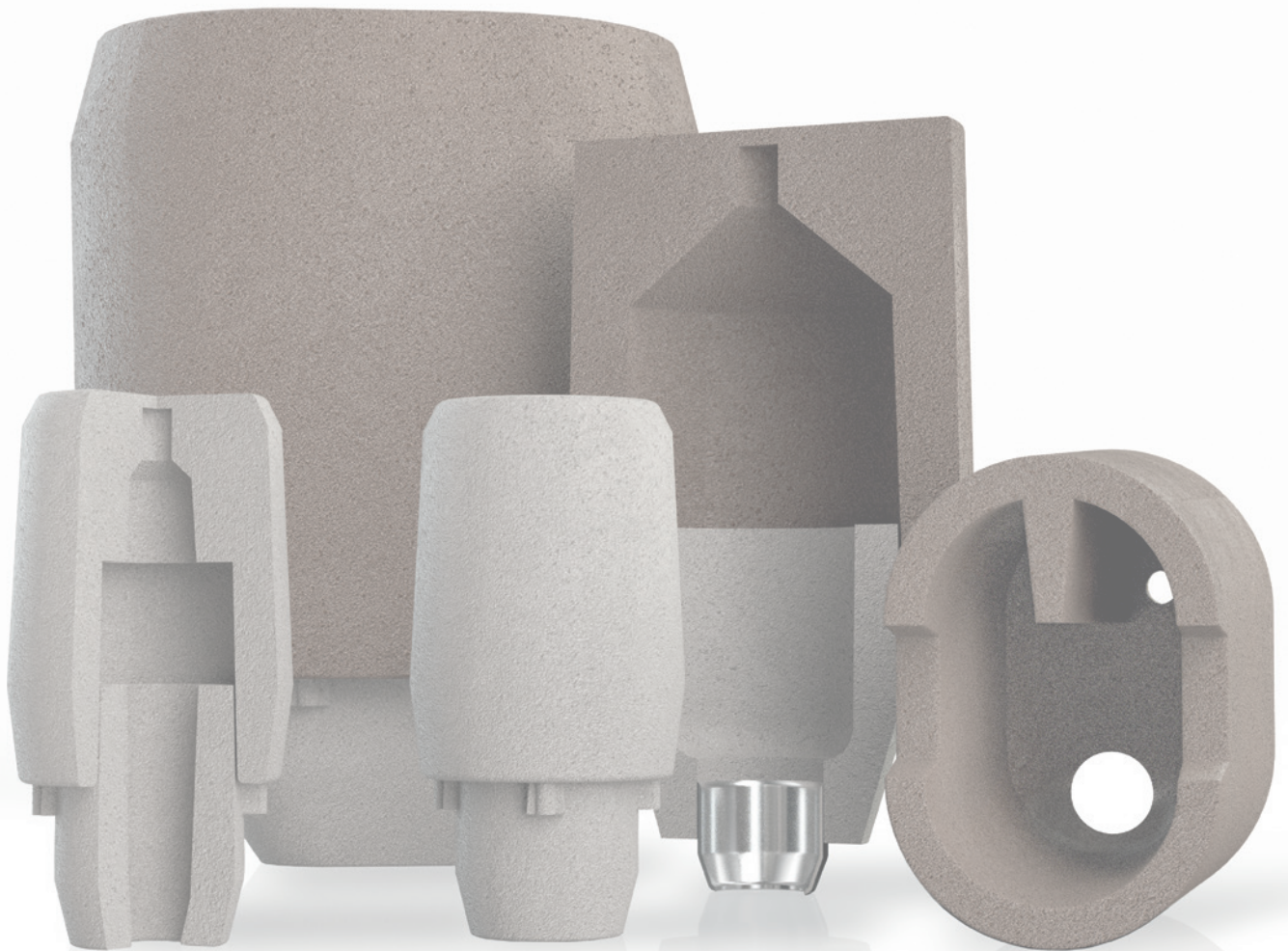


Product Information | Innovative Feeder Technology



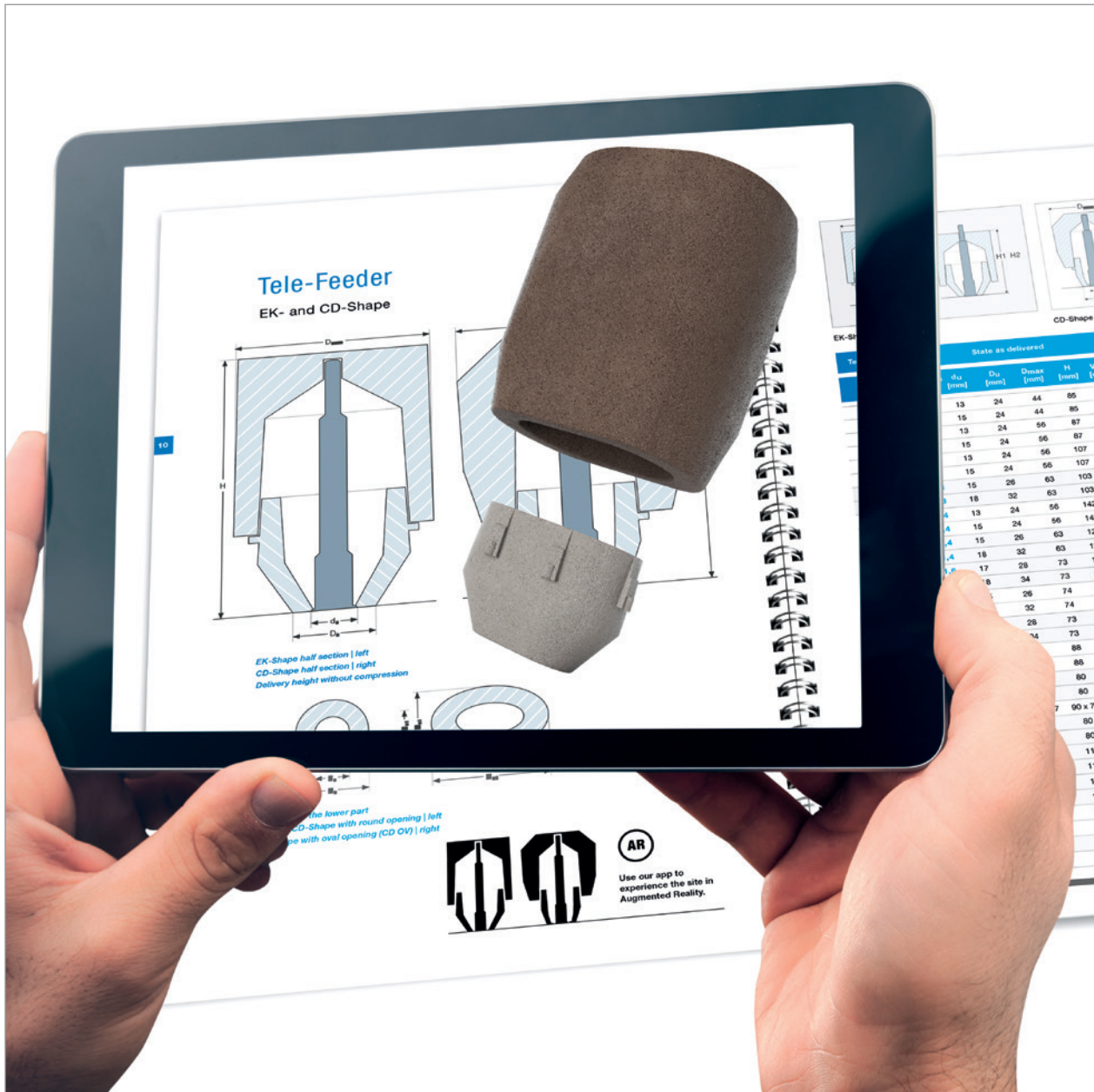
CHEMEX
Foundry Solutions GmbH
Member of Hilti Group

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 FOR HORIZONTAL PARTED
MOULDING LINES

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 FOR VERTICAL PARTED
MOULDING LINES



Technical drawings within the catalogue marked with this symbol are compatible with the new Chemex App.

The new mobile Chemex App

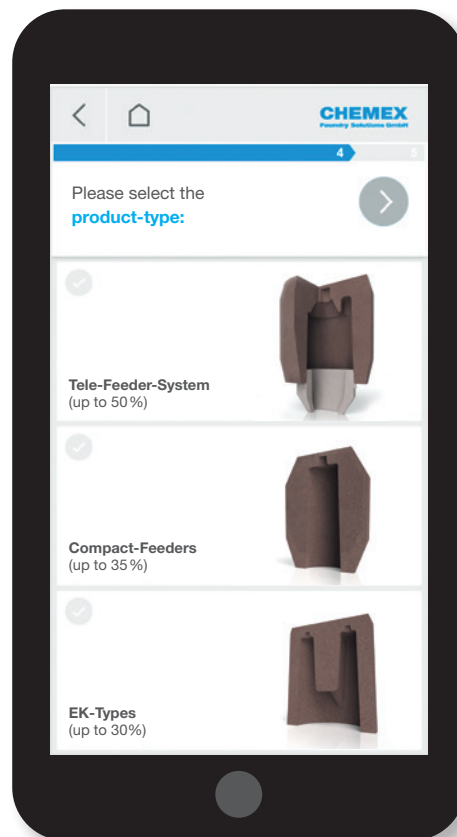
Find or visualise products quickly and easily

With this application for your smartphone or tablet, we primarily pursue two goals. On the one hand, the product finder enables you to quickly and easily find the right product depending on your moulding process and the alloy to be cast. On the other hand, products featuring an AR symbol in the catalogue can be displayed in 3D. With the help of modern Augmented Reality (AR) technology, the respective 2D drawings are also displayed in 3D.

As an innovative partner, we would like to support you in your everyday routine by

providing this service in the best possible way. At the same time, we are committed to the continuous further development and improvement of this application.

This is another step of many towards the foundry industry 4.0, an approach we are open to as a modern and progressive company. If you have any questions regarding use, suggestions or recommendations for improvement, please contact your responsible product manager or write to us at app@chemex.de.



[Download Chemex App](#)
Apple / Android



Chemex Animations

Our technologies simply explained

With our animations we try to gain a better understanding for our different feeding systems and to show some potential applications where they are used. Get inspired!

Our two-part **Tele-Feeder-System** is a Chemex invention and at the same time the flagship of our company. Technical information about this System can be found on page 8 up to 19.



With the **Tele-Side-Riser-System**, Chemex has redeveloped its own innovative telescopic technology. These changes will allow to use it also on vertically divided molding lines. More on the pages 44 to 47.

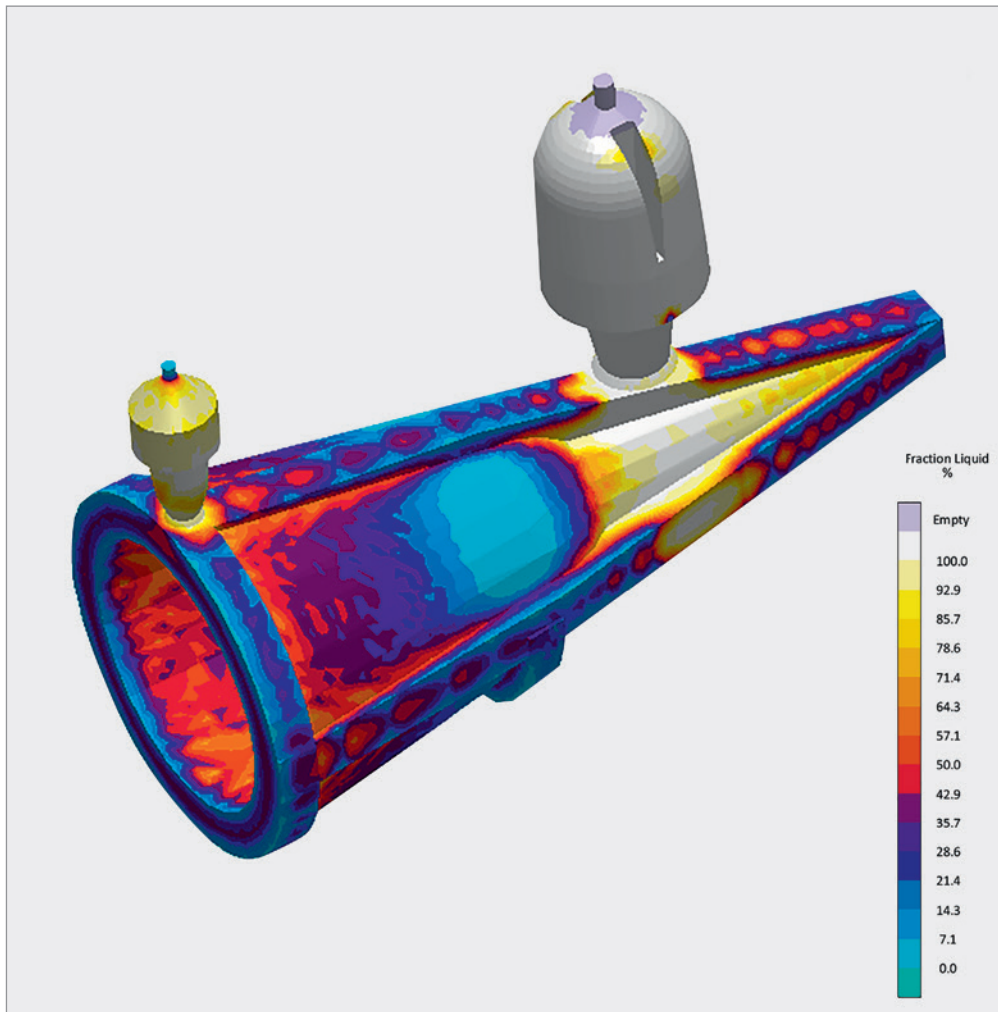
The **Side-Insert-Sleeve** is one of the latest developments of the Chemex Foundry Solutions GmbH. Technical information and details can be found on page 48 and 49.

Just scan the QR code on the right and see how our different feeders work!



Chemex Simulations

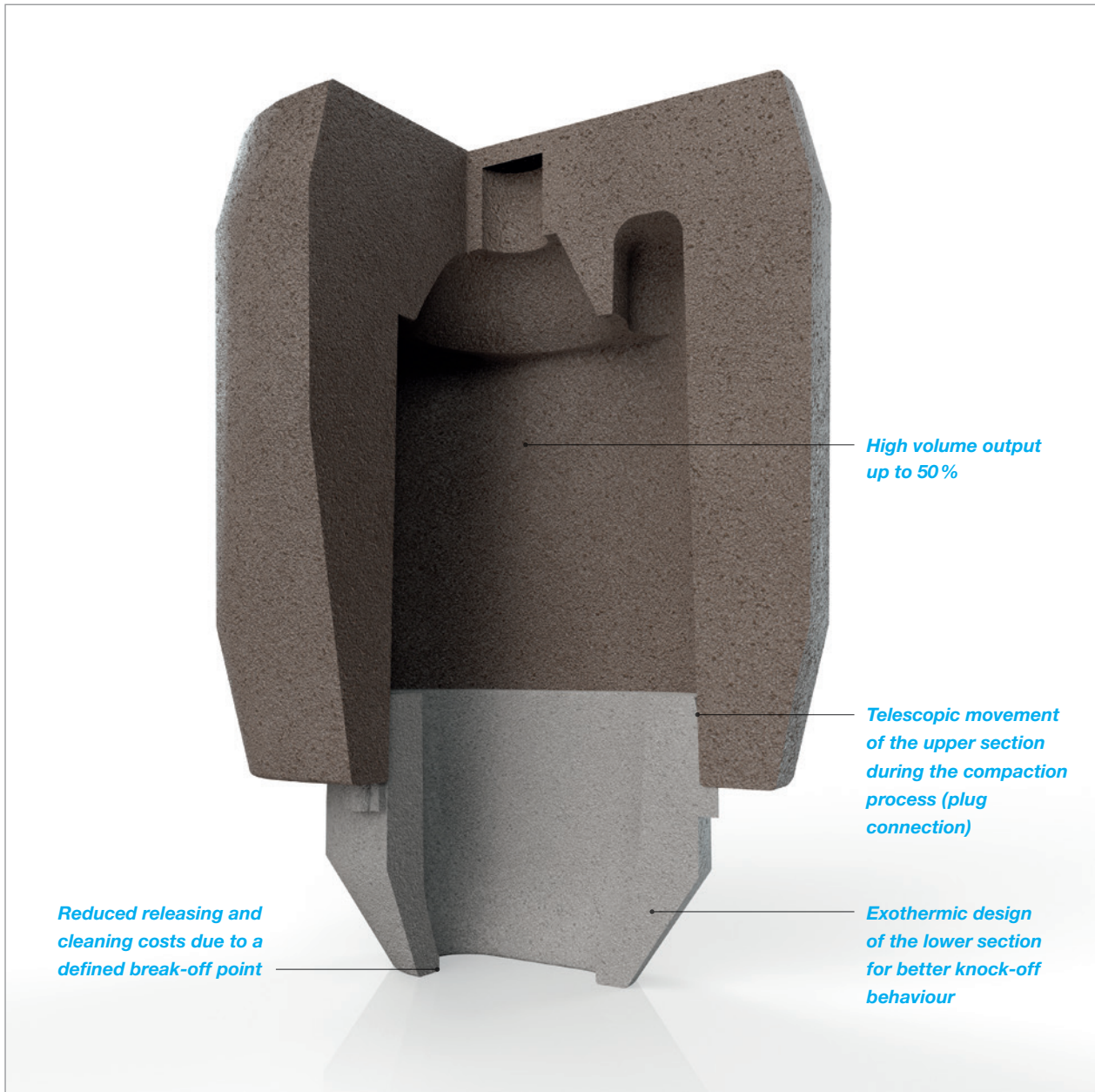
Effective customer communication with MAGMA



We have been offering our customers filling and solidification simulations for several years now. For these simulations we exclusively rely on our partner MAGMA. This allows a close productive technical discussion between customer and product manager. With MAGMAinteract® it is also possible for our customers to visualise and analyse the results without their own simulation license internally. Not only the result, also each phase of filling or solidification can

be visualised. In this way we can learn more about the causes of problems and try to achieve a deeper understanding of the individual and different process.

