

DISA parts and services catalogue 2019



Because innovation never stops

DISA Training Department



A correctly adjusted and well maintained machine provides better casting products, less scrap, higher uptime and lower running costs by maximizing the life of the Wear parts.

The training programs provide excellent understanding of your moulding equipment.

The training programs will give you confidence in operating and maintaining your DISA equipment through theoretical and practical exercises.

DISA offers the following Training

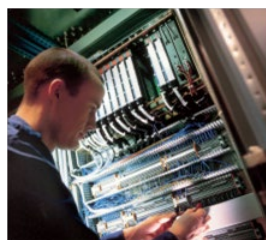
- Standard courses for new customers
- Tailor-made courses for existing customers
- Combined training courses and service visits

A Standard Training Program includes

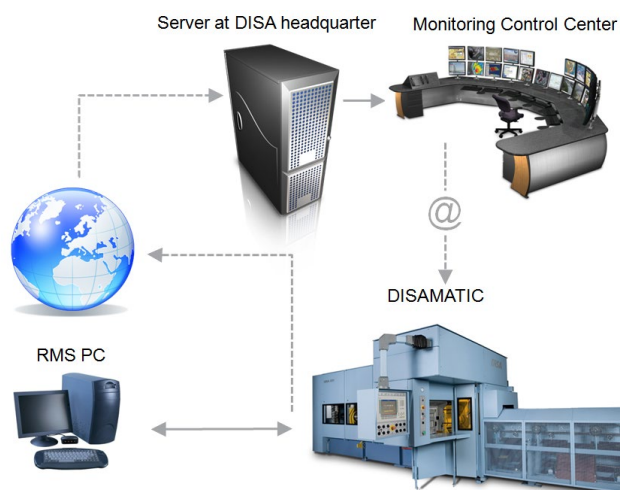
- Operator Training
- Mechanical Training
- Hydraulic and Pneumatic Training
- Understanding Electrical Diagrams
- Systematic Troubleshooting
- Proper Adjustment of the DMS Moulding Line

The DISA Training Department can help you increase your Profits by

- Increasing the uptime of the Moulding Equipment
- Reducing the Scrap Rate
- Getting better qualified Maintenance
- More motivated and committed Employees



RMS Remote Monitoring System



Early warnings to prevent downtime and an expert evaluation on a weekly basis

Machine Data Logging 24/7

- On operational pressure, speed, acceleration and pump
- A DISA specialist remotely analyses machine data/status
- Immediate response to critical issues
- Erroneous machine behaviour is reported to the customer

Monthly Reports

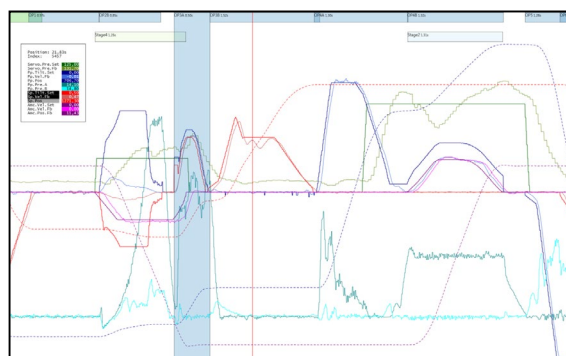
- Performance report based on the weekly inspection with recommendations is sent to the customer once a month

Remote Diagnostic Assistance

- DISA service organization assist the customer when required
- Easier troubleshooting and support

Benefits

- Optimize machine performance
- Minimize downtime
- Inside-out view of machine performance
- Act on the early warning signals
- Immediately contact about any critical issues
- Support to more efficient maintenance
- Optimized production



Machine Type

Support Status

DISA 130 – 280	Supported
DISAMATIC 2013 PLC upgraded	Supported
DISAMATIC 2013 MK5	Supported
DISAMATIC 2070 MK2	Supported
DISAMATIC 2110 MK3	Supported
DISAMATIC D1	Supported
DISAMATIC D3	Supported

Production Optimization Training



Well trained operators and maintenance personnel are the key to run your highly automatic DISA moulding machine in the most efficient way.

Understanding how the moulding machine interacts with foundry technology is fundamental to solving products and productivity related problems.

This training program deals with the grey zone between machine and foundry technology. Foundry personnel will achieve the ability to find the root cause to each problem.

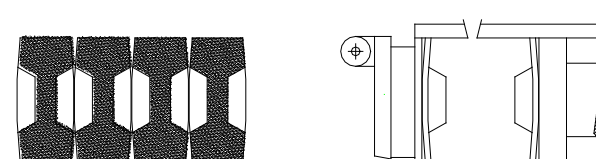
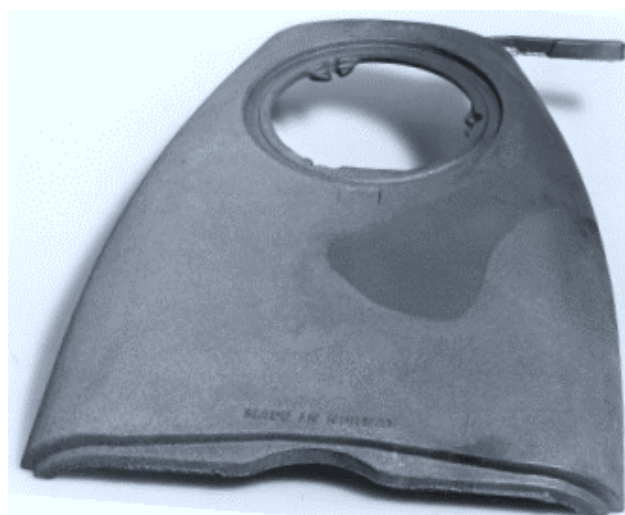
Essential Training Areas

- Machine and Foundry Technology Training
- Chamber filling
- Unparallel moulds
- Tear off
- Mismatch
- Deformation of mould cavity
- Loose sand in moulds

Production optimization is a 5-days training in machine and foundry technology.

The last day is a workshop on solving customer issues.

Solutions to many common problems are given from a machine and foundry technology perspective.



Foundry Technology for DISA Operators



Small self directed teams of skilled and well trained operators are the key to run your highly automated moulding machine in the most efficient way.

Bringing foundry technology knowledge to the operators is the easiest and cheapest way to maintain a foundry process of constant improvements, making your foundry more competitive.

This training program produces confident and motivated operators directly involved in the decision making process.

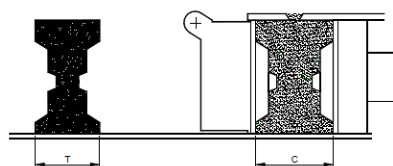
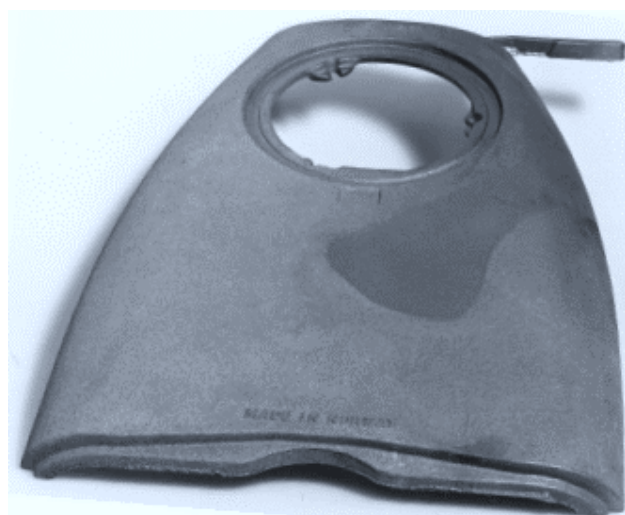
- Machine Settings
- Production Features

Essential Training Areas

- Moulding sand
- Pattern equipment
- Moulding of green sand cores
- Process control

The operator training is tailor made to suit the foundries' needs in the best possible way and consists of both theoretical and practical training directly at the customer site.

The final goal is to give the DISA operators the necessary knowledge to be able to maintain on target production.



$$\text{Compressibility} = \frac{C - T}{C} \times 100$$

Foundry Optimization Technology Assistance



The DISA Foundry Optimization Technology Department has for the past four decades, successfully helped hundreds of customers around the world solving problems related to the DISA production line of the foundry process in general.

DISA engineers make up a complete team of experts in foundry technology with a lot of practical experience, cultural and language knowledge.

The technology assistance helps foundries trouble shooting and solving complex problems using modern tools and methods mixed with hands-on experience.

The assistance is tailor-made problem solving to suit the foundries' needs in the best possible way and consists of on-site foundry consultations.

The final goal is to lower production costs and increase earnings long terms.

Areas of Assistance

- Moulding sand
- Pattern equipment
- Cores
- Moulding of green sand cores
- Feeding and gating
- Process control
- Machine settings
- Production features



DISA Win-Win through foundry optimization



Money saved



Quality



Resource Control



Productivity

Achieve risk-free process improvements and pay by results. DISA's Application's Win-Win consultancy boosts quality, yield and profit at zero risk

Foundries working with DISA's Application team of elite engineers can now benefit from a zero risk 'Win-Win' contract - an agreement whereby customers only pay once DISA has delivered real improvements to their process to help them overcome specific pains like the following:

- Improvement of yield
- Reduction of scrap
- Increase the moulding output

DISA's Application engineers agree the target metrics with clients and guide them through the improvement journey, testing and measuring, making recommendations and managing their implementation. Customers must therefore be open to implementation changes.

The aim for DISA is to share our experience from serving hundreds of foundries worldwide, and the Win-Win agreement is only efficient through a trusting and engaged collaboration between DISA and the customer. The customer describes the foundry's pains and can choose up to 10 pattern plates to improve, providing relevant data from production. The customer decides the objectives for optimization.

If the agreed optimization is achieved, the customer pays EUR 5,000 per 1% the category in question improves (up to a maximum of 5% corresponding to EUR 25,000 per pattern plate). Improvements of more than 5% will not be invoiced.

"With a Win-Win contract, instead of paying a consultancy day rate, the client pays by results. No win, no fee."

This arrangement means DISA only gets paid when the engineers improve the process - we take the risk – not the client."

Bo Wolff Haugbølle
Vice President, OEM Sales DISA

Cleaning Tool for Chamber Vents



Clean Vents are the key to reliability

In order to prevent soft moulds due to sand blocking in the chamber vents, DISA recommends using this cleaning tool kit, which is available for all DISA machines.

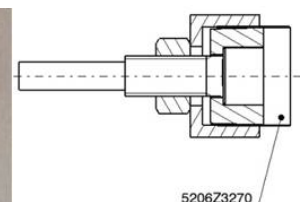
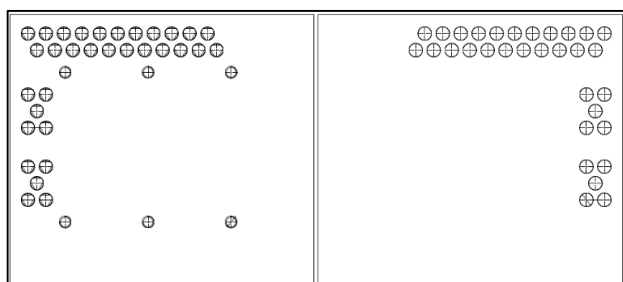
Normally, cleaning of chamber nozzles can be a time consuming task, but this new cleaning tool kit ensures a fast and easy process.

The cleaning tool is prepared for mounting on a regular drilling machine.

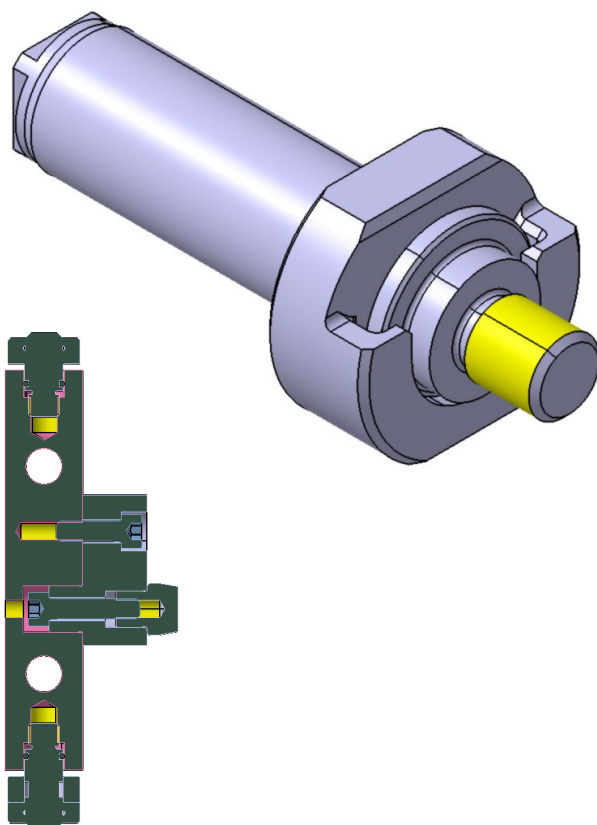
Advantages of applying this kit

- Prevents soft moulds
- Easy cleaning of chamber nozzles
- Easy to use and handle
- The cleaning tool is delivered assembled

Please contact your local DISA representative and ask for item number **5206Z3260**



Pattern plate guides and locks for DISA 130, 131, 230, 231 and DISAMATIC D3



Tackle mismatch with this simple DISA upgrade

We have got the right solution lined up to reduce mismatch

Only perfectly aligned pattern plates can produce perfect moulds.

Inconsistent pattern alignment during pattern changes causes mould mismatch which can reduce your casting quality. Faultfinding that mismatch can be very time consuming, eating up hours of unplanned downtime.

To ensure plates are precisely in line, we optimised the guide pins and pattern locks on the latest DISAMATIC D3. These are now available as retrofittable kits for DISA 130/230, 131/231 and DISAMATIC D3 (150201-150261).

The result?

Constantly aligned pattern plates after every pattern change. And it's an easy upgrade for your machine too.

The DMM kits include all necessary update parts and screws to update 10 sets of pattern plates.

The APC kit includes new locks and pivoting brackets to update 2 pattern plate jigs.

Minimise pattern misalignment

Upgrading your DISAMATIC with stronger guide pins and floating pattern locks gives you reliable, ultra-accurate pattern plate alignment.

The new guide pin mechanism is stiffer with tighter tolerances, so alignment is consistently better – today and for years to come. Changing patterns becomes easier too.

Fit a pattern lock upgrade kit to your DISAMATIC machine and gain:

- Perfect pattern plate alignment for minimum mould mismatch
- A more rigid connection between machine and pattern plates
- Faster, slicker pattern plate changes by operators

Consistent accuracy and quality

Fitting new pins and guide locks to your DISAMATIC machine is quick and easy. Just click on the button below to find a simple route to cutting-edge mould and casting accuracy.

Part Type	Part No.
Kit_Not comp. A/B/X/Y/Z, M12, D3	11148204
Kit_Not comp. C, M12, D3	11148235
Kit_Comp. A/B/X, M12, D3	11148236
Kit_Not comp. A/B/X/Y/Z, UNC, D3	11148292
Kit_Not comp. C, UNC, D3	11148305
Kit_Comp. A/B/X, UNC, D3	11148307
Kit_APC parts, D3	11148321

V-rings for Core Masks



V-rings in Core Masks

Sometimes it is necessary to obtain a better sealing and an increased suction area for holding the cores in position in the core mask. This can be done by using V-rings (lip rings) in the core mask.

This can be necessary in cases of heavy cores or cores where the location of the suction area is unfavorable because of the core geometry.

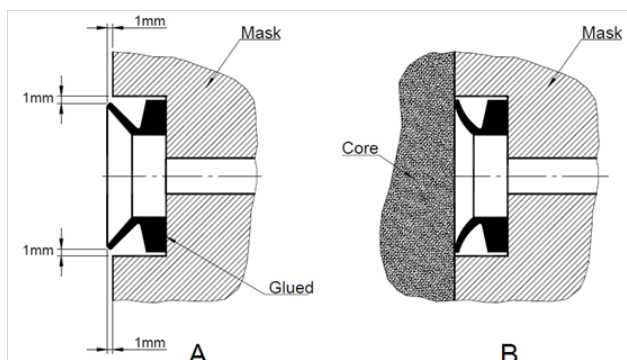
In many cases a simple small recess is made in the core mask in which the V-ring can be glued into position.

The figure below shows the principle in the use of and placement of the V-ring. A is Unloaded and B is loaded.

Please contact your local DISA Representative and ask for the part required from the table below.



Part Type	Part No.	Inner dia (d)	Outer dia (D)	Height (H)
V-ring - D5,5 - 6,5	10083362	5,0	9,0	3,7
V-ring - D8,0 - 9,5	10083363	7,0	11,0	3,7
V-ring - D9,5 - 11,5	10083364	9,0	15,0	5,5
V-ring - D911,5 - 12,5	10083365	10,5	16,5	5,5
V-ring - V14A	9105F0985	12,5	18,5	5,5
V-ring - D15,5 - 17	10083366	14,0	20,0	5,5
V-ring - D17,5 - 19	10083367	16,0	22,0	5,5
V-ring - D19 - 21	10083368	18,0	26,0	7,5
V-ring - D24 - 27	10083369	22,0	30,0	7,5
V-ring - V40A	9105F0642	38,0	43,0	9,0
V-ring - D53 - 58	10083208	49,0	59,0	9,0



DISA FMK Cassette Filter for DISAMATIC 2013, DISA 130, 131, 230 and 231



Excellent efficiency and improved workspace

The new upgrade kit for DISAMATIC is a development of the well tested cyclone, used to clean air from the sand chamber. The upgrade kit improves the environment by providing a higher cleaning efficiency and improves the workspace by reducing the sound levels.

Advantages of applying this kit

- The filter is manufactured in galvanized sheet metal and this protect against wear and tear

- Cleaning efficiency is above 99,9%
- Protection shield for the cassette to avoid damage from abrasive dust types
- Self cleaning filters via compressed air with adjustable timer
- Lower sound levels compared to existing cyclone
- Easy front access for controls and dust bin
- 100 liters dust bin plan

Please contact your local DISA Representative and ask for item number **2440R1970**

Spare Parts for Cassette Filter

Part Type	Part No.	Qty
Door seal	10143427	1
Filter cassette	9107L8041	2
Securing arm	10143428	2
Diaphram VEB 508	10143429	2
Coil for solenoid Valve	10143431	2
Complete Valve cover for solenoid Valve	10143433	2
Pressure gauge	10143434	1
Electrical controller DFC-08M	10143436	1
Seal for filter cassette	10143437	2



Double cassette filters are self cleaning via compressed air, controlled by an adjustable timer.



Tie Rod and Bushing for DISA 130, 131, 230, 231 and D3



Maintaining Casting Quality

Keeping your DISA in top operating condition is one of the keys to maintaining your overall casting quality. Worn tie rods and bushings can lead or contribute to parting line shift, sand inclusion and other casting defects related to the moulding process.

DISA has designed and assembled an easy to order kit to help ensure that you order all of the necessary components required to replace the swing plate guiding system.

This kit includes 4 hardened tie rods, 4 bushings and all necessary seals and scrapers for a complete overhaul of tie rods.

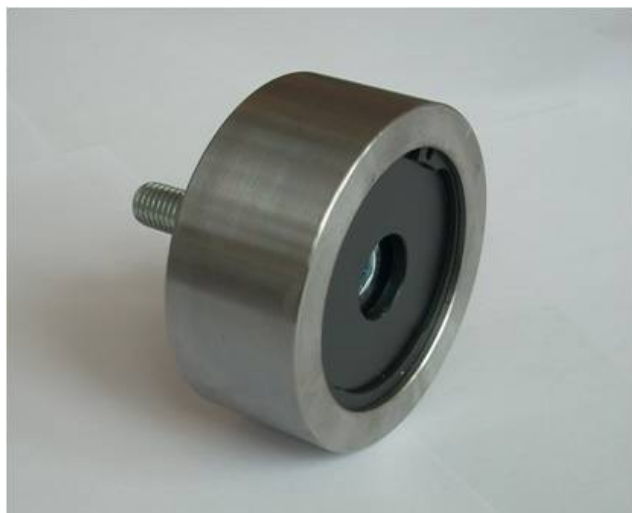
- Easy and convenient to order all necessary parts
- Reduced price compared to ordering the parts individually

Please contact your local DISA Representative and ask for item number **10166129**

Part Type	Part No.	Qty
Tie Rod Bearing	2440F2000	4
Tie Rod Hardened	2440F2080	4
Scraper	9105F0974	8
Stepseal	9105F1001	8
O-Ring	10083357	4
O-Ring	10083328	4
O-Ring	10083052	4



AMC Thrust Bar Support Rollers for DISAMATIC 2013 MK3, MK4 A/B and MK4 LP



Reduce your change Out-time

Keeping your DISAMATIC in top operating condition is one of the keys to maintain your overall casting quality.

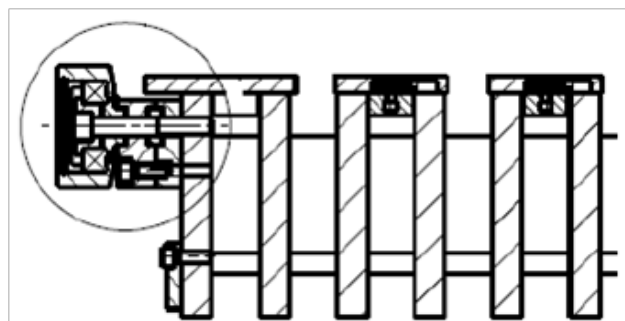
The AMC is a vital part of the moulding process and is subject to extreme heat in addition to Wear associated with transporting the mould string.

To help reduce maintenance man-hours, DISA has designed and assembled an easy to change AMC roller to save you time and money.

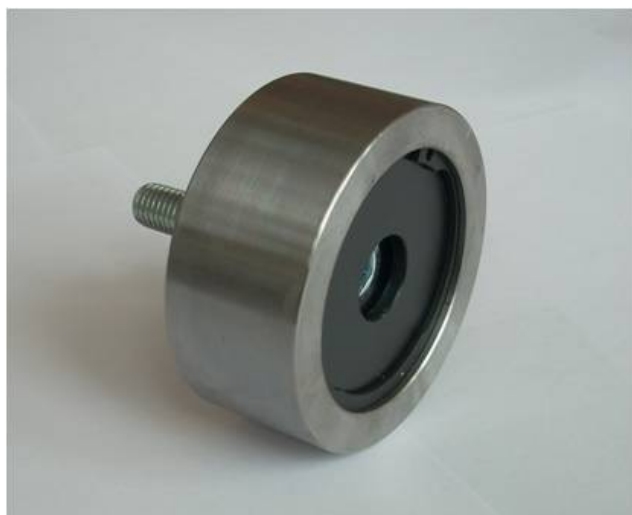
This new design roller is currently available for A, B, C & X size machines.

Please contact your local DISA Representative and ask for the part specified for your machine type as indicated in table below.

Machine Type	Part No.
DISAMATIC 2013 MK3, MK4 A/B & MK4 LP	10179021
	2052R0280
Replaces:	2052R0310



AMC Thrust Bar Support Rollers for DISAMATIC 2013 MK5, DISA 130, 131, 230 and 231



Reduce your change Out-time

Keeping your DISAMATIC in top operating condition is one of the keys to maintain your overall casting quality.

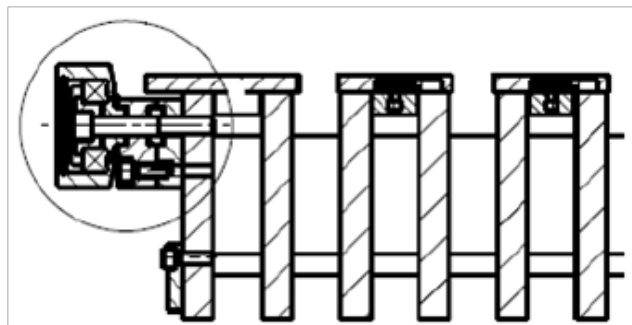
The AMC is a vital part of the moulding process and is subject to extreme heat in addition to Wear associated with transporting the mould string.

To help reduce maintenance man-hours, DISA has designed and assembled an easy to change AMC roller to save you time and money.

This new design roller is currently available for A, B, C & X size machines.

Contact your local DISA Representative and ask for the part specified for your machine type as indicated in table below.

Machine Type	Part No.
DISAMATIC 2013 MK5 & DISA 130 - 231	10135450
Replaces:	2052R0790
	2052R0800



Bushing for DISAMATIC 2013 MK3, MK4, MK4 LP and MK5



Maintaining Casting Quality

Keeping your DISAMATIC in top operating condition is one of the keys to maintain your overall casting quality.

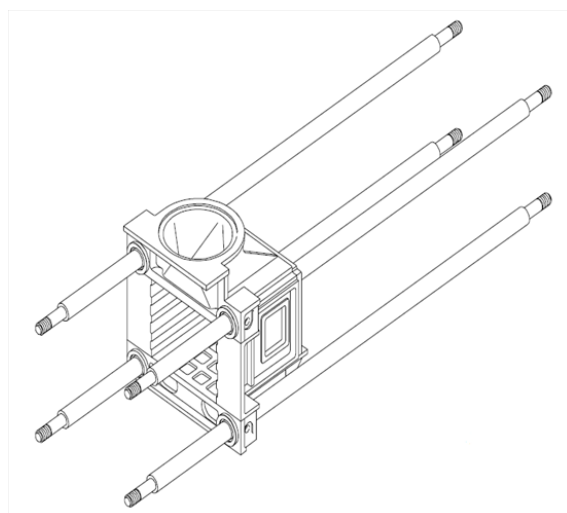
Worn tie rods and bushings can lead or contribute to parting line shift (mismatch), sand inclusion and other casting defects related to the moulding process.

DISA has designed and assembled an easy to order kit to help ensure that you order all of the bushings and scrapers required to replace the Swing Plate guiding system.

This kit is currently available for 2013 Mk 3 through 2013 Mk 5 machines with A, B & X chamber sizes.

Please contact your local DISA Representative and ask for item number **10165667**

Part Name	Part No.	Qty
Bushing	2040F1061	12
Scrapers	2040F0471	40
Fittings	2050D1130	12



Original Pattern Plate – Metric for DISAMATIC 2013 compatible to DISA 130, 131, 230 and 231 B



Original DISA Pattern Plate available at attractive Price

Please ask for our best prices for 20 or 50 pieces.

Get the best out of your DISA machine using original Pattern Plate.

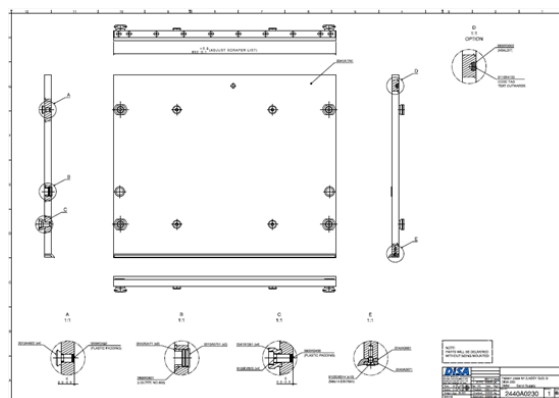
Please contact your local DISA Representative and ask for item number **2440A0230**

DISA has improved the supply chain and is now able to provide high quality Pattern Plates at attractive prices.

Type of Machine:

DISAMATIC 2013 MK3 - 5 B, LP B & DISA 130 - 231 - B

Part Name	Part No.	Qty
Pattern Plate size B	2041A1741	1
Screw Mh2	2013A4922	4
Lock button size A/B	2041A1351	4
Screw Mh12x25	10022910	4
Scraper size B, Pattern Plate	2040A3661	1
Rail size B, Pattern Plate	2040A3671	1
Screw M6x14	10023412	10



Original Pattern Plate – Metric for DISAMATIC 2013 compatible to DISA 130, 131, 230 and 231 A



Original DISA Pattern Plates available at attractive prices.

Please ask for our best prices for 20 or 50 pieces.

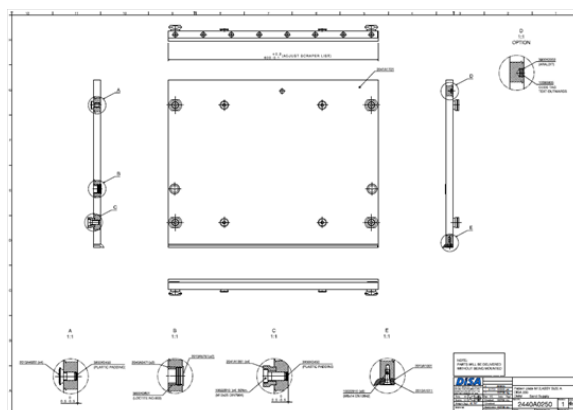
Get the best out of your DISA machine using the original Pattern Plate.

Please contact your local DISA Representative and ask for item number **2440A0250**

DISA has improved the supply chain and is now able to provide high quality Pattern Plates at attractive prices.

Type of Machine
DISAMATIC 2013 MK3-5 A, LP A &
DISA 130-231 A

Part Name	Part No.	Qty
Pattern Plate size A	2041A1721	1
Screw Mh2	2013A4922	4
Lock button size A/B	2041A1351	4
Screw Mh12x25	10022910	4
Scraper size A, Pattern Plate	2013A1001	1
Rail size A, Pattern Plate	2013A1011	1
Screw M6x14	10023412	8



Original Pattern Plate – Quick Lock Version for DISAMATIC 2110



Original DISA Pattern Plates available at attractive prices.

Please ask for our best prices for 20 or 50 pieces.

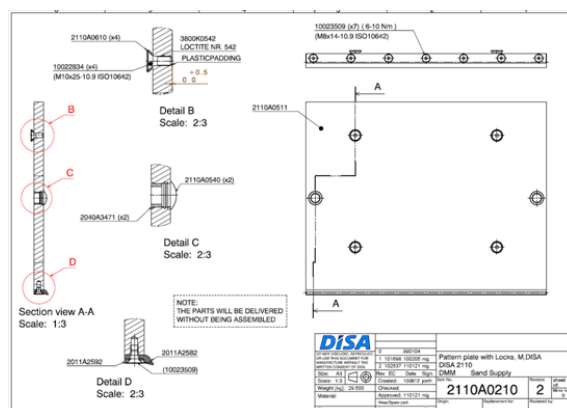
Get the best out of your DISA machine using the original Pattern Plate.

Please contact your local DISA Representative and ask for item number **2110A0210**

DISA has improved the supply chain and is now able to provide high quality Pattern Plates at attractive prices.

Type of Machine: DISAMATIC 2110

Part Name	Part No.	Qty
Pattern Plate	2110A0511	1
Scraper Pattern Plate	2011A2582	1
Rail, Pattern Plate	2011A2592	1
Screw M8x14	10023509	7
Washer	2110A0610	4
Screw M10x25	10022834	4
Bushing	2040A3471	2
Plug	2110A0540	2



Automatic Cleaning of Lifting Cam's for DISA 130, 131, 230 and 231



The kit for automatic cleaning of lifting cam's is developed to give you a lower cost of maintenance and to upgrade existing machines with the latest technology.

Further more this kit will provide a more smooth movement of SP operations, and it will increase the lifetime on all Wear parts in the SP lifting mechanism.

Easy installation and low cost compared to parts lifetime.

- Extend the lifetime to lifting cam's
- Extended lifetime to SP bearings
- Reduce your cost of maintenance
- More smooth movement of SP in Op. 3 and 6

Please contact your local DISA Representative and ask for item number **10098012**



Tie Rod and Bushing for DISAMATIC 2013 MK3, MK4 and MK5



Maintaining Casting Quality

Keeping your DISAMATIC in top operational condition is one of the keys to your overall casting quality.

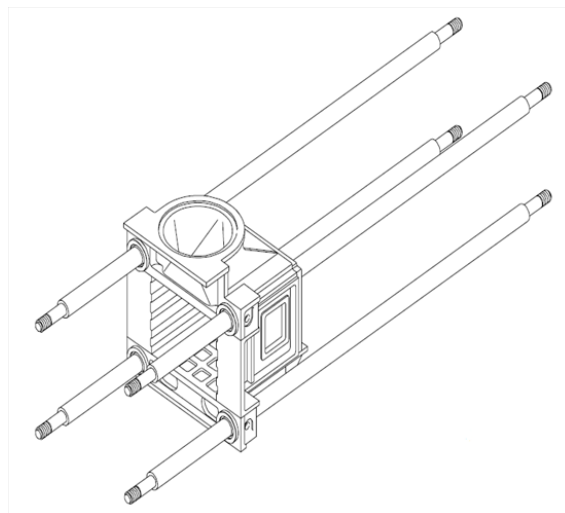
Worn tie rods and bushings can lead or contribute to parting line shift, Sand inclusion and other casting defects related to the moulding process.

