Clamping force kN 55,000 60,000 80,500 90,500 Clamping force Ton 5,607 6,118 8,206 9,225 Injection dynamic force (2° phase) kN 9986 1,430 1,430 Injection force with 20 bar outs of pressure kN 3,711 3,111 4,520 4,520 Ejection force kN 1100 1000 1238 1,238 Max. die height mm 2,400 2,600 2,600 2,600 Min. die height mm 1,500 1,500 1,700 1,700 Platens dimensions HAV mm 3,600,3,600 3,600,3,600 4,100,4100 4,100,4100 Tie bar diameter mm 4,50 4,50 5,50 5,50 Movable platen stroke mm 2,300 2,600 2,600 2,600 Ejection stroke mm 4,00 4,00 4,00 4,00 4,00 Injection stroke mm 1,00 1,00 9 9 1,00	MODEL GIGAPRESS NE®		OL 5500 CS	OL 6100 CS	OL 8000 CS	OL 9000 CS
Injection dynamic force INN 996 996 1.430	Clamping force	kN	55.000	60.000	80.500	90.500
(2° phase) IN 3999 996 IASO IASO Injection force IN 3.III 3.III 4.320 4.320 Ejection force IN 1100 1100 1238 1238 Max. die height Imn 2.400 2.400 2.600 2.600 Min. die height Imn 1.500 1500 1700 1700 Platens dimensions HaV Imn 3.600x3.600 3.600x3.600 4.100x4.100 4.100x4.100 Tie bar spacing Imn 2.500x2.300 2.500x2.600 2.600x2.600 2.600x2.600 Tie bar diameter Imn 450 450 530 550 Movable platen stroke Imn 2.500 2.500 2.600 2.600 Ejection stroke Imn 4.00 4.00 4.00 4.00 4.00 Movable platen stroke Imn 1.600 1.600 2.200 2.200 2.200 Mox sieve diameter Imn 2.00 4.00 4.00 4.00<	Clamping force	Ton	5.607	6.118	8.206	9.225
Bigetion force IN 1100 1100 1238 1238 1238 Max. die height mm 2400 2400 2600 2600 2600 2600 Min. die height mm 1500 1500 17	Injection dynamic force (2^ phase)	kN	996	996	1.430	1.430
Max. die height mm 2,400 2,600 2,600 Min. die height mm 1,500 1,500 1,700 1,700 Platens dimensions HxV mm 3,600x3,600 3,600x3,600 4,100x4,100 4,100x4,100 Tie bar spacing mm 2,300x2,300 2,300x2,600 2,600 2,600 2,600 Tie bar diameter mm 450 450 530 550 Movable platen stroke mm 2,300 2,300 2,600 2,600 Ejection stroke mm 400 400 400 400 Max. singetion velocity without alloy mm 1600 1,600 2,200 2,200 Max. sleeve diameter mm 200 200 280 280 Max. sleeve diameter mm 240 240 320 320 Max shot weight (Al alloy) with 55% mm, sleeve filling up and 95% of injection stroke kg 60,7 80,7 217.5 217.5 217.5 95% of injection stroke mm 240		kN	3.111	3.111	4.320	4.320
Min. die height mm 1,500 1,500 1,700 1,700 Platens dimensions HxV mm 3,600×3,600 3,600×3,600 4,100×4,100 4,100×4,100 Tie bar spacing mm 2,300×2,300 2,500×2,620 2,600×2,600 Tie bar diameter mm 450 450 530 550 Movable platen stroke mm 2,300 2,800 2,600 2,600 Ejection stroke mm 1,600 1,600 2,200 2,200 Min. sleeve diameter mm 1,600 1,600 2,200 2,200 Max. sleeve diameter mm 2,00 2,00 2,80 2,80 Max. sleeve diameter mm 2,00 2,00 2,80 2,80 Max. sleeve diameter mm 2,40 3,20 3,20 Max shot weight (Al alloy) with home stroke weight (All alloy) with home stroke weight (Alloy) w	Ejection force	kN	1.100	1.100	1.238	1.238
Platens dimensions HxV	Max. die height	mm	2.400	2.400	2.600	2.600
Tie bar spacing mm 2300x2300 2300x2300 2620x2620 2600x2600 Tie bar diameter mm 450 450 530 550 Movable platen stroke mm 2300 2300 2600 2600 2600 Ejection stroke mm 400 400 400 400 400 Injection stroke mm 1600 1600 2200 2200 Max. Injection velocity (without alloy) Min. sleeve diameter mm 200 200 280 280 Max. sleeve diameter mm 240 240 320 320 Max shot weight (A) alloy) with 65% min. sleeve filling up and 95% of injection stroke Max shot weight (A) alloy) with 65% max. sleeve filling up and 95% of injection stroke Max shot weight (A) alloy) with 65% max sleeve filling up and 95% of injection stroke Max projected area with min sleeve diameter cm² 2 5.553 6.060 11.476 12.902 Max projected area with nominal clamping force and p=400 bar on alloy Pressure on the alloy in the mm 1010 1010 715 715 Pressure on the alloy in the mm 201 701 548 548 Injection positions mm 700 700 1280 1280 Working pressure bar 180 180 180 180 180 Dry Ciclyng (DIN 24480) n/T 1.5 1.5 1.2 1.2 Pump motor power NW 4x75 4x75 4x110 4x110 Injection motor power NW 427 427 590 590	Min. die height	mm	1.500	1.500	1.700	1.700
