

Lesson 4 Glossary

Anchor: Appliance used to hold cores in moulds.

Arbor: A device to reinforce or lift a mass of sand.

Bedding in: Sinking a pattern in to the sand by digging a "bed" in which the pattern is placed for ramming up.

Bottom Board: The board that the mould rests on

Chaplet: A metal support used to hold a core in place in a mould.

Cheek: The portion of a flask placed between the cope and drag when a mould has more than two sections.

Chill: A metal object placed in the wall of a mould, causing the metal to solidify more quickly at such a point.

Choke: The part of the gating system that most regulates the flow of metal into the mould cavity.

Close Over: The operation of lowering a part of the mould over some projecting portion such as a core.

Contraction: Decrease in size due to cooling of the metal after it is poured.

Cope: The upper or topmost section of a flask.

Core Dryer: A metal form in which the core is baked.

Core Rod: Irons or bars imbedded in a core to strengthen it.

Dowel: A pin used between the sections of parted patterns or core boxes to locate and hold them in position.

Draft: Slight taper given to a pattern to allow drawing from the sand.

Drawing: Removing the pattern from the sand.

Drop: The falling away of a body of sand when the mould is jarred or lifted.

Feeding: delivering additional molten metal to a casting to make up for volume shrinkage during solidification.

Feed Head: A reservoir of molten metal from which the casting feeds as it solidifies.

Fin: A thin projection on a casting due to an imperfect joint in the mould.

Fillet: A concave corner piece used at the intersection of two surfaces to round out a sharp corner.

Follow Board: A board shaped to the parting line of the mould.

Gate: A channel through which the molten metal enters the casting cavity.

Gaggers: Metal supports shaped like the letter "L" that are used to reinforce the sand in the mould.

Head: The pressure exerted by a column of fluid, such as molten metal, water, etc.

Match Plate: A plate to which the pattern is attached at a parting line.

Nowel: The lower section of the flask; commonly called the drag.

Overhang: The extension on the vertical surface of a core print, providing clearance for closing the mould over the core, also known as "shingle."

Ramming up: The process of packing the sand in the mould or core box with a rammer.

Rapping: Loosening the pattern from the mould by jarring or knocking.

Rechucking: Reversing a pattern upon a face plate to permit turning the opposite face to the required shape.

Rolling over: Operation of turning flask over to reverse its position.

Shakeout: The stage in the casting process where the sand from the mould is cleaned off of the newly formed castings through dynamic vibration.

Shrink Hole: A cavity in a casting due to insufficient feed metal.

Sizing: A primary coating of glue applied to the end grain of wood to seal the pores.

Soldiers: Wooden hooks used to reinforce a body of sand.

Strike: A straightedge used for removing excess sand from a mould or core box.

Stripping Plate: A plate, formed to the contour of the pattern, which holds the sand in place while the pattern is drawn through the plate.

Sweep or Skree: A board shaped to a required profile. It is used to remove excess material from a mould or core.

Tucking: Pressing the sand in place with the hands.

Tuyere: Opening in the cupola where the air blast enters.

Vibrator: A mechanical device used to loosen a pattern from a mould.