

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	700.00	200.00	5,000.00	2,500.00
EVA Film for creating Vacuum			600.00		
Normal Film for creating Vacuum	20.00		100.00		
Paint/Refractory Coating		3,000.00	3,000.00	2,000.00	1,500.00
Ceramic Coating	9,500.00				
Co-Polymer (STMMA) for foam pattern		4,000.00			
Cup Grade EPS for foam pattern	1,000.00				
Pattern Cost (considering pattern life & maintenance cost)			1,500.00	1,000.00	800.00
Aluminium Mould/Die for Foam Pattern	2,500.00	2,500.00			
Vacuum Cost	500.00	2,000.00	5,000.00		
Heating Drying / Burnoff	800.00	800.00	500.00	300.00	200.00
Core Cost (No-bake sand)			3,000.00	3,000.00	3,000.00
Moulding labour	1,000.00	1,000.00	1,000.00	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	600.00	1,500.00	1,500.00	4,000.00	6,000.00
Total Cost Per Metric Ton	26,000.00	27,500.00	26,400.00	26,500.00	25,000.00
Suitable for Stainless Steel, Carbon Steel, Grey Iron, Ductile Iron, Aluminium, 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

* Jayshree Machines And Tools, India disclaims liability for any loss or damages whatsoever arising out of your use of above information

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