A 212 - Cast Iron, Green Sand

AFS test casting for study of defects.

Remedy: Employ a sand of sufficient resistance to erosion.

Figure 20

Sand

Non-geometric projections on the vertical or oblique surfaces of the casting in the direction in which the mold is closed or in which a core is placed. Generally the defect can be found in numerous areas of the same casting, often combined with sand inclusions.

Possible Cause

During mold closing, particularly when there are high mold projections, corners or surfaces of the mold rub against each other causing a tearing away of sand (see sketch). This defect can also occur upon closing the mold after the setting of the core.

Remedies

- Improve the design of the casting if possible in order to provide greater draft or increased wall thickness.
- Use adequate alignment pins or positioning devices during the closing of the mold.
- Use caution in closing the mold to verify that rubbing has not occurred.