SHIFTED CORE

All castings made with cores produced from core boxes with parting lines, or with core assemblies.

The two parts of the casting cavity formed by a core show a relative displacement parallel to the parting line of the core (a plane corresponding to the parting line of the core box). Considered separately, the two halves of the cavity correspond well to the drawing so far as shape and dimensions are concerned.

Recommended Remedies
- Assure that core box halves are properly matched.
- Reduce clearance between core box pins and bushings.
- For pasted cores, be sure both parts are exactly aligned.

RAMOFF, RAMAWAY

A thickening of the casting in the vicinity of the parting line (a) or an increase in dimension of a surface parallel to the parting line (b). It resembles defect F 221 (shift), from which it differs by virtue of the fact that the projections are not equal, and in opposite directions, around the parting plane.

Possible Cause
Improper ramming of the mold has caused the sand to separate away from certain vertical walls of the pattern.

Remedy
Pay close attention to mold ramming.