Are you interested in more detailed simulation discussion? Our simulation expert Dipl.-Ing. Markus Effmert is ready to support you at any time.



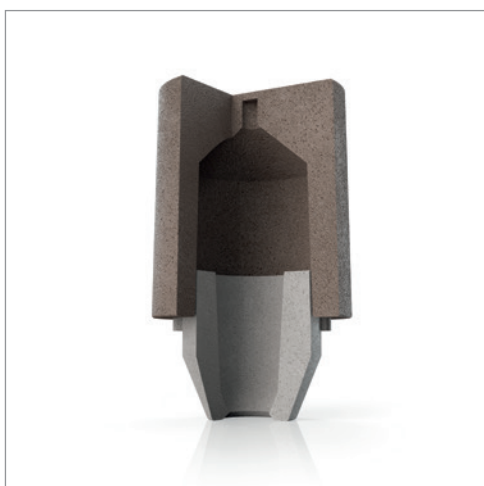
Tele-Feeder CD-Shape oval, sectional view

Tele-Feeder-System

The Tele-Feeder-System developed by Chemex has proven its worth especially in horizontally parted moulding lines regarding high pressure resistance.

After simply placing the feeder on the pattern plate, the upper section of the feeder slides telescopically over the lower section during the compaction process. This means that the lower section is practically not exposed to pressure, and therefore, damage.

At the same time, shifting the upper part leads to additional compaction of the moulding sand underneath (transition area between feeder and casting), precisely where shadows of poorly compacted sand may occur in other feeding systems. The range of applications of the Tele-Feeder-System has been extended over the years. This system is thus not only used for hand moulding, but also for all common alloys in the non-ferrous sector, for cast iron and steel casting.

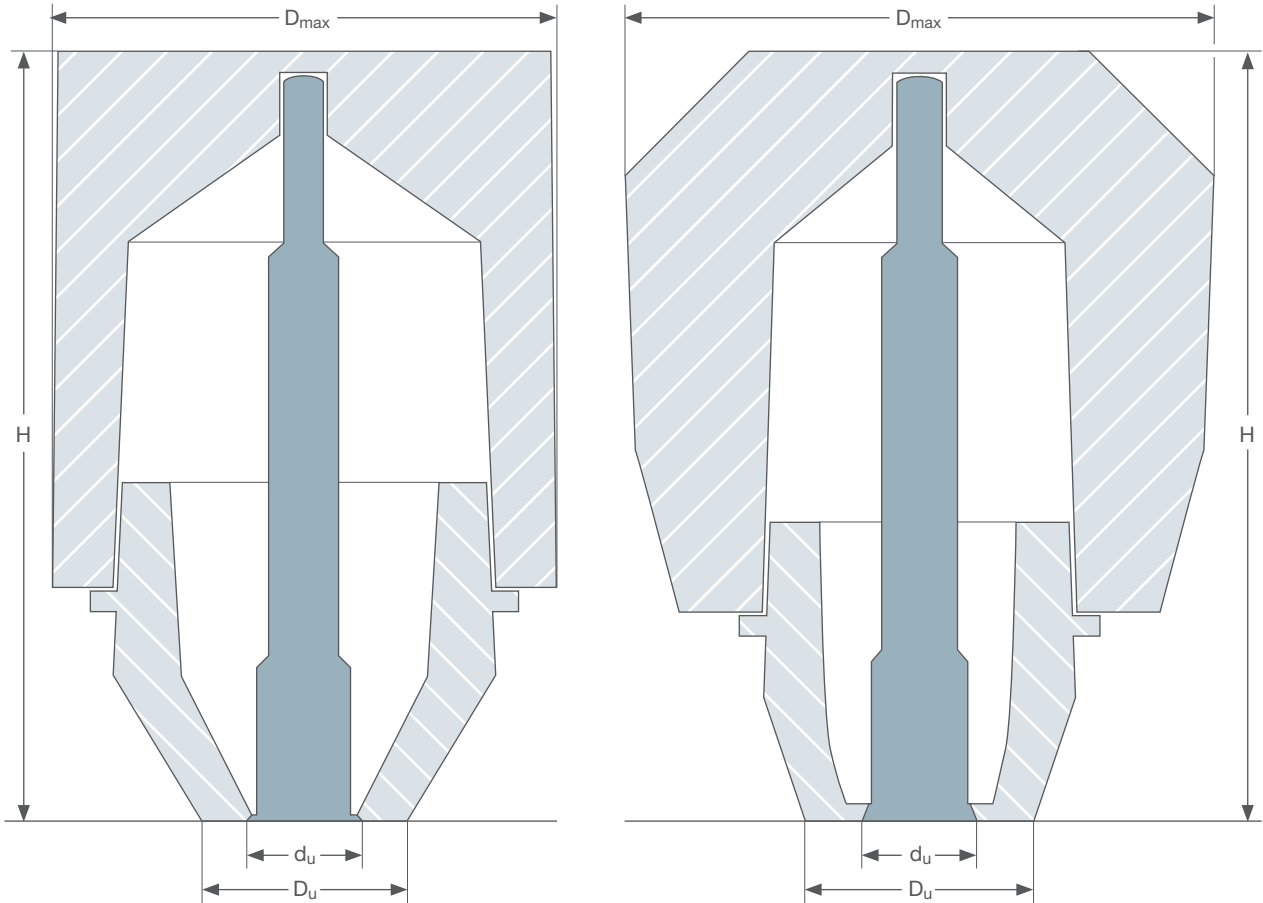


*Tele-Feeder EK-Shape standing | above
Tele-Feeder EK-Shape standing, sectional
view | below*

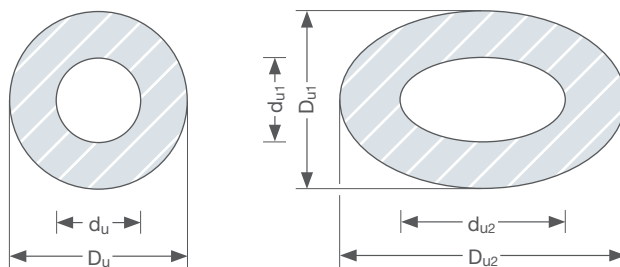
*Tele-Feeder CD-Shape standing | above
Tele-Feeder CD-Shape reclining | below*

Tele-Feeder

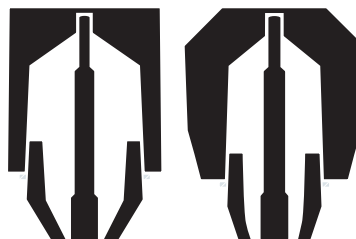
EK- and CD-Shape



*EK-Shape half section | left
CD-Shape half section | right
Delivery height without compression*

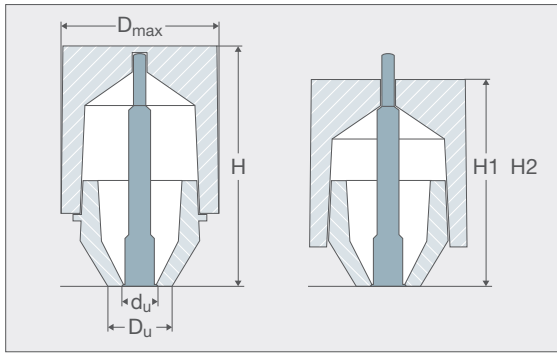


*Plan view of the lower part
EK- and CD-Shape with round opening | left
CD-Shape with oval opening (CD OV) | right*

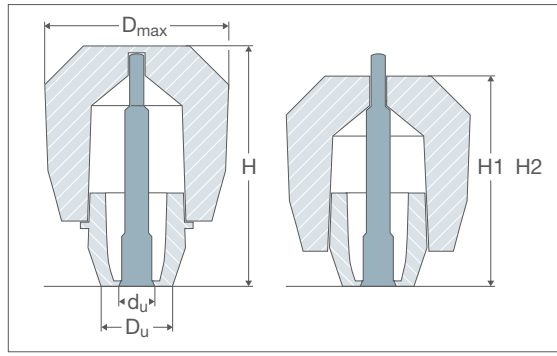


Use our app to
experience the site in
Augmented Reality.





EK-Shape



CD-Shape

Tele-Feeder	State as delivered						ΔH and ΔV after compression				Shape
							Middle	High			
Type	Modulus [cm]	d _u [mm]	D _u [mm]	D _{max} [mm]	H [mm]	Vol.* [cm ³]	H1 [mm]	Vol. 1** [cm ³]	H2 [mm]	Vol. 2** [cm ³]	
10- 13 (24)	0.8	13	24	44	85	23	70	14	70	14	CD
10- 15 (24)	0.8	15	24	44	85	23	70	14	70	14	CD
12- 13 (24)	0.9	13	24	56	87	29	72	20	67	16	CD
12- 15 (24)	0.9	15	24	56	87	29	72	20	67	16	CD
24- 13 (24)	1.0	13	24	56	107	38	92	28	87	25	CD
24- 15 (24)	1.0	15	24	56	107	38	92	28	87	25	CD
40- 15 (26)	1.3	15	26	63	103	61	88	43	83	37	EK
40- 18 (32)	1.3	18	32	63	103	61	88	43	83	37	EK
42- 13 (24)	1.4	13	24	56	142	50	127	41	122	38	CD
42- 15 (24)	1.4	15	24	56	142	50	127	41	122	38	CD
50- 15 (26)	1.4	15	26	63	127	70	112	52	107	46	EK
50- 18 (32)	1.4	18	32	63	127	70	112	52	107	46	EK
80- 17 (28)	1.6	17	28	73	115	111	100	80	90	60	EK
80- 18 (34)	1.6	18	34	73	115	111	100	80	90	60	EK
60- 15 (26)	1.7	15	26	74	140	87	125	69	120	63	CD
60- 18 (32)	1.7	18	32	74	140	87	125	69	120	63	CD
90- 17 (28)	1.7	17	28	73	135	136	120	105	110	86	EK
90- 18 (34)	1.7	18	34	73	135	136	120	105	110	86	EK
65- 15 (26)	1.8	15	26	88	140	87	125	69	120	63	CD
65- 18 (32)	1.8	18	32	88	140	87	125	69	120	63	CD
100- 18 (35)	1.9	18	35	80	132	149	112	96	102	73	EK
100- 25 (40)	1.9	25	40	80	132	149	112	96	102	73	EK
125- 32/14 B0	2.0	32 x 14	45 x 27	90 x 70	131	130	116	104	106	86	CD OV
180- 18 (35)	2.0	18	35	80	160	187	140	138	130	115	EK
180- 25 (40)	2.0	25	40	80	160	187	140	138	130	115	EK
190- 20 (40)	2.0	20	40	115	110	216	90	123	90	123	EK
190- 25 (40)	2.0	25	40	115	110	216	90	123	90	123	EK
190- 30 (46)	2.0	30	46	115	110	216	90	123	90	123	EK
190- 40 (64)	2.0	40	64	115	110	216	90	123	90	123	EK
91- 15 (26)	2.1	15	26	104	146	110	131	92	126	86	CD
91- 18 (32)	2.1	18	32	104	146	110	131	92	126	86	CD
195- 22 (38)	2.1	22	38	94	139	262	119	190	109	155	EK
95- 15 (26)	2.2	15	26	104	165	121	150	103	145	97	CD

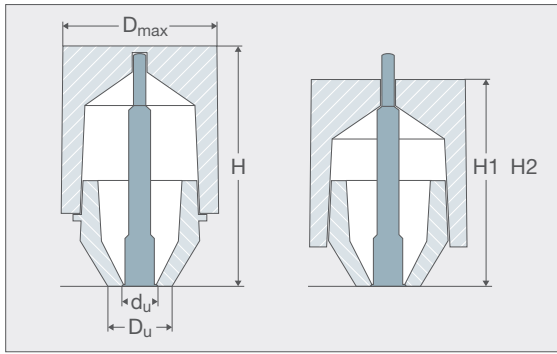
* Volume in state as delivered at feeder height H. | ** Volume after compression at feeder height H1/H2.

Tele-Feeder

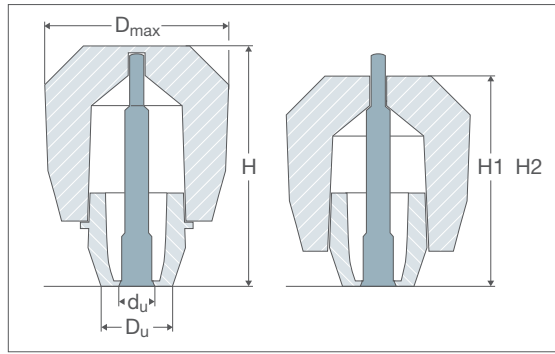
EK- and CD-Shape

Tele-Feeder	State as delivered						ΔH and ΔV after compression				
Type	Modulus [cm]	d _U [mm]	D _U [mm]	D _{max} [mm]	H [mm]	Vol.* [cm ³]	H1 [mm]	Vol. 1** [cm ³]	H2 [mm]	Vol. 2** [cm ³]	Shape
95- 18 (32)	2.2	18	32	104	165	121	150	103	145	97	CD
120- 18 (35)	2.2	18	35	94	139	166	119	117	109	94	EK
120- 25 (40)	2.2	25	40	94	139	166	119	117	109	94	EK
302- 22 (38)	2.2	22	38	94	168	346	148	276	138	242	EK
140- 17 (28)	2.3	17	28	115	155	175	135	135	130	126	CD
140- 18 (34)	2.3	18	34	115	155	175	135	135	130	126	CD
220- 20 (40)	2.3	20	40	104	157	369	137	274	127	227	EK
220- 25 (40)	2.3	25	40	104	157	369	137	274	127	227	EK
220- 30 (46)	2.3	30	46	104	157	369	137	274	127	227	EK
220- 40 (64)	2.3	40	64	104	157	369	137	274	127	227	EK
170- 18 (35)	2.4	18	35	126	165	217	145	169	135	145	CD
170- 25 (40)	2.4	25	40	126	165	217	145	169	135	145	CD
210- 30/20 OV	2.4	30 x 20	50 x 34	120 x 90	155	264	140	220	130	191	CD OV
210- 40/20 OV	2.4	40 x 20	50 x 34	120 x 90	155	264	140	220	130	191	CD OV
280- 20 (40)	2.4	20	40	104	187	460	167	365	157	319	EK
280- 25 (40)	2.4	25	40	104	187	460	167	365	157	319	EK
280- 30 (46)	2.4	30	46	104	187	460	167	365	157	319	EK
280- 40 (64)	2.4	40	64	104	187	460	167	365	157	319	EK
320- 30/20 OV	2.6	30 x 20	50 x 34	120 x 90	195	357	180	313	170	283	CD OV
320- 40/20 OV	2.6	40 x 20	50 x 34	120 x 90	195	357	180	313	170	283	CD OV
330- 30 (52)	2.6	30	52	128	120	323	100	181	100	181	EK
330- 40 (52)	2.6	40	52	128	120	323	100	181	100	181	EK
330- 40 (70)	2.6	40	70	128	120	323	100	181	100	181	EK
330- 40 (90)	2.6	40	90	128	120	323	100	181	100	181	EK
330- 40 / 20	2.6	40 x 20	52 x 32	128	120	323	100	181	100	181	EK ov
295- 20 (40)	2.7	20	40	115	207	582	182	464	172	418	EK
295- 25 (40)	2.7	25	40	115	207	582	182	464	172	418	EK
295- 30 (46)	2.7	30	46	115	207	582	182	464	172	418	EK
295- 40 (64)	2.7	40	64	115	207	582	182	464	172	418	EK
290- 30 (52)	2.8	30	52	128	155	480	130	303	120	234	EK
290- 40 (52)	2.8	40	52	128	155	480	130	303	120	234	EK
290- 40 (70)	2.8	40	70	128	155	480	130	303	120	234	EK
290- 40 (90)	2.8	40	90	128	155	480	130	303	120	234	EK
290- 40 / 20	2.8	40 x 20	52 x 32	128	155	480	130	303	120	234	EK ov
175- 17 (28)	3.0	17	28	133	173	207	153	167	148	158	CD
175- 18 (34)	3.0	18	34	133	173	207	153	167	148	158	CD

* Volume in state as delivered at feeder height H. | ** Volume after compression at feeder height H1/H2.



