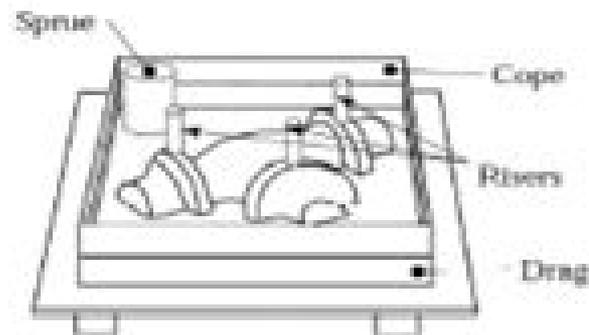
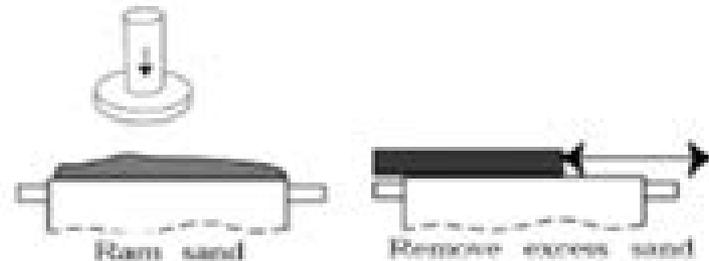


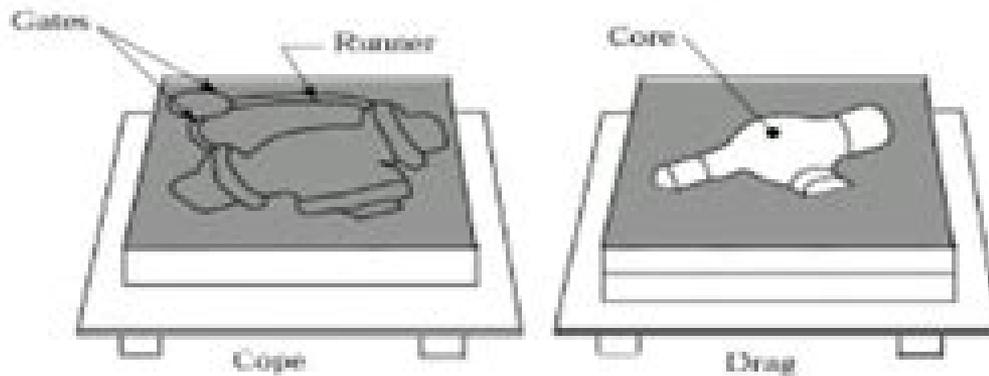
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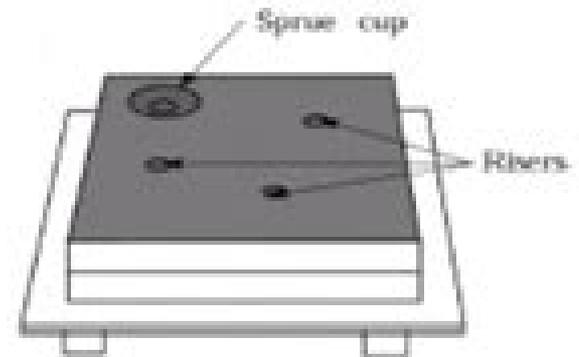
5. Roll drag over, place cope half of pattern and flask.
Note: sprue and risers are standard inserts



6. Preparing cope half of mold; this step must be repeated for each half of the mold



7. Separate flask — remove all patterns. Place core in place, close flask.



8. Flask closed and clamped, ready for pouring of molten metal.

Fig: Manufacturing steps in sand casting that causes that uses rapid-prototyped patterns

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