



Catalog 2014

Adolf's Foundry Solutions

by: Adolf's Pattern Shop

Alignment Solutions

Style ~A~ Alignment Insert



Ai-100
1.5 dia.



Ai-101
2.0 dia.



Ai-102
2.5 dia.



Ai-103
2.5 dia.



Ai-104
3.5 dia.

Style ~A~ alignment inserts are available in four different sizes and have three different depths. These inserts are made out of A.B.S. plastic and will help foundries create a perfect match when mounted on: match plates, match boards, insert boards, cope & drag boards, and molding boxes. These alignment inserts can also be used in cold molding, airset, nobake and vacuum molding.



ACP-130
2.5 x 1.87 x 15°



ACP-131
2.5 x 2.5 x 10°



ACP-132
3.5 x 3.5 x 10°

Alignment Core Print

Alignment core prints are a great solution for aligning larger molds. These prints locate on a half inch hole, and are used in green-sand, no-bake and air-set molding. They are reversible and fit perfectly on either side of the cope and drag. Adolf designed his core prints with a sand-trap ring and an additional .125 inch height for clearance to collect sand that rubs off during mold closure. The sand-trap rings are absolutely necessary for no-bake and air-set molding.

Wood Cutting Tools

Adolf's wood cutting tools are specifically design to support styles A & B alignment inserts. They are made of hardened high speed steel and will create a perfect diameter on all your match boards or molding boxes. The cutting blades are interchangeable with our cutting blade holder. This allows pattern shops and foundries to explore multiple options in creating different diameters with limited tooling cost. *Not intended for aluminum.*

- WCT-120** 1.5 in cutter w. 3/8 pilot hole.
- WCT-121** .75 in. cutting blade holder.
- WCT-122** 1.5 in. cutting blade.
- WCT-123** 1.75 in. cutting blade.
- WCT-124** 2.0 in. cutting blade.
- WCT-125** 2.5 in. cutting blade.
- WCT-126** 3.5 in. cutting blade.



Alignment Solutions

Applying registration marks



Ai-105
1.5 dia.



Ai-106
1.75 dia.



Ai-107
2.5 dia.



Ai-108
1.5 dia. Z Tol.



Ai-109
1.75 dia. Z Tol.



Ai-110
2.5 dia. Z Tol.

Style ~B~ alignment inserts are specifically designed for match-plates, match boards and automated molding machines. With both halves telescoping and inter-locking at the parting through the diameter. These inserts will create the deepest match buttons possible and can be mounted on either side of the cope and drag. Our grey *zero tolerance* insert are designed for the green sand **only**.

Alignment Core Boxes



Adolf's alignment core-boxes are lightweight, compact, and produce perfectly round and seamless cores. They are available in two, four, seven, and thirteen cavity core-boxes. All core-boxes are made of DuraTech tooling material for optimal wear resistance and effortless mold releasing properties.

Pouring & Filtering Solutions

Single Cavity Filtering Basins



PFB-200
2 sq. x 1 in. filter



PFB-201
3 dia. X 1 in. filter



PFB-202
3 sq. x 1 in. filter



PFB-203
4 sq. & 5 sq. filters



PFB-204
3 sq. x 1 in. filter

Adolf's single cavity filtering basins are lightweight molds made out of DuraTech tooling material. Imagine a combination of pouring, filtering, and riser technologies all in one basins. With several different basins to choices from, foundries can now use their own no-bake sand to create an endless supply of filtering basins. Additional savings can also be increased by utilizing sand reclamation.

Double Cavity Filtering Basins



PFB-207
2.17 sq. filters



PFB-208
2 sq. & 3 sq. filters



PFB-209
2.17 sq. & 3 dia.



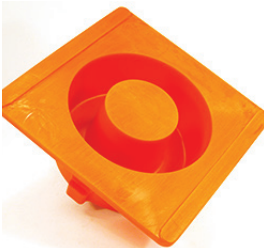
PFB-210
2.17sq. & 3 sq.



PFB-211
2.5 dia. x .5 filter

Our double cavity filtering basins are also made of DuraTech tooling material. With twice the value an our single cavity filtering basins, foundries can actually increase productivity and profit by customizing these basins into 4 and 6 cavity basins. One customized six cavity filtering basins has already produced over 2 million cores and is still operational.

