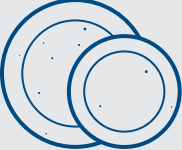



















# Common Casting Faults

FAULT							
Poor Filling	Flabby Casts	Brittle Casts	Poor Draining	Wreathing	Pinholes	Cracking	Casting spot and casting flash
							
DESCRIPTION							
Too long to fill moulds	Soft casts - difficult to handle	Hard casts - difficult to fettle	Slip not draining from narrow sections	Small uneven fringes on slip side of cast	Small holes	Small cracks, e.g. where handle joins body of piece	Discoloured patch occurring on the mould side of the article
CAUSE							
							
Fluidity too low	Thixotropy too high	Thixotropy too low	Fluidity too low/ thixotropy too high	Thixotropy too low	Fluidity too low	Thixotropy too low	Fluidity too high/ thixotropy too low
CURE							
							
Increase water addition or <b>increase</b> deflocculant addition	Increase deflocculant addition	Decrease deflocculant addition	Increase water addition or <b>increase</b> deflocculant addition	Decrease deflocculant addition or <b>decrease</b> water addition	Increase water addition or <b>increase</b> deflocculant addition	Decrease deflocculant addition or <b>decrease</b> water addition	Decrease water addition or <b>decrease</b> deflocculant addition