REVISION # REVISION DATE

CASTING MOLD DEPARTMENT OSBORN PROCESS CARD

MOLD MACHINE REQUIREMENTS

DRAG VIEW

COPE VIEW

PATTERN LOCATION

IMPRESSIONS

DATE CODE TYPE

SHIFT CODE

HOUR CODE

SLEEVE REQUIREMENTS

SQUEEZE PRESSURE

AERATOR SETTINGS

NORTH

SOUTH

SPRUE DRILL PRESET

CORESET RELEASE BUTTON

SPECIAL INSTRUCTIONS

CRITICAL INSTRUCTIONS

CURRENT SCRAP ISSUES

VENT LOCATIONS

DOCUMENT REVISION HISTORY

FINAL PRODUCT

MOLD HARDNESS READINGS

AREA 1	AREA 2	AREA 3
C	C	C
D	D	D
AREA 4	**AREA 5**	**AREA 6**
C	C	C
D	D	D

CORESET SIDE

ASSOCIATE SIGNATURES

CORESETTER SIGNATURES

MOLD MACHINE OPERATOR SIGNATURE

SUPERVISOR SUBMITTAL PASSWORD

Submit

CORESET PROCESS REQUIREMENTS

CORESET ORDER

VENTING REQUIREMENTS

IN-MOLD INOCULANT

FILTER REQUIREMENTS

CORESET FIXTURE

CHAPLET REQUIREMENTS

REAMER SIZE

FILTER REQUIREMENTS

ADDITIONAL INFORMATION

PROCESS STEPS

1

2

3

4

5

6

7