

Combined advantages

the productivity and economy of Green Sand Process and the superior quality of Low-pressure Die-casting Process

Green Sand Low - Pressure Casting Process

For producing quality aluminium castings utilizing existing Green Sand Molding

Eco
conscious

- Gas inclusion 1/2 *¹ (Decreasing reject ratio)
 - Equipment depreciation per piece of casting. Reduced by 10% *²
 - Pattern yield. Increased by 10% *²
- *¹ Compared to gravity die-casting.
*² Compared to pressure die-casting



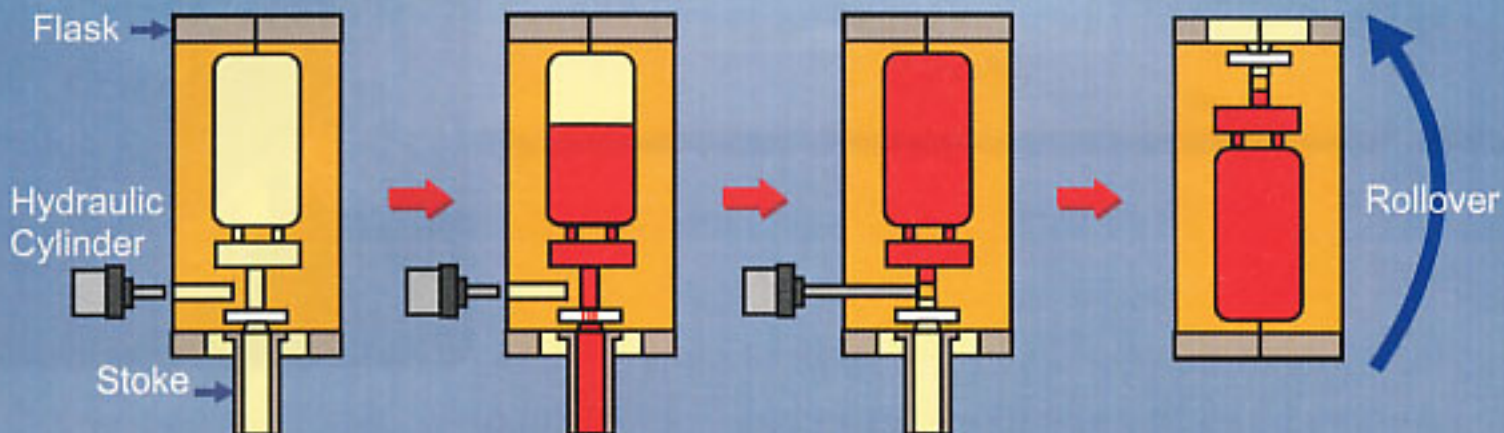
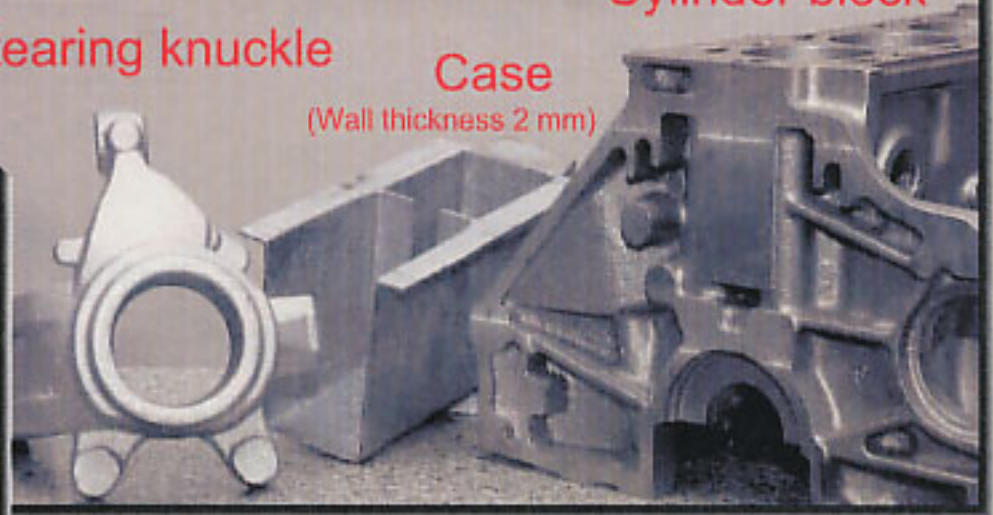
Examples of products

Steering knuckle

Cylinder block

Case

(Wall thickness 2 mm)



Set the mold
at pouring
station

Molten metal
filling by low-
pressure
method

Gate shutting
by cylinder
pressure releasing

Upside down
Transportation



Responding to the Needs of Environment

① Upgrading the quality

As the pouring is performed by low-pressure casting method, the casting rejects caused by gas and oxide inclusion are remarkably reduced.

