

Manufacturing Process Horizontal Mold / DISA Sand Casting

Melting

- Chemical Analysis
- CE, Temperature check

Pouring Amount

- Load Cell Auto Weigh

Sand preparation

- Compatibility, Moisture
- Strength, IG Loss
- Active Clay, Total Clay

Molding

- Compressive strength
- Mold check & Heat up

Nodularization

- Auto Feeding
- Error Proof system

Inoculation

- Auto Feeding M/C

Pouring

- Chemical component (n=1/ladle)
- FCD_Nodularity ratio Tester (n=1/Ladle)
- FC_Plate Chill Tester (n=1/Ladle)
- Temperature Check (n=1/mold)
- Area possession for identifying process defects mold

Cooling

Cutting(Riser / Gate)

Inspection

- Visual Check
- Mechanical Test
- Matrix Check
- Dimension Check

Deburring

- Bending Gage Check
- Surface Check
- Dimension Check

Final Inspection

- Final Visual Inspection

NDT

- MPI
- UT



Manufacturing Process Lost Wax Casting

- Injection Wax
- Assembly Tree
- Cleaning
- First Coating
- Drying
- Back up Coating
- Drying
- De-Wax
- Burn out / Preheating
- Melting
- Pouring
- Releasing mold
- Cutting
- Cleaning Surface
- Inspection



Products (Horizontal Mold / Disa Sand Casting)

Bearing Cover, Support Plate, Adjust Ring, Shift Block

Material: Ductile / Grey Iron

Finish: E-Coating / Zn Plating / Induction Hardening



Products (Lost Wax Casting)

Cover, Impeller, Valve & etc

Material: Carbon Steel, Alloy Steel, Stainless Steel, Heat-Resistant Steel, Super Alloy & Ti

