

FOUNDRY PICTURES



Pattern/Mold



Induction Furnaces



Sand Cast Pouring



Centrifugal Casting

FOUNDRY OVERVIEW

Sand Casting

- The goal of the foundry at Geronimo is to produce 100% defect free castings to be machined.
- Our patterns are designed to produce a casting that has no defects and is designed to machine in the most economical manner.
- Geronimo designs and builds our own patterns and core boxes to be poured in stainless steel, nickel, and cobalt based alloys.
- One of the advantages of solid models is that the cores can be fitted in the mold and checked for metal flow.
- The patterns are used to make sand and shell molds and cores.
- The ability to make shell cores allows tighter tolerances and better surface finishes on the interior products such as valves.

Centrifugal Casting

- Water-Cooled Horizontal Centrifugal Casting Machine.
- Centrifugal Casting up to 32" OD.
- Centrifugal Casting up to 48" Length.

Pouring

- The foundry has the ability to pour up to a 1300 lb. pour which would produce a casting of 455 lbs. with a 35% yield.
- This amount is available because we have two power supplies and can melt the 1,000 lb. furnace and the 250 lb. furnace at the same time.
- Normal operation gives us a choice of melting in a 250 lb., 750 lb., or 1,000 lb. furnace. We can do the equivalent of 10, 1000 lb. heats per 10 hour shift for a total of 10,000 lbs. per day.

Heat Treating, Quenching, Cutting, Sandblasting

- We have 4 heat treat ovens that are more than adequate for the pouring capacity, along with our induction heat capabilities.
- Quenching is done in a 6' x 6' x 4' tank where the liquid is bubble aerated with compressed air to dissipate heat. We can water quench 1,000 lbs. per hour and "polymer" quench 300 lbs./hour.
- Use of Odysseus saw allows a 20" cut up to a 32" OD w/7" wall or 14" round bar.
- 12' x 10' x 8' Sandblasting booth.

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