DISA has designed and assembled an easy to order kit to help ensure that you order all of the necessary components required to replace the Swing Plate guiding system.

This kit is currently available for 2013 Mk3 - 5 machines with A, B & X chamber sizes.

Please contact your local DISA Representative and ask for item number **10177443**

Part Name	Part No.	Qty
Tie Rods	2011B1472	4
Bushings	2040F1061	12
Flange Scraper	2040F0041	24
Scrapers	2040F0471	40
Fittings	2050D1130	12
Screws	10023336	96



Hydraulic Filter Kit for DISAMATIC 2013 MK5



Clean Oil is key to reliability

Most hydraulic component failures are due to the presence of abrasive contaminants in the fluid.

Clean hydraulic fluid is the key to reliability, and effective contamination control is the way to achieve and maintain this.

Get a Filter Kit for every 800,000 moulds produced

This hydraulic filter kit contains all filter cartridges for 800,000 moulds.

3 advantages of applying this kit

- Avoid unplanned stops due to oil contamination
- Reduce cost of maintenance by preventive replacement of filter cartridges
- We recommend to replace the filters by a delivery that matches your foundry plan

The kit can be installed to

- 2013 MK5 with serial number 2919 and higher
- 2013 MK5 that have been upgraded with **2050R9930**
- 2013 MK4 that have been upgraded with **2040R7540**
- 2013 MK4 LP that have been upgraded with **2040R7530**

Please contact your local DISA Representative and ask for item number **10177450**

Type of Machine: DISAMATIC 2013 MK5

Part Name	Component	Part No.	Qty
DMM hydraulic			
Breather filter	HY57	9107L7003	2
HY filter	HY20	9107L7490	1
HY filter	HY21	9107L7535	1
AMC			
Breather filter	HY119	9107L7003	2
HY filter	HY113	9107L7490	1



Hydraulic Filter Kit for DISA 230



Clean Oil is key to reliability

Most hydraulic component failures are due to the presence of abrasive contaminants in the fluid.

Clean hydraulic fluid is the key to reliability, and effective contamination control is the way to achieve and maintain this.

Get a Filter Kit for every 800,000 moulds produced

This hydraulic filter kit contains all filter cartridges for 800,000 moulds.

3 advantages of applying this kit

- Avoid unplanned stops due to oil contamination
- Reduce cost of maintenance by preventive replacement of filter cartridges
- We recommend to replace the filters by a delivery that matches your foundry plan

Please contact your local DISA Representative for more information.

Type of Machine: DISA 230

Machine Type	Part No.
DISA 230	10122551



Hydraulic Filter Kit for DISA 240



Clean Oil is key to reliability

Most hydraulic component failures are due to the presence of abrasive contaminants in the Fluid.

Clean hydraulic Fluid is the key to reliability, and effective contamination control is the way to achieve and maintain this.

Get a Filter Kit for every 800,000 moulds produced

This hydraulic filter kit contains all filter cartridges for 800,000 moulds.

3 Advantages of applying this kit

- Avoid unplanned stops due to oil contamination
- Reduce cost of maintenance by preventive replacement of filter cartridges
- We recommend to replace the filters by a delivery that matches your foundry plan

Please contact your local DISA Representative and ask for this item.

Type of Machine: DISA 240

Machine Type	Serial No.	Part No.
DISA 240	170001 - 170026	10122553
	170027 -	10852287



Hydraulic Filter Kit for DISA 250



Clean Oil is key to reliability

Most hydraulic component failures are due to the presence of abrasive contaminants in the Fluid.

Clean hydraulic fluid is the key to reliability, and effective contamination control is the way to achieve and maintain this.

Get a Filter Kit for every 800,000 moulds produced

This hydraulic filter kit contains all filter cartridges for 800,000 moulds.

3 advantages of applying this kit

- Avoid unplanned stops due to oil contamination
- Reduce cost of maintenance by preventive replacement of filter cartridges
- We recommend to replace the filters by a delivery that matches your foundry plan

Please contact your local DISA Representative and ask for this item.

Type of Machine: DISA 250

Machine Type	Serial No.	Part No.
DISA 250	160001 - 160015	10122553
	160016 -	10852287



Hydraulic Filter Kit for DISA 270



Clean Oil is key to reliability

Most hydraulic component failures are due to the presence of abrasive contaminants in the Fluid.

Clean hydraulic Fluid is the key to reliability, and effective contamination control is the way to achieve and maintain this.

Get a Filter Kit for every 800,000 moulds produced

This hydraulic filter kit contains all filter cartridges for 800,000 moulds.

3 advantages of applying this kit

- Avoid unplanned stops due to oil contamination
- Reduce cost of maintenance by preventive replacement of filter cartridges
- We recommend to replace the filters by a delivery that matches your foundry plan

Please contact your local DISA Representative and ask for this item.

Type of Machine: DISA 270

Machine Type	Serial No.	Part No.
DISA 270	180001 - 180010	10122553
	180011 -	10852287



Hydraulic Filter Kit for DISA 280 (Serial numbers 190001-190006)



Clean Oil is key to reliability

Most hydraulic component failures are due to the presence of abrasive contaminants in the fluid.

Clean hydraulic fluid is the key to reliability, and effective contamination control is the way to achieve and maintain this.

Get a Filter Kit for every 800,000 moulds produced

This hydraulic filter kit contains all filter cartridges for 800,000 moulds.

3 advantages of applying this kit

- Avoid unplanned stops due to oil contamination
- Reduce cost of maintenance by preventive replacement of filter cartridges
- We recommend to replace the filters by a delivery that matches your foundry plan

Please contact your local DISA Representative and ask for item number **10642693**

Type of Machine: DISA 280

Part Name	Component	Part No.	Qty
DMM Hydraulic			
Breather filter	H0 V88	9107L7332	4
HY filter	H1 Z55	9107L7510	1
HY filter	H1 Z62	9107L8005	2
Central Lubrication			
Oil filter	L1 Z2	9107L5701	4
AMC/PMC			
Breather filter	H3 Z103	9107L7833	1
HY filter	H3 Z112	9107L7512	1



Hydraulic Filter Kit for DISA 231



Clean Oil is key to reliability

Most hydraulic component failures are due to the presence of abrasive contaminants in the fluid.

Clean hydraulic fluid is the key to reliability, and effective contamination control is the way to achieve and maintain this.

Get a Filter Kit for every 800,000 moulds produced

This hydraulic filter kit contains all filter cartridges for 800,000 moulds.

3 advantages of applying this kit

- Avoid unplanned stops due to oil contamination
- Reduce cost of maintenance by preventive replacement of filter cartridges
- We recommend to replace the filters by a delivery that matches your foundry plan

Please contact your local DISA Representative and ask for item number **10122552**

Type of Machine: DISA 231

Machine Type	Serial No.	Part No.
DISA 231	150101 - 150184	10122552
	150185 -	10852277



Hydraulic Filter Kit for DISA 130 and 131



Clean Oil is key to reliability

Most hydraulic component failures are due to the presence of abrasive contaminants in the Fluid.

Clean hydraulic fluid is the key to reliability, and effective contamination control is the way to achieve and maintain this.

Get a Filter Kit for every 800,000 moulds produced

This hydraulic filter kit contains all filter cartridges for 800,000 moulds.

3 advantages of applying this kit

- Avoid unplanned stops due to oil contamination
- Reduce cost of maintenance by preventive replacement of filter cartridges
- We recommend to replace the filters by a delivery that matches your foundry plan

Please contact your local DISA Representative and ask for item number **10122554**

Type of Machine: DISA 130 & 131

Part Name	Component	Part No.	Qty
DMM Hydraulic			
Breather filter	H0 V88	9107L7332	4
HY filter	H1 Z55	9107L7512	1
HY filter	H1 Z64	9107L7512	1
Central Lubrication			
Oil filter	L1 Z2	9107L5701	4



Hydraulic Filter Kit for DISAMATIC 2120



Clean Oil is key to reliability

Most hydraulic component failures are due to the presence of abrasive contaminants in the Fluid.

Clean hydraulic fluid is the key to reliability, and effective contamination control is the way to achieve and maintain this.

Get a Filter Kit for every 800,000 moulds produced

This hydraulic filter kit contains all filter cartridges for 800,000 moulds.

3 advantages of applying this kit

- Avoid unplanned stops due to oil contamination
- Reduce cost of maintenance by preventive replacement of filter cartridges
- We recommend to replace the filters by a delivery that matches your foundry plan

Please contact your local DISA Representative and ask for item number **10152507**

Type of Machine: DISAMATIC 2120

Part Name	Component	Part No.	Qty
DMM Hydraulic			
Breather filter	HY2	9107L7132	4
HY filter	HY18	9107L7153	1
HY filter	HY20	9107L7077	1
Off line filter	HY45	9107L7118	1



Hydraulic Filter Kit for DISAMATIC 2130



Clean Oil is key to reliability

Most hydraulic component failures are due to the presence of abrasive contaminants in the Fluid.

Clean hydraulic fluid is the key to reliability, and effective contamination control is the way to achieve and maintain this.

Get a Filter Kit for every 800,000 moulds produced

This hydraulic filter kit contains all filter cartridges for 800,000 moulds.

3 advantages of applying this kit

- Avoid unplanned stops due to oil contamination
- Reduce cost of maintenance by preventive replacement of filter cartridges
- We recommend to replace the filters by a delivery that matches your foundry plan

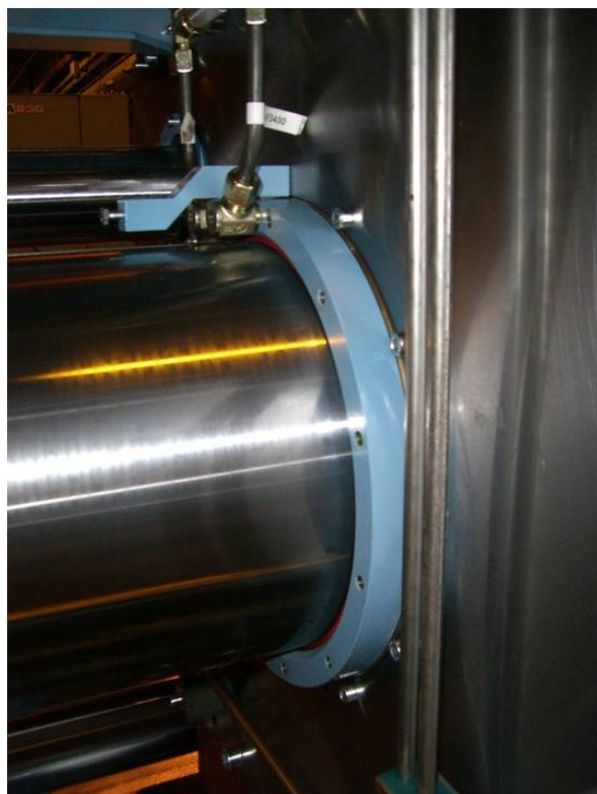
Please contact your local DISA Representative and ask for item number **10152508**

Type of Machine: DISAMATIC 2130

Part Name	Component	Part No.	Qty
DMM Hydraulic			
Breather filter	HY2	9107L7132	8
HY filter	HY10	9107L7058	1
HY filter	HY18	9107L7077	1
HY filter	HY20	9107L7077	1
Off line filter	HY45	9107L7118	1
Central Lubrication			
Oil filter	L1 Z2	9107L5701	4



Seal Kit for PP Chamber Bearings for DISA 130, 131, 230 and 231



Maintenance of PP Chamber Bearings

When considering your preventive maintenance incentives, we recommend repairing the chamber bearings in order to avoid Wear on the outer piston.

It is important to keep all scrapers and seals in good condition; therefore we recommend preventive maintenance on chamber bearings as a minimum at every 1 million moulds. This can easily be performed using this DISA repair kit, which has all the necessary parts included.

3 advantages of applying this kit

- Improves the Lifetime of Outer Piston
- Improves the Lifetime of the Chamber Bearing
- Easy to order - only one item number, which includes all necessary parts

The seal kit is delivered with all O-rings, step-seals, scraper and Loctite, so that repairing of the chamber bearings can be easily performed.

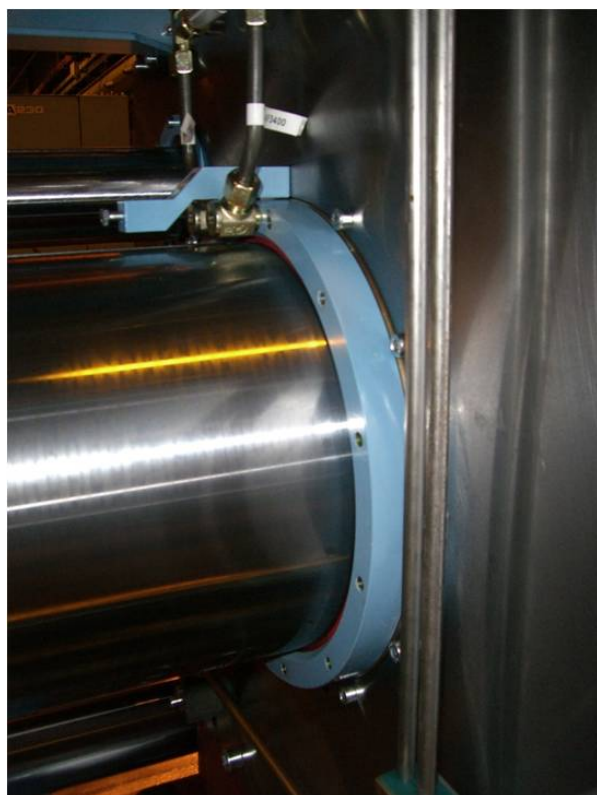
The seal kit can be installed on all new generations of DISA machines.

Please contact your local DISA Representative and ask for the part specified for your Machine Type and Serial number as indicated in the tables below.

Type of Machine	Serial No.	Seal Kit Item No.	Bushing Item No.
DISA 131-350	140001-140053	2440R2260	2440B2520
DISA 131-350	140054->	10633585	2440B2520
DISA 131-400	140201-140228	2440R2260	2440B2520
DISA 131-400	140229->	10633585	2440B2520

Type of Machine	Serial No.	Seal Kit Item No.	Bushing Item No.
DISA 230	All	2440R2260	2440B2520
DISA 231	150101-150149	2440R2260	2440B2520
DISA 231	150151-150160	2440R2260	2440B2520
DISA 231	150150+150161->	10633585	2440B2520

Seal Kit for PP Chamber Bearings for DISA 240 and 250



Maintenance of PP Chamber Bearings

When considering your preventive maintenance incentives, we recommend repairing the chamber bearings in order to avoid Wear on the outer piston.

It is important to keep all scrapers and seals in good condition; Therefore we recommend preventive maintenance on chamber bearings as a minimum at every 1 million moulds. This can easily be performed using this DISA repair kit, which has all the necessary parts included.

3 Advantages of applying this kit

- Improves the Lifetime of Outer Piston
- Improves the Lifetime of the Chamber Bearing
- Easy to order - only one item number, which includes all necessary parts.

The seal kit is delivered with all O-rings, step-seals, scraper and Loctite, so that repairing of the chamber bearings can be easily performed.

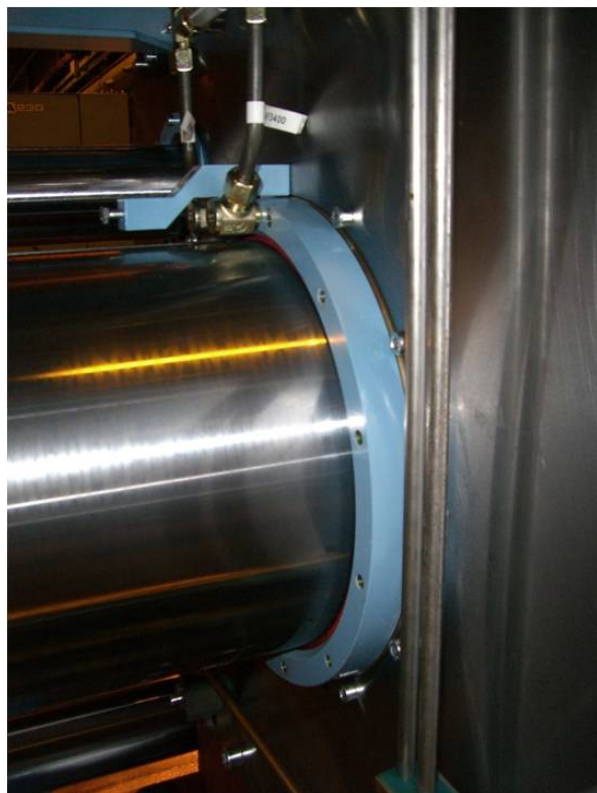
The seal kit can be installed on all new generations of DISA machines.

Please contact your local DISA Representative and ask for the part specified for your Machine Type and Serial number as indicated in the table below.

Type of Machine	Serial No.	Seal Kit Item No.	Bushing Item No.
DISA 240	170001-170020	2450R0320	2450B2000
	170021->	10633579	2450B2000

Type of Machine	Serial No.	Seal Kit Item No.	Bushing Item No.
DISA 250	160001-160012	2450R0320	2450B2000
	160013->	10633579	2450B2000

Seal Kit for PP Chamber Bearings for DISA 270



Maintenance of PP Chamber Bearings

When considering your preventive maintenance incentives, we recommend repairing the chamber bearings in order to avoid Wear on the outer piston.

It is important to keep all scrapers and seals in good condition; Therefore we recommend preventive maintenance on chamber bearings as a minimum at every 1 million moulds. This can easily be performed using this DISA repair kit, which has all the necessary parts included.

3 Advantages of applying this kit

- Improves the Lifetime of Outer Piston
- Improves the Lifetime of the Chamber Bearing
- Easy to order - only one item number, which includes all necessary parts.

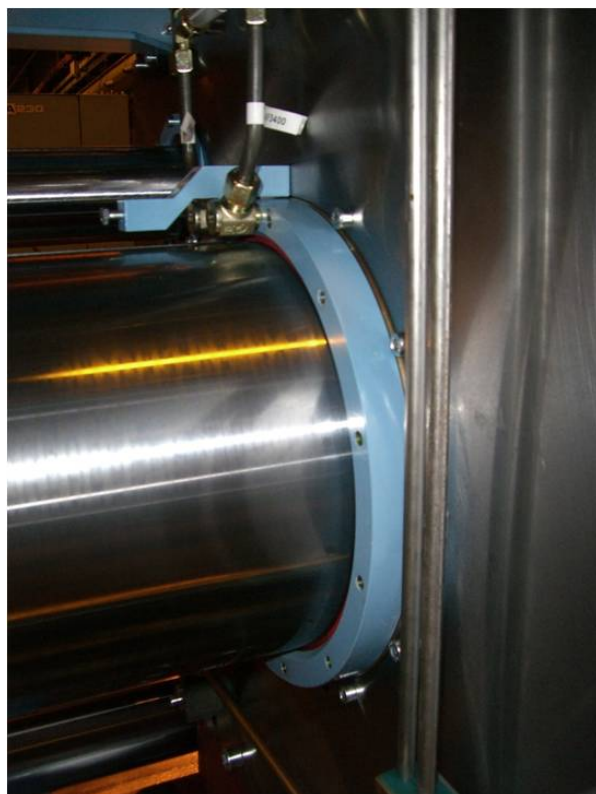
The seal kit is delivered with all O-rings, step-seals, scraper and Loctite, so that repairing of the chamber bearings can be easily performed.

The seal kit can be installed on all new generations of DISA machines

Please contact your local DISA Representative and ask for the part specified for your Machine Type and Serial number as indicated in the table below.

Type of Machine	Seal Kit Item No.	Bushing Item No.
DISA 270	2470R0150	2470B2280

Seal Kit for PP Chamber Bearings for DISA 280



Maintenance of PP Chamber Bearings

When considering your preventive maintenance incentives, we recommend repairing the chamber bearings in order to avoid Wear on the outer piston.

It is important to keep all scrapers and seals in good condition; Therefore we recommend preventive maintenance on chamber bearings as a minimum at every 1 million moulds. This can easily be performed using this DISA repair kit, which has all the necessary parts included.

3 Advantages of applying this kit

- Improves the Lifetime of Outer Piston
- Improves the Lifetime of the Chamber Bearing
- Easy to order - only one item number, which includes all necessary parts.

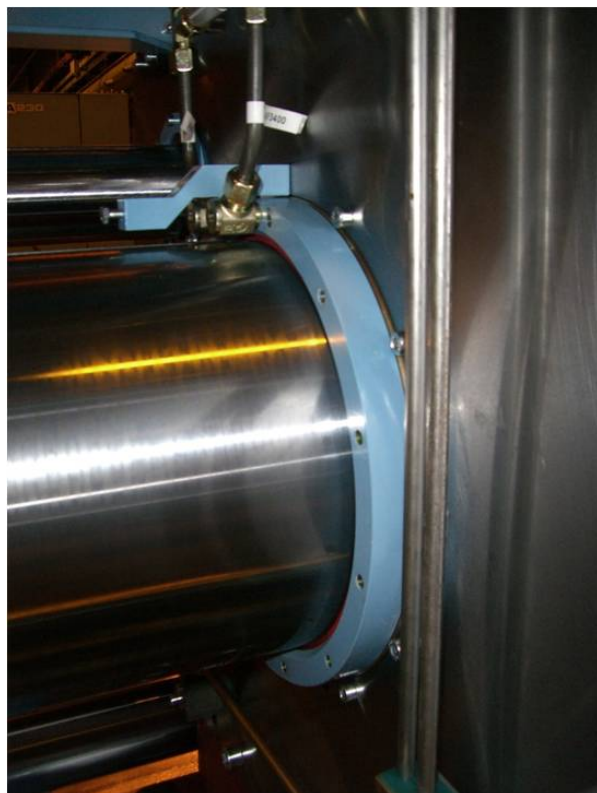
The seal kit is delivered with all O-rings, step-seals, scraper and Loctite, so that repairing of the chamber bearings can be easily performed.

The seal kit can be installed on all new generations of DISA machines.

Please contact your local DISA Representative and ask for the part specified for your Machine Type and Serial number as indicated in the table below.

Type of Machine	Seal Kit Item No.	Bushing Item No.
DISA 280	2490R0110	2490B2110

Seal Kit for PP Chamber Bearings for DISAMATIC D3



Maintenance of PP Chamber Bearings

When considering your preventive maintenance incentives, we recommend repairing the chamber bearings in order to avoid Wear on the outer piston.

It is important to keep all scrapers and seals in good condition; Therefore we recommend preventive maintenance on chamber bearings as a minimum at every 1 million moulds. This can easily be performed using this DISA repair kit, which has all the necessary parts included.

3 Advantages of applying this kit

- Improves the Lifetime of Outer Piston
- Improves the Lifetime of the Chamber Bearing
- Easy to order - only one item number, which includes all necessary parts.

The seal kit is delivered with all O-rings, step-seals, scraper and Loctite, so that repairing of the chamber bearings can be easily performed.

The seal kit can be installed on all new generations of DISA machines.

Please contact your local DISA Representative and ask for the part specified for your Machine Type and Serial number as indicated in the table below.

Type of Machine	Seal Kit Item No.	Bushing Item No.
DISAMATIC D3	10633585	2440B2520

Vacuum Unit for DISAMATIC 2013, DISA 130 – 250 and DISA MATCH



New Vacuum Unit

Based on the new generation of machines, DISA now provides a new vacuum unit.

The new vacuum unit is driven by air and is even more silent than the previous unit.

The new unit is fully compatible with the previous vacuum unit, providing a vacuum of -0.25 bar, and very easy to install.

The new vacuum unit is more reliable than the old unit and requires less maintenance.

The consuming of air is 3.4 m3 per minute with a pressure of 6 bar.

4 good reasons to install the new Vacuum Unit on DISA moulding machines

- Less Maintenance
- More silent to operate
- Easy installation
- Higher reliability

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Type of Machine	Component	Part No.
DISAMATIC 2013	110V	10026632
DISA 130 - 250	24V	10162998
DISA MATCH	24V	10162998



Seal Kit for PP, SP Main Cylinder and HY-10 for DISA 130, 131, 230, 231 and D3



This is a complete seal kit that allows you to replace all seals in the PP Cylinder, SP cylinder and the HY10 valve at the same time.

We have included the seals for Hy10 valve, because it is a great opportunity to repair and inspect the HY10 valve when you have already drained the oil from the main cylinders.

Make sure to check the HY10 valve and valve seat for damage. The spring inside HY10 should also be visually inspected for damage.

This kit it also very suitable if you only replace the seals in one of the two main cylinders.

As all the seals are the same in the PP and SP cylinders, this kit will make sure you have a spare seal, if you should damage a seal during the assembly of either the PP or SP cylinder.

Some of the advantages of applying this kit:

- Easy to order – only one item number, which includes all seals and O-rings
- All seals / O-rings to repair PP cylinder, SP cylinder and HY10 at the same time
- Replace seals to keep your machine in top condition for maximum production speed
- A great opportunity to inspect the big HY10 Valve for wear

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Type of Machine	Part No.
DISA 130, 131, 230 & 231 and D3	2440R0420

Seal Kit for PP, SP Main Cylinder and HY-10 for DISA 240 and 250



This is a complete seal kit that allows you to replace all seals in the PP Cylinder, SP cylinder and the HY10 valve at the same time.

We have included the seals for Hy10 valve, because it is a great opportunity to repair and inspect the HY10 valve when you have already drained the oil from the main cylinders.

Make sure to check the HY10 valve and valve seat for damage. The spring inside HY10 should also be visually inspected for damage.

This kit it also very suitable if you only replace the seals in one of the two main cylinders.

As all the seals are the same in the PP and SP cylinders, this kit will make sure you have a spare seal, if you should damage a seal during the assembly of either the PP or SP cylinder.

Some of the advantages of applying this kit:

- Easy to order – only one item number, which includes all seals and O-rings
- All seals / O-rings to repair PP cylinder, SP cylinder and HY10 at the same time
- Replace seals to keep your machine in top condition for maximum production speed
- A great opportunity to inspect the big HY10 Valve for wear

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Type of Machine	Part No.
DISA 240 and 250	2450R0310

Seal Kit for PP, SP Main Cylinder and HY-10 for DISA 270



This is a complete seal kit that allows you to replace all seals in the PP Cylinder, SP cylinder and the HY10 valve at the same time.

We have included the seals for Hy10 valve, because it is a great opportunity to repair and inspect the HY10 valve when you have already drained the oil from the main cylinders.

Make sure to check the HY10 valve and valve seat for damage. The spring inside HY10 should also be visually inspected for damage.

This kit it also very suitable if you only replace the seals in one of the two main cylinders.

As all the seals are the same in the PP and SP cylinders, this kit will make sure you have a spare seal, if you should damage a seal during the assembly of either the PP or SP cylinder.

Some of the advantages of applying this kit:

- Easy to order – only one item number, which includes all seals and O-rings
- All seals / O-rings to repair PP cylinder, SP cylinder and HY10 at the same time
- Replace seals to keep your machine in top condition for maximum production speed
- A great opportunity to inspect the big HY10 Valve for wear

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Type of Machine	Part No.
DISA 270	2470R0170

Seal Kit for PP, SP Main Cylinder and HY-10 for DISA 280



This is a complete seal kit that allows you to replace all seals in the PP Cylinder, SP cylinder and the HY10 valve at the same time.

We have included the seals for Hy10 valve, because it is a great opportunity to repair and inspect the HY10 valve when you have already drained the oil from the main cylinders.

Make sure to check the HY10 valve and valve seat for damage. The spring inside HY10 should also be visually inspected for damage.

This kit it also very suitable if you only replace the seals in one of the two main cylinders.

As all the seals are the same in the PP and SP cylinders, this kit will make sure you have a spare seal, if you should damage a seal during the assembly of either the PP or SP cylinder.

Some of the advantages of applying this kit:

- Easy to order – only one item number, which includes all seals and O-rings
- All seals / O-rings to repair PP cylinder, SP cylinder and HY10 at the same time
- Replace seals to keep your machine in top condition for maximum production speed
- A great opportunity to inspect the big HY10 Valve for wear

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Type of Machine	Part No.
DISA 270	2470R0170

New Base Plate, Wear Plate and Spray System for DISA MATCH 130



New improved design of Cope and Drag base and Wear Plates incl. a new developed Spray system

- Uniform distribution of Spray Fluid on Pattern surface
- Minimum Fluid dripping after Spray Valve shut off
- Less Sand block up in Spray nozzle
- Easy mounting / dismantling of Spray nozzle assembly on Squeeze Plate
- Easy cleaning procedure
- Different Spray angles available to reach best Pattern Spray cover (Optional)
- Hardened materials for all surfaces with Sand contact
- Height adjustment shims to ensure level fit with the Wear Plate

New Cope and Drag Squeeze Plate

- Without Groove for the inflatable sealing
- Prepared for the new Spray system

New Cope and Drag Wear Plate

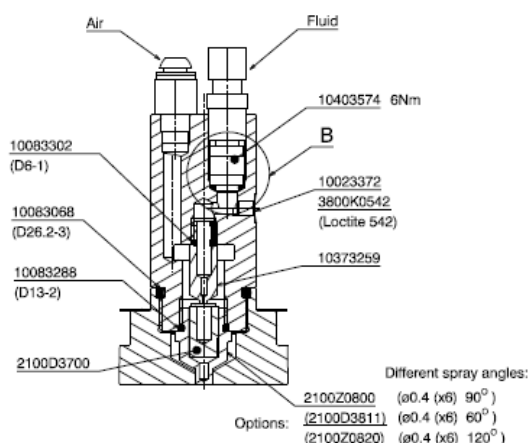
- Integrated Groove for Inflatable Sealing
- Future changing of Wear Plate. You will automatically receive a new fresh Groove for the Inflatable Sealing

Contact your local DISA Representative and ask for:

Drag Squeeze Plate Kit: Item number **10409075**

Cope Squeeze Plate Kit: Item number **10409755**

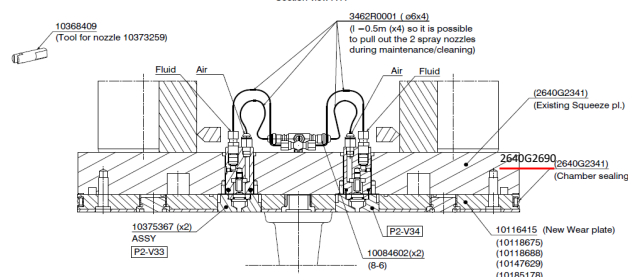
Section view A-A



A: Modification of the existing Squeeze plate
New Wear plate
(with new groove for the Chamber sealing)

[Parts list: 10409669]

Section view A-A





Technical drawing of a spray gun assembly in cross-section. The drawing shows the internal components including the air inlet, fluid inlet, and various seals and O-rings. Labels point to specific parts: Air, Fluid, 10403574 6Nm, B, 10083302 (D6-1), 10083068 (D26.2-3), 10083288 (D13-2), 2100D3700, 10023372, 3800K0542 (Loctite 542), and 10373259.

