



A Diagnostic Study on Sand Inclusion Casting Defect for Reduction in Rejection Level of Cast Iron Casting

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ABSTRACT: This paper presents the reduction of Sand Inclusion casting defect which occurs at different locations in motor stator housing casting of gray cast iron. Either a single cause or multiple causes may be responsible for this defect. This defect was the major cause of rejection in a medium scale foundry. Gating system fault was identified as one of the major causes responsible for defect. In this paper, two suggestions were proposed and implemented to reduce Sand Inclusion casting defect; i.e. to provide skim bob in gating system, and to mix 10% new sand during each cycle of sand preparation. Outcome of production trial shown considerable reduction in Sand Inclusion casting defect.

Keywords: Casting defects, Sand Inclusion, Gating system, Skim bob

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