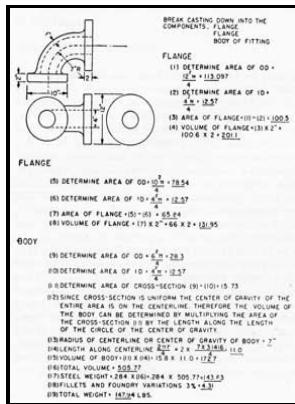


Manual of foundry practice for cast iron.

Chapmanand Hall - Foundry Manual



Description: -

-manual of foundry practice for cast iron.

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Guidelines for Welding Cast Iron

Cores made with coke cinders, gravel, or similar material in their central sections do not usually need additional venting. The size, type, and location of sprue and runner. Note that there is no excess of core paste.

Cast iron & Ductile iron foundry practice

One of the necessary requirements of a core is venting. This would then have equalized the hydrostatic pressure in the two risers.

Numbers & Letters

Pencil gates permit the metal to fall in a number of small streams and help to reduce erosion of the mold.

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Feeding through a thin section. For small and medium castings, such as will be made for most emergency work, vents made by the use of molder's lifters or by a saw blade are satisfactory.

Cast Iron

To be effective, it must be the last portion of the casting to solidify. When cool, all excess materials such as fine and loose sand should be cleaned from them. A good method for determining the size of riser necks involves the use of inscribed circles in roughly drawn sectional layouts as shown in figure 143.

FOUNDRY LAB MANUAL

This second specification is necessary because the strength of gray iron is highly sensitive to cross section the smaller the cross section, the faster the cooling rate and the higher the strength. In other words, for a given weight of metal, the shape which has the smallest surface area will take the longest time to solidify.

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