Options:

Part Number	Dimensions and Spray Angle
2100Z0800	(ø0.4 (x6) 90°)
2100D3811	(ø0.4 (x6) 60°)
2100Z0820	(ø0.4 (x6) 120°)

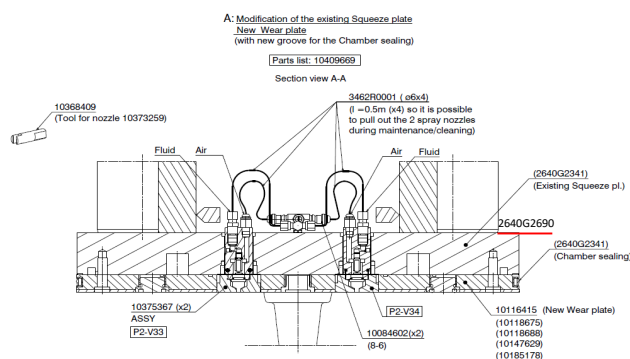
Different spray angles:

- Uniform distribution of Spray Fluid on Pattern Surface
- Minimum Fluid dripping after Spray Valve shut off
- Less Sand block up in Spray Nozzle
- Easy mounting / dismounting of Spray Nozzle assembly on Squeeze Plate
- Easy cleaning Procedure
- Different Spray Angles available to reach best Pattern Spray Cover (Optional)
- Hardened materials for all surfaces with Sand contact
- Height adjustment shims to ensure level fit with the Wear Plate

- Integrated Groove for inflatable sealing
- Future changing of Wear Plate, you will automatically receive a new fresh Groove for the inflatable sealing

- Precise drill / machining to increase the hole diameter for the new Spray Nozzles
- Drilling and threading of new holes to fastening of the new Spray Nozzles

Cope Squeeze Plate Kit:
10409669



New Spray System for DISA MATCH 130



New improved Design of Cope and Drag Base and Wear Plates incl. a new developed Spray System

- Uniform distribution of Spray Fluid on Pattern Surface
- Minimum Fluid dripping after Spray Valve shut off
- Less Sand block up in Spray Nozzle
- Easy mounting / dismantling of Spray Nozzle assembly on Squeeze Plate
- Easy cleaning Procedure
- Different Spray Angles available to reach best Pattern Spray Cover (Optional)
- Hardened materials for all surfaces with Sand contact
- Height adjustment Shims to ensure level fit with the Wear Plate

Modification of existing Cope and Drag Squeeze Plate:

- Precise Drill / machining to increase the hole diameter for the new Spray Nozzles
- Drilling and threading of new holes to fastening of the new Spray Nozzles

Contact your local DISA Representative and ask for:

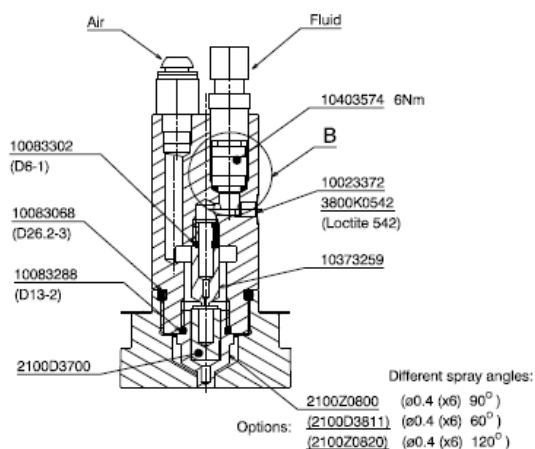
Drag Squeeze Plate Kit:

10409059

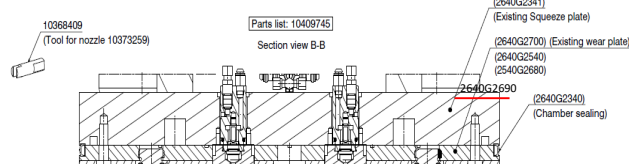
Cope Squeeze Plate Kit:

10409745

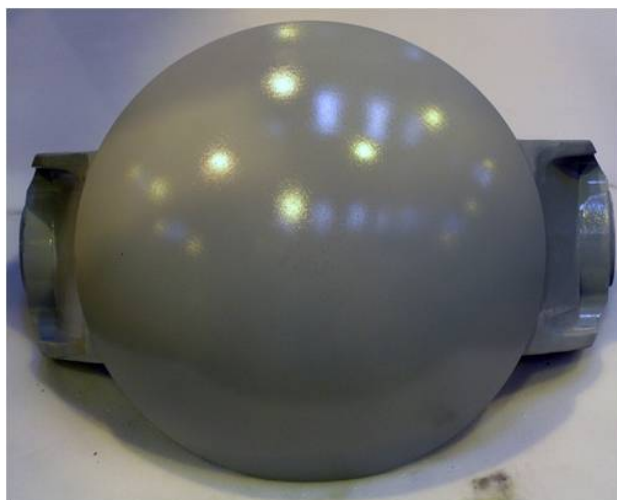
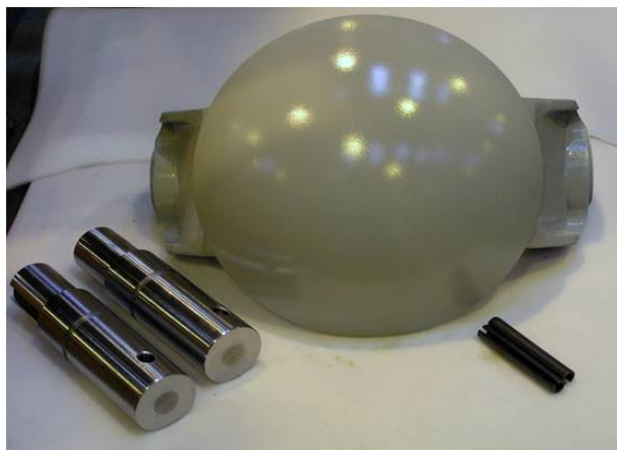
Section view A-A



B: Modification of the existing Squeeze plate Existing Wear plate



Hardened Dome Upgrade Kit for DISAMATIC 2013 MK5 X, DISA 230, MATCH 28/32 and 32/32



Reduce maintenance cost

Keeping your DISAMATIC in top operating condition is one of the keys to ensure your overall casting quality. The Sand Valve is a vital part of the moulding process and is subject to extreme wear.

The new hardened dome is more resistant to the wear from continuous contact with the sand and the lifetime of the dome is extended.

As a result of the reduced wear on the dome itself also the dome seal will last longer.

The result is that the machine will stay in shape at lower maintenance cost.

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

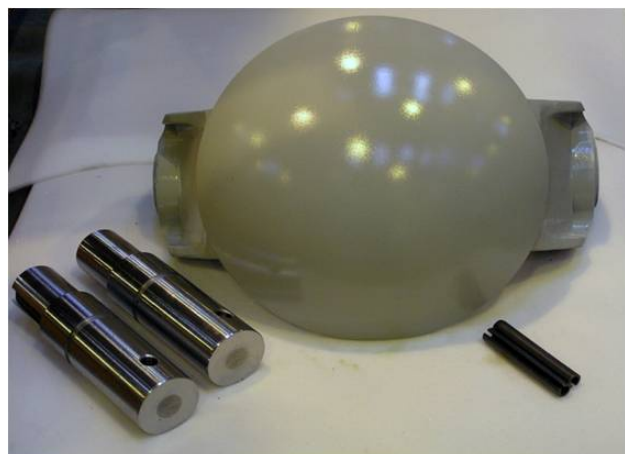
Please note:

First time buying this Kit: Use highlighted number

For later replacement: Use non-highlighted number

Machine Type	Part No.	Qty
DISAMATIC 2013 MK5 X, DISA 230, MATCH 28/32 & 32/32	2440R2800	1
Dome	2440A4240	1
Shaft	2440A4250	2
Dowel Pin	10022576	2

Hardened Dome Upgrade Kit for DISA 131 and 231



Reduce maintenance cost

Keeping your DISAMATIC in top operating condition is one of the keys to ensure your overall casting quality. The Sand Valve is a vital part of the moulding process and is subject to extreme wear.

The new hardened dome is more resistant to the wear from continuous contact with the sand and the lifetime of the dome is extended.

As a result of the reduced wear on the dome itself also the dome seal will last longer.

The result is that the machine will stay in shape at lower maintenance cost.

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

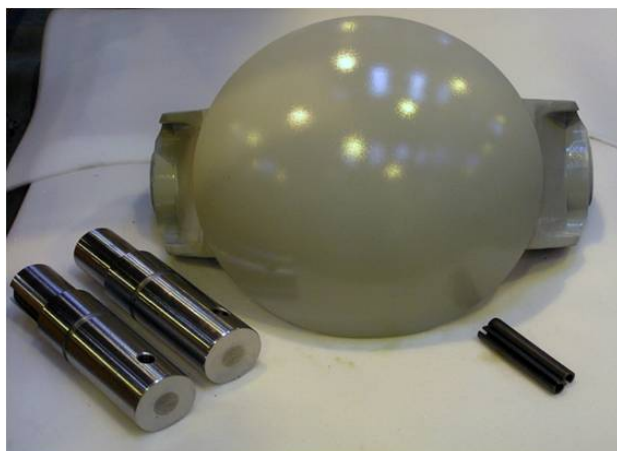
Please note:

First time buying this Kit: Use highlighted number

For later replacement: Use non-highlighted number

Machine Type	Part No.	Qty
DISA 131 & 231	10136140	1
Dome	2440A4240	1
Shaft	2450A2810	1
Shaft	10135951	1
Dowel Pin	10022576	2

Hardened Dome Upgrade Kit for DISA 240 and 250



Reduce maintenance cost

Keeping your DISAMATIC in top operating condition is one of the keys to ensure your overall casting quality. The Sand Valve is a vital part of the moulding process and is subject to extreme wear.

The new hardened dome is more resistant to the wear from continuous contact with the sand and the lifetime of the dome is extended.

As a result of the reduced wear on the dome itself also the dome seal will last longer.

The result is that the machine will stay in shape at lower maintenance cost.

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

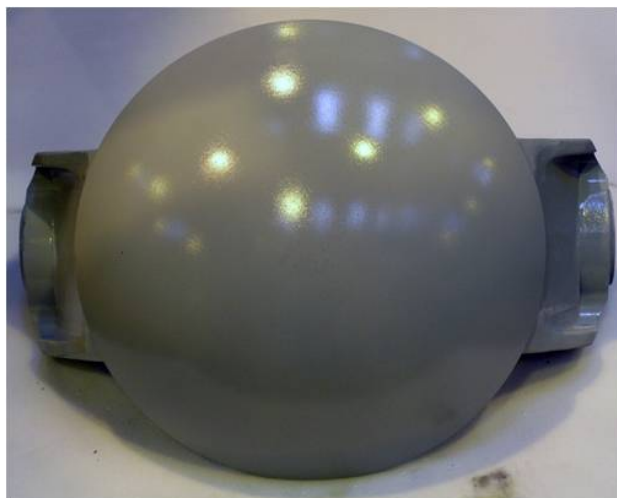
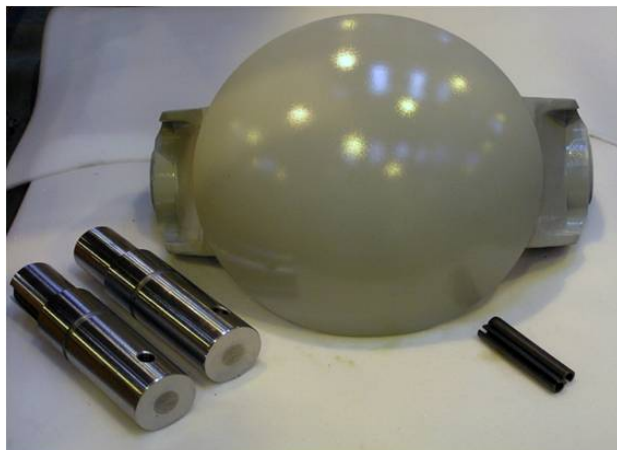
Please note:

First time buying this Kit: Use highlighted number

For later replacement: Use non-highlighted number

Machine Type	Part No.	Qty
DISA 240 & 250	2450R1400	1
Dome	2440A4240	1
Shaft	2450A2810	1
Shaft	2450A2820	1
Dowel Pin	10022576	2

Hardened Dome Upgrade Kit for DISAMATIC 2013 MK4 and MK5 A with Dome Ø250



Reduce maintenance cost

Keeping your DISAMATIC in top operating condition is one of the keys to ensure your overall casting quality. The Sand Valve is a vital part of the moulding process and is subject to extreme wear.

The new hardened dome is more resistant to the wear from continuous contact with the sand and the lifetime of the dome is extended.

As a result of the reduced wear on the dome itself also the dome seal will last longer.

The result is that the machine will stay in shape at lower maintenance cost.

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

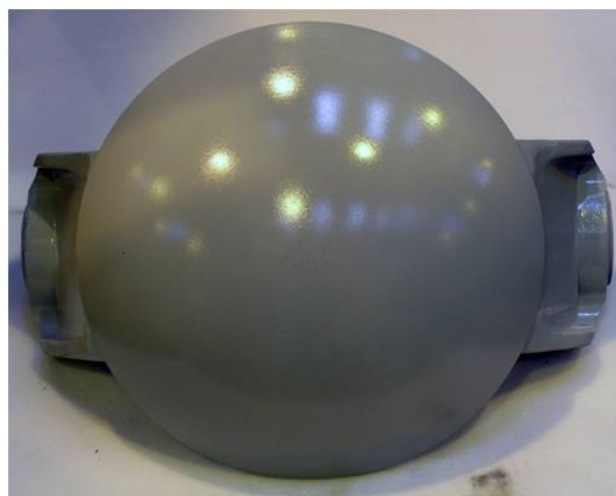
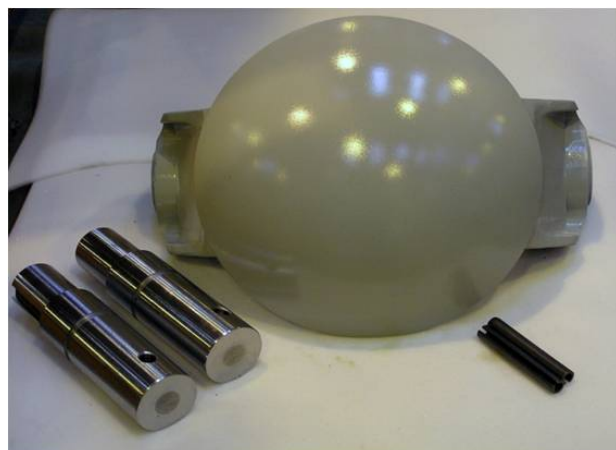
Please note:

First time buying this Kit: Use highlighted number

For later replacement: Use non-highlighted number

Machine Type	Part No.	Qty
DISAMATIC 2013 MK4 - 5 A with dome Ø250	2050A3360	1

Hardened Dome Upgrade Kit for DISAMATIC 2013 B and 2070 A with Dome Ø300



Reduce maintenance cost

Keeping your DISAMATIC in top operating condition is one of the keys to ensure your overall casting quality. The Sand Valve is a vital part of the moulding process and is subject to extreme wear.

The new hardened dome is more resistant to the wear from continuous contact with the sand and the lifetime of the dome is extended.

As a result of the reduced wear on the dome itself also the dome seal will last longer.

The result is that the machine will stay in shape at lower maintenance cost.

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

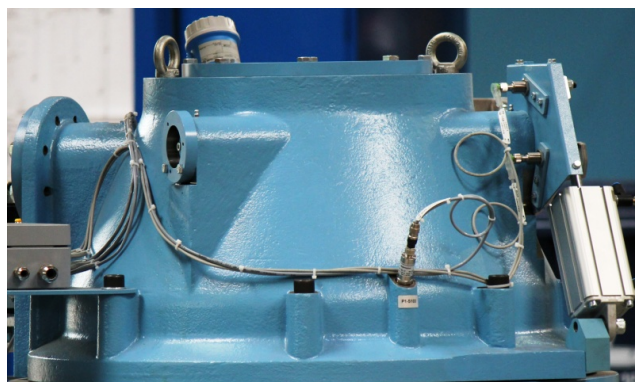
Please note:

First time buying this Kit: Use highlighted number

For later replacement: Use non-highlighted number

Machine Type	Part No.	Qty
DISAMATIC 2013 B & 2070 A with dome ø300	2050A3370	1

New generation Dome Valve Repair and Upgrade Kit for DISA 131 and 231



Reduce maintenance cost with Dome Valve repair Kit and new hardened Dome Kit

Repair Kit

Keeping your DISAMATIC in top operating condition is one of the keys to your overall casting quality. The sand valve is a vital part of the moulding process and is subject to extreme wear.

DISA has specifically designed these repair kits based on many years of worldwide experience from our service engineers and our valued customers.

The kits are an easy-to-order kit, ensuring that you order all of the necessary components required to maintaining the dome valve, keeping the machine in shape at a lower maintenance cost.

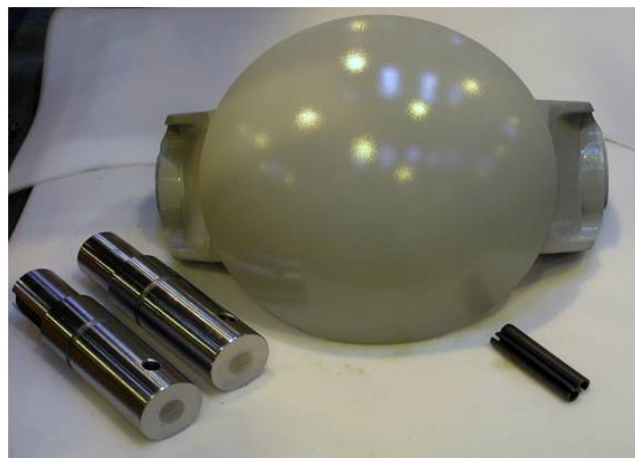
Upgrade Kit

The new hardened dome is more resistant to the wear from continuous contact with the sand, and the lifetime of the dome is extended.

As a result of the reduced wear on the dome itself, the dome seal will also last longer.

The result is that the machine will stay in shape at lower maintenance cost

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.



Repair Kit

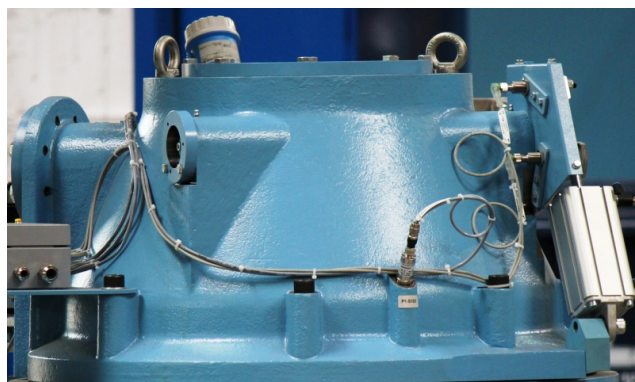
Machine Type	Part No.
DISA 131 & 231	10370576

Hardened Dome Valve Upgrade Kit

Machine Type	Part No.
DISA 131 & 231	10136140



New generation Dome Valve Repair and Upgrade Kit for DISA 230 and DISAMATIC 2013 MK5 X



Reduce maintenance cost with Dome Valve repair Kit and new hardened Dome Kit

Repair Kit

Keeping your DISAMATIC in top operating condition is one of the keys to your overall casting quality. The sand valve is a vital part of the moulding process and is subject to extreme wear.

DISA has specifically designed these repair kits based on many years of worldwide experience from our service engineers and our valued customers.

The kits are an easy-to-order kit, ensuring that you order all of the necessary components required to maintaining the dome valve, keeping the machine in shape at a lower maintenance cost.

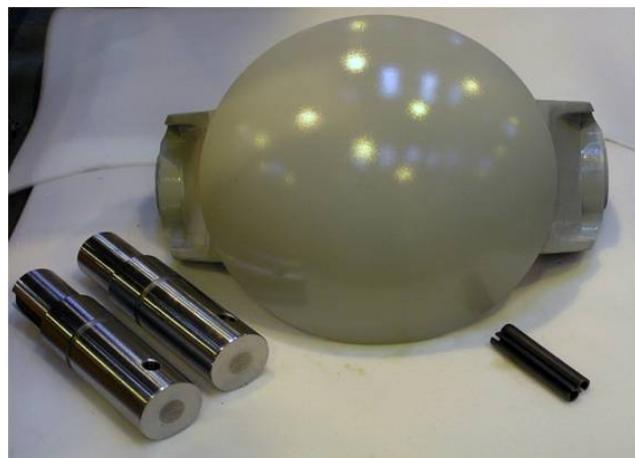
Upgrade Kit

The new hardened dome is more resistant to the wear from continuous contact with the sand, and the lifetime of the dome is extended.

As a result of the reduced wear on the dome itself, the dome seal will also last longer.

The result is that the machine will stay in shape at lower maintenance cost

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.



Repair Kit

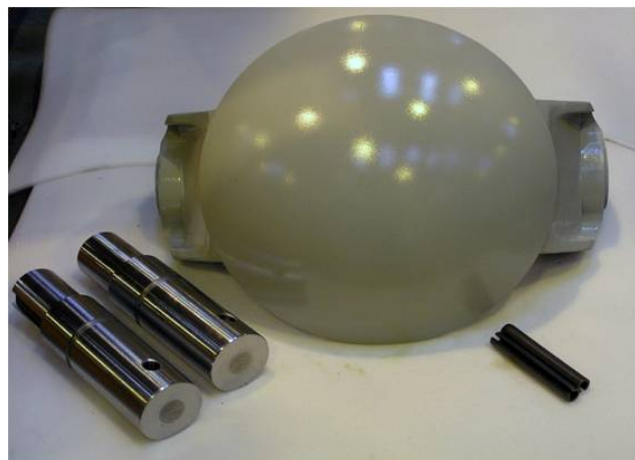
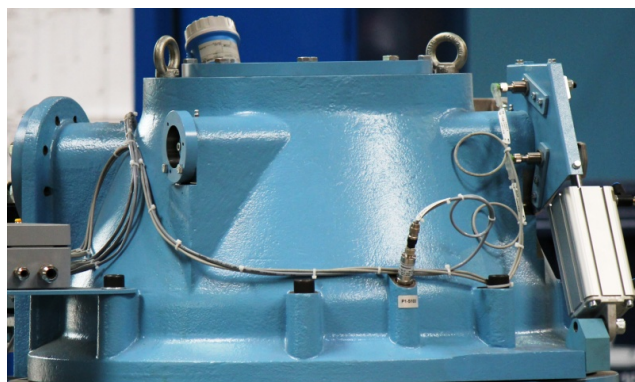
Machine Type	Part No.
DISA 230 & DISAMATIC 2013 MK5 X	10372616

Hardened Dome Valve Upgrade Kit

Machine Type	Part No.
DISA 230 & DISAMATIC 2013 MK5 X	2440R2800



New generation Dome Valve Repair and Upgrade Kit for DISA MATCH 28/32 and 32/32



Reduce maintenance cost with Dome Valve repair Kit and new hardened Dome Kit

Repair Kit

Keeping your DISAMATIC in top operating condition is one of the keys to your overall casting quality. The sand valve is a vital part of the moulding process and is subject to extreme wear.

DISA has specifically designed these repair kits based on many years of worldwide experience from our service engineers and our valued customers.

The kits are an easy-to-order kit, ensuring that you order all of the necessary components required to maintaining the dome valve, keeping the machine in shape at a lower maintenance cost.

Upgrade Kit

The new hardened dome is more resistant to the wear from continuous contact with the sand, and the lifetime of the dome is extended.

As a result of the reduced wear on the dome itself, the dome seal will also last longer.

The result is that the machine will stay in shape at lower maintenance cost

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Repair Kit

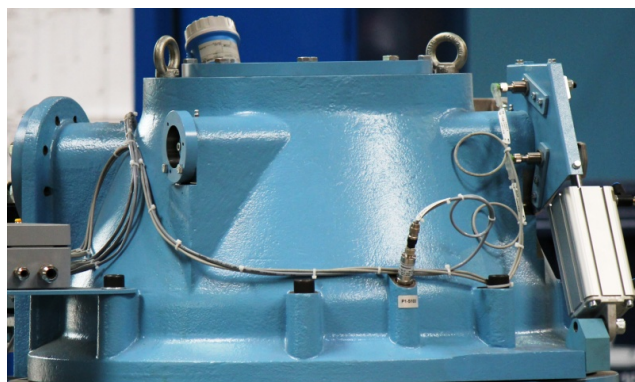
Machine Type	Part No.
DISA MATCH 28/32 & 32/32	10372624

Hardened Dome Valve Upgrade Kit

Machine Type	Part No.
DISA MATCH 28/32 & 32/32	2440R2800



New generation Dome Valve Repair and Upgrade Kit for DISA 240 and 250



Reduce maintenance cost with Dome Valve repair Kit and new hardened Dome Kit

Repair Kit

Keeping your DISAMATIC in top operating condition is one of the keys to your overall casting quality. The sand valve is a vital part of the moulding process and is subject to extreme wear.

DISA has specifically designed these repair kits based on many years of worldwide experience from our service engineers and our valued customers.

The kits are an easy-to-order kit, ensuring that you order all of the necessary components required to maintaining the dome valve, keeping the machine in shape at a lower maintenance cost.

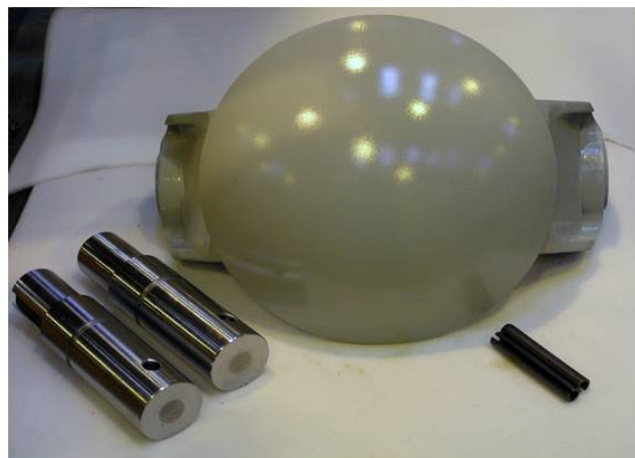
Upgrade Kit

The new hardened dome is more resistant to the wear from continuous contact with the sand, and the lifetime of the dome is extended.

As a result of the reduced wear on the dome itself, the dome seal will also last longer.

The result is that the machine will stay in shape at lower maintenance cost

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.



Repair Kit

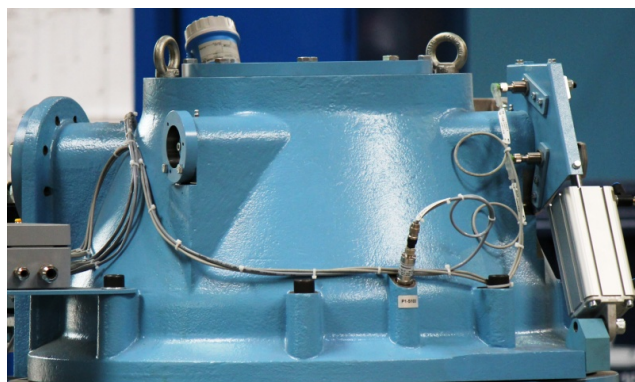
Machine Type	Part No.
DISA 240 & 250	10372586

Hardened Dome Valve Upgrade Kit

Machine Type	Part No.
DISA 240 & 250	2450R1400



New generation Dome Valve Repair Kit for DISA 270



Reduce maintenance cost with Dome Valve repair Kit and new hardened Dome Kit

Repair Kit

Keeping your DISAMATIC in top operating condition is one of the keys to your overall casting quality. The sand valve is a vital part of the moulding process and is subject to extreme wear.

DISA has specifically designed these repair kits based on many years of worldwide experience from our service engineers and our valued customers.

The kits are an easy-to-order kit, ensuring that you order all of the necessary components required to maintaining the dome valve, keeping the machine in shape at a lower maintenance cost.

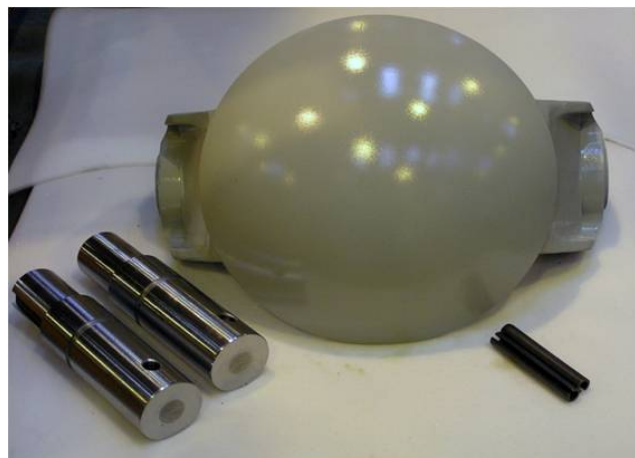
Upgrade Kit

The new hardened dome is more resistant to the wear from continuous contact with the sand, and the lifetime of the dome is extended.

As a result of the reduced wear on the dome itself, the dome seal will also last longer.

The result is that the machine will stay in shape at lower maintenance cost

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.



Repair Kit

Machine Type

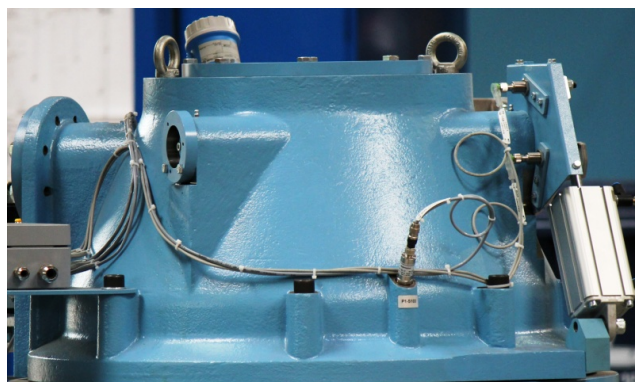
DISA 270

Part No.

10372670



New generation Dome Valve Repair Kit for DISA 280



Reduce maintenance cost with Dome Valve repair Kit and new hardened Dome Kit

Repair Kit

Keeping your DISAMATIC in top operating condition is one of the keys to your overall casting quality. The sand valve is a vital part of the moulding process and is subject to extreme wear.

DISA has specifically designed these repair kits based on many years of worldwide experience from our service engineers and our valued customers.

The kits are an easy-to-order kit, ensuring that you order all of the necessary components required to maintaining the dome valve, keeping the machine in shape at a lower maintenance cost.

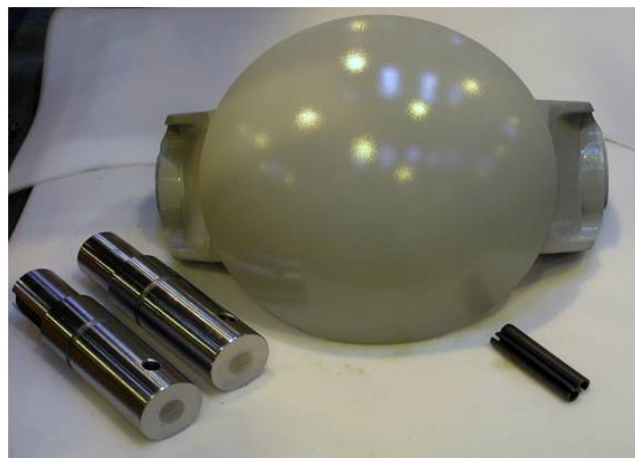
Upgrade Kit

The new hardened dome is more resistant to the wear from continuous contact with the sand, and the lifetime of the dome is extended.

As a result of the reduced wear on the dome itself, the dome seal will also last longer.

The result is that the machine will stay in shape at lower maintenance cost

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.



Repair Kit

Machine Type	Part No.
DISA 280	10372674



Reconditioned Parts



Repair and Supply of Reconditioned Parts

DISA has the knowledge and equipment to repair your used DISA parts.

Send your selected components to DISA customer service for repair and you will:

- Extend the lifetime of your machine components
- Save costs
- Receive a 1-year warranty on all repairs
- Average price is 60 % of new price

DISA offers repair and supply of:

- Hydraulic Components
- Pneumatic Components
- Mechanical Components
- Electrical Components



Reconditioned Bearing House for DISA 240, 250, 270 and 280



In order to reduce the overhaul time during repair of bearing houses on your PMC, DISA now offers reconditioned bearing houses, which are overhauled according to OEM specifications.

You only have to build-in the reconditioned bearing house and you are ready to restart your machine / production.

