

## **DIE CASTING UNIT**



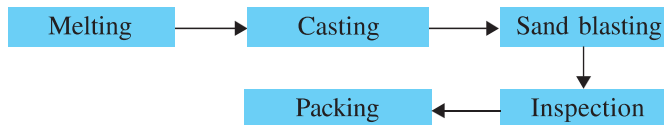
**Production capacity/annum**

105 MT

### **Production process**

Aluminium alloy ingots and scraps are melted in oil fired furnace. Molten Aluminium alloy of requisite quantity poured manually by a ladle on the pouring sleeve of the machine. Rest of the operations are automatic which starts with pressing of the foot switch or cycle start push button switch. Hot molten material fills the die cavity by hydro mechanical pressure of the machine.

### **Process flow chart**



### **Machinery & equipment required**

- Die casting machine
- Furnace
- Buffing machine
- Optional equipments/accessories required, if any

### **Raw material/consumables required**

- Aluminium ingots and scraps
- Flux
- Mould

### Utilities required

Power required (load)	:	30 K.W.
Water required (per shift basis)	:	1000 litres

### Manpower required

Supervisor	:	1 No.
Skilled	:	3 Nos.
Unskilled	:	2 Nos.

### Area required

Total Area	:	400 Sq. Mtr.
Covered Area	:	450 Sq. Mtr.

### Investment required

Machinery & Equipment	:	} ₹ 55.60 Lakhs
Working Capital for 3 Months	:	
(Raw material, utilities & salary)	:	