

Cost Comparison Between Foundry Processes

Cost Components	Average Cost Per Metric Ton of Casting (Rs.)				
	foam cast [®]	Vacuum Lost Foam from China (V-LFC)	Vacuum Pressure Casting (VPC)	No-Bake Sand hand moulding	Green Sand
Silica Sand (With Sand Reclamation)	80.00	100.00	100.00	3,300.00	1,500.00
EVA Film for creating Vacuum			450.00		
Normal Film for creating Vacuum	20.00		65.00		
Paint/Refractory Coating		3,000.00	2,000.00	1,000.00	1,000.00
Ceramic Coating	7,000.00				
Co-Polymer (STMMA) for foam pattern		3,000.00			
Cup Grade EPS for foam pattern	1,000.00				
Pattern Cost (considering pattern life & maintenance cost)			1,000.00	500.00	500.00
Aluminium Mould/Die for Foam Pattern	1,500.00	2,000.00			
Vacuum Cost	100.00	300.00	3,500.00		
Heating Drying / Burnoff	700.00	500.00	300.00	150.00	100.00
Core Cost (No-bake sand)			2,000.00	2,000.00	2,000.00
Moulding labour	500.00	500.00	500.00	1,200.00	1,000.00
Metal Melting Cost (Approx)*	10,000.00	12,000.00	10,000.00	10,000.00	10,000.00
Fettling and Salvaging Cost	500.00	1,000.00	1,000.00	3,000.00	5,000.00
Total Cost Per Metric Ton	21,400.00	22,400.00	20,915.00	21,150.00	21,100.00
Suitable for Stainless Steel, Carbon Steel, Grey Iron, Ductile Iron, Aluminum, Bronze & Brass	YES	Not Suitable for Stainless Steel and Carbon Sensitive alloys	YES - But has limitation of size since process requires plated patterns	YES - But sand used for the mold is difficult to reuse	YES - But has higher in process rejection especially in stainless steel

Note: Melting cost for Vacuum Lost Foam from China is higher since the metal has to be overheated to melt the foam pattern

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