

Insulating and Exothermic Riser Sleeves

The Joy-Mark CF series of insulating riser sleeves and CFX series of exothermic riser sleeves provide the foundry with a reliable cost effective approach for optimizing feeding efficiency, improving quality, and lowering cost. Stringent manufacturing procedures and quality control standards ensure that your risering needs will be met on a continual basis.

Joy-Mark CF insulating and CFX exothermic riser sleeves offer the following advantages over ordinary sand risers:



- Reduction of heat loss allowing smaller risers to be used
- Improved casting yield
- Reduction of melting and cleaning room costs
- Reduction of piping and shrinkage
- Maintain integrity – will not contaminate sand system
- Improved soundness of castings
- Light weight yet strong compositions to withstand molding forces
- Low smoke and fumes
- Reduction of remelt volumes
- Easily modified to create special feeding effects while maintaining thermal performance

Joy-Mark riser sleeves are available in a variety of compositions to meet your casting needs. Refer to our technical bulletin on “Ceramic Fiber Compositions” for specific application information, or contact your Joy-Mark representative for application assistance.

Joy-Mark features a wide variety of standard riser sleeve shapes and sizes. We also have internal tooling capability, so prototypes of custom shape and sizes can be produced quickly. Costs to prove out new designs are minimized. Scale up time to full production can be greatly reduced.

CF 100, CF 200, CF 300 insulating, and **CFX 700 and CFX 760** exothermic resin-bonded and starch-bonded (W) straight sleeves are available in the following standard sizes:

- 1" to 9" diameter in ½ " increments up to 18" tall, ½" wall standard
- 9" to 16" diameter in 1" increments up to 12" tall, ½ to 1" wall available
- 16" to 30' diameter in 2" increments up to 12": tall, 1 to 2" wall available

CFX800 exothermic resin-bonded sleeves are available in the following sizes:

3" to 6" diameter in ½" increments to 12" high, ½" to 1" wall available

6" to 14" diameter in 1" increments to 12" high, ½ " to 1- ½ " wall available

16" to 28" diameter in 2" diameters to 12" high, 1 – ½" to 2" wall available