



**VANGUARD FOUNDRY**

manufacturers of high integrity ductile castings

# CASTING PRODUCTION

With its emphasis on service and flexibility Vanguard Foundry Ltd offers two distinctly different moulding systems to its customers, a high pressure greensand moulding line and a chemically bonded boxless moulding system. The greensand system, based on the Heinrich Wagner Sinto (HWS) moulding machine, is ideally suited to the smaller product with repeating or higher volume demand. The chemically bonded system with its variable mould size can cater for much larger castings and also suits the low volume items which repeat rarely if ever. Both systems give good dimensional stability and repeatability.



## **Greensand Moulding**

The HWS HSP-2D moulding machine was chosen after careful consideration because it most closely matched the companies' needs. In tests it had proved to provide the quality of casting finish and dimensional accuracy demanded by our customers. The air-flow, hydraulic squeeze system this machine employs ensures good repeatability and enables Vanguard Foundry to easily transfer to high volume foundries, for long series production, the prototype product it develops with its customers. Conversely Vanguard Foundry is ideally placed to receive back the business when the product has reached maturity and demand is reduced to aftermarket volumes.

The flask size is 800mm X 650mm X 250mm/250mm. Castings up to 40kg can be accommodated on this moulding line.





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### Boxless Moulding

Originally the airset moulding system at Vanguard was created to provide a development facility for our customers to minimise initial investments but the system has been expanded and developed and is now a production unit in its own right. Patterns which may be wood, resin or metal are mounted in compact frames and supplied to the mixer head from a carousel transfer unit. The carousel then moves the pattern and sand around to the stripping station during which time the chemical reaction occurs giving a rigid mould without the need for external support. The mould is given a coating to prevent sand burn on to the finished casting before being closed and transferred to the casting line for pouring.

The maximum mould size on this section is 1200mm X 1000 mm X 500mm/500mm and a maximum casting weight of 200kg.

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