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RAGA
TECHNOLOGIES & CONSUMABLES

Consumables Catalog

25
YEARS

RAGA
JET COOLER

Facilitates high pressure water & air into thin channels
and slender holes of core pins during casting processs

Important part of the Jet cool system
to reduce shrinkage porosities

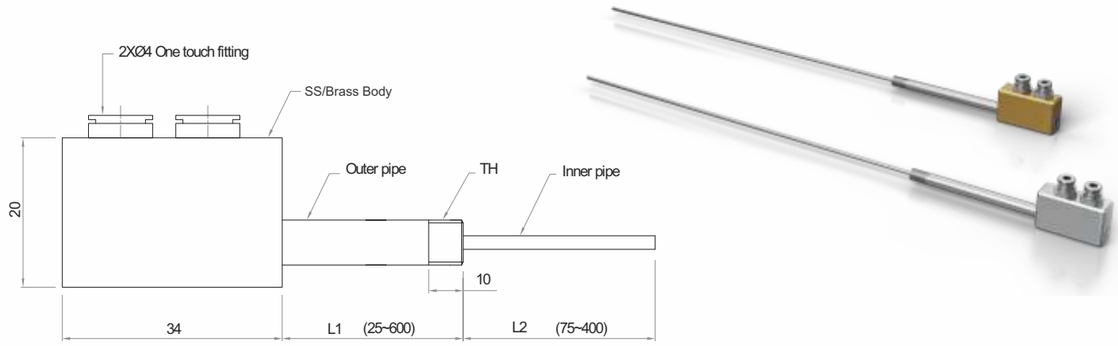
Easy to Install & long life

Improved material and design gives higher life

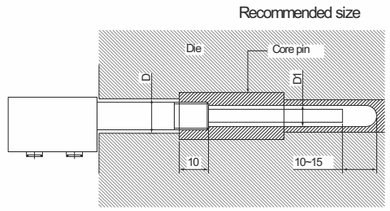
Available in 4 variants & with quick delivery

RAGA
JET COOLER

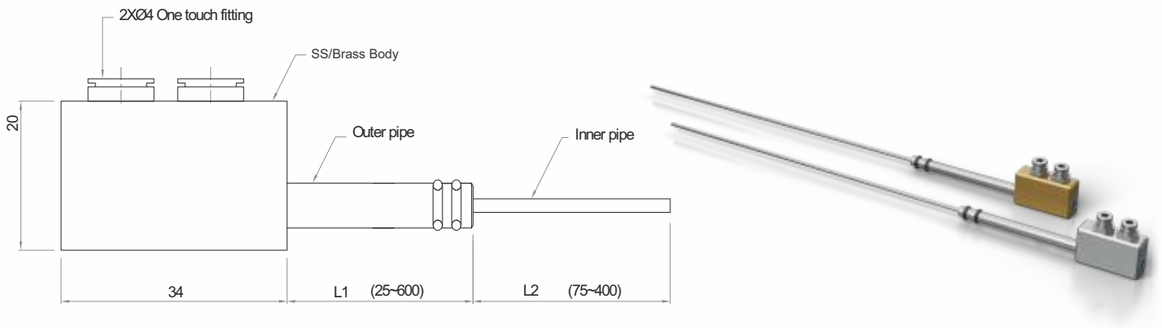
Thread Type (JCT)



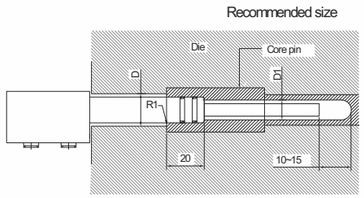
Outer Pipe		Inner Pipe		Die Hole	Pin Hole	JCT Outer Pipe Thread
OD	ID	OD	ID	D	D1	TH
4	2	1.2	0.85	8	~2	M4X0.7
6	3	1.2	0.85	10	~3	M6X1
		1.8	1.35			
8	4	1.8	1.35	12	~4.5	1/16 PT
		2.3	1.8			
10	5	1.8	1.35	13	~6	1/8 PT
		2.3	1.8			
		2.8	2.3			



O-Ring Type (JCO)



Outer Pipe		Inner Pipe		Die Hole	Pin Hole	JCO O Ring	
OD	ID	OD	ID	D	D1	Used	Dia
4	2	1.2	0.85	8	~2	NA	
6	3	1.2	0.85	0	~3	S4	6.3
		1.8	1.35				
8	4	1.8	1.35	2	~4.5	S6	8.2
		2.3	1.8				
10	5	1.8	1.8	13	~6	P7	10.2
		2.3	1.8				
		2.8	2.3				

