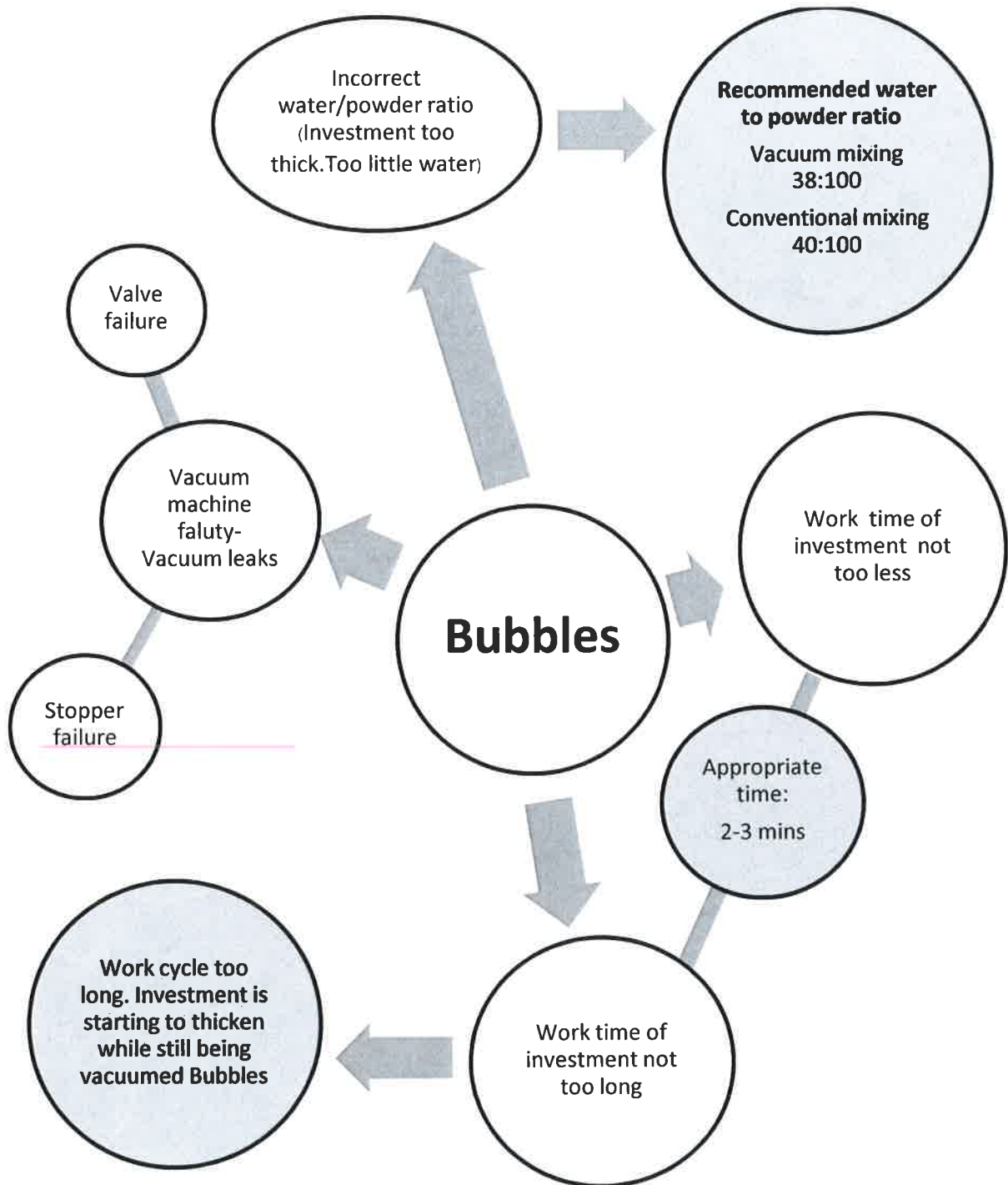


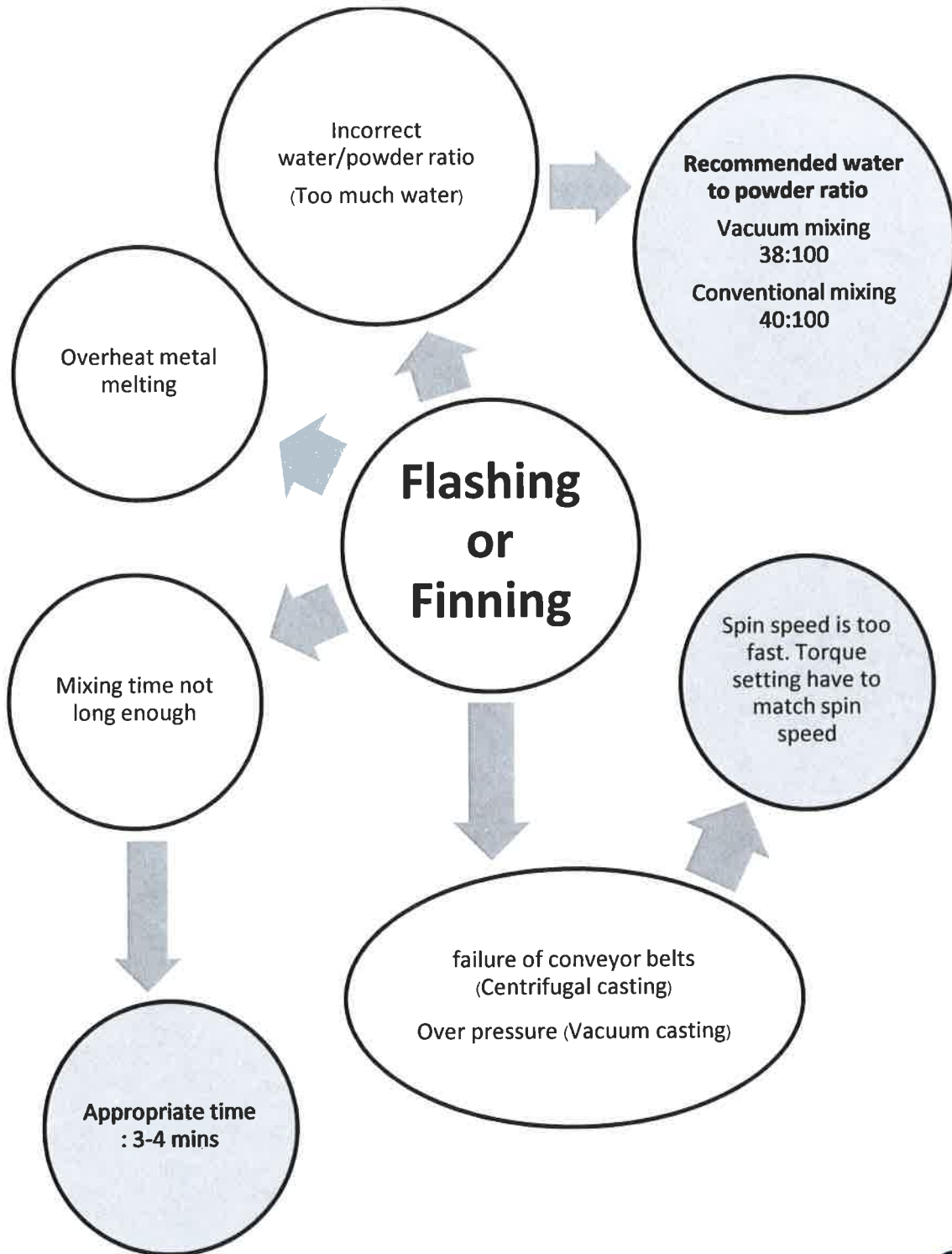


