

# Pattern Material

Each material has its own advantages, limitations, and field of application.

Some materials used for making patterns are: wood, metals and alloys, plastic, plaster of Paris, plastic and rubbers, wax, and resins.

The usual pattern materials are wood, metal, and plastics. The most commonly used pattern material is wood, since it is readily available and of low weight. Also, it can be easily shaped and is relatively cheap.

To be suitable for use, the pattern material should be:

1. Easily worked, shaped and joined
2. Light in weight
3. Strong, hard and durable
4. Resistant to wear and abrasion
5. Resistant to corrosion, and to chemical reactions
6. Dimensionally stable and unaffected by variations in temperature and humidity
7. Available at low cost

# Pattern Allowances

Pattern allowance is a vital feature as it affects the dimensional characteristics of the casting. Thus, when the pattern is produced, certain allowances must be given on the sizes specified in the finished component drawing so that a casting with the particular specification can be made.

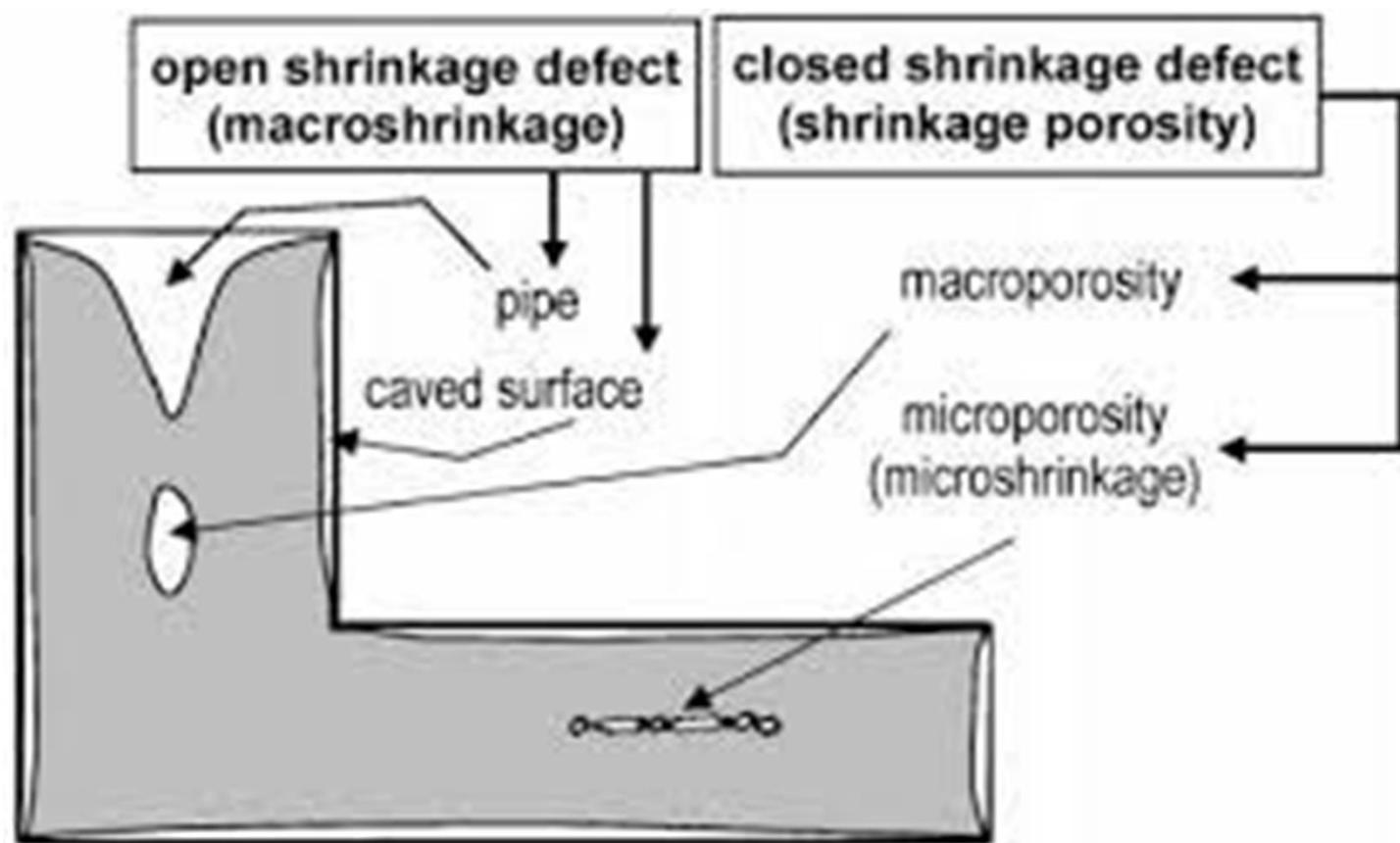
The allowances usually considered on patterns and core boxes are as follows:

