



Mahalakshmi Alloys & Metals (P)Ltd

- » Control of the temperature of the mold before steel casting. The recommended range is 80 to 120 C. In frigid winters cold molds must be pre-heated.
- » Mold cooling method, looking for lowering of its wall's temperatures as isothermally as possible and preferably slowly by natural air.
- » Mold temperature cycle . A period of time after stripping until the next steel casting should be specified aiming to keep the mold temperature in the recommended range. So, an adequate number of molds is necessary to maintain the rotation of the molds.
- » Molds positioning lay out with an enough space among them to facilitate the heat dissipation from their walls. It's a factor to be considered previously during the steel casting project.
- » Removal of ingot as gently as possible (without hitting, banging). This is possible when a proper equipment is used (for example : hydraulic stripper), and/or when a good internal surface of the mold is kept with a preventive conditioning program, such as grinding of its internal walls after a certain number of runs.