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INTRODUCTION

We would like to congratulate you on becoming the new owner of a MINICAST casting machine. This machine has been carefully designed, manufactured and tested to give you complete satisfaction.

You will be making perfect castings effortlessly and risk-free, whatever alloy you use.

To make the best use of your MINICAST, please read the operating instructions and advice contained in this manual attentively.

SPECIFICATIONS

- Power requirement : single phase 230v
- Frequency range : 50Hz or 60HZ
- Power consumption : 300W
- Arm rotation speed : 500rpm
- Crucible capacity : 60gr of alloy
- Injection time-delay : 6 to 60 seconds

DIMENSIONS

- Length : 700mm
- Depth : 530mm
- Height, cover closed: 330mm
- cover open : 730mm
- Net weight : 50kg

ACCESSORIES

- 2 crucibles type Minicast DF1F, code *P15145*

OPTIONS

- Casting ring table
- oxy acetylene torch
- oxy propane torch
- casting ring tongs
- set of casting rings
- set of casting ring base plates

INSTALLATION AND SET-UP

OF THE MINICAST CASTING MACHINE

1-After unpacking the machine, verify its condition and notify the shipper and supplier of any damage. Remember to have the deliveryman sign the shipping order on which any reservations have been noted and to confirm the latter to the shipper by registered letter with acknowledgement of receipt. .

2-Set the machine on a flat surface and level it if needed .

COMMENT: The machine may also be bolted onto a table or bench top.

Necessary equipment

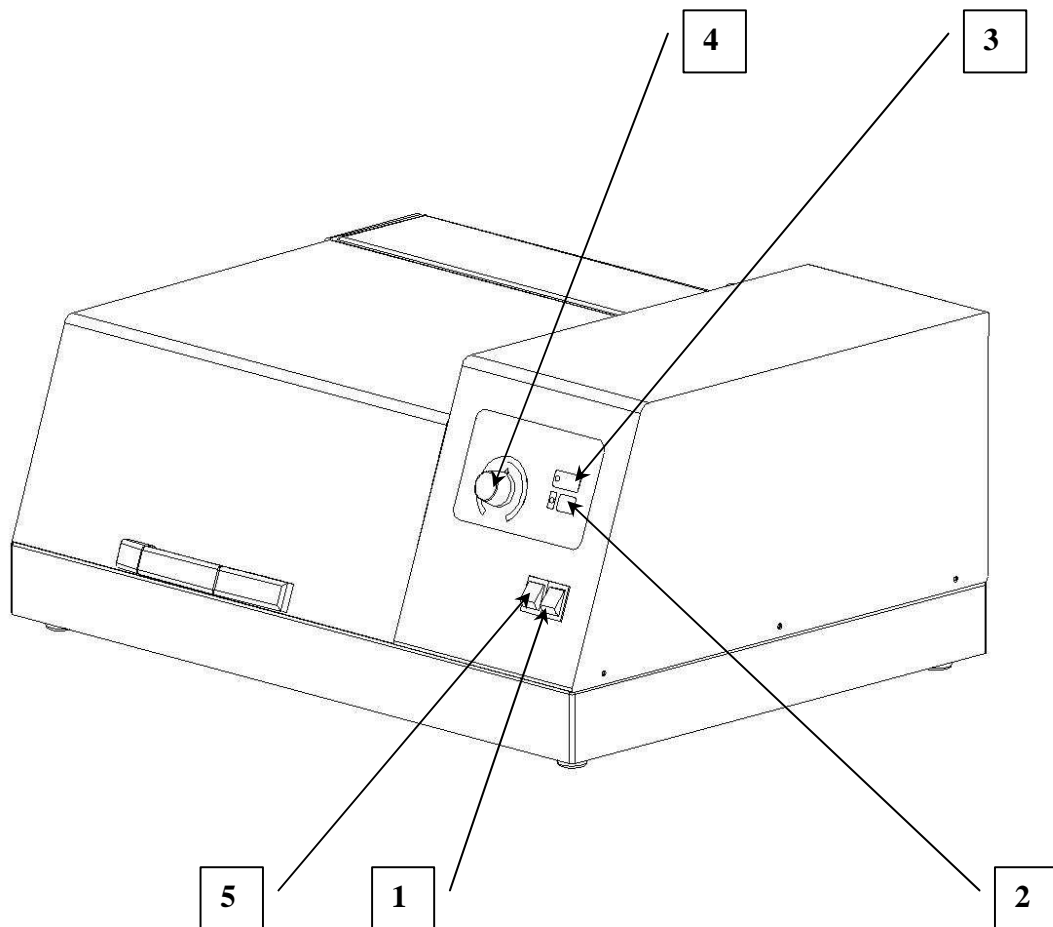
- 12 8 mm diameter nuts
- 12 8 mm diameter washers
- 4 8 mm diameter screw rods - Length depends on thickness of base.

