



(19) **United States**

(12) **Patent Application Publication**

**Boyle et al.**

(10) **Pub. No.: US 2018/0221942 A1**

(43) **Pub. Date: Aug. 9, 2018**

(54) **MOLD BODY WITH INTEGRATED CHILL**

(52) **U.S. Cl.**

CPC ..... *B22D 15/04* (2013.01); *B22C 9/02* (2013.01); *B33Y 80/00* (2014.12)

(71) Applicant: **FISHER CONTROLS INTERNATIONAL LLC**,  
Marshalltown, IA (US)

(72) Inventors: **Adam Taylor Boyle**, Bukit Timah (SG); **Nathan Padriac VanBecelaere**,  
Marshalltown, IA (US)

(57) **ABSTRACT**

(21) Appl. No.: **15/425,055**

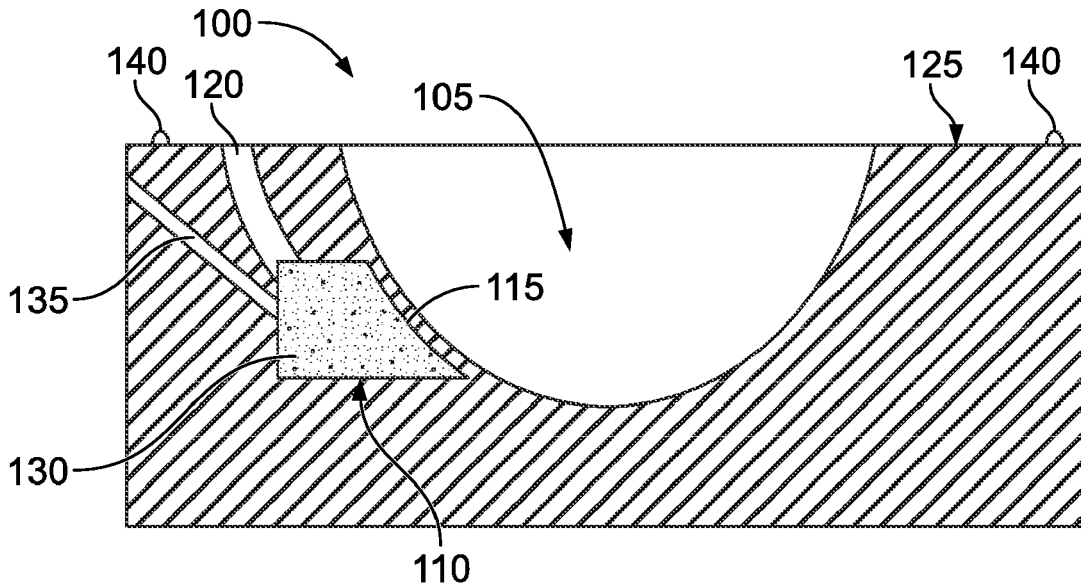
(22) Filed: **Feb. 6, 2017**

**Publication Classification**

(51) **Int. Cl.**

*B22D 15/04* (2006.01)  
*B33Y 80/00* (2006.01)  
*B22C 9/02* (2006.01)

A mold body for use in a mold includes a mold cavity, a chill cavity, a fill channel, and a chill material having a thermal conductivity that is greater than the thermal conductivity of the mold body disposed within the chill cavity. The chill cavity is formed adjacent the mold cavity and is separated from the mold cavity by a chill wall. The fill channel is in communication with the chill cavity and with an exterior surface of the mold body.



