

The Basics

Company Name:

Contact:

Address:

City:

State / Province:

Zip:

Country:

E-Mail:

Telephone:

Fax:

Molding

1. Size of Area for Molding (Site Drawing would be Helpful)?
2. Half Mold Size (Cope OR Drag)
First (2) Values should be the overall minimum and maximum size to be made in this area.
Minimum - Length x Width x Height
Maximum - Length x Width x Height

Next (2) Values should be the typical minimum and maximum size to be made in this area that will cover 80-90% of the work for the area.
In many jobbing foundries, there are often odd large or small sizes that are run very rarely. These values should be for the sizes that are run regularly and are NOT the rare items that are encompassed in above.
Minimum - Length x Width x Height
Maximum - Length x Width x Height

Average Size to be used for Molds/Hour Calculations
Length x Width x Height
(If left blank, we will assume halfway between the Typical Minimum and Typical Maximum)
3. Estimated Maximum Half Mold Weight? lbs.

Estimated Average Half Mold Weight? lbs.

Estimated Maximum Closed Mold Weight? lbs.

Estimated Average Closed Mold Weight? lbs.
4. Number of Mold/Core Boxes to Run Simultaneously on the Loop?
5. Desired Full Mold Production Rate per Hour?
(We will assume 2 mold halves per full mold unless otherwise specified.)
6. Estimated Strip Time?
7. Level of Automation?: Full Semi Manual
8. Flaskless Cope/Drag Boxes
 In-Flask Cope/Drag with Separate Pattern Plates
 In-Flask Dual Sided Matchplate Patterns
9. Bottom Board Type? Other:
10. Pattern Mount Board Type? Other:
11. Pattern/Board Material? Other:
12. How Many Shifts Will the Molding System Run?
13. Additional Molds/Hour Capacity to Design into the System? %
14. Do you require the following?
 Sand Heater Sand Cooler Primary Sand All Sands

Mold Handling

Mold Wash

1. Water or Alcohol
2. Flow-coat Spray Swab
3. Mold Handler Tilt Device Rolling Device
4. Drying Oven?:
5. Preheat Required before Mold Wash Application? Yes No

Mold Closing

1. Mold Handler Required? Yes No
If yes: Scissor Style Gantry Style
2. Minimum Number of Cores Per Mold?
3. Maximum Number of Cores Per Mold?
4. Average Number of Cores Per Mold?
5. Current Average Time for Core Placement?

Pouring

1. Primary Metal Poured?
Maximum Casting Weight:
Average Casting Weight:
2. Type of Castings Produced?
3. Is Separation of Alloy or Heat Required? Yes No
4. Is Pouring Continual or Batch-Poured? Continual Batch
5. Estimated Number of Molds Staged for Pouring?
6. Conveyor Pouring Floor Pouring
7. Average Cooling Time per Mold?
8. Is There Sufficient Pouring Capacity to Match Above Molding Requirements?
 Yes No
9. Is Mold Clamping Required for Pouring? Yes No

Reclamation

1. Shakeout Method? Shakeout Deck Manual on Floor or Other:
2. How Many Shifts will the Reclamation System Run?
3. Estimated Average Sand Temperature at Shakeout (°F)?
4. Magnetic Separation Required? Yes No
5. Sand Cooling Required? Yes No
6. Mechanically Reclaimed Sand Will be Fed to: Mixer Thermal Reclaimer Both Mixer and Thermal Reclaimer
7. Does a Thermal Reclaimer already exist in facility? Yes No
If no, are there any plans to add one in the future? Yes No