



**FOUNDRY APPLICATION
GREEN SAND PREPARATION
DATA FORM**

Address All Correspondence

To: SIMPSON GROUP
751 Shoreline Drive
Aurora, IL 60504
Tel: 630-978-0044
Fax: 630-978-0068

1. Company Name _____
Contact (Name & Title) _____
Phone Number _____ Fax Number _____
Email Address _____
Address _____
City _____ State _____ Zip _____

2. Type of Foundry: _____ Jobbing _____ Production

3. Make, size and type of muller(s) currently in use: _____

4. Molding machine(s) in use: _____

5. Type of metal cast: _____ Steel _____ Iron _____ Aluminum
_____ Brass _____ Bronze _____ Other
Pouring temperature _____

6. Casing size: Weight _____ lbs. to _____ lbs.
Section thickness _____ inches to _____ inches
Sand to metal ratio _____



SIMPSON

TECHNOLOGIES

7. Type(s) of sand used: _____ Silica _____ Lake _____ Olivine
_____ Zircon _____ Chromite _____ Other

8. Sand Data: _____ AFS/GFN

| Screen | % Retained | Screen | % Retained |
|--------|------------|--------|------------|
| 6 | _____ | 70 | _____ |
| 12 | _____ | 100 | _____ |
| 20 | _____ | 140 | _____ |
| 30 | _____ | 200 | _____ |
| 40 | _____ | 270 | _____ |
| 50 | _____ | Pan | _____ |

9. Bonds and additives: Sodium Bentonite % _____ Calcium Bentonite % _____
Seacoal % _____ Moisture % _____ Other % _____

10. Sand Test / List results :

GREEN PROPERTIES

- _____ a. Moisture
- _____ b. Permeability
- _____ c. Green Compression
- _____ d. Compactability
- _____ e. 2 x 2 Specimen wt.
- _____ f. 165 Ram Density

PHYSICAL PROPERTIES

- _____ a. Methylene Blue
- _____ b. Loss on Ignition
- _____ c. A.F.S. Clay
- _____ d. Screen Analysis

Comments: