

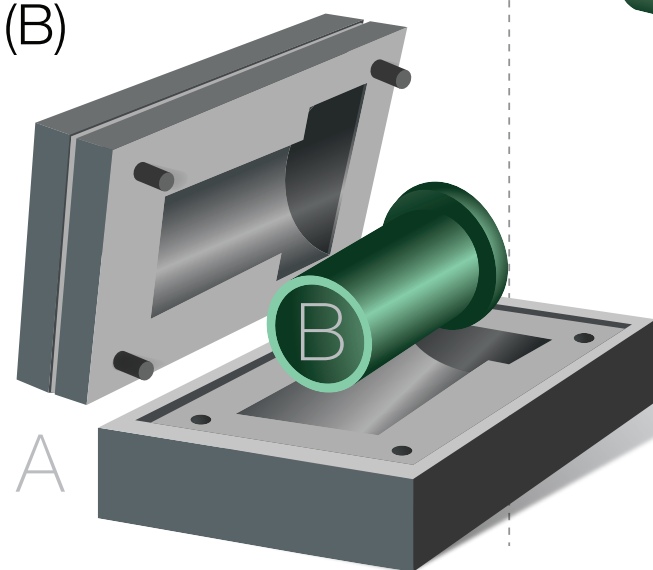
Investment Casting Process Steps

Kormax

1

Tooling and Pattern Making

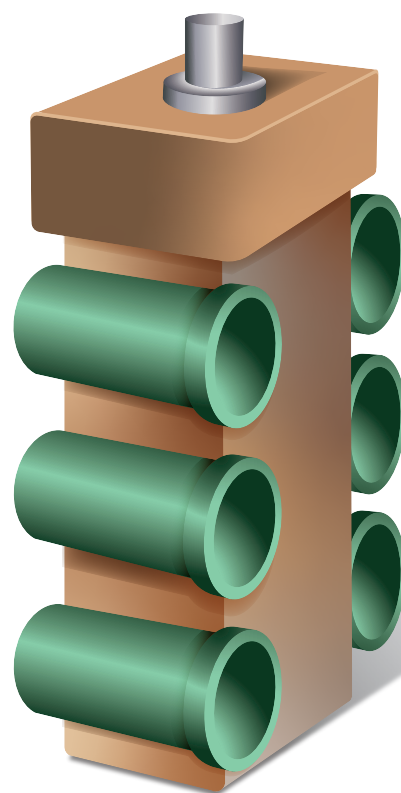
A tool is built to customer-provided specifications (A). Cold wax is then injected into the tool to create a wax pattern/prototype (B) that will hold precise dimensional requirements in the final casting.



