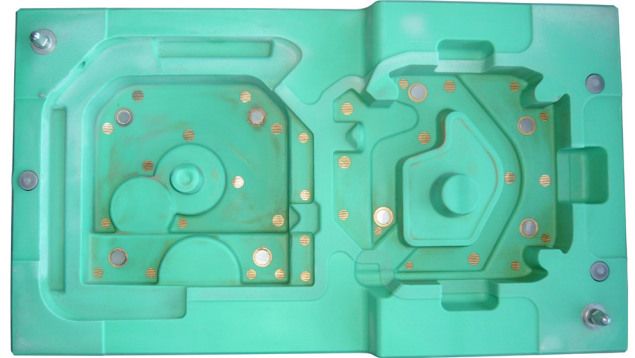
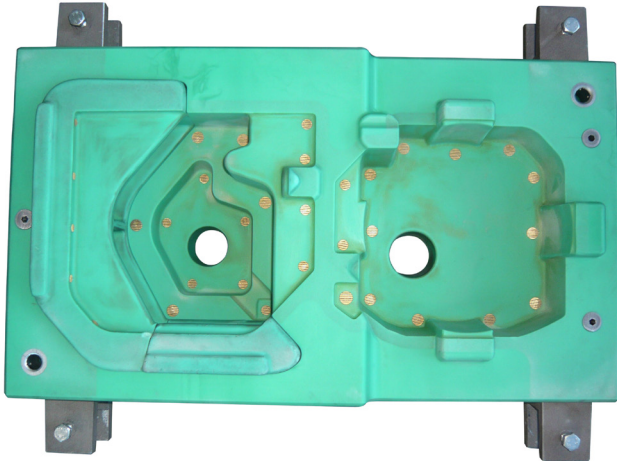




## Case Study: RAKU<sup>®</sup> TOOL WB-1250 Board

Production of a two-part core box



**Customer:**

Ohm & Häner Metallwerk GmbH & Co. KG,  
Olpe / Germany

**Objective / Application:**

Production of a two-part core box for the manufacture of an electric chain hoist housing

**Production process - Core box:**

- > Milling of core box halves from board material RAKU<sup>®</sup> TOOL WB-1250
- > Setting up of core box for core shooter
- > Finishing of core box
- > Insertion of air jets
- > Trial

**Basic molding material (sand):**

F33 Quarzwerke Frechen with a binder percentage of 0.6 % (ASK Chemicals)

**Molding process:**

Coldbox process

**Molding machine:**

Laempe L10

**Number of parts produced:**

Already approx. 10,000

**RAMPF Tooling Solutions Product:**

**The advanced board RAKU<sup>®</sup> TOOL WB-1250**

- > Easy and fast to machine, little wear of your milling cutters
- > No swelling
- > Dimensionally stable due to low coefficient of thermal expansion
- > Excellent abrasion resistance
- > Good resistance to chemicals
- > Compatible with all paints and release agents in line with industry standards
- > „Sustainable“ board, manufactured from recycling PET polyol



**Key benefits:**

- > Fast production of core box through CNC milling
- > Excellent dimensional accuracy as shrinkage, distortion and mismatch in mold can be eliminated during production. In addition fewer application errors like mixing error, temperature etc.

Our recommendations on the use of the material are based on many years of experience and current scientific and practical knowledge. They are, however, provided without any obligation on our part and do not relieve the buyer of the need for suitability tests. They do not constitute a legal relationship, nor are any protected third party rights whatsoever affected thereby. No liability accepted for misprints.