## 1. Bubbles



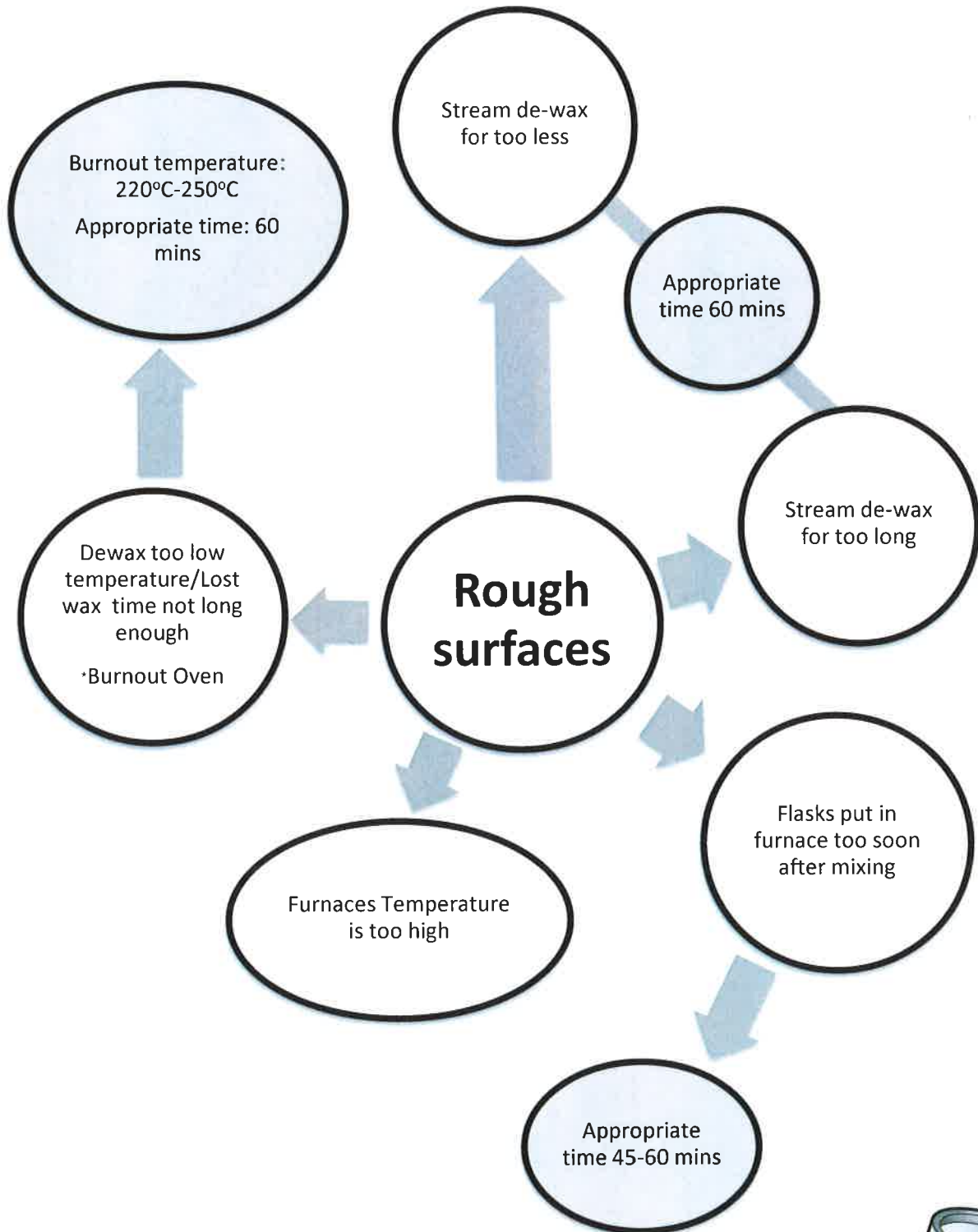


