

Molding and Pouring Floor

- Inoculant blocks are added to each mold to assure metallurgical consistency and quality
- Sand is reclaimed via a mechanical reclamation process once molds are shaken out.



Finishing

- 15'x32' Blast Booth for cleaning large castings
- Large open area and several benches to accommodate a large variety of casting sizes

Pattern Shop

- Two Journeymen pattern makers with several years of experience
- Utilize foam, wood and metal tooling
- Fully equipped to build foam and wood tooling

Quality Assurance

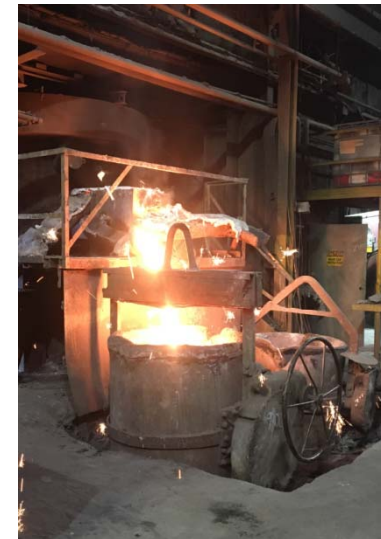
- CE tester on-site to determine quick analysis of chemistry
- Mechanical and Chemical Samples taken from each ladle of iron and sent to a certified outside lab for analysis
- Microstructural analysis is completed on each grade of iron poured on each pour day
- Each casting has a brinell hardness checked on it prior to shipping
- Dimensional verification is performed on any new samples and or production jobs if required

Thank you for coming today!



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**An Employee Owned
Company Providing
Excellence in Casting Quality
and Service**

De Pere Foundry Overview

- 54,000 Square Feet of Manufacturing Space
- 4 Large Overhead Cranes (15, 20, 25, 30 Ton)
- 12,000 Square Feet of Pattern Storage
- Furon No-Bake Molding
- All Grades of Gray and Ductile Iron
- Castings from 1# to 50,000#
- On-Site Pattern Shop

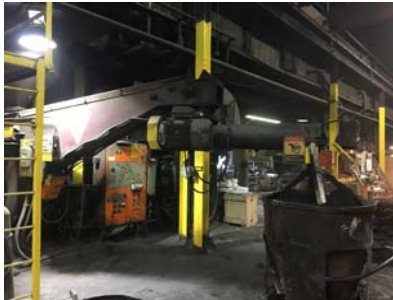
Core Room

- Furon No-Bake Cores
- Specialty Sands
 - Chromite
 - Zircon
 - Graphite Pieces
- Wood, Foam and Metal Boxes
- Large, complex core assemblies
- Quality Control Tests
 - Tensile
 - LOI
 - pH Measurement
- All cores are washed prior to molding



Ram Floor

- Whirl-Air Sand Mixer (1000# sand/min)
- Flask sizes from 20" x 20" up to 150" x 222"
- Patterns and Gating are arranged and sand is dumped over to set-up
- A mix of reclaimed and new sand is used, primarily reclaimed.



Melt and Metal Processing

- 54" Cold Blast, Refractory Lined Cupola
- Melt rate of 12-14 Tons Per Hour
- Melt both Gray Iron and Ductile Iron utilizing external Desulfurization
- Porous Plug and Sandwich methods of DI treatment
- Alloying is done on a per ladle "batch" system

Melt and Metal Processing

- Various Ladle sizes from 800# to 30,000#
- Charge consists of Steel, Purchased Cast, Returns and Pig Iron
- Charges loaded with an Excavator into a Weigh Hopper. Coke is weighed and added via skidsteer and wheelbarrow. Charge Bucket directly dumps into Cupola



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- Mold Halves are inspected, washed, blown out and put together in this area
- All molds are filtered to assure the cleanest metal goes into the cavity
- Molds are put on the "loose" sand bed or are set on transited beds to assure they are level