Riser Rings



PBR-223
3 id. x 6 od. x 2.75 h



PFB-224
4 id. x 7.5 od. x 3 h



PFB-225
6 id. x 11 od. x 2.75 h



PFB-226
6 id. x 11 od. x 6 h

Adolf's riser rings are lightweight molds made out of DuraTech for effortless mold releasing properties. Just spray once a day with a silicone base releasing agent and have years of worry free service.

Runner Filtering Basins

Filtering basins for the running system are an alternative filtering method used in the vacuum molding and horizontal filtering processes. Adolf's filtering basins are available in eight sizes and come with single and double filtering outlets. All filtering basins can be easily adapted to a running system and are secured with wood screws.

Single Outlet

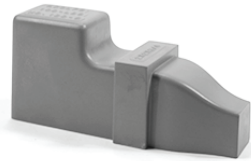
Double Outlets

Filtering Basins



PFB-205
4 sq. x 1.25 in filter

PFB-206
PFB-205/Sand saver



FBR-230
2 sq. x .75 in. filter

FBR-231
2 sq. x .75 in. filter

Pouring Basins

Adolf's pouring basins are lightweight molds made out of DuraTech tooling material. They support nobake, greensand, air-set, and flaskless molding.



FBR-232
2.17 sq. x .5 in. filter

FBR-233
2.17 sq. x .5 in. filter



PFB-220

Single face *vortex* reducing pouring basin.



FBR-234
3 sq. x 1 in. filter

FBR-235
3 sq. x 1 in. filter



PFB-221

Pop-off riser or small pouring basin.



FBR-236
4 sq. x 1 in filter

FBR-237
4 sq. x 1 in filter

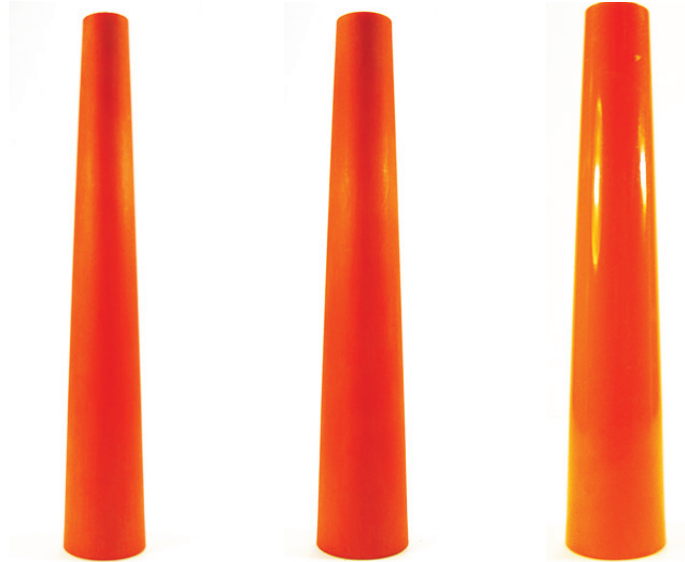


PFB-222

Tilt faced pouring cup

Sprue Solutions 1

14 Inch Sprues



Adolf's 14 inch Sprues are made of DurTech tooling material for effortless mold releasing properties. They come in three different sizes: 1¼, 1½, and 1¾ inches with a 2° draft angle. They are designed to support foundries that utilize extra-long down sprues in their molding process.

LDS-300
1.25 d x 2.25 d
w. 2° draft

LDS-301
1.50 d x 2.50 d
w. 2° draft

LDS-302
1.75 d x 2.75 d
w. 2° draft

Sprue Filtering Plug



DFP-310
2" dia. filter
8 in. height w. 2° draft

DFP-311
3" dia. filter
8 in. height w. 2° draft

DFP-312
4" dia. filter
8 in. height w. 2° draft

DFP-313
5" dia. filter
8 in. height w. 2° draft

Adolf designed his sprue filtering plugs which includes a break off notches to locate on a half inch pin that can be either mounted on a pattern or on your runner system. These plugs utilize circular ceramic filters and come in four different sizes (2, 3, 4, 5 inches diameters) to meet your foundry's needs. Like all of our orange tooling Adolf's sprue filtering plugs are made out of DuraTech tooling material.