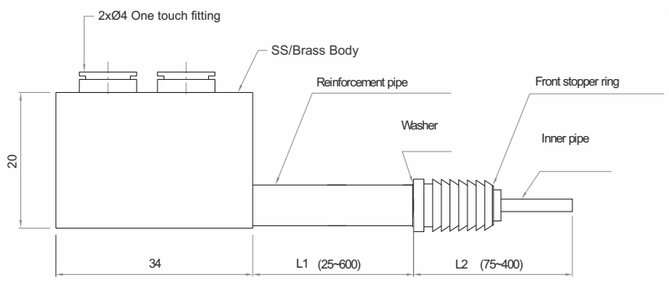


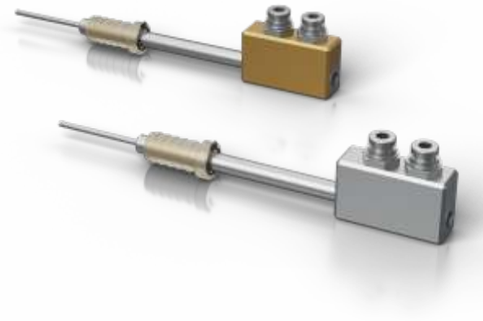
ORDERING CODE

Part Type	Outer Pipe (OD)	Inner Pipe (OD)	L1	L2
JCT/JCO	6	1.8	50	210

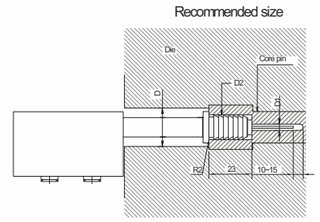
RAGA
JET COOLER

Sleeve Type (JCS)

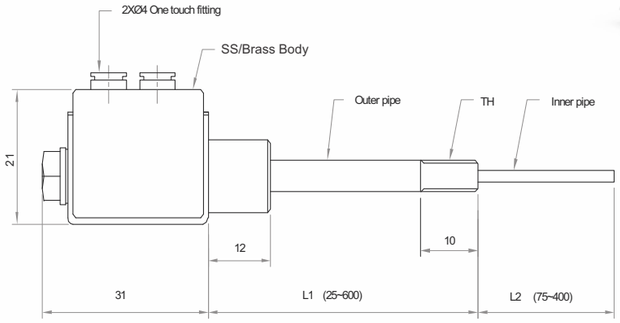




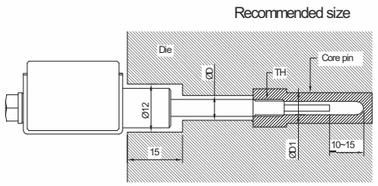
Outer Pipe		Inner Pipe		Reinforcement	Hole for	Die Hole	Pin Hole
OD	ID	OD	ID	Pipe (ID)	Packing (D2)	D	D1
6	3	1.2	0.85	6.4	10	14	~3
		1.8	1.35				
6	3	1.2	0.85	6.4	13	17	~3
		1.8	1.35				
8	4	1.8	1.35	11	13	17	~45
		2.3	1.88				



Roto Type (JCR)



Outer Pipe		Inner Pipe		JCR Outer Pipe	Die Hole	Hole Dia
OD	ID	OD	ID	Thread TH	D	D1
4	2	1.2	0.85	M4X0.7	8	2
6	3	1.2	0.85	M6X1	10	3.5
		1.8	1.35			
8	4	1.2	0.85	Rc1/16	12	4.5
		1.8	0.35			
		2.3	1.8			
10	5	2.3	1.8	Rc1/8	12	4.5



ORDERING CODE

Part Type	Outer Pipe (OD)	Inner Pipe (OD)	L1	L2
JCS/JCR	6	1.8	50	210

RAGA COREPIN

Reduce breakdown by use of long life RAGA core pin

Core pins used to create holes in die casting
are fitted & part of a die casting mold

Precisely machined and ground custom pins
are made from high quality DIN 1.2344/AISI H-13

Vacuum Heat treatment, nitriding
& coating enhances life of the core pins

RAGA
JET COOLED CORE PIN

Jet cooled (JC) core pins are an integral
& most important part of the jet cool system

Casters prefer RAGA JC Core pins for their
life and deep hole concentricity

Custom made pins go through stringent quality
checks to ensure straightness of holes & dimensions