1. Shrinkage or contraction allowance
2. Draft or taper allowance
3. Machining or finish allowance
4. Distortion or camber allowance
5. Rapping allowance

# Shrinkage or Contraction Allowance

All most all cast metals shrink or contract volumetrically on cooling.

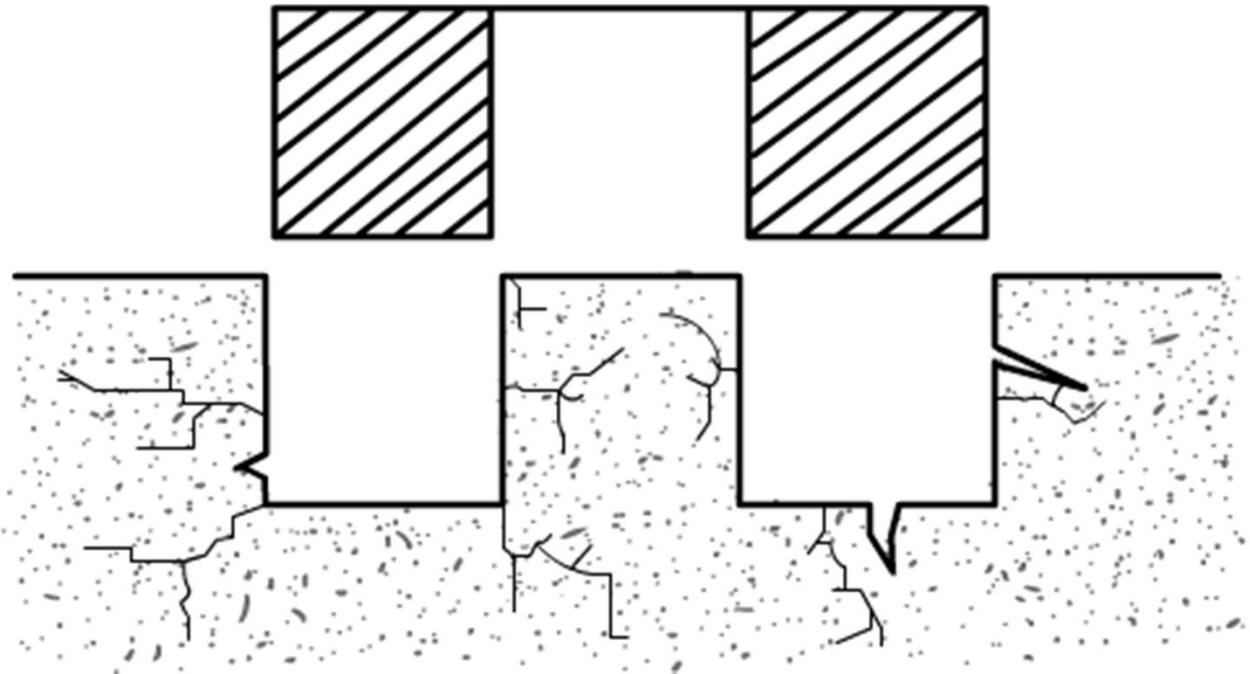
The rate of contraction with temperature is dependent on the material. For example steel contracts to a higher degree compared to aluminum. To compensate the solid shrinkage, a shrink rule must be used in laying out the measurements for the pattern.