EK-Shape



CD-Shape

Tele-Feeder	State as delivered						ΔH and ΔV after compression				
							Middle		High		
Type	Modulus [cm]	d _u [mm]	D _u [mm]	D _{max} [mm]	H [mm]	Vol.* [cm ³]	H1 [mm]	Vol. 1** [cm ³]	H2 [mm]	Vol. 2** [cm ³]	Shape
225- 20 (40)	3.0	20	40	128	157	369	132	251	122	204	EK
225- 25 (40)	3.0	25	40	128	157	369	132	251	122	204	EK
225- 30 (46)	3.0	30	46	128	157	369	132	251	122	204	EK
225- 40 (64)	3.0	40	64	128	157	369	132	251	122	204	EK
300- 30 (52)	3.0	30	52	128	178	606	153	429	143	360	EK
300- 40 (52)	3.0	40	52	128	178	606	153	429	143	360	EK
300- 40 (70)	3.0	40	70	128	178	606	153	429	143	360	EK
300- 40 (90)	3.0	40	90	128	178	606	153	429	143	360	EK
300- 40 / 20	3.0	40 x 20	52 x 32	128	178	606	153	429	143	360	EK ov
370- 25 (40)	3.2	25	40	115	189	460	164	342	154	295	CD
370- 30 (46)	3.2	30	46	115	189	460	164	342	154	295	CD
370- 40 (64)	3.2	40	64	115	189	460	164	342	154	295	CD
310- 30 (52)	3.2	30	52	128	178	526	153	349	143	279	EK
310- 40 (52)	3.2	40	52	128	178	526	153	349	143	279	EK
310- 40 (70)	3.2	40	70	128	178	526	153	349	143	279	EK
310- 40 (90)	3.2	40	90	128	178	526	153	349	143	279	EK
310- 40 / 20	3.2	40 x 20	52 x 32	128	178	526	153	349	143	279	EK ov
500- 40 (62)	3.2	40	62	155	157	749	132	484	122	379	EK
500- 50 (80)	3.2	50	80	155	157	749	132	484	122	379	EK
500- 60 (80)	3.2	60	80	155	157	749	132	484	122	379	EK
500- 70 (98)	3.2	70	98	155	157	749	132	484	122	379	EK
500- 45 / 20	3.2	45 x 20	70 x 45	155	157	749	132	484	122	379	EK
510- 45 / 20	3.3	45 x 20	70 x 45	160 x 110	175	666	150	486	140	416	CD OV
510- 45 / 30	3.3	45 x 30	70 x 45	160 x 110	175	666	150	486	140	416	CD OV
450- 30 (52)	3.3	30	52	128	195	623	170	446	160	376	EK
450- 40 (52)	3.3	40	52	128	195	623	170	446	160	376	EK
450- 40 (70)	3.3	40	70	128	195	623	170	446	160	376	EK
450- 40 (90)	3.3	40	90	128	195	623	170	446	160	376	EK
450- 40 / 20	3.3	40 x 20	52 x 32	128	195	623	170	446	160	376	EK ov
700- 30 (52)	3.3	30	52	128	215	830	190	653	180	584	EK
700- 40 (52)	3.3	40	52	128	215	830	190	653	180	584	EK
700- 40 (70)	3.3	40	70	128	215	830	190	653	180	584	EK

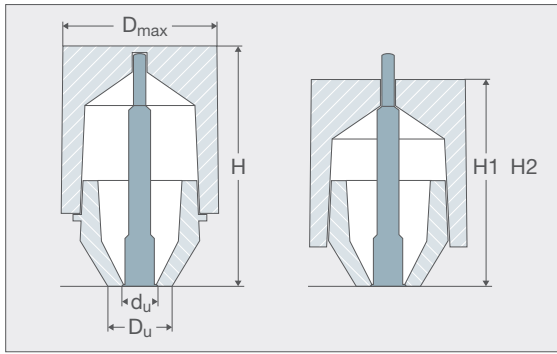
* Volume in state as delivered at feeder height H. | ** Volume after compression at feeder height H1/H2.

Tele-Feeder

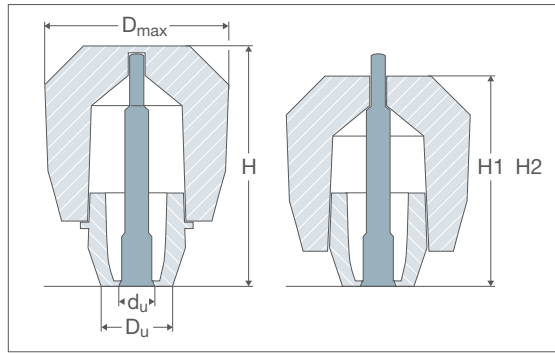
EK- and CD-Shape

Tele-Feeder	State as delivered						ΔH and ΔV after compression				
Type	Modulus [cm]	d _U [mm]	D _U [mm]	D _{max} [mm]	H [mm]	Vol.* [cm ³]	H1 [mm]	Vol. 1** [cm ³]	H2 [mm]	Vol. 2** [cm ³]	Shape
700- 40 (90)	3.3	40	90	128	215	830	190	653	180	584	EK
700- 40 / 20	3.3	40 x 20	52 x 32	128	215	830	190	653	180	584	EK ov
250- 20 (40)	3.4	20	40	128	180	369	155	251	145	204	EK
250- 25 (40)	3.4	25	40	128	180	369	155	251	145	204	EK
250- 30 (46)	3.4	30	46	128	180	369	155	251	145	204	EK
250- 40 (64)	3.4	40	64	128	180	369	155	251	145	204	EK
390- 25 (40)	3.5	25	40	146	197	554	172	436	162	389	CD
390- 30 (46)	3.5	30	46	146	197	554	172	436	162	389	CD
390- 40 (64)	3.5	40	64	146	197	554	172	436	162	389	CD
710- 45 / 20	3.5	45 x 20	70 x 45	160 x 110	215	890	190	712	180	641	CD OV
710- 45 / 30	3.5	45 x 30	70 x 45	160 x 110	215	890	190	712	180	641	CD OV
850- 40 (62)	3.7	40	62	155	197	1023	172	758	162	654	EK
850- 50 (80)	3.7	50	80	155	197	1023	172	758	162	654	EK
850- 60 (80)	3.7	60	80	155	197	1023	172	758	162	654	EK
850- 70 (98)	3.7	70	98	155	197	1023	172	758	162	654	EK
850- 45 / 20	3.7	45 x 20	70 x 45	155	197	1023	172	758	162	654	EK ov
1200- 40 (62)	4.0	40	62	155	247	1354	222	1089	212	984	EK
1200- 50 (80)	4.0	50	80	155	247	1354	222	1089	212	984	EK
1200- 60 (80)	4.0	60	80	155	247	1354	222	1089	212	984	EK
1200- 70 (98)	4.0	70	98	155	247	1354	222	1089	212	984	EK
1200- 45 / 20	4.0	45 x 20	70 x 45	155	247	1354	222	1089	212	984	EK ov
820- 30 (52)	4.2	30	52	190	220	944	195	764	185	694	CD
820- 40 (52)	4.2	40	52	190	220	944	195	764	185	694	CD
820- 40 (70)	4.2	40	70	190	220	944	195	764	185	694	CD
820- 40 (90)	4.2	40	90	190	220	944	195	764	185	694	CD
820- 40 / 20	4.2	40 x 20	52 x 32	190	220	944	195	764	185	694	CD ov
660- 30 (52)	4.3	30	52	190	255	849	230	670	220	600	CD
660- 40 (52)	4.3	40	52	190	255	849	230	670	220	600	CD
660- 40 (70)	4.3	40	70	190	255	849	230	670	220	600	CD
660- 40 / 20	4.3	40 x 20	52 x 32	190	255	849	230	670	220	600	CD ov
660- 40 (90)	4.3	40	90	190	255	849	230	670	220	600	CD
960- 30 (52)	4.3	30	52	190	255	1074	230	895	220	824	CD
960- 40 (52)	4.3	40	52	190	255	1074	230	895	220	824	CD
960- 40 (70)	4.3	40	70	190	255	1074	230	895	220	824	CD
960- 40 (90)	4.3	40	90	190	255	1074	230	895	220	824	CD
960- 40 / 20	4.3	40 x 20	52 x 32	190	255	1074	230	895	220	824	CD ov

* Volume in state as delivered at feeder height H. | ** Volume after compression at feeder height H1/H2.



EK-Shape



CD-Shape

Tele-Feeder	State as delivered					ΔH and ΔV after compression				Shape	
	Modulus [cm]	d _u [mm]	D _u [mm]	D _{max} [mm]	H [mm]	Vol.* [cm ³]	H1 [mm]	Vol. 1** [cm ³]	H2 [mm]		Vol. 2** [cm ³]
1100- 50 (80)	4.7	50	80	225	217	1322	192	1057	182	952	CD
1100- 60 (80)	4.7	60	80	225	217	1322	192	1057	182	952	CD
1100- 70 (98)	4.7	70	98	225	217	1322	192	1057	182	952	CD
1100- 45 / 20	4.7	45 x 20	70 x 45	225	217	1322	192	1057	182	952	CD ov
1600- 40 (62)	5.0	40	62	225	277	1785	252	1520	242	1415	CD
1600- 50 (80)	5.0	50	80	225	277	1785	252	1520	242	1415	CD
1600- 60 (80)	5.0	60	80	225	277	1785	252	1520	242	1415	CD
1600- 70 (98)	5.0	70	98	225	277	1785	252	1520	242	1415	CD
1600- 45 / 20	5.0	45 x 20	70 x 45	225	277	1785	252	1520	242	1415	CD ov
2400- 65 (100)	5.0	65	100	290	220	3243	190	2574	180	2354	CD
2400- 100 / 45	5.0	100 x 45	135 x 80	290	220	3243	190	2574	180	2354	CD ov
2000- 40 (62)	5.4	40	62	225	307	2085	282	1820	272	1715	CD
2000- 50 (80)	5.4	50	80	225	307	2085	282	1820	272	1715	CD
2000- 60 (80)	5.4	60	80	225	307	2085	282	1820	272	1715	CD
2000- 70 (98)	5.4	70	98	225	307	2085	282	1820	272	1715	CD
2000- 45 / 20	5.4	45 x 20	70 x 45	225	307	2085	282	1820	272	1715	CD ov
5300- 165 / 65	5.6	165 x 65	200 x 100	360 x 260	240	5965	210	4812	200	4433	CD OV
3600- 65 (100)	5.8	65	100	290	310	4227	280	3559	270	3338	CD
3600- 100 / 45	5.8	100 x 45	135 x 80	290	310	4227	280	3559	270	3338	CD ov
7400- 165 / 65	6.4	165 x 65	200 x 100	360 x 260	310	8535	280	7372	270	6990	CD OV
6600- 165 / 65	6.6	165 x 65	200 x 100	360 x 260	310	7707	280	6541	270	6157	CD OV
7800- 165 / 65	7.0	165 x 65	200 x 100	410 x 260	310	9450	280	8025	270	7553	CD OV
9900- 100 (160)	8.6	100	160	400	310	11610	280	9792	270	9187	CD

* Volume in state as delivered at feeder height H. | ** Volume after compression at feeder height H1/H2.

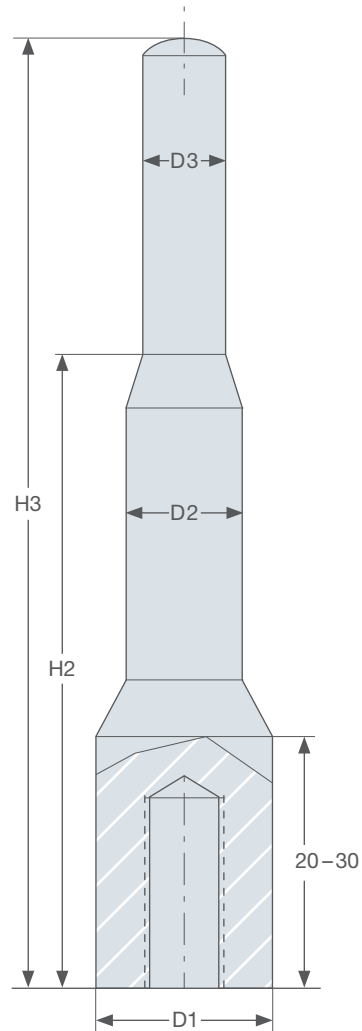
Pin cylindrical

Maintenance-free positioning aid for the Tele-Feeder-System

Pin cylindrical					
Type	D1 [mm]	D2 [mm]	D3 [mm]	H2 [mm]	H3 [mm]
10- 13	12.5	12	5,7	50	81
10- 15	14.5	14	5,7	50	81
12- 13	12.5	12	6,5	50	83
12- 15	14.5	14	6,5	50	83
24- 13	12.5	12	6,5	70	103
24- 15	14.5	14	6,5	70	103
40- 15	14.5	14	7,5	65	99
42- 13	12.5	12	7,5	110	137
42- 15	14.5	14	7,5	110	137
50- 15	14.5	14	7,5	87	123
60- 15	14.5	14	7,5	105	135
65- 15	14.5	14	7,5	102	132
80- 17	16.5	16	7,5	70	110
80- 18	17.5	17	7,5	70	110
90- 17	16.5	16	7,5	90	130
90- 18	17.5	17	7,5	90	130
91- 15	14.5	14	9,5	105	141
95- 15	14.5	14	9,5	125	160
100- 18	17.5	17	7,5	78	128
100- 25	24	20	7,5	78	128
120- 18	17.5	17	7,5	95	134
120- 25	24	20	7,5	95	134
140- 17	16.5	16	11,5	107	150
140- 18	17.5	16	11,5	107	150
170- 18	17.5	16	11,5	125	168
170- 25	24	20	11,5	125	168
175- 17	16.5	16	11,5	125	168
175- 18	17.5	16	11,5	125	168
180- 18	17.5	17	9,5	108	155
180- 25	24	20	9,5	108	155
190- 20	19.5	19	9,5	75	105
190- 25	24	20	9,5	75	105
190- 30	29	25	9,5	75	105
190- 40	39	30	9,5	75	105
195- 22	21	20	7,5	95	135
220- 20	19.5	18	11,5	95	152

Pin cylindrical					
Type	D1 [mm]	D2 [mm]	D3 [mm]	H2 [mm]	H3 [mm]
220- 25	24	20	11.5	95	152
220- 30	29	25	11.5	95	152
220- 40	39	30	11.5	95	152
225- 20	19,5	19	11.5	95	152
225- 25	24	20	11.5	95	152
225- 30	29	25	11.5	95	152
225- 40	39	30	11.5	95	152
250- 20	19,5	18	11.5	120	175
250- 25	24	20	11.5	120	175
250- 30	29	25	11.5	120	175
250- 40	39	30	11.5	120	175
280- 20	19,5	18	11.5	135	182
280- 25	24	20	11.5	135	182
280- 30	29	25	11.5	135	182
280- 40	39	25	11.5	135	182
290- 30	29	25	11.5	100	150
290- 40	39	25	11.5	100	150
295- 20	19,5	18	11.5	145	202
295- 25	24	20	11.5	145	202
295- 30	29	25	11.5	145	202
295- 40	39	30	11.5	145	202
300- 30	29	25	11,5	120	173
300- 40	39	25	11.5	120	173
310- 30	29	25	11.5	120	173
310- 40	39	30	11.5	120	173
330- 30	29	25	11.5	60	115
330- 40	39	35	11.5	60	115
370- 25	24	20	11.5	135	185
370- 30	29	25	11.5	135	185
370- 40	39	30	11.5	135	185
390- 25	24	20	13.5	140	192
390- 30	29	25	13.5	140	192
390- 40	39	35	13.5	140	192
450- 30	29	25	11.5	140	190
450- 40	39	35	11.5	140	190
500- 40	39	35	11.5	100	152

Pin cylindrical					
Type	D1 [mm]	D2 [mm]	D3 [mm]	H2 [mm]	H3 [mm]
500- 50	49	40	11.5	100	152
500- 60	59	50	11.5	100	152
500- 70	69	60	11.5	100	152
660- 30	29	25	19	185	249
660- 40	39	30	19	185	249
700- 30	29	25	11.5	160	210
700- 40	39	30	11.5	160	210
820- 30	29	25	19	154	212
820- 40	39	30	19	154	212
850- 40	39	34	11.5	130	192
850- 50	49	34	11.5	130	192
850- 60	59	34	11.5	130	192
850- 70	69	34	11.5	130	192
960- 30	29	25	19	185	249
960- 40	39	30	19	185	249
1100- 40	39	30	19	140	211
1100- 50	49	40	19	140	211
1100- 60	59	40	19	140	211
1100- 70	69	40	19	140	211
1200- 40	39	35	15	185	242
1200- 50	49	35	15	185	242
1200- 60	59	35	15	185	242
1200- 70	69	35	15	185	242
1600- 40	39	35	15	210	272
1600- 50	49	40	15	210	272
1600- 60	59	40	15	210	272
1600- 70	69	40	15	210	272
2000- 40	39	35	19	240	302
2000- 50	49	40	19	240	302
2000- 60	59	50	19	240	302
2000- 70	69	60	19	240	302
2400- 65	64	50	19	140	215
3600- 65	64	50	19	230	304
9900- 100	99	56	28	230	303

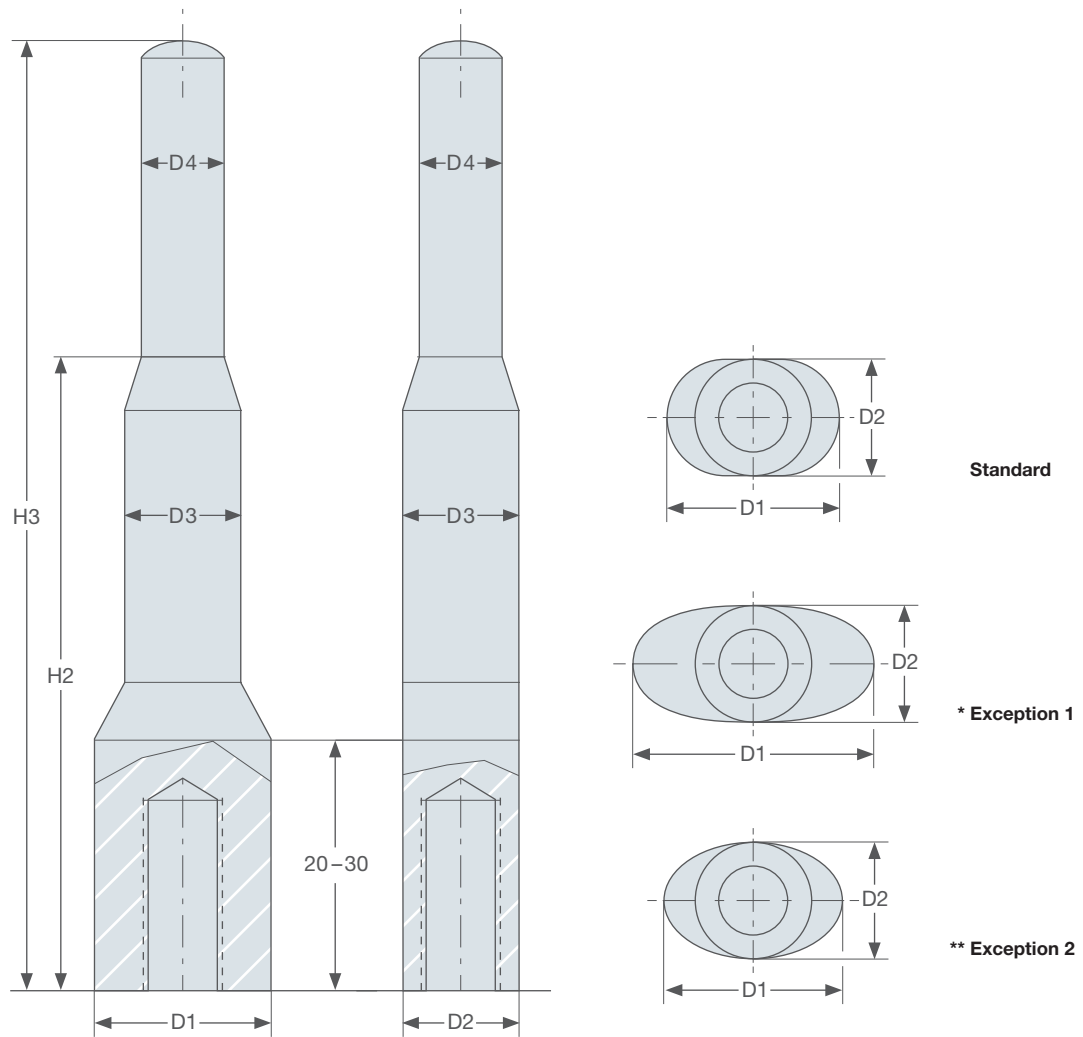


Tolerances				
D1	D2	D3	H2	H3
H8	H8	H8	H13	H13

Chemex delivers the pins without a thread.

