



STELEX*
Pro

STELEX Pro – THE FOAM FILTER FOR STEEL

FOR THE PRODUCTION OF CLEAN FILTERED CASTINGS

STELEX* Pro

A NEW GENERATION FOR THE FILTRATION OF STEEL

Calculation of gating systems

The choke of a STELEX Pro gating system is usually the downsprue diameter. The calculation of this choke area is based on the "general ingate formula"

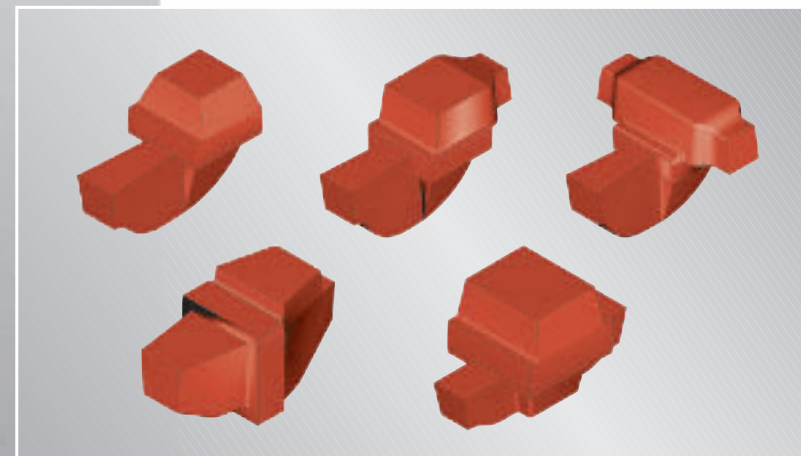
$$D_A = \frac{22.6 \times G}{\xi \times \rho \times t \times \sqrt{H}}$$

- D_A = downsprue area (cm²)
- 22.6 = constant for acceleration
- G = poured weight (kg)
- ξ = friction factor
- ρ = density (kg/dm³)
- t = required pouring time (s)
- H = effective pressure or pouring height (cm)

Our recommendations for the gating system cross sections are:

- downsprue = 1.0
- runners cross section = 1.1
- ingates cross section = 1.2.

Range of STELEX filter prints



The filter area must be sufficiently large to prevent early blockage during pouring, and the surface area should be at least 4.5 times that of the choke. The filter must be well supported around all edges of the exit face. For this purpose almost 45% of the exit area should be used for support.

More information about filter types, filtration capacities and packaging is available from your local Foseco company.

Additional support is available from our technical experts who can offer advice on application rules and gating system design.

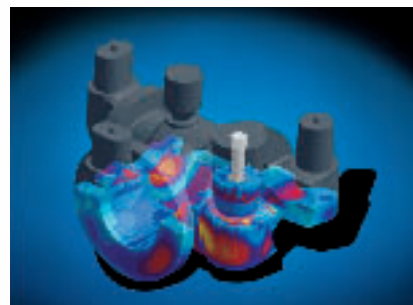
In-line gating system with STELEX filter print 7



In-line gating system with two no. 6 prints



KALPUR ST direct pour unit, side feeder



KALPUR ST direct pour unit, top feeder



- Consistent "Priming"
- Reduction of temperature related inclusions
- Higher filtration capacity
- Excellent flow rate characteristics

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LOW WEIGHT, HIGH PERFORMANCE, COST EFFECTIVE...