Pop-Up Sprues

Adolf's pop-up sprues are manufactured to locate on a half inch pin and come in either as *soft base*, *solid base* or *solid core* construction. Our pop-up sprue can be mounted on either the pattern or your runners. They are available in nine different pattern sizes and used in jolt and squeeze box molding. They are made of compressible DuraTech tooling material.



PDS-320

.50 sq. x 2.5 sq. x 6 in.



PDS-321

.75 sq. x 2.0 sq. x 8 in.



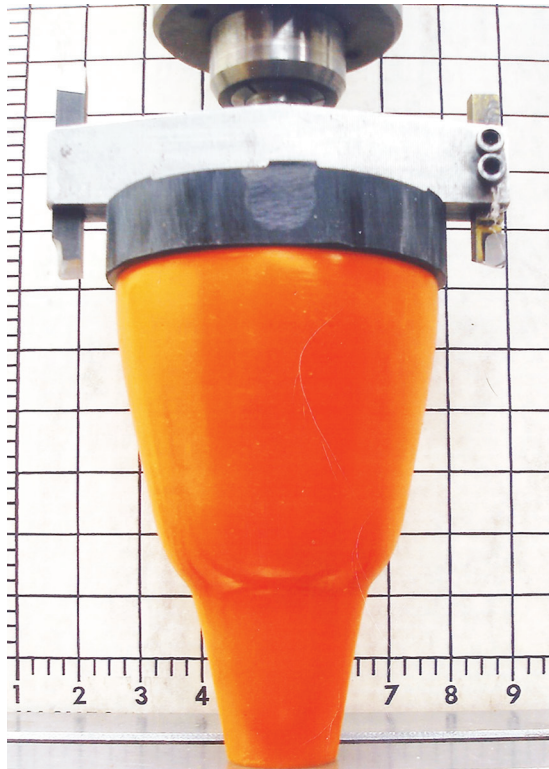
PDS-322

1.25 dia. x 3.0 dia. x 5 in.



PDS-323

1.25 dia. x 3.5 dia. x 6.5 in.



PDS-324 pop-up sprue under compression



PDS-324

1.25 dia. x 4.0 dia. x 7.5 in.



PDS-325

1.25 dia. x 3.5 sq. x 8 in.



PDS-328

1.75 dia. x 3.5 sq. x 8 in.



PDS-327

1.25 dia. x 3.5 sq. x 12 in.



PDS-326

1.5 dia. x 3.5 sq. x 10 in.

Spure Solutions 2

Single Faced Sprues



ADB-330
.625 dia. x 3.0 dia.
2.5 in. height



ADB-331
.75 dia. x 3.0 dia.
2.5 in. height



ADB-332
.75 dia. x 3.0 dia.
3.0 in. height



ADB-333
.875 dia. x 3.0 dia.
2.5 in. height



ADB-334
.875 dia. x 3.0 dia.
3.0 in. height

Adolf's single faced sprues are specifically designed to support foundries that utilize automated molding technology. All basins are made from DuraTech Tooling Material for optimal wear resistance. Our single faced sprues come in several sizes, that vary in diameter and height to support your foundries automated molding needs.

Pyramid Style Sprues



ADB-339
1.25 dia. x 2.5 sq.
1.25 height



ADB-340
1.25 dia. x 2.5 sq.
1.625 height



ADB-341
1.0 dia. x 2.5 sq.
1.25 height



ADB-342
1.0 dia. x 2.5 sq.
1.625 height



ADB-343
.75 dia. x 2.5 sq.
1.25 height

Adolf's pyramid sprues are new to our inventory. Our basins are designed to reduce the vortex in automated molding machines. These new down sprues have a 2.50 inch square base and taper to 1.25 or 1.625 inches in height. All of Adolf's sprue basins are supported by our sprue pins.

