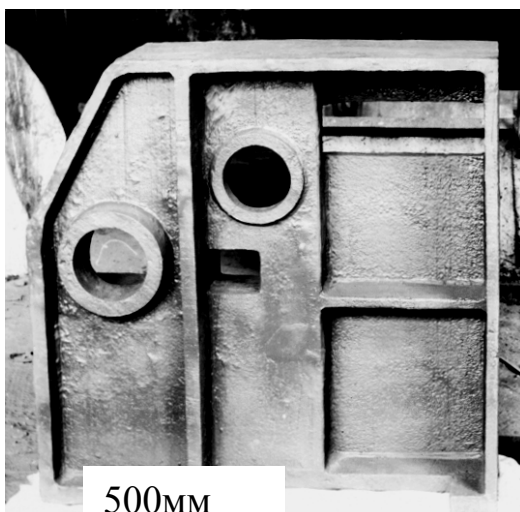
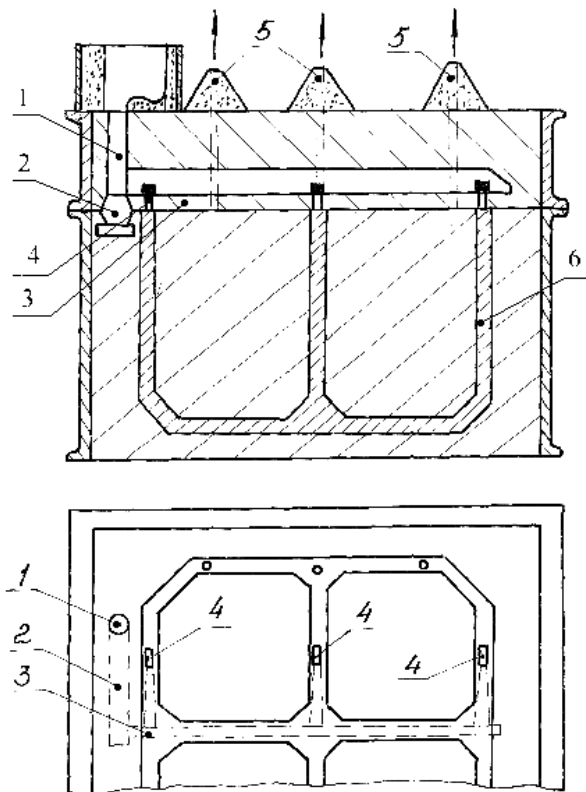




Technology of obtaining of large dimension in sand moulds castings by Lost-Foam (FULL MOULD process)

Full mould process (FMP) technology permits to obtain mould castings from gray cast iron, high-strength cast-iron, steel and non-ferrous alloys in temporary patterns from expanded polystyrene manufactured by methods of figured carving of bulk polystyrene ($\gamma \leq 0,03 \text{ g/sm}^3$) with the following gluing by synthetic glues (БФ-6 and ПВА). Manufactured and tinted by refractory paint patterns are formed in usual casting flasks simultaneously with patterns of gating system gas withdrawal system. Self-hardening mould blends on the base of quartz sand and liquid glass of synthetic gums are used as mould blend. Gasification of pattern happens in the process of pouring-in of mould by metal. Extraction of gas products of



1 –post ; 2 –slag catcher; 3 –gating runner; 4 –feeders; 5 –gas extraction channels; 6 – gasified pattern.

gasification is made by the special system of gas extraction into ventilation exhaust system with the subsequent after-burning. There are no limits for mass of casting.