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Fig. 16.2. Distribution of resin in bonded sand

good casting surface and excellent delineation to the casting. However, a balance between gas evolution and permeability must be maintained¹⁾.

If the sand grains have a perfectly round shape and uniform diameter, the total volume of pores per unit volume is independent of the diameter of the grains. The pressure increase due to friction dependent upon the void diameter must be considered. Although large pores are desirable to permit the escape of gases, they can permit the penetration of the liquid metal into the voids. Fine sands and multimesh sands offer better resistance to erosion and better surface quality of the casting, but require more bonding material. All of these factors must be considered and invariably a compromise must be made.

Due to the highly increased cost for sand, transport and disposal, sand reclamation becomes increasingly important. Reclamation plants provide the following regeneration processes:

- mechanical regeneration (breaking, grinding and dust removal);
- pneumatic regeneration (impact screening);
- wet regeneration (washing process for inorganic binders);
- thermal regeneration (incineration process).

Problems associated with reclaimed synthetic resin bonded sands have been thoroughly studied. Phenol levels observed in reclaimed sand eluted with water, are definitely lower than those determined in household sewage^{1,3} (Chap. 6.3).

16.2 Shell Molding Process

In the shell molding process resin coated sand is placed into a heated metal pattern (250–280 °C) by means of a dump-box or blowing with special machines into hot, closed molds. Prior to this, the mold is sprayed with a silicone release agent. The resin melts on the hot surface and binds the sand grains. A solid shell is formed; the thickness depends upon the time of direct contact, the temperature of the mold and the hardening rate of the resin. As soon as the shaped molding has reached a thickness of 4–7 mm, usually after 20–30 s, the unhardened surplus mixture is removed and fed back into the chute. The shell is only hardened on one side. The reverse side is then completely cured by infrared radiation or in a tunnel oven. This cured shell constitutes one half of the mold. The mold is assembled by clamping both shell halves together or gluing them together with thermosetting resins (bonding time 20–40 s), after the re-

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