Casting Operations for Green Sand Molding

Mold Process
- Automated Green Sand
- Manual Green Sand

Core Process
- Automated SO2
- Shell
- No Bake

Tooling Set Up
(Select mold and core type)

Build Mold & Set Cores

Pour Certified Alloy

- Shake Out Mold
- Core Knock Out
- Degate Part(s)

Cleaning
(Flash and parting line removal)

Welding / Rework

Molding Sand Prep.
(Sand control utilizing PLC controls and lab testing)

Return Sand for Reprocessing

Alloy Process
- Certified Material
- Traceable Heats
- Specific Gravity Test
- Spectrochemical

Alloy Returns
(Reprocessing of gates and risers)

Heat Treat / Self Age

CNC Machining

Perform Finishing Operations

Final Q.C. Inspection

Physical Properties Testing
- Test Bars
- Hardness

Chem. Treat
- Paint
- Anodize
- Plate
- Polish
- Assembly
- Vibratory Debur
- Shot Blasting

Real Time X-Ray
- Dye Penetrant Testing
- CMM Dimensional Measurement
- Visual Inspection
- Vacuum/Pressure Testing

Package & Ship