Tile bar diameter	Platens dimensions HxV	mm	3.600x3.600	3.600×3.600	4.100×4.100	4.100x4.100
Movable platen stroke mm 2.300 2.500 2.600 2.600 Ejection stroke mm 400 400 400 400 400 Max. injection stroke mm 1600 1600 2.200 2.200 Max. injection velocity (without alloy) m/s 10 10 9 9 Min. sleeve diameter mm 200 200 280 280 Max. sleeve diameter mm 240 240 320 320 Max shot weight (Al alloy) with 65% min. sleeve filling up and 95% of injection stroke 80,7 80,7 217,5 217,5 Max shot weight (Al alloy) with 65% min. sleeve filling up and 95% of injection stroke 80,7 116.2 284 284 Max projected area with min sleeve filling up and 95% of injection stroke 80,7 116.2 284 284 Max projected area with max sleeve diameter cm*2 5.533 6.060 11.476 12.902 Max. projected area with max sleeve diameter cm*2 14.016 15.296 20.515 23.063	Tie bar spacing	mm	2.300x2.300	2.300×2.300	2.620×2.620	2.600x2.600
Ejection stroke	Tie bar diameter	mm	450	450	530	550
Max. injection stroke mm 1.600 1.600 2.200 2.200	Movable platen stroke	mm	2.300	2.300	2.600	2.600
Max. injection velocity (without alloy) m/s 10 10 9 9 Min. sleeve dlameter mm 200 200 280 280 Max. sleeve dlameter mm 240 240 320 320 Max shot weight (Al alloy) with 65% min. sleeve filling up and 95% of injection stroke kg 80,7 217,5 217,5 Max shot weight (Al alloy) with 65% max. sleeve filling up and 95% of injection stroke kg 116,2 116,2 284 284 Max projected area with max projected area with max sleeve dlameter cm°2 5.533 6.060 11.476 12.902 Max projected area with nominal clamping force and p=400 bar on alloy cm°2 7.997 8.727 14.985 16.846 Max. projected area with nominal clamping force and p=400 bar on alloy cm°2 14.016 15.296 20.515 23.063 Pressure on the alloy in the min. sleeve mm 1.010 7.01 548 548 Injection positions mm 701 701 548 548 Injection positions mm 700	Ejection stroke	mm	400	400	400	400
With sleeve diameter mm 200 200 280 280 Max. sleeve diameter mm 240 240 320 320 Max shot weight (Al alloy) with 65% min. sleeve filling up and 95% of injection stroke kg 80.7 80.7 217.5 217.5 Max shot weight (Al alloy) with 65% max. sleeve filling up and 95% of injection stroke kg 116.2 116.2 284 284 Max projected area with min sleeve diameter cm^2 5.533 6.060 11.476 12.902 Max projected area with max sleeve diameter cm^2 7.997 8.727 14.985 16.846 Max. projected area with nominal clamping force and p=400 bar on alloy cm^2 14.016 15.296 20.515 23.063 Pressure on the alloy in the min. sleeve mm 1.010 1.010 715 715 Pressure on the alloy in the max sleeve mm 701 701 548 548 Injection positions mm 701 701 548 548 Injection positions mm 700 700	Injection stroke	mm	1.600	1.600	2.200	2.200
Max. sleeve diameter mm 240 240 320 320 Max shot weight (Al alloy) with 65% min. sleeve filling up and 95% of injection stroke kg 80.7 80.7 217.5 217.5 Max shot weight (Al alloy) with 65% max. sleeve filling up and 95% of injection stroke kg 116,2 116,2 284 284 Max projected area with min sleeve diameter cm°2 5.533 6.060 11.476 12.902 Max projected area with max sleeve diameter cm°2 7.997 8.727 14.985 16.846 Max, projected area with max sleeve diameter cm°2 14.016 15.296 20.515 23.063 Pressure on the alloy in the min sleeve mm 1.010 1.010 715 715 Pressure on the alloy in the min sleeve mm 701 701 548 548 Injection positions mm 0; -650 0; -650 -550; -1.000 -550; -1.000 Max plunger penetration mm 700 1280 1280 Sleeve centering diameter mm 310 310 480 <th></th> <th>m/s</th> <th>10</th> <th>10</th> <th>9</th> <th>9</th>		m/s	10	10	9	9