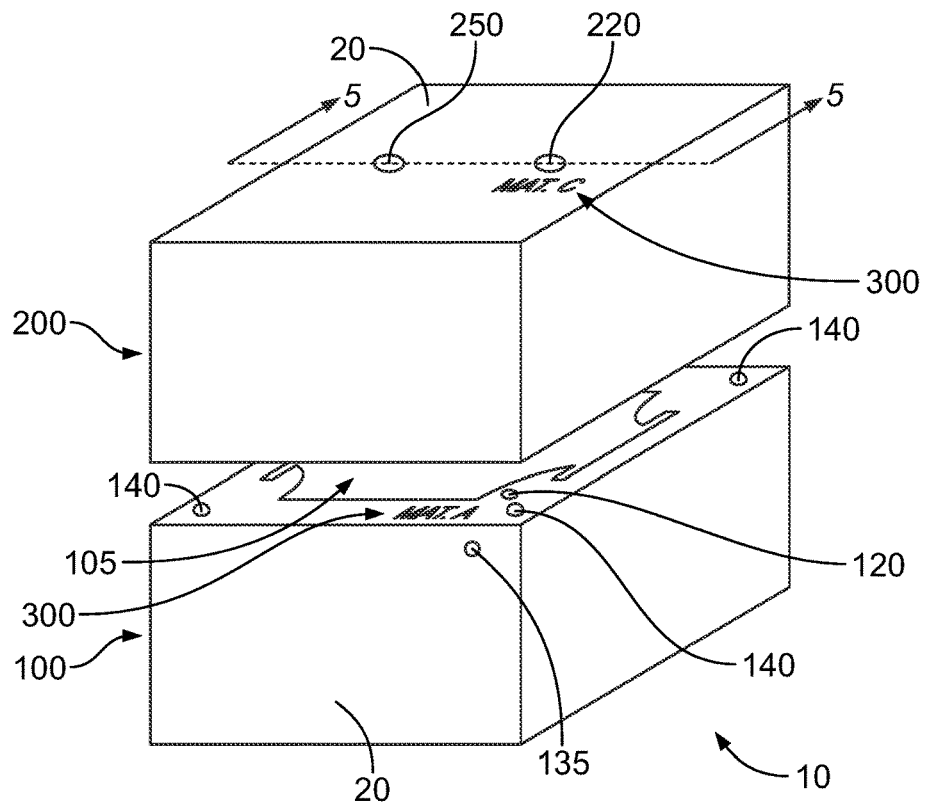


FIG. 1

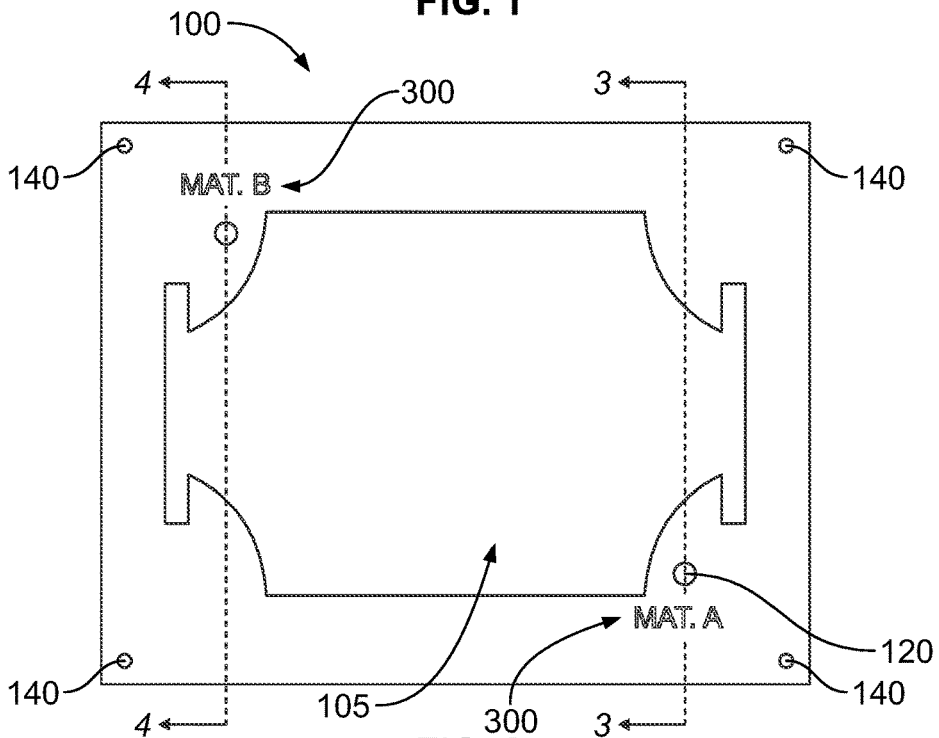


FIG. 2

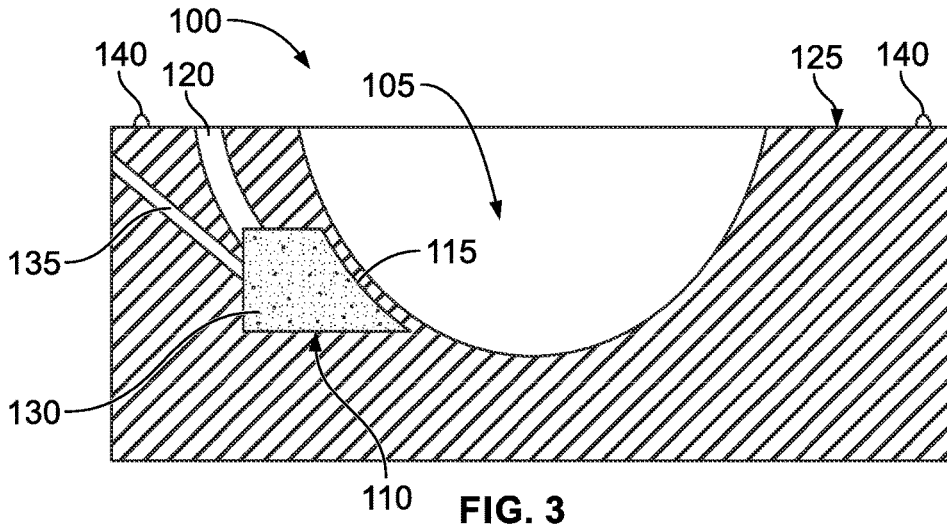


FIG. 3

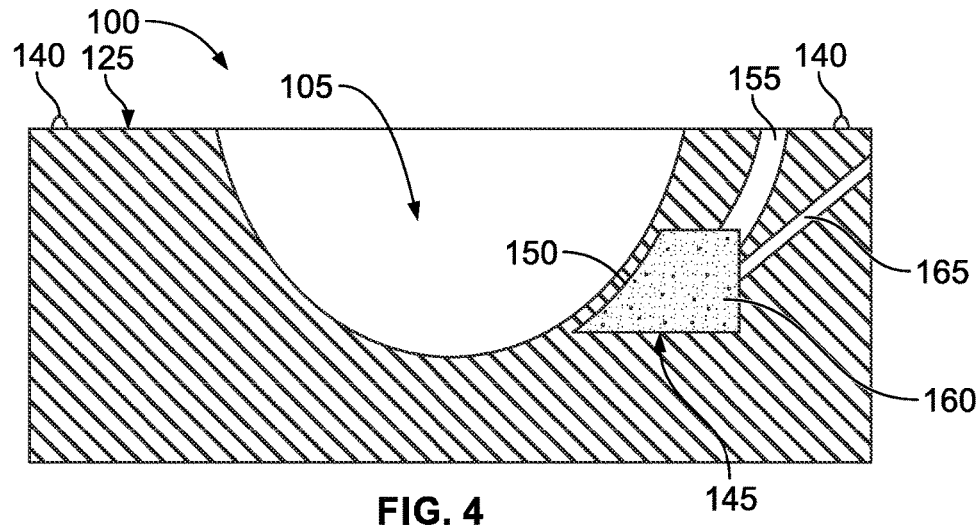


FIG. 4

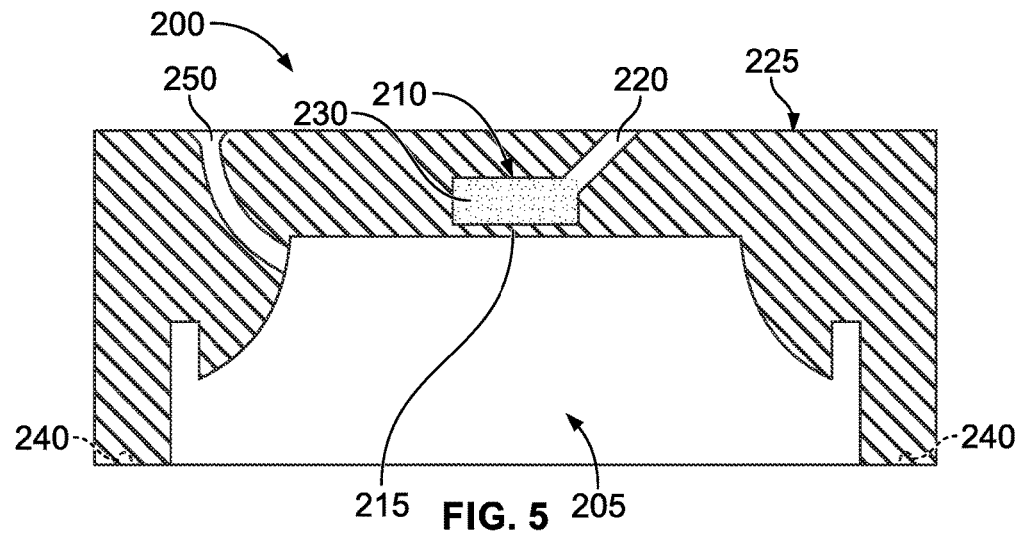


FIG. 5

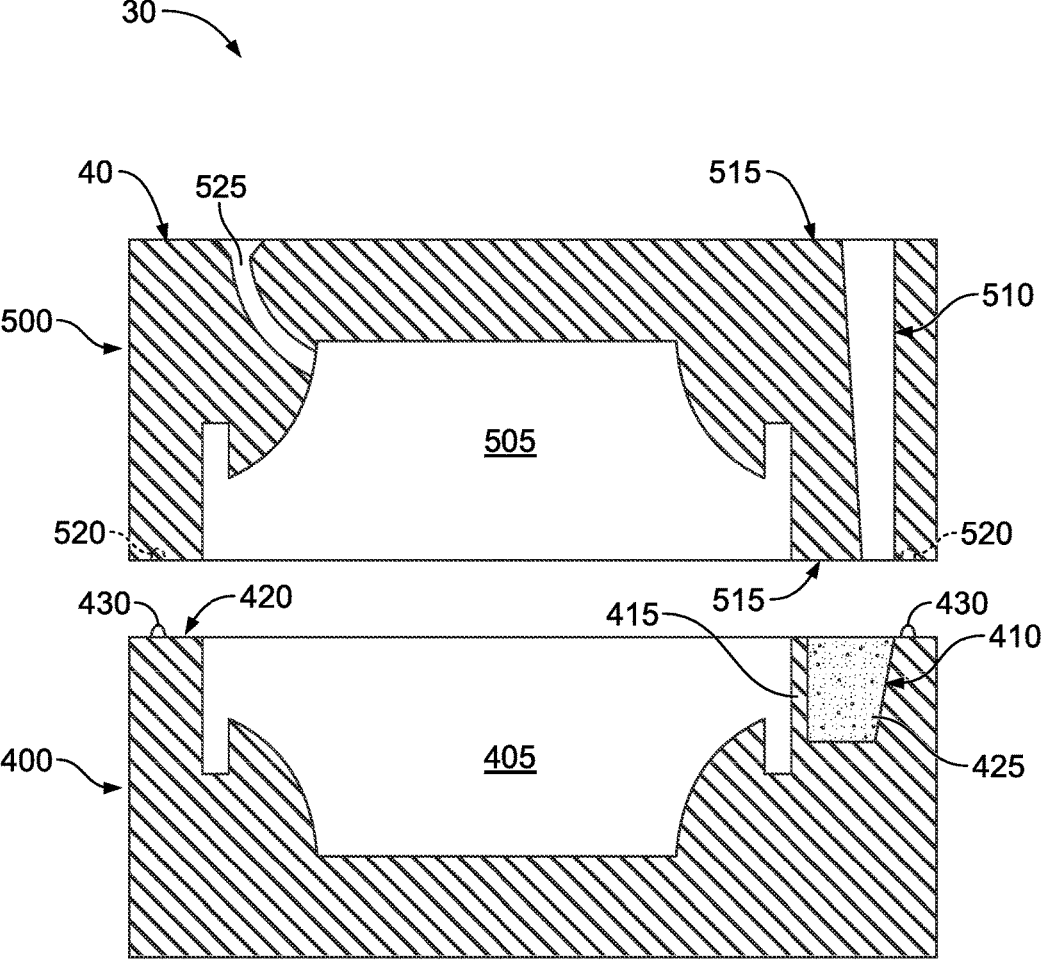


FIG. 6

## MOLD BODY WITH INTEGRATED CHILL

### FIELD OF THE DISCLOSURE

[0001] The present disclosure is directed generally to molds and, more particularly, to mold bodies with integrated chills.

### BACKGROUND

[0002] Foundries use molds, such as sand molds, investment molds, etc., to produce metal and other material castings having a great variety of sizes, shapes, and complexities. Some castings, such as those for valve bodies, have very unique shapes that require a high level of quality to be maintained. To better control the casting process and maintain a high level of quality, chills can be utilized in the molds to more rapidly cool molten metal, which is commonly done to minimize or eliminate shrink defects in all types of metal castings. A typical chill is a piece of metal, or other acceptable material, that is incorporated into a mold body at the edge of the molding cavity and forms a part of the molding cavity in the area where accelerated cooling of the casting is desired. The chill is incorporated into the mold body when the mold body is produced.