Surface treatments like Nitriding & coating ensures higher life

FEATURES

Hole: Min Dia 2.5mm & Max length 600mm,
Casting Dia: Min 4.5mm, Coating options available

RAGA
JET COOLER

Application

Jet Cooler JCO with Core Pin

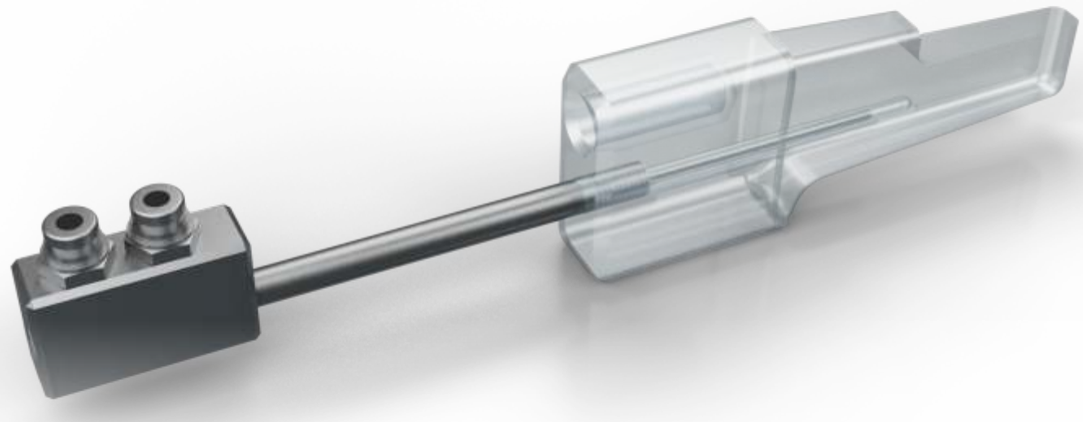
Jet Cooler JCT with Core Pin

Jet Cooler JCS with Core Pin

RAGA
JET COOLER

Application

Jet Cooler JCR with Core Pin



Jet Cooler JCP with Insert

RAGA
SPOT COOLER

Minimise mold breakdown and maintenance time using RAGA SPOT COOLERS

Standard options for customised needs keeps mold thermally balanced

Stainless steel option gives high life against poor water quality

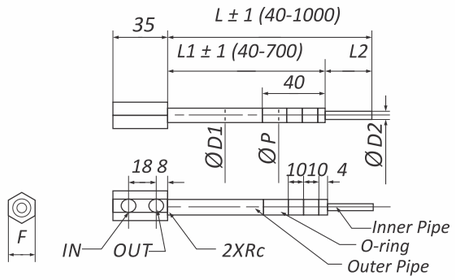
Easy installation for both thread type & O-ring types

Design ensures strength against breakage or bending

Options for rotatable head & hose connection gives flexibility to use

RAGA
SPOT COOLER

O-Ring Type SCO



Characteristics

·W1 is 1-way and W2 is 2-ways.
·O2 is 2-O rings and 03 is 3-O rings.
·For W1 only O3 available.
·All units are in MM.

Working Condition

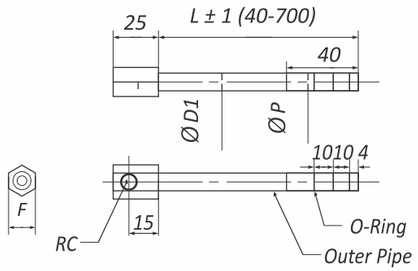
·Pressure- Max. 2MPA
·Fluid Temp.- > 150°C

Material

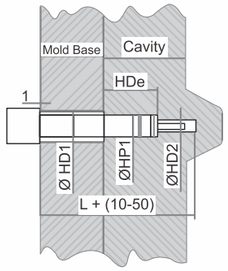
Code	Head	Outer Pipe	Inner Pipe
M1	MS	MS	Copper
M2	SS	SS	SS

SCO-W2

SCO-W1



Installation dimm.