2

Pattern Assembly

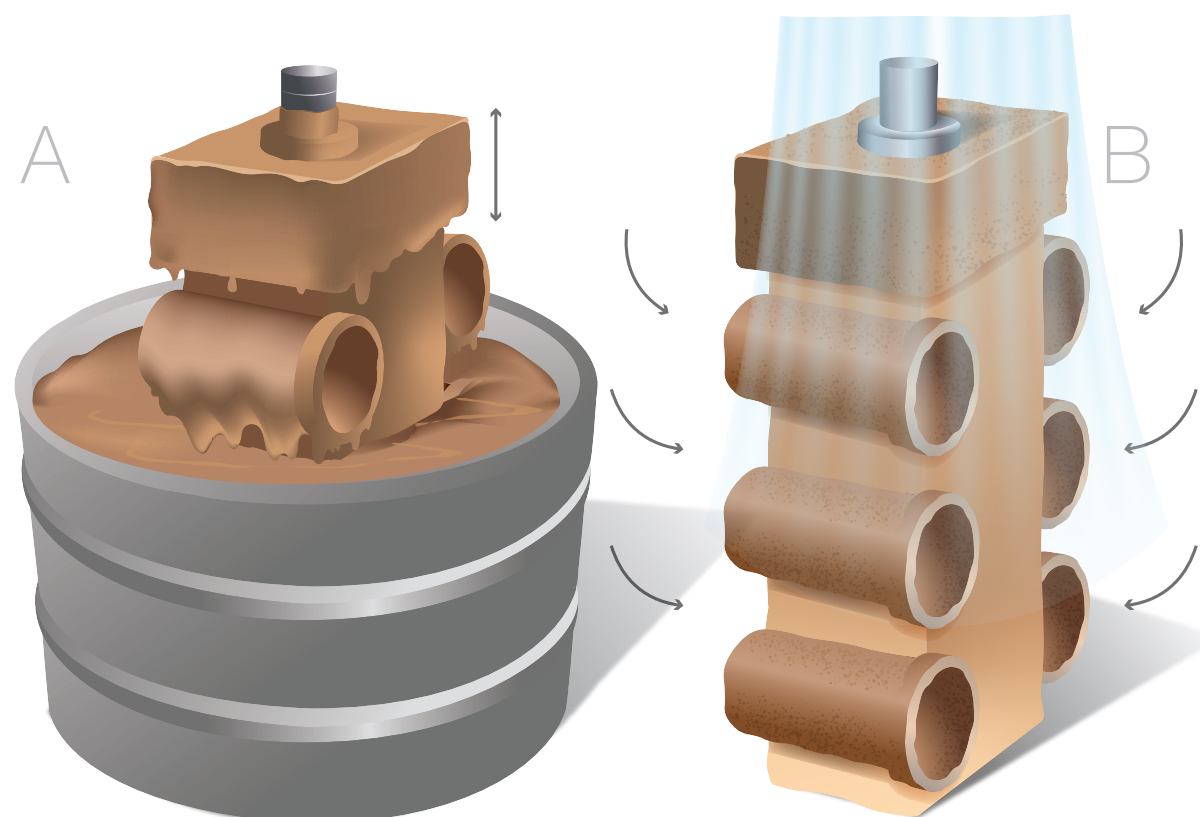
The wax patterns are assembled onto the sprue



3

Dipping and Coating

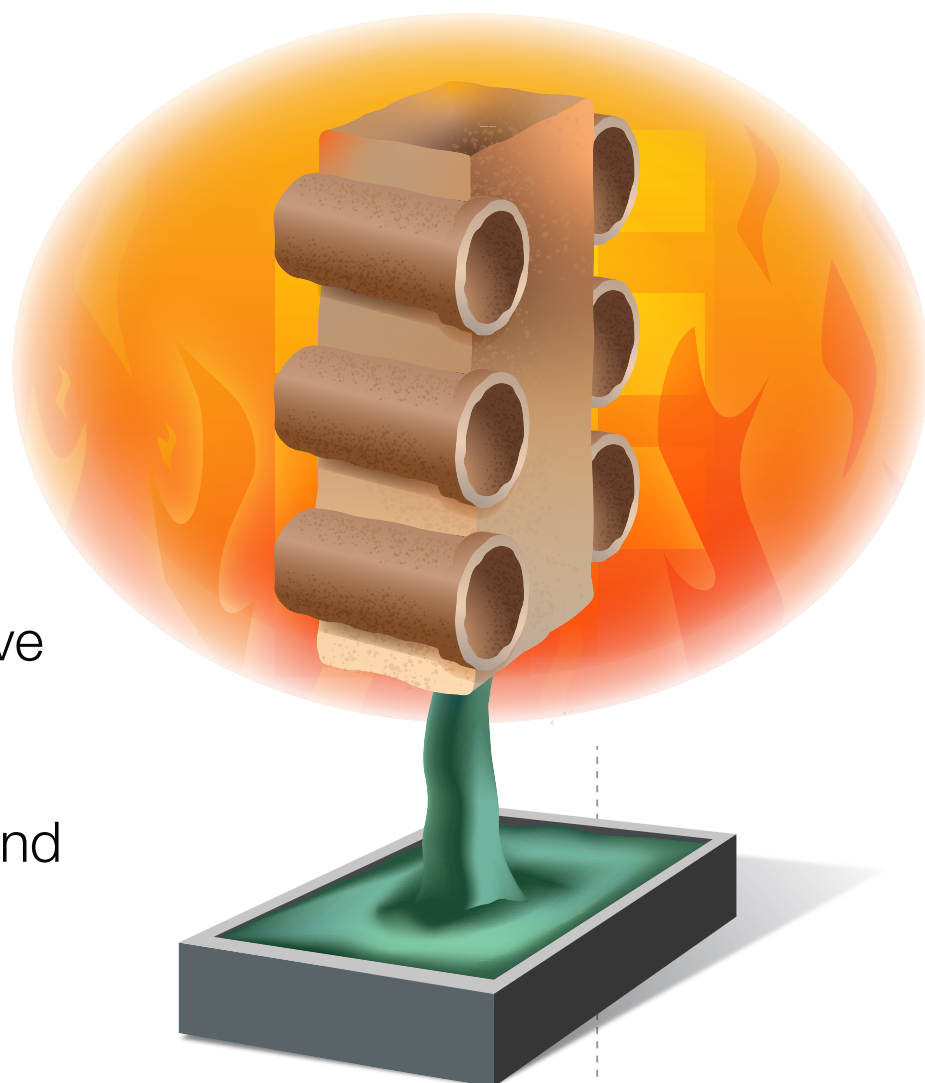
Successive layers of ceramic (A) and stucco (B) are applied to the sprue assembly to form a hard shell.



