

Foundry

1. STEPPED CONE PULLEY

AIM

To make the mould for the given stepped cone pulley pattern.

MATERIALS REQUIRED

1. Moulding Sand
2. Parting Sand
3. Facing Sand

TOOLS REQUIRED

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|----------------|--------------------|
| 1. Trowel | 8. Riddle |
| 2. Lifter | 9. Moulding Box |
| 3. Gate Cutter | 10. Strike off bar |
| 4. Swab | 11. Riser |
| 5. Rammer | 12. Draw Spike |
| 6. Runner | 13. Sprue Pin |
| 7. Vent Wire | 14. Bellow |

PROCEDURE

1. The mould box, pattern, tools and the table / floor are cleaned. A suitable core is prepared with the help of core box.
2. The drag box is placed above the moulding board. Now the pattern is kept at centre of the drag.
3. Now parting sand is sprinkled before we keep the pattern.
4. Facing sand is sprinkled over the pattern to a depth of 5 mm. Then green sand filled over it.
5. Proper ramming is done on the green sand to get a air tight packing. Excess sand is removed by strike off bar.
6. The drag box is inverted upside down. The cope box is placed over the drag box and locked.
7. The riser pin and sprue pin is placed at right position and green sand is filled over the pattern.
8. Proper ramming is done on the green sand to get air tight packing, with strike off bar levelling is done.
9. The pattern is removed by draw spike tool.
10. Gate is prepared using gate cutter and core is placed vertically inside the cavity. 12. The vent holes are made with vent wire on the cope.

RESULT

Thus, the mould for the given stepped cone pulley pattern is developed.

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