

The following 2 questions regarding a Romanoff Spin Caster were asked by a reader:

1) I have a eight year old Romanoff spin casting machine that has worked very well over the last 4 years I have had the machine. However, there has developed a grinding sound from the machine as the spin platter, while under pressure, is spinning to a stop. Have changed to a new thrust bearing, greased every possible bearing, put grease into the grease nipples. No change .If the air pressure is released just before the platter spins to a stop there is no grinding sound. The higher the pressure (in my case 25psi to 35psi on 9 inch moulds )on the mould the worse the sound.

Secondly . Some of my small white metal castings result in poor alignment. The section of the casting made by the top rubber disc is not aligned with the bottom disc. do the two discs of the same thickness expand at different rates outwards while hot , due to the hole in the top disc and none in the bottom, I have had this occur in black organic rubbers 9 inch dia 1&1/4 inch thick and silicone RTV rubbers also. All moulds have large numbers of square alignment studs and have tried putting studs through the center of some moulds but still get top of castings misalign with the bottom. Would be great full of any assistance you could forward to me.

Dear John, Thank you for contacting us about your Romanoff Spin Caster today.

I have referred your concern to our Technician and there are some additional points to check, before arriving at a helpful solution for you.

Mechanical:

1st/ Please check the inner shaft & observe if it is contacting the outer shaft, near the thrust bearing. Possibly the shaft is worn & causing this grinding noise.

2nd/ Check if the "Counter Sink", that holds the innershaft to the Top Plate, is worn in any way & not symmetrical any longer.

My technician has also just asked, to let you know the oiling of the bearings is fine, but have you "greased" the shaft & not just the bearings ?

After checking these points, we will be able to offer you the best solution, on the parts you may need to make this repair.

Rubber Shifting:

As for your shifting problem, we have some checking-up questions, for you as well:

If you are only doing a couple of molds (& not 8-10 molds, it is possible that the time between them is too short.

When you return to cast them they are possibly still too hot, in addition to introducing the molten metal, (too hot, too soft).

Testing:

1st/ If this is the case, you can try putting a fan near the mold to help cool it faster. When you return to cast, the temperature of the mold will be cooler, therefore firmer to accept the metal.

2nd: You may try leaving a couple of molds, overnight & cast them in the morning & see if this helps your situation somewhat, if not totally.

The use of lugs & caps is the correct method, so that doesn't seem to be the cause of the shifting.