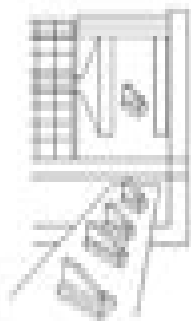


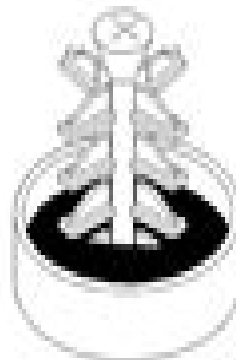
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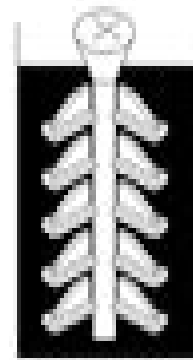
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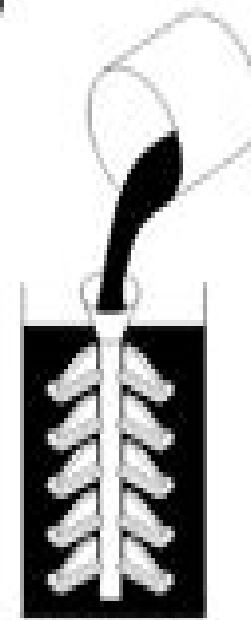
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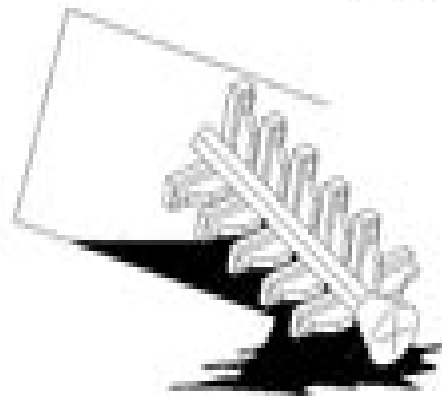
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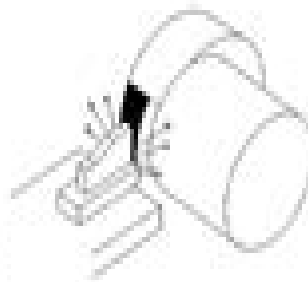
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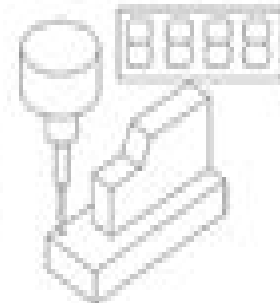
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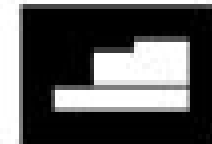
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The Lost Foam Casting Process

Taras Molibog



The Lost Foam Casting Process:

Program Management and the Lost Foam Casting Process Greg Sanders, 2000 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 **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 casting 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 **A Methodology for Monitoring the Metal-fill in Lost Foam Casting Process** Jeanison Pradeep Arulanantham, 2005 **Lost Foam Castings in Steel: Determination of the Foam Displacement Mechanism and Carbon Pick-up** Siddharth Gupta, 2008. Lost foam casting process has been widely adopted to manufacture complex parts without the need for cores. Numeric modeling of expanded polystyrene EPS foam displacement is only recently reaching a point where it can provide useful insight in helping optimize design and process variables. The objective of this thesis study

was to develop an understanding of the pattern replacement mechanism in the lost foam casting process in steels Abstract
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Experimental Modeling of the Metal/pattern Exchange Mechanism in the Lost Foam Casting Process

Taras Molibog,1999 **Casting Design and Performance** ,2009

Studies of Processing Parameters and Thermal

Properties of Mold in Lost Foam Casting Process Cunmin Wang,1995

Founding - Equipment for the Production of

Lost Patterns for the Lost Foam Casting Process Polska. Polski Komitet Normalizacyjny,2002 **Final Technical**

Report Quantification and Standardization of Pattern Properties for the Control of the Lost Foam Casting Process

