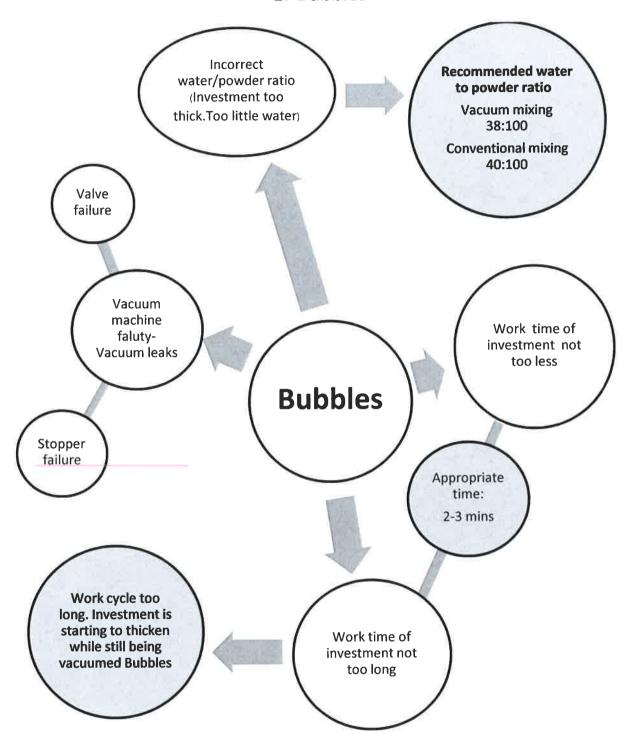




1. Bubbles

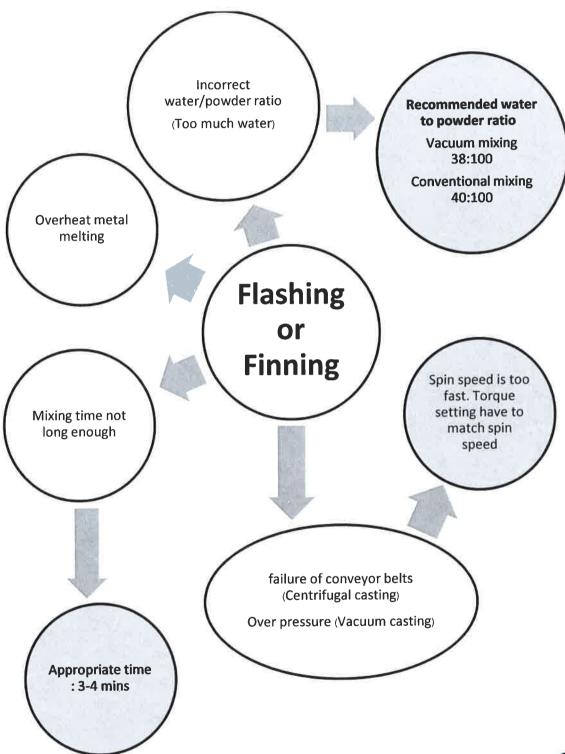








2. Flashing or Finning

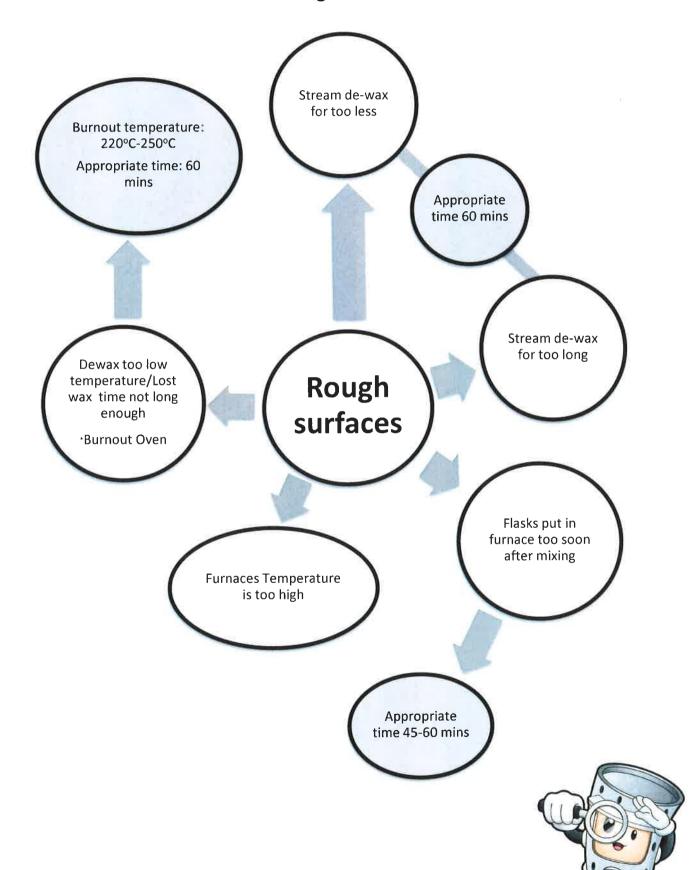








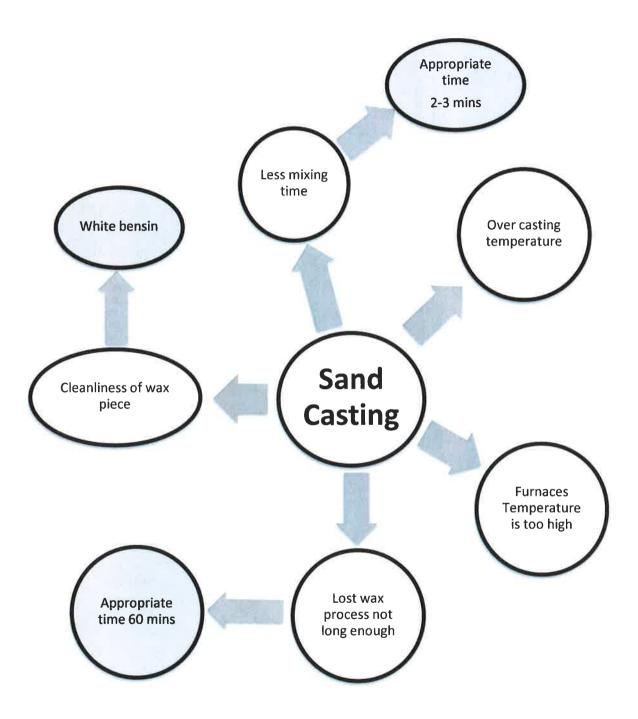
3. Rough surfaces







4. Sand Casting



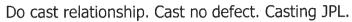






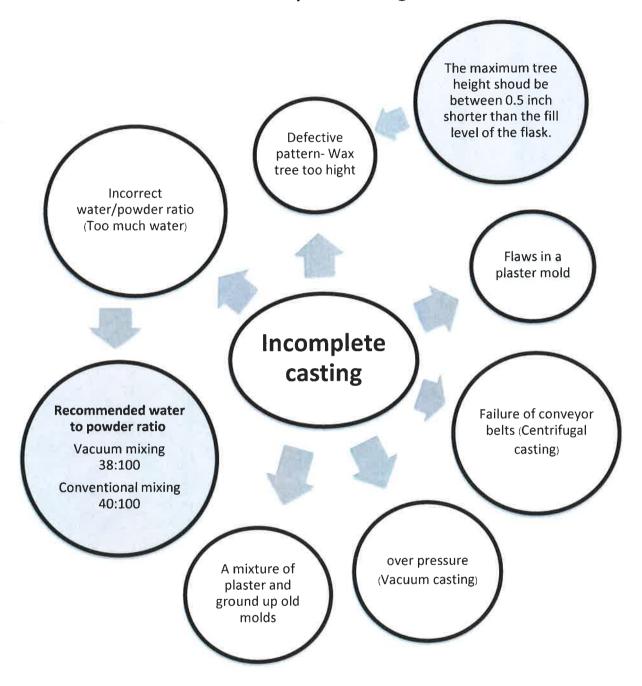
5. Finning Furnace temperature is too high Appropriate Incorrect time 45 mins water/powder ratio (Too much water) **Finning** Moving flask too **Recommended water** soon after mixing to powder ratio Vacuum mixing 38:100 Conventional mixing 40:100 **Furnaces** failure Room temperature is too low/Too much Investment cracking humidity



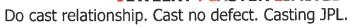




6. Incomplete casting









7. Gas porosity