Pin oval

Maintenance-free positioning aid for the Tele-Feeder-System

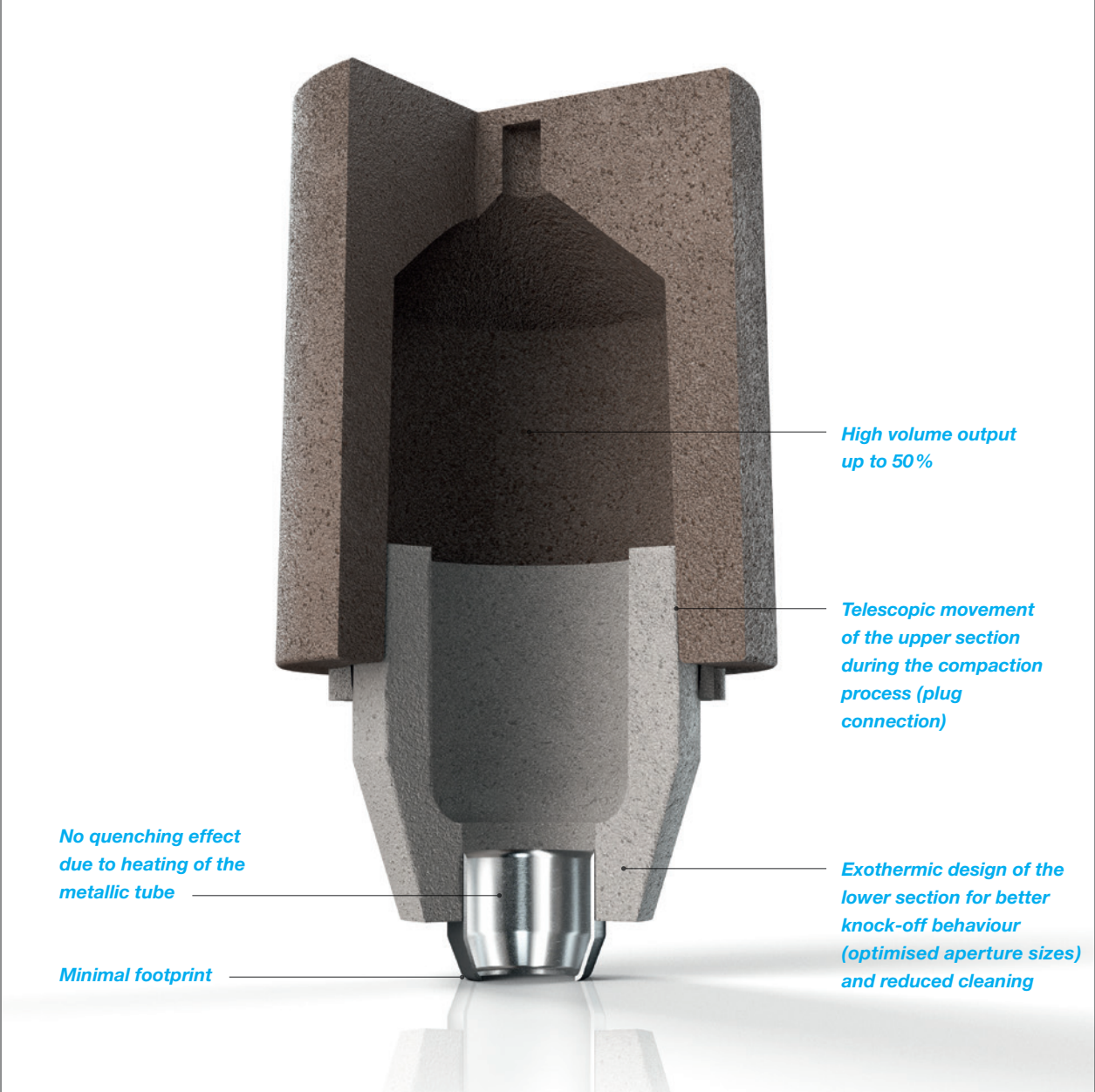


Pin oval

Type	D1 [mm]	D2 [mm]	D3 [mm]	D4 [mm]	H2 [mm]	H3 [mm]
125- 32/14	31	13	13	9.5	75	125
210- 30/20*	29	19	19	13	100	150
210- 40/20**	39	19	19	13	100	150
290- 40/20	39	19	19	11.5	100	150
300- 40/20	39	19	19	11.5	120	173
310- 40/20	39	19	19	11.5	120	173
320- 30/20*	29	19	15	13	140	190
320- 40/20**	39	19	15	13	140	190
330- 40/20	39	19	19	11.5	60	115
450- 40/20	39	19	19	11.5	140	190
500- 45/20	44	19	18	11.5	100	152
510- 45/20	44	19	18	11.5	100	152
510- 45/30	44	29	28	11.5	100	152
660- 40/20	39	19	19	19	185	249
700- 40/20	39	19	19	11.5	160	210
710- 45/20	44	19	19	11.5	160	210
1100- 45/20	44	19	19	19	140	211
1200- 45/20	44	19	19	15	185	242
1600- 45/20	44	19	19	15	210	272
2000- 45/20	44	19	19	19	240	302
2400- 100/45	99	44	42	19	140	215
3600- 100/45	99	44	42	19	230	304
5300- 165/65	164	64	60	29	160	234
6600- 165/65	164	64	60	29	230	304
7400- 165/65	164	64	60	29	230	304
7800- 165/65	164	64	60	29	230	304

Tolerances

D1	D2	D3	D4	H2	H3
H8	H8	H8	H8	H13	H13



Tele-MT-System EK-Shape sectional view

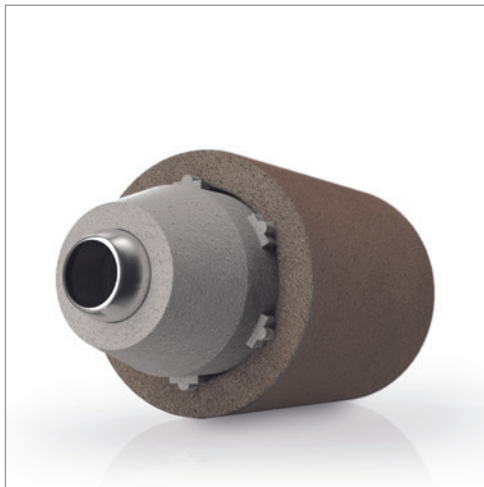
Tele-MT-System

The Tele-MT-System was successfully introduced in foundries throughout Europe as a logical further development of the Tele-Feeder-System. The special feature of the MT-Type is a metallic tube positioned in the lower section of the Tele-Feeder.

With the design of the MT-Type, the already small footprint of the Tele-Feeder

has been further reduced by another 37 % with almost unchanged feeder neck diameter.

This reduction provides foundries with significantly improved possibilities of application on sophisticated casting contours, combined with a very clean break-off point at casting surface level.



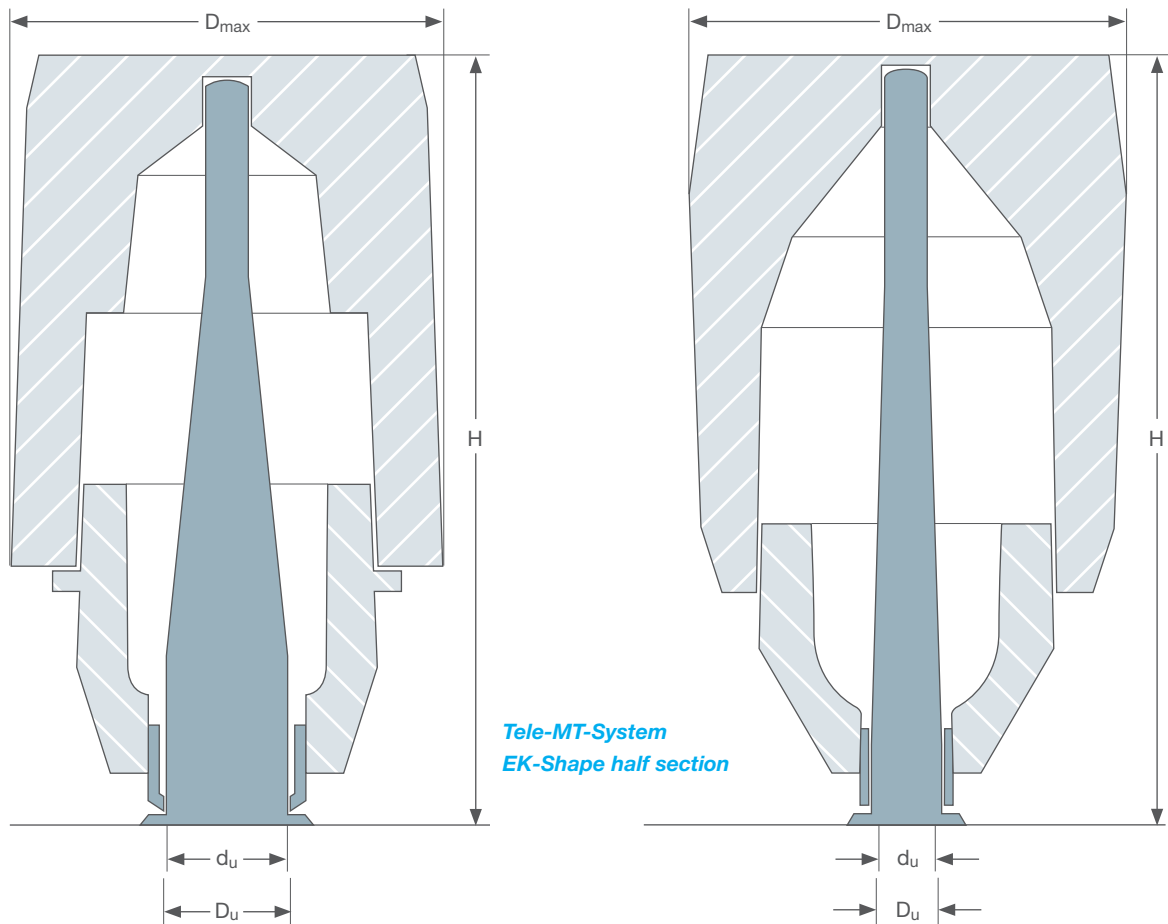
Tele-MT-System reclining



Tele-MT-System standing

Tele-MT-System

Minimal footprint



Tele-MT-System	State as delivered						ΔH and ΔV after compression				Shape
	Modulus [cm]	d _u [mm]	D _u [mm]	D _{max} [mm]	H [mm]	Vol.* [cm ³]	H1 [mm]	Vol. 1** [cm ³]	H2 [mm]	Vol. 2** [cm ³]	
80- 18 MT	1.6	18	19	73	120	118	105	87	95	67	EK-MT
80- 23 MT	1.6	23	24	73	120	118	105	87	95	67	EK-MT
90- 18 MT	1.7	18	19	73	140	143	125	113	115	92	EK-MT
90- 23 MT	1.7	23	24	73	140	143	125	113	115	92	EK-MT
100- 18 MT	1.9	18	19	80	142	162	122	114	112	90	EK-MT
100- 23 MT	1.9	23	24	80	142	162	122	114	112	90	EK-MT
100- 30 MT	1.9	30	31	80	140	162	120	114	110	90	EK-MT
180- 18 MT	2.0	18	19	80	170	204	150	155	140	132	EK-MT
180- 23 MT	2.0	23	24	80	170	204	150	155	140	132	EK-MT
180- 30 MT	2.0	30	31	80	168	204	148	155	138	132	EK-MT
190- 18 MT	2.0	18	19	115	120	218	100	124	100	124	EK-MT
190- 23 MT	2.0	23	24	115	120	218	100	124	100	124	EK-MT

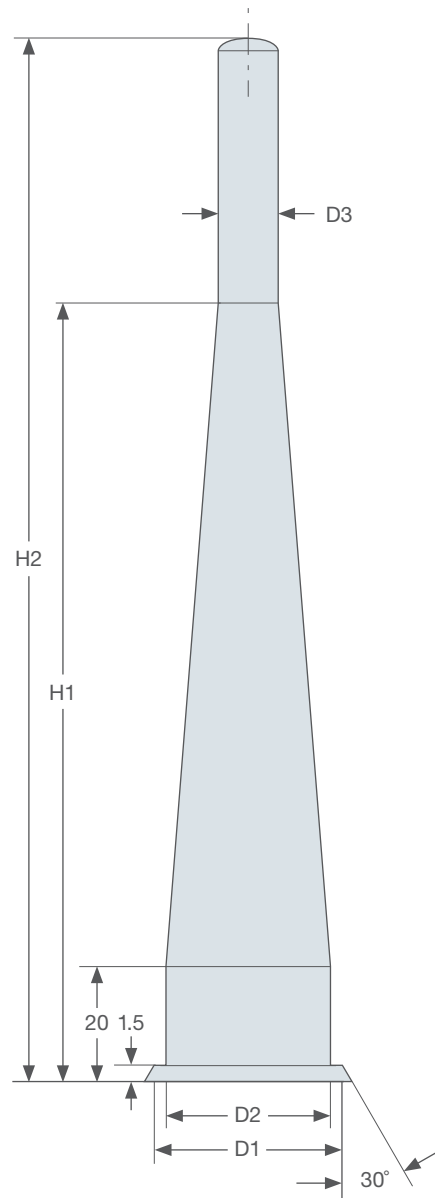


Tele-MT-System	State as delivered						ΔH and ΔV after compression				Shape
	Type	Modulus [cm]	d _U [mm]	D _U [mm]	D _{max} [mm]	H [mm]	Vol.* [cm ³]	H1 [mm]	Vol. 1** [cm ³]	H2 [mm]	
190- 30 MT	2.0	30	31	115	118	218	98	124	98	124	EK-MT
190- 40 MT	2.0	40	41	115	111	218	91	124	91	124	EK-MT
120- 18 MT	2.2	18	19	94	149	183	129	134	119	111	EK-MT
120- 23 MT	2.2	23	24	94	149	183	129	134	119	111	EK-MT
120- 30 MT	2.2	30	31	94	147	183	127	134	117	111	EK-MT
140- 18 MT	2.3	18	19	115	160	182	140	142	135	132	CD-MT
140- 23 MT	2.3	23	24	115	160	182	140	142	135	132	CD-MT
220- 18 MT	2.3	18	19	104	167	370	147	276	137	229	EK-MT
220- 23 MT	2.3	23	24	104	167	370	147	276	137	229	EK-MT
220- 30 MT	2.3	30	31	104	165	370	145	276	135	229	EK-MT
220- 40 MT	2.3	40	41	104	158	370	138	276	128	229	EK-MT
170- 18 MT	2.4	18	19	126	175	234	155	186	145	162	CD-MT
170- 23 MT	2.4	23	24	126	175	234	155	186	145	162	CD-MT
170- 30 MT	2.4	30	31	126	173	234	153	186	143	162	CD-MT
280- 18 MT	2.4	18	19	104	197	462	177	367	167	321	EK-MT
280- 23 MT	2.4	23	24	104	197	462	177	367	167	321	EK-MT
280- 30 MT	2.4	30	31	104	195	462	175	367	165	321	EK-MT
280- 40 MT	2.4	40	41	104	188	462	168	367	158	321	EK-MT
295- 18 MT	2.7	18	19	115	217	583	190	456	180	410	EK-MT
295- 23 MT	2.7	23	24	115	217	583	190	456	180	410	EK-MT
295- 30 MT	2.7	30	31	115	215	583	188	456	178	410	EK-MT
295- 40 MT	2.7	40	41	115	208	583	181	456	171	410	EK-MT
175- 18 MT	3.0	18	19	133	178	214	158	174	153	164	CD-MT
175- 23 MT	3.0	23	24	133	178	214	158	174	153	164	CD-MT
225- 18 MT	3.0	18	19	128	167	370	140	243	130	197	EK-MT
225- 23 MT	3.0	23	24	128	167	370	140	243	130	197	EK-MT
225- 30 MT	3.0	30	31	128	165	370	138	243	128	197	EK-MT
225- 40 MT	3.0	40	41	128	158	370	131	243	121	197	EK-MT
370- 18 MT	3.2	18	19	115	199	462	174	334	164	288	CD-MT
370- 23 MT	3.2	23	24	115	199	462	174	334	164	288	CD-MT
370- 30 MT	3.2	30	31	115	197	462	172	334	162	288	CD-MT
370- 40 MT	3.2	40	41	115	190	462	165	334	155	288	CD-MT
250- 18 MT	3.4	18	19	128	190	370	165	252	155	206	EK-MT
250- 23 MT	3.4	23	24	128	190	370	165	252	155	206	EK-MT
250- 30 MT	3.4	30	31	128	188	370	163	252	153	206	EK-MT
250- 40 MT	3.4	40	41	128	181	370	156	252	146	206	EK-MT
390- 18 MT	3.5	18	19	146	207	556	180	428	170	382	CD-MT
390- 23 MT	3.5	23	24	146	207	556	180	428	170	382	CD-MT
390- 30 MT	3.5	30	31	146	205	556	178	428	168	382	CD-MT
390- 40 MT	3.5	40	41	146	198	556	171	428	161	382	CD-MT

* Volume in state as delivered at feeder height H. | ** Volume after compression at feeder height H1/H2.