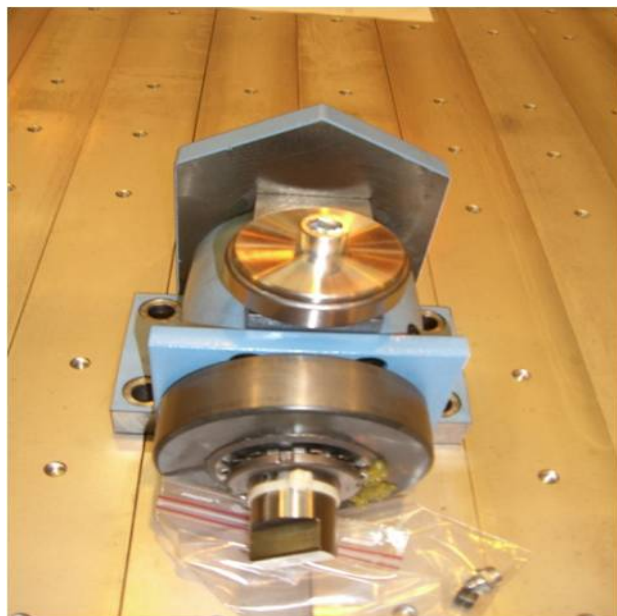
3 good reasons to install reconditioned bearing houses

- Cost efficient
- Fast change of bearing houses
- Available as reconditioned or repaired

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Machine Type	Part No.	Qty
DISA 240 - 280	R2452B0170	1
	R2072B0402	1

Reconditioned Bearing House for DISAMATIC 2070



In order to reduce the overhaul time during repair of bearing houses on your PMC, DISA now offers reconditioned bearing houses, which are overhauled according to OEM specifications.

You only have to build-in the reconditioned bearing house and you are ready to restart your machine / production.

3 good reasons to install reconditioned bearing houses

- Cost efficient
- Fast change of bearing houses
- Available as reconditioned or repaired

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Machine Type	Part No.	Qty
DISAMATIC 2070	R2072B0412	1
	R2072B0402	1

Reconditioned PP or SP Cylinder for DISA 130



In order to reduce the overhaul time during repair of PP/SP cylinders on your DMM, DISA now offers a reconditioned PP or SP cylinder, which is overhauled according to OEM specifications.

- DISA supplies the reconditioned cylinder and you return the used one after repair has been completed
- Be sure that repair is carried out correctly before assembling
- No surprises during repair

- You only have to build-in the reconditioned cylinder, align it and you're ready to restart your machine/production
- Cost efficient compared to buying a new cylinder
- Fast change of PP and SP cylinder
- Can be sold as reconditioned or repair

Please contact your local DISA Representative and ask for the part specified for your machine type

Part Type	Part No.
Reconditioned PP cylinder	R2440R1390
Reconditioned SP cylinder	R2440R1280

Reconditioned PP or SP Cylinder for DISA 131



In order to reduce the overhaul time during repair of PP/SP cylinders on your DMM, DISA now offers a reconditioned PP or SP cylinder, which is overhauled according to OEM specifications.

- DISA supplies the reconditioned cylinder and you return the used one after repair has been completed
- Be sure that repair is carried out correctly before assembling
- No surprises during repair

- You only have to build-in the reconditioned cylinder, align it and you're ready to restart your machine/production
- Cost efficient compared to buying a new cylinder
- Fast change of PP and SP cylinder
- Can be sold as reconditioned or repair

Please contact your local DISA Representative and ask for the part specified for your machine type

Part Type	Part No.
Reconditioned PP cylinder	R2440R1390
Reconditioned SP cylinder	R2440R1280

Reconditioned PP or SP Cylinder for DISA 230



In order to reduce the overhaul time during repair of PP/SP cylinders on your DMM, DISA now offers a reconditioned PP or SP cylinder, which is overhauled according to OEM specifications.

- DISA supplies the reconditioned cylinder and you return the used one after repair has been completed
- Be sure that repair is carried out correctly before assembling
- No surprises during repair

- You only have to build-in the reconditioned cylinder, align it and you're ready to restart your machine/production
- Cost efficient compared to buying a new cylinder
- Fast change of PP and SP cylinder
- Can be sold as reconditioned or repair

Please contact your local DISA Representative and ask for the part specified for your machine type

Part Type	Part No.
Reconditioned PP cylinder	R2440R1390
Reconditioned SP cylinder	R2440R1280

Reconditioned PP or SP Cylinder for DISA 231



In order to reduce the overhaul time during repair of PP/SP cylinders on your DMM, DISA now offers a reconditioned PP or SP cylinder, which is overhauled according to OEM specifications.

- DISA supplies the reconditioned cylinder and you return the used one after repair has been completed
- Be sure that repair is carried out correctly before assembling
- No surprises during repair

- You only have to build-in the reconditioned cylinder, align it and you're ready to restart your machine/production
- Cost efficient compared to buying a new cylinder
- Fast change of PP and SP cylinder
- Can be sold as reconditioned or repair

Please contact your local DISA Representative and ask for the part specified for your machine type

Part Type	Part No.
Reconditioned PP cylinder	R2440R1390
Reconditioned SP cylinder	R2440R1280

Reconditioned PP or SP Cylinder for DISAMATIC D3



In order to reduce the overhaul time during repair of PP/SP cylinders on your DMM, DISA now offers a reconditioned PP or SP cylinder, which is overhauled according to OEM specifications.

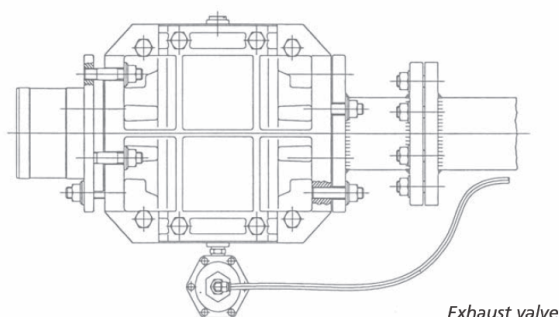
- DISA supplies the reconditioned cylinder and you return the used one after repair has been completed
- Be sure that repair is carried out correctly before assembling
- No surprises during repair

- You only have to build-in the reconditioned cylinder, align it and you're ready to restart your machine/production
- Cost efficient compared to buying a new cylinder
- Fast change of PP and SP cylinder
- Can be sold as reconditioned or repair

Please contact your local DISA Representative and ask for the part specified for your machine type

Part Type	Part No.
Reconditioned PP cylinder	R2440R1390
Reconditioned SP cylinder	R2440R1280

Improved Exhaust Valve for DISAMATIC 2013 MK3, MK4, MK5 and LP



The exhaust Valve installed on new generation DISA machines, now offers a great improvement to 2013 MK3 - 5 and LP machines.

The new exhaust Valve will reduce build-up of Sand in the shot Valve pipe and the improved design extends the lifetime of the exhaust rubber insert tube. The new exhaust Valve measures 100 mm instead of 80 mm as the old type.

3 reasons to install the improved Exhaust Valve

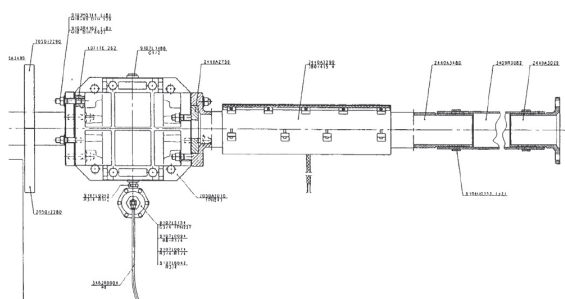
- Improves exhaust air flow
- Reduces sand build-up
- Extends lifetime of the exhaust insert tube

It is easy to install the new improved exhaust Valve and installation time is approximately 30 minutes.

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Machine Type	Part No.
DISAMATIC 2013 MK5 serial No. \geq 2599 & LP \geq 2809	2050A2920
DISAMATIC 2013 MK3 - 5 serial No. \leq 2598 & LP \leq 2808	10073613

Improved Exhaust Valve and Heated Exhaust Pipe for DISAMATIC 2013 MK3, MK4, MK5 and LP



The exhaust Valve with heated exhaust pipe installed on new generation DISA machines, now offers a great improvement to 2013 MK3 - 5 and LP machines.

A customer in UK experienced problems with Sand build-up in the exhaust pipe and reduced lifetime on the Exhaust Insert Tube. The problem was solved with 80% by installing this new Exhaust Valve and the last 20% were solved by adding the heating element. The new exhaust Valve measures 100 mm instead of 80 mm as the old type.

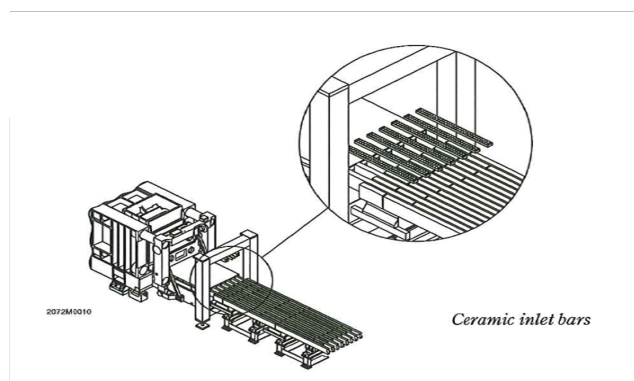
3 reasons to install the improved Exhaust Valve:

- Improves exhaust air flow
- Reduces Sand build-up
- Extends lifetime of the exhaust insert tube

Please contact your local DISA Representative and ask for item number **2050R6790**

Please note: It's important to state the Machine Type and serial number.

Ceramic PMC Inlet Bars for DISAMATIC 2070



With the new inlet bars the number of bars has been reduced from 21 to 7, all covered with ceramic tiles.

These particular tiles are characterized by low friction and long life.

Advantages

- Longer life of PMC inlet bars
- The kit consists of 7 bars
- Risk of Sand sticking is reduced
- No Corrosion

Please contact your local DISA Representative and ask for item number **2072R0780**

For illustrative purposes, the equipment may be shown without any warning labels and with some of the protective guards removed. The warning labels and guards must always be in place when the equipment is in use.

Seal Kit for PP Cylinder for DISAMATIC 2110



It's a major repair job to change all the seals of the PP cylinder, so in order to be sure that all parts are available when you're about to do the changes, we recommend you to use this repair seal kit.

The kit contains all the o-rings, step-seals and scraper to cover the repair job of the main piston.

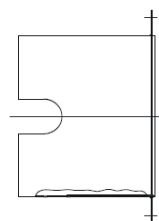
The kit is a convenient way to order all necessary parts compared to ordering the parts individually.

Please contact your local DISA Representative and ask for item number **2110R1410**

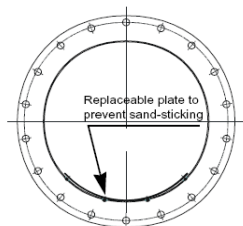
The Seal Kit contains:

Part Name	Part No.	Qty
Hose clamp	9104U0147	1
O-ring D12,00 - 3,00	10083008	2
O-ring D26,20 - 3,00	10083068	5
O-ring D31,20 - 3,00	10083129	2
Pakning stepseal ø125	9105F0733	2
O-ring D129,54 - 5,33	10083263	3
Slydring ø125	9105F0735	1
Slydring ø125	9105F0736	1
DA Excluder ø125	9105F0737	1
Slydring ø141,4	9105F0738	2
Glydring ø141,4	9105F0739	1
O-ring D116,84 - 7,00	10083264	1
O-ring D149,20 - 5,70	10083265	1
O-ring D72,62 - 3,53	10083266	1
Scraper 220 - 240 - 12 M00101 AS	10083271	1
O-ring D14,00 - 3,00	10083180	1

Blow-head Insert for DISAMATIC 2013 MK5 B



2050M1670



*Blowhead insert with
replaceable non-sticking plate*

This kit is developed to reduce sand build-up in the blow head; i.e. reduced Sand probe error messages resulting in increased production.

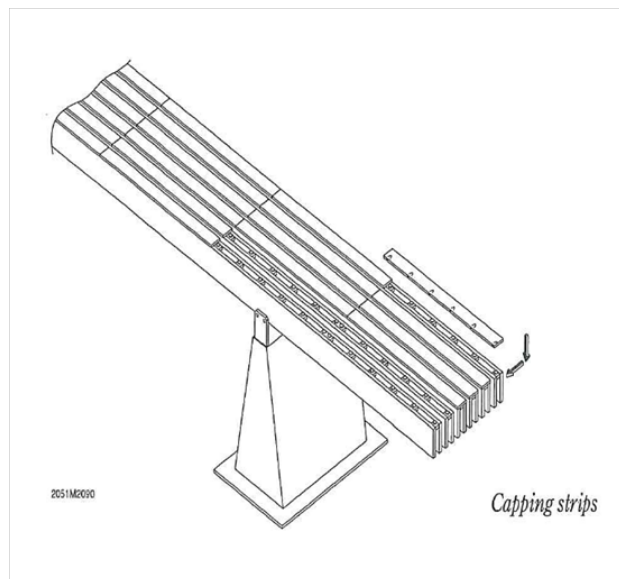
Advantages

- Prevent Sand sticking
- Simple and service friendly

The kit has a replaceable non-sticking Plate which prevents sand sticking between sand probe and blow head insert.

Please contact your local DISA Representative and ask for item number **2050Z1930**

Welding Kit for AMC for DISAMATIC 2110



All wear strips undergo a thorough inspection to ensure highest quality and life expectancy which is standard for all DISA products.

Depending on your requirements, DISA can provide capping strips of hardened stainless steel

This material extends the lifetime of your slide way and reduces build up of corrosion on your AMC.

Accessories

Zinc paste to eliminate corrosion between slide way and wear strip. Components to fixate wear strips. Supporting roll cap for height level reduction if a combination of cold rolled and hardened stainless steel is used.

3 reasons to apply the capping strips package

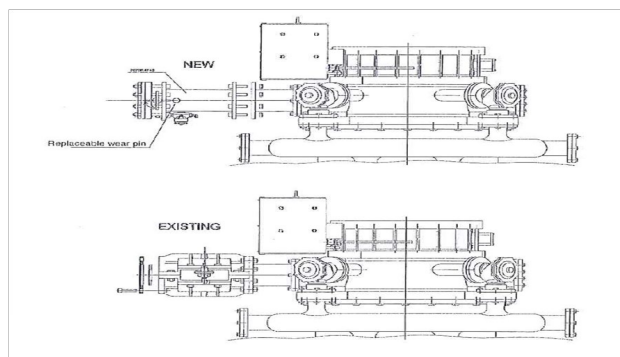
- Wear strips provided in the material are suited to your needs.
- All necessary items contained within 1 kit number.
- Accessories to perform fast installation.

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Part Type	Part No.	Qty
2110 Capping strip welding kit 12 m	2112R0200	1
2110 Capping strip welding kit 15 m	2112R0220	1



New Exhaust Valve for DISAMATIC 2070



Some customers have problems with the lifetime of their exhaust Valve hoses.

This kit replaces the existing exhaust Valve with a butterfly Valve, providing a considerably longer lifetime.

The pipe supplied with the Valve ensures that the length of the kit is identical with the original hose-type Valve.

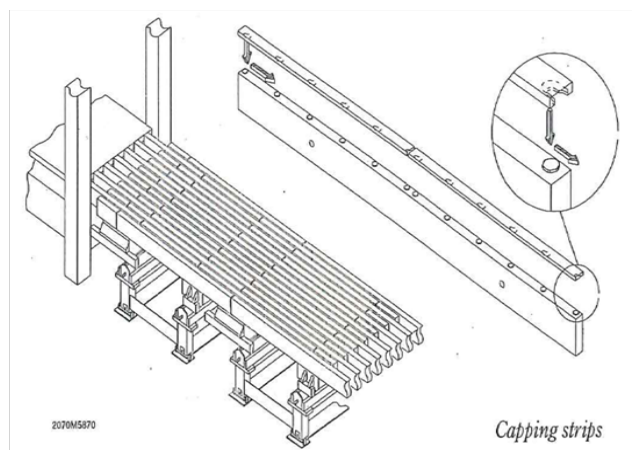
The pipe is fitted with a wear pin protecting the gate of the butterfly valve.

Advantages

- Longer lift time
- Easy to install
- Uses same connection as existing exhaust Valve
- Service friendly

Please contact your local DISA Representative and ask for item number **2070R4800**

Capping Strips for PMC for DISAMATIC 2070



Capping strips for the 2070 AMC have been developed to allow a quick and individual change of strips.

Use capping strips to protect the PMC sections, which are exposed to the most wear.

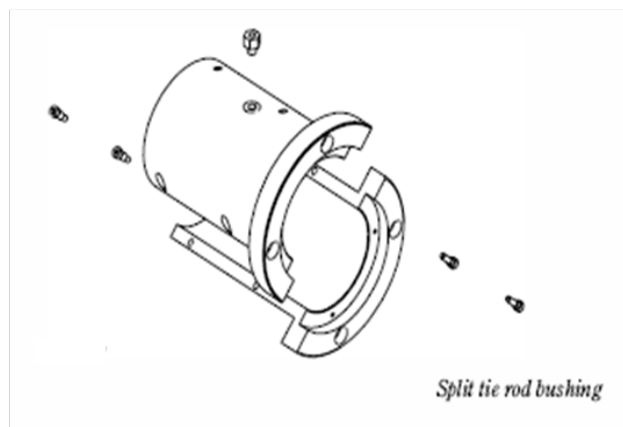
Advantages

- Service friendly
- Less sticking problems
- Quick changing of capping strips
- Available in several materials

- The capping strips may be changed and mounted individually
- Capping strips are available in several materials:
 - Standard
 - Non-corrosive
 - Hardened and non-corrosive
 - Upgrade of existing gratebar to capping strips system

Please contact your local DISA Representative and ask for **Capping strips for PMC DISAMATIC 2070**

Split Tie Rod Bushing for DISAMATIC 2013 MK3, MK4, MK5 and LP



The split tie rod bushings make replacing bushings an easier task and so they attribute to the maintenance friendliness of your machine.

The material used for split bushings is identical to that of the bushings already installed on your machine.

4 Reasons to install Split Tie Rod Bushing to your machine

- Faster replacement
- Maintenance friendly
- Fits both oil and grease lubrication systems
- Reduced downtime

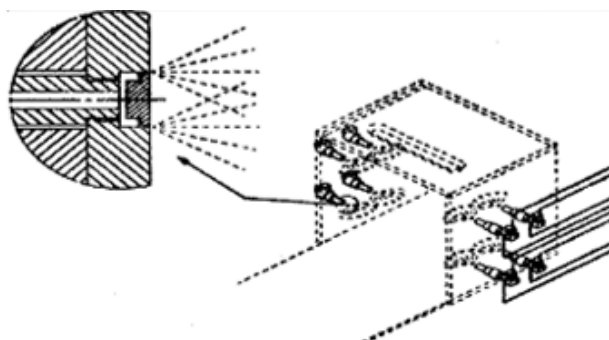
Please note

When ordering a split tie rod bushing, remember also to order new scrapers (item number 2040F0471). 2 or 6 scrapers per bushing depending on the DMM model. If additional tie rod protection is fitted to your machine, you must order 6 scrapers.

Please contact your local DISA Representative and ask for parts as indicated in the table below.

Part Name	Part No.	Qty
Tie rod bearing in two parts	2050R1290	1
Scraper ring	2040F0471	2 or 6

In-chamber Spray System with non-blocking Nozzle design for DISAMATIC 2013 MK3 and MK4 with PLC upgrade



We've designed the latest version of our in-chamber parting Spray systems as a retro-fit kit. This kit is based on our patented and highly successful system, which is used on our New Generation machines.

A high demand from satisfied customers working with the 230 Spray system and who now want the same facility for their older machines, has promoted us to develop this new system.

The new in-chamber Spray system provides following advantages:

- Less maintenance on Nozzles due to new design
- Reduces your Spray Fluid consumption
- Improves the working environment
- Extends the lifetime of chamber Plates
- The new robust design ensures non-blocking Nozzles.

The Kit does NOT include:

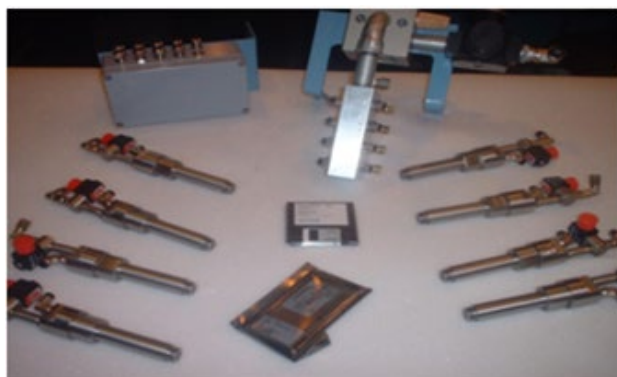
To allow in-chamber spray, new design chamber side wear plates are required!

Order new side plates according to below, and remember to replace the original part numbers in your DISA parts manual with the new numbers for future replacements.

In-Chamber spray side wear plates:

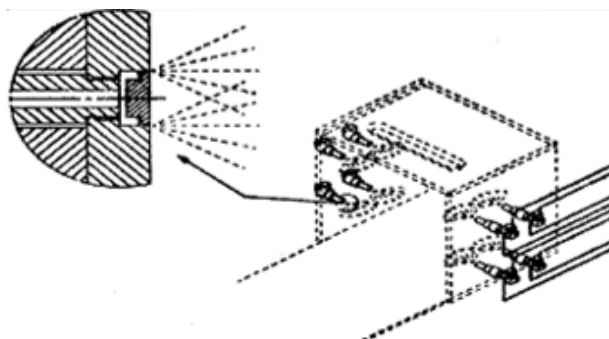
2013MK3 + 4A: 2040B2320 Right side + 2040B2330 Left side

2013MK4B: 2050B3250 Right side + 2050B3260 Left side



Machine Type	Part No.	Qty
2013 MK3 & 4 with PLC upgrade	2050R6770	1

In-chamber Spray System with non-blocking Nozzle Design for DISAMATIC 2013 MK5



We've designed the latest version of our in-chamber parting Spray systems as a retro-fit kit. This kit is based on our patented and highly successful system, which is used on our New Generation machines.

A high demand from satisfied customers working with the 230 Spray system and who now want the same facility for their older machines, has promoted us to develop this new system.

The new in-chamber Spray system provides following advantages:

- Less maintenance on Nozzles due to new design
- Reduces your Spray Fluid consumption
- Improves the working environment
- Extends the lifetime of chamber Plates
- The new robust design ensures non-blocking Nozzles.

The Kit does NOT include:

To allow in-chamber spray, new design chamber side wear plates are required!

Order new side plates according to below, and remember to replace the original part numbers in your DISA parts manual with the new numbers for future replacements.

In-Chamber spray side wear plates:

2013MK5A: 2050B3220 Right side + 2050B3230 Left side

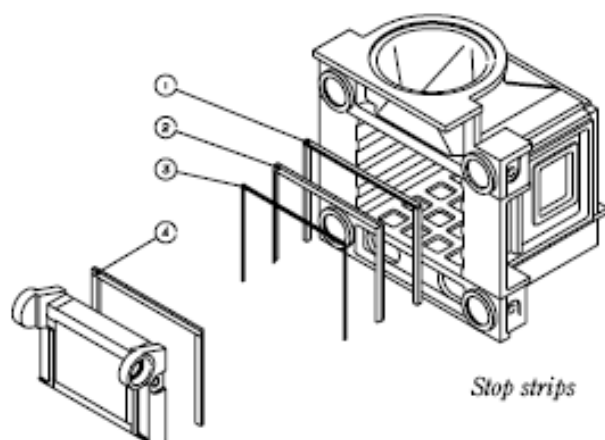
2013MK5B: 2050B3250 Right side + 2050B3260 Left side

2013MK5X: 2050B3270 Right side + 2050B3280 Left side



Machine Type	Part No.	Qty
2013 MK5	2050R6770	1

Stop Strips for DISAMATIC 2013 MK3



1. Stop strip
2. New chamber seat
3. Chamber sealing strip
4. Stop strip

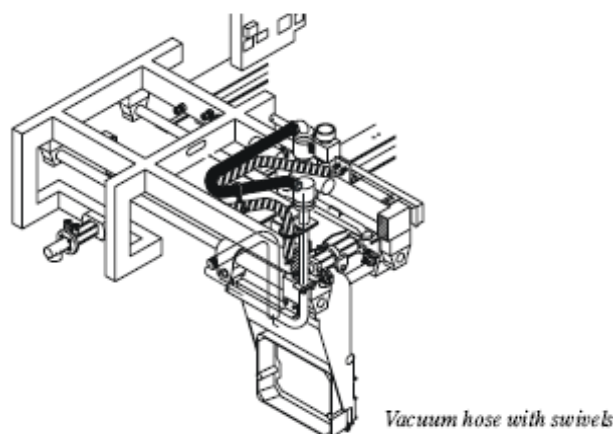
4 reasons to install Stop Strips to your DISAMATIC moulding machine

- Improved parallelism of moulds
- Improved sealing during sand shot
- Certainty of a closed moulding chamber
- Reduction of risk for mismatch

Please contact your local DISA Representative and ask for item number **2040R5241**

Part Name	Part No.	Qty
Stopping strip side	2040B0842	2
Stopping strip upper	2040B0852	1
Strips side	2040B0861	2
Strips upper	2040B0871	1
Sealing strip	2040B0881	3
Stopping bar upper	2040F0501	1
Stopping bar right	2040F0511	1
Stopping bar left	2040F0521	1
Valve Plate	2040F0611	1
Holes for stopping strip MTP	2040Z3240	1
Holes for stopping strip Chamber	2040Z3250	1

Vacuum Hose with Swivels for DISAMATIC 2013 MK3, MK4, MK5 and LP



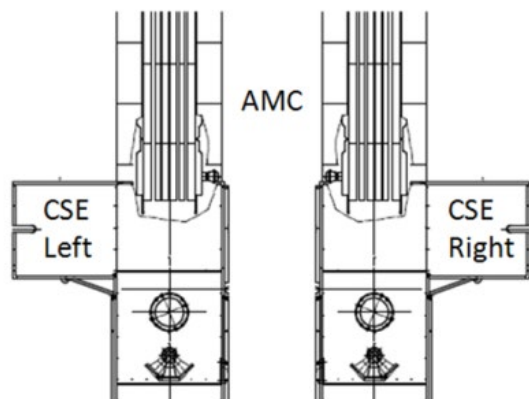
DISA has developed a new vacuum hose mechanism with swivels as a replacement to ensure a longer lifetime of the vacuum hose.

The vacuum hose was introduced as a standard on DISAMATIC 2013 machines in 1998.

4 reasons to install a Vacuum Hose with Swivels on your machine

- Extended lifetime of vacuum hose
- Reduces twisting of vacuum hose
- No reduction in airflow due to collapse of vacuum hose
- Easy and simple installation

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.



Machine Type	Part No.	Qty
CSE in right side	2055R4040	1
CSE in left side	2055R4070	1

Proportional Control of HY13 & Shot Air for DISAMATIC 2013 MK3 and MK4 with PLC Upgrade



We've adapted the control system from 2013 MK-5 machines to control HY13 and the shot air pressure so this feature can be installed on 2013 MK-3 and MK-4 machines with PLC upgrade.

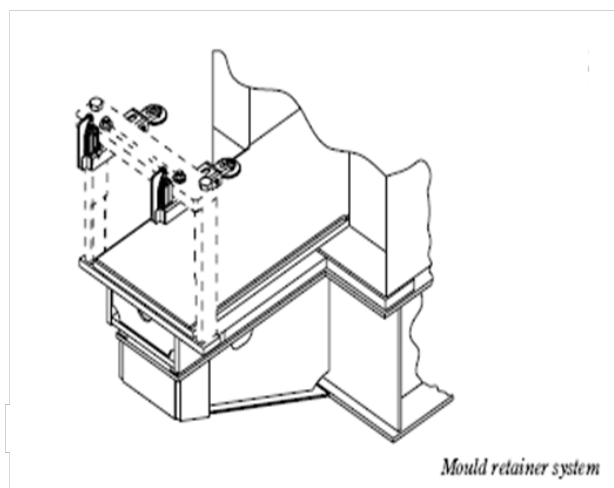
4 reasons to install the Proportional Control Kit

- Operator faults meaning wrong manual adjustments
 - Possible of CIM controlled pressures on the machine
 - Proportional controlled valves HY13 and shot air
 - Less maintenance of the old Seitz valves
-
- Please contact your local DISA Representative and ask for item number **2013R6400**

Part Name	Part No.	Qty
Proportional Valve HY13	2013R6380	1
Shot Valve	2013R6390	1
Memory compact flash 512	10087014	1
Memory EEPROM 64K	10087059	1
VDU OP277 6" colour keys	10087021	1
Memory card MMC 1GB	10087020	1



Mould Retainer System for DISAMATIC 2013 MK3, MK4, MK5 A/B and LP



The design of the new system is based on use of standard cylinders and bearings. It's quick to install. The mould retainer system fits all 2013 machines with an A or B chamber.

4 reasons to install the mould Retainer System

- New improved design
- Service and maintenance friendly
- Quick responding mould retainer
- Adjustable distance between mould retainer and Sand mould.

Please contact your local DISA Representative and ask for item number **2040R7080**

Machine	Serial No.	
MK3	All	
MK4	All	
MK5	2501-2543	2546-2547
MK4 LP	2405-2804	

New Main Pump with closed Loop Control for DISAMATIC 2013 MK3 and MK4



DISA has developed a new replacement pump kit – for the well known 468 main pump for DISAMATIC 2013 MK-3 and MK-4 which is no longer in production.

The performance of the replacement pump kit and it's controls are equal to that of the DISAMATIC 2013 MK-5.

With fast and reliable speed control, the closed loop control compensates for oil temperature changes, leakages, friction and other things which may reduce the performance.

5 reasons to install the new Main Pump Kit

- Regain reliability, speed and performance
- Make the same mould in every cycle
- Reduce mould tear-off and crashes. Especially defects caused by jump-starts and varying stop positions
- Simplify your maintenance work
- Installed over a weekend

Please contact your local DISA Representative and ask for part specified for your pump type as indicated in the table below.

Existing Pump	Control System	Part No.	Qty
468	50 Hz with gearbox	2040R7800	1
468	60 Hz with gearbox	2040R7810	1
468	50 Hz PLC upgrade	10039498	1
468	60 Hz PLC upgrade	10039500	1
500 HD	With control box	2040R8060	1
500 HD	With PLC upgrade	10039499	1

New Vacuum Unit for DISAMATIC 2070, 2013 MK3 and MK4

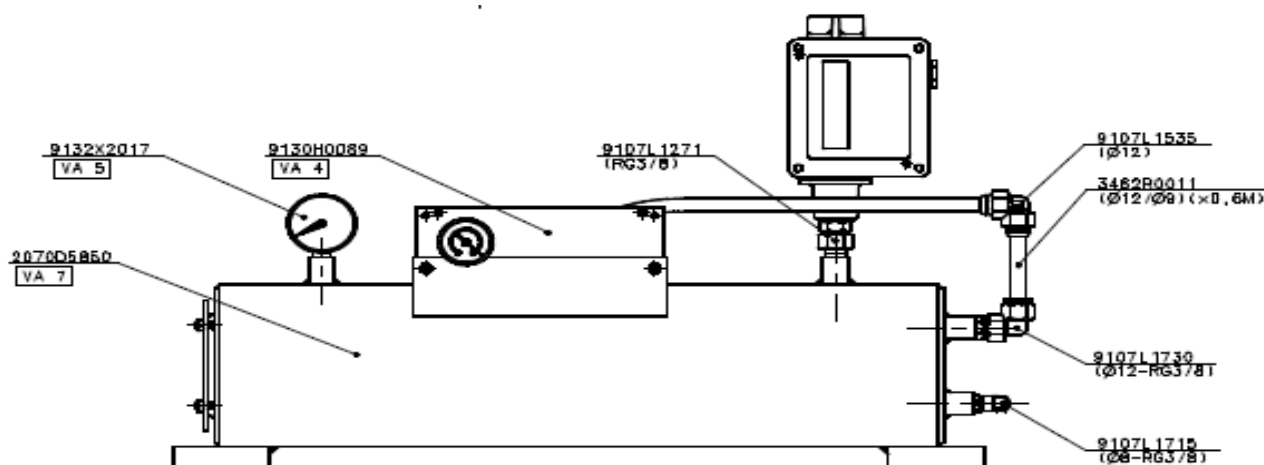
The new vacuum unit is driven by air and is even more silent than the old vacuum unit. It's fully compatible with the old vacuum unit and is very easy to install.

The new vacuum unit is more reliable than the old unit and requires less maintenance.

