Sand Coated Iron Mould Process

Case 1: Crankshaft

Material: High grade ductile iron (QT600-3~QT800-2)
Weight: 1~500kg
Process: Sand coated iron mould
Production efficiency: 20-40 mould/H

The ductile iron crankshaft produced by sand coated iron mould casting process can obtain sufficient fatigue strength and rigidity, and good wear resistance.
## Advantage

<table>
<thead>
<tr>
<th>Technical indicators</th>
<th>Sand coated iron mould</th>
<th>Sand casting</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nodulizing grade</td>
<td>1~2</td>
<td>2~4</td>
</tr>
<tr>
<td>Size of graphite</td>
<td>6~7</td>
<td>5~6</td>
</tr>
<tr>
<td>Ra (μm)</td>
<td>6.3~12.5</td>
<td>25~100</td>
</tr>
<tr>
<td>Dimension tolerance</td>
<td>CT 6~7</td>
<td>CT 9~13</td>
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<tr>
<td>Weight tolerance</td>
<td>MT 7~9</td>
<td>MT 9~13</td>
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</tbody>
</table>
Sand casting:
Large riser, poor surface quality

Sand coated iron mould casting:
No riser, good surface quality

Disa mould line:
Process yield: 60%.

Sand coated iron mould casting
Process yield: 80%

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