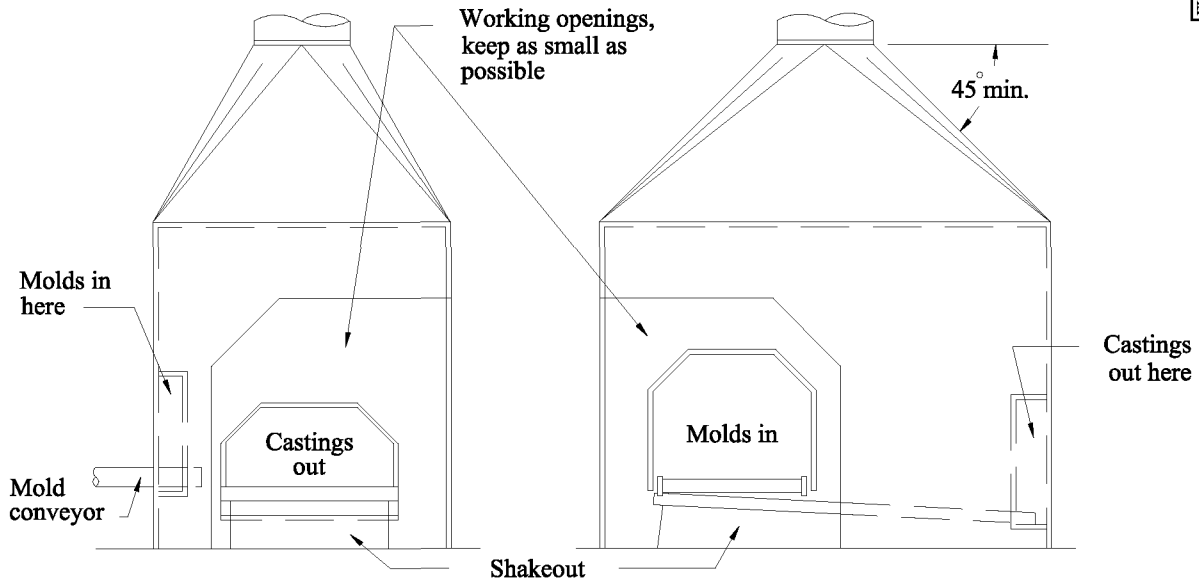


ENCLOSING HOOD

Provides best control with least flow rate
Minimum duct velocity = 4000 fpm
 $h_e = 0.25 VP_d$



Shakeout exhaust, minimum*

Type of hood	Hot castings	Cool castings
Enclosing ** VS-20-01	200 cfm/ft ² opening At least 200 cfm/ft ² grate area	200 cfm/ft ² opening At least 150 cfm/ft ² grate area
Two sides and 1/3 top area enclosed ** VS-20-02	300 cfm/ft ² grate area	275 cfm/ft ² grate area
Side hood (as shown or equivalent) ** VS-20-02	400-500 cfm/ft ² grate area	350-400 cfm/ft ² grate area
Double side hood ** VS-20-02	400 cfm/ft ² grate area	300 cfm/ft ² grate area

- * Choose higher values when
- (1) Castings are quite hot
 - (2) Sand to metal ratio is low
 - (3) Cross-drafts are high

** Shakeout hoppers require an additional 10% exhaust.



TITLE

FOUNDRY SHAKEOUT
ENCLOSURE

FIGURE

VS-20-01

DATE

10-90