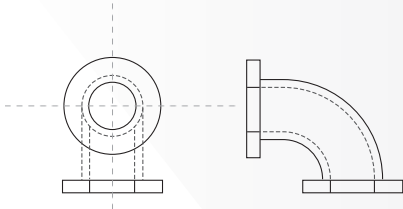
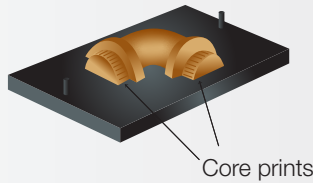


Sand Casting Process Steps

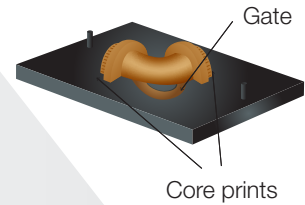
1 Mechanical drawing of part



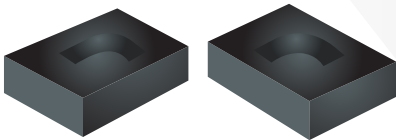
2 Cope pattern plate



3 Drag pattern plate



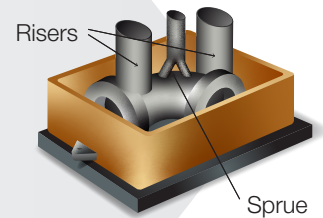
4 Core boxes



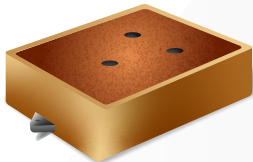
5 Core halves pasted together



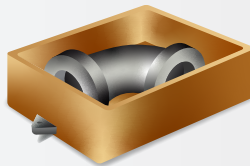
6 Cope ready for sand



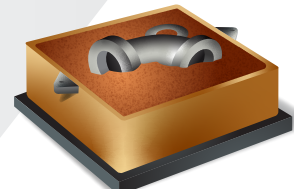
7 Cope after ramming with sand and removing pattern, sprue, and risers



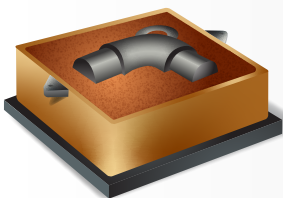
8 Drag ready for sand



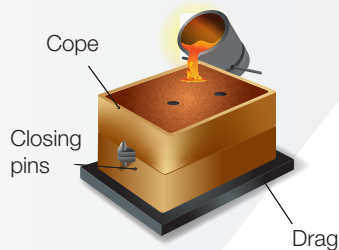
9 Drag after removing pattern



10 Drag with core set in place



11 Cope and drag assembled ready for pouring



12 Casting as removed from mould; heat treated



13 Casting ready for shipment