## 2. Flashing or Finning



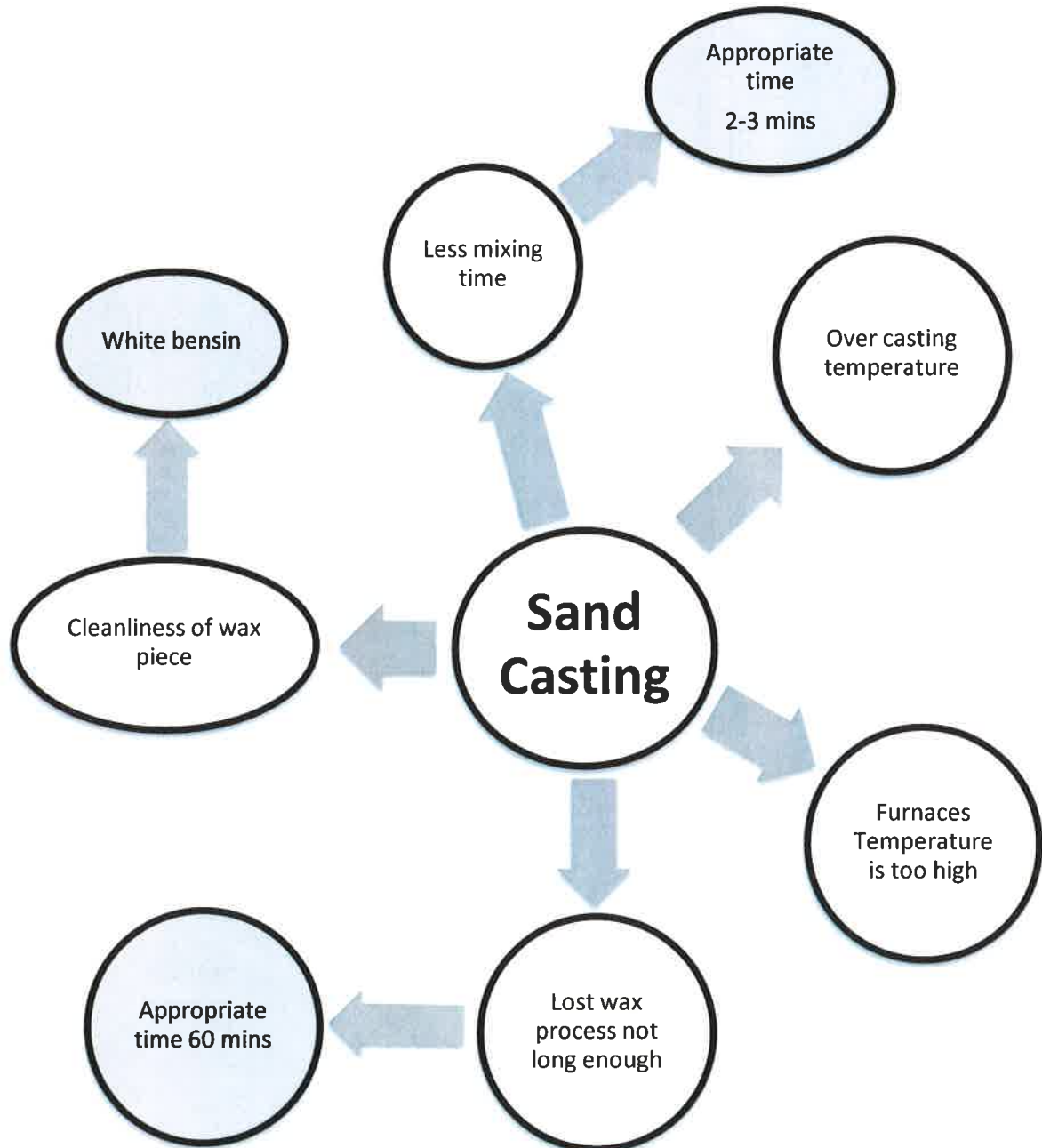


