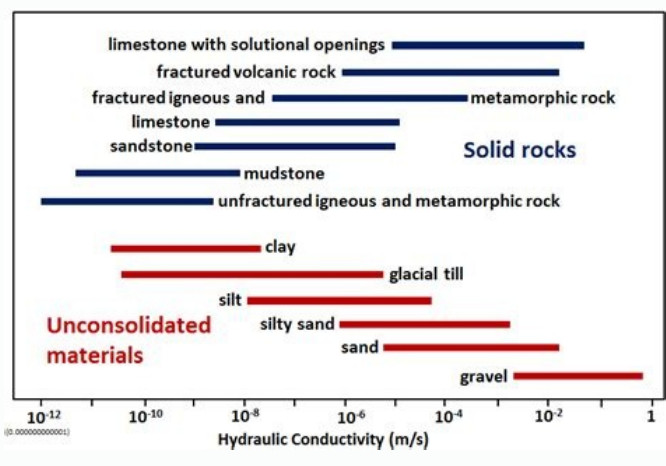




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### General Characteristics of Casting Processes

**TABLE 11.2**

Process	Typical materials cast	Weight (kg)		Typical surface finish ( $\mu\text{m}, R_a$ )	Porosity*	Shape complexity*	Dimensional accuracy*	Section thickness (mm)	
		Minimum	Maximum					Minimum	Maximum
Sand	All	0.05	No limit	5-25	4	1-2	3	1	No limit
Shell	All	0.05	1000	1-3	4	2-3	2	2	—
Expendable metal pattern	All	0.05	No limit	5-20	4	1	2	2	No limit
Plaster mold	Nonferrous (Al, Mg, Zn, Cu)	0.05	50	1-2	3	1-2	2	1	—
Investment (high melting)	All	0.005	1000	1-3	3	1	1	1	75
Permanent mold	All	0.5	300	2-3	2-3	3-4	1	2	50
Die	Nonferrous (Al, Mg, Zn, Cu)	<0.05	50	1-2	1-2	3-4	1	0.5	12
Centrifugal	All	—	3000+	2-10	1-2	3-4	3	2	100

\*Relative rating: 1 best, 5 worst.  
 Note: These ratings are only general; significant variations can occur, depending on the methods used.







The pearl that broke its shell chapter 1 summary. The pearl chapter 1-3 summary.

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Wounds were the end of the line the family. Cherie left home before her, moving with her boyfriend and having a child while she was still a teenager. You realize that she wants to continue her education and attends the legal faculty. One day, Queen returns home and finds a social worker waiting to talk to her. She then returns to some stories of her infant adverse her. They were not strangers to the shoplifting and reduced it to science, paying only for a few objects that could never stop out of the store. The larger sisters of Queen, Camille and Cherie, took most of the weight to take care of smaller children until they were able to leave the situation. Queen and the brothers of her have experienced a brutal childhood full of hunger, homeless and violence. Against all the provisions of the social worker, Queen grows until the college finish and undertakes a successful career while Camille grows to start a loving family. The woman has promised. The memory is transmitted over time. Kindle AZW file. The themes of her include resilience, abuse and boosting to help others. Usually Camille would redirect cookie angerÅ € à € ˘™, but Camille à € is home for months. She soon she moved with the two smaller children in Idaho, where Roses secretly came to her brothers's bigger than horrible abuse. Regina said she would start that course only if the social worker had promised that they would work tirelessly to make sure Roses and Norm were never back to cookies. Queen and Camille quickly obtained their emancipation, but cookies obtained Rose and Norm in a very short time. The state continued to pay a monthly check to his adoptive parents until she moved, then queen got the checks until she finished college. The book has become a bestseller all over the world. Queen It is the daughter of five children, a woman's daughter who calls cookies because he doesn't feel right to call his mother with the mother's name. 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