

COMPARISON OF CASTING TECHNIQUE	DIE CASTING	SHELL CASTING	SAND CASTING	INVESTMENT-CASTING	INVESTMENT- CASTING FONDERIA BIAGIOTTI
Cost of the mould	High	Middle	Low	Low	Very low
Possibility of geometrical changing during production	Very limited	Limited	Very good	Middle	Good
Batch size	High	Flexible	Flexible	Flexible	Very flexible
Dimensional precision	Very good	Good	Limited	Good	Good
Casting materials	Aluminum and magnesium alloys	Aluminum, brass and copper alloys	Ferrous and non-ferrous metals	Ferrous and non-ferrous metals	All the steels, nickel and cobalt based super-alloys, aluminum, bronze and magnesium alloys
Reachable geometrical complexity	Middle	Middle	Good	Very good	Best
Weight of castings (kg)	From 0.05 to 50	From 0.5 to 300	Starting from 0.05	From 0.005 to 15	From 0.005 to 40
Thickness of castings (mm)	From 0.5 to 12	From 2 a 50	Starting from 3	From 2,5 to 80	Starting from 1,5
Superficial finishing degree of castings (RMS)	150-350	150-200	63-90	60-125	60-125