Casting Cart Options

Continuous casting machines such as the Autocaster Economizer and Autocaster Ultra are typically used with conveyor systems that move the molds throughout the manufacturing process. Casting carts have been developed to provide flexibility in moving and positioning the molds in front of the machine. Here are some of the typical features of the casting carts:

**Cart Length**
The casting carts are typically 12-15 foot long. The longer length provides enough room for a tall mold to be positioned at one end of the cart, the cart to be lowered, and the tall mold to be moved under the mixing auger of the casting machine. When the mold is full, the cart is raised to the normal conveyor height and the mold is moved off the casting cart.

**Vibration**
Casting carts are typically equipped with either a pneumatic or electric vibrators.

**X Dimension**
Manual or powered movement of the molds across the length of the casting cart.

**Y Dimension**
Fixed base, manual or powered movement of the cart towards and away from the front of the casting machine.

**Z Dimension**
Fixed base, manual or powered movement of the cart platform up or down to decrease or increase the distance between the top of the mold and the end of the mixing auger of the casting machine.

**Control Type**
Pneumatic or electric

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**Elevating/Vibrating/Transversing Casting (EVTC) Cart**

![EVTC Cart](image)

*Order No. 083084*

**Cart Length**
Typically 13 foot long

**Vibration**
Two pneumatic vibrators

**X Dimension**
Manual movement of the molds across the length of the casting cart

**Y Dimension**
Manual movement of the cart towards and away from the front of the casting machine

**Z Dimension**
Pneumatically powered movement of the cart platform up or down to decrease or increase the distance between the top of the mold and the end of the mixing auger of the casting machine

**Control Type**
Pneumatic or electric
### MCT (Mechanized Casting Transfer) Cart, 15' - with 1-Dimensional (X-Axis) Control only

Also referred to as the X Cart  
*Order No. 162302*

<table>
<thead>
<tr>
<th><strong>Cart Length</strong></th>
<th>15 foot long.</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Vibration</strong></td>
<td>One electric vibrator.</td>
</tr>
<tr>
<td><strong>X Dimension</strong></td>
<td>Powered movement of the molds across the length of the casting cart</td>
</tr>
<tr>
<td><strong>Y Dimension</strong></td>
<td>Fixed base bolted to floor</td>
</tr>
<tr>
<td><strong>Z Dimension</strong></td>
<td>Fixed height with manual adjustment (threaded rod with jam nuts)</td>
</tr>
<tr>
<td><strong>Control Type</strong></td>
<td>Electric</td>
</tr>
</tbody>
</table>

### MCT (Mechanized Transfer Cart), 15' with 2-Dimensional (X & Y Axis Only) Controls

Also referred to as the XY Cart  
*Order No. 150111*

<table>
<thead>
<tr>
<th><strong>Cart Length</strong></th>
<th>15 foot long</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Vibration</strong></td>
<td>One electric vibrator</td>
</tr>
<tr>
<td><strong>X Dimension</strong></td>
<td>Powered movement of the molds across the length of the casting cart</td>
</tr>
<tr>
<td><strong>Y Dimension</strong></td>
<td>Manual movement of the cart towards and away from the front of the casting machine</td>
</tr>
<tr>
<td><strong>Z Dimension</strong></td>
<td>Fixed height with manual adjustment (threaded rod with jam nuts)</td>
</tr>
<tr>
<td><strong>Control Type</strong></td>
<td>Electric</td>
</tr>
</tbody>
</table>
MCT (Mechanized Casting Transfer) Cart, 15', with 3-Dimensional (X, Y and Z) Controls

Also referred to as the XYZ Cart

Order No. 150110

Cart Length 15 foot long
Vibration One electric vibrator
X Dimension Powered movement of the molds across the length of the casting cart
Y Dimension Manual movement of the cart towards and away from the front of the casting machine
Z Dimension Powered movement of the cart platform up or down to decrease or increase the distance between the top of the mold and the end of the mixing auger of the casting machine
Control Type Electric

Modified Standard Exchange Cart, 12' - modified to add Vibration Platform & Vibrator

Order No. 083079M

Cart Length 12 foot long
Vibration Choose from one pneumatic or electric vibrator
X Dimension Powered movement of the molds across the length of the casting cart
Y Dimension Manual movement of the cart towards and away from the front of the casting machine
Z Dimension Fixed height with manual adjustment (threaded rod with jam nuts)
Control Type Manual vibrator on/off
Maintenance and Repair Parts

Like any other piece of equipment, the casting carts will require periodic maintenance and repair parts. Gruber Systems is ready to provide support to our customers as needed.

Note the following:

- Some of the older carts used Siemens inverters in the electrical panel. We have seen deterioration in the plastic housing surrounding some of the inverters. We currently use Yaskawa inverters and can provide a replacement inverter and instructions on how to wire the new inverter in place.

- As mentioned in previous Tech Tips, the Baldor gearboxes used in the older casting carts on the chain drive (X) and cart drive (Y) are no longer available. Gruber Systems can provide replacement gearboxes and any adapters or intermediate shafts required to replace the gearboxes.

- Call Gruber Systems for support for any other electrical or mechanical issues.