Max shot weight (Al alloy) with 65% min. sleeve filling up and 95% of injection stroke kg 80,7 80,7 217,5 217,5 95% of injection stroke 95% of injection stroke 65% max. sleeve filling up and 95% of injection stroke Max projected area with min sleeve diameter kg 116,2 284 284 Max projected area with min sleeve diameter cm^2 5.533 6.060 11.476 12.902 Max projected area with min sleeve diameter cm^2 7.997 8.727 14.985 16.846 Max. projected area with nominal clamping force and p=400 bar on alloy cm^2 14.016 15.296 20.515 23.063 Pressure on the alloy in the min. sleeve mm 1.010 1.010 715 715 Pressure on the alloy in the max. sleeve mm 701 701 548 548 Injection positions mm 0;-650 0;-650 -550;-1.000 -550;-1.000 Max plunger penetration mm 700 700 1.280 1280 Sleeve centering diameter mm 310 480 480 Working pressure bar	Min. sleeve diameter	mm	200	200	280	280
65% min. sleeve filling up and 95% of injection stroke kg 80,7 80,7 217,5 217,5 Max shot weight (Al alloy) with 65% max. sleeve filling up and 95% of injection stroke kg 116,2 116,2 284 284 Max projected area with min sleeve diameter cm^2 5.533 6.060 11.476 12.902 Max projected area with max sleeve diameter cm^2 7.997 8.727 14.985 16.846 Max. projected area with max sleeve diameter cm^2 14.016 15.296 20.515 23.063 Max. projected area with max sleeve diameter mm 1.010 1.010 715 715 Pressure on the alloy in the min. sleeve mm 1.010 1.010 715 715 Pressure on the alloy in the max. sleeve mm 701 701 548 548 Injection positions mm 0; -650 -550; -1.000 -550; -1.000 Max plunger penetration mm 700 700 1.280 1280 Sleeve centering diameter mm 310 310 480	Max. sleeve diameter	mm	240	240	320	320
65% max. sleeve filling up and 95% of injection stroke kg 116.2 116.2 284 284 Max projected area with min sleeve diameter cm^2 5.533 6.060 11.476 12.902 Max projected area with min sleeve diameter cm^2 7.997 8.727 14.985 16.846 Max. projected area with nominal clamping force and p=400 bar on alloy cm^2 14.016 15.296 20.515 23.063 Pressure on the alloy in the min. sleeve mm 1.010 1.010 715 715 Pressure on the alloy in the min. sleeve mm 701 701 548 548 Injection positions mm 0; -650 0; -650 -550; -1.000 -550; -1.000 Max plunger penetration mm 700 1.280 1.280 Sleeve centering diameter mm 310 310 480 480 Working pressure bar 180 180 180 180 Dry Ciclyng (DIN 24480) n/1' 1,5 1,5 1,2 1,2 Pump motor power </th <th>65% min. sleeve filling up and</th> <th>kg</th> <th>80,7</th> <th>80,7</th> <th>217,5</th> <th>217,5</th>	65% min. sleeve filling up and	kg	80,7	80,7	217,5	217,5
min sleeve diameter Cm ⁻² 5.533 6.060 II.4/6 I2.902 Max projected area with max sleeve diameter cm ⁻² 7.997 8.727 14.985 16.846 Max. projected area with nominal clamping force and p=400 bar on alloy cm ⁻² 14.016 15.296 20.515 23.063 Pressure on the alloy in the min. sleeve mm 1.010 1.010 715 715 Pressure on the alloy in the max. sleeve mm 701 701 548 548 Injection positions mm 0; -650 0; -650 -550; -1.000 -550; -1.000 Max plunger penetration mm 700 700 1.280 1.280 Sleeve centering diameter mm 310 310 480 480 Working pressure bar 180 180 180 180 Dry Ciclyng (DIN 24480) n/1' 1,5 1,5 1,2 1,2 Pump motor power kW 4x75 4x75 4x110 4x110 Injection motor power kW 427 427 5	65% max. sleeve filling up and	kg	116,2	116,2	284	284
