



Shell Mold Casting for Intake Rockers

Shell mold casting is a casting method to produce castings with thin shell mold, also it's ideal for medium-to-high-volume production. Similar to the sand casting, in that molten metal, a dispensable mold is poured. Shell casting was invented by German J. Cronin in 1943. It was first used in Germany in 1944 and began to be used in other countries after 1947. At present, our company Ningbo Zhiye Mechanical Components is widely used this Shell Mold Casting for intake Rockers.



Product Description

Zhiye is a professional leader China Shell Mold Casting for Intake Rockers manufacturer with high quality and reasonable price. Welcome to contact us.

Material:GH65-48-05

Technique:Shell Mold Casting with Phenol Formaldehyde Resin pre-coated Sand

Gross Weight:1.06KG

Application Area:Automobile

Product Name:Intake Rockers

Anti-Rust:with anti-rust water

Heat treatment:Is Fire

Ningbo Zhiye Mechanical Components Co.,Ltd. Shell Mold Casting

The metal pattern we provide is first heated at a temperature of 200°C / 392°F. Then covered with a mixture of sand and thermoset plastic. It forms a skin of sand / plastic mixture of about 3.5 mm (0.125 inch) which adheres to the pattern. The shell mold is formed after the skin gets removed from the pattern. The two halves of the shell mold are secured together and the metal is poured in the shell to form the part. Once the metal solidifies, the shell is broken.

Features of Shell Mold Casting:

- Good Surface Finish: 1.25μm to 3.75μm (50μin to 150μin) rms Dimensional tolerance of 0.5%
- Size Limits: 30g to 12kg (1 oz to 25 lb)
- Minimum Thicknesses: As low as 1.5 mm (0.062 in) to 6.25 mm (0.25 in), depending on the material Superior Machining Qualities: As it has soft skins and hard or dense interiors.
- Draft Allowance: Typically 1°C

Ningbo Zhiye Mechanical Components Co.,Ltd.

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Application of Shell Mold Casting from our company:

The materials that can be used with this process are aluminum, cast irons, and copper alloys. Parts made can be connecting rods, gear housings, lever arms etc.



Ningbo Zhiye Mechanical Components Co.,Ltd.



Product Name	Cast Iron Factory Custom Grey Iron Ductile Iron Sand Casting Shell Mold Cast Iron Casting Parts
Tooling Design	We have own R&D team to make customized tooling, usually 7-15days can be ready.
Business Type	We are a professional OEM manufacturer.
Production Line	Latest casting method applicated
Machining	Cutting, punching, drilling, bending, weld, mill, CNC, etc.
Material	QT200, 250,HT250 (Special alloy could be made upon your requirements.)
Temper	T3-T8
Standard	China GB high precision standard.

Thickness	Based on your requirements.
Length	Pls provide drawings, then we can input technical dates to machine. High quality CNC machined parts are made on this way.
MOQ	Can be discussed
Surface Finish	Mill finish, Anodizing, Powder coating, Wood grain, Polishing, Brushing, Electrophoresis.
Color Can be	Silver, black, white, bronze, champagne, green, gray, golden yellow, nickel, or customized.
Film Thickness	Anodized

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	Powder Coating	C u s t o n i z e d . N o r n a l t h i c k n e s s : 6 0 - 1

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Chemical Composition & Performance	Meet and execution by the China GB high precision level.	
Packing	Plastic film & Kraft paper. Protect film for each piece of profile is also ok if required.	
FOB Port	Ningbo China	

MORE PRODUCT



PRODUCT CLASSIFICATION



Production Machinery:

Machine Name	Brand&Model No.	Quantity	Number of Years Used
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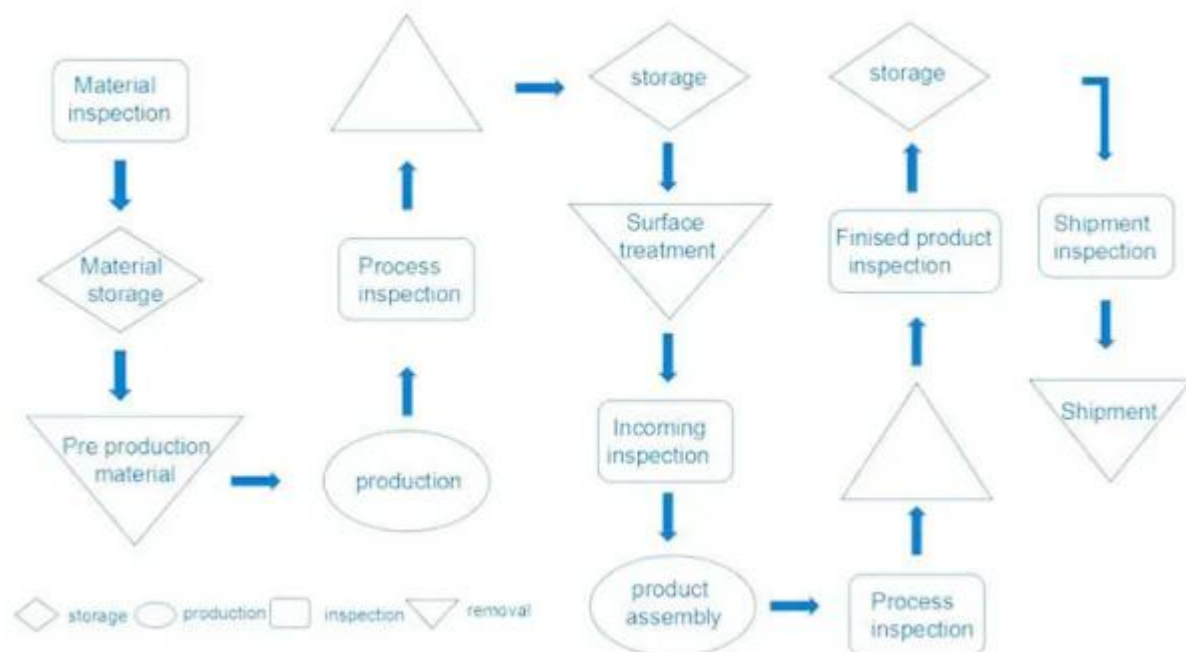
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Die Casting Machine	J11566	30	8.0
Polishing Machine	No Information	9	8.0
Drilling Machine 1	ZS4116B	24	8.0
Drilling Machine 2	Z3040	5	1.0
Shot Blasting Machine	No Information	5	8.0
Sand Blasting Machine	7B-7060	6	8.0
Core Shooting Machine	2H70	3	4.0
CNC Lathe	TK36	15	3.0
Machining Center	DILM 1300	15	3.0
Milling Machine	X5330B	4	4.0
Sawing Machine	GD535	1	4.0
Gravity Casting Machine	No Information	2	2.0
plastic injection machine	Haitian	12	3.0
stamping and punch machine	Wode	30	2.0
cnc laser cutting machine	No Info	2	4.0

• TECHNOLOGICAL PROCESS •



• PACKAGE AND TRANSPORT •



FAQ

Q: Are you manufacturer?

A: Yes, we are manufacturer.

Q: When will you deliver the goods?

A: About 30 days after payment. It also depends on the quantity and whether you need mould making.

Q: How about quality of products?

A: We strictly control every detail of the products. Each product is inspected before leaving factory.

Q: Do you accept customized orders?

A: Yes. With design team, OEM and ODM orders are highly welcome.

Q: Which transportation do you accept?

A: DHL, FedEx, EMS etc, as for your convenience.

Q: Can you accept mould making?

A: Yes.