

Gravity Casting

Gravity die casting is a casting technique, where the molten aluminum is manually poured into the iron die. The main advantage of it is that it is more economical in comparison to low pressure die casting and sand casting.

Moreover the surface quality is better than those produced with the sand casting technique, but gravity castings are not as smooth as castings produced with low pressure or high pressure die casting techniques.

Gravity castings are mostly chosen for low and medium sized batch quantities.

Information on implementation

Degree of Complexity	low - medium
Tolerances	medium
Process	manual
Cores	possibility of using steel and sand cores
Inserts	possibility of using steel, stainless steel, brass
Part weights	200g – 10000g
Batch quantity	from 2500 pieces up
Heating treatment	T6 can be applied
Mechanical treatment	CNC machine, drilling, thread cutting
Surface treatments	powder coating, wet paint, technical anodizing
Cast investment	low - medium