



**FOUNDRY FILTER (FOAM)**

Date of issue: 01 Sept 1995

Modification: 01

Date of validity: 01 Oct 2001

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**1. PURPOSE OF USE**

For cleaning of cast iron before the mould cavity.

**2. GENERAL QUALITY REQUIREMENTS**

Conformity with the manufacturer's catalogue.

**3. PROPERTIES OF MATERIAL**

Foundry filter must withstand the temperature of 1450 – 1500°C for at least 30 sec. or the temp. of 1420°C for at least 45 sec.

**4. PACKAGING, PACKING AND TRANSPORT**

In cardboard boxes and protected by foam between rows.

**5. WARRANTY OF QUALITY**

Certificate for each shipment.

**6. MANNER OF ACCEPTANCE**

Filters will be accepted by the acceptance control according to the prescribed quality characteristics.

**7. CONTROL PROCEDURE**

By 5 samples/1000 pieces, dimension control and in-process control.

Filter is exposed to the jet of cast iron with a temperature above 1460°C. Quality is deemed appropriate if the filter remains undamaged for at least 45 sec.

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**8. MANNER OF MEASUREMENT**

QUALITY CHARACTERISTICS, VALUE, MANNER OF MEASUREMENT

75x75-10 ppi

DIMENSION DEVIATIONS	VALUE	MANNER OF VERIFICATION
Length	75±1 mm	caliper
Width	75±1 mm	caliper
Height	22±1 mm	caliper
PERMEABILITY	10 ppi	visual comparison with the sample
TEMPERATURE PERSISTENCE	1450 - 1500 °C min. 30 s or 1420 – 1450 °C min. 45 s	

QUALITY CHARACTERISTICS, VALUE, MANNER OF MEASUREMENT

50x50-20 ppi

DIMENSION DEVIATIONS	VALUE	MANNER OF VERIFICATION
Length	50±1 mm	caliper
Width	50±1 mm	caliper
Height	22±1 mm	caliper
PERMEABILITY	20 ppi	visual comparison with the sample
TEMPERATURE PERSISTENCE	1450 - 1500 °C min. 30 s or 1420 – 1450 °C min. 45 s	