A portion of the casting is missing. The cope surface is usually concave and the sidewalls may extend upwards as fins which more or less follow the edges of the mold.

The missing portion, especially in the case of thick parts, may be localized within the interior of the casting, which appears to have been drained.

Do not confuse with E 121 (misrun) and E 122 (poured short).

Possible Causes
- Poorly-sealed mold or insufficient strength of mold walls or cores (esp. for thick castings); the walls break under high metallostatic pressure.
- Negligence in sealing holes used for mold or core assembly.
- Poorly-sealed core vents.
- Surfaces of cope and drag pattern plates do not match (warped). In hand molding - poorly-sealed mold joint; in machine molding - warped plates.
- Insufficient mold weights or clamping force (see also defect A 121).
- Premature shakeout (casting not solidified).

Note: In the case of an improperly weighted or clamped mold, this defect occurs in conjunction with defect A 121 (raised mold).

Remedy
Correct the possible causes listed above.
E 123 - Cast Iron, Green Sand
Pillow block cover of gray cast iron. The mold cavity partially drained after being completely filled. Clamp or weight the flasks adequately.

E 123 - Cast Iron, Dry Sand
Gray iron casting. After complete filling of the mold cavity, a large internal core filled with coke developed a crack and allowed a portion of the iron to drain slowly into the center of the core.

E 123 - Aluminum Alloy, Permanent Mold
Permanent molded aluminum alloy piston; runout occurred due to premature opening of the mold.

E 123 - Malleable Iron, Green Sand
Differential housing of malleable iron. Metal has partially drained away after filling of the mold due to mold rupture at the parting line adjacent to the runners.