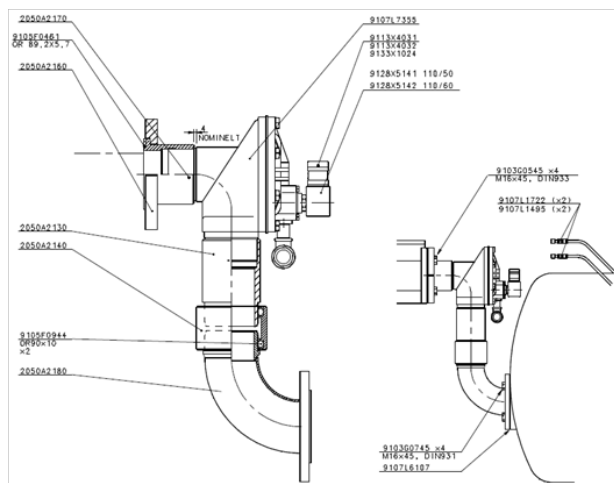
4 reasons to install the New Vacuum Unit

- Less maintenance
- More silent to operate
- Easy installation
- More reliable
- Based on the latest generation of 2070 MK-2 machines, DISA has developed a new update kit for the bottom wear plate

Please contact your local DISA Representative and ask for item number **10027282**



New Shot Valve for DISAMATIC 2013 MK3, MK4, MK5 and LP



Using a 3" shot Valve the airflow area is increased by a factor 3,4. This will in time provide a more efficient filling of the chamber.

The pipe of the shot Valve is fitted with a floating coupling to make it easier to install and to absorb any vibrations.

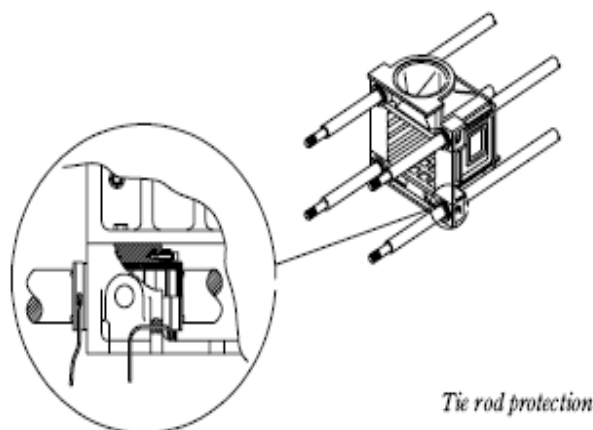
4 reasons to install the new Shot Valve

- Large air flow area
- Better filling within short time
- Simple and easy to handle
- Extended lifetime

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Machine Type	Part No.
DISAMATIC 2013 MK3 5 serial No. ≤ 2597 & LP ≤ 2808	2050R9940
DISAMATIC 2013 MK5 ≥ serial No. 2598 & LP ≥ 2809	2050R1914

Tie Rod Protection for DISAMATIC 2013 MK3, MK4 and LP



The modification kit serves to improve the protection of the four tie rod bearings in the chamber front against penetration of Sand and other impurities. The modification involves a trebling of the number of scrapers in each tie rod bearing.

4 reasons to install the new Tie Rod Protection Kit

- Extended lifetime of tie rods
- Extended lifetime of tie rod bushings
- Reduced downtime
- Improved utilization of lubrication grease or oil

Please contact your local DISA Representative and ask for item number **2050R0220**

Please note

To order a total kit: Use item number above

To order parts: Use item numbers in the table.

Part Name	Part No.	Qty
Scraper ring	2040F0471	24
Intermediate flange	2050B1230	4
Intermediate flange	2050B1240	4
Screw M5x50/22-8,8 ZN ENISO476	10023365	16
Screw M5x35/22-8,8 ZN ENISO476	10023359	16
Spacing bushing	2050A1250	2
Screw M12x45/36-8,8 ZN ENISO47	10022926	2
Fitting QRTM-S 6-R1/8 M	10084442	4
Fitting QRTM-T 2x6-R1/8 M	10084249	4
6 X 4 hose 35ATO	3462R0001	5
Safety tool	2050A1241	1
Scraper flange kit	2050B0150	1

Bottom Plate Kit with Heater for DISAMATIC 2013 MK3, MK4 and LP



The wear which normally occurs on the Wear Plate is mainly caused by the moisture from the moulds. This new kit provides heating below the moulds which are in the close up position on the Wear Plate.

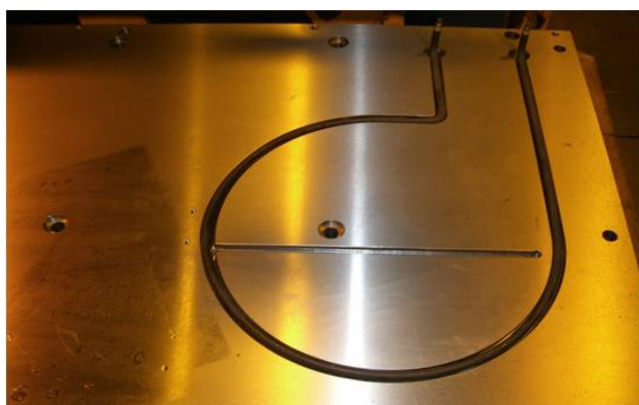
3 reasons to install a Bottom Plate Kit with Heater

- Reduces corrosion on the bottom Wear Plates, thereby improving lifetime and reducing costs
- After installation, you can remove the old vacuum system, which holds down the bottom wear plate
- Same system as 2013 MK-5 and the New Generation of machines from DISA

Please contact your local DISA Representative and ask for item number **2040R2961**

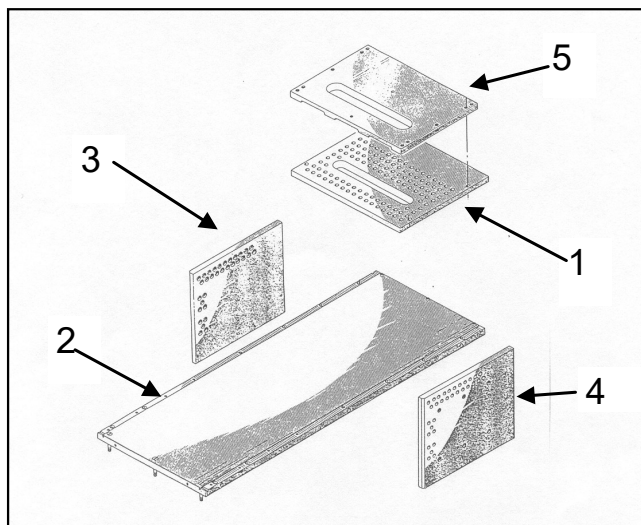
Please note

- This kit correlates with "Critical Parts for Bottom Plate Kit with Heater for DISAMATIC 2013 MK3, 4 & LP"
- By ordering, please state which spray system is installed to your machine.



Critical Parts for Bottom Plate Kit with Heater for DISAMATIC 2013 MK3, MK4 and LP

Chamber Plates for DISAMATIC 2013, after bottomplate kit 2040R2961



- 1: Top Plate
- 2: Bottom Plate
- 3: Left Plate
- 4: Right Plate
- 5: Nozzle Plate

Chamber Sizes A & LP (480 x 600)

Part Name	Part No.	Note
Top Plate	2040B1960	
Bottom Plate	2050B1300	With chrome
Left Plate 1 Spray hole, A	2050B2640	
Left Plate 2 Spray holes, A	2050B2500	
Left Plate 4 Spray holes, A	2050B3230	
Right Plate 1 Spray hole, A	2050B2620	
Right Plate 2 Spray holes, A	2050B2490	
Right Plate 4 Spray holes, A	2050B3220	
Nozzle Plate	2013B1402	MK3 & 4

Chamber Size B (535 x 630)

Part Name	Part No.	Note
Top Plate	2050B2510	
Bottom Plate	2050B2970	With chrome
Left Plate 1 Spray hole, A	2050B2610	
Left Plate 2 Spray holes, A	2050B2530	
Left Plate 4 Spray holes, A	2050B3260	
Right Plate 1 Spray hole, A	2050B2600	
Right Plate 2 Spray holes, A	2050B2520	
Right Plate 4 Spray holes, A	2050B3250	

AMC Capping Strips Package 6m for DISAMATIC 2013 MK3, MK4, MK5 & DISA 130, 131, 230 and 231 A



The mounted T-bolts allow a smooth assembly of strips onto the slide way. If one or more capping strips need changing the DISA patented solution allows a fast and smooth change from worn to new.

4 Reasons to install the Capping Strips Package

- Reduction of sand sticking
- Quick and simple installation
- Accessories to perform quick installation
- Attractive package price

Depending on your requirements DISA can provide capping strips in following material:

- 3 m cold rolled steel/non hardened stainless steel. Provides increased friction to your moulds and lessens the risk of mould gapping and metal run out.
- 6 m hardened stainless steel: Extends the lifetime of your slide way and reduces build up of corrosion on your AMC.

Accessories

Zink paste to eliminate corrosion between war rail and capping strip. Order T-bolts for installation.

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Part Name	Part No.	Qty	Item No.
DISAMATIC 2013 MK1 - 5 & DISA 130 - 231 A			
6m hardened stainless steel	2052R0810	36	2052B2380
3m non hardened stainless steel	2052R1840	18	2052B3050
3m cold rolled steel	2052R1810	18	2052B3070
Additional Items			
T-bolt	2072B2850	1	To fix & mount capping strips
Zink paste	3800A0014	1	Protection against corrosion

AMC Capping Strips Package 6m for DISAMATIC 2013 MK3, MK4, MK5 & DISA 130, 131, 230 and 231 B



The mounted T-bolts allow a smooth assembly of strips onto the slide way. If one or more capping strips need changing the DISA patented solution allows a fast and smooth change from worn to new.

4 Reasons to install the Capping Strips Package

- Reduction of sand sticking.
- Quick and simple installation.
- Accessories to perform quick installation.
- Attractive package price.

Depending on your requirements DISA can provide capping strips in following material:

- 3 m cold rolled steel/non hardened stainless steel. Provides increased friction to your moulds and lessens the risk of mould gapping and metal run out.
- 6 m hardened stainless steel: Extends the lifetime of your slide way and reduces build up of corrosion on your AMC.

Accessories

Zink paste to eliminate corrosion between war rail and capping strip. Order T-bolts for installation.

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Part Name	Part No.	Qty	Item No.
2013 MK1 - 5 & DISA 130 - 231 B			
6m hardened staines steel	2052R0820	24	2052B2380
		12	2052B2390
3m non hardened stainless steel	2052R1850	12	2052B3050
		6	2052B3060
3m cold rolled steel	2052R1820	12	2052B3070
		6	2052B3080
Additional			
T-bolt	2072B2850	1	To fix & mount capping strips
Zink paste	3800A0014	1	Protection against corrosion

AMC Capping Strips Package 6m for DISA 130, 131, 230 and 231 C



The mounted T-bolts allow a smooth assembly of strips onto the slide way. If one or more capping strips need changing the DISA patented solution allows a fast and smooth change from worn to new.

4 Reasons to install the Capping Strips Package

- Reduction of sand sticking
- Quick and simple installation
- Accessories to perform quick installation
- Attractive sackage price

Depending on your requirements DISA can provide capping strips in following material:

- 3 m cold rolled steel/non hardened stainless steel. Provides increased friction to your moulds and lessens the risk of mould gapping and metal run out.
- 6 m hardened stainless steel: Extends the lifetime of your slide way and reduces build up of corrosion on your AMC.

Accessories

Zink paste to eliminate corrosion between war rail and capping strip. Order T-bolts for installation.

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Part Name	Part No.	Qty	Item No.
DISA 130 - 231 C			
6m hardened stainless steel	2442R0740	24	2052B2380
		12	2442B2380
Additional			
T-bolt	2072B2850	1	To fix & mount capping strips
Zink paste	3800A0014	1	Protection against corrosion

AMC Capping Strips Package 6m for DISAMATIC 2013 MK3, MK4, MK5 & 130, 131, 230, 231 X and Z



The mounted T-bolts allow a smooth assembly of strips onto the slide way. If one or more capping strips need changing the DISA patented solution allows a fast and smooth change from worn to new.

4 Reasons to install the Capping Strips Package

- Reduction of sand sticking.
- Quick and simple installation.
- Accessories to perform quick installation
- Attractive sackage price

Depending on your requirements DISA can provide capping strips in following material:

- 3 m cold rolled steel/non hardened stainless steel. Provides increased friction to your moulds and lessens the risk of mould gapping and metal run out.
- 6 m hardened stainless steel: Extends the lifetime of your slide way and reduces build up of corrosion on your AMC.

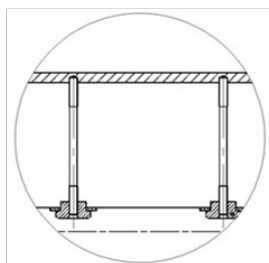
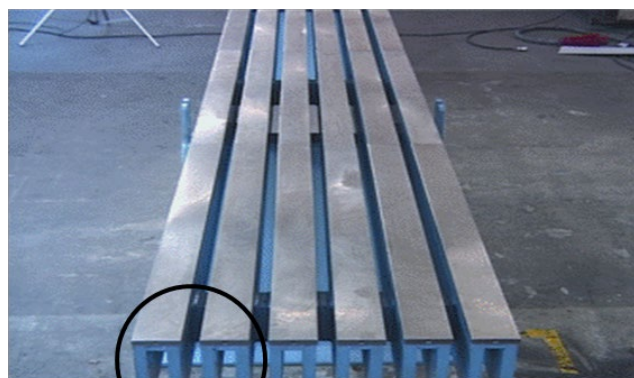
Accessories

Zink paste to eliminate corrosion between war rail and capping strip. Order T-bolts for installation.

Please contact your local DISA Representative and ask for the part specified for your Machine Type as indicated in the table below.

Part Name	Part No.	Qty	Item No.
2013 MK1 - 5 & 130 - 231 X & Z			
6m hardened stainless steel	2052R0830	30	2052B2380
		12	2052B2390
3m non hardened stainless steel	2052R1860	15	2052B3050
		6	2052B3060
3m cold rolled steel	2052R1830	15	2052B3070
		6	2052B3080
Additional			
T-bolt	2072B2850	1	To fix & mount capping strips
Zink paste	3800A0014	1	Protection against corrosion

Wear Strips for DISAMATIC 2013 MK3, MK4, MK5 and LP



All Wear strips undergo a thorough inspection to ensure highest quality and life expectancy which is the standard for all DISA products.

3 Reasons to install the Capping Strips Package

- Wear strips provided in materials suited to your needs
- All necessary items contained in one kit number
- Accessories to perform fast installation.

Depending on your requirements, DISA can provide capping strips of the following material:

- Cold rolled steel. Provides increased friction to moulds and reduces the risk of mould gapping and metal run out.
- Hardened stainless steel: Extends the lifetime of your slide way and reduces build up of corrosion on your AMC.

Accessories

- Zink paste to eliminate corrosion between slide way and Wear strip. Components to fixate Wear strips. Supporting roll cap for height level reduction if a combination of Cold Rolled and Hardened stainless Steel is used.

Please contact your local DISA Representative and ask for part specified for your Machine Type in the table.

Part Name	Part No.	Qty	Item No.
DISAMATIC 2013 MK1 - 5 A & LP			
6m hardened stainless steel	2052R1770	24	2052B1650
		6	2052B1700
6m cold rolled steel	2052R2000	24	2052B3770
		6	2052B3780
DISAMATIC 2013 MK1 - 5 B			
6m hardened stainless steel	2052R1790	16	2052B1650
		4	2052B1700
		8	2052B1670
		2	2052B1710
6m cold rolled steel	2052R2010	16	2052B3770
		4	2052B3780
		8	2052B3790
		2	2052B3800
DISAMATIC 2013 MK5 X			
Inlet & Midsection HSS Wear strips kit & Mounting hardware	2052R1700		
Outlet HSS Wear strips kit & mounting hardware	2052R1710		
Inlet & Midsection HSS Wear strips	2052R1890		
Outlet HSS Wear strips kit	2052R1900		

Additional Items	Part No.	Q.	Description
Zink Paste	3800A0014	1	Against corrosion
Fixation	2052R1750	1	650 items to mount
Height Reduction	2052B2030	1	Supporting roll cap

Welding Kit for Capping Strips AMC for DISAMATIC 2013 MK3, MK4, MK5 and LP



Upgrade your old Slideway with Capping Strips

The welding kit, capping strips for AMC is developed to allow a quick and individual change of strips. The wear strip is made of hardened and stainless material and can be mounted/dismounted from the above with a plastic hammer. The wear strip is retained by a special screw system.

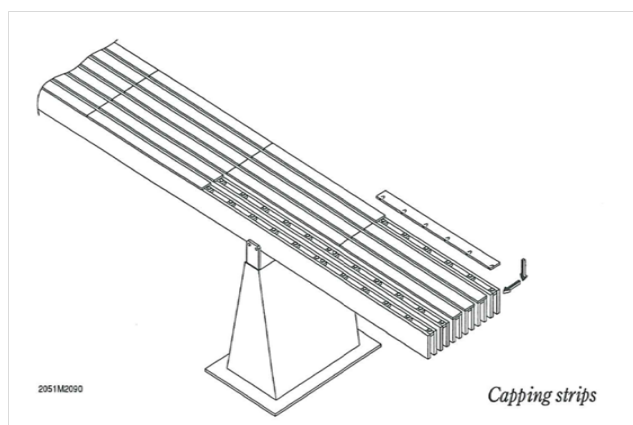
Please contact your local DISA Representative and ask for: **Welding Kit for Capping Strips AMC.**

Remember to state the Machine Type and serial number.

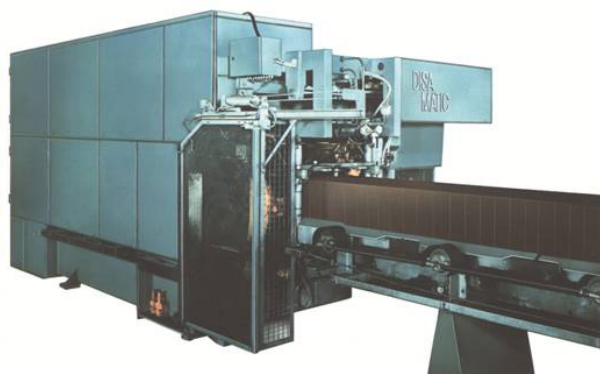
[Link to Video](#)

4 reasons to install a Welding kit

- Less sticking problems.
- Service friendly.
- Fast change of capping strips.
- Capping strips can be changed and mounted individually.



Upgrade with Hydraulic AMC and SBC System for DISAMATIC 2013 MK3 PLC



The DISAMATIC moulding machine is a high quality product that lasts for many years. You can upgrade your older MK-3 machine with a hydraulic AMC/SBC and be ready in the future to add a new DISAMATIC with no additional AMC/SBC costs. The hydraulic AMC system is already working successfully in over 100 foundries worldwide.

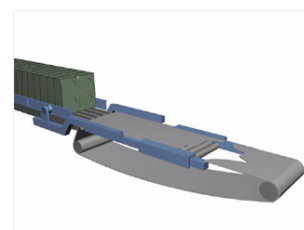
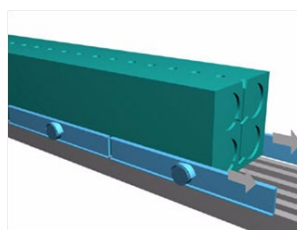
Automatic Mould Conveyor (AMC)

The perfectly controlled synchronisation of the DISAMATIC/AMC movements controls the forces between the moulds thus minimizing the risk of mould deformation during close-up and mould string transport. Noise below 70 dB (A).

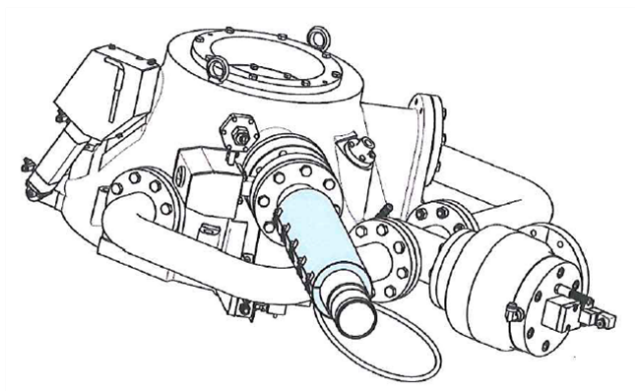
Synchronised Belt Conveyor (SBC)

The SBC extends the cooling zone beyond the AMC if longer in-mould cooling time is required. The sturdy SBC is provided with a multi-ply heat-resistant rubber belt. It is powered by and fully synchronised with the AMC via pneumatic clamping clutches. This prevents mould gaps at the critical transition point between the MAC and the SBC.

Please contact your local DISA Representative and ask for Upgrade for DISAMATIC 2013 MK3 PLC with a Hydraulic AMC & a SBC system.



Exhaust Pipe Heating with Flap Type Sand Valve for DISA 130



The new Exhaust Pipe Heating offers improved reliability of the DISA 130

- Improves exhaust flow
- Reduces Sand build up in the pipe and related production loss
- Prolongs lift time of exhaust pipe

The kit includes heating cover for the exhaust pipe and the necessary electrical control parts.

Please contact your local DISA Representative and ask for item number **10065419**

Repair Kit Divided Column for SAM 6 Mixer



SAM 6 Mixer with Divided Columns

At DISA, we have developed a spare part kit to replace the complete lower part of the center column in one assembled unit. The kit includes O-rings to the connection piece, a new water seal and the connecting flange to the water inlet.

To mount a preassembled unit is a fast and safe solution. This action will ensure the maximum uptime for the Sam Mixer system.

Please contact your local DISA Representative and ask for item number **10230988**

Part Name	Part No.	Qty
Water Seal	596-481-124	1
Water Connecting Flange	592-466-082	1
Adjustment Ring	592-466-076	1
O-rings	062-1630-730	2

Repair Kit Divided Column for SAM 10 Mixer



SAM 10 Mixer with Divided Columns

At DISA, we have developed a spare part kit to replace the complete lower part of the center column in one assembled unit. The kit includes O-rings to the connection piece, a new water seal and the connecting flange to the water inlet.

To mount a preassembled unit is a fast and safe solution. This action will ensure the maximum uptime for the Sam Mixer system.

Please contact your local DISA Representative and ask for item number **10231806**

Part Name	Part No.	Qty
Water Seal	596-481-124	1
Water Connecting Flange	592-466-104	1
Adjustment Ring	592-466-190	1
O-rings	10083488	2

Repair Kit Divided Column for SAM 16



SAM 16 Mixers with Divided Columns

At DISA, we have developed a spare part kit to replace the complete lower part of the center column in one assembled unit. The kit includes O-rings to the connection piece, a new water seal and the connecting flange to the water inlet.

To mount a preassembled unit is a fast and safe solution. This action will ensure the maximum uptime for the Sam Mixer system.

Please contact your local DISA Representative and ask for item number **10189865**

Part Name	Part No.	Qty
Water Seal	596-481-106	1
Water Connecting Flange	592-466-023	1
Adjustment Ring	592-466-024	1
O-rings	10083483	2

Divided Column for SAM Mixer



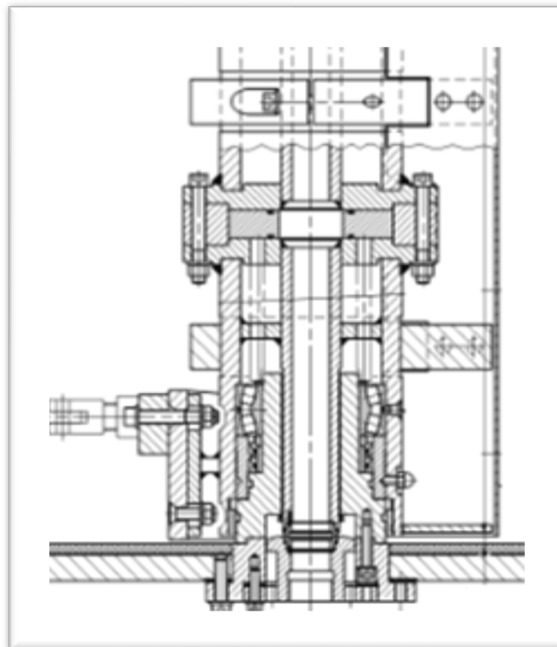
The SAM centre bearings are to be replaced at a frequency of every 4 years.

In order to ease the replacement job, DISA has developed the divided column kit for the SAM mixer program.

The SAM Mixer Divided Column Kit provides

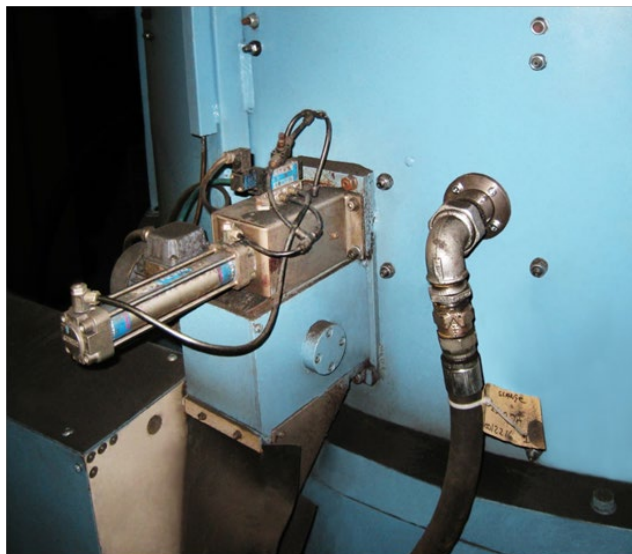
- Reduced downtime for maintenance
- Reduced maintenance cost
- Easier replacement of bearings

Please contact your local DISA Representative and ask for the part specifically for your Machine Type in the table below.



Part Name	Part No.
SAM 3	592-466-064
SAM 6	592-466-080
SAM 10 Ceramic	592-466-239
SAM 10	592-466-186
SAM 16 Ceramic	592-466-212
SAM 14 & 16	592-466-141
SAM 16 (180S)	592-466-155

Water Supply for SAM Mixer



The Sam Mixers can be updated to add water from 3 positions on the mixer wall.

The SAM Mixer Water Supply Kit provides

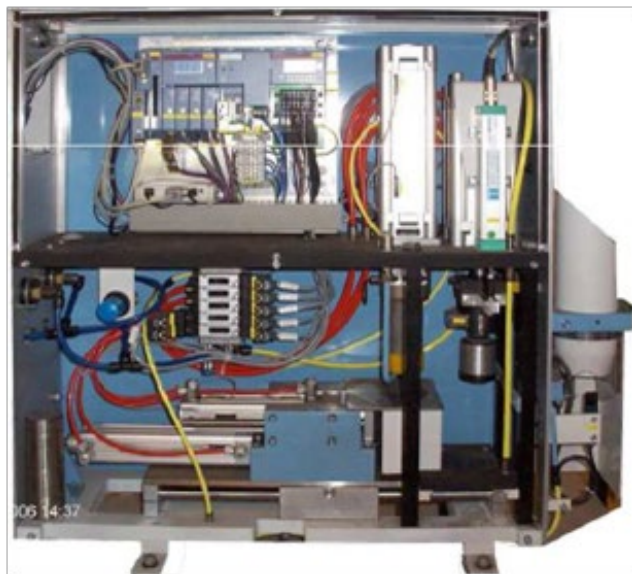
- Reduced sand sticking inside mixer bowl
- Reduced maintenance
- Higher mixing efficiency

A manual for installation is supplied with the kit to enable the customer to install the kit without the help of a DISA technician.

Please contact your local DISA Representative and ask for the part specifically for your mixer type in the table below.

Machine Type	Part No.
SAM3, 6, 10 & 14 with steel lining	10425973
SAM16 & 16S with steel lining	10425995
SAM3, 6 & 10 with ceramic lining	10425986
SAM16 & 16S with ceramic lining	10426001
All SAM – Hose and fitting kit	10556290

Wear Parts for SMC



Maintain Top Performance of the SMC

The DISA SMC Wear parts enable you to maintain the top performance of the SMC.

Spare parts kit is for 2 years use

On the picture and drawing below you can see where to replace the Wear parts on the SMC.

Advantages

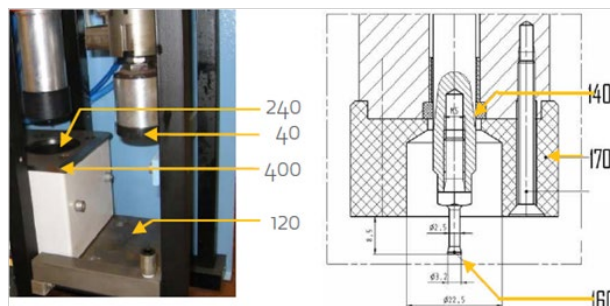
- Reliable readings
- Stable moulding sand

Please contact your local DISA Representative and ask for item number **10140403**

Please note

For a total kit, apply the number above. For specific parts, apply the number in the table.

Part Name	Position	Part No.	Qty
Test pin	160	592-802-616	8
Pressure ring	170	592-802-598	1
Seal ring	140	592-802-643	1
Piston ring	40	592-801-522	1
Bushing	240	592-801-505	1
Top Plate	400	592-801-909	1
Low slide Plate	120	592-801-544	1



DISACOOL 2400 Update: 17" Low Profile Tyres



Picture is for illustrative purpose only as size depends on machine size

DISACOOL Kit Wheel with Tyre 16" to 17"

DISA has developed a new Kit with lower profile of Tyres 17".

It will now be possible to update your DISACOOL with low profile Tyres 17" which are used on all new DISACOOL today.

6 advantages using this kit

- This type of Tyres can endure 20% more load
- Extended lifetime
- Less deformation of Tyres and thereby less wear
- Lower roller friction and thereby approximately 5% less energy consumption
- It will be possible to change the complete wheel / rim without removing bearings from the shaft
- This new solution will make it much more service friendly

Please contact your local DISA Representative for further information.

DISACOOL Type	Kit Name	Part No.	Qty	Description - Contains all necessary Parts
DISACOOL 2400				
Drive Roller	Low Profile Drive Roller	10155842	2	Wheel with Tyre-Bushing-Shaft-Sealing-Bearing Housing-Bearing-Assy without: Gear
Carrying Roller	Low Profile Carrying Roller	10155843	2	Wheel with Tyre-Bushing-Shaft-Sealing-Bearing Housing-Bearing-Assy without: Gear

DISACOOL 2900 Update: 17" Low Profile Tyres



Picture is for illustrative purpose only as size depends on machine size

DISACOOL Kit Wheel with Tyre 16" to 17"

DISA has developed a new Kit with lower profile of Tyres 17".

It will now be possible to update your DISACOOL with low profile Tyres 17" which are used on all new DISACOOL today.

6 advantages using this kit

- This type of Tyres can endure 20% more load
- Extended lifetime
- Less deformation of Tyres and thereby less wear
- Lower roller friction and thereby approximately 5% less energy consumption
- It will be possible to change the complete wheel / rim without removing bearings from the shaft
- This new solution will make it much more service friendly

Please contact your local DISA Representative for further information.

DISACOOL Type	Kit Name	Part No.	Qty	Description - Contains all necessary Parts
DISACOOL 2900				
Drive Roller	Low Profile Drive Roller	10155840	2	Wheel with Tyre-Bushing-Shaft-Sealing-Bearing Housing-Bearing-Assy without Gear
Carrying Roller	Low Profile Carrying Roller	10155841	2	Wheel with Tyre-Bushing-Shaft-Sealing-Bearing Housing-Bearing-Assy without Gear

DISACOOL 3200 Update: 17" Low Profile Tyres



Picture is for illustrative purpose only as size depends on machine size

DISACOOL Kit Wheel with Tyre 16" to 17"

DISA has developed a new Kit with lower profile of Tyres 17".

It will now be possible to update your DISACOOL with low profile Tyres 17" which are used on all new DISACOOL today.

6 advantages using this kit

- This type of Tyres can endure 20% more load
- Extended lifetime
- Less deformation of Tyres and thereby less wear
- Lower roller friction and thereby approximately 5% less energy consumption
- It will be possible to change the complete wheel / rim without removing bearings from the shaft
- This new solution will make it much more service friendly

Please contact your local DISA Representative for further information.

DISACOOL Type	Kit Name	Part No.	Qty	Description - Contains all necessary Parts
DISACOOL 3200				
Drive Roller	Low Profile Drive Roller	10154951	2	Wheel with Tyre-Bushing-Shaft-Sealing-Bearing Housing-Bearing-Assy without Gear
Carrying Roller	Low Profile Carrying Roller	10117852	2	Wheel with Tyre-Bushing-Shaft-Sealing-Bearing Housing-Bearing-Assy without Gear

DISACOOL 3400 Update: 17" Low Profile Tyres



Picture is for illustrative purpose only as size depends on machine size

DISACOOL Kit Wheel with Tyre 16" to 17"

DISA has developed a new Kit with lower profile of Tyres 17".

