

## ***BOTTOM REFRACTORY RAMMING MACHINE***

### **Description**

It is used for bottom refractory ramming operation of coreless induction furnaces.



### **Working Principle**

Calculate the refractory amount for bottom.

Spread 15% more than calculated refractory amount to the bottom. (Bottom thickness higher than 400mm. must be rammed as two layers.)

Step on to refractory or use an equipment to make levelling and precompression.

Plug bottom ramming machine air hose to compressor.

Hang bottom ramming machine to a crane and lower down on refractory.

Start operation with full air pressure. Lower down air pressure until you can observe the stoke, then continue operation.

While the machine is operating, change the air flow rate for a couple of times to acquire better density and avoid vacuum existence under bottom rammer plate.

If bottom thickness does not reach to desired level, add more material and repeat ramming operation

### Advantages

- Compacts bottom refractory material with equal density.
- Remove risks .such as cracks and gas pockets on refractory.
- Completes ramming operation in a very short time.
- Extends life of lining material (refractory).
- More melting done with the time saving.
- Manpower used more economic.
- Suitable for use in each capacity furnace

### Technical Specifications

Makine Çalışma Aralığı		Vibrasyon Frekansı			Hava Tüketimi		
Makine 1	Ø400	4 BAR	5 BAR	6 BAR	4 BAR	5 BAR	6 BAR
Makine 2	Ø600	720 V.P.M	735 V.P.M	784 V.P.M	15 L/dk.	19 L/dk.	23 L/dk.
Makine 3	Ø800						
Makine 4	Ø1000						
Makine 5	Ø1300						
Makine 6	Ø1600						
Makine 7	Ø1800						