

Cores are defined as a body of sand which is used to form the hollow interior of the casting or a hole through the casting. These are prepared separately in a core box.

Core Sand : Moulding Sand + Organic binders + Inorganic binders

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resins, plastics	clay iron oxide

Core Chaplets :

Chaplets are metal shapes used for supporting large and odd shaped cores which can not be adequately supported by itself.

Chills :

To effect directional solidification towards the riser chills widely used as they extract heat from the casting metal much more readily than does the moulding sand.

Chills are the small pieces of metal, capable of quick heat absorption.

- Internal Chills
- External Chills.

Padding :

Padding is another method to promote directional solidification.