,2005 This project takes a fresh look at the white side of the lost foam casting process We have developed the gel front hypothesis for foam pyrolysis behavior and the magnetic metal pump method for controlling lost foam casting metal fill event The subject of this report is work done in the improvement of the Lost Foam Casting Process The original objective of this project was to improve the control of metal fill by understanding the influence of foam pattern and coating properties on the metal fill event Relevant pattern properties could then be controlled providing control of the metal fill event One of the original premises of this project was that the process of metal fill was relatively well understood Considerable previous work had been done to develop fluid mechanical and heat transfer models of the process If we could just incorporate measured pattern properties into these models we would be able predict accurately the metal fill event As we began to study the pyrolysis behavior of EPS during the metal fill event we discovered that the chemical nature of this event had been completely overlooked in previous research Styrene is the most prevalent breakdown product of EPS pyrolysis and it is a solvent for polystyrene Much of the styrene generated by foam pyrolysis diffuses into intact foam producing a molten gel of mechanically entangled polystyrene molecules Much of the work of our project has centered on validation of this concept and producing a qualitative model of the behavior of EPS foam undergoing pyrolysis in a confined environment A conclusion of this report is that styrene dissolution in EPS is a key phenomenon in the pyrolysis process and deserves considerable further study While it is possible to continue to model the metal fill event parametrically using empirical data we recommend that work be undertaken by qualified researchers to directly characterize and quantify this phenomenon for the benefit of modelers researchers and workers in the field Another original premise of this project was that foam pattern and coating properties could be used to efficiently control metal fill After studying the structure of EPS foam in detail for the period of this contract we have come to the conclusion that EPS foam has an inherent variability at a scale that influences metal fill behavior This does not allow for the detailed fine control of the process that we originally envisioned We therefore have sought other methods for the control of the metal fill event Of those we now believe that the magnetic metal pump shows the most promise We have conducted two casting trials using this method and preliminary results are very encouraging A conclusion of our report is that while every effort should continue to be made to produce uniform foam and coatings the use of the magnetic metal pump should be encouraged and closed loop control mechanisms should be developed for this pouring

method *Thermal Degradation of Foamed Polymer Patterns in the Lost Foam Casting Process* Najeeb Quadeer, 2009 The thermal decomposition products and kinetic behavior of foam patterns constructed with expanded polystyrene EPS and expanded polystyrene polymethylmethacrylate EPS PMMA copolymers were evaluated in support of the lost foam casting LFC process development This research specifically investigated the effects of high temperature and radiant heat transfer to the foamed polymer patterns that are exposed to the molten metal during the steel casting process Abstract leaf iii

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 **Lost Foam Inside**, 2018 *Complete Casting Handbook* John Campbell, 2015-08-06 Campbell's Complete Casting Handbook Metal Casting Processes Techniques and Design Second Edition provides an update to the first single volume guide to cover modern principles and processes in such breadth and depth while also retaining a clear practical focus The work has a unique viewpoint interpreting the behavior of castings and metals as a whole in terms of their biofilm content the largely invisible casting defects which control much of the structure and behavior of metals This new edition includes new findings many from John Campbell's own research on crack initiation contact pouring vortex gates and the Cosworth Process Delivers the expert advice that engineers need to make successful and profitable casting decisions Ideal reference for those interested in solidification vortex gates nucleation biofilm remelting and molding Follows a logical two part structure that covers both casting metallurgy and casting manufacture Contains established must have information such as Campbell's 10 Rules for successful casting manufacture Includes numerous updates and revisions based on recent breakthroughs in the industry

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 **Casting Processes and Modelling of Metallic Materials**

Zak Abdallah, Nada Aldoumani, 2021-02-24 This book *Casting Processes and Modelling of Metallic Materials* explores the various casting and modelling activities related to metallic alloy systems The book provides results of research work conducted by experts from all over the globe to add to the research community in the era of the casting process and modelling The book was edited by two experts in the field of materials science and modelling Dr Abdallah and Dr Aldoumani whom both have several publications in peer reviewed journals worldwide conferences and scientific books The book introduces the casting processes and then discusses the various issues and possible solutions Over the past years various models have been proposed and utilized to predict the performance of castings Some of these models proved to be accurate whereas others failed to predict the casting performance The strength of any predictive tool depends on the employment of physically meaningful parameters that replicate the real life conditions This has been illustrated in the current book with such predictive models and finite element FE modelling to illustrate the behaviour of castings in real life conditions

Workshop Processes, Practices and Materials Bruce Black, 2015-03-27 *Workshop Processes Practices and Materials* is an ideal introduction for entry level engineers and workshop technicians as well as engineering university students with little or no practical experience With detailed illustrations throughout and simple clear language this is a practical introduction to what can be a very complex subject It has been significantly updated and revised to include new material on current Health and Safety legislation gauging and digital measuring instruments as well as modern measuring techniques such as laser scan micrometer co ordinate and visual measuring systems A new chapter on an introduction to CNC milling and turning has been added This book covers all standard workshop topics including safe practices measuring equipment hand and machine tools metal and plastics materials joining methods including welding presswork primary forming casting and moving loads making it an indispensable handbook for use both in class and the workshop Its broad coverage makes it a useful reference book for many different courses worldwide Health and Safety chapter covers current best practice and has been checked by a certified health and safety examiner Addition of modern measuring techniques using laser scan micrometer co ordinate and visual measuring systems Addition of an introduction to CNC milling and turning

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 GATE Question Bank -

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