Dismount the underside plate. Unscrew the four rubber pads and replace them with the screw rods, held firmly in place with nuts and washers on either side of the frame plate. Drill 4 holes in the table or bench top at a center distance of 644 mm x 450 mm. Center the machine so that the screw rods on the underside fit into these holes. Screw down the machine from underneath the table or bench top using 4 nuts and washers

3-Raise the cover and remove the arm block.

4-After making sure that the mains voltage corresponds to that mentioned on the identification plate, connect the power cord to a standard 10/16A plug with a grounding terminal.

DESCRIPTION OF THE CONTROL PANEL



- 1 - Power On / Off key
- 2 - «Cycle start » key
- 3 - Door safety lock indicator
- 4 - Injection time-delay
- 5 - Selector of arm acceleration

1 - POWER ON/OFF KEY

This key switches indicate the power on. It may also be used in the event of a problem for emergency

2 - CYCLE START KEY

Before beginning a melting operation, you must make sure to press this key (with the cover open).

The indicator coupled with the key lights to confirm that the cycle start command has been registred.

When you close the cover, the arm will automatically begin rotating.

Advantage : The user; with the torch in one band and the cover handle in the other, does not need to enter any commands on the control panel during melting and injection.

3 – DOOR SAFETY LOCK INDICATOR

During arm rotation, the cover is locked by an electromagnetic latch.

The DOOR SAFETY LOCK indicator lights to confirm that the cover is locked.

4 - INJECTION TIME DELAY 6 to 60 seconds

The potentiometer is used to set centrifuging time. The count down begins as soon as the cover is closed.

The arm stops automatically at the end of the hold time.

Waiting time for non-precious metals : 10 to 15 seconds

Waiting time for precious metals: 2 to 25 seconds

5- SELECTOR OF ARM ACCELERATION. (Low-high)

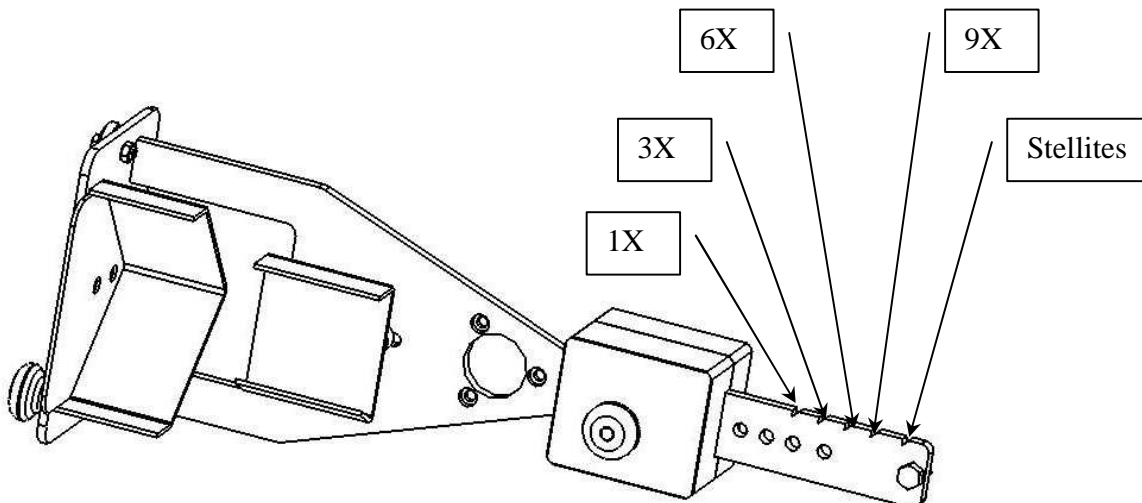
This switch with two positions allows a choice of speed for arm rotation

IMPORTANT: DO NOT CHANGE THE POSITION OF THE SELECTOR DURING THE CYCLE.

MELTING AND INJECTION

After installing your machine according to the instructions on page 9

- Press the ON/OFF key.
- Set the time-delay potentiometer " (roughly 1/4 turn above the minimum).
- Open the cover.
- Position the casting ring and adjust its height using the lever.
- Position the counterweight according to the size of the casting ring.



- Put the metal in the crucible.
- Position the crucible against the casting ring.
- Press the CYCLE key.
- Melt the alloy with the torch.
- When the alloy is ready to be injected, close down the cover which will make the motor starts.

N.B. : The rotation way is counter clockwise.