Pin Tele-MT-System

Maintenance-free positioning aid with pattern protection for the Tele-R-System



Pin Tele-MT-System

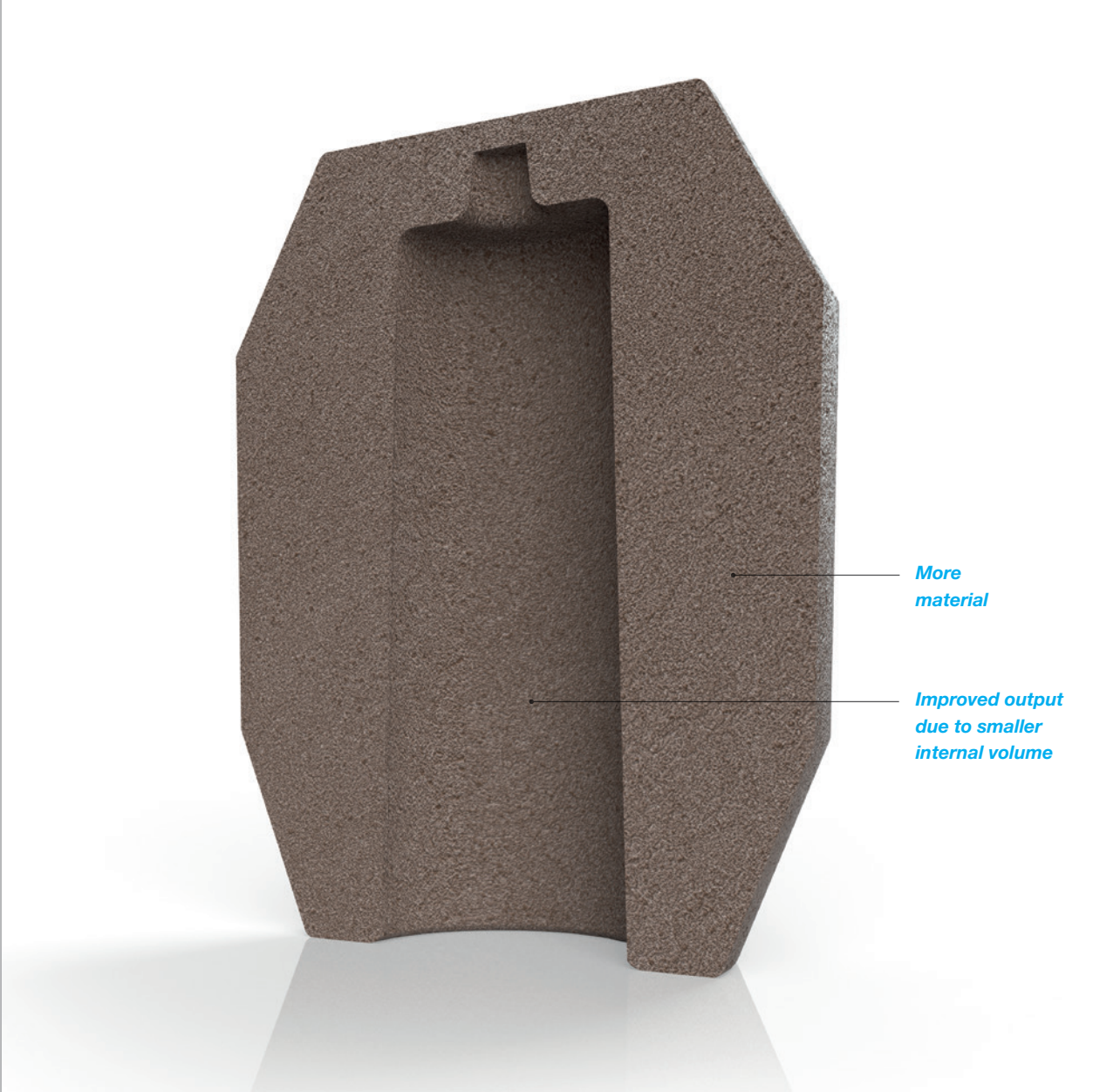
Type	D1 [mm]	D2 [mm]	D3 [mm]	H1 [mm]	H2 [mm]
80- 18 MT	20	17	7.5	70	110
80- 23 MT	25	22	7.5	70	110
90- 18 MT	20	17	7.5	90	130
90- 23 MT	25	22	7.5	90	130
100- 18 MT	20	17	7.5	96	134
100- 23 MT	25	22	7.5	96	134
100- 30 MT	32	29	7.5	96	134
120- 18 MT	20	17	7.5	103	140
120- 23 MT	25	22	7.5	103	140
120- 30 MT	32	29	7.5	103	140
140- 18 MT	20	17	7.5	120	145
140- 23 MT	25	22	7.5	120	145
170- 18 MT	20	17	11	135	176
170- 23 MT	25	22	11	135	176
170- 30 MT	32	29	11	135	176
175- 18 MT	20	17	11.5	125	168
175- 23 MT	25	22	11.5	125	168
180- 18 MT	20	17	9	116	161
180- 23 MT	25	22	9	116	161
180- 30 MT	32	29	9	116	161
190- 18 MT	20	17	9	83	111
190- 23 MT	25	22	9	83	111
190- 30 MT	32	29	9	83	111
190- 40 MT	42	39	9	83	111
220- 18 MT	20	17	11	103	158
220- 23 MT	25	22	11	103	158

Pin Tele-MT-System

Type	D1 [mm]	D2 [mm]	D3 [mm]	H1 [mm]	H2 [mm]
220- 30 MT	32	29	11	103	158
220- 40 MT	42	39	11	103	158
225- 18 MT	20	17	11.5	95	148
225- 23 MT	25	22	11.5	95	148
225- 30 MT	32	29	11.5	95	148
225- 40 MT	42	39	11.5	95	148
250- 18 MT	20	17	11	120	175
250- 23 MT	25	22	11	120	175
250- 30 MT	32	29	11	120	175
250- 40 MT	42	39	11	120	175
280- 18 MT	20	17	11	143	188
280- 23 MT	25	22	11	143	188
280- 30 MT	32	29	11	143	188
280- 40 MT	42	39	11	143	188
295- 18 MT	20	17	11	153	208
295- 23 MT	25	22	11	153	208
295- 30 MT	32	29	11	153	208
295- 40 MT	42	39	11	153	208
370- 18 MT	20	17	11	135	185
370- 23 MT	25	22	11	135	185
370- 30 MT	32	29	11	135	185
370- 40 MT	42	39	11	135	185
390- 18 MT	20	17	13	148	198
390- 23 MT	25	22	13	148	198
390- 30 MT	32	29	13	148	198
390- 40 MT	42	39	13	148	198

Tolerances

D1	D2	D3	D4	H2	H3
H8	H8	H8	H8	H13	H13



Compact-Feeder half section



Compact-Feeders

Compact feeders have an increased wall thickness compared to classic insert sleeves. The resulting increased exothermic reaction makes it possible to reduce the volume of the inner feeder and thus leads to improved output. This effect is

supported by the good insulation properties of the Cold-Box-bonded formulations. This product range is part of the classic feeder systems and is suitable both for moulding onto the pattern plate and for core shooting.



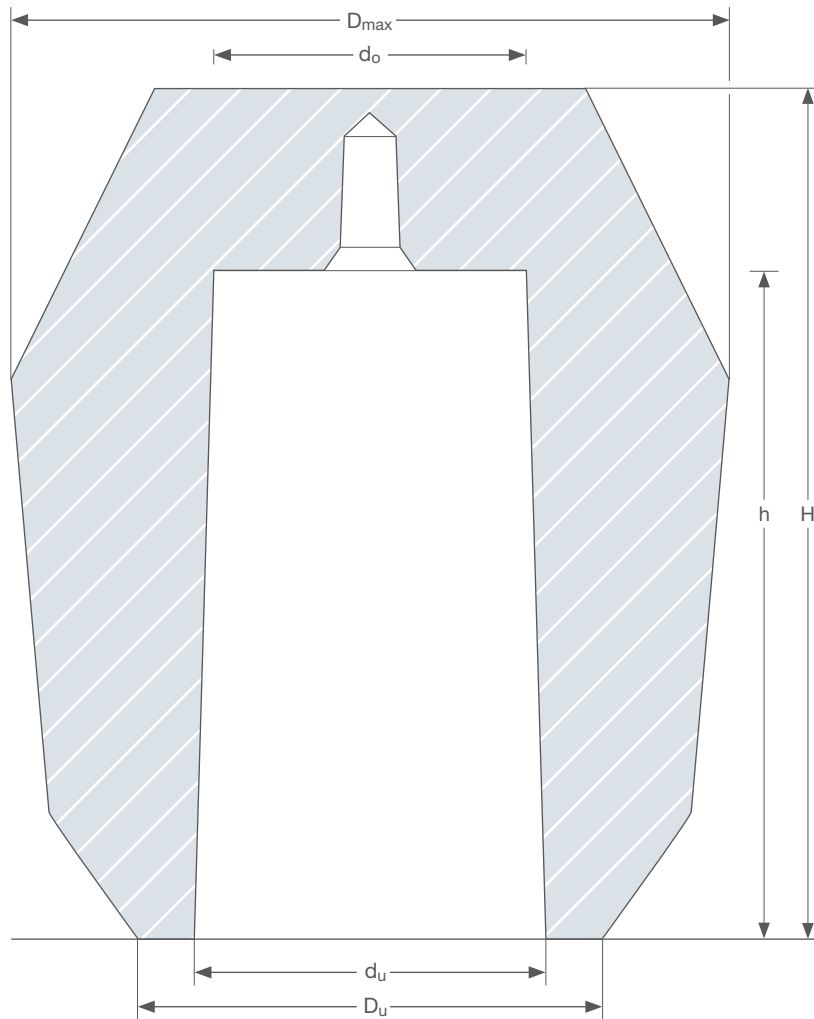
Compact-Feeder reclining



Compact-Feeder standing

Compact-Feeder, CD-Shape

High efficiency due to more material

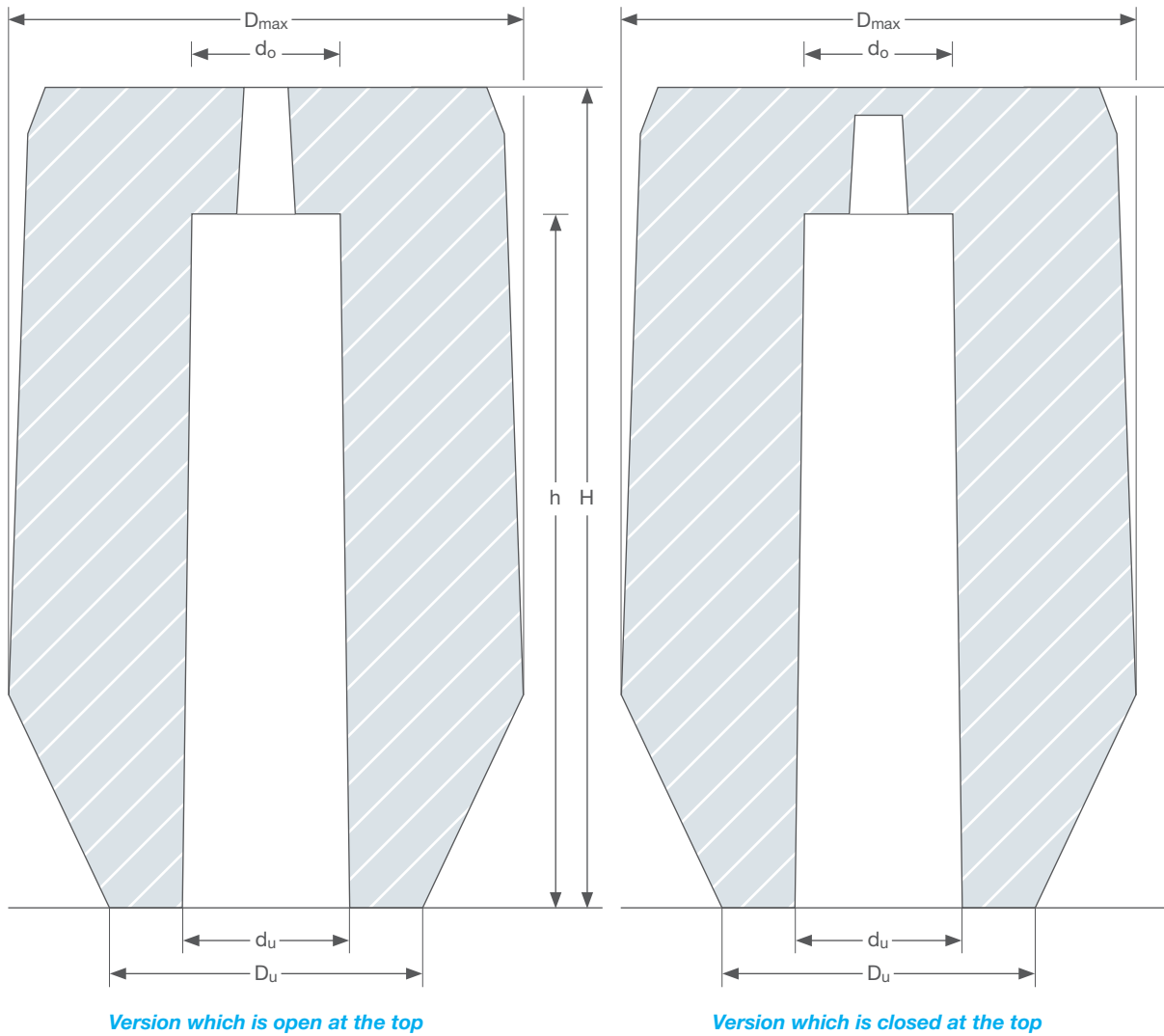


Compact-Feeder CD-Shape		State as delivered							
Type	Modulus [cm]	Vol. [cm ³]	D _u [mm]	d _u [mm]	D _{max} [mm]	d _o [mm]	H [mm]	h [mm]	
CD 56	1.5	57	60	34	90	28	100	80	
CD 88	1.7	87	60	38	88	32	110	97	
CD 121	1.9	123	66	43	104	35	135	110	
CD 159	2.2	162	82	54	115	40	120	100	
CD 191	2.7	193	90	53	133	40	138	120	
CD 238	2.2	240	90	62	126	50	125	100	
CD 338 Q	3.2	348	98	67	115	55	142	120	
CD 590	3.4	590	110	80	146	75	150	125	
CD 780	4.2	780	130	80	190	70	210	175	
CD 980	4.3	981	130	97	190	92	160	140	