### 3. Rough surfaces



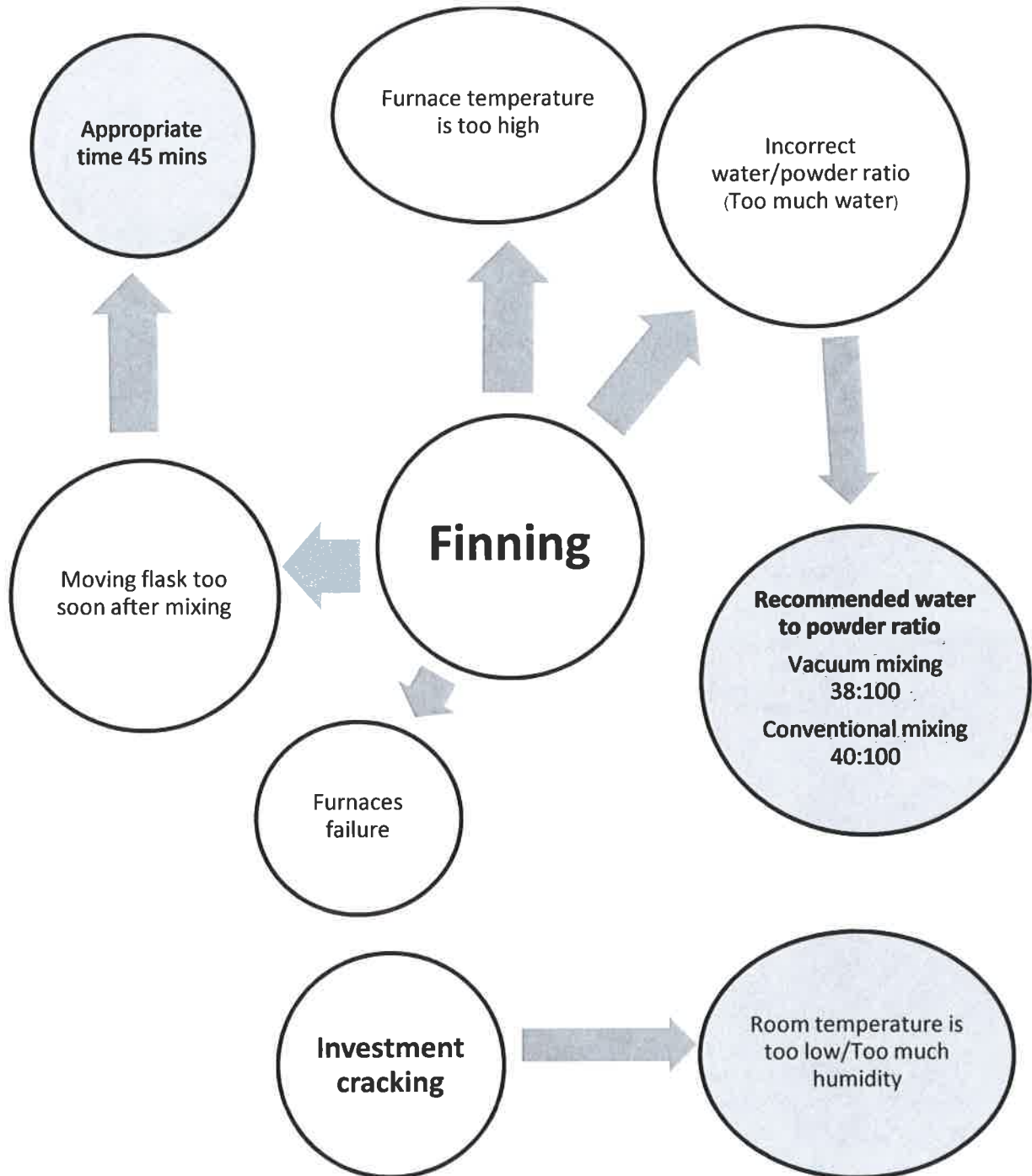


