

PERMANENT PATTERN

MAKE PIECE MOULD

SET RUNNERS & RISERS

DISASSEMBLE FLASK & SAND PIECE PARTS

REMOVE PATTERN

CUT CORE

APPLY SAND DRESSING

REASSEMBLE SAND PIECE PARTS, CORE & FLASK

FLOW CHART FOR SAND CASTING PROCESS

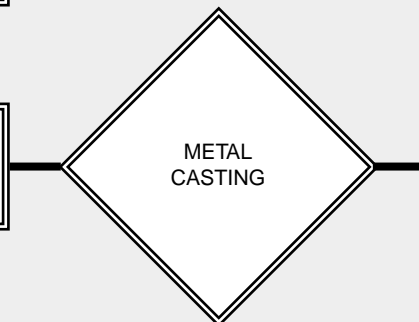
Stages of permanent and lost pattern sand casting process (as typically carried out in art foundries). Those aspects of the process which require direct participation, or approval, by the artist are highlighted in heavily blocked boxes.

LOST PATTERN (FOAM)

ATTACH METAL RUNNING SYSTEM

APPLY ANTI SAND BURN DRESSING TO THE PATTERN & DRY

RAM SAND AROUND PATTERN & SET HARD



KNOCK OUT & FETTLE

APPROVE CASTING

APPROVE FINISH (PATINATION)

INSTALLATION