DEFORMED PATTERN

The casting shows general or localized distortion in comparison with the drawing, but not with respect to the pattern which itself is deformed in the same manner. The distortion is consistent from one casting to another.

Recommended Remedies

— Check the construction of the pattern.
— Use pattern lumber of proper quality and type for the application.
— Select a class of pattern appropriate for the kind of castings and molding method involved.
— Store patterns in an area of constant temperature and humidity.
— Stack patterns carefully using suitable supports.
— Avoid bending the pattern or pattern plate during mounting or dismounting from the molding machine.
— Avoid pickup of moisture by the pattern from the mold by using a good surface coating (lacquer, varnish, etc.) and by limiting the length of time the pattern is embedded in the sand.
— In matchplate molding, be sure both flask halves are filled with sand before squeezing (Ed. note).