

HPDC runner and gating system design

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High pressure die casting (HPDC) die gating system consists of a biscuit or a sprue, a runner, a gate, overflows and vents. The biscuit forms in the cold chamber HPDC machine shot sleeve and sprue in the hot chamber HPDC die sprue bushing. Sprue bushing is an active element in guiding the metal flow. Cold chamber HPDC shot sleeve does nothing much but offers a closed place to shoot the metal from.

There are two basic runner types: tangential and fan runner. (See images below.) Runner is a carefully designed part of the HPDC die. It controls the metal flow by accelerating and directing it to the right places inside the die.

Overflows gather the oxidized front of the metal and function as heat storages near thin and/or distant parts of the casting. Vents lead gases out of the die cavity. Short die cavity fill time requires more generous venting than longer fill time. Vents and overflows attract the metal front to the wanted directions, but mainly it is the runner, which does the directing.



Image 1. Fan type runner with the basic elements in HPDC die gating systems. Cold runner gating system on the left and hot runner system on the right.

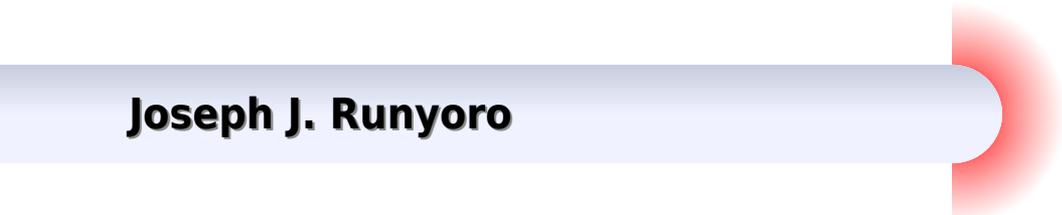


Image 2. Tangential runner for a cold chamber HPDC die.

Both runner types are widely in use. Tangential runner gives better possibility to guide the metal flow in the runner and inside the die cavity. It also gives better possibility to control the metal velocity in the gate and raise the velocity as high as wanted.

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Joseph J. Runyoro



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