Machine tool casting

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Lost foam casting

Material: more for HT200 and HT250
Process: Lost foam casting
Production characteristics: Open production line, low investment cost.

Full mold casting

Material: more for HT300
Process: Full mold casting
Production characteristics: Open production line, low investment cost.

Process Data for Machine Tool

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Item		Traditional sand casting	Full mold casting	Lost foam casting
Die	Split die	Need	No	
	Draft angle	Need	Almost No	
	Material	Wood or Metal	Foam	
Sand core		Need	No	
Mould		Resin sand	Resin sand	Dry sand
Design		/	Flexible, because cavity made by foam pieces.	
Blanks		Heavier	Lighter, because no draft angle, no split dia	
Clean		More difficult	Simpler, casting has no flash, burr and draft angle	

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Lost foam casting production site

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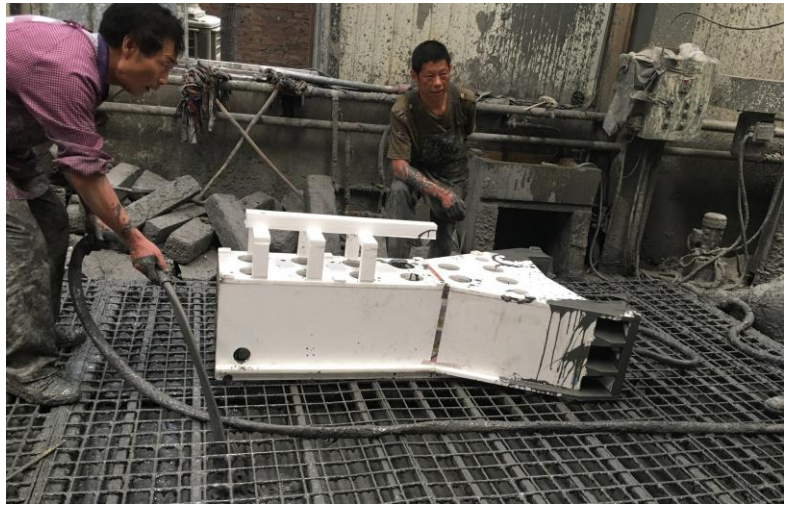

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Full mold casting production site