



# Herman High Pressure Molding

Increasing production rates and improving mold quality were the major goals of Herman engineers who pioneered high pressure molding in the 1950s. The engineers developed a system of squeezing sand around a pattern by using hydraulic pressure which achieves molds of 90-95 mold hardness.

The self-compensating automatic squeeze head is the basic element of the Moldmaster squeeze station, and produces the high pressure molds. An assembly of individual hydraulic cylinders with squeeze feet transmit hydraulic pressure to the molding sand, compressing it as required. Multiple squeeze feet "contour" to any pattern shape, flowing the sand in such a way as to insure high density molds.

This method produces a uniform density which keeps mold wall movement to a minimum when molds are poured. It works equally well with large or small mold sizes.

**More Accurate Molds**

**Reduced Cleaning Costs**

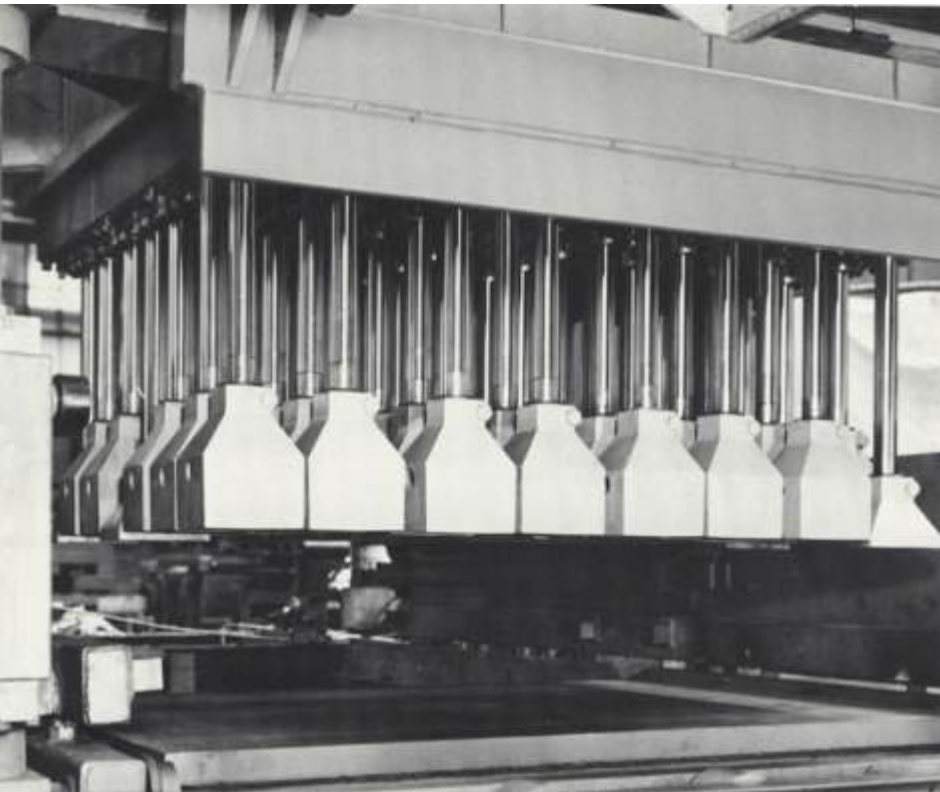
**True-to-Pattern Casting**

**Reduced Mold Wall Movement**

**Casting Weight Reduction up to 10%**

**Better Casting Surface Finish**

**Maximum Versatility**



# Herman Moldmaster

## Herman Moldmaster Single Pass Line System

Designed for lower production rates up to 60 complete molds per hour this Moldmaster system uses a single molding station producing alternate cope and drag molds. One, two or three sets of patterns can be run on the system depending on the machine style. The turntable styles can shuttle one set of patterns or run continuously in one direction to produce molds from two sets of patterns.

Typical sizes and speeds in production now

SIZE	Millimeters	Complete Molds per Hour
36 x 48 x 18 / 18"	915 x 1220 x 460 / 460	60
42 x 48 x 18 / 18"	1070 x 1220 x 460 / 460	25
42 x 48 x 15 / 14"	1070 x 1220 x 380 / 380	50
34 x 44 x 12 / 12"	865 x 1120 x 305 / 305	70
36 x 96 x 13 / 13"	915 x 2440 x 330 / 330	20
36 x 94 x 15 / 15"	865 x 2390 x 380 / 380	50
36 x 72 x 18 / 21"	915 x 1830 x 460 / 535	30

## Herman Moldmaster Double Pass Line

This system produces medium production speeds of up to 180 complete molds per hour or 360 half-mold cycles, from a single squeeze station. It is capable of running two sets of patterns alternately and produces railway car castings, truck wheels, fifth wheels, grey iron fittings, compressor parts and grey iron jobbing castings. Pattern changes can be made within the mold cycle.

Typical sizes and speeds in production now

SIZE	Millimeters	Complete Molds per Hour
20 x 40 x 9 / 8"	510 x 1015 x 230 / 205	180
32 x 40 x 12 / 12"	815 x 1015 x 305 / 305	110
48 x 48 x 14 / 10"	1220 x 1220 x 355 / 255	90
30 x 60 x 15 / 12"	760 x 1525 x 380 / 305	70
42 x 72 x 24 / 24"	1070 x 1830 x 610 / 610	40
38 x 114 x 16 / 24"	960 x 2895 x 406 / 610	40
42 x 116 x 24 / 24"	1065 x 2945 x 610 / 610	40

- Remote controlled sprue cutter
- position adjustment
- Automatic batch (weigh) hopper
- Drag molds at good working height from floor
- Easy pattern access
- Rolling cope for core setting, or inspection and rollback
- Automatic vent drilling
- Aerated sand onto pattern

