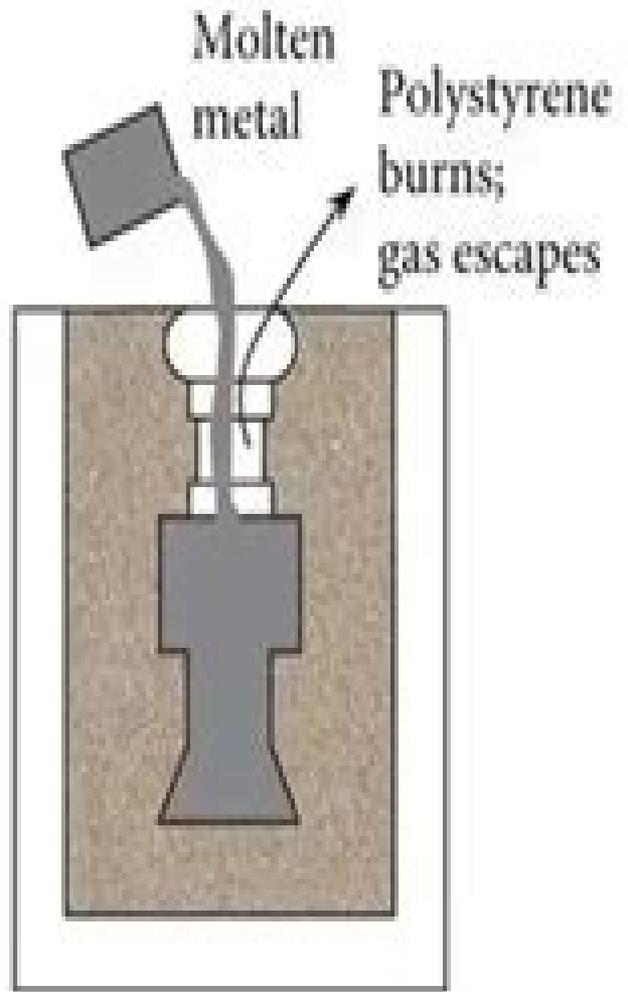
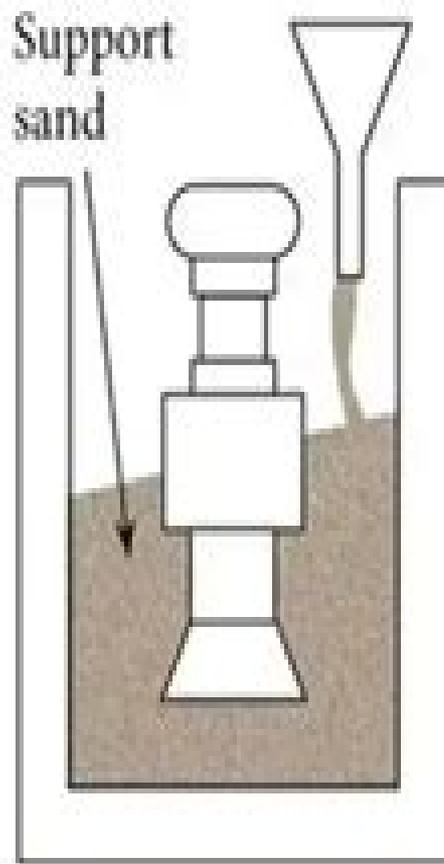


Polystyrene pattern



The Lost Foam Casting Process

Greg Sanders



The Lost Foam Casting Process:

