

## Tailored feeding solution leads to reduced rework and improved yield



## KNOWLEDGE & PARTNERSHIP

### THE CHALLENGE

Limited space on the pattern plate prevented the use of conventional side risering for the castings. In order to pour two castings in one mould, the foundry developed a spot feeding solution using FEEDEX\* VAK customised collapsible metal core technology.

### FOUNDRY:

IRONCASTINGS SPA is a specialist producer of grey and ductile iron parts, located

in the North of Italy. They produce parts for the truck, agricultural, hydraulic, wind power and pump sectors amongst others. The foundry has an automatic HWS greensand moulding line and melting capacity of ca. 100 tonnes per day. They export ca. 50% of their production.



### PARAMETER

|                   |  |
|-------------------|--|
| Alloy:            | Ductile Iron<br>EN-GJS 400.3           |
| Casting Weight:   | 68.6 kg                                |
| Pouring Weight:   | 172 kg                                 |
| Pouring Time:     | 16 s                                   |
| Pouring Temp.:    | 1380 °C                                |
| Moulding Process: | Horizontal green<br>sand moulding line |

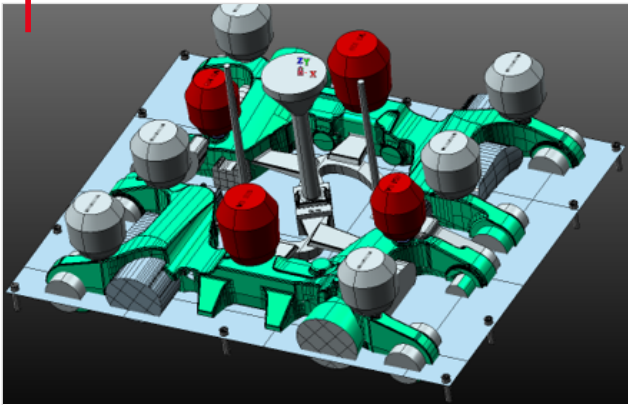
### FOSECO PRODUCTS

FEEDEX\* HD1 VAK 159/64 M  
FEEDEX HD1 VAK 339/61 M  
SEDEX\* 75x75x22 10ppi

## OUR SOLUTION

Tailored metal breaker core design enabling spot feeding of critical areas within the casting.

Cope pattern plate with FEEDEX VAK sleeves positioned



## KEY BENEFITS

- Increased productivity (pattern plate utilisation)
- Improved casting yield from VAK feeders
- Minimum footprint and contact to the casting – reduced fettling
- Customised solution

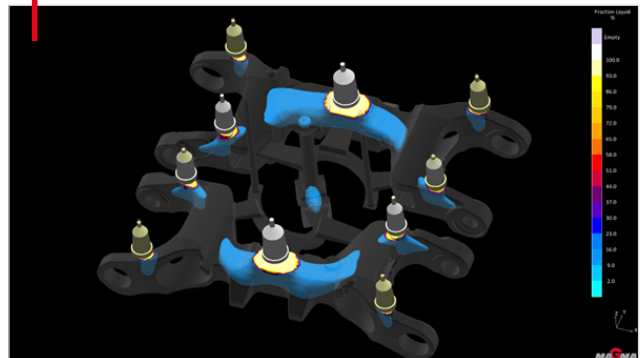
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## THE OUTCOME

Improved pattern plate utilisation (productivity) and casting yield. The minimum contact area of the FEEDEX VAK feeders ensures fettling work is reduced to a minimum.

MAGMA Soundness View



MAGMA Fraction Liquid View



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