

## FOUNDRY DIVISION

Description : **MOULDING AND CORE MAKING OPERATION FOR ESTIMATED QUANTITY**

Tender Document No. : **FYM / CONT /2009-10/05**

Quantity : **3188 MT** (Finished casting weight as per drawing without runner / riser)

### 1. SCOPE OF WORK

#### MOULDING OPERATION INCLUDES :

- a) Pattern setting
- b) Mould box setting
- c) Gagger setting
- d) Setting of ingates and runner sleeves
- e) Riser setting
- f) Mould box filling with sand
- g) Mould Making
- h) Pattern drawing
- i) Core Making
- j) Painting (2 to 3 coats)
- k) Mould closing
- l) Preheating of moulds before pouring of moulds.
- m) Sprinkling of Ferrux & Thermexo powder on risers during pouring of moulds
- n) Transporting of materials required for preparation of moulds by hand trolley from stores and yards.
- o) Knockout of castings.

**CORE MAKING OPERATION INCLUDES :**

- a) Core box cleaning
- b) Setting of reinforcement / gagger
- c) Filling of sand
- d) Core drawing
- e) Painting (2 & 3 Coats)