

매몰이 주조에 미치는 영향

대구보건전문대학

-Anstract-

A Study on the Effects of Investment Factors on Casting

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This experiment was intended to obtain a perfect casting body the same as the original wax patterns by melting metal into the opening of the ring. The investment ring was dried to the temperature between 600 and 700 , when the wax pattern would be completely melted to leave an empty mould made in the ring.

The main point to studied was the investing process for perfect casting body. This process was experimented on several important factors: the size and spatulation of investment particles, purity of wax patterns, investing time after the completion of model, and investing temperature.

The results obtained from the above experiment were as follows: A desirable cast body with no fissure or pore would be mode by investing with smaller particles in the first time and with larger onces in the second, both at the temperature between 180.

I . 서 론

II . 실험방법

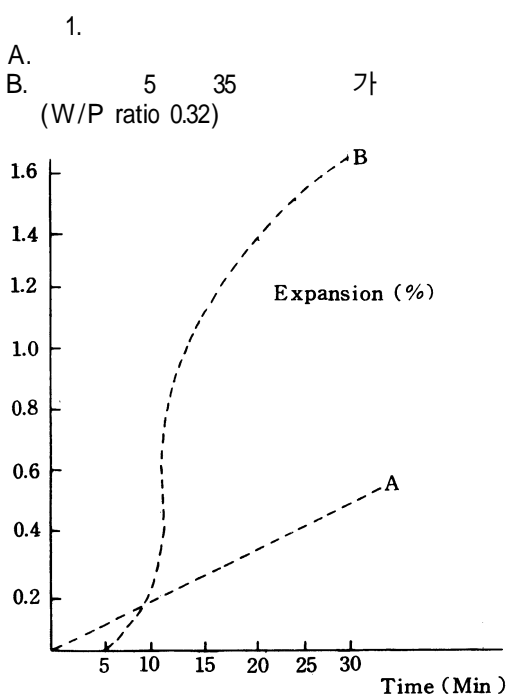
가

Wax Pattern
Wetting Agent hydrogen peroxide(
) Soap

가

Bureau of standard
1.5%

Tea spoon 0.5l
Wax Pattern Wetting Agent
Agent Pettern Wax Pattern die 1
가 Wax Wax Pattern 1,2 gold alloy 2 1
W/P ratio Wax Pattern 가 Mold gas가 2 Ring asbestos
35 가 가 1 가 가



Wax Pattern investment model Model 80 3 가
가 Wax Pattern Wax Pattern Ring furnace door 1 20
investment model refractory(10 650 20
burn out 20
burn out

Furnace 가 Ring Wax pattern die
 가 furnace Ring W/P
 Ring investment 가 ratio 가
 가 가 pyrometer c) fin
 가 furnace W/P over burn out
 Ring investment 가 가 Ring Mold
 pyrometer 가 가 d) Round Margin
 Reducing zone 가 furnace Mold 가
 Margin Casting
 gold alloy 가 Alloy가 , Mold gas가 가
 body가 Wax Pattern
 가 Margin()
 Flux e) pickling
 Oxide film() burn out
 pickling over heating
 sulfur gas가 Ring
 Melting f) Casting body가
 W/P ratio가
 over

III. 실험성적 및 고찰

a) 가
 ㄱ) Sprue Wire
 Sprue Wire 가

Mold
 ㄴ) Sprue Wire
 reservoir

b) 가 (Loose) 가
 ㄱ) 가 Ring 가

heating
 g) Casting body 가 metal
 (가
 Wax 가 Mold
 Reducing Agent

IV. 결론

Wax pattern □

참고문헌

1) 가

2) 오

Smooth

body

3) Working Model Die

가

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