Modeling of Metal/pattern Replacement in the Lost Foam Casting Process Taras Molibog,2002 *Mold Filling in the Lost Foam Casting Process* Ron Paul Walling,1992 *Program Management and the Lost Foam Casting Process* Greg Sanders,2000 *Gating Design and Mold Filling in the Lost Foam Casting Process* Mickey Dean Lawrence,1995 Gating and mold filling of castings in the lost foam casting process have been studied to determine the importance of processing parameters and how these parameters can be used to control mold filling The research in paper 1 describes the statistically significant effects of processing parameters and gating system design for an industry type hat shaped pattern on mold filling characteristics such as fill time horizontal velocities and vertical velocities The permeability of the refractory coating is the most important variable The metallostatic pressure head and the pouring temperature also affected the mold filling characteristics to a smaller degree A maximum velocity about 1 in s cannot be exceeded if a sound castings is to be produced Paper 2 describes how processing parameters might be used to predict and control the mold filling in the lost foam casting process The research involved four steps Step 1 which used a pattern for a tube holder for a heat exchanger the pendant pattern explored ways to force the pattern to fill faster than the runner and to skew the progressing metal front towards the gates in order to force any foam decomposition products into the gating system Although some improvements were made this was only accomplished when a straight plate pattern was substituted for the curved pendant pattern Step 2 used the information from step 1 and previous work to produce a model which predicted the position of the molten metal front throughout the filling process of a pump housing pattern It was found that intersections involving sharp direction changes from vertical to horizontal flow have a sizable effect on the velocity of the molten metal front as the pattern fills The slope of the line when actual time was plotted versus the expected time also differed because the actual pattern had a higher density than those used to produce the model Step 3 explored in more detail the effect that sharp direction changes have on mold filling characteristics in simple plate patterns The effect of the intersection on the flow of the molten aluminum was confirmed The change in velocity was measured as a jump in the elapsed time when plotted against the predicted time Step 4 included the effect of the intersection on the predicted metal front progression in an industry type pipe pattern casting The predictions were not confirmed suggests that the effect of intersections is more complex expected More research on the effect of direction changes must be performed in order to make a model that accurately predicts mold filling in the lost foam process Abstract leaves iv v **Casting Design and Performance** ,2009 **Handbook of Metallurgical Process Design** George E. Totten,Kiyoshi Funatani,Lin Xie,2004-05-25 Reviewing an extensive array of procedures in hot and cold forming casting heat treatment machining and surface engineering of steel and aluminum this comprehensive reference explores a vast range of processes relating to metallurgical component design enhancing the production and the properties of engineered components while reducing manufacturing costs It surveys the role of computer simulation in alloy design and

its impact on material structure and mechanical properties such as fatigue and wear It also discusses alloy design for various materials including steel iron aluminum magnesium titanium super alloy compositions and copper

Advanced Casting Technologies Dr.T.R Vijayaram,2018-05-02 Major casting processing advancements have been made in experimental and simulation areas Newly developed advanced casting technologies allow foundry researchers to explore detailed phenomena associated with new casting process parameters helping to produce defect free castings with good quality Moreover increased computational power allows foundry technologists to simulate advanced casting processes to reduce casting defects In view of rapid expansion of knowledge and capability in the exciting field of casting technology it is possible to develop new casting techniques This book is intended to discuss many casting processing technologies It is devoted to advanced casting processing technologies like ductile casting production and thermal analysis casting of metal matrix composites by vortex stir casting technique aluminum DC casting evaporative casting process and so on This book entitled *Advanced Casting Technologies* has been organized into seven chapters and categorized into four sections Section 1 discusses the production of ductile iron casting and thermal analysis Section 2 depicts aluminum casting Section 3 describes the casting manufacturing aspects of functionally graded materials and evaporative casting process Section 4 explains about the vortex stir casting technique to process metal matrix composite castings All the chapters discussed in detail the processing steps process parameters involved in the individual casting technique and also its applications The goal of the book is to provide details on the recent casting technologies

Proceedings of the National Conference on Investment Casting Biswanath Mondal,2004 Contributed papers presented at the conference held at Central Mechanical Engineering Research Institute Durgapur

ASM Handbook D. M. Stefanescu,1988 Gives you a thorough yet easy to understand introduction to the principles of composition control gas evolution in melts and inclusion forming reactions as well as the basic concepts of crystal growth and solidification that aids you with interpretation of structures This volume discusses casting molding and coremaking practices in a series of articles that describe the basic steps and equipment associated with each process along with their advantages limitations and applications Each article is preceded by a review of the manufacture design and selection of patterns

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Progress in Light Metals, Aerospace Materials and Superconductors Ya Fang Han,2007-05-15 *Proceedings 2006 Beijing International Materials Week* June 25 30 2006 Beijing China

Manufacturing Processes for Engineering Materials Serope Kalpakjian,Steven R.

Schmid,2008 This comprehensive up to date text has balance coverage of the fundamentals of materials and processes its analytical approaches and its applications in manufacturing engineering Proceedings of the ASME Materials Division,2003 *Marine Engineers Review* ,2001 **Transactions of the American Foundrymen's Society** American Foundrymen's Society,1999 **Rheology and Fluid Mechanics of Nonlinear Materials** ,2001 Papers presented at the ASME International Mechanical Engineering Congress and Exposition **F. Weinberg International Symposium on Solidification Processing** Metallurgical Society of CIM. Basic Sciences Section,1990 **The Foundryman** ,1994 *Aluminum Now* ,2001 **Popular Mechanics** ,1990

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