

METAL FILLING CHARACTERISTICS OF ALUMINIUM LOST FOAM CASTING

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A report submitted in partial fulfillment of the  
requirements for the award of the degree of Master of Engineering  
(Mechanical- Advanced Manufacturing Technology)

Faculty of Mechanical Engineering  
Universiti Teknologi Malaysia

NOVEMBER 2009

To my beloved Mother, Father and Sisters

## ACKNOWLEDGEMENTS

In preparing this report, I was in contact with many people, academicians and lecturers. They have contributed towards my understanding and thoughts. First of all, I wish to express my sincere appreciation to my postgraduate project supervisor, Professor Madya Dr. Mohd Hasbullah bin Idris for his encouragement, guidance, comments, advices and friendship during the duration of my undergraduate project. Without my supervisor's support and interest, this report would not have been the same as present here.

Besides that, I am also very thankful to casting laboratory technician, Mr. Wan for his guidance's and advice.

My fellow postgraduate students should be recognized for their support. My sincere appreciation also extends to all my friends and others who have provided assistant at various occasions. Their views and tips are very useful indeed. Unfortunately, it is not possible to list all of them in this limited space. Finally, I am very grateful to my family members.

## ABSTRACT

In the present research, experimental investigation of flow pattern of lost foam casting has been conducted. For this project, the investigation has main objectives to investigate the effect of sprue position, pouring temperature and different pouring condition on flow pattern of aluminium lost foam casting. Casting in the shape of step five with five sections were produced mainly using a foam density of  $16\text{kg/m}^3$  and pouring was made at two different temperatures of  $700^\circ\text{C}$  and  $740^\circ\text{C}$ , three different sprue positions (middle, 'full', right and left) and two pouring conditions (vacuum and non-vacuum). The results obtained shown that pouring temperature ( $700^\circ\text{C}$  and  $740^\circ\text{C}$ ) do not affect flow pattern for same sprue position. However, different sprue positions got different flow pattern Timing for molten aluminium to reach latest point 18 is faster for vacuum condition if compare with non vacuum condition. It is because vacuum machine has removed trapped air to make sure free flow of liquid casting material.

## ABSTRAK

Dalam kajian menunjukkan, siasatan percubaan bagi cara pengaliran aluminium (Al) telah dijalankan. Siasatan kesan pintu penuangan berlainan, suhu penuangan, dan keadaan penuangan adalah objektif –objektif utama bagi projek ini. Acuan-acuan dalam bentuk langkah seperti lima bahagian telah dihasilkan terutamanya menggunakan ketumpatan busa  $16\text{kg/m}^3$  dan penuangan adalah dibuat pada dua suhu yang berbeza ( $700^\circ\text{C}$  dan  $740^\circ\text{C}$ ), tiga jenis pintu penuangan, dan dua keadaan penuangan yang berbeza. Keputusan yang diperolehi menunjukkan suhu penuangan tidak mempengaruhi cara pengaliran aluminium bagi jenis pintu penuangan yang sama. Bagaimanapun, pintu penuangan yang berbeza menunjukkan cara pengaliran aluminium adalah berlainan. Masa bagi cecair aluminium untuk mengalir sampai titik terakhir adalah lebih pendek dalam keadaan vakum jika dibandingkan dengan keadaan tidak vakum. Ini disebabkan mesin vakum telah menghisap keluar semua udara untuk memastikan kebebasan pengaliran cecair aluminium (Al).

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## **CHAPTER 1**

### **INTRODUCTION**

#### **1.1 Background**

Lost foam casting (LFC) is a type of investment casting process that uses foam patterns as a mold. The method takes advantage of the properties of foam to simply and inexpensively create castings that would be difficult to achieve using other casting techniques.

Weldments and complex casting assemblies can be made using this near net shape casting process. Similar to lost wax investment casting, the process uses a single ceramic coat for process step reduction. This is a value added casting method, which reduces finish machining and increases foundry yield for overall project cost advantages. Lost foam casting allows for the casting of parts that would otherwise be difficult to achieve in metal casting.

This casting process is advantageous for very complex castings that would regularly require cores. It is also dimensionally accurate, maintains an excellent surface

finish, requires no draft, and has no parting lines so no flash is formed. As compared to investment casting, it is cheaper because it is a simpler process and the foam is cheaper than the wax. Risers are not usually required due to the nature of the process; because the molten metal vaporizes the foam the first metal into the mold cools more quickly than the rest, which results in natural directional solidification. Foam is easy to manipulate, carve and glue, due to its unique properties. The flexibility of LFC often allows for consolidating the parts into one integral component; other forming processes would require the production of one or more parts to be assembled.

The two main disadvantages are that pattern costs can be high for low volume applications and the patterns are easily damaged or distorted due to their low strength. If a die is used to create the patterns there is a large initial cost.

## **1.2 Problem Statement**

In previous, many of the considerations arise for lost foam casting process. Examples consideration are pouring temperature, heat transfer and foam decomposition, coating effect and others. Simulations and experiments can help for better understanding the complex mechanisms and interplay of different process parameters in the mold filling.

## **1.3 Objectives of Project**

To investigate the flow of molten aluminium in lost foam casting with constant pouring speed.



#### **1.4 Scopes of Project**

1. LFC (Lost Foam Casting).
2. Material to be investigated is aluminium.
3. Flow of 2 different pouring temperatures (700 <sup>0c</sup> , 740 <sup>0c</sup> )
4. Flow of 3 different position of pouring sprues.
5. Flow in vacuum and non-vacuum condition.

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