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Effect of Melt Velocity on Density of Aluminum Alloy Castings in Expendable Pattern Casting Process

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著者

Sadatoshi Koroyasu

概要

The casting defects inside the aluminum alloy castings in the expendable pattern casting process were evaluated by measuring the density of castings. There was the tendency for the casting density to decrease with increasing melt velocity. In the case of bottom pouring, the casting density with reduced pressure is larger than that with non reduced pressure. In the case of top pouring, the casting density was higher than that in bottom pouring, and the effect of the reduced pressure was not significant.