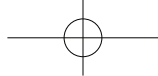


Metal Casting

CNBSolutions offers our overseas customers with one stop engineering and manufacturing OEM services in China. CNBSolutions has extensive experience with metal casting products including major processes of Investment Casting, Die Casting, Gravity Casting and Sand Casting.

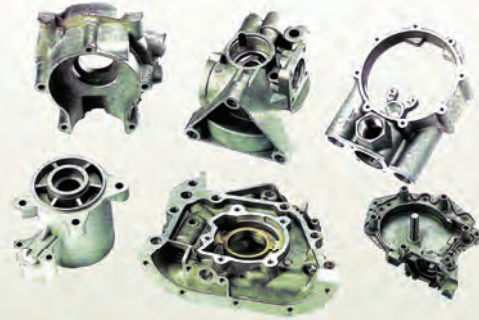
Process	Investment casting	Die Casting	Gravity Casting	Sand Casting
Main Process Property	<ul style="list-style-type: none"> • Net shape casting with close tolerance • Low alloy waste • Good surface finish 	<ul style="list-style-type: none"> • High efficient process • Expensive mold needed • Hi-quality surface finish • Suitable for large volume production run over 5000 	<ul style="list-style-type: none"> • High efficiency, closer dimensional tolerance and better surface finish than Sand casting process • Suitable for production run above 1000 	<ul style="list-style-type: none"> • Rough casting process • Low mold investment and short lead time • Low efficiency • Suitable for small volume production run less than 1000
Typical Applied Alloy Variety	<ul style="list-style-type: none"> • Stainless Steel: Austenitic Stainless, Martensitic Stainless, Duplex Stainless • Specialized Nickel Alloys • Carbon Steel • Titanium Alloy • Cooper • Aluminum 	<ul style="list-style-type: none"> • Al Alloys: A360, A380, A383, A413 per ASTM Spec. or ADC10, ADC12, AC3A, AC2B per JIS Spec. • Zinc Alloy: ZDC1, ZDC2, ZAMAK-2, ZAMAK-3, ZAMAK-5, ZAMARK-7, ZA-27 	<ul style="list-style-type: none"> • Al Alloys: A356 per ASTM Spec. • Zinc Alloy: ZAMAK-8, ZAMARK-12 	<ul style="list-style-type: none"> • Iron: Grey iron Ductile/ Malleable iron • Steel: Carbon Steel, Alloy Steel, Stainless Steel • Aluminum Alloy • Brass, Bronze
Size Range	350 X 350 X 350 mm	800 X 800 X 250mm	800 X 600 X 400 mm	1500 x 1500 x 500 mm
Casting Weight Range	5g to 60 kg	5g to 25kg	200g to 50kg	200g to 2000kg
Typical Surface Finish	90 ~ 125 RMS	32 ~ 63 RMS	100 ~ 250 RMS	250 ~ 500 RMS
Min. Wall Thickness	1.5mm	1.5mm to 6.25mm depending on the material	2.5mm to 6.25mm depending on the material	2.5mm to 6.25mm depending on the material
Available Secondary Process and Finishes	<ul style="list-style-type: none"> • Heat Treatment • Pickling/Passivation • Machining 	<ul style="list-style-type: none"> • Sand Blasting •Bead Shaking / Tumbling • E-Coating • Anodizing • Powder Coating • Painting 	<ul style="list-style-type: none"> • Sand Blasting • Polishing • E-Coating • Anodizing • Powder Coating • Painting 	<ul style="list-style-type: none"> • Sand Blasting • Plating • Powder coating • Painting
Available QC Approaches	<ul style="list-style-type: none"> • PMI analysis, • Non-destructive Test, • Metallurgy Microscope, • 3D-CMM, • Surface Roughness Measurer • Hardness Test 	<ul style="list-style-type: none"> • Spectrometer, • 3D-CMM • Porosity Detection • Surface Roughness Measurer • Mechanical Plug Gauge, • Air Tightness Test • Hardness Test 	<ul style="list-style-type: none"> • Spectrometer, • 3D-CMM • Porosity Detection • Hardness Test • Digital Caliper 	<ul style="list-style-type: none"> • Spectrometer, • 3D-CMM • Porosity Detection • Hardness Test • Digital Caliper
Mold Material	Aluminum patterning mold	H13, H21, SKD61, 8407, W302, DAC, DAC55, 3Cr2W8V	Ferrous Iron Mold, Graphite Mold	Wood Pattern Mold, AI Patterning Mold
Normal Lead Time	3 weeks ~ 3 months	4 weeks to 3 months	3 weeks to 3 months	1 weeks to 2 months



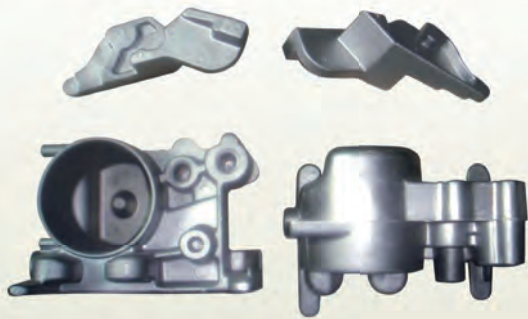
Different Types Of Metal Casting Products



Investment Casting Products



Die Casting Products

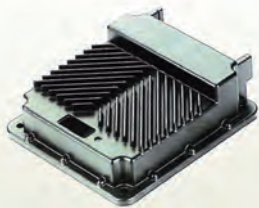


Gravity Casting Products



Sand Casting Products

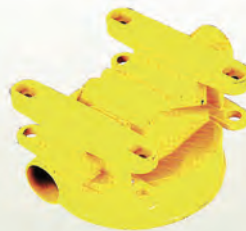
Various Surface Finish Solutions for Metal Casting Products



E-Coating Finish



Powder Coating Finish



Painting Finish



Sand Blasting Finish

Metal Casting Mould Engineering

CNBSolutions has a group of experienced engineers who can work with you to offer mould-know-how solutions for our customers.



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