

The core removal of Combicore inlay tubes

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 Page: 1/1

Combicore cores are extremely stable thanks to their filling. After the casting process, it is easy to remove within the cycle time. This is usually done by high-pressure water. The component is protected from splash water. In our technical center we determine the parameters suitable for your application, such as pressure, suitable nozzles and procedures. We also remove the core of samples and prototypes or small series for you. We are happy to advise you or your system builder on the implementation of your own system.

That's how it works:

Normally, the water jet is directed from the outside onto the core cast into the component. Channels with a small inner diameter and short length can be rinsed quickly and completely in this way.

Bar cooling systems with internal \varnothing 4 and a flat internal height of 0.8 mm can be cleaned within less than 15 seconds (Fig. 1).

The filling is broken off by the water jet. As a rule, the water is circulated and only rinsed with fresh water. Drying with compressed air is recommended.

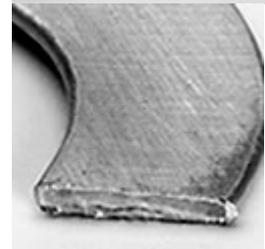


Fig. 1: The core in bar cooling system is removed in max. 15 seconds.



Fig. 2: The hose inlet facilitates the coring of long channels.

Complex, long channels (Fig. 2):

For long channels with a larger inner diameter, the introduction of a hose that directs the water jet directly to the filling material has proved its worth. Here, too, can be worked in the circulation. This method is particularly suitable for pipe inside $\varnothing > 8$ mm.

And if it's small and complex ...

For smaller inner diameters, Combicore GmbH offers an extended solution in which the dissolution of the molding material plays a greater role: in this variant too, the cleaning medium strikes the molding material inside the pipe at high pressure. To prevent a jam, and so that the dissolved molding material is conveyed out of the tube as quickly as possible, the high-pressure jet stops briefly. A vacuum is applied to the tube and the molding solution is sucked out of the tube. Then the next cleaning cycle starts again with a high-pressure coring process from the front.

The metal casing of the casting core remains as a protective channel wall in the component.

The suitable plant concept ...

... is adapted to your components and possibly existing framework conditions in your foundry.

Any questions? Feel free to contact us.
 We are happy to help.

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