

# Short Instruction for Using Casting Unit **LUKACAST M**



Valued Customer,  
**After setting-up LUKACast M according to our instruction manual, you should make a final countercheck before you start casting:**

## Please check once more connection:



- |                           |   |
|---------------------------|---|
| <b>Electrical Supply:</b> | Voltage supply according to label on machine ?<br>Plugged-in?               |
| <b>Cooling water:</b>     | Water tap is connected to <b>Water In</b> ?<br>Water tap open?              |
| <b>Vacuum:</b>            | Vacuum pump installed, plugged-in and switched on?                          |
| <b>Protective Gas:</b>    | Valve on bottle opened<br>Pressure regulator gauge on bottles shows 6 bars? |

All is OK?

## Insertion of crucible



- Quartz wool in quartz crucible shield?
- Crucible has no damages or cracks?

## **Insertion of thermocouple**

- Thermocouple's protection tube is mantled?
- For crucibles with graphite inlet: Tip of thermocouple touches graphite?
- If no thermocouple is used: do not forget to connect DUMMY-plug

## **Insertion of flask adapter**

- Adapter's size is suitable for diameter of your flasks?
- Inserted on right length = only small gap between flask and crucible's spout?

## **Test running (without metal and without hot flask)**

To ensure that machine is running well, please check system by a test running .

- Insert crucible with graphite inlet.
- Start the program 19 as a test run
- Complete casting process simulation

## **Ready! Now you can start casting metal!**

**Caution:** After starting first casting of the session, LUKACast **M** makes a self-test. Routine is checking vacuum and insert gas pressure. If vacuum is missing or system is leaking, error message E081 appears, if inert gas pressure is missing or too low, error message E083 appears.