Compact-Feeder, CKD-Shape

High efficiency due to more material

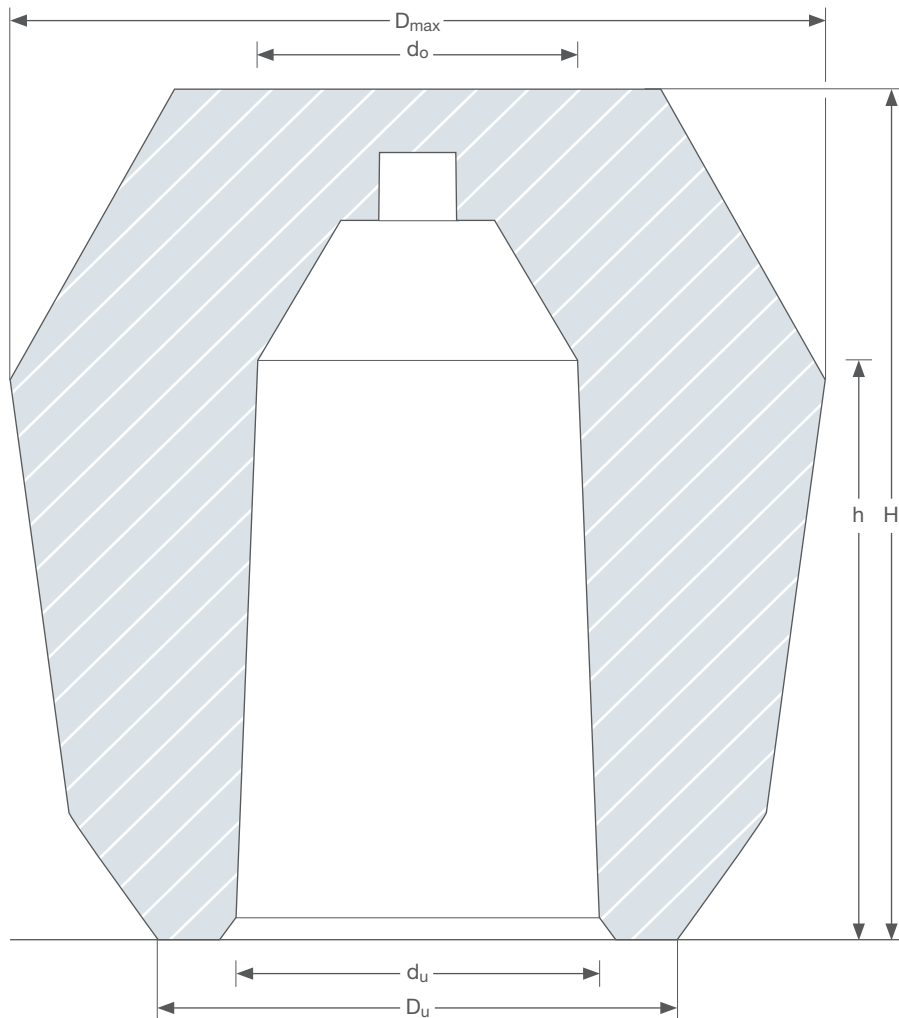


Kompakt-Feeder CKD-Shape		State as delivered								
Type	Modulus [cm]	Vol. [cm ²]	D _u [mm]	d _u [mm]	D _{max} [mm]	d _o [mm]	H [mm]	h [mm]	Open at the top	
CKD 25	0.8	9	30	16	44	14	60	50		
CKD 35/62-1	1.0	16	38	21	54	19	62	50	Yes	
CKD 35/2	1.2	28	40	25	62	20	78	70	Yes	
CKD 50	1.7	89	60	36	74	32	110	97		
CKD 50 SZP	1.7	87	60	40	74	28	110	88		



Compact-Feeder, SZP-Shape

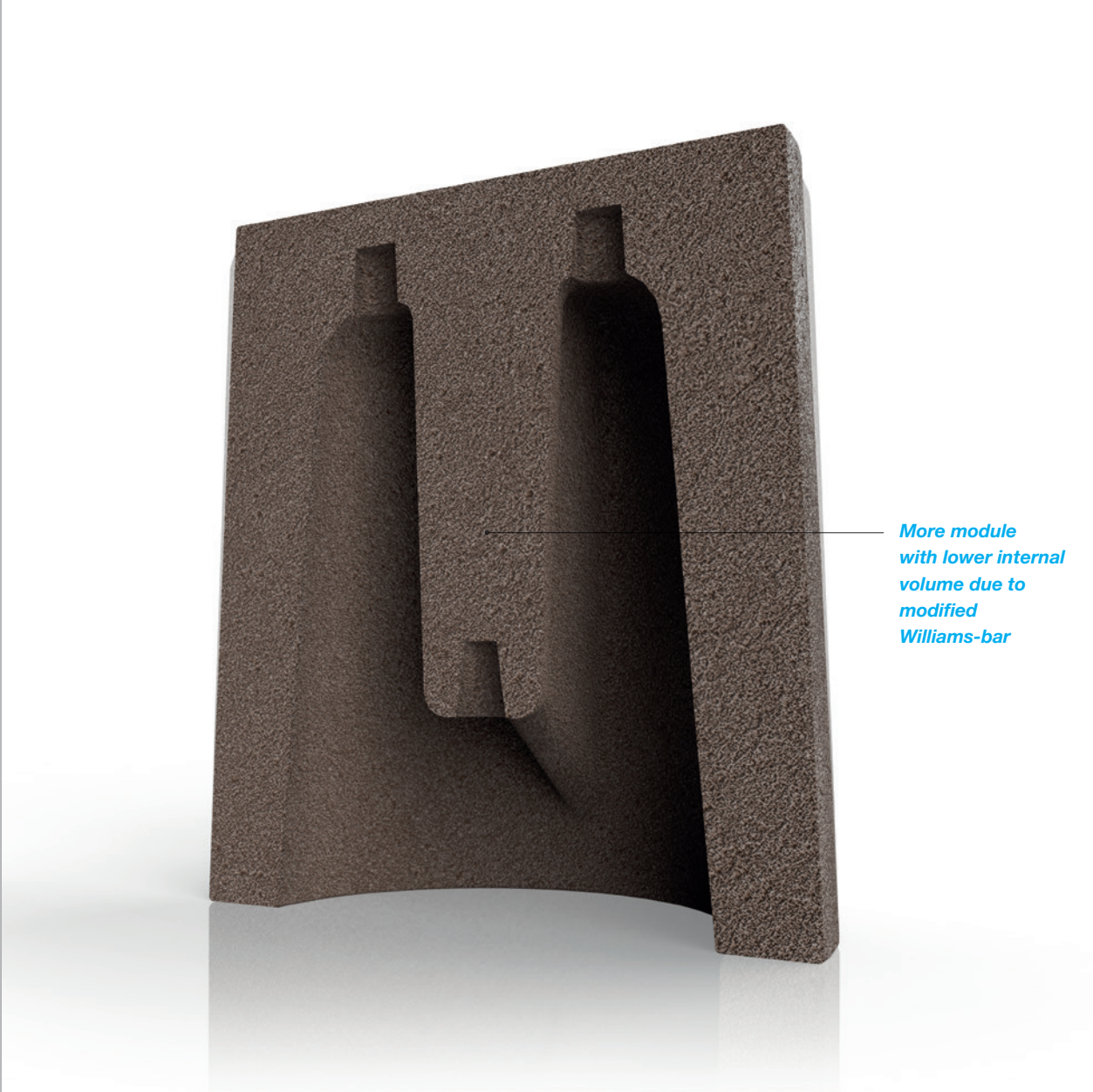
High efficiency due to more material



32



Kompakt-Feeder SZP-Shape		State as delivered							
Type	Modulus [cm]	Vol. [cm ³]	D _U [mm]	d _U [mm]	D _{max} [mm]	d _O [mm]	H [mm]	h [mm]	
CD 25 SZP	0.7	25	40	30	44	13	60	47	
CD 27 SZP	0.9	31	46	30	56	28	62	46	
CD 37 SZP	1.0	38	46	30	56	28	82	47	
CD 45 SZP	1.3	52	46	30	56	20	117	94	
CD 88 SZP	1.8	88	60	40	88	38	110	50	
CD 110 SZP	1.9	110	66	40	104	36	116	93	
CD 121 SZP	2.0	121	66	40	104	34	135	105	
CD 127 SZP OV	2.0	124	52 x 84	36 x 60	70 x 90	32 x 56	96	67	
CD 143 SZP OV	2.1	143	55 x 103	35 x 75	79 x 117	33 x 72	90	52	
CD 159 SZP	2.3	178	82	52	115	44	120	90	
CD 191 SZP	2.7	210	90	52	133	44	138	107	
CD 200 SZP	2.9	208	95	59	143	50	125	74	
CD 238 SZP	2.4	228	90	57	126	52	125	91	
CD 280 SZP OV	2.4	262	65 x 104	46 x 76	90 x 120	42 x 72	120	83	
CD 338 Q SZP	3.2	454	98	79	115	60	142	94	
CD 360 SZP OV	2.6	356	65 x 104	46 x 76	90 x 120	42 x 72	160	100	
CD 590 SZP	3.5	548	110	79	146	74	150	110	
CD 860 SZP	4.3	879	130	97	190	70	210	160	
CD 950 SZP OV	3.2	884	100 x 150	70 x 120	110 x 160	66 x 116	170	80	
CD 1007 SZP	4.2	974	130	97	190	92	175	135	
CD 1100 SZP	4.3	1100	130	97	190	88	210	150	
CD 1380 SZP	4.7	1365	160	118	225	114	170	112	
CD 1800 SZP	5.0	1828	160	118	225	108	230	100	
CD 2100 SZP	5.4	2127	160	118	225	108	260	200	
CD 3100 SZP	5.0	3137	220	170	290	164	170	140	
CD 4100 SZP	5.8	4122	220	170	290	140	260	195	
CD 5900 SZP OV	5.6	5510	220 x 320	170 x 270	260 x 360	160 x 262	190	109	
CD 7200 SZP OV	6.6	7250	220 x 320	170 x 270	260 x 360	161 x 26	260	160	
CD 8000 SZP OV	6.4	8077	220 x 320	170 x 270	260 x 360	158 x 256	260	189	
CD 9000 SZP OV	7.0	9050	220 x 320	170 x 270	260 x 410	164 x 614	260	160	
CD 11400 SZP	8.6	11470	330	280	400	260	260	180	



*More module
with lower internal
volume due to
modified
Williams-bar*

EK T-Type, half section



EK Types

EK Types are the oldest form of feeder inserts and were originally designed for subsequent insertion into the turned upper box (cope). If required, they can also be fitted with a breaker core.

Today, these sleeves have very high strengths, so that they can easily be moulded onto the pattern plate or shot

into cores. Chemex has further developed these classic feeder inserts with the T-Types. This insert sleeve variant has a smaller internal volume for the same module than the classic insert sleeve.

The yield can be significantly increased by using this variant.



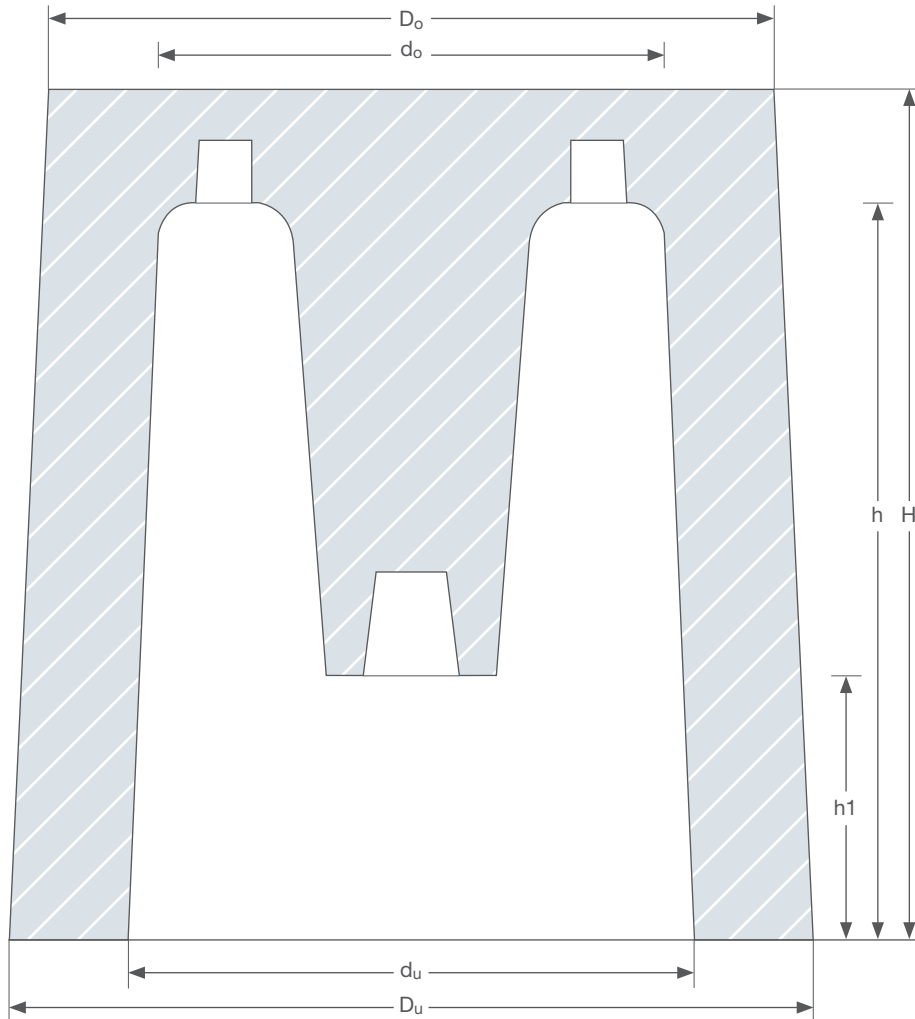
EK T-Type reclining



EK T-Type standing

EK T-Type

For insert, pattern mounted or core integrated applications



36



Use our app to experience the site in Augmented Reality.

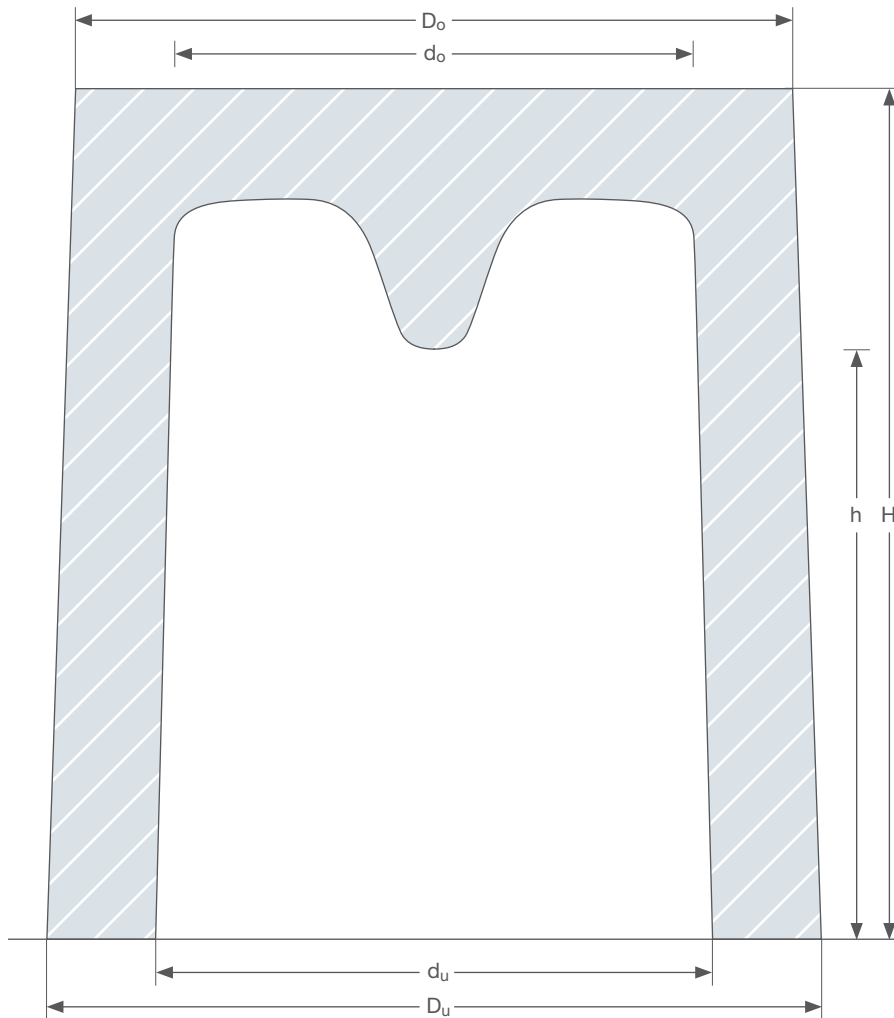


EK T-Type		State as delivered								
Type	Modulus [cm]	Vol. [cm ³]	D _u [mm]	d _u [mm]	D _o [mm]	d _o [mm]	H [mm]	h [mm]	h1 [mm]	
EK 40/70 T	1.5	56	63	42	59	34	73	63	23	
EK 50/80 T	1.7	105	73	53	70	48	80	70	27	
EK 60/90 T	1.9	117	80	57	76	44	92	76	25	
EK 70/100 T	2.3	189	94	67	88	53	99	84	27	
EK 80/110 T	2.6	284	104	78	97	61	110	95	28	
EK 80/140 T	2.8	377	104	79	97	58	140	127	28	
EK 100/130 T	3.1	615	128	100	119	83	133	112	37	
EK 120/150 T	3.7	1236	155	123	147	117	150	131	41	



