



**Manufacturers of Grey Iron
and Ductile Iron Castings**

Commitment to quality, delivery and personalized service has made Manitowoc Grey Iron Foundry an industry leader in the production of grey and ductile iron castings since 1946. The key to our success has been our knowledgeable experienced and skilled staff. We are a semi-production, conventional and automatic molding green sand foundry. Our typical orders are in the 50-1000 mold range. We also have floor molding available on a low volume basis in Self-Set sand.

CONVENTIONAL GREEN SAND MOLDING FACILITY

| | |
|------------------------------|---|
| Squeezer range: | Most standard snap flask sizes from 12x13 to 16x16. |
| Cope and Drag Pinlift range: | 24x24, 26x26, 30x30, 22x30, 24x34, 24x40, 30x60, Flask Sizes. |
| Floor work range: | Up to 42x45" Flask Sizes in Self-Set. |
| Automatic molding: | 16x20 Flask, (Robert Sinto FBO) |

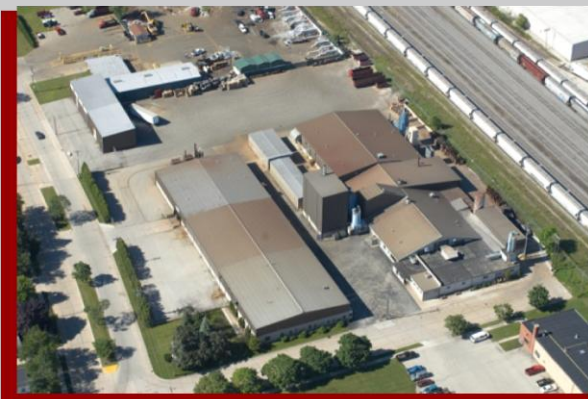


Typical Iron specifications that we pour:

| GREY IRON | DUCTILE IRON |
|------------|-----------------------------------|
| 25,000 psi | 60-45-10 As cast |
| 30,000 psi | 65-45-12 As cast |
| 35,000 psi | 60-40-18 Annealed |
| 40,000 psi | 80-55-06 As cast |
| | 100-70-03 As cast or heat treated |
| | 120-90-02 Quenched and tempered |
| | ADI - All Grades |
| | Silicon Moly Ductile |
| | Compacted Graphite Iron |

Our typical weight range is:

1-250 lbs. in production lots.
Up to 1500 lbs. in grey iron floor molds.
Up to 750 lbs. in ductile iron floor molds.



FULL PATTERN FACILITIES AVAILABLE.

COMPLETE CORE FACILITIES INCLUDING:

- Shell, Oil and Self-Set Cores.

MELTING FACILITY IS:

- (2) 4 Ton Inductotherm Coreless Dual-Melt Electric Furnances. Melting capacity is 100 tons daily.

FULL CLEANING FACILITIES INCLUDE:

- Snag Grinding and Wheelabrating.

LABORATORY EQUIPMENT FOR COMPLETE CONTROL OF SAND AND METAL CHEMISTRY TO CUSTOMER SPECIFICATIONS.

- Quality is assured by strict control of raw materials, the use of MELTLAB DI, ELECTRONITE DT375 TEMP METERS and a GDS500A Spectrometer for checking iron chemistry, and the use of outside labs for verification. **Quality Control manual available upon request.**

A Foundry Equipment List is available.

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