**Minimizing Core Requirements & Redesigning Cast Components**

**1. Why Minimize Cores in Casting?**

Cores are used to create internal cavities and complex shapes in castings, but they:  
✔ Increase **manufacturing cost & time**.  
✔ Lead to **core shift & dimensional inaccuracy**.  
✔ Require **additional handling and machining**.  
✔ Can cause **weak spots & porosity in castings**.

**2. Strategies to Reduce or Eliminate Cores**

**A. Redesigning to Avoid Cores**

✅ **Use Open Passages Instead of Internal Cavities** → Convert enclosed holes into slots that can be machined later.  
✅ **Modify Parting Line to Integrate Features** → Adjust the mold design so internal shapes can be cast without cores.  
✅ **Replace Cored Holes with Post-Machined Holes** → Design solid sections where holes can be **drilled later** instead of using cores.  
✅ **Use Bosses or Pads for Machining Allowance** → Provide extra material for machining instead of relying on cast holes.  
✅ **Split the Casting into Multiple Parts** → Assemble **simpler castings** instead of using complex core-dependent designs.

**B. Design Guidelines for Machined Holes in Castings**

✔ **Avoid Deep Cored Holes** → Cast **shallow recesses** and finish them with machining.  
✔ **Use Drilling Instead of Casting** → Drill **cylindrical holes** instead of casting them with cores.  
✔ **Maintain Uniform Wall Thickness** → Prevents uneven cooling and internal stress.  
✔ **Position Holes Along Machining Axes** → Align holes with standard drilling and milling operations.

**C. Alternative Methods to Reduce Core Usage**

| **Approach** | **Benefit** |
| --- | --- |
| **Replace cores with machining** | More precise & cost-effective |
| **Use permanent metal cores** | Reduces sand core defects |
| **Adjust mold parting line** | Eliminates unnecessary cores |
| **Change hole geometry** | Converts deep cored holes into machinable features |