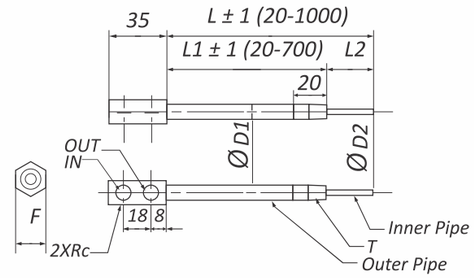
Size No.	Head		Outer Pipe			Inner Pipe		Hole Dimension			
	RC Thread	RC Thread	D 1 (ø Inner)	d 1 (ø Inner)	P (ø Inner)	D 2 (ø Inner)	d 2 (ø Inner)	HP1	H1D	HD2	HDe
1A	17	1/8	10.5	5.7	4.0	2.4	2.4	$11^{+0.05}$	15	6	30
1B	24	1/4									
2A	19	1/8	13.8	7.8	6.0	4.0	4.0	$13^{+0.05}$	17	8	
2B	24	1/4									
3A	21	1/8	17.3	10.9	8.0	6.0	6.0	$18^{+0.05}$	22	10	
3B	29	1/4									
4A	24	1/8	21.7	16.1	10.0	8.0	8.0	$22^{+0.05}$	26	12	
4B	29	1/4									

ORDERING CODE

Part Type	Outer Pipe (OD)	Inner Pipe (OD)	L	L1*
SCO-03-W2	M2	2A	378	321
SCO-03-W1	M1	3B	377	

RAGA
SPOT COOLER

Thread Type SCT



Characteristics

·W1 is 1-way and W2 is 2-ways.
·All units are in MM.

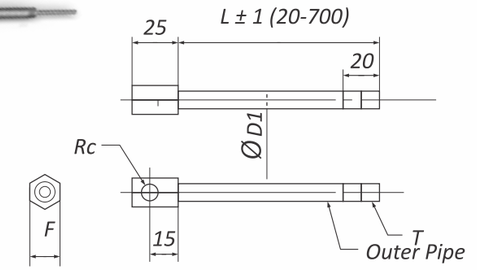
Working Condition

·Pressure- Max. 2MPA
·Fluid Temp.- > 150°C

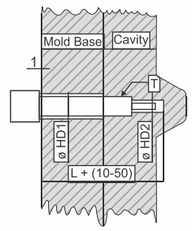
Material

Code	Head	Outer Pipe	Inner Pipe
M1	MS	MS	Copper
M2	SS	SS	SS

SCT-W2



Installation dimm.



SCT-W1

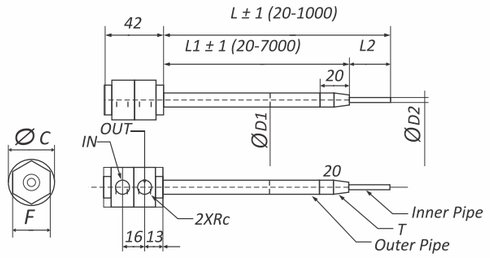
Size No.	Head		Outer Pipe		Inner Pipe		Thread	Hole Dimension	
	F (Acc. Flat)	RC (Thread)	D1 (ø Outer)	D1 (ø Inner)	D2 (ø Outer)	D2 (ø Inner)	T	HD1	HD2
1A	17	1/8	10.5	5.7	4.0	2.4	1/8	15	6
1B	24	1/4							
2A	19	1/8	13.8	7.8	6.0	4.0	1/4	17	8
2B	24	1/4							
3A	21	1/8	17.3	10.9	8.0	6.0	3/8	22	12
3B	29	1/4							
4A	24	1/8	21.7	16.1	10.0	8.0	1/2	26	16
4B	29	1/4							

ORDERING CODE

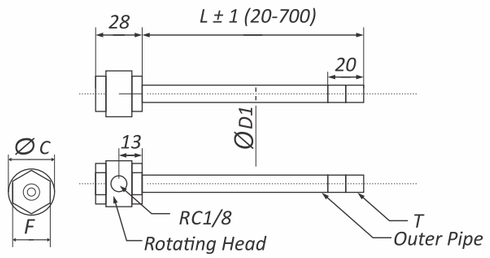
Part Type	Material	Size	L	L1*
SCT-W2	M2	2A	378	321
SCT-W1	M1	3B	377	

RAGA
SPOT COOLER

Thread Type Rotating Head SCT-R



SCT-R-W2



SCT-R-W1

Characteristics

·W1 is 1-way and W2 is 2-ways.
·All units are in MM.

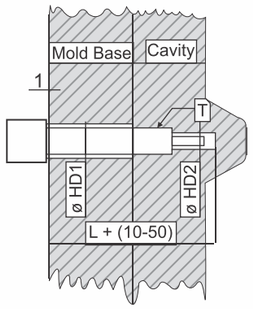
Working Condition

·Pressure- Max. 2MPA
·Fluid Temp.- > 150°C

Material

Code	Head	Outer Pipe	Inner Pipe
M1	MS	MS	Copper
M2	SS	SS	SS

Installation dimm.



