion of special resin together , mix thoroughly and shoot them into cold box, then add into triethylamine. Triethylamine is heated by the generator ,blowed into cold box by compressed air, to make it solidfied quickly.
2	Coated sand has good fluidity, in order to prevent leakage of sand, need to install sand shield or maze.	Cold core sand had poor fluidity , sand channel required wide, jet nozzle should be straight, so it can not be installed sand shield or maze.
3	Sand core hardening is mainly through electricity heating or gas heating mold sand. (no generator)	Sand core hardening requires triethylamine cgenerator producing triethylamine gas, blowed into cold box to make sand hard.
4	Sand has good fluidity and the requirement for sand injection air intake is low, in general sand shooting press and Sand injection intake channel are relatively small. Machine structure and other requirements are low.	Sand fluidity is poor, the requirement of shot machine is high, air intake channel and sand shooting pressure should be bigger.
5	The transmission mode is mainly cylinder transmissions.	The main transmission mode is hydraulic transmission.
6	The pressure of Pneumatic transmission is small, relatively steel requirements for each part of the machine is low.	The pressure of Hydraulic transmission is large, the requirements for the steel of the machine is higher.

7	Long cycle time and low production efficiency	Short cycle time and higher production efficiency
8	Sand has good fluidity , sand adding mechanism is relatively simple, in general the dimension of 60-80mm is enough for sand mouth.	Sand has poor fluidity, sand adding mechanism has higher requirements, sand mouth should be bigger with vibrating equipment.
9	The machine is universal, according to the process requirments, the cold core machine can also be converted to hot core machine.	

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