|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| Nr ćw. 1 | **BADANIE PODSTAWOWYCH WŁAŚCIWOŚCI MAS FORMIERSKICH** | | | |
| Nazwisko i imię | | Wydział:  Kierunek: | Grupa | Dzień tygodnia:  godz. odbywania zajęć: |

**1. Skład masy formierskiej**

a) składniki suche:

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| piasek kwarcowy | .................... | cz. w. [%] | .................... | [g] |
| glinka bentonitowa | .................... | cz. w. [%] | .................... | [g] |
| dekstryna | .................... | cz. w. [%] | .................... | [g] |
|  |  |  |  |  |

Razem: .................... [g]

b) składniki ciekłe

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| woda | …………. | [%] | ……………… | [g] |

**2. Sposób przygotowania masy formierskiej**

………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………………

**3. Pomiar wilgotności metodą grawimetryczną   
(suszarka trójstanowiskowa napromiennikowa)**

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| **Próbka nr** | **Masa pojemnika [g]** | **Masa próbki  przed suszeniem**  **[g]** | | | **Masa próbki po wysuszeniu**  **[g]** | **Wilgotność**  **[%]** |  |
| 1 |  |  | | |  |  |  |
| 2 |  |  | | |  |  |  |
| 3 |  |  | | |  |  |  |
|  |  | |  |  | |  | **średnia**  **[%]** |

**4. Pomiar wilgotności metodą automatyczną (wagosuszarka)**

czas pomiaru: …………… [min]

wilgotność: …………… [%]

**5. Pomiar przepuszczalności i wytrzymałości masy formierskiej:**

|  |  |  |  |
| --- | --- | --- | --- |
| **Lp.** | **Krotność**  **zagęszczenia**  **próbki** | **Przepuszczalność** | **Wytrzymałość na ściskanie Rcw**  [MPa] |
| 1 | 3x |  |  |
| 2 | 3x |  |  |
| 3 | 3x |  |  |
|  |  |  |  |
| 4 | 4x |  |  |
| 5 | 5x |  |  |
| 6 | 6x |  |  |
| 7 | 7x |  |  |
| 8 | 8x |  |  |
| 9 | 9x |  |  |
| 10 | 10x |  |  |
| 11 | 11x |  |  |
| 12 | 12x |  |  |





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**6. Wnioski**

Przebieg ćwiczenia (swojej części)

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Analiza otrzymanych wyników (wilgotność, przepuszczalność, wytrzymałość)

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W jaki sposób poprawić przepuszczalność formy i jej wytrzymałość

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Na co wpływa przepuszczalność formy odlewniczej

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