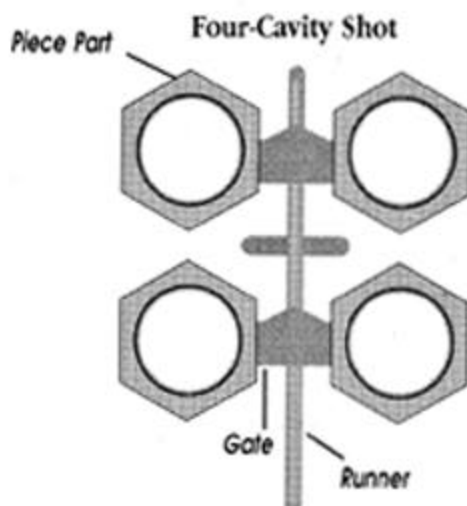


**Data Bulletin #403:****“Degating”**Part Three of the  
Tooling for Zinc Diecastings Series

The tooling you choose to manufacture your zinc diecasting is an important consideration in the successful production of your product. The method of degating requires the casting designer's attention, as it will affect the quality and cost of the product.

**How It Works**

The degating process is the removal of the part from the sprue/runner system at the gate (point at which the molten zinc enters the part cavity in the diecasting machine).



Degating Method	Advantages	Questions
Tumbling	<ul style="list-style-type: none"> <li>• Low-cost</li> <li>• Finish plateable as is</li> </ul>	<ul style="list-style-type: none"> <li>• Are small nicks okay?</li> <li>• Is gate scar too prominent?</li> </ul>
Break Off	<ul style="list-style-type: none"> <li>• Low-cost piece part</li> <li>• Low-cost tooling</li> </ul>	<ul style="list-style-type: none"> <li>• Is flash control achievable?</li> <li>• Is gate scar too prominent?</li> </ul>
Trim Die	<ul style="list-style-type: none"> <li>• Closer tolerance</li> <li>• Provides opportunity for flash removal</li> </ul>	<ul style="list-style-type: none"> <li>• What is extra cost to piece part?</li> <li>• What is extra tooling cost?</li> </ul>
In-Die Degating	<ul style="list-style-type: none"> <li>• Lower cost on extra-long runs</li> </ul>	<ul style="list-style-type: none"> <li>• Is cycle time reduced?</li> <li>• Is cast die life reduced?</li> <li>• What is extra cost of the casting die?</li> </ul>

Let DeCardy Diecasting work with you in choosing the best degating method for your part.  
Call or fax Will Vogel today.