## 4. Sand Casting





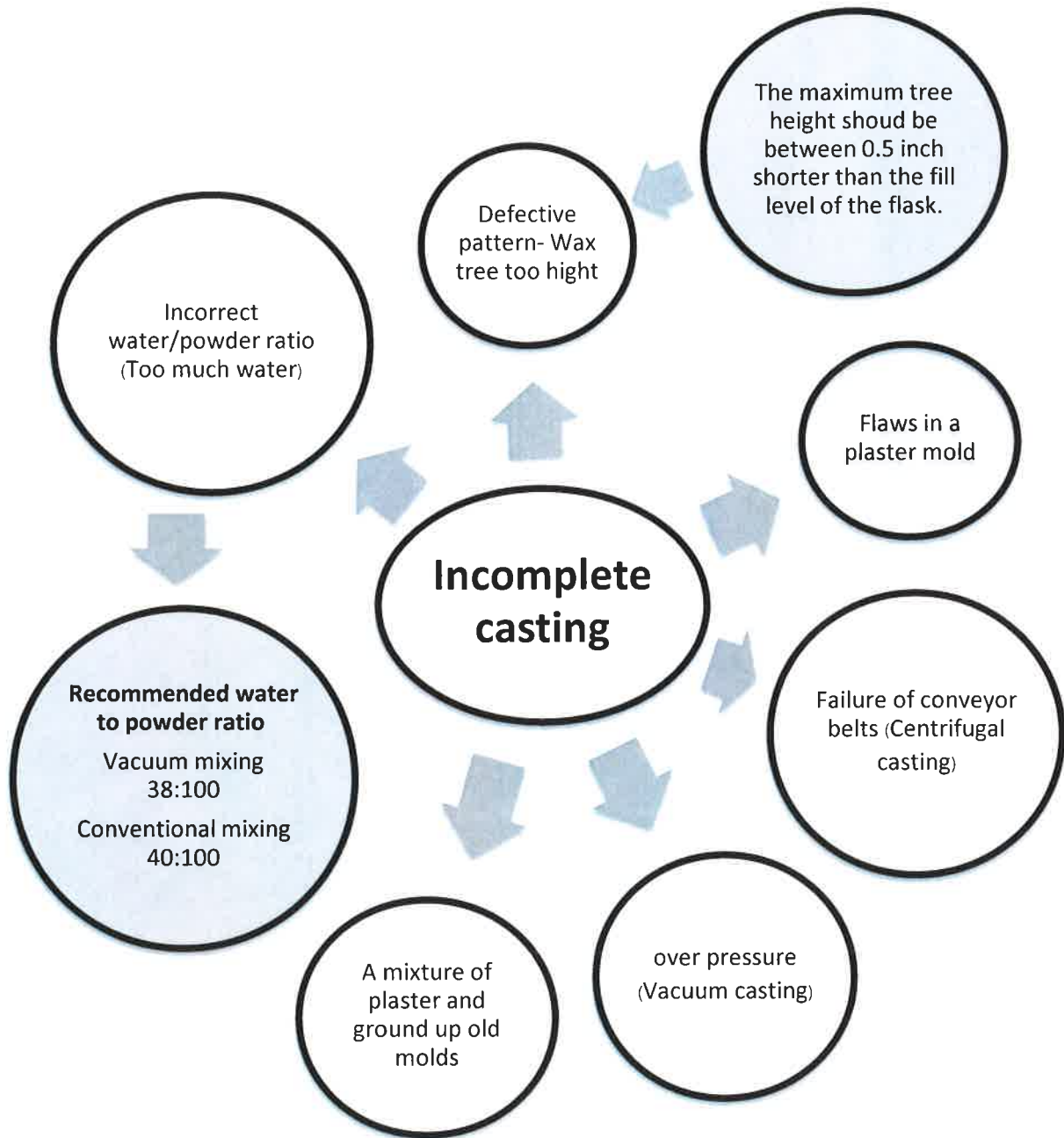
## 5. Finning







## 6. Incomplete casting





## 7. Gas porosity

