

## Single/double-strip casting line

A horizontal continuous casting system is ideal for casting single-strand and double-strand strips of bronze, brass and copper alloys with dimensions in the 100-1,070 x 14-20 mm range.

### Process

The quantity of liquid metal required for the casting process is provided by the melting furnace and transferred to the holding furnace at regular intervals in order to ensure a virtually constant metallostatic pressure.

The holding furnace is heated by a flange-mounted, water-cooled mains frequency channel-type inductor.

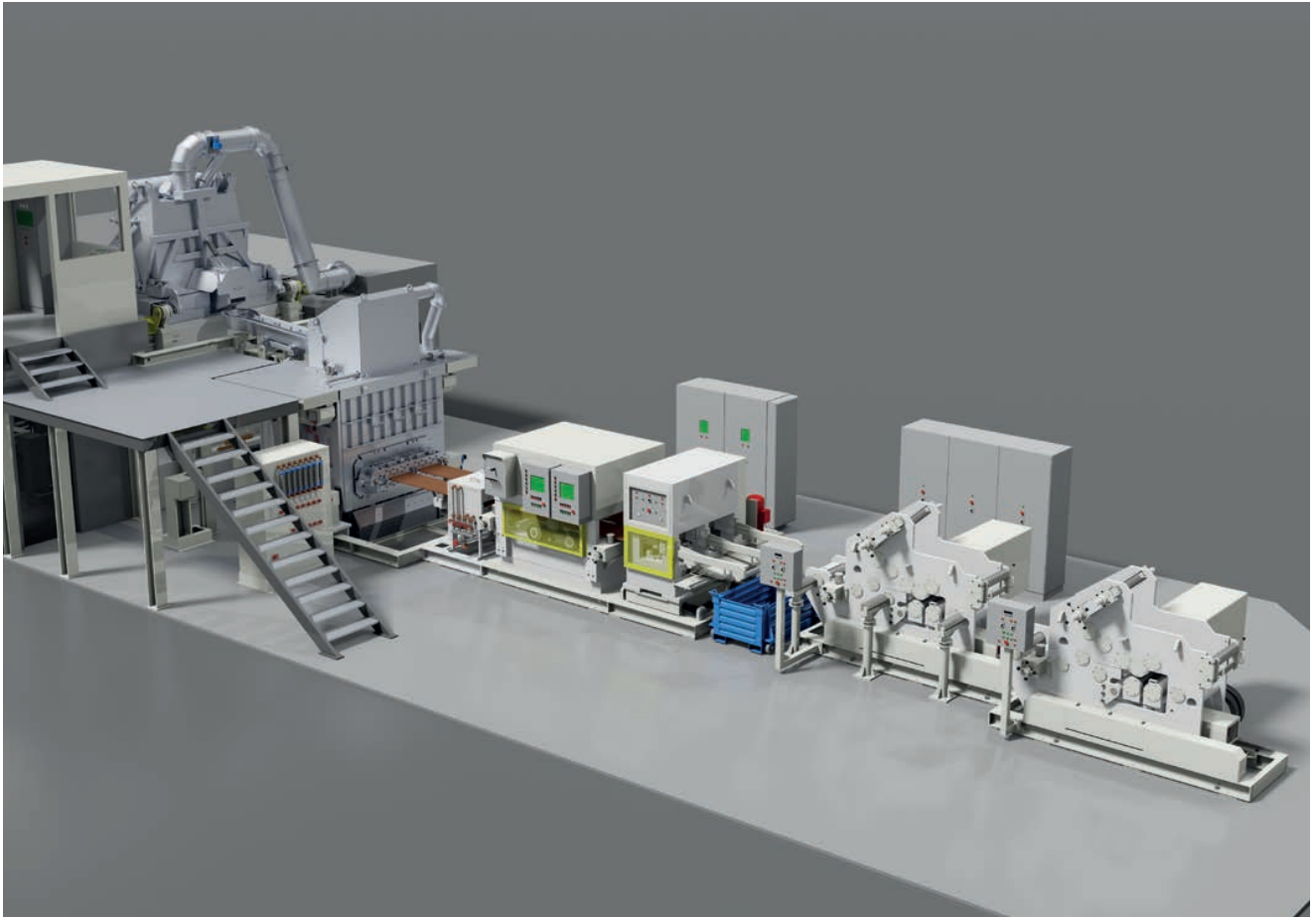
The customer's water-cooled die assembly in which the liquid metal solidifies is mounted directly to the holding furnace and the strip is drawn at variable speed from the die by means of the withdrawal machine.

Finally, the strip is coiled by the upcoiler and cut to the desired length by the hydraulic shear.

### Utilisation factor

Various factors allow production capacity to reach almost 100% in continuous operation. Working three shifts, for example, has been shown to result in a utilisation factor of 0.95. This factor takes into account all downtimes for changing dies and reduced production on start-up until the

cooling the cooling system reaches its thermal balance. Other influences include different graphite qualities, reduced heat transfer as a factor of the time the graphite die has been in use, and a series of other parameters that can affect production.



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