



Renotek International
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Foundry : _____
 Contact : _____
 Phone : _____
 Email : _____
 Cell (opt): _____

Green Sand Audit

1) ADMINISTRATIVE DATA

Number of days of work per year :	
Number of month :	
Number of week :	
Number of hour per day :	
Type of molding plant :	
Type of metal :	

2) MOLDING PLANT

	Molding Line 1	Molding Line 2	Molding Line 3	Molding Line 4
Type of clay:				
Type of carbon product:				
Type of sand:				
Type of mold				
Amount of sand per hour or month in To				
Amount of sand per year in To				
Mixing quantity necessary per hour				

3) MIXER PRODUCTION

	Molding Line 1	Molding Line 2	Molding Line 3	Molding Line 4
Capacity of mixer in kg				
Time of cycle in seconds				
Sand/metal Ratio				
Added Bentonite in kg				
Cost of bentonite in \$/to				
Added carbon in kg				
Cost of carbon in \$/to				
Added new Sand in kg				
Cost of new Sand in \$/to				
Added water in kg (or liters)				
Cost of water in \$/ m ³				
Total sand in the molding plant in To				
Total new sand per day or month in kg				
Total bentonite per day or month in kg				
Total carbon per day or month in kg				
Total Water per day in m ³ or month (or liters,galons)				

4) LABORATORY ANALYSIS

	Molding Line 1	Molding Line 2	Molding Line 3	Molding Line 4
Sand granulometry in AFS:				
Average LOI in %				
Average Carbon in %				
Active Bentonite ,methylene blue %:				
Compressive strenght of your molding sand				
Bentonite LOI in %				
Bentonite water in %				
Bentonite swelling in ml				
Bentonite pH				
New sand pH				
New sand LOI in %				

Green Sand Audit

Total sand reject in To/ days					
Cost of your discharge of sand reject					
Total dust reject in To/ days					
Moisture of your molding sand					
Water pH					
Tank possibility Water in production in L or gallons					
Water for moulding sand per day in l					

5) CORE INFO		Molding Line 1	Molding Line 2	Molding Line 3	Molding Line 4
Type of mixer					
production in to/h of sand resin					
type of resin					
type of catalyst					
% of resin in sand molding					
% of catalyst in sand molding					
Price of resin					
Price of catalyst					
Quantity of molding sand in to/h					
Quantity of core sand in to/h					
Quantity of resin sand reject by day in to					
Quantity of resin sand reject by month in to					
Quantity of resin sand reject by year in to					
Quantity of new sand by year in to					
Quantity of sand resin reject by year					

Thank you, please email to : patrick.hardy@renotek-int.com