max sleeve diameter cm°2 7.997 8.727 14.985 16.846 Max, projected area with nominal clamping force and p=400 bar on alloy cm°2 14.016 15.296 20.515 23.063 Pressure on the alloy in the min. sleeve mm 1.010 1.010 715 715 Pressure on the alloy in the max. sleeve mm 701 701 548 548 Injection positions mm 0; -650 0; -650 -550; -1.000 -550; -1.000 Max plunger penetration mm 700 700 1.280 1.280 Sleeve centering diameter mm 310 310 480 480 Working pressure bar 180 180 180 180 Dry Ciclyng (DIN 24480) n/1' 1,5 1,5 1,2 1,2 Pump motor power kW 4x75 4x75 4x110 4x110 Injection motor power kW 427 427 590 590		cm^2	5.533	6.060	11.476	12.902
clamping force and p=400 bar on alloy cm^2 14.016 15.296 20.515 23.063 Pressure on the alloy in the min. sleeve mm 1.010 1.010 715 715 Pressure on the alloy in the max. sleeve mm 701 701 548 548 Injection positions mm 0; -650 0; -650 -550; -1.000 -550; -1.000 Max plunger penetration mm 700 700 1.280 1.280 Sleeve centering diameter mm 310 310 480 480 Working pressure bar 180 180 180 180 Dry Ciclyng (DIN 24480) n/1' 1,5 1,5 1,2 1,2 Pump motor power kW 4x75 4x75 4x110 4x110 Injection motor power kW 427 427 590 590		cm^2	7.997	8.727	14.985	16.846
min. sleeve mm 1,010 1,010 715 715 Pressure on the alloy in the max. sleeve mm 701 701 548 548 Injection positions mm 0; -650 0; -650 -550; -1,000 -550; -1,000 Max plunger penetration mm 700 700 1,280 1,280 Sleeve centering diameter mm 310 310 480 480 Working pressure bar 180 180 180 180 Dry Ciclyng (DIN 24480) n/1' 1,5 1,5 1,2 1,2 Pump motor power kW 4x75 4x75 4x110 4x110 Injection motor power kW 427 427 590 590	clamping force and p=400 bar	cm^2	14.016	15.296	20.515	23.063
max. sleeve mm 701 701 548 548 Injection positions mm 0; -650 0; -650 -550; -1,000 -550; -1,000 Max plunger penetration mm 700 700 1,280 1,280 Sleeve centering diameter mm 310 310 480 480 Working pressure bar 180 180 180 180 Dry Ciclyng (DIN 24480) n/1' 1,5 1,5 1,2 1,2 Pump motor power kW 4x75 4x75 4x110 4x110 Injection motor power kW 55 55 75 75 Machine weight kW 427 427 590 590	<u> </u>	mm	1.010	1.010	715	715
Max plunger penetration mm 700 700 1.280 1.280 Sleeve centering diameter mm 310 310 480 480 Working pressure bar 180 180 180 180 Dry Ciclyng (DIN 24480) n/1' 1,5 1,5 1,2 1,2 Pump motor power kW 4x75 4x75 4x110 4x110 Injection motor power kW 55 55 75 75 Machine weight kW 427 427 590 590	-	mm	701	701	548	548
Sleeve centering diameter mm 310 310 480 480 Working pressure bar 180 180 180 180 Dry Ciclyng (DIN 24480) n/1' 1,5 1,5 1,2 1,2 Pump motor power kW 4x75 4x75 4x110 4x110 Injection motor power kW 55 55 75 75 Machine weight kW 427 427 590 590	Injection positions	mm	0; -650	0; -650	-550; -1.000	-550; -1.000
Working pressure bar 180 180 180 180 Dry Ciclyng (DIN 24480) n/1' 1,5 1,5 1,2 1,2 Pump motor power kW 4x75 4x75 4x110 4x110 Injection motor power kW 55 55 75 75 Machine weight kW 427 427 590 590	Max plunger penetration	mm	700	700	1.280	1.280
Dry Ciclyng (DIN 24480) n/1' 1,5 1,5 1,2 1,2 Pump motor power kW 4x75 4x75 4x110 4x110 Injection motor power kW 55 55 75 75 Machine weight kW 427 427 590 590	Sleeve centering diameter	mm	310	310	480	480
Pump motor power kW 4x75 4x75 4x110 4x110 Injection motor power kW 55 55 75 75 Machine weight kW 427 427 590 590	Working pressure	bar	180	180	180	180
Injection motor power kW 55 55 75 75 Machine weight kW 427 427 590 590	Dry Ciclyng (DIN 24480)	n/1'	1,5	1,5	1,2	1,2
Machine weight kW 427 427 590 590	Pump motor power	kW	4x75	4x75	4x110	4x110
	Injection motor power	kW	55	55	75	75
Machine dimensions (LxWxH) m 19,8x7,37x6,0 19,8x7,37x6,0 26x8,4x7,7 26x8,4x7,7	Machine weight	kW	427	427	590	590
	Machine dimensions (LxWxH)	m	19,8x7,37x6,0	19,8x7,37x6,0	26x8,4x7,7	26x8,4x7,7

