

vLFC (Vacuum assisted Lost Foam Casting) Cost for CI/DI/WCB				
Molding Cost	Unit	Qty	Rate/kg	Rs/ton of Casting
STMTA	kg	3.33	₹ 800	₹ 2,666.67
Ceramic Coating	kg	35	₹ 90	₹ 3,150.00
Polythene Sheet	kg	0.15	₹ 80	₹ 12.00
Cost of Misc Glue etc/ton				₹ 300.00
Energy Cost (other than Liquid Metal)	kWh	120	₹ 9	₹ 1,098.00
Sand (Ceramic)	ton	0.003	₹ 35	₹ 0.10
Fettling Consumable				₹ 3,000
Misc Expenses				₹ 500
Raw material Cost /ton				₹ 10,727
Manpower cost per 300 ton/month	Rs/man	40	₹ 25,000	₹ 3,333
Total				₹ 14,060

vLFS (Vacuum assisted Lost Foam Shell) for Low Carbon Steel				
Molding Cost	Unit	Qty	Rate/kg	Rs/ton of Casting
EPS	kg	3.33	₹ 150	₹ 500
Refractory Coating	kg	200	₹ 85	₹ 17,000
Polythene Sheet	kg	0.15	₹ 80	₹ 12
Cost of Misc Glue etc/ton				₹ 300
Energy Cost (other than Liquid Metal) Shell Baking	kWh	200	₹ 9	₹ 1,830
Sand (Ceramic)	ton	0.003	₹ 35	₹ 0
Fettling Consumable				₹ 15,000
Misc Expenses				₹ 500
Raw material Cost /ton				₹ 35,142
Manpower cost per 100 ton/month	Rs/man	40	₹ 25,000	₹ 10,000
Total				₹ 45,142

Lost Wax Process for Low Carbon Steel based on 15 Ton Production				
Molding Cost	Unit	Qty	Rate/kg	Rs/ton of Casting
Wax (Unfilled Wax)	kg	500	₹ 240.00	₹ 8,000
Zircon Flour	kg	1000	₹ 195.00	₹ 13,000
Zircon Sand	kg	1000	₹ 180.00	₹ 12,000
Silica for mixing Zircon Flour	Ltr	10000	₹ 25.50	₹ 17,000
Backup Powder	kg	8000	₹ 12.00	₹ 6,400
16/30 Backup Sand	kg	4500	₹ 12.00	₹ 3,600
30/80 Backup Sand	kg	3500	₹ 12.00	₹ 2,800
50/80 Backup Sand	kg	2000	₹ 12.00	₹ 1,600
Power average bill			₹ 7,00,000.00	₹ 46,667
Gas average bill			₹ 3,00,000.00	₹ 20,000
Fettling Consumable			₹ 2,25,000.00	₹ 15,000
Manpower cost per 15 ton/month			₹ 7,80,000.00	₹ 52,000
Total				₹ 1,98,067