Greater Flexibility for higher Quality.
The newly developed Bühler Multistep Casting Technology now offers even more flexibility for the filling process. Six freely programmable velocity steps make it possible to adjust the casting profile to meet the requirements of each part. The casting profile can now be programmed in absolute units thanks to Multistep. This makes it even easier to handle the die-casting machine and makes the casting process more transparent.

The expanded capability of the Ecoline machine also includes the “filling test” and “Startup Program”. Now users with “filling test” can interrupt the filling profile to verify the filling pattern of the part. The “Startup Program” automatically adjusts the shot profile to minimize damage to the die during warm-up. Multistep technology is now available on the Ecoline series of die casting machines.

Ecoline Shot Unit.
Multistep Technology for more flexibility.
Casting profile with:
- 6 setting points for low speed with min. speed 0.02 m/s.
- 1 setting point for high speed with max. speed of 8.5 m/s.
- 1 break point with setting of speed/stroke and process-optimized deceleration ramp.
- 2 pressure points for intensification.
  Production start-set up.
For a optimum filling at high speeds and intense injection forces.
Ecoline Multistep.

Comparison:

3-Phase Technology.
Hand and Remote Control.

- Settings for 1st and 2nd phase in %
- Break point in %
- Intensification pressure in bar

Multistep Technology.

- Setting points for low speed (1–5)
- Setting point for high speed (vI2)
- Break point (sIbr/vIbr)
- Pressure points for intensification pIM3 acc/pIM3

Ecoline Multistep for:
- Optimal part filling
- Better part quality
- Higher productivity
- Stable production