



Casting Process Data Sheet

Gravity Die Casting

Contact name:

Company:

Address:

Tel:

Fax:

Email:

Website:

Date:

1- CAD(3D) or drawings

Casting (Raw)	Gating system	Dies	Cores	Die cooling	Furnace	Wight of cast part

2- Materials properties

Cast metal	Compositions %													
Alloys														

Die Material and coating				
Die Material	Die coating (permanent)	Die spraying (each cycle)	Die coating (each cycle)	Comments:

Gravity Die Casting

Core			
Sand Type	Coating	Binder	Initial core temperature

Others						
Cast temperature: [°C]		Degassing treatments		Filter		Grain refining treatment
				Type	Size	
Total weight of alloy cast: [kg]	Cycle Time [s]	Number of cycles to heat the die	Complete cycle time (cast to cast) [s]	Die opens after	Side cores withdrawal [s]	
Casting removal [s]	Start of spraying [s]	End of spaying [s]	Duration of spaying: [s]	Die closes after [s]	Start of filling (second cycle) [s]	

3-Pouring process

Pouring Temperature °C	Pouring time (S)	Pouring rate kg/s	Die Temperature °C

## Gravity Die Casting

Die cooling/ tempering		
Coolant	Cooling [s]	Cooling off [s]

Filling conditions					
Height of casting above hold bath: [cm]	Filling time: [s]	Filling pressure: [mbar]	Holding time: [s]	Holding pressure: [mbar]	Measured pressure profile available

Die thermocouples	
Measured temperature data available	Position

Any other process information which might affect the cast part please specify

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Thank you for your inquiry