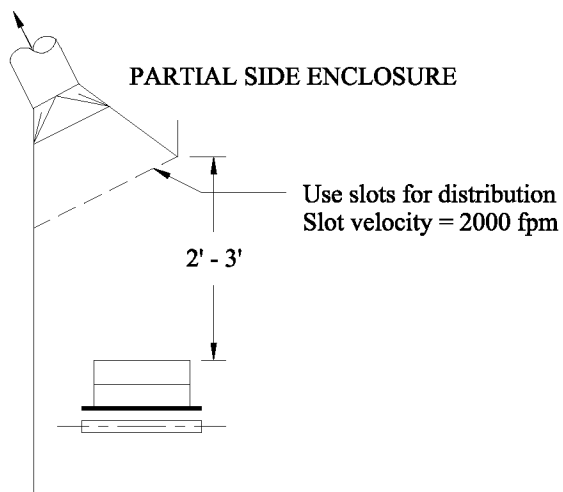


SMALL MOLDS

$Q = 200 (10 X^2 + A)$  where A equals hood area.  
 Minimum duct velocity = 3500 fpm  
 $h_e = 1.78 VP_s + 0.25 VP_d$   
 Use slots for uniform distribution, size slots  
 for 2000 fpm



$Q = 200 - 300 \text{ cfm/ft of hood length}$

Note:  
 For large molds and ladles  
 provide large - draft hood  
 similar to shakout.  
 $Q = 400 \text{ cfm/ft}^2 \text{ working area}$



TITLE

POURING STATION

FIGURE

VS-55-10

DATE

2-91