4

De-Waxing and Firing

The moulds are flash-fired to remove the wax and sprue materials and then heated to 1,800° and placed on a sand bed, ready for pouring.



5

Casting

Molten metal, up to 3,000°, is poured into the hollow mould and then cooled.



6

Knockout

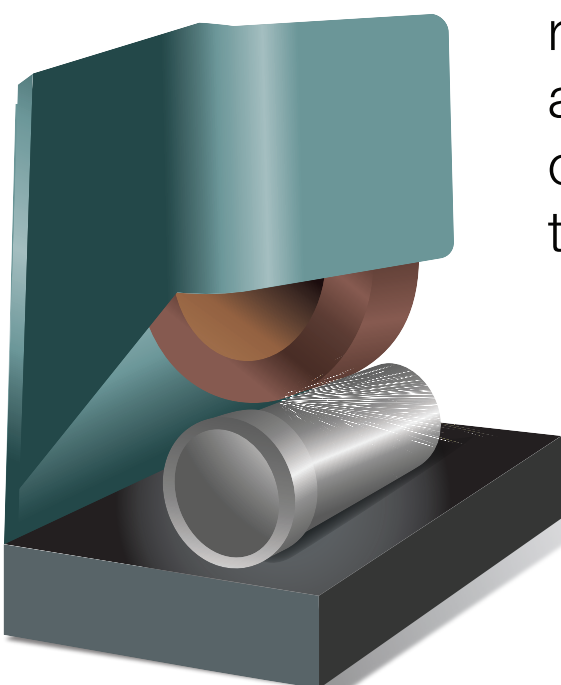
The ceramic shell is broken off, and the individual castings are cut away.



7

Finishing

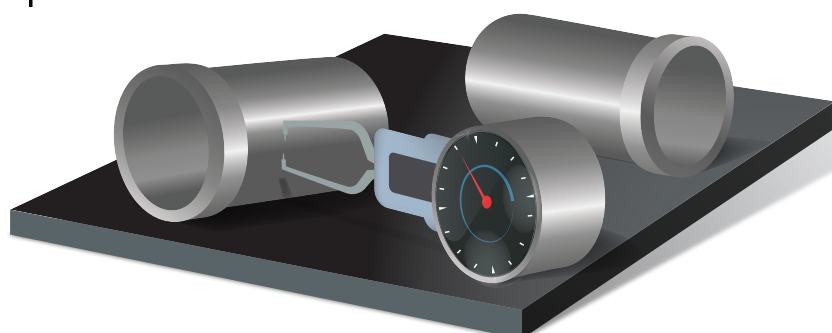
Excess metal is removed, surfaces are finished, and castings are heat treated



8

Testing and Inspection

Casting undergo through testing and inspection to ensure that they meet dimensional tolerances and specifications



9

Packing and Shipping

Castings are securely packaged for shipping to the customer.

