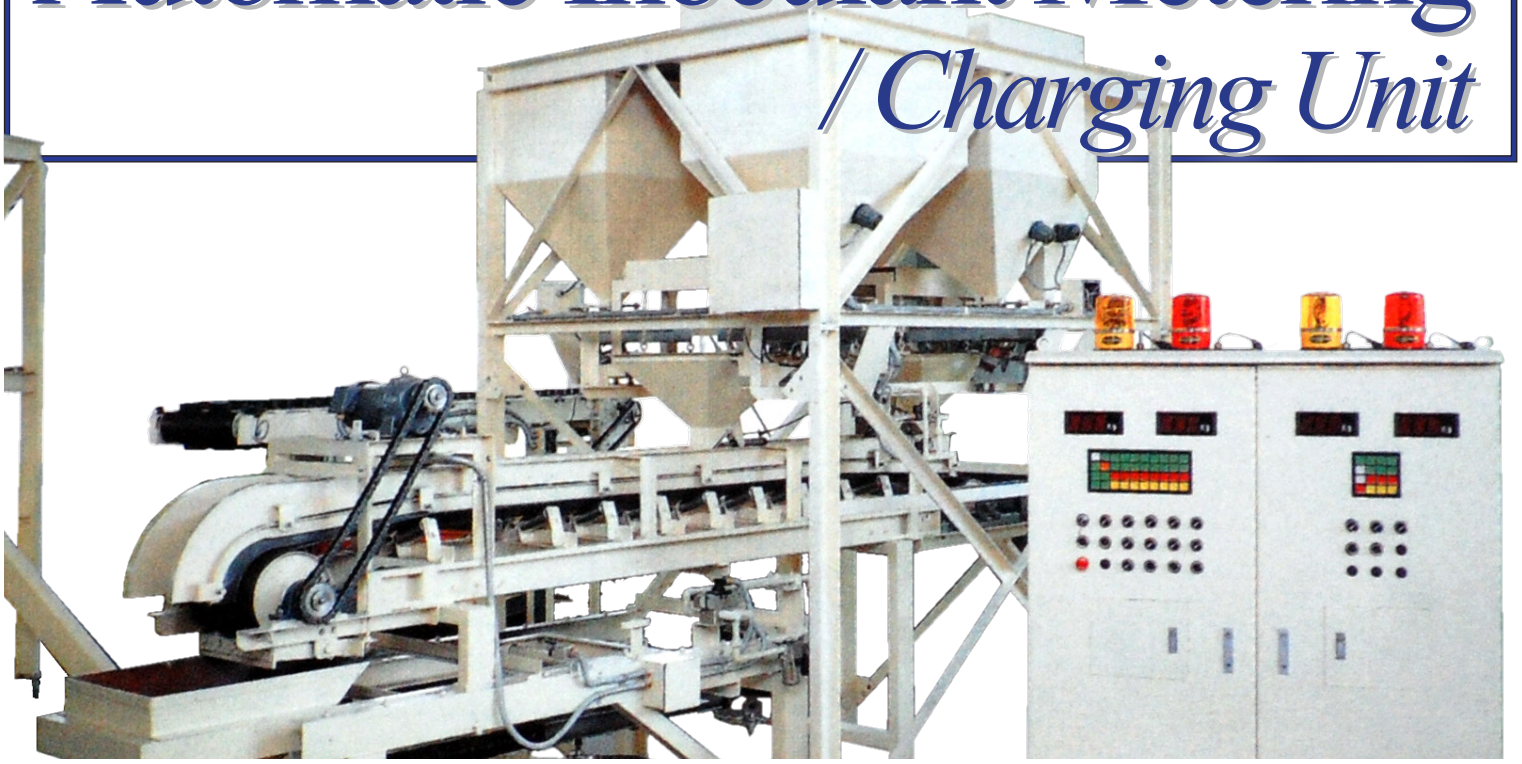
# Automatic Inoculant Metering / Charging Unit



## Systematized Melting Process

NAKAYAMA's product

Return scrap → Storing bunker with automatic metering

Metering system → Automatic metering and transporting

Storing bunker with automatic metering ← **Main material :** Pig iron

**Additional material :**
- Steel scrap
- Coke
- Lime stone
- Ferro-Silicon
- Ferro-Manganese
- Carburizer

Storing bunker with automatic metering → Automatic metering and transporting → Charging unit → Cupola/electric furnace → Holding furnace → Ladle for melt treatment → Automatic metering → Ladle carrier → Slag removal → Trough → Automatic pouring machine → Pouring into mold

Cupola/electric furnace ← QCR-1000,2000,WIN

Analysis by CountVac

Nodularity counter SGR-WIN
SG% is obtained within 3 minutes. → Ladle for melt treatment

Automatic inoculant metering /charging unit
- Spheroidizer (10 types)
- Inculant
- Charging pattern (4 to 8 types)
- One pattern for one material

Reporting system from analysis lab
Composition can be checked on the floor. → Analysis by CountVac

Air shooter → Analysis by CountVac

Automatic inoculant metering /charging unit for late stage inoculation
- Inoculant (3 to 7 types)

Trough ← Automatic inoculant metering /charging unit for late stage inoculation

Automatic pouring machine → QCR-1000,2000,WIN

Melt quality control system
SYSTEM ZERO1 ← Automatic pouring machine

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