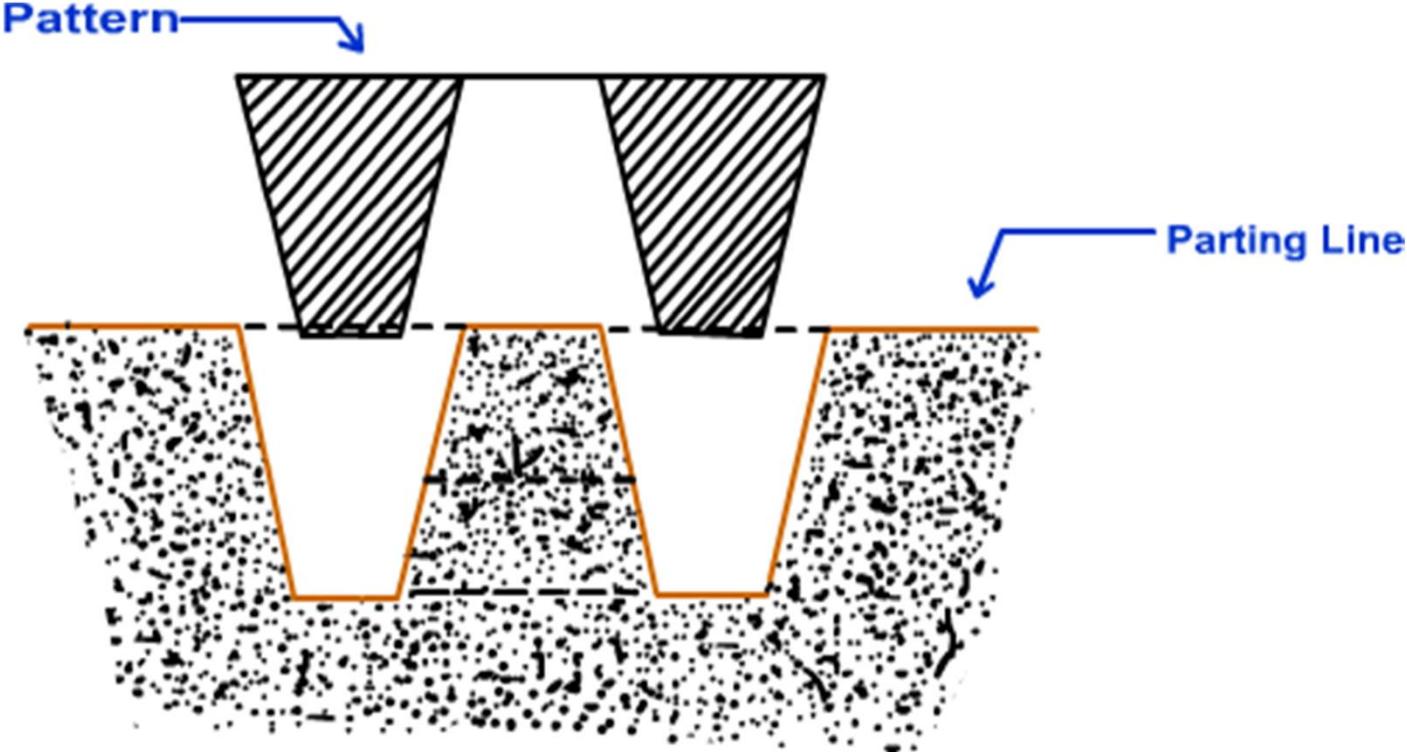
# Draft or Taper Allowance

By draft is meant the taper provided by the pattern maker on all vertical surfaces of the pattern so that it can be removed from the sand without tearing away the sides of the sand mold and without excessive rapping by the molder.

Pattern having no draft on vertical edges



# Pattern having draft on vertical edges



- Draft allowance varies with the complexity of the sand job.
- But in general inner details of the pattern require higher draft than outer surfaces.
- The amount of draft depends upon the length of the vertical side of the pattern to be extracted.