It will now be possible to update your DISACOOL with low profile Tyres 17" which are used on all new DISACOOL today.

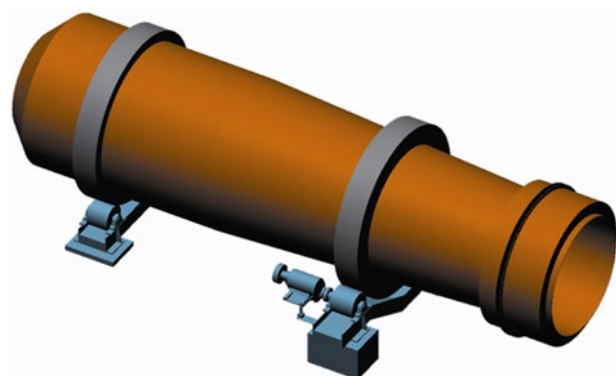
6 advantages using this kit

- This type of Tyres can endure 20% more load
- Extended lifetime
- Less deformation of Tyres and thereby less wear
- Lower roller friction and thereby approximately 5% less energy consumption
- It will be possible to change the complete wheel / rim without removing bearings from the shaft
- This new solution will make it much more service friendly

Please contact your local DISA Representative for further information.

DISACOOL Type	Kit Name	Part No.	Qty	Description - Contains all necessary Parts
DISACOOL 3400				
Drive Roller	Low Profile Drive Roller	10155833	4	Wheel with Tyre-Bushing-Shaft-Sealing-Bearing Housing-Bearing-Assy without Gear

Recommended Spare Parts for DISACOOOL 2400 before 2010



Faster and easy change of Tyres.

We can offer RIM and Tyres assembled.

Idler Roller Assembly: Position 16 and 260 of
Drawing No.: 2117B2531

Wheel with 1 pcs. of 9"-Tyre	10135737	2	1
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**Drive Roller Assembly: Position 16 and 260 of
Drawing No.: 2117B2521**

Wheel with 1 pcs. of 9"-Tyre	10135737	2	1
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**Water Dosing Unit
Drawing No.: 2047B8451 1"**

Water meter (Kit)	ITEM 13	10073259	1	1
Pneu. Operated Axial Valve	ITEM 16	10053180	2	1
BasePlate	ITEM 18	10078634	2	1
Air Valve 24vdc	ITEM 19	10085340	2	1

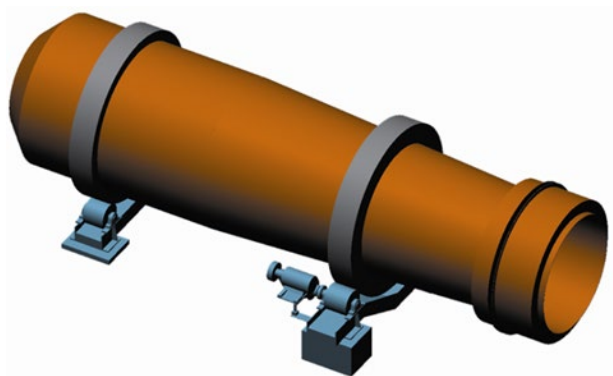


Type of Machine: DISACOOOL 2400 (BEFORE 2010)

Part Type	Item No.	ID	Recom- mended Qty	Critical Qty
Critical & Recommended Spare Parts List Drawing No.: 2117B2501, 2511, 2531 and 2541				
Vulkollan Tyre (22x9x16")	ITEM 260	2067B3870	4	2
Thrust Wheel	ITEM 10	10076813	2	1
Thrust Wheel Bearing R 50/90/20	ITEM 30	10000078	2	1
Roller Bearing R 130/200/65 RL	ITEM 245	10024171	8	2
Bearing Housing	ITEM 250	9108K5058	8	2
Sealing for Bearing	ITEM 26	2047B3561	16	4
Locking Assembly	ITEM 265	9108A1047	4	1
Inductive Sensor	ITEM 300	10055504	4	1
Shaftmoun. Planetary Gear Unit	ITEM 275	10076787	2	1
Electric Motor	ITEM 280	10113937	2	1
Buffer Ø63X17X63	ITEM 230	9105H0107	4	2
Proxim Switch 24V	ITEM 200	10043469	1	1
Proxim Switch 24V	ITEM 295	10085871	1	1
Sensor Temp 0-250gr 4-20ma 15	ITEM 530	10103052	1	1
Inductive Sensor M18 24VDC	ITEM 560	10055552	1	1
Sensor Temp 0-250gr 4-20mA 2:1	ITEM 580	10103138	1	1



Recommended Spare Parts for DISACOOOL 2400 after 2010



Water Dosing Unit Drawing No.: 2047B8451 1"

Water Meter	ITEM 11	10056101	1	1
Air Valve	ITEM 13	10098946	2	1
Gunmetal Angle Seat Valve	ITEM 14	10055506	2	1

Faster and easy change of Tyres.
We can offer RIM and Tyres assembled.

Carrying Roller: Position 16 and 260 of Drawing No.: 10120953

Rim 17" with 1 pcs. of 9" Tyres Assy.	10135750	2	1
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Drive Roller Assembly: Position 16 and 260 of Drawing No.: 10120949

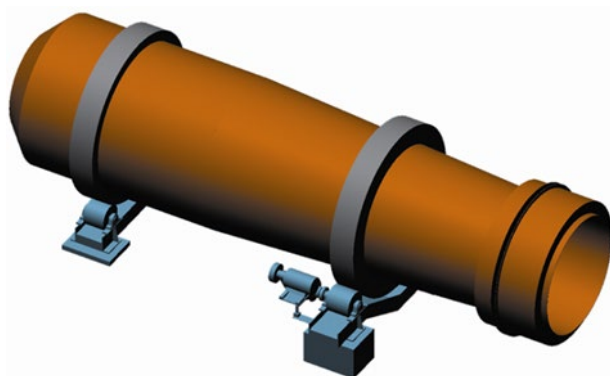
Rim 17" with 1 pcs. of 9" Tyres Assy.	10135750	2	1
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Type of Machine: DISACOOOL 2400

Part Type	Item No.	ID	Recom- mended Qty	Critical Qty
Critical & Recommended Spare Parts List Drawing No.: 10700395, 10170354, 10120949 AND 10120953				
Urelast Spring / Buffer ø63x17x63	ITEM 230	9105H0107	4	2
Vulkollan Tyre (22x9x17")	ITEM 10/181	10116497	4	2
Thrust Wheel	ITEM 10	10A076813	2	1
Thrust Wheel Bearing R 50/90/20	ITEM 30	10000078	2	1
Roller Bearing R 130/200/65 RL	ITEM 80/150	10024171	8	2
Bearing Hoousing	ITEM 90/160	9108Ka5058	8	2
Sealing for Bearing	ITEM 100/140	2047B3561	16	4
Locking Assembly	ITEM 20	10107223	4	1
Inductive Sensor	ITEM 300	10055504	4	1
Shaftmounted Planetary Gear Unit	ITEM 70	10076787	2	1
Proxim Switch 24V	ITEM 200	10043469	1	1
Proxim Switch 24V	ITEM 295	10085871	1	1
Sensor Temp 0-250gr 4-20mA 15	ITEM 530	10103052	1	1
Inductive Sensor M18 24VDC	ITEM 560	10055552	1	1
Sensor Temp 0-250gr 4-20mA 2:1	ITEM 580	10103138	1	1



Recommended Spare Parts for DISACOOL 2900 before 2010



IMPORTANT: Gear ratio is changed

Remember to replace all Units at the same time.

New type of Gear

Shaft mounted planetary Gear Unit	item 190	10077895	2	1
Electric Motor	item 191	10022110	2	1

Water Dosing Unit

Drawing No.: 2047B8052

Water meter (Kit)	item 13	10073259	1	1
Pneu. Operated Axial Valve	item 16	10053180	2	1
BasePlate	item 18	10078634	2	1
Air Valve 24vdc	item 19	10085340	2	1

Type of Machine: DISACOOL 2900 (before 2010)

Part Type	Item No.	ID	Recom- mended Qty	Critical Qty
Critical & Recommended Spare Parts List				
Drawing No.: 2047A4201, 4211, 4222, 4233 and 4241				
Urelast Spring / Buffer	item 172	9105H0079	4	2
Vulkollan Tyre (22x9x16")	item 181	2067B3870	4	2
Vulkollan Tyre (22x8x16")	item 182	2067B3860	4	2
Thrust Wheel	item 180	9108O0082	2	1
Sealing for Bearing	item 46	2047B3221	16	4
Bearing	item 175	10024172	8	2
Bearing Housing	item 176	9108K5155	8	2
Locking Assembly	item 183	9108A1017	8	2
Sensor	item 195	9116X7545	4	1

Faster and easy change of Tyres.

We can offer wheel and Tyres assembled.

Drive Roller Assembly: Position 44 and 181 of

Drawing No.: 2047A4221

Wheel Assy. with two 9" Tyres	10110138	2	1
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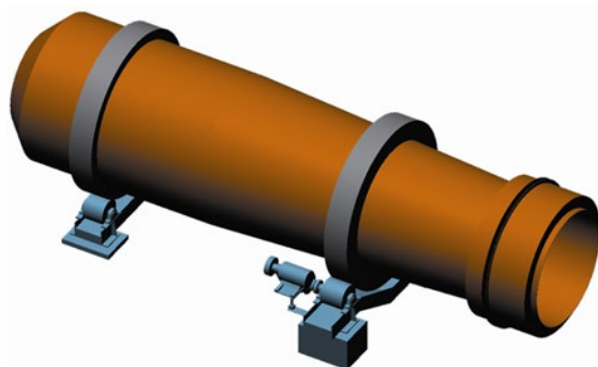
Drive Roller Assembly: Position 20 and 182 of

Drawing No.: 047A4231

Wheel Assy. with two 8" Tyres	10110141	2	1
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Recommended Spare Parts for DISACOOL 2900 after 2010



Faster and easy change of tyres.
We can offer RIM and Tyres assembled.

**Drive Roller Assembly: Position 44 and 181 of
Drawing No.: 10122139**

Rim 17" with 2 pcs. of 9" Tyres Assy.	10135769	2	1
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**Drive Roller Assembly: Position 20 and 182 of
Drawing No.: 10122137**

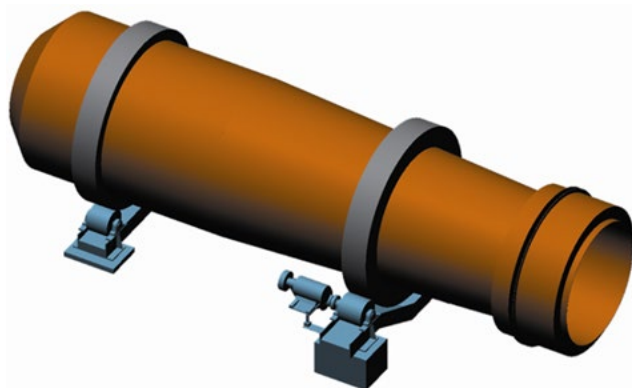
Rim 17" with 2 pcs. of 8" Tyres Assy.	10135765	2	1
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Type of Machine: **DISACOOL 2900**

Part Type	Item No.	ID	Recom- mended Qty	Critical Qty
Critical & Recommended Spare Parts List Drawing No.: 2047A4201, 4211, 10122139 AND 10122137				
Urelast Spring / Buffer ø80xø21x80	ITEM 172	9105H0079	4	2
Vulkollan Tyre (22x9x17")	ITEM 181	10116497	4	2
Vulkollan Tyre (22x8x17")	ITEM 182	10116496	4	2
Thrust Wheel (400/100/050)	ITEM 180	910800082	2	1
Roller Bearing	ITEM 175	10024172	8	2
Bearing Housing	ITEM 176	9108K5155	8	2
Sealing for Bearing	ITEM 46	2047B3221	16	4
Locking Assembly 160x210	ITEM 183	10107223	8	2
Inductive Sensor	ITEM 195	10055504	4	1
Shaftmounted Planetary Gear Unit	ITEM 190	10077895	2	1
Proxim Switch 24V	ITEM 200	10043469	1	1
Sensor Temp 0-250gr 4-20ma 15	ITEM 330	10103052	1	1
Inductive Sensor M18 24VDC	ITEM 350	10055552	1	1
Sensor Temp 0-250gr 4-20mA 2:1	ITEM 370	10103138	1	1



Recommended Spare Parts for DISACOOL 3200 before 2010



Water Dosing Unit
Drawing No.: 2047B382x

Water Meter (Kit)	ITEM 13	10073259	1	1
Pneu. Operated Axial Valve	ITEM 16	10075692	2	1
Air Valve	ITEM 18	10027738	2	1

Water Dosing Unit
Drawing No.: 2047B380x

Water Meter (Kit)	ITEM 13	10073259	1	1
Pneu. Operated Axial Valve	ITEM 16	10075692	1	1
Air Valve	ITEM 11	10091005	1	1

Water Dosing Unit
Drawing No.: 2047B805x

Water Meter (Kit)	ITEM 13	10073259	1	1
Pneu. Operated Axial Valve	ITEM 16	10053180	2	1
Base Plate	ITEM 18	10078634	2	1
Air Valve 24 vdc	ITEM 19	10085340	2	1

Type of Machine: DISACOOL 3200 (before 2010)

Part Type	Item No.	ID	Recom- mended Qty	Critical Qty
Critical & Recommended Spare Parts List Drawing No.: 2047B237x, 241x, 253x, 832x AND 261X				
Urelast Spring/Buffer	ITEM 172	9105H0079	1	1
Vulkollan Tyre (22x9x16")	ITEM 181	2067B3870	4	2
Vulkollan Tyre (22x10x16")	ITEM 181.1	2067B3880	4	2
Thrust Wheel	ITEM 180	10077528	2	1
Sealing for Bearing	ITEM 46	2047B3561	16	4
Bearing	ITEM 177	10024171	8	2
Bearing Housing	ITEM 178	9108K5058	8	2
Locking Assembly	ITEM 182	9108A1017	4	2
Sensor	ITEM 195	10038316	1	1
Shaftmounted Planetary				
Gear Unit	ITEM 200	9108D0056	2	1
Electrical Motor	ITEM 201	10032933	2	1
V-Belt Set	ITEM 213	10032030	2	2

Faster and easy change of Tyres.

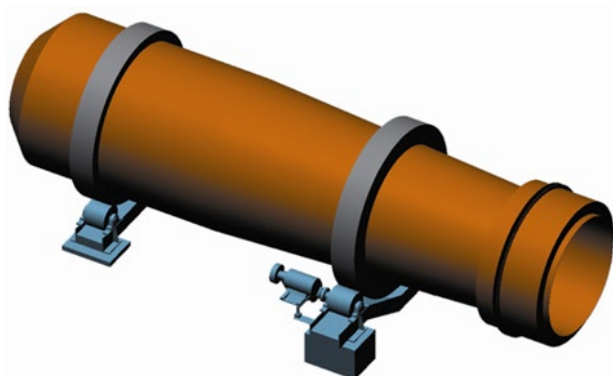
We can offer wheel and tyres assembled.

Support Wheel: Position 15 and 181 of
Drawing No.: 2047B2611

Wheel Assy. with two 9" Tyres	10110138	2	1
Drive Wheel: Position 16 and 181.1 of Drawing No.: 2047B2541			
Wheel assy. with two 10" Tyres	10110099	2	1



Recommended Spare Parts for DISACOOOL 3200 after 2010



Faster and easy change of Tyres.
We can offer RIM and Tyres assembled.

Drive Roller Assembly: Position 16 and and 181.1 of
Drawing No.: 10106817

Rim 17" with 2 pcs. of 10" Tyres Assy.	10136037	2	1
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Carrying Roller Assembly: Position 15 and 181 of
Drawing No.: 10106809

Rim 17" with 2 pcs. of 9" Tyres Assy.	10135769	2	1
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Water Dosing Unit
Drawing no.: 2047B8051 1"

Water Meter	ITEM 11	10056101	1	1
Air Valve	ITEM 13	10098946	2	1
Gunmetal Angle Seat Valve	ITEM 14	10055506	2	1

Type of Machine: DISACOOOL 3200

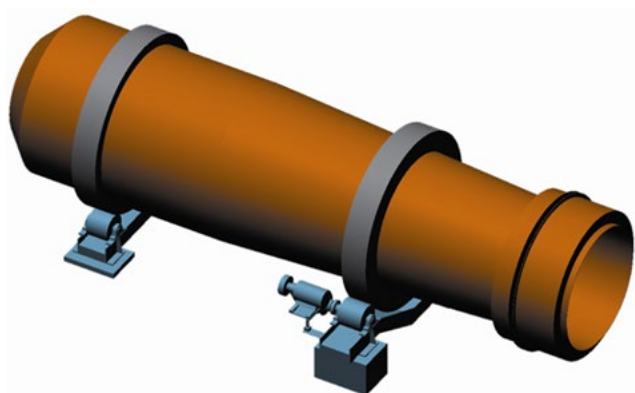
Part Type	Item No.	ID	Recom- mended Qty	Critical Qty
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Critical & Recommended Spare Parts List
Drawing No.: 2047B8521, 8531, 10106817 and 10106809

Urelast Spring / Buffer ø80xø21x80	ITEM 172	9105H0079	4	2
Vulkollan Tyre (22x9x17")	ITEM 181	10116497	4	2
Vulkollan Tyre (22x10x17")	ITEM 181.1	10116498	4	2
Thrust Wheel (400/100/050)	ITEM 180	910800082	2	1
Roller Bearing	ITEM 177	100244171	8	2
Bearing Housing	ITEM 178	9108K5058	8	2
Sealing for Bearing	ITEM 46	2047B3561	16	4
Locking Assembly 160x210	ITEM 182	10107223	8	2
Inductive Sensor	ITEM 195	10055504	4	1
Planet Gear Unit	ITEM 200	9108D0056	2	1
Proxim Switch 24V	ITEM 214	10043469	1	1
Sensor Temp 0-250gr 4-20ma 15	ITEM 330	10103052	1	1
Inductive Sensor M18 24VDC	ITEM 350	10055552	1	1
Sensor Temp 0-250gr 4-20mA 2:1	ITEM 370	10103138	1	1



Recommended Spare Parts for DISACOOOL 3400 before 2010



IMPORTANT: Gear Ratio is changed
Remember to replace all 4 at the same time.

New Type of Gear				Recom- mended Qty	Critical Qty
Shaftmounted Planetary					
Gear Unit SL 3013 50 Hz	item 190	10077895	4	1	
Gear Unit SL 3013 60 Hz	item 190	10175836	4	1	
Drive Roller Assembly: Position 21 and 181 of Drawing No.: 2067B3651 & 2067B3941					
Wheel Assy. with 3 pcs. 9" tyres		10108886	4	1	

Faster and easy change of Tyres.
We can offer Wheel and Tyres assembled.

Type of Machine: DISACOOOL 3400 (before 2010)

Part Type	Item No.	ID	Recom- mended Critical	
			Qty	Qty
Critical & Recommended Spare Parts List				
Drawing No.:2067B3621, 2131, 3611, 3651 and 3661				
Urelast Spring / Buffer	item 172	9105H0079	1	1
Vulkollan Tyre (22x9x16")	item 181	2067B3870	12	3
Thrust Wheel	item 180	10077528	2	1
Bearing	item 174	10024173	4	2
Bearing	item 175	10024172	4	2
Bearing Housing	item 176	9108K5155	8	2
Locking Assembly	item 182	9108A1047	2	2
Sensor	item 195	10038316	1	1
Sealing for Bearing	item 25	2047B3221	16	16

Water Dosing Unit
Drawing No.: 2047B8051 & 52

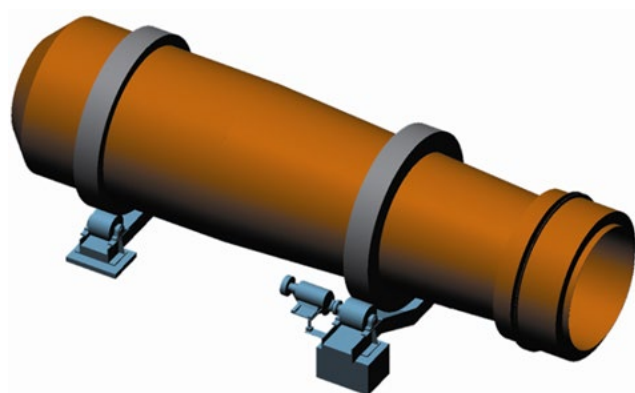
Water Meter (Kit)	ITEM 13	10073259	1	1
Pneu. Operated Axial Valve	ITEM 16	10053180	2	1
BasePlate	ITEM 18	10078634	2	1
Air Valve 24vdc	ITEM 19	10085340	2	1

Water Dosing Unit
Drawing No.: 2077F8591

Water Meter (Kit)	ITEM 11	10073260	1	1
Valve Angle Seat	ITEM 14	10055507	2	1
Pilot Valve	ITEM 13	10098946	2	1



Recommended Spare Parts for DISACOOL 3400 after 2010



Water Dosing Unit
Drawing No.: 2047B8051 1"

			Recom- mended Qt	Critical Qt
Water Meter	ITEM 11	10056101	1	1
Air Valve	ITEM 13	10098946	2	1
Gunmetal Angle Seat Valve	ITEM 14	10055506	2	1

Faster and easy change of Tyres.
We can offer RIM and Tyres assembled.

Drive Roller Assembly: Position 10 and 30 of
Drawing No.: 10120859

Rim 17" with 3 pcs. of 9" Tyres Ass.	10136045	4	1
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Type of Machine: DISACOOL 3400

Part Type	Item No.	ID	Recom- mended Qty	Critical Qty
Critical & Recommended Spare Parts List Drawing No.: 2067B3611, 3621 and 10120859				
Urelast Spring / Buffer Ø80 x Ø21 x 80	item 172	9105H0079	8	2
Vulkollan Tyre (22x9x17")	item 10	10116497	12	3
Roller Bearing R 140/210/85 RL	item 110	10024173	4	2
Roller Bearing R 140/210/70 RL	item 70	10024172	4	2
Bearing Housing	item 120	9108K5155	8	2
Sealing for Bearing	item 100	2047B3221	16	4
Locking Assembly 170x225	item 50	10178440	8	2
Gear Unit SL3013 50 Hz	item 180	10077895	4	1
Gear Unit SL3013 60 Hz	item 180	10175836	4	1
Inductive Sensor	item 195	10055504	4	1
Proxim Switch 24V	item 200	10085871	1	1
Sensor Temp 0-250gr 4-20ma 15	item 330	10103052	1	1
Inductive Sensor M18 24VDC	item 350	10055552	1	1
Sensor Temp 0-250gr 4-20mA 2:1	item 370	10103138	1	1
Thrust Wheel (500/150/070)	item 180	10038409	2	1



Wall Scraper Kit for SAM 10 Mixer



The Sam 10 Mixers can be updated with a wall Scraper kit to change the working angle of the unit from 30 to 23 degrees.

The Hard Metal Scrapers and the Wall Plough have a new design.

The design of the Support bar is changed and moved from the bottom to the middle of the Mixer Bowl.

Installation information is included in the kit.

The SAM Mixer Wall Scraper Kit provides

- 10 – 20 % more mixing capacity
- Higher mixing efficiency
- Reduced load on the main gear box

Please contact your local DISA Representative and ask for item number **10492224**



Wall Scraper Kit for SAM 6 Mixer



The SAM 6 Mixers can be updated with a wall scraper kit to change the work angle of the wall scraper parts from 27 to 21 degrees.

The parts to change are mostly normal wear parts: Holder, arm, scraper holder plate, and scrapers.

This update will move between 6 to 12% of the energy consumption from the gear bridge and into the mixing turbine.

Scrapers and bottom plough have a new design.

Installation information is included in the kit.

The SAM Mixer Wall Scraper Kit provides

- 6-12% more mixing capacity
- Higher mixing efficiency
- Reduced load on the main gear box
- Reduced wear on the scrapers and the mixer wall

Please contact your local DISA Representative and ask for item number **10497176**

Down Sprue for DISA MATCH 130



All parts in the down sprue can be replaced individually. Drawing with a list of spare parts is supplied to the part when purchased.

Please contact your local DISA Representative and ask for the required part in the table below.

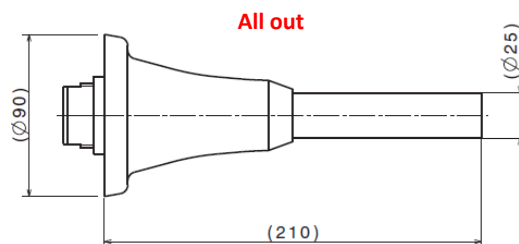
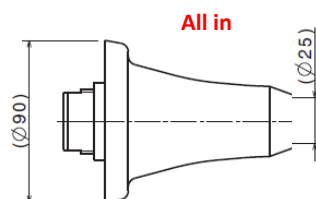
Please note

Diameter refers to the part in contact with the pattern plate.

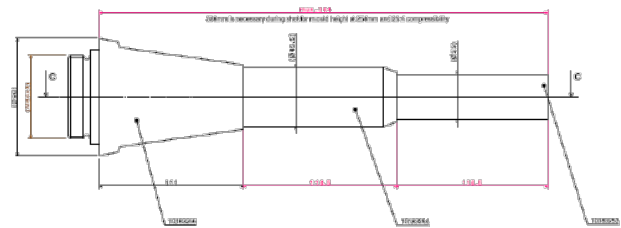
The Advantages of Down Sprues

- DISA quality standards and tolerances
- Hardened wear surfaces
- All individual parts are available as spare parts
- Several down sprue sizes
- Special design on request

Part Name	Part No.	All in mm	All out mm
Down Sprue Ø20 Assy	10463876	100	197
Down Sprue Ø25 Assy	10263602	100	197
Down Sprue Ø30 Assy	10406682	138	255
Down Sprue Ø20 Assy	10558250	105	210
Down Sprue Ø20 Assy	10558252	135	270
Down Sprue Ø25 Assy	10558253	105	210
Down Sprue Ø25 Assy	10558254	135	270
Down Sprue Ø30 Assy	10558255	125	229
Down Sprue Ø30 Assy	10558256	146	271
Down Sprue Ø35 Assy	10558257	125	229
Down Sprue Ø35 Assy	10558258	146	271



Down Sprue for DISA MATCH 24/28



All parts in the Down Sprue can be replaced individually. Drawing with list of spare parts is supplied to the part when purchased.

Please contact your local DISA Representative and ask for the required part in the table.

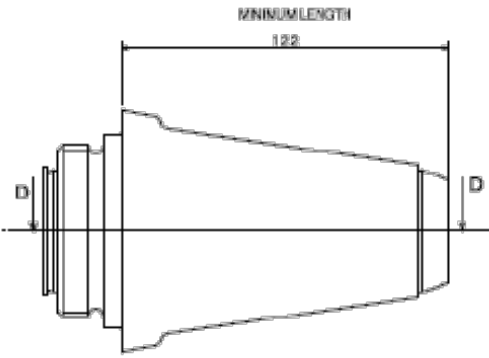
Please note

Diameter refers to the part in contact with the pattern plate.

The Advantages of Down Sprues

- DISA quality standards and tolerances
- Hardened wear surfaces
- All individually parts are available as spare parts
- Several Down sprue sizes
- Special design on request

Part Name	Part No.	All in mm	All out mm
Down Sprue Ø25 Assy	10134342	122	344
Down Sprue Ø30 Assy	10147018	122	344
Down Sprue Ø35 Assy	10183252	122	344



Down Sprue for DISA MATCH 28/32 and DISA MATCH 32/32



All parts in the Down Sprue can be replaced individually. Drawing with list of spare parts will be added to part when purchased.

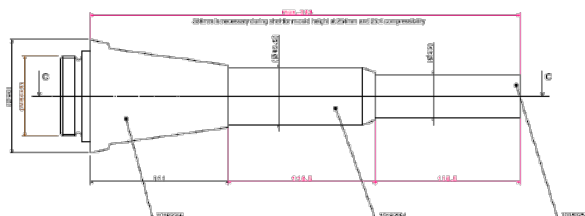
Please contact your local DISA Representative and ask for the required part in the table.

Please note

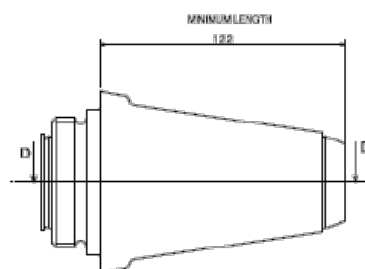
Diameter refers to the part in contact with the Pattern Plate.

The Advantages of Down Sprues

- DISA quality standards and tolerances
- Hardened wear surfaces
- All individually parts are available as spare parts
- Several down sprue sizes
- Special design on request



Part Name	Part No.	All in mm	All out mm
Down Sprue Ø20 Assy	10216023	165	473
Down Sprue Ø25 Assy	10043319	165	473
Down Sprue Ø25 special Assy	10446278	165	473
Down Sprue Ø30 Assy	10216027	165	473
Down Sprue Ø30 special Assy	10446270	165	473
Down Sprue Ø35 Assy	10216031	165	473
Down Sprue Ø35 special Assy	10453559	165	473
Down Sprue Ø40 specail Assy	10446285	191	473



Down Sprue for DISA MATCH 20/24



All parts in the Down Sprue can be replaced individually. Drawing with list of spare parts will be added to part when purchased.

Please contact your local DISA Representative and ask for the required part in the table.

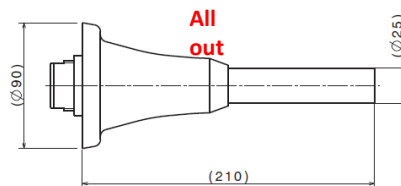
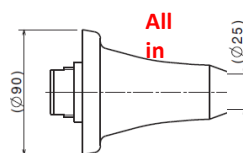
Please note

Diameter refers to the part in contact with the Pattern Plate.

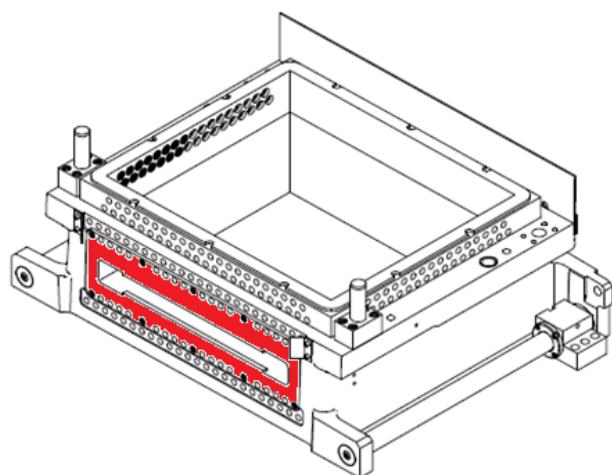
The Advantages of Down Sprues

- DISA quality standards and tolerances
- Hardened wear surfaces
- All individually parts are available as spare parts
- Several down sprue sizes
- Special design on request

Part Name	Part No.	All in mm	All out mm
Down Sprue Ø20 Assy	10463876	100	197
Down Sprue Ø25 Assy	10263602	100	197
Down Sprue Ø30 Assy	10406682	138	255
Down Sprue Ø20 Assy	10558250	105	210
Down Sprue Ø20 Assy	10558252	135	270
Down Sprue Ø25 Assy	10558253	105	210
Down Sprue Ø25 Assy	10558254	135	270
Down Sprue Ø30 Assy	10558255	125	229
Down Sprue Ø30 Assy	10558256	146	271
Down Sprue Ø35 Assy	10558257	125	229
Down Sprue Ø35 Assy	10558258	146	271



Sand Slot Units for DISA MATCH 130



Drag Sand slots specified for Pattern Plate thickness.

To ensure a perfect line up between drag chamber, sand slot and the sand hopper, 3 different drag sand slots are available in the parts catalogue.

We have made a 4th model to cover a wider pattern plate thickness ranging from 17-31 mm. This flexibility can for example be used to change Pattern thickness in new Patterns and still be able to run the old patterns.

All units are made of hardened Impax steel.

