

## **Iron Sand Casting,China Iron Sand Casting , Iron Sand CastingManufacturers**

In a two-part mold, which is typical of sand castings, the upper half, including the top half of the pattern, flask, and core is called cope and the lower half is called drag. The parting line or the parting surface is line or surface that separates the cope and drag. The drag is first filled partially with sand, and the core print, the cores, and the gating system are placed near the parting line. The cope is then assembled to the drag, and the sand is poured on the cope half, covering the pattern, core and the gating system. The sand is compacted by vibration and mechanical means. Next, the cope is removed from the drag, and the pattern is carefully removed. The object is to remove the pattern without breaking the mold cavity. This is facilitated by designing a draft, a slight angular offset from the vertical to the vertical surfaces of the pattern. This is usually a minimum of 1° or 1.5 mm (0.060 in), whichever is greater. The rougher the surface of the pattern, the more the draft to be provided. sand casting, cast iron casting