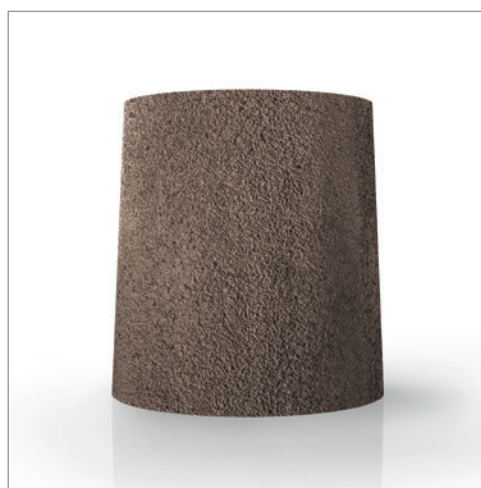
EK W-Type

For insert, pattern mounted or core integrated applications



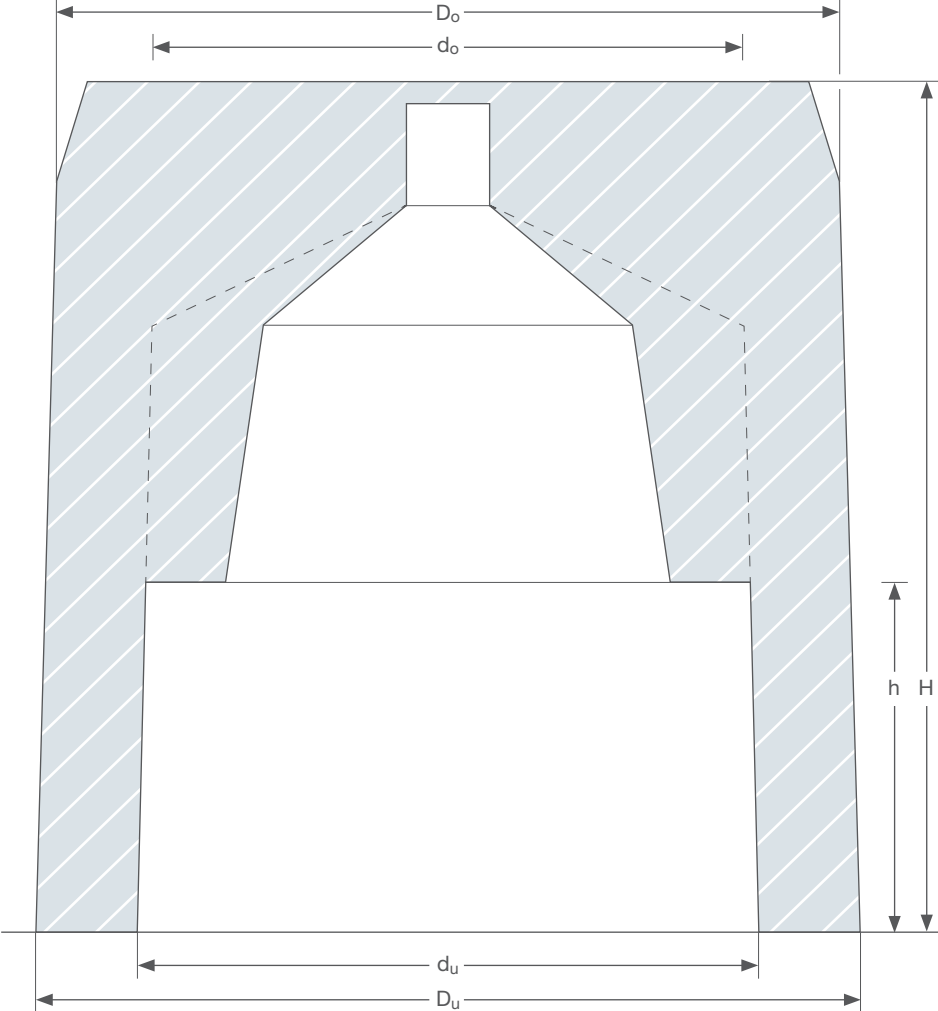
Use our app to experience the site in Augmented Reality.

EK W-Type		State as delivered							
Type	Modulus [cm]	Vol. [cm ³]	D _U [mm]	d _U [mm]	D _O [mm]	d _O [mm]	H [mm]	h [mm]	
EK 35/50 W	0.9	32	47	35	44	31	50	28	
EK 40/70 W	1.2	70	63	41	59	36	73	49	
EK 40/95 W	1.3	100	63	43	59	36	97	71	
EK 50/80 W	1.5	130	73	52	70	48	80	54	
EK 60/90 W	1.7	178	80	58	76	52	92	78	
EK 60/120 DFW	1.9	204	80	57	75	52	120	25	
EK 70/100 W	2.0	296	94	69	89	65	99	67	
EK 80/110 W	2.2	419	104	79	97	71	110	74	
EK 80/110 DFW	2.3	310	104	73	97	65	110	30	
EK 90/120 W	2.5	569	115	90	105	81	120	80	
EK 100/130 W	2.8	783	128	97	119	91	133	90	
EK 120/150 W	3.2	1315	154	118	146	112	150	102	
EK 120/200 W	3.5	1782	155	117	145	109	200	154	

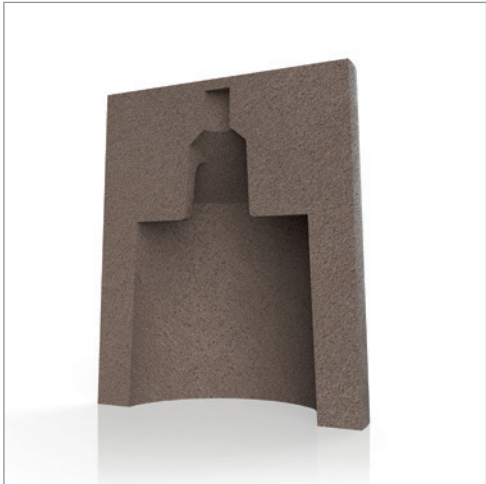


EK SZP-Type

For insert, pattern mounted or core integrated applications



40



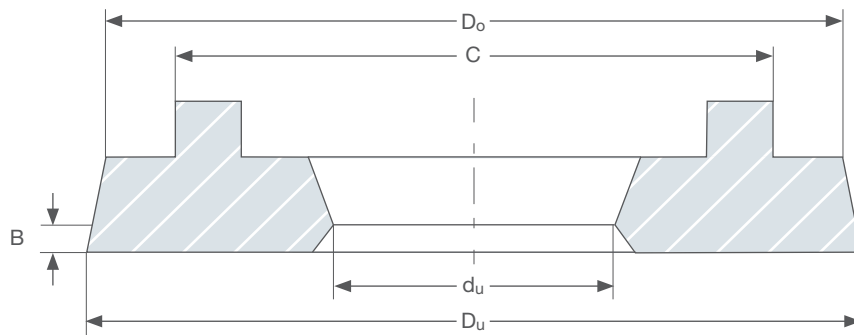
EK SZP-Type		State as delivered							
Type		Modulus [cm]	Vol. [cm ³]	D _u [mm]	d _u [mm]	D _o [mm]	d _o [mm]	H [mm]	h [mm]
EK	40/70 SZP	1.3	62	63	40	59	38	73	50
EK	40/95 SZP	1.4	70	63	40	59	37	97	47
EK	50/80 SZP	1.6	114	73	52	70	50	80	48
EK	50/100 SZP	1.7	139	73	52	70	49	100	60
EK	60/90 SZP	1.8	155	80	57	76	53	92	53
EK	60/120 SZP	1.9	198	80	57	75	54	120	55
EK	70/100 DF SZP	2.0	176	94	57	89	53	99	67
EK	70/100 SZP	2.1	242	94	69	89	64	99	56
EK	70/140 SZP	2.2	369	94	69	89	65	140	60
EK	80/110 SZP	2.3	362	104	79	97	76	110	64
EK	80/140 SZP	2.4	454	104	79	97	75	140	60
EK	90/160 DF SZP	2.7	575	115	79	110	75	160	80
EK	100/110 SZP	2.7	508	128	97	119	93	110	60
EK	100/110 DF SZP	2.8	362	128	79	119	75	110	64
EK	120/110 SZP	2.9	791	155	118	150	115	110	70
EK	100/130 SZP	3.0	617	128	97	119	94	133	70
EK	100/130 DF SZP	3.1	554	128	97	119	93	133	67
EK	100/150 SZP	3.1	651	128	97	119	93	150	70
EK	100/170 SZP	3.1	859	128	97	119	93	170	65
EK	80/130 DF SZP	3.2	362	128	79	119	76	133	60
EK	120/150 SZP	3.4	1066	155	118	147	114	150	80
EK	120/200 SZP	3.8	1396	155	118	145	114	200	80

Breaker cores

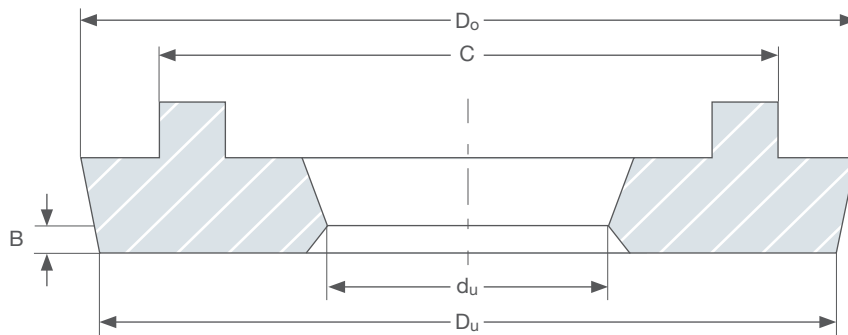
For use in combination with classic insert sleeve or compact feeders

Breaker cores reduce the size of the aperture and allow a reduction of the separation effort. Breaker cores are usually

made of silica or chromite sand and fixed to the respective feeder with an adhesive bond.



Version A



Version B

Breaker cores		State as delivered		
Type	d _u [mm]	C-D ₀ -D _u [mm]	Breaker cores B [mm]	
BC	18	36-58-47	B 0	
BC	28	78-102-104	B 3	
BC	25	40.5-61.5-62	B 4	
BC	21	264.5-98-94	B 4	
BC	22	67-93-95	B 2.5	
BC	28	67-93-95	B 2.5	
BC	30	99-127-130	B 4	
BC	41-15.5	0-71-72	B 0	
BC	18	36-58-47	B 3	
BC	10	21-37-25	B 0	
BC	18.5	56-82-85	B 0	
BC	18	42.5-63.3-64.5	B 2	
BC	25	56.5-82.5-83.5	B 3	
BC	15	36-60-61.5	B 2	
BC	25	78-102-104	B 0	
BC	30	87.5-115-115.5	B 3.5	
BC	18	52-75-76	B 0	
BC	25	52-75-76	B 2.5	
BC	30	98-128-130	B 3	
BC	22.5	50.5-75.5-76	B 3	
BC	27	68-96.5-97.5	B 3	
BC	35	96-131.5-133	B 2.5	
BC	35	78-102-104	B 2	
BC	40	120.5-150-152	B 4	
BC	50	152-192-194	B 5	

Other breaker cores are available on request. Please enter the desired values in the table below. Scan or photograph the completed table and then email it to your responsible product manager.

Orientation	A <input type="checkbox"/>	B <input type="checkbox"/>
D ₀ [mm]		
D _u [mm]		
d _u [mm]		
B [mm]		

Feeding systems for nonferrous applications

Insulating feeder recipes – High pressure resistant and fiber free



Available feeding systems

Tubes		State as delivered					
Type	Modulus [cm]	Vol. [cm ³]	D _u [mm]	d _u [mm]	D _o [mm]	d _o [mm]	H [mm]
H 40/150	0.8	218	62	40	55	38	148
H 78/80/60 ov	1.1	165	100 x 60	80 x 40	104 x 62	78 x 39	60

Tele-Feeder	State as delivered						ΔH and ΔV after compression Middle		High		
Type	Modulus [cm]	d _U [mm]	D _U [mm]	D _{max} [mm]	H [mm]	Vol.* [cm ³]	H1 [mm]	Vol. 1** [cm ³]	H2 [mm]	Vol. 2** [cm ³]	Shape
10- 10 (24)	0.7	10	24	44	85	23	70	14	70	14	CD
12- 10 (24)	0.8	10	24	56	87	29	72	20	67	16	CD
24- 13 (24)	0.9	13	24	56	107	38	92	28	87	25	CD
40- 15 (26)	1.1	15	26	63	103	61	88	43	83	37	EK
42- 13 (24)	1.2	13	24	56	142	50	127	41	122	38	CD
90- 17 (28)	1.5	17	28	73	135	136	120	105	110	86	EK
100- 23 MT	1.7	23	24	80	142	162	122	114	112	90	EK
100- 25 (40)	1.7	25	40	80	132	149	112	96	102	73	EK
180- 25 (40)	1.8	25	40	80	160	187	140	138	130	115	EK
190- 30 (46)	1.8	30	46	115	110	216	90	123	90	123	EK
125- 32/14 B0	1.9	32 x 14	45 x 27	90 x 70	131	130	116	104	106	86	CD OV
120- 18 (35)	1.9	18	35	94	139	166	119	117	109	94	EK
220- 30 (46)	2.0	30	46	104	157	369	137	274	127	227	EK
280- 30 (46)	2.1	30	46	104	187	460	167	365	157	319	EK
330- 30 (52)	2.3	30	52	128	120	323	100	181	100	181	EK
290- 30 (52)	2.5	30	52	128	155	480	130	303	120	234	EK
500- 40 (62)	2.8	40	62	155	157	749	132	484	122	379	EK
850- 40 (62)	3.2	40	62	155	197	1023	172	758	162	654	EK
1200- 40 (62)	3.9	40	62	155	247	1354	222	1089	212	984	EK

EK- and CD-Shape		State as delivered							
Type	Modulus [cm]	Vol. [cm ³]	D _U [mm]	d _U [mm]	D _O [mm]	d _O [mm]	H [mm]	h [mm]	
EK 50/100 SZP	1.5	139	72	52	70	49	100	60	
EK 90/63 W	1.6	210	115	79	110	77	60	40	
EK 60/90 SZP	1.6	155	80	57	76	53	92	53	
EK 60/100 SZP	1.7	198	80	57	75	54	120	55	
EK 70/100 DF SZP	1.8	176	94	57	89	53	99	67	
EK 100/75 W	1.9	351	128	97	119	95	75	40	
CD 280 SZP ov	1.9	262	116 x 65	76 x 46	120 x 90	72 x 43	120	83	
EK 80/110 SZP	2.0	362	104	79	97	75	140	60	
EK 80/140 SZP	2.1	454	104	79	97	75	140	60	
EK 100/110 SZP	2.4	508	128	97	119	93	110	60	
EK 120/110 SZP	2.5	791	155	118	150	115	110	70	
EK 100/150 SZP	2.7	651	128	97	119	93	150	70	
EK 120/150 SZP	3.0	1066	155	118	147	114	150	80	
EK 120/200 SZP	3.3	1396	155	118	150	115	110	70	

* Volume in state as delivered at feeder height H. | ** Volume after compression at feeder height H1/H2.



Available Side-Risers

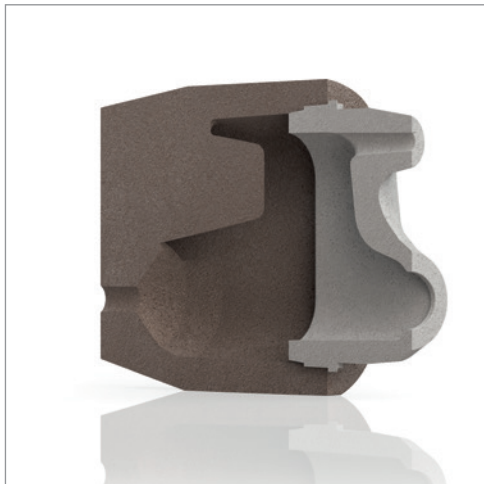


Side-Risers

Side-Risers have been specially designed for use on vertically partitioned moulding lines.

A distinction is made between two product lines. The first is the Tele-Side-Feeder-System which is suitable for moulding

on the pattern plate, analogous to the classic Tele-Feeder-System for horizontal moulding lines. Chemex also offers insert sleeves that can be inserted into the mould bales manually or with the help of the core inserter after the compaction process.