Please contact your local DISA Representative and ask for the required part in the table.

Part Name	Part No.	Thickness Pattern Plate	Qty
Sand Slot Unit 1 Drag Chamber	2640Z2080	12-26 mm	1
Sand Slot Unit 2 Drag Chamber	2640Z2060	27-40 mm	1
Sand Slot Unit 3 Drag Chamber	2640Z2040	24-34 mm	1
Sand Slot Unit 4 Drag Chamber	2640Z2270	17-31 mm	1
Screw M8X25	9103D0425		10

Lift-off Devices for Pattern Plate



Part Name	Part No.
Rubber Ball Ø5	9107T0100
Rubber Ball Ø6	9107T0101
Rubber Ball Ø7	9107T0102
Rubber Ball Ø8	9107T0103
Rubber Ball Ø10	9107T0104
Rubber Ball Ø12	9107T0105
Rubber Ball Ø14	9107T0106
Rubber Ball Ø15	9107T0107
Rubber Ball Ø16	9107T0108
Rubber Ball Ø18	9107T0109
Rubber Ball Ø20	9107T0110
Rubber Ball Ø25	9107T0111
Rubber Ball Ø30	9107T0112

Shore A65

Part Name	Part No.
Silicone Ball Ø5	9107T0120
Silicone Ball Ø6	9107T0121
Silicone Ball Ø7	9107T0122
Silicone Ball Ø8	9107T0123
Silicone Ball Ø10	9107T0124
Silicone Ball Ø12	9107T0125
Silicone Ball Ø14	9107T0126
Silicone Ball Ø15	9107T0127
Silicone Ball Ø16	9107T0128
Silicone Ball Ø18	9107T0129
Silicone Ball Ø20	9107T0130
Silicone Ball Ø25	9107T0131
Silicone Ball Ø30	9107T0132

Shore A25

Bump-on for Pattern Plate

A rubber ball at the bottom of a deep concave pattern plate helps to push green sand moulds out during stripping by delivering back the energy accumulated inside during squeezing (fig. 2.23).

If an impression-less top of the green sand mould is required after mould assembly, a convex rubber lifter can be employed. Air holes must be provided under the lifter as shown in fig. 2.24.

The softness, surface area and thickness of the rubber ball or lifter depends on the pressure exercised to the part of a specific pattern during the squeezing operation. In turn, the pressure depends on the machine settings, depth, pattern and surface finish of the pattern.

Please contact your local DISA Representative and ask for the required part in the table.

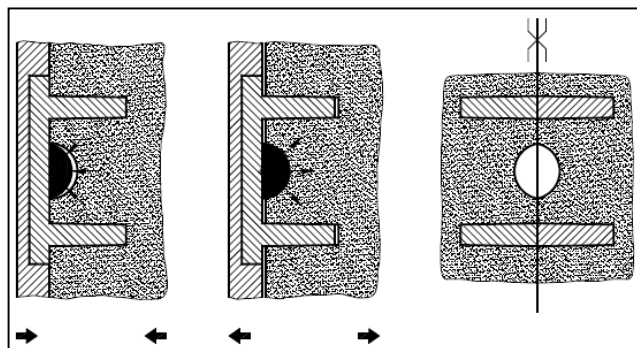


Figure 2.23

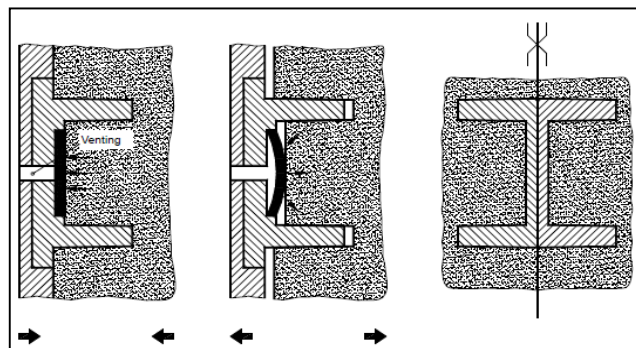
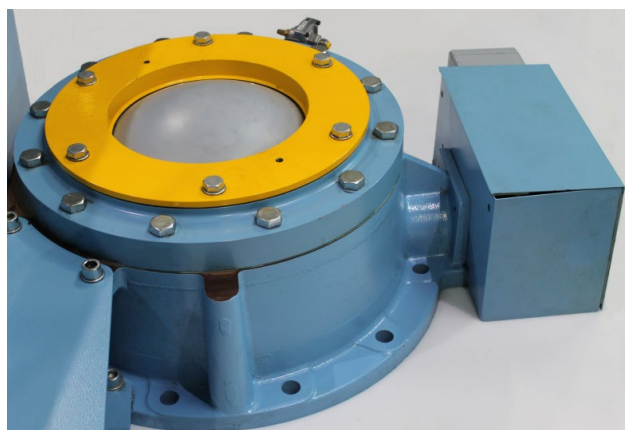


Figure 2.24

Dome Valve Repair Kit for DISAMATIC 2013 MK4 B, 2013 MK5 B and 2070 MK1 A



Reduce maintenance cost

Keeping your DISAMATIC in top operating condition is one of the keys to maintain your overall casting quality. The sand valve is a vital part of the moulding process and is subject to extreme wear.

DISA has specifically designed these repair kits based on many years of worldwide experience from our service engineers and our valued customers.

The kits are an easy-to-order kit, ensuring that you order all of the necessary components required to maintaining the dome valve, keeping the machine in shape at a lower maintenance cost.

The new hardened dome is more resistant to the wear from continuous contact with the Sand and the life time of the dome is extended.

As a result of the reduced wear on the dome itself, the dome seal will also last longer, and the machine will stay in shape at a lower maintenance cost.

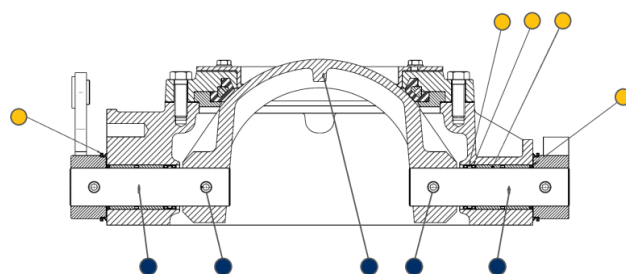
Please contact your local DISA Representative and ask for the required part in the table.

Repair Kit ●

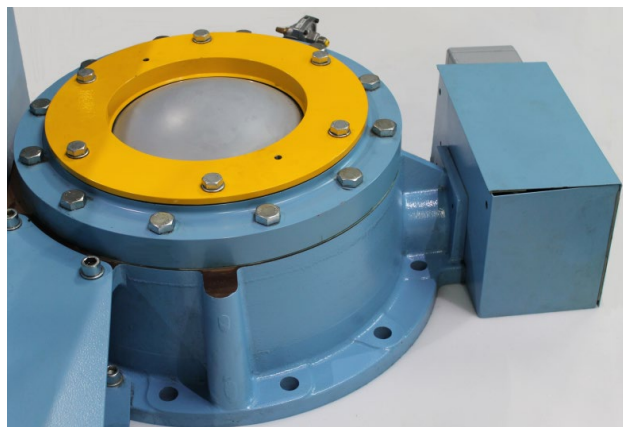
Machine Type	Part No.
DISAMATIC 2013 MK4 B, 2013 MK5 B & 2070 MK1 A	2070R0071

Hardened Dome ●

Machine Type	Part No.
DISAMATIC 2013 B & 2070 A with dome ø300	2050A3370



Dome Valve Repair Kit for DISAMATIC 2013 MK4 A and 2013 MK5 A



Reduce maintenance cost

Keeping your DISAMATIC in top operating condition is one of the keys to your overall casting quality. The sand valve is a vital part of the moulding process and is subject to extreme wear.

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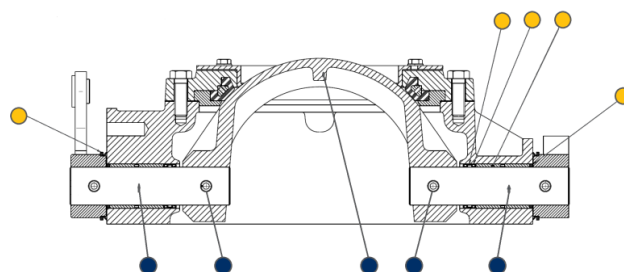
Please contact your local DISA Representative and ask for the required part in the table.

Repair Kit

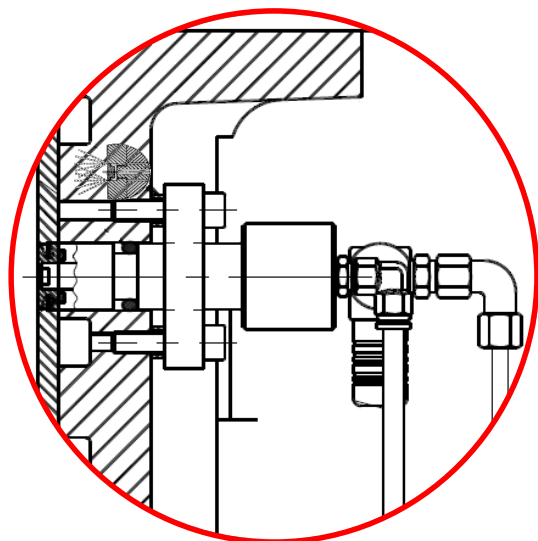
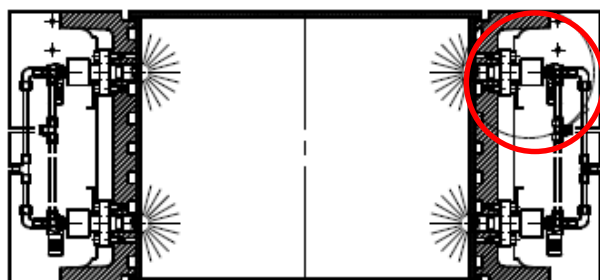
Machine Type	Part No.
DISAMATIC 2013 MK4 A & 2013 MK5 A	2040R1481

Hardened Dome

Machine Type	Part No.
DISAMATIC 2013 MK4 - 5 A with dome ø250	2050A3360



In-chamber Spray System with non-blocking Nozzle Design for DISAMATIC 2110 MK3



We have designed the latest version of our in-chamber parting spray systems as a retro-fit kit.

This kit is based on our patented and highly successful system, which is used on our New Generation machines.

A high demand from satisfied customers working with the 230 spray system, who want the same facility for their older machines, has promoted us to develop this new system.

The new in-chamber Spray System provides these Advantages

- Less maintenance on nozzles due to new design.
- Variable selection from 2 to 4 nozzles
- Reduces your spray fluid consumption
- Improves your working environment
- Adjustable spray frequency via the PLC (DISAMATIC 2110 MK3)
- Extends the lifetime of your chamber plates

Please note

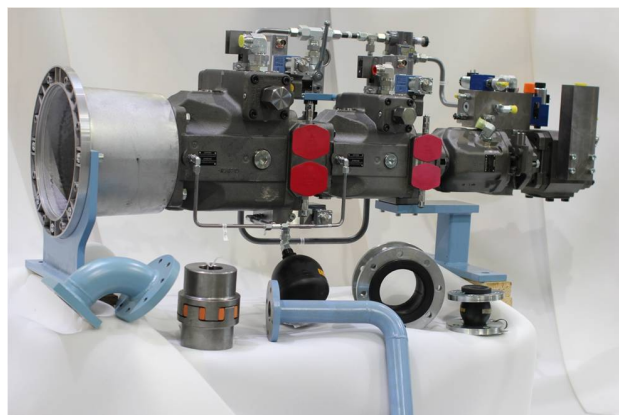
Chamber plates to match the nozzles are required, but not included in this kit.

Please contact your local DISA Representative and ask for item number **2110R1830**

Remember to state your machine type and serial number.

If the existing VDU is op25 or op27, an Upgrade is required.

Pump Kit: Vickers to Rexroth Upgrade for DISA 230



From the beginning of the DISA 230 era, DISA used two suppliers of the main pumps to ensure a high service level to customers. Over time the Rexroth pump has proven to be the better choice both from a quality and price perspective.

DISA has made this kit available to enable installation of the Rexroth pump in machines originally equipped with the Vickers pump.

Pump Replacement Kit

The pump comes preassembled with all necessary parts and software in order to install the Rexroth pump to your DISA 230.

Benefits of changing from Vickers to Rexroth:

- Longtime proven reliability compared to Vickers pump
- Better pump control as the feedback system is more precise on the Rexroth pump
- Reduced cost for Rexroth pump almost covers cost of installation
- High availability on Rexroth spare parts
- Quick installation, only 3 days production stop is necessary

Please contact your local DISA Representative and ask for item number **10649057**

Please note

We recommend that a skilled DISA service technician completes the installation and start up.

Upgrade your DISA 130 and 131 to 400 moulds



Increase the Capacity of your DISA 130/131 with approx. 15%

This upgrade will boost the output of your DISA 130/131 from 300 to 350 cored moulds/hrs.

The number of uncored moulds will increase from 350 to 400 moulds/hrs.*

Scope of Delivery

- Larger main pump
- New type of servo pump
- Upgrade kit for pumps
- Updated CSE with rotary cylinder and a more rigid design, increasing uptime and ensuring a higher casting quality**

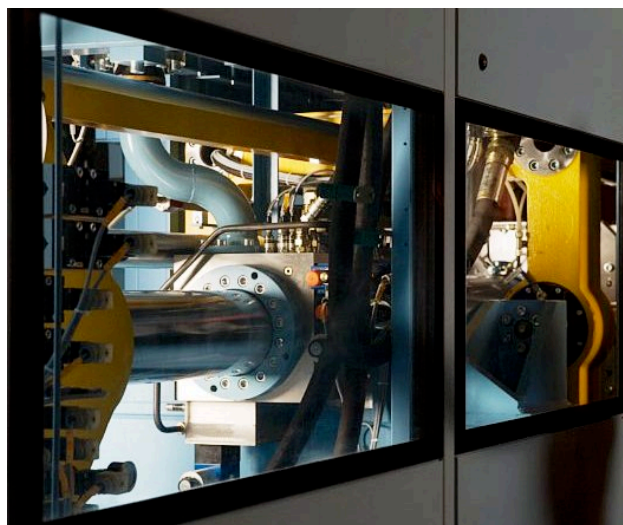
* Standard Mould size 200mm

** Only required with DISA 130 with machine serial No. 140028

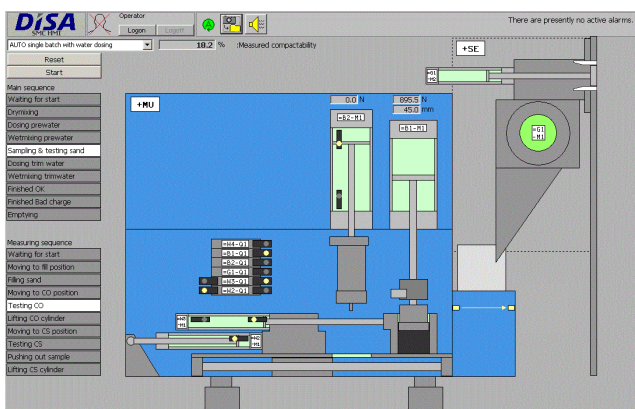
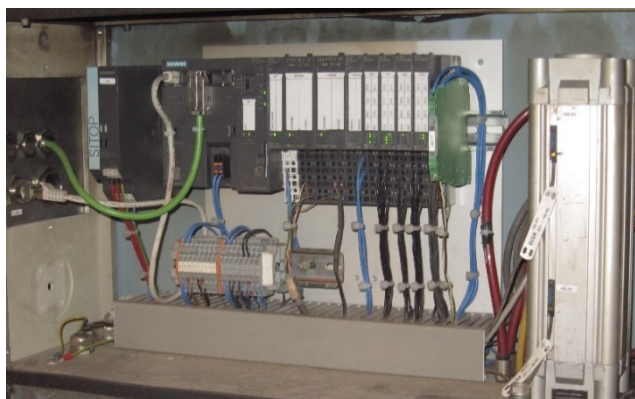
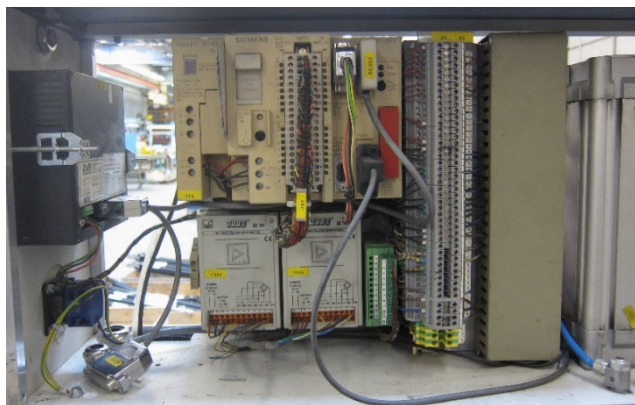
Benefits:

- Approx. 15% increased capacity
- Fast installation – only 1 week production stop
- 1 year warranty on replaced parts

Contact your local DISA Representative and ask for:
Upgrade Kit for DISA 130 – 131



PLC Upgrade Kit for SMC



Upgrade your SMC ver2.x – ver5.x and SMC Pro.

This PLC update and upgrade kit has been developed to bring older SMC's up to today's standards using Siemens PLC S7 and HMI, based on the latest version of Windows7. The kit will ensure availability of future spare parts for SMC's from 1994 to 2008, which are rapidly becoming obsolete and discontinued.

Why?

Your existing SMC system can be updated to today's standard without the need of buying a completely new, ensuring continued production and sand quality. The batch consistency is greatly increased, improving the overall sand quality.

Traceability of the batch data is increased, and is easily accessed from any network PC. The existing system has many obsolete components, which makes availability of spare parts difficult and costly.

The update kit is based on standardized components at cost effective prices, reducing trouble shooting and increasing speedy availability of spare parts.

Benefits

- The HMI system is upgraded to the latest version available
- Systems are aligned from DISA and Windows 3 to Windows 7
- Increased diagnostics ability.
- Complexity of system is reduced, simplifying trouble shooting
- Service functions simplified
- Calibration and adjustments easily implemented
- Obsolete parts are updated, ensuring continued service of your SMC device
- Lead time on spare parts is reduced considerably
- Existing documentation for mechanical functions can still be used

Please contact your local DISA Representative and ask for the **PLC Upgrade Kit for SMC**.

PMC Capping Strips for DISAMATIC 2032

Capping strips for the DISAMATIC 2032 PMC have been developed to allow a quick and individual change of strips.

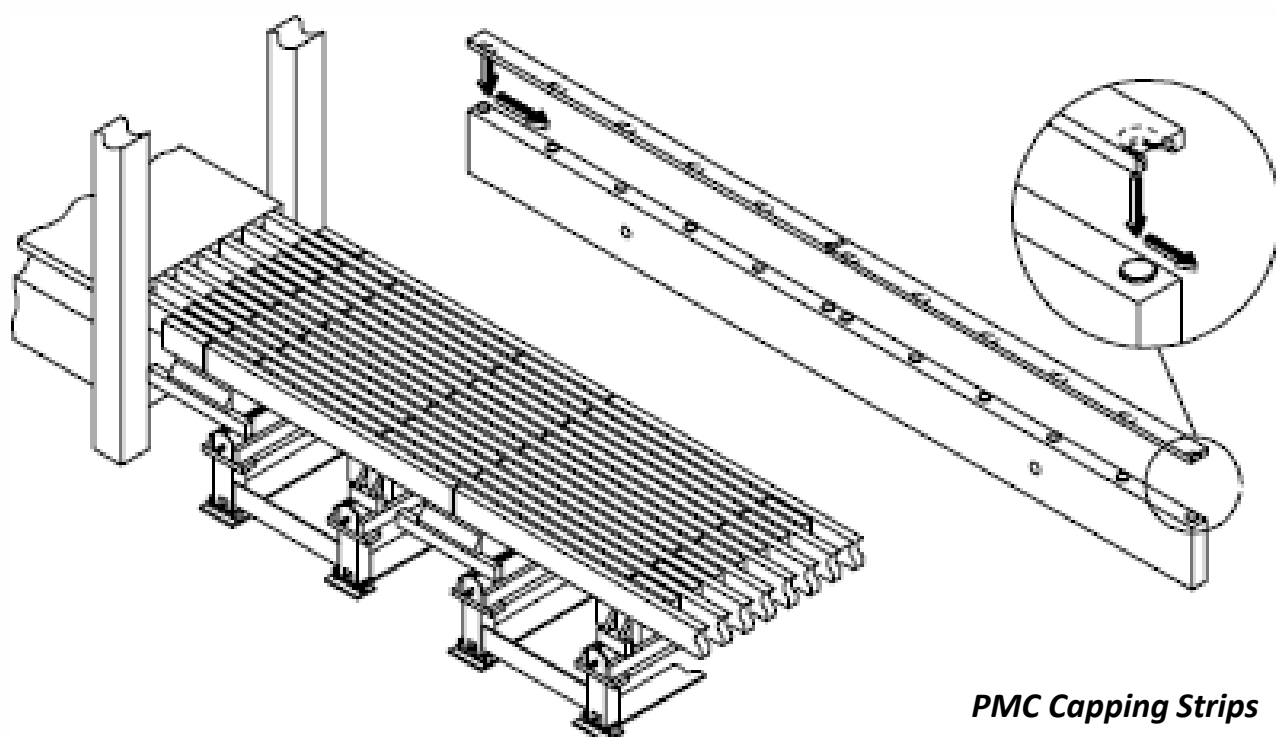
Use capping strips to protect the PMC sections, which are worn the most.

Capping Strips are available in several Materials:

- Standard
- Non-corrosive
- Hardened and non-corrosive

Advantages

- Service friendly
- Less sticking problems
- Quick changing of capping strips
- Available in several materials
- The capping strips may be changed and mounted individually



PMC Capping Strips

PMC Capping Strips for DISAMATIC 2120 and 2130

Capping strips for the DISAMATIC 2120 & 2130 PMC have been developed to allow quick and individual change of strips.

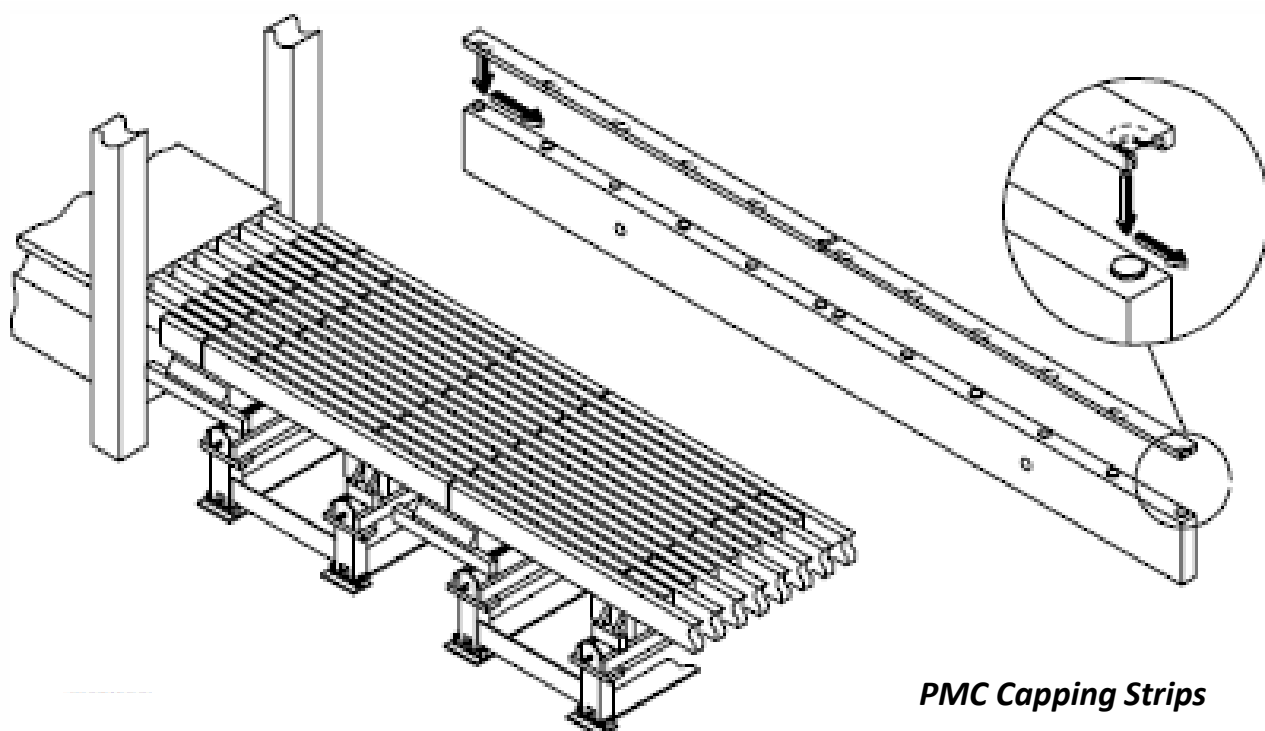
Use capping strips to protect the PMC sections which are worn the most.

Capping Strips are available in several materials

- Standard
- Non-corrosive
- Hardened and non-corrosive

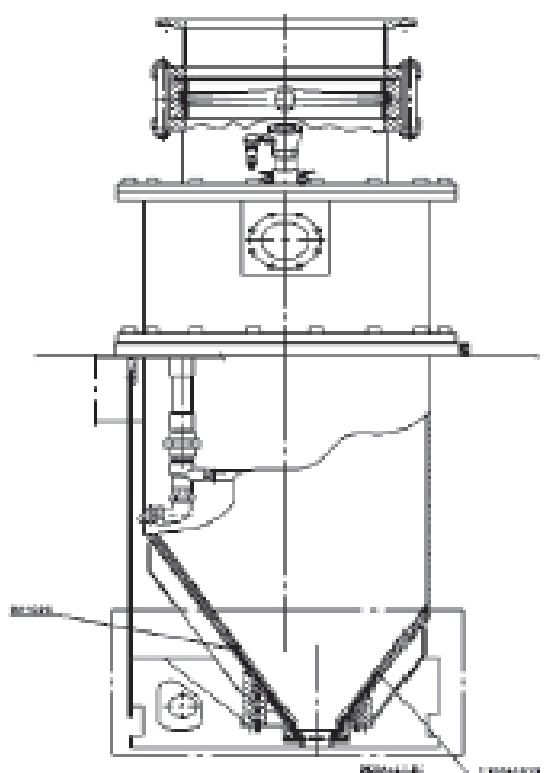
Advantages

- Service friendly.
- Less sticking problems.
- Quick changing of capping strips.
- Available in several materials.
- The capping strips may be changed and mounted individually.



PMC Capping Strips

Improved Sand Hopper for DISAMATIC 2120 and 2130



EXIST.

In order to improve the lifetime of the DISAMATIC 2120 & 2130 Sand hopper, DISA has developed a sand hopper with increased thickness of the bottom Plates.

Mounting access is from the top in order to facilitate easier replacement of the sand hopper.

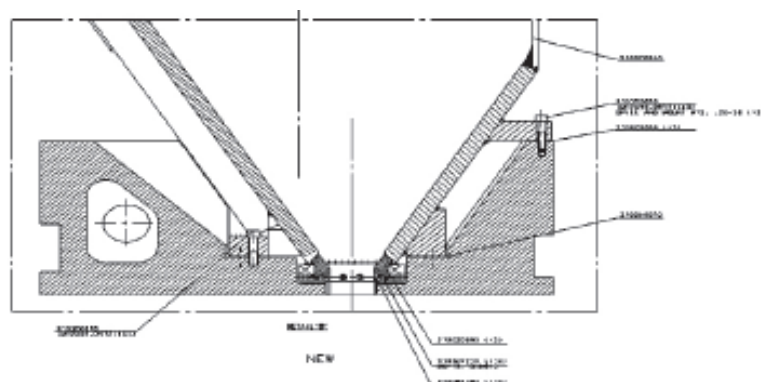
Advantages

- Longer lifetime
- Reduced service time
- Better sand flow

Please contact your local DISA Representative and ask for item number **2100R5450**

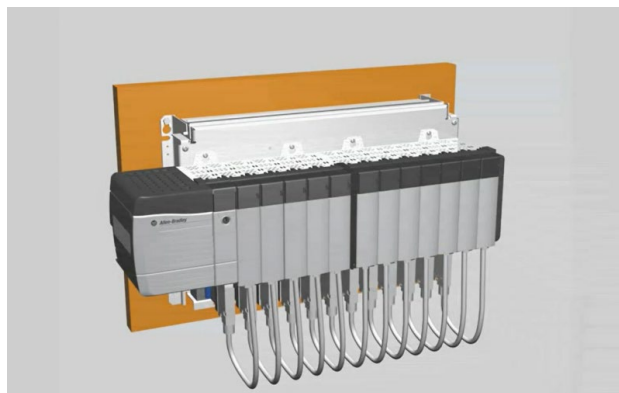
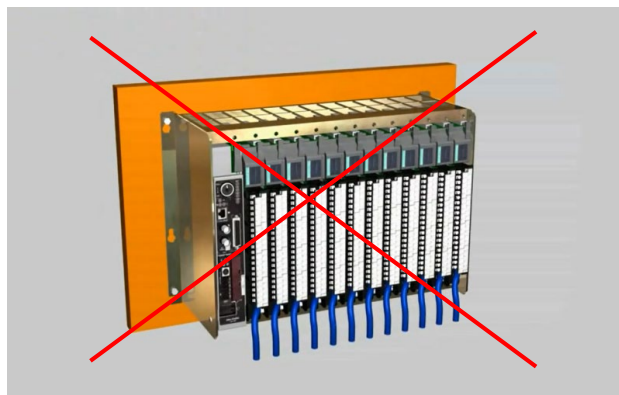
Please note

This design comes without Aeration Plates.



NEW

New PLC Control for DISAMATIC 2013 MK5



Extended Lifetime for DISAMATIC 2013 MK5

DISA has developed a kit to replace the obsolete PLC of the DISAMATIC MK5 with a state of the art PLC control system.

Easy Installation

Installation can be completed during a normal weekend. The existing plug connectors and wiring will be reused preventing any connection error.

Software converted by one of our experienced DISA Programmers

The software is converted by our experienced programmers ensuring that the machine will work just as well as with the original program.

Parts Availability

Parts are available with short notice and will be available for many years to come.

Remote Support

The kit is delivered with VPN router providing safe communication for possible remote support.

Data Highway replaced by Ethernet

Old data highway may be replaced by modern Ethernet for communication with CIM.

Optional Add-on

Light curtain kit and forced mode.

The new software includes all standard configurations. Any specific customized solutions are subject to extra costs.

The pattern plate code reader is not supported by this upgrade. The upgrade requires a PC-based VDU. Machines with T30, Versa view must upgrade the VDU.

If existing CIM is an older version, an upgrade may be required.

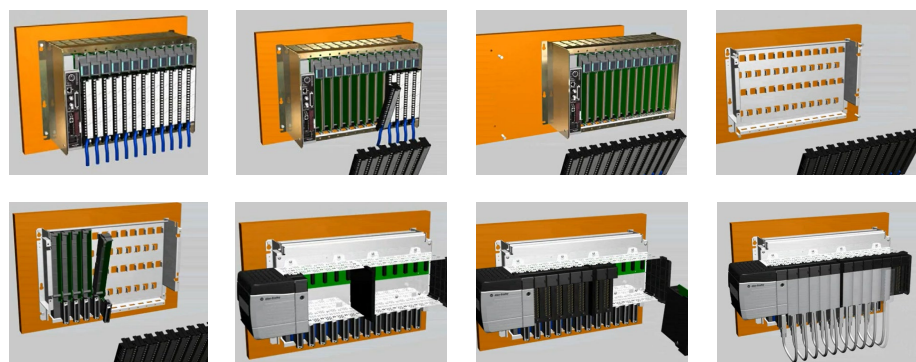
The kit price does not include the cost of installation by our DISA service technician (3 working days, travel and hotel expenses).

Please note

The price does not include installation. Expect 1 day machine stop.



Copy/paste text to YouTube: PLC-5 replacement by Rockwell Automation Korea



Spare Parts for the old PLC will not be available for long.

Please contact your local DISA Representative and ask for item number **10760216**

PLC Upgrade for DISAMATIC 2110 MK3 and LP



Update your DISAMATIC 2110 to the latest Standards to obtain several Advantages

Increased Capacity

For MK2 & 3 it is possible to increase capacity with up to 15 uncured moulds per hour.

