



Casting Process Data Sheet

Low Pressure Die Casting

Contact name:

Company:

Address:

Tel:

Fax:

Email:

Website:

Date:

1- CAD(3D) or drawings

Casting (Raw)	Gating system	Dies	Cores	Die cooling	Furnace	Wight of Cast part

2- Materials properties

Cast metal	
Alloys	Compositions %

Die Material and coating				
Die Material	Die coating (permanent)	Die spraying (each cycle)	Die coating (each cycle)	Comments:

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Core			
Sand Type	Coating	Binder	Initial core temperature

Others					
Cast temperature: [°C]		Degassing treatments		Filter	
				Type	Size
Total weight of alloy cast: [kg]	Cycle Time [s]	Number of cycles to heat the die	Complete cycle time (cast to cast) [s]	Die opens after	Side cores withdrawal [s]
Casting removal [s]	Start of spraying [s]	End of spraying [s]	Duration of spraying: [s]	Die closes after [s]	Start of filling (second cycle) [s]

3-Pouring process

Pouring Temperature °C	Pouring time (S)	Pouring rate kg/s	Die Temperature °C

Die cooling/Tempering		
Coolant	Cooling [s]	Cooling off [s]

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Filling conditions

Time: 0 s

Empty mould, start of mould filling

Velocity or Pressure profile in function of time:

Time:						
Pressure:						
Velocity						

Die thermocouples	
Measured temperature data available	Position

Any other process information which might affect the cast part please specify

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Thank you for your inquiry