



Chapter V MAKING MOLDS

Castings are made by pouring molten metal into refractory molds and allowing the metal to solidify. The solidified metal will retain the shape of the mold cavity and can be removed from the mold when the metal is solid. A mold is made by shaping a suitable sand mixture around a pattern of the desired form. A metal or wood box (flask) is used to retain the sand. The pattern is then removed from the sand, leaving a cavity in the sand into which the molten metal can be poured.

The molder's skill is the basic skill of the foundry. He must know how to prepare molds with the following characteristics:

1. Strong enough to hold the weight of the metal.
2. Resistant to the cutting action of the rapidly moving metal during pouring.
3. Generate a minimum amount of gas when filled with molten metal.
4. Constructed so that any gases formed can pass through the body of the mold itself rather than penetrate the metal.
5. Refractory enough to withstand the high temperature of the metal, so it will strip away cleanly from the casting after cooling.
6. Collapsible enough to permit the casting to contract after solidification.

during casting. The pins and fittings should be continually checked for wear and misalignment to avoid mismatched or shifted molds.

The use of steel flasks is preferred, but cases will arise requiring a size of flask not available. Under such circumstances, a flask may be constructed of wood. It should be husky enough to stand wear and tear. If it is planned to use the flask for several molds, allowance should be made for some burning of the wood, which will often occur when the metal is poured.

A flask is made of two principal parts, the cope (top section) and the drag (bottom section). When more than two sections of a flask are necessary, either because of the size or design of the casting, intermediate flask sections, known as cheeks, are used.

HAND TOOLS

RIDDLES are used for sifting the sand over the surfaces of the pattern when starting a mold. The size of the riddle is given by the number of meshes to the inch. A No. 8 riddle has eight meshes per inch, a No. 4 riddle has four meshes per inch, etc. The particular riddle used depends on the kind and character of casting to be made; castings with fine surface detail require finer sand and a finer riddle.

RAMMERS are used for tamping the sand around the pattern in the flask. For the heavier class of molding, they are made of

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