Upgrade to a Higher Safety Level

In the new PLC, doors and guards are integrated in the safety supervision.

Easy Maintenance & Troubleshooting

For MK1 & 2, troubleshooting can not be supported due to the relay solution. Upgrade to the PLC solution enables troubleshooting and provides easier daily maintenance.

New Operator Interface / VDU

Upgraded operator interface with information on VDU and possibility of integrating RMS and CIM.

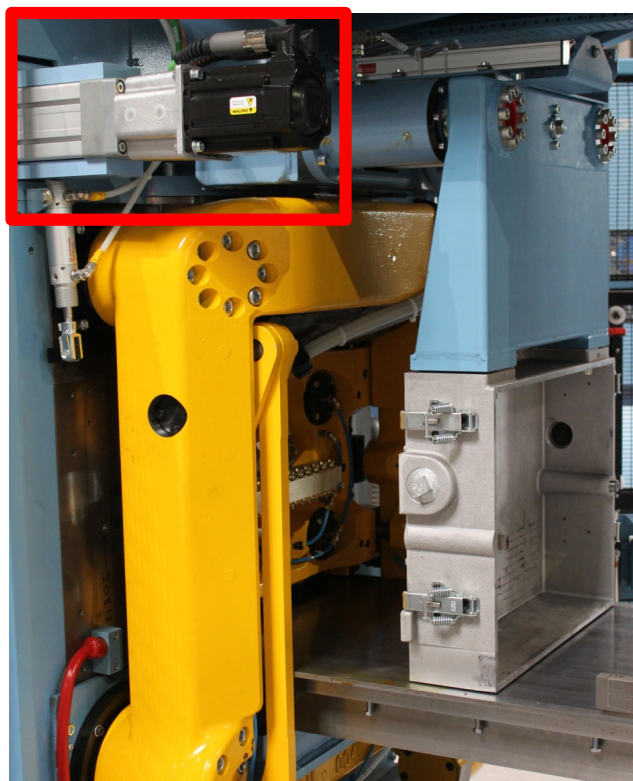
Speed Control of CSE

Upgrading the CSE from pneumatic to electrical makes it possible to adjust the speed and precision of the CSE.

Please contact your local DISA Representative and ask for the **PLC upgrade for DISAMATIC 2110 MK1 – 3 & LP**

Please note

Spare parts for the current MK3 PLC are obsolete.



Content of Kit

- Complete Control Cabinet
- New Electrical CSE
- New 24V Relay
- New VDU
- New Software
- New Operator Interface System
- New Safety System
- New Pneumatic System



Melt Overflow Covers for DISAMATIC 2013 MK3, MK4, MK5, LP, DISA 130, 131, 230 and 231



The simple and efficient way to stop melt overflow

Melt overflow, over-pours and leakages cover your mould conveyers and thrust bars in iron. They cause mould gaps and mismatches. They make your foundry filthy. Now there's an easy way to stop them.

DISA's new Melt Overflow Cover (MOC) bolts straight onto the sides of your moulding conveyor. The MOC barrier keeps any molten metal where it belongs – safely on top of the mould.

No spills means no more iron-coated thrust bars – and scrap they cause. No damaged equipment. No more stopping to clean up the mess.

Facts

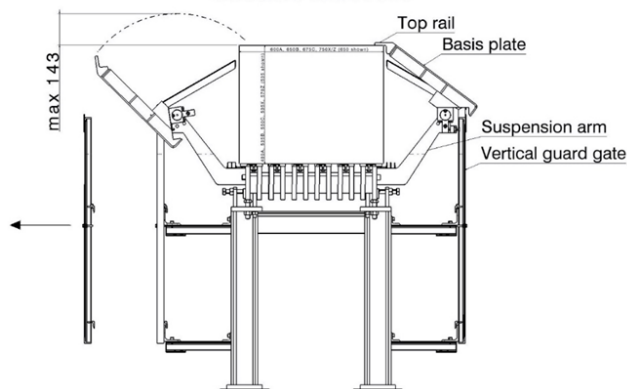
- Protects the AMC and moving parts from metal overflow.
- Increases uptime by minimizing unforeseen stops to clean the AMC.
- Quick installation
- 2 meter and 4 meter versions are available

Advantages

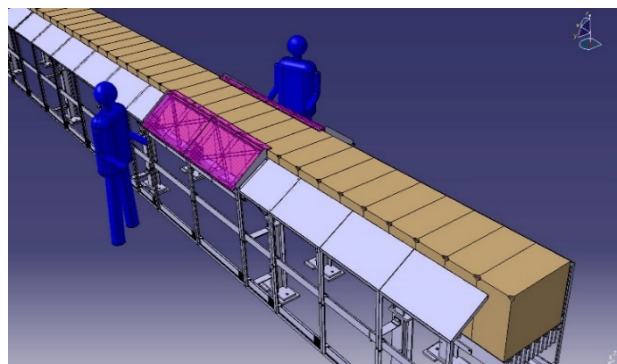
- A clean conveyor for less maintenance
- Improved casting quality
- A safer working environment

Please contact your local DISA Representative and ask for:

Section view A-A



Item Number	Item Name
11315167	MOC KIT 2013MkX/231, 2 m , Assy
11295177	MOC KIT 2013MkX/231, 4 m , Assy



Special Offer for Pattern Plates for DISAMATIC 2110



DISA provides a one time offer of the remaining inventory of the specific Pattern Plate item number 2110A0511 compatible with the following machines:

- DISAMATIC 2110 (ex. machines in Japan)
- DISAMATIC D1 without QPC

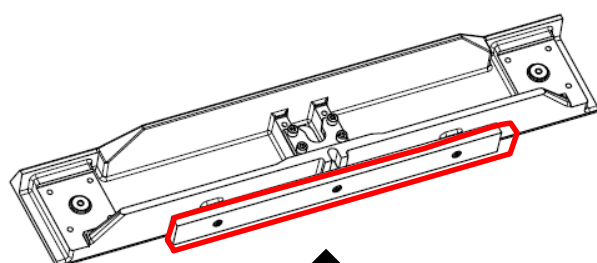
The remaining 96 pcs of pattern plates are available at a special price:

- 24 pcs of 7,750 EUR
- 48 pcs of 13,500 EUR

This special offer is only valid until the 100 pcs have been sold.

Please contact your local DISA Representative and ask for the required part, specifying your machine type.

Upgrade with new, larger and improved Thrust Bars for DISAMATIC 2013 MK3, MK4, MK5 and DISA 230



Replaceable Wear Part



Improve the Mould Line Transportation by increasing the Thrust Bar with the latest technology.

When DISA introduced the DISA 130 & 231 moulding machine, larger and improved thrust bars were introduced.

- The size of the new thrust bar is increased by 19% compared to the previous version of the DISA 230 thrust bar
- The drive rail can be replaced when worn out, instead of replacing the complete thrust bar thus reducing the maintenance cost
- The position of the thrust bar is lifted with approx. 25 mm, improving support of the critical area of the mould
- The cylinder is replaced with a bigger type, affecting the thrust force to increase using the same operational air pressure
- All thrust bars with liners are prepared for heating elements
- Easy adjustment of thrust bar pressure

It has been proven that the larger cylinder and a larger thrust bar increases the grip friction on the mould string, resulting in a more precise and stable acceleration, transportation and deceleration of the mould line.

For machines running full speed or with a big chamber size, the benefits of using DISA 231 thrust bars will increase significantly compared to the original DISA 230 thrust bars.

The Advantages increase with the Mould Size

- Increase stability of the mould string
- Reduce the risk of gaps between moulds during transportation
- Reduce maintenance cost
- Reduce the risk of thrust bar sliding on the mould surface

Variations of Upgrades

All existing solutions for DISA 230 are available in this new kit.

- Solid thrust bars
- Plain steel liners (with or without heating)
- Stainless liners (with or without heating)

Requirements

The new thrust bar kit can be installed on DISAMATIC 2013 MK3-5 and DISA 230 if the AMC is with a hydraulic unit.

For machines with Mould Side Support (MSS), DISA will need to check the specific machine configuration to approve if the kit can be installed.

Please contact your local DISA office to require a quotation.

CIM Modules & Spare CIM Cell Controller

Part Name	Part No.
CIM Upgrade - Windows 7	2900A0000
Spare CIM Cell Controller for DH+ Network	11009328
Spare CIM Cell Controller for Ethernet Network	11009331
Spare CIM Cell Controller AB Ethernet	11019051
Spare CIM Cell Controller Siemens & AB ethernet	11307017
CIM Update of Costumer PC	11250465
CIM-1.0 16 bit - Basic Module 16-bit	2901A0010
CIM-1.0 32 bit - Basic Module 32-bit	2901A0011
CIM-1.1 - Additional DMS Connection	2901A0020
CIM-1.2 - Cell Controller PC for CIM	2901A0030
CIM-2.1 - Process Control for Universal Pouring Unit	2902A0010
CIM-2.3A - Process Control for Koins or Pourtech	2902A0030
CIM-2.3B - Process Control for Fujiwa	2902A0120
CIM-2.5 - Process Control: Shuttle	2902A0050
CIM-2.11 - Process Control: WDP Interface	2902A0110
CIM-3.0 - Mould & Casting Database	2903A0010
CIM-4.0 - Management Module	2904A0010
CIM-5.0 - Preventive Maintenance Module	2905A0010
CIM-6.0 - Remote Operator Information	2906A0010
CIM-7.0 - LAN Communication Module for 4 pc	2907A0010
CIM-7.1 - LAN extend to 10 pc	2907A0020
CIM-8.0 - External Pattern Plate Database	2908A0010
CIM-8.0wF5 – Storing of F5 Settings with F3 parameters	2908A0050
CIM-8.3 – Parameter Protection Levels (PPL)	2908A0040

The DISA CIM Concept

A PC, here called a “Cell Controller”, is the heart of the CIM concept.

It collects, stores and distributes information between:

- The PLC of the DISA Moulding System
- Other Process Equipment, for example Pouring Unit and Cooling Drum
- The Foundry Computer System

Advantages of the CIM:

Management Module:

To evaluate and improve the productivity of equipment, up-to-date information about the production must be available. With the up-time report you can locate bottlenecks in the moulding system.

The system can detect delays less than 0,1 sec. and saving 0,5 sec. per cycle saves between 3-5%.

Preventive Maintenance Module

To achieve optimum production, preventive maintenance jobs must be scheduled. Based on the actual number of moulds produced or time, the module can schedule maintenance jobs such as:

- Cleaning
- Checking
- Lubricating
- Replacing wear parts

Process Control

- Store pouring parameters
- Often cut off 5% or more of cycle time

Mould and Casting Database Module

This module stores parameters and production conditions in the database for every mould produced

- Pattern Plate number used
- Compressibility
- Mould poured (yes/no)
- Time when poured
- Actual machine setup

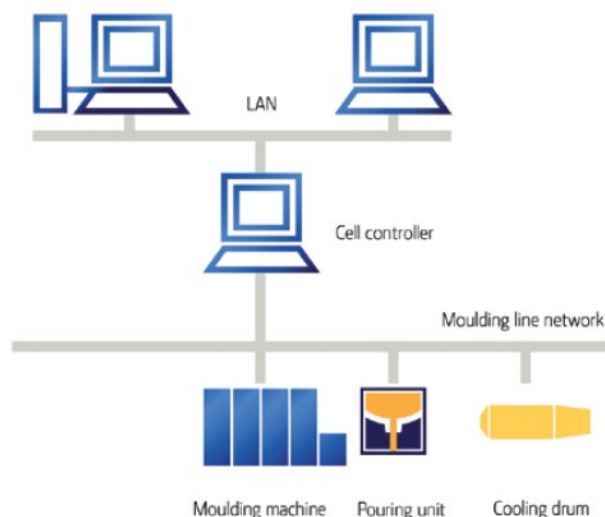
Spare CIM Cell Controller

The PC comes with the necessary network cards and is loaded with the customer specific CIM modules as well as database and communication software.

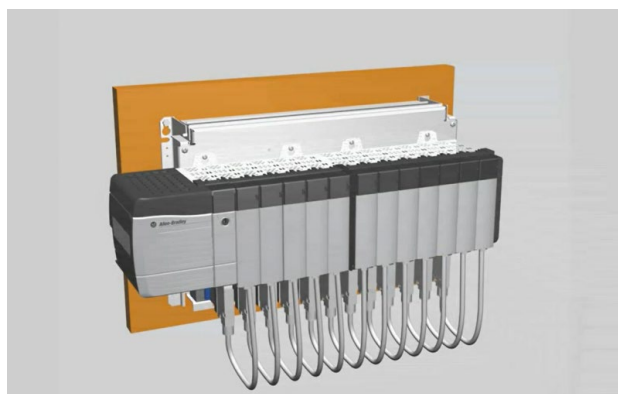
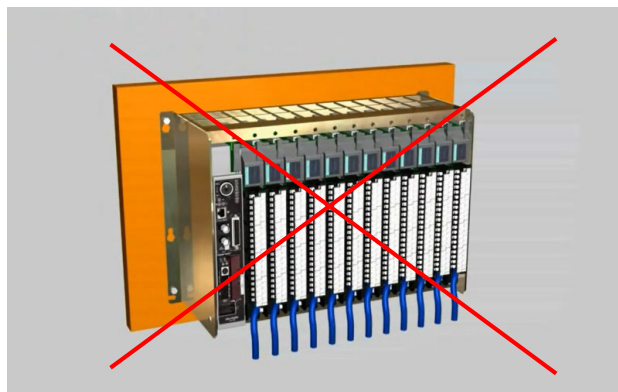
Please contact your local DISA Representative and ask for the required part as indicated in the table.

Please note

Before a quotation can be placed, we need your order variable form.



New PLC Control System for DISA 230



Extended Lifetime of DISA 230

DISA has developed a kit to replace the obsolete PLC of the DISA 230 with a State of the Art PLC control system.

Easy Installation

Installation can be completed over the weekend. The existing plug connectors and wiring will be reused preventing any connection error.

Software converted by one of our experienced DISA Programmers

The software is converted by our experienced programmers, ensuring that the machine will work just as well as with the original program.

Parts Availability

Parts are available with short notice and will be available for many years to come.

Remote Support

The kit is delivered with a VPN router providing safe communication for possible remote support.

Data highway replaced by Ethernet

The old data highway may be replaced by modern Ethernet for communication with CIM.

Optional Add-on

The new software will include all standard configurations. Any specific customized solutions are subject to extra cost.

The pattern plate code reader is not supported by this upgrade.

The kit price does not include the cost of installation by DISA service technician (3 working days, travel and hotel expenses).

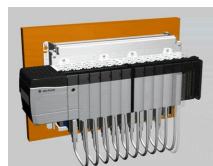
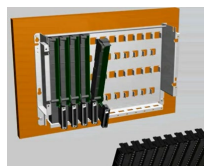
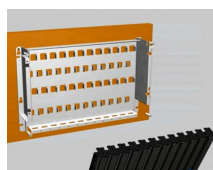
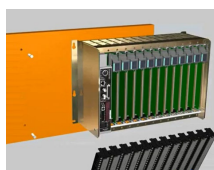
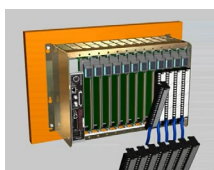
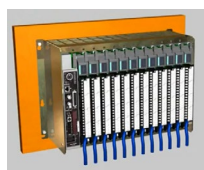
Contact your local DISA Representative and ask for item number **11050067**

Please note

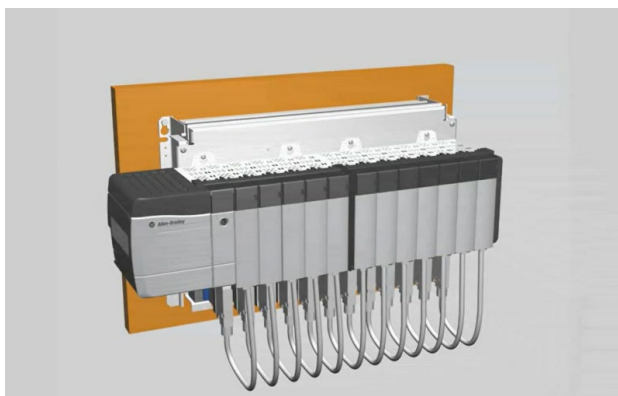
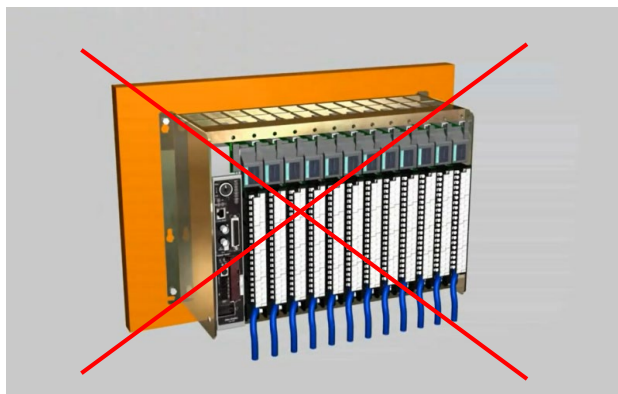
The price does not include installation.

Expect a total of 1 day machine stop and 2-3 days service.

YouTube : PLC-5 replacement by Rockwell Automation Korea



New PLC Control System for DISA 240, 250, 270 and 280



Extended Lifetime of DISA 240, 250, 270 and 280

DISA has developed a kit to replace the obsolete PLC with a State of the Art PLC control system.

Easy Installation

Installation can be completed over the weekend. The existing plug connectors and wiring will be reused preventing any connection error.

Software converted by one of our experienced DISA Programmers

The software is converted by our experienced programmers, ensuring that the machine will work just as well as with the original program.

Parts Availability

Parts are available with short notice and will be available for many years to come.

DISA 270 SN 180001-180004

DISA 280 SN 190001-190003

Remote Support

The kit is delivered with a VPN router providing safe communication for possible remote support.

Ready for ethernet

After installation of ControlLogix kit it will be possible to change PLC/CIM communication to Ethernet. It requires that CIM can run ethernet and has RSLinx version 3.0 or newer.

If replacing the VDU it will also be possible to use ethernet for communication to the VDU.

Optional Add-on

The new software will include all standard configurations. Any specific customized solutions are subject to extra cost.

Scope

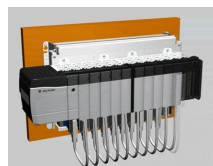
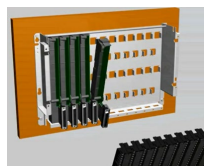
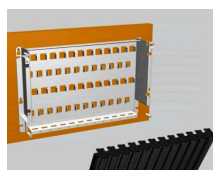
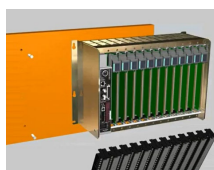
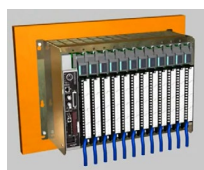
2 racks of PLC components
VPN router
Ethernet switch
Cables
Linear transducer (PPC)
Kit description

The pattern plate code reader is not supported by this upgrade.

Please note

The price does not include installation. Expect a total of 2 days machine stop and 5 days service.

YouTube : PLC-5 replacement by Rockwell Automation Korea



The kit is available for Serial Numbers:

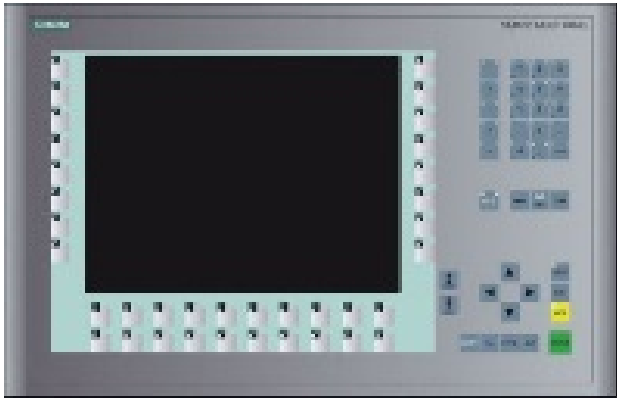
DISA 240: 170001-170005,
170008-170014

DISA 250: 160001-160007,
160010

DISA 270: 180004

DISA 280: 190001

VDU Solutions for DISA 240, 250, 270 and 280 with Allen Bradley PLC Control



The VDUs used until now on the DISA 240/250/270/280 is no longer available. DISA has introduced a new version based on the Siemens PC 477.

The PC 477 uses the a separate gateway Ethernet IP to Allen Bradley DH+ for the communication with the PLC control system.

Valid for these machines

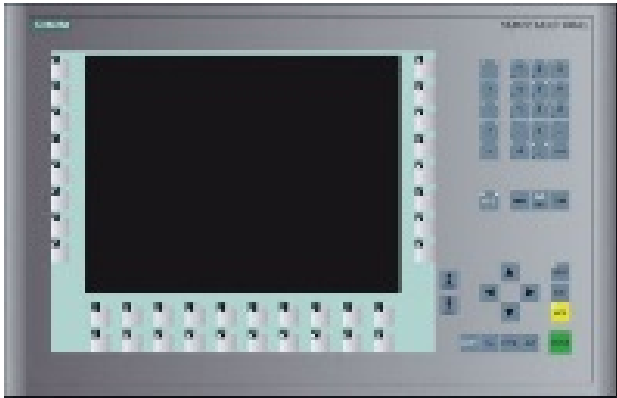
- DISA 240 SN 170001-170010, 170012-170014
- DISA 250 SN: 160001-160010
- DISA 270 SN 180001-180004
- DISA 280 SN 190001-190003



Replacement Kits	Part No.
Replacement Kit for Siemens VDU	11004420
Replacement Kit for XYCOM VDU	11004598

Spare Parts for the new Solution	Part No.
Spare VDU installed with specific Program	11003671
Network Adaptor configured	10983949

VDU Solutions for DISAMATIC 2013 MK5



New VDU replaces all previous versions

The VDUs used until now on the 2013MK5 is no longer available. DISA has introduced a new version based on the Siemens PC 477.

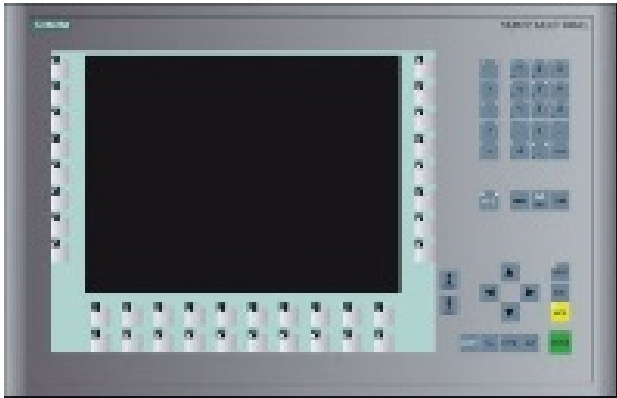
The PC 477 uses the a separate gateway Ethernet IP to Allen Bradley DH+ for the communication with the PLC control system.

Future replacement VDUs will be cheaper since the network adaptor is no longer a part of it.

Replacement Kits	Part No.
Replacement Kit for Siemens VDU	11007508
Replacement Kit for XYCOM VDU	11004595
Replacement Kit for T30 and Versaview	11014540

Spare Parts for the new Solution	Part No.
Spare VDU installed with specific Program	11007513
Network Adaptor configured	11004194

VDU Solutions for DISA 230



New VDU replaces all previous Versions

The VDUs used until now on the DISA 230 is no longer available. DISA has introduced a new version based on the Siemens PC 477.

The PC 477 uses the a separate gateway Ethernet IP to Allen Bradley DH+ for the communication with the PLC control system.

Future replacement VDUs will be cheaper since the network adaptor is no longer a part of it.

Replacement Kits	Part No.
Replacement Kit for Siemens VDU	10979346
Replacement Kit for XYCOM VDU	2440R2200

Spare Parts for the new Solution	Part No.
Spare VDU installed with specific Program	11003671
Network Adaptor configured	10983949

Complete Plant Solutions – Spare Parts

Part Type

Project Name

Project Number

Equipment Type

Equipment Number

DISA Part Number

Drawing Number

Description of Component

Photos

DISA has through many years been a supplier of complete foundry

solutions and sand plants.

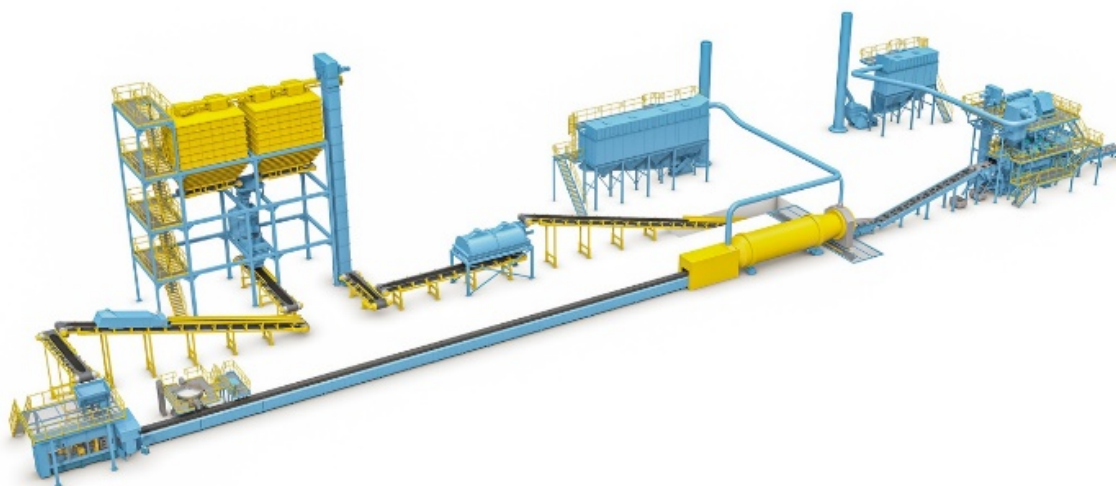
DISA can supply spare parts to all DISA equipment and projects.

DISA provides fast and accurate delivery of spare parts and services to our customer.

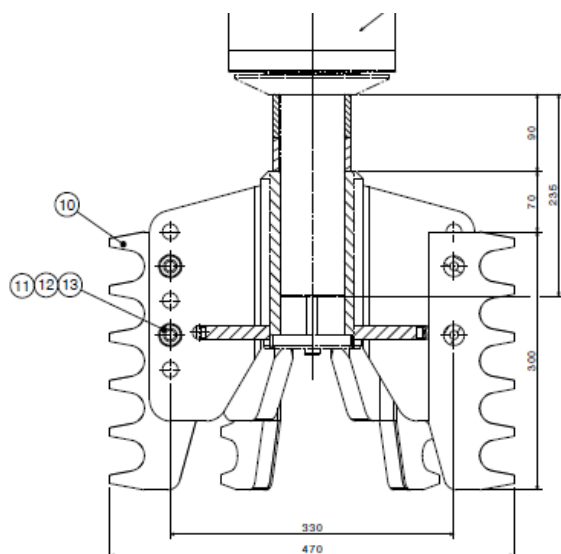
Advantages:

- Only one supplier/one stop shopping
- One year warranty on all spare parts
- Technical assistance from DISA specialists
- Original manufacturer parts

When ordering spare parts please state the information mentioned in the table.



Impeller blade kit for TM-190



What are your challenges?

DISA introduces specially coated impeller blades to obtain longer lifetime of the wear parts.

The picture below shows the blades state after 500 hours of operation and does not show any sign of wear. The specific blades have been in operation more than 1,200 hours and are still in good condition.

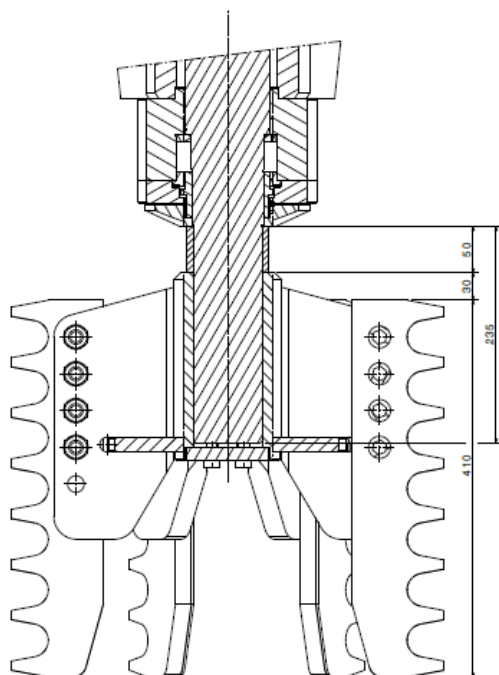
For TM 190 select 1 kit of item number 11391825, which contains 6 impeller blades and the necessary fasteners for installation.

Be aware that it is necessary to replace all 6 blades due to weight differences.



Position	Item number	Item name	Quantity	Unit
10	11390408	Impeller blade	6	pcs.
11	10000961	Screw M16x70/44-12.9 ENISO4762	12	pcs.
12	10099899	Nut M16-10 ZN ISO4032	12	pcs.
13	10023626	Washer 16-FSt ZN DIN127B	12	pcs.

Impeller blade kit for TM-240 and TM-285



What are your challenges?

DISA introduces specially coated impeller blades to obtain longer lifetime of the wear parts.

The picture below shows the blades state after 500 hours of operation and does not show any sign of wear. The specific blades have been in operation more than 1,200 hours and are still in good condition.

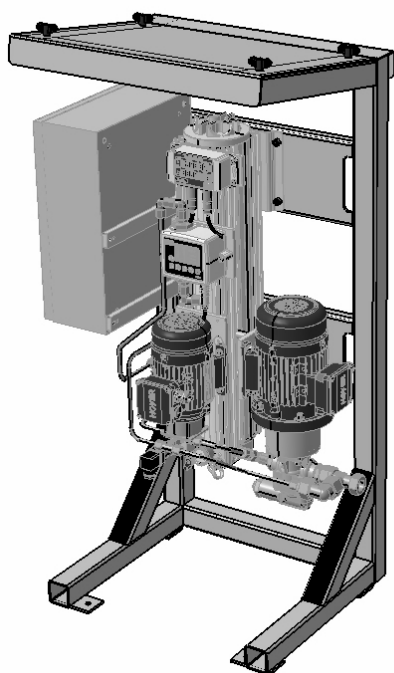
Each kit includes 6 impeller blades and the necessary fasteners for installation. Be aware that it is necessary to replace all 6 blades due to weight differences.

For TM-240/90 select 1 piece 11393355
For TM-240/110 select 2 pieces 11393355
For TM-285/160 select 2 pieces 11393355
For TM-285/200 select 2 pieces 11393355



Position	Item number	Item name	Quantity	Unit
10	11275939	Impeller blade	6	pcs.
11	10000961	Screw M16x70/44-12.9 ENISO4762	24	pcs.
12	10099899	Nut M16-10 ZN ISO4032	24	pcs.
13	10023626	Washer 16-FSt ZN DIN127B	24	pcs.

Optimal Oil Filtration (OOF) for DISA 130, 131, 230, 231, 240, 250, 270 and 280



What are your challenges?

- Uptime
- Quality
- Sustainability
- Competition
- Working Environment

Solution

The OOF goes beyond removing particles from oil. It provides a constant, real-time overview of the status, quality and purity of the oil currently used to run your foundry equipment

A major source of declining oil performance is contamination with water.

Water in oil is an almost invisible contaminant with highly damaging effects on system efficiency.

- The OOF connects directly to the pre-made connections in the hydraulic system
- The OOF needs external electrical power
- The OOF must be positioned 6 m from the Moulding Machine or DMM.

Advantages

The OOF allows foundry operators to sleep well at night, because it ensures optimal performance of your equipment at all times.

- The OOF is designed to provide real-time information on the condition of the oil in the hydraulic system
- Reduced equipment maintenance
- Reduced downtime due to equipment failure
- Extended component life
- Reduced oil changing cost
- Reduced oil testing cost
- Reduced environmental impact

Please contact your local DISA representative to learn more about the specific solution suitable for your DISA Moulding Line.

Part Type	Part No.
Kit OOF DISA 130/131	11267731
Kit OOF DISA 230/231	11265226
Kit OOF DISA 240/250	11142238
Kit OOF DISA 270	11145305
Kit OOF DISA 280	11146554

