

You can rely on FEEDEX*
- even when subjected to
the highest pressures



KNOWLEDGE & PARTNERSHIP

THE CHALLENGE

The elevated position of the spot feeders on the cope pattern, meant that there was insufficient height available between the moulding press head and feeder sleeve. We therefore had to develop a customised FEEDEX sleeve for the application, with the required modulus and volume to deliver shrinkage free castings.

FOUNDRY:

IRONCASTINGS SPA is a specialist producer of grey and ductile iron parts, located

in the North of Italy. They produce parts for the truck, agricultural, hydraulic, wind power and pump sectors amongst others. The foundry has an automatic HWS greensand moulding line and melting capacity of ca. 100 tonnes per day. They export ca. 50% of their production.



PARAMETER

Alloy:	Ductile Iron EN-GJS 400.3
Casting Weight:	40.7 kg
Pouring Weight:	195 kg
Pouring Time:	21 s
Pouring Temp.:	1380 °C
Moulding Process:	Horizontal green sand moulding line

FOSECO PRODUCTS

FEEDEX HD1 VSK 319/37 MH
SEDEX* 75x75x22/10 ppi

OUR SOLUTION

Develop a customised FEEDEX sleeve with reduced height, to fit between the cope pattern and press head of the moulding line. Whilst meeting the requirements for reduced height, it was necessary to ensure that the feeder delivered the required modulus and volume for the casting.

Cope pattern plate showing elevated spot feeder position



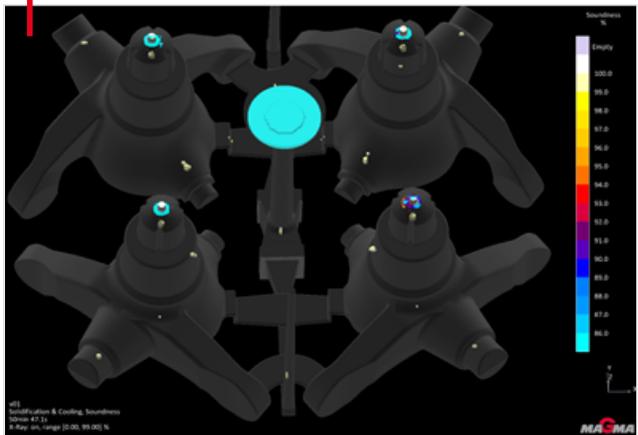
THE OUTCOME

The high-pressure resistance of the FEEDEX material allows spot feeder application in the most demanding applications. In this case, the feeder is located only 15mm beneath the press head of the moulding line. Productivity and yield were maximised by the utilisation of spot feeding.

MAGMA fraction liquid view



MAGMA Soundness view



KEY BENEFITS

- Customised FEEDEX design allows optimal spot feeder location beneath the press head
- FEEDEX resistance to extreme moulding pressures ensures feeders do not crack or break during moulding
- Improved productivity and yield
- Minimum footprint area – reduced fettling costs

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