The FUTURE of die casting is HERE

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GIGAPRESS introduces a new dimension in high end die casting technology.



"Giga Press is a thing that hopefully changes the world of automotive and it will definitely change the world of die casting machines forever"

Riccardo Ferrario

"WE WANT TO MAKE

the largest single piece castings in the world" Riccardo Ferrario had this clear goal in mind, when he first thought about **GIGAPRESS**, a visionary project to overcome the limits of traditional die casting press market.

The 'mission impossible' took 4 years of R&D, a talented team of excellent professionals in different fields, a total commitment and a strong perseverance to succeeding.

And now the future od die casting is here.

With many machines in full effect all over the world and many orders received by Idra Group, **GIGAPRESS** is already a huge success, a revolution that is changing the world of automotive and die casting machines forever.

GIGAPRESS going from 5500 to 9000 tons and counting opens a new era in die-casting 'giga' solutions.



GIGAPRESS is a revolutionary die casting machine for the automotive industry, offering the perfect solution for the production of single piece chassis for Hybrid - full electric vehicles, not plagued by defects inherent with welding and bolting parts together.

Equipped with the brand new 5S Injection System, **GIGAPRESS** provides more stable injection conditions in all phases, with the best possible dynamic force in every possible operating phase and therefore the possibility of manufacturing larger structural castings with thinner walls: the single piece chassis weigh less despite being structurally superior.

GREAT

in sustainability, in reliability, in innovation, in style. A result of three years of R&D by Idra's 'Dream Team' of experts, **GIGAPRESS** is a huge step-forward for the industry, offering best-in-class injection performance, a high dynamic force with strong intensification for final pressure and a complete setting flexibility with precise, and stable production parameters.

GIGAPRESS is great in sustainability, with 50% energy savings compared to Idra's existing OLCS product line, great in reliability, with easy maintenance and long lasting components, great in innovation, with a new and amazing Injection System, and great in style, with its good looking Italian design guarding system.

GIGAPRESS

offers unparalleled guaranteed long life and reliability.

Fastest cycle times

- Integrated high flow hydraulic manifold blocks
- Increased pump capacity utilizing DCP technology

Low Energy cost

- Energy efficient motors with speed control
- Minimize injection pressure loss and accumulator recharge time

Easy maintenance and minimal risk of fluid loss

- All-in-one hydraulic manifolds
- Limited use of external pipe-work
- Designed-for-access mechanical groups with new guard design



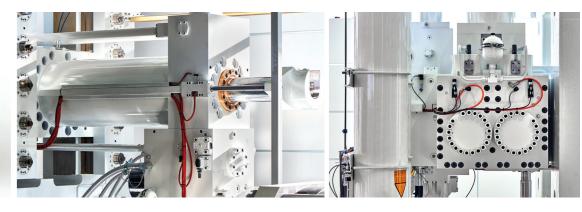
User friendly controls

- Inject Computer 3.2 (best in class machine management software)
- Eliminate push button Unit using Multiple touch screens.
- Cell controller Single point setting for integrated peripheral automation.

Fit for complex parts manufacture

- Closed loop 5S regenerative control of the injection velocity.
- Programming and control of process parameters





New injection series 55°

- Closed loop regenerative injection with aux servo pump for efficient recharge
- Extended velocity control valve life by balance of hydraulic forces
- High dynamic force necessary to fill difficult castings
- Maintaining same final pressure requirement for porosity in power train castings

New Guarding System

- Good looking Italian style
- Reducing complex electrical parts and stops
- Simplified assembly of the system with modular scalable construction
- Increased safety requirements for access while machine is running.
- Reduced emissions from the die casting process

DCP Hydraulic System

- Reduced energy consumption per cycle of the DCM cell
- Separated closing and injection pump systems
- Allowing subgroup testing for the injection system

Cell Controller Integration

- A more efficient way of managing the software requirements for complicated cells.
- Standard DCM software avoids instability and unnecessary stops
- Flexibility and customization for many different configurations
- Easy integration with the best in market products