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By Prior F Willis

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Excerpt: . prevent it. Do not attempt to prevent a casting from expanding by means of clamps. If you should be so foolish as to try, and the clamps were strong enough, distortion of the casting would inevitably result. As most castings are of irregular shape, and the metal usually varies in thickness, it is necessary to take some precautions in heating so that the heavy parts will expand in the same ratio as the thin parts. If this is not done either breaking or distortion is very apt to occur. This precaution is uniform heating and in order to secure a uniform heat sloiv heating is necessary. For pre-heating of cylinders and like castings in order to take care of expansion, remember to heat slowly and uniformly and of course to take care of contraction cool slowly and uniformly. That is the meat in the...



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