



Osborn • SPO • Sutter

## Request for Quote / More Info.

### 1. INFORMATION

Fill in the **CONTACT INFORMATION** and the **SPECS INFORMATION** on the following pages.

### 2. FAX TO 216-651-6331

Fax the information to us and we will have a Sales Representative contact you.

### OR CALL US DIRECT AT 216-651-6700

Call a Sales Representative directly to answer questions about your specific projects.

**At EMI, we have your specific solutions to your molding and core room production requirements.**

**We offer both NEW and REMANUFACTURED equipment to satisfy your budget.**

### Equipment Merchants International

1203 West 65th Street Cleveland, Ohio 44102-2159 • Phone (216) 651-6700 • Fax (216) 651-6331  
E-Mail: [sales@emi-inc.com](mailto:sales@emi-inc.com) • [www.emi-inc.com](http://www.emi-inc.com) • Traditional business. Proven technology. Today's answers.

## Company Info

# Green Sand Molding Info / Specs

COMPANY NAME ▲

ADDRESS

CITY

STATE

CITY

WEB ADDRESS

## Contact Info

CONTACT PERSON

PHONE

EMAIL

FAX

DATE

## Customer Requirements for Green Sand Molding

Action Required: (check one)  Layout Only  Budget Quote  Firm Quote

Product or type of casting:

Production requirements (good molds per hour):

Suggested cycle rate:

Flask Size (inside):

W=

L=

C =

D=

Flask Barring Arrangement:

Cope

Drag

Green Sand Project Beyond Parting Surface: Cope

Drag

Max Pattern Height Above Parting Surface: Cope

Drag

Depth of Pattern Plates or Bolsters: Cope

Drag

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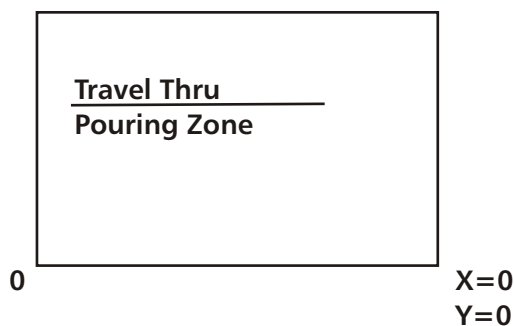
# Green Sand Molding Info / Specs

Preferred Type of Compaction (Jolt/Squeeze, High Pressure, Impact, Etc.): \_\_\_\_\_

Pattern Shuttle (Alternating, Cycling, None) \_\_\_\_\_

Number of Pattern Plates to be Active in System: \_\_\_\_\_

Location of Pouring Basins:



Cope Vents to be Open to Atmosphere  
(to be Opened Automatically, Manually, Not Required) \_\_\_\_\_

If Cope Vents are to be Opened Automatically  
List "X" and "Y" Coordinates of each  
(X=0 and Y=0 per sketch above) and Indicate Diameter of each. \_\_\_\_\_

Are Copes to be Rolled Over for Inspection?  Yes  No

Are Cores to be Set in the Copes?  Yes  No

Number of Drag Molds Required in Core Set Zones: \_\_\_\_\_

Max Weight of Cores: \_\_\_\_\_

Is Automatic Core Setting Device to be included?  Yes  No

Method of Core Supply to System (Overhead Conveyor, Truck, Core Racks, Other) \_\_\_\_\_

Pouring Arrangement  Manual  Automatic Max Weight of Pour: \_\_\_\_\_

Pouring Weights to be Used: \_\_\_\_\_ Max Pouring Time per Mold: \_\_\_\_\_

Number of Closed Molds Required in Pouring Zone: \_\_\_\_\_

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# Green Sand Molding Info / Specs

**Preferred Method of Casting Removal from Mold**  
(Rollover-Dump, Punch-Down, Punch-Up, Manual Hook-Out, Other): \_\_\_\_\_

Castings (If Removed Automatically) to be  
Deposited on Shakeout, Vibrating Conveyor,  
Overhead Conveyor Tray, Overhead Conveyor Bucket, Other: \_\_\_\_\_

**Mold Cooling Time:** Max: \_\_\_\_\_ Min: \_\_\_\_\_ Variable: \_\_\_\_\_

**Operating Hours Per Day:** \_\_\_\_\_ **Operating Hours Per Year:** \_\_\_\_\_

**Available Space for Molding System:** L: \_\_\_\_\_  
W: \_\_\_\_\_  
H: \_\_\_\_\_

**Programmable Control Brand Preference:** \_\_\_\_\_

**HMI Brand Preference:** \_\_\_\_\_

**Type of Hydraulic Controls** (Centralized or De-Centralize): \_\_\_\_\_

**Brand of Hydraulic Controls:** \_\_\_\_\_

**Location** of Expected Operating Areas Adjacent to and/or Supporting the Molding System:

- A) Melting Area & Pouring Zone
- B) Core Department & Core Set Zones
- C) Sand System Area
- D) Casting Removal Zone & Finishing Area

NOTE (1): IF SYSTEM MUST GO IN AN EXISTING AREA, IT IS ESSENTIAL THAT A LAYOUT OF THE AREA BE SUPPLIED INDICATING AREA LIMITATIONS AND DIRECTIONS OF FLOW (METAL, CORES, CASTINGS).

NOTE (2): IF THE MOLTEN METAL SUPPLY TO THE MOLDING SYSTEM IS NOT CONTINUOUS, PLEASE SPECIFY THE SEQUENCE AND CYCLE TIMES OF MOLTEN METAL DELIVERY AND INCLUDE THE EXPECTED TOTAL POUR-OFF TIME.

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