



**CERAFLUX**

An ISO 9001 Certified Company

**"The Only Indian Company Manufacturing  
Wide Range of Metallurgical Products "**

## **CERAL RISER SLEEVE FOR GDC**

### **RISER FUNCTION :**

Risers are elements of the gating and feeding system which are intended for displacing shrinkage cavity and porosity outside the casting.

### **FEEDING BY HEAT INSULATING:-**

By using insulating Riser material one can achieve effective rise ring and directional solidification for permanent mould gravity die casting of aluminium-silicon alloys. Most satisfactory results can be achieved by using CERAL RISER SLEEVE as heat insulating material for riser

### **CERAL RISER SLEEVES:-**

Through our continuous research, we have developed and standardized two grades of CERAL RISER SLEEVES:

CERAL HI 93,

CERAL HI 142 having very high and moderately high insulating property respectively.

These are suitable grades for efficient heat insulation at riser and hence directional solidification can be achieved.

Following table proves its better properties :

Sr.	Grade CERAL	Thermal Conductivity At 800 C W/mK	Heat Transfer Coefficient BTU/h Ft <sup>2</sup> F	C.C.S. (kg/cm <sup>2</sup> )
No.1	HI 142 CERAL	0.38 to 0.40	2.65 to 2.85	45 - 50
2	HI 131	0.44 to 0.46	3.05 to 3.25	105 - 115

### **CUSTOM DESIGN :**

We can supply CERAL RISER SLEEVE as per customer's design as well as our standards.

### **APPLICATION:-**

- 1) Fit CERAL RISER SLEEVE to GDC die by using proper adhesive material or by mechanical clamping (if possible)
- 2) Then preheat the die and sleeve by torching upto 250C. Now die is ready for pouring.

### **ADVANTAGES:**

- 1) We supply machined and custom made product, just ready for use. As compared to conventional board which has material loss with added machining costs, CERAL RISER SLEEVE has zero wastage at customer's end.
- 2) High insulating promotes to minimize riser volume and hence better yield can be achieved.

NOTE:- Above information is true and accurate based on controlled laboratory testing. However user is responsible for determining suitability for application at their end. No guarantee is implied since the condition in actual use differs widely & beyond our control.

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