New

Three Faced Sprues



ADB-373
1.25 dia. x 3.5 dia.
3.5 in. height

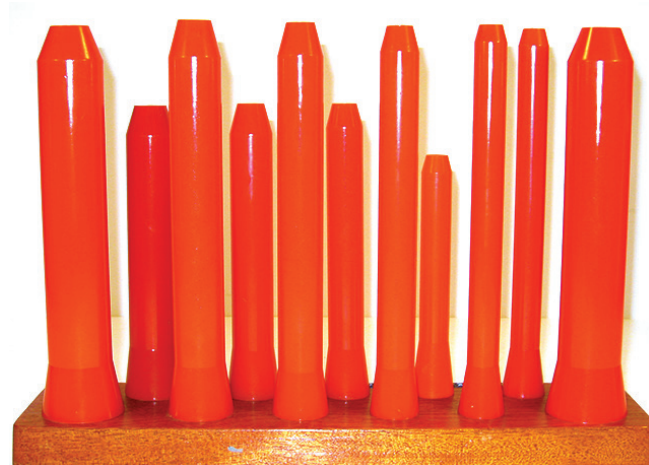


ADB-374
1.0 dia. x 3.0 dia.
3.5 in. height



ADB-375
1.0 dia. x 3.0 dia.
3 in. height

Adolf's three faced sprues are the newest addition to our *vortex* reducing sprue technology. Plus we have currently adapted our tooling to support both Hunter and Sinto automated moulding machine on these basins. All basins are made of DuraTech tooling material to give foundries a quality product with optimal wear resistance and effortless mould releasing properties.



Automated Sprues & Pins

Single Faced Sprues



ADB-335
1.0 dia. x 3.5 dia.
2.25 in. height



ADB-336
1.0 dia. x 3.0 dia.
3 in. height

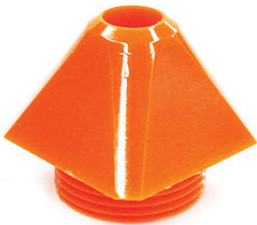


ADB-337
1.0 dia. x 3.0 dia.
3.5 in. height



ADB-338
1.25 dia. x 3.5 dia.
3.5 in. height

Pyramid Style Sprues



ADB-344
.75 dia. x 2.5 sq.
1.625 height



ADB-345
.625 dia. x 2.5 sq.
1.25 height



ADB-346
.625 dia. x 2.5 sq.
1.625 height

Filtering Sprue



ADB-360
1.25 dia. X 3.125 sq.
2.25 in. Height
Utilizes a 55 mm filter

Sprue Pins

Adolf's sprue pins are made of DuraTech for optimal wear resistance, and specifically designed to support foundries which utilize automated molding technologies.

Our sprue pins range in sizes from .625 inch in diameter to 1.25 inches in diameter, and from 5½ to 7½ inches in height.



New

Four Faced Sprues



ADB-383
1.25 dia. x 3.5 dia.
3.5 in. height



ADB-384
1.0 dia. x 3.0 dia.
3.5 in. height



ADB-385
1.0 dia. x 3.0 dia.
3 in. height

Adolf's four faced sprues are the newest addition to our *vortex* reducing sprue technology. Plus we have currently adapted our tooling on our 3 and 4 faced sprues to support both Hunter and Sinto automated moulding machine. All basins are made of DuraTech tooling material to give foundries a quality product with optimal wear resistance and effortless mould releasing properties.

Metallurgy Solutions

Test Bars & Inter-Changeable Bars



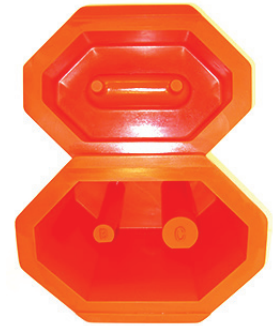
TBB-400
ASTM: A-871
Steel Keel Block



TBB-401
ASTM: A-536-93
Ductile Iron



TBB-402
ASTM: A-48
Gray Iron



TBB-403
ASTM: A-48
Gray Iron

Adolf's test bar basins come in five different sizes and support A.F.S. standards and adhere to ASTM specifications: A-48, A-536-93, and A-781. All test bars and basins are made out of DuraTech tooling material. Our *Inter-changeable* test bars support our 1, 2 and 4 cavity test bar basins.