Size No.	Head			Outer Pipe		Inner Pipe		Thread	Hole Dimension	
	F (Acc. Flat)	C (ø Head)	RC (Thread)	D1 (ø Outer)	D1 (ø Inner)	D2 (ø Outer)	D2 (ø Inner)	T	HD1	HD2
1	24	30	1/8	10.5	5.7	4.0	2.4	1/8	15	6
2			1/8	13.8	7.8	6.0	4.0	1/4	17	8
3			1/8	17.3	10.9	8.0	6.0	3/8	22	12

ORDERING CODE

Part Type	Material	Size No.	L	L1*
SCT-R-W2	M2	2	385	350
SCT-R-W1	M1	3	413	

RAGA
SPOT COOLER

Roto Type New Design - SCT-R-H

SCT-R-H

Characteristics

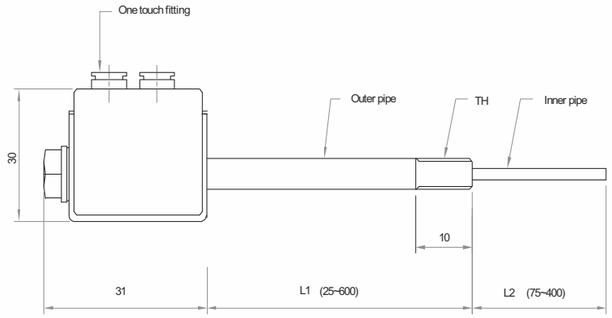
- Roto Type head give flexibility to take hose any dissection
- All units are in MM.

Working Condition

·Pressure- Max. 2MPA
·Fluid Temp.- > 150°C

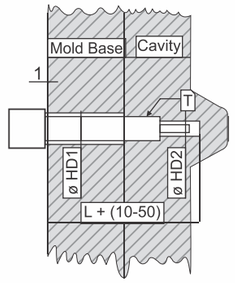
Material

Head	Outer Pipe	Inner Pipe
SS	SS	SS



Outer Pipe		Inner Pipe		Outer Pipe Thread	Hole Dimension	
OD	ID	OD	ID	TH(Rc)	HD1	HD2
10.5	5.7	4	2.4	1X8	15	6
13.8	7.8	4	2.4	1/4	17	8
		6	4			
17.3	10.9	4	2.4	3X8	22	12
		4	2.4			
		8	6			
21.7	16.1	10	8	1/2	26	16

Installation dimm.



ORDERING CODE

Part Type	Outer Pipe (OD)	Inner Pipe (OD)	L1	L2
SCT-R-H	10.5	4	50	210

RAGA CHILLVENT

End gas evacuation worries with
RAGA CHILL VENTS

Efficiently exhaust residual air and/or gas
from inside of a die cast mold cavity

Zigzag profile ensures gas leaving from
chill vent & molten metal chilled

High quality DIN1.2344/AISIH-13
with treatment ensures longer life

	RAGA Chillvent 30		RAGA Chillvent 60		RAGA Chillvent 100		RAGA Chillvent 140	
DCM tonnage (t)	**<300**		**200-800**		**800-1600**		**1600-2400**	
Mold side	Fix side	Moving side	Fix side	Moving side	Fix side	Moving side	Fix side	Moving side
Width (mm)	63	63	100	100	140	140	150	150
Depth (mm)	50	50	50	50	60	60	80	80
Height (mm)	150	149	250	249	300	299	360	359
Weight (mm)	4.1	3.9	9.4	8.5	18.8	17.2	30.6	32.6

RAGA
CHILL VACCUM BLOCK

Force evacuate gases by installing RAGA CHILL VACUUM BLOCK
in the mold and connect it with RAGA VACUUM SYSTEM

The aerodynamic profile ensures fast and compact alloy
solidification while the gases are completely sucked

Reduced complication as no cooling system required

Simple & effective

	RAGA Chill Vaccum Block -30		RAGA Chill Vaccum Block -60		RAGA Chill Vaccum Block -100		RAGA Chill Vaccum Block -140	
DCM tonnage (t)	**<400**		**200-1200**		**800-2800**		**1600-4500**	
Mold side	Fix side	Moving side	Fix side	Moving side	Fix side	Moving side	Fix side	Moving side
Width (mm)	63	63	100	100	140	140	150	150
Depth (mm)	50	50	50	50	60	60	80	80
Height (mm)	150	149	250	249	300	299	360	359
Weight (mm)	4.1	3.9	9.4	8.5	18.8	17.2	30.6	32.6

