CRACKED OR BROKEN MOLD

Formation of large thin fins in planes related to the position of the casting in the mold. Cracks initiate at the surface of the mold cavity and extend through the zones of least resistance of the mold.

Possible Cause

The mold has been cracked:
- During the investment of the pattern.
- At the time of dewaxing.
- During the course of thermocycling to which the mold is subjected (block mold).
- As a result of poor choice of material or because of inadequate strength of the coatings.