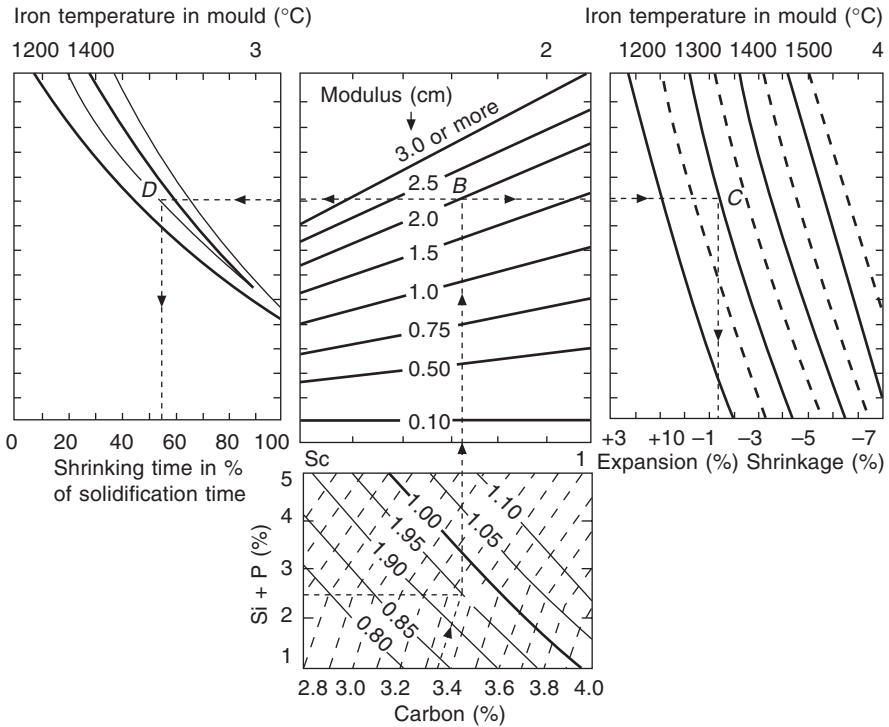




Estimation of shrinkage and shrinking time from Analysis, casting modulus and metal temperature in the mould.

Example: 3.35% C, 2.5% Si + P

Casting modulus:	2.0 cm
Casting temperature:	1300°C
Shrinkage:	1.6%
Shrinking time	55.0%

Figure 19.7 Determination of shrinkage time and shrinkage for grey and ductile iron castings.

demand of the casting section. This must always be checked and if the feeder is found to contain insufficient available feed metal the feeder dimensions must be increased. Generally it is preferable to retain the feeder diameter dictated by modulus considerations and increase the feeder height. Sometimes it is more convenient to increase the feeder diameter in place of or as well as height. Never reduce the feeder diameter below that necessary to meet modulus requirements.

The following data is necessary:

- The proportion of feed metal available from the feeder which meets modulus requirements (C%). Safe values although not necessarily the most effective are:
33–50% if a Foseco sleeve is being used;