Test Wedges & Inter-Changeable Wedges



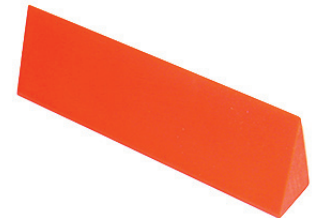
TWB-410
ASTM: A-367
2.W Test Wedge



TWB-411
ASTM: A-367
3.W Test Wedge



TWB-412
ASTM: A-367
Inter-changeable Wedges



TWB-413
ASTM: A-367
3.5W Test Wedge

Adolf's test wedge basins coming in four different sizes, support A.F.S. standards and adhere to ASTM specification: A-367. All of our inter-changeable test wedges and basins are made out of DuraTech tooling material for optimal wear resistance and durability.

Test Coupon Basin



Adolf's test coupon basin is made out of DuraTech tooling material. This basins adhere ASTM specifications: A-367 and A-842-7.

Metallurgy Solutions

Test Bars & Inter-Changeable Bars



TBB-404
ASTM: A-48
Gray Iron



TBB-405
ASTM: A-48
.88 dia. x 6 in

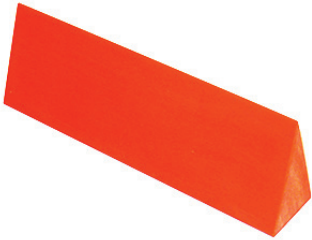


TBB-406
ASTM: A-48
1.20 dia. x 8 in



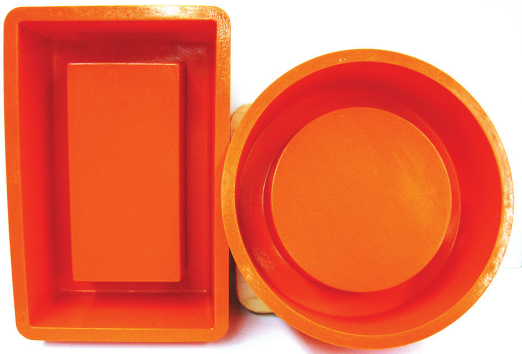
TBB-407
ASTM: A-48
2.0 dia. x 8 in

Inter-Changeable Wedge



TWB-414
ASTM: A-367
4.W Test Wedge

50 lbs. PIG Boxes



PIG-501

PIG-502

Adolf's PIG boxes create a 50 pounds size ignots designed to help foundries have more control over their inventory and formulating alloys. Our Pig boxes are light weight molds made out of DuraTech to provide optimal wear resistance, durability, and effortless mold releasing properties.

PIG-501 produces a rectangular casting 12" x 6" x 3".
PIG-502 produces a diameter casting of 10" x 2 3/4".

Silent Adjustable Vibrator

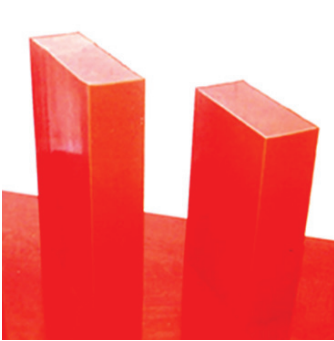


Adolf's silent adjustable vibrator is a time efficient solution for any molding line, and helps to prevent lower back injuries. Our vibrator is powered by a 3-phase, 60 hz., $\frac{3}{4}$ horse power electrical motor. The motor has enclosed counter weights to ensure safety. When set up properly the adjustable vibrator will set sand within 10-12 seconds.

We recommend attaching this vibrator to a 24" x 30" x 27" steel table. The motor can be mounted either vertically or horizontally depending on your needs; table capacity should not to exceed 1000 lbs.

Larger table are available upon request.

DuraTech Tooling Material



DuraTech Tooling Material is a lightweight orange polyurethane plastic designed for high production runs. It is known in the foundry industry for its exceptional mold releasing properties, optimal wear resistance, and its extra-ordinary strength and durability. This amazing tooling material is available in sheets from $\frac{1}{8}$ - 2 inches in thickness by 31.5 inches by 55 inches; custom blocks, rods, tubing are also available.

For more information about Adolf's Foundry Solutions contact Ricardo Volkmann at Adolf's Pattern Shop Inc.

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