



**IEG** s. r. o./ IPIDES EUROCAST GROUP

Czech Republic

*Slévárna přesného lití – Investment  
castings foundry*

## **THE CASTINGS QUALITY CONTROL – brief overview.**

### **1. First pieces dimension control (wax models die approval).**

Each imprint measured, by independent authority. Final protocol issued consequently.

### **2. Series production dimension control.**

Each piece determined sizes are verified by usual calibres and/or dimension gauges.

### **3. BRINELL hardness, ČSN/EN/ISO 6506-1**

Type	Ball diameter [mm]	Load/diameter [N/sq.mm]	Nominal load value [N]
HBW 2,5/187,5	2,5	30	1839

### **4. Control of melting and teeming temperature.**

Contact pyrometres (by ELKOSO, TERMOSONDY). Calibration interval: 1 year  
(within 2008- incl. direct PC registration). Data stored.

### **5. Chemical composition control.**

Each smelting managed and released only if spectral analysis OK; Vacuumed Optical Flame Emission Spectrometer FOUNDRY MASTER (WAS Germany); Incl. Certificate ;Data stored.

### **6. Mikrostructure control.**

a) Control wedges ultrasonic testing, for modification proces efficiancy control.

b) Metallography , 1 pc of each smelting. + photo.

### **7. Mechanical properties control.**

Tensile test, 1 pc of each smelting, cast together with castings (Testing bar drawings – see enclosure).

*The approved quality management system, certified by TÜV Rheiland, Germany.  
ISO 9001, ISO 14001*



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