

Investment Casting Technical Data at RMC Foundry

R&D	Software: Solidworks, CAD, Procast, Pro-e
	Lead Time for Development and Samples: 25 to 35 days
Molten Metal	Ferritic Stainless Steel, Martensitic Stainless Steel, Austenitic stainless steel, Precipitation Hardening Stainless Steel, Duplex Stainless Steel
	Carbon Steel, Alloy Steel, Tool Steel, Heat Resistant Steel,
	Nickle-base Alloy, Aluminium Alloy, Copper-base Alloy, Cobalt-base Alloy
Metal Standard	ISO, GB, ASTM, SAE, GOST EN, DIN, JIS, BS
Material for Shell Building	Silica Sol (Precipitated Silica)
	Water Glass (Sodium Silicate)
	Mixtures of Silica Sol and Water Glass
Technical Parameter	Piece Weight: 2 gram to 200 kilo gram
	Max Dimension: 1,000 mm for Diameter or Length
	Min Wall Thickness: 1.5mm
	Casting Roughness: Ra 3.2-6.4, Machining Roughness: Ra 1.6
	Tolerance of Casting: VDG P690, D1/CT5-7
	Tolerance of Machining: ISO 2768-mk/IT6
	Inner Core: Ceramic Core, Urea Core, Water Soluble Wax Core
Heat Treatment	Normalizing, Tempering, Quenching, Annealing, Solution, Carburization.
Surface Treatment	Polishing, Sand / Shot Blasting, Zinc Plating, Nickel Plating, Oxidation Treatment, Phosphating, Powder Painting, Geomet, Anodizing
Dimension Testing	CMM, Vernier Caliper, Inside Caliper. Depth Gage, Height Gage, Go/No go Gage, Special Fixtures
Chemical Inspection	Chemical Compostion Analysis (20 chemical elements), Cleanliness Inspection, X-ray Radiographic Inspection, Carbon-Sulfur Analyser
Physical Inspection	Dynamic Balancing, Static Blancing, Mechanical Properties (Hardness, Yield Strength, Tensile Strength), Elongation
Production Capacity	More than 250 tons per month, more than 3,000 tons annually.