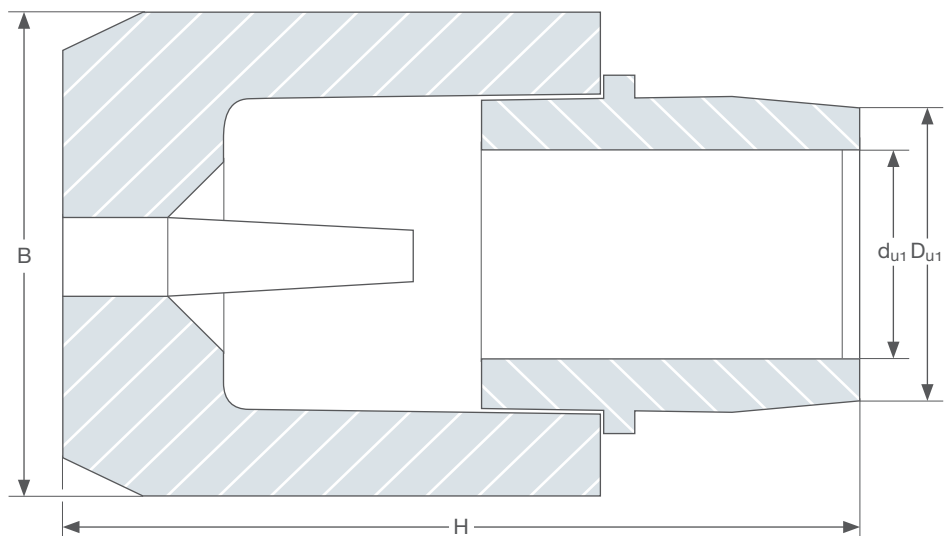
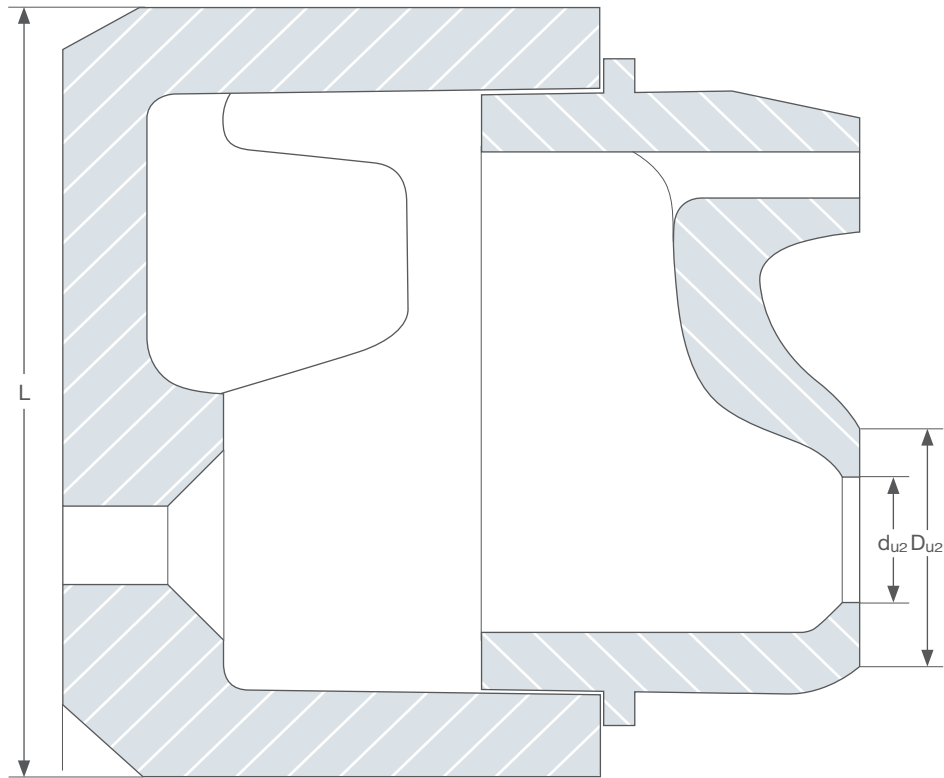
Tele-Side-Riser half section



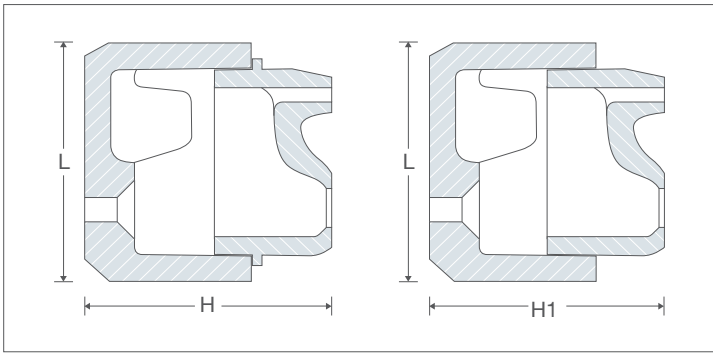
Side-Insert-Sleeve

Tele-Side-Riser*

Efficient feeding systems for vertical moulding lines



*When using this product attention should be paid to the following patent: EP 2 718 040 B1

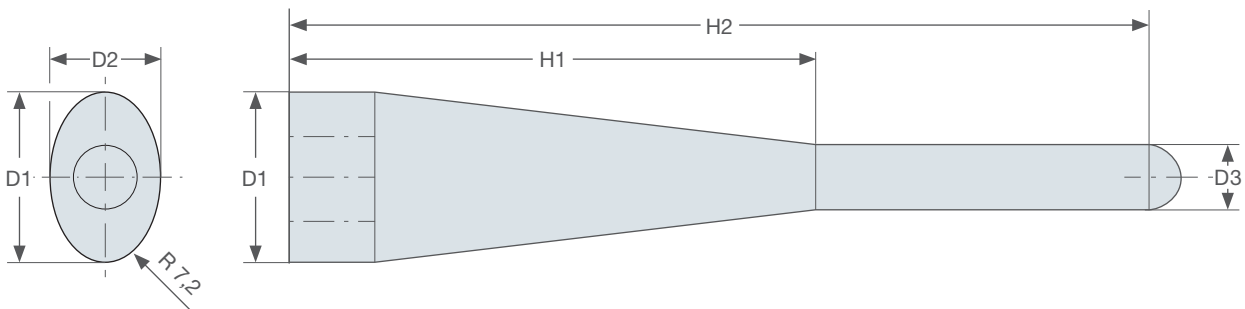


Tele-Side-Riser | As delivered and after compression

Tele-Side-Riser												
Type	Modulus [cm] isolating	Modulus [cm] exothermic	Vol. [cm ³]	D _{u1} [mm]	D _{u2} [mm]	d _{u1} [mm]	d _{u2} [mm]	H [mm]	B [mm]	L [mm]	H1 [mm]	Vol. [cm ³]
171- 30/20 B0S	1.5	1.8	245	44	34	30	20	116	72	113	96	171
233- 30/20 B0S	1.7	2.0	310	44	34	30	20	148	72	113	128	23

Pin Tele-Side-Riser

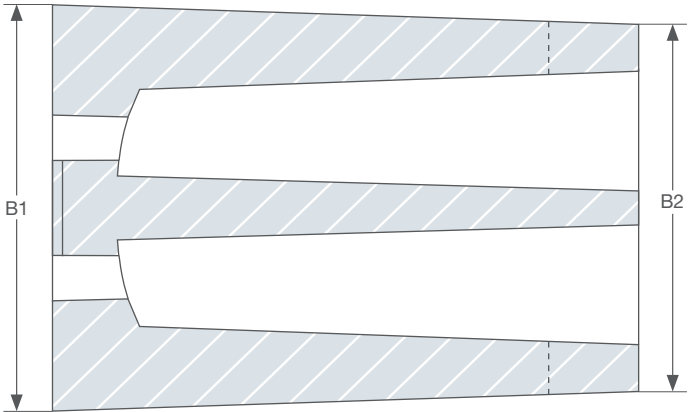
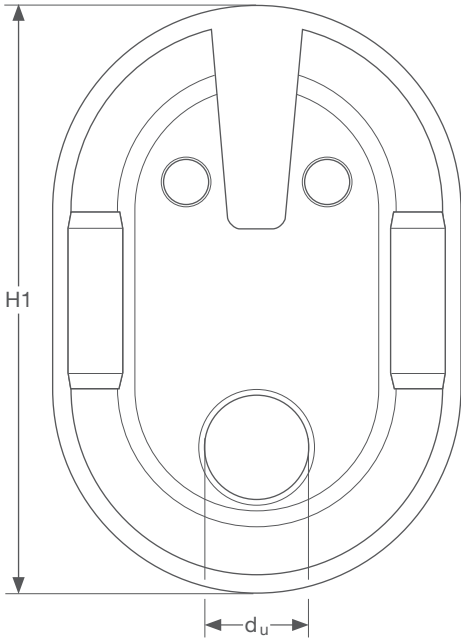
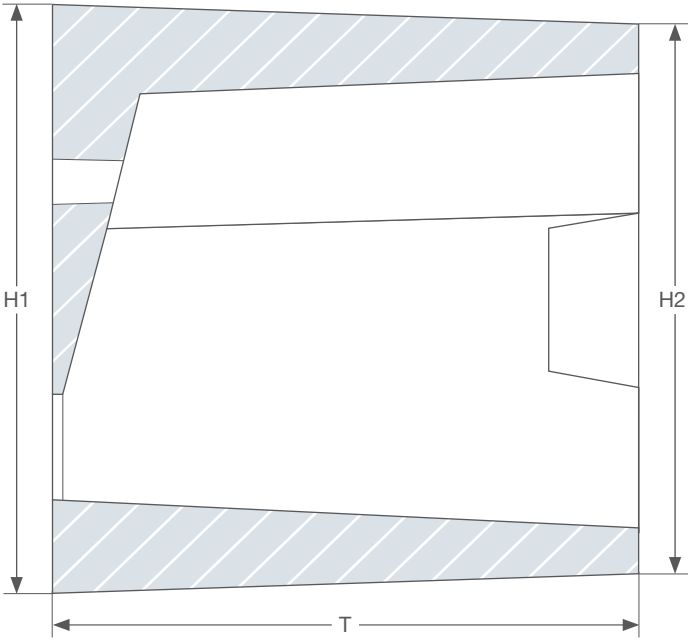
Maintenance-free positioning aid for the Tele-Side-Riser

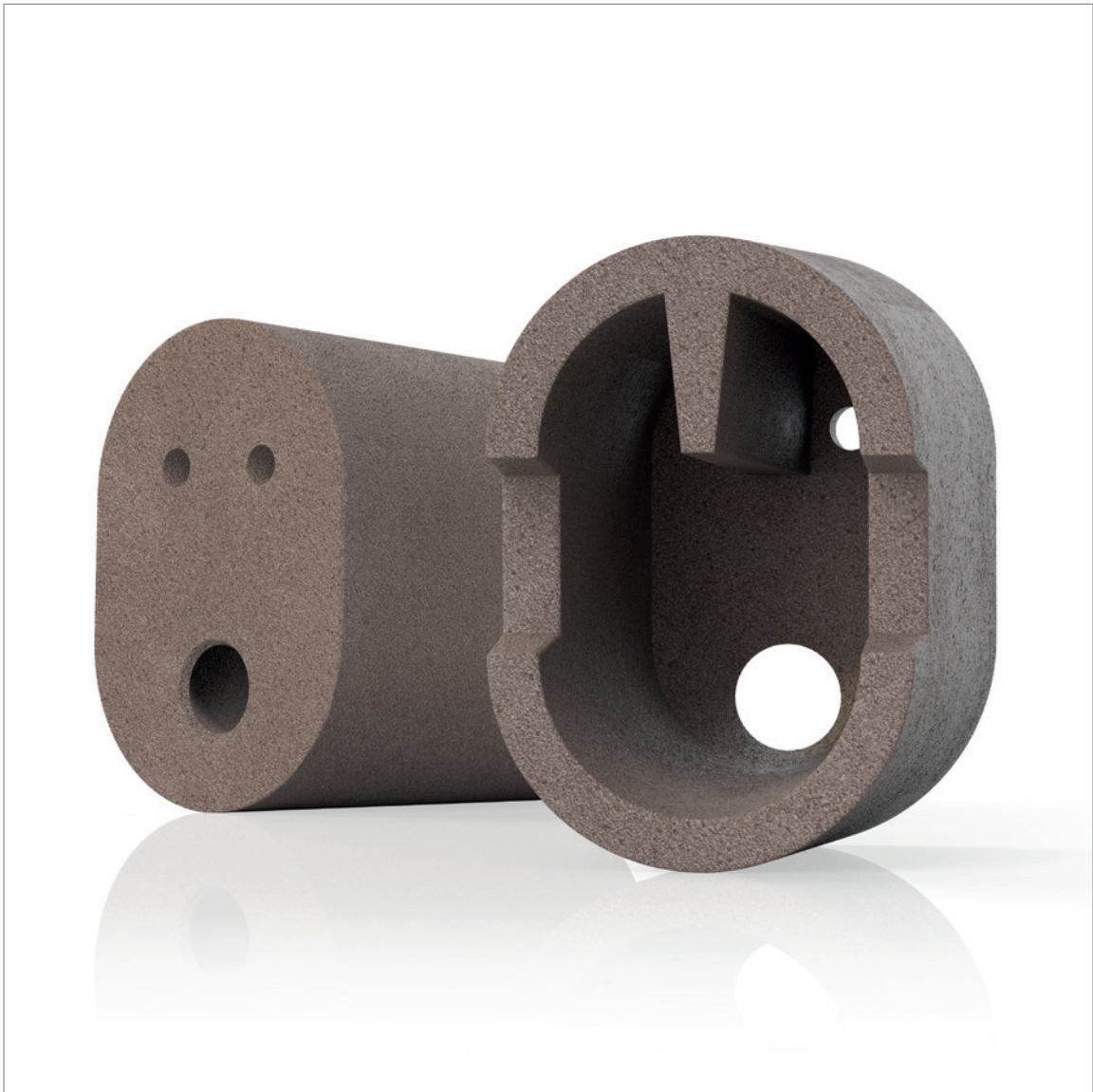


Pin Tele-Side-Riser					
Type	D1 [mm]	D2 [mm]	D3 [mm]	H1 [mm]	H2 [mm]
171- 30/20 B0	29	19.5	11.4	63	118
233- 30/20 B0	29	19.5	11.4	92	150

Side-Insert-Sleeve

Efficient feeding systems for vertical moulding lines





Side-Insert-Sleeve								
Type	Modulus [cm]	V [cm ²]	d _u [mm]	H1 [mm]	H2 [mm]	T [mm]	B1 [mm]	B1 [mm]
EH 71/50 W ov S	1.4	66	18	100	97	50	69	66
EH 71/100 W ov S	1.7	305	18	100	94	100	69	63

A holistic view of casting production

Our philosophy

We want to develop technical solutions together with our customers. The products listed in this catalogue represent our standard portfolio.

We also have many other products that have been specially developed for individual customers. The goals and wishes defined by the customer can be very different.

For example, we were able to achieve a significant increase in cycle time by reducing the number of feeders at several customers with the aid of contour breaker core technology. We are currently the market leader in this area. The high dimensional accuracy of the fluorine-free Cold-Box-bonded materials makes it

possible to go directly onto the casting contour over a large area and to reach several feeding areas with an overlying feeder.

Our focus of cooperation is on the following areas:

- Close cooperation with customers
- View of the overall process
- Reduction of melting costs
- Increased output
- Reduction of cutting and fettling costs
- Clean surfaces

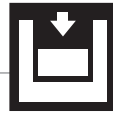




MELTING COST
REDUCTION



Tele-Feeder-System in steel applications



MELTING COST
REDUCTION



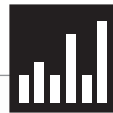
EK T-Types



REDUCTION OF CUTTING
AND FETTLING COSTS



Tele-R-System



INCREASED
CYCLE TIME



Contour breaker core technology



Exothermic ring



Contour Breaker Core Technology

Easily feed hard-to-reach hotspots

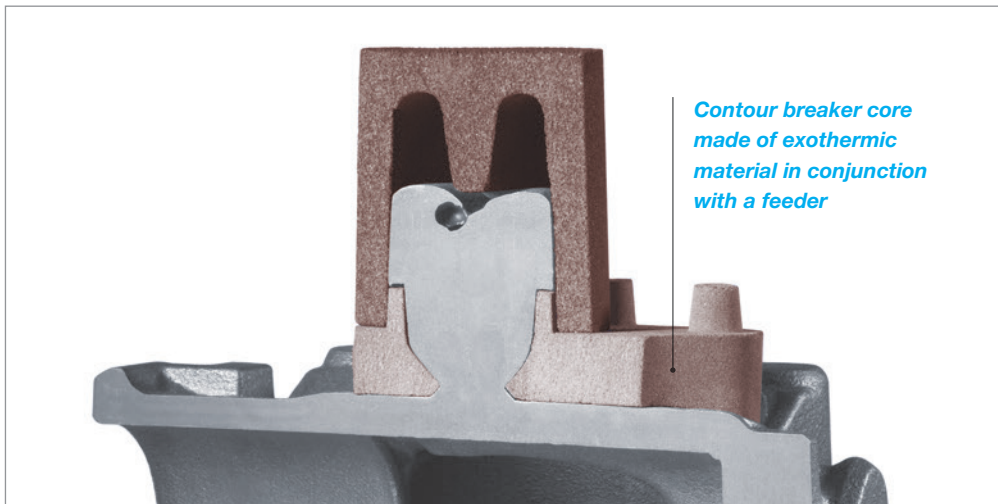
The trend among designers toward lighter castings has resulted in casting geometries that are difficult to feed. Due to the large differences in wall thickness, it was difficult to pass the required leak tests.

The development of fluorine-free Cold-Box contour breaker cores enables high dimensional accuracy to be achieved in conjunction with a very good surface without graphite degenerations.

These properties have made it possible to use exothermic contour cores or pads

on larger sections directly on the casting surface. These can be pattern-mounted, inserted into the mould or shot into a core. This technology makes it possible to keep thin walls open longer, to ensure feeding through this section.

In many cases this technology made it possible to significantly reduce the total number of feeders on the specific casting and reduced the manufacturing costs.



Our mission

Chemex Foundry Solutions GmbH was founded in 1974 and has grown to become a global technology leader in feeding systems. We are an innovative partner for the worldwide foundry industry and are represented in more than 30 countries as a subsidiary of the Hüttenes-Albertus Group.

We offer our customers excellent service thanks to our strong product manager team. In addition to expert advice on the

standard portfolio, this service also includes the development of tailored solutions.

Our goal is to optimise the casting production with regard to the feeder system in the best possible way. To this end, we focus on increasing output, minimising separation and cleaning costs and ongoing further development of our formulations and feeder geometries – all in close cooperation with our customers.



*“We want to be the most innovative company
to generate the greatest possible customer benefit
and thus be the preferred partner for the
foundry industry worldwide.”*



Tolerances for CB-Feeders

One-piece Cold-Box bonded feeders are subject to size tolerance DIN EN ISO 8062-3:2008-09 DCTG9.

CB-Feeders (multi-part)

Multi-parted Cold-Box bonded feeders, which were either glued or pressre-grouted are subject in their height to DIN EN ISO 8062-3:2008-09 DCTG9.

Storage life

We recommend consumption of our CB-products within a period of 2 years after receipt of goods. During this period, the products should be carefully stored in their original sealed packaging.

The information provided on our products is based on our present state of knowledge and experience. Due to the diversity of possible applications, the information is non-binding. This also applies to existing property rights of third parties.

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