RAGA
SHOT SLEEVE

Long life RAGA SHOT SLEEVES come in fully
or partially cooled with one or two part options

High quality AISIH-13/DIN1.2344 is precisely
machined, ground, hardened & Nitrided

Thermally balanced sleeve improves
performance and quality of casting

Continual improvements in finishes and treatment
work towards giving a caster value for money

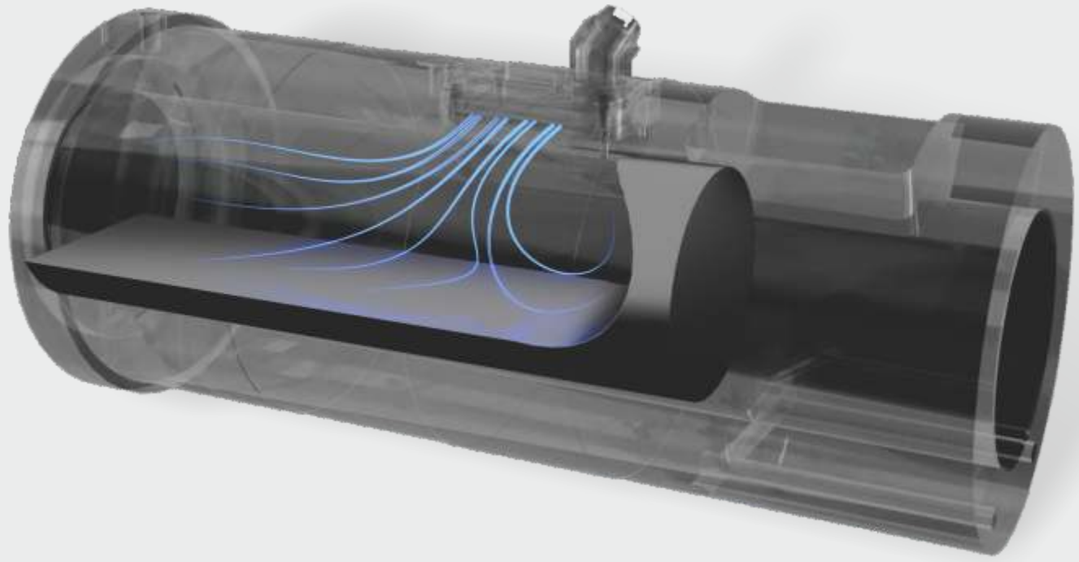
RAGA
VACCUM SHOT SLEEVE

Casters have effectively used RAGA VACUUM SHOT SLEEVE
to minimise porosiites around gate area

RAGA's twin stage VACUUM SYSTEM gets
connected to this sleeve and the mold

Air is extracted from the shot sleeve via 4 wide
cross-section path during the first phase of injection

Simple design, easy to install & maintain



RAGA
PLUNGER TIP

RAGA PLUNGER TIP reduces breakdown
time due to plunger tip change

Made with high quality AISIH-13/DIN1.2344,
it gives multiple times more life than cast iron

Precisely machined & grounded

Results in higher sleeve life

RAGA
SPRUE BUSH & DIFFUSER

Refined material structure and heat treatment makes
SPRUE BUSH & DIFFUSER more durable

High quality AISI H-13/DIN 1.2344 is precisely
machined, ground, hardened & Nitrided

With options of integral/jacket/conformal
cooling makes it thermally balanced

Diffuser is ground blue matched
with thermal clearances

RAGA
LPDC NOZZLE

Custom profiled RAGA LPDC NOZZLES
have been used & appreciated by die casters

Nozzles increase mold life & decreases
production downtime

Precisely machined and polished surfaces ensures
effective flow of molten aluminum into a LPDC mold

High quality AISI H-13/DIN 1.2344 hardened
to specifications gives high life

GLOBAL PRESENCE

RAGA TECHNOLOGIES

For Die Casting

RAGA
NEX

RAGA
UNO

RAGA
TRIO

RAGA
VACMAX

RAGA
COMBO

RAGA ACCESSORIES

RAGA
BLOCK TYPE
MANIFOLD

RAGA
VISUAL FLOW
MANIFOLD

RAGA
PIN BREAKAGE
DETECTION DEVICE

RAGA
FLOW SENSING
DEVICE

RAGA
FLOW INDICATION
DEVICE

RAGA
WATER FILTER

RAGA
WATER SOFTENER