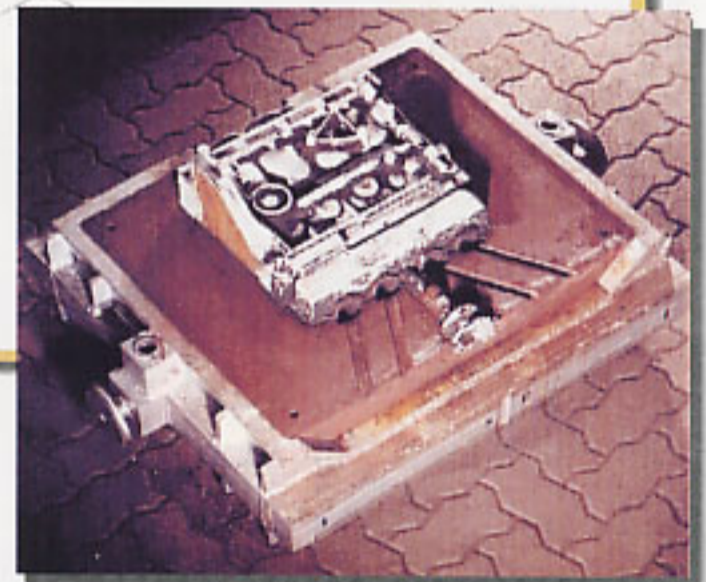
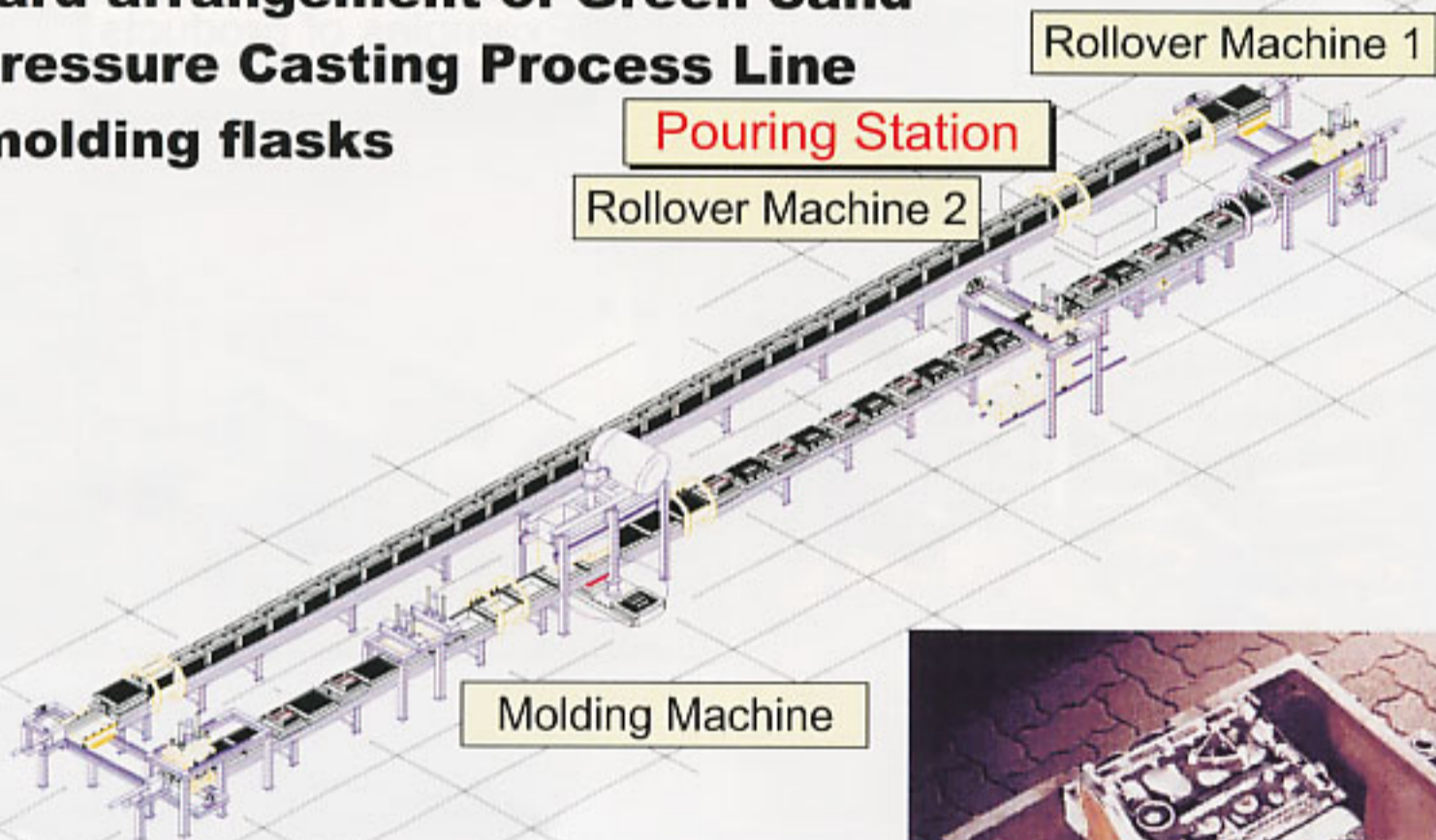
② Improving pattern yield

Pattern yield is improved for about 10% due to the simplified gating systems.

③ Higher productivity

The total productivity is substantially improved by shortening the waiting time for metal solidification in the mold as the new method shuts off the runners by green sand plug and rolls over the whole mold.

Standard arrangement of Green Sand Low-pressure Casting Process Line with molding flasks



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