



Fig 27

Diagram illustrating some of the features found in a commercial foundry pattern. (A) one of two pattern plates (the second, not shown, is similar in layout – but without a gating system, and forms a mirror impression in the drag box). (B) half of the design to be cast, in this case a total of 8 items are set out on the pattern plate in a radial layout. (C) half round runner layout, combines with the print in the drag to create a tubular running system for feeding the castings. (D) pattern print for locating the main ingate (F), which is tapered to assist it's removal after the sand is set hard. (E) registration points which locate the pattern plate with the cope box and the corresponding plate which forms the other side of the print in the drag box. (G) the cast design eventually formed from the prints (B) made in the sand from the two pattern plates.