

intersection and acting as hindrance to quality. Hot metal leakage from the platen centre tends the formation of flashes adding extra weight to material.

#### **3.6.1. Case study**

Grid plate of Grade SG1500/71S1865 undertaken for study showed flashes defect.

#### **3.6.2. Causes**

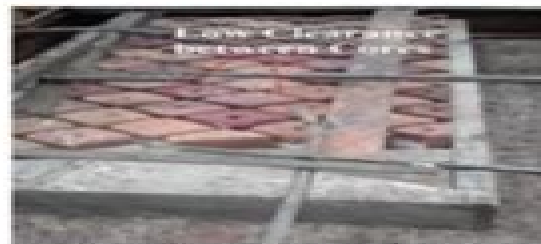
- Excessive Clearance between top and bottom parts of mould box.
- High pouring pressure.
- Use of mould with poor pattern designs.
- Patterns having cavities at the end.
- Improper clamping of top and bottom parts.



**Fig.14. Flashes**

#### **3.6.3. Remedial Measures**

- Sealing of mould box near parting line.
- Ensure end cavities to be filled to avoid metal leakage.
- Dimensions to be controlled.
- Carefully setting mould assembly.
- Proper core setting.



**Fig.15. Core Clearance Setting**

#### **3.7. Mismatch**

Mismatch is a defect in which shifting of top and bottom parts of a mould above or below the centerline takes place causing the casting to be defective. Segments dislocated above the centerline leads to this serious defect.

#### **3.7.1. Case Study**

Valve of Grade ASTM A216 WCB undertaken for study showed mismatch.

#### **3.7.2. Causes**

- Clamping cope and drag using worn out dowels.

# Analysis Of Casting Defects And Identification Of Remedial

**Linda Garverick**



## **Analysis Of Casting Defects And Identification Of Remedial:**

## Reviewing **Analysis Of Casting Defects And Identification Of Remedial**: Unlocking the Spellbinding Force of Linguistics

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