[0003] However, various issues arise in an attempt to incorporate typical chills in mold bodies created using 3D printing, such as 3D sand printing. In 3D sand printing, a 3-dimensional design of the entire mold or of a particular mold body is produced and divided into multiple layers. A thin layer of sand, such as silica sand, which could be mixed with a suitable activator, is then laid down representing the first layer of the design. A binder is applied to the areas required to form the solid structure for that particular layer. A second thin layer of sand, representing the second layer of the design, is then laid down over the first layer and the binder is applied to the areas required to form the solid structure for that particular layer. This continues layer after layer to form the completed mold or mold body design.

[0004] Using this 3D sand printing process, the mold body can no longer be produced around a typical chill, as placement of the chill would impede the machinery used in the 3D sand printing process. Thus, instead of producing the mold body around the chill, the chill has to be produced outside of the mold body to a near net shape, a cavity has to be formed in the mold body to receive the chill, and the chill has to be inserted into the existing 3D sand printed mold. However, various issues arise such as maintaining the dimensional tolerances of the chill and the cavity formed in the mold body required for the chill to properly fit in the 3D sand printed mold body and to properly align the chill with the desired surface of the casting. In addition, it can be difficult to place and secure the chill within the cavity so that the chill does not move or become dislodged during the casting process.

### BRIEF SUMMARY OF THE DISCLOSURE

[0005] In accordance with one exemplary aspect of the present invention, a mold body for use in a mold includes a mold cavity, a chill cavity, a fill channel, and a chill material having a thermal conductivity that is greater than the thermal conductivity of the mold body disposed within the chill cavity. The chill cavity is formed adjacent the mold cavity and is separated from the mold cavity by a chill wall. The fill

channel is in communication with the chill cavity and with an exterior surface of the mold body.

[0006] In further accordance with any one or more of the foregoing exemplary aspects of the present invention, the mold body may further include, in any combination, any one or more of the following preferred forms.

[0007] In one preferred form, the mold body is one of a sand mold body and a 3D printed sand mold body.

[0008] In another preferred form, the chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand.

[0009] In another preferred form, the mold body includes a second chill cavity, a second fill channel, and a second chill material. The second chill cavity is formed adjacent the mold cavity, is spaced apart from the chill cavity, and is separated from the mold cavity by a second chill wall. The second fill channel is in communication with the second chill cavity and with the exterior surface of the mold body. The second chill material is disposed within the second chill cavity and has a thermal conductivity that is greater than the thermal conductivity of the mold body.

[0010] In another preferred form, the second chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand.

[0011] In another preferred form, the second chill material is different than the chill material.

[0012] In another preferred form, the mold body includes a vent channel having a first end in communication with the chill cavity and a second end in communication with an exterior surface of the mold to vent the chill cavity to the atmosphere.

[0013] In accordance with another exemplary aspect of the present invention, a method of producing a mold body for use in a mold, comprising the steps of: forming a mold cavity; forming a chill cavity adjacent the mold cavity and separated from the mold cavity by a chill wall; forming a fill channel in communication with the chill cavity and with an exterior surface of the mold body; and filling the chill cavity with a chill material, the chill material having a thermal conductivity that is greater than the thermal conductivity of the mold body.

[0014] In further accordance with any one or more of the foregoing exemplary aspects of the present invention, the method may further include, in any combination, any one or more of the following preferred forms.

[0015] In one preferred form, the mold body is produced by 3D sand printing.

[0016] In another preferred form, the chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand.

[0017] In another preferred form, the method includes the steps of: forming a second chill cavity adjacent the mold cavity and spaced apart from the chill cavity, the second chill cavity separated from the mold cavity by a second chill wall; forming a second fill channel in communication with the second chill cavity and with the exterior surface of the mold body; and filling the second chill cavity with a second chill material, the second chill material having a thermal conductivity that is greater than the thermal conductivity of the mold body.

[0018] In another preferred form, the second chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand.

**[0019]** In another preferred form, the second chill material is different than the chill material.

**[0020]** In another preferred form, the method includes the step of forming a vent channel having a first end in communication with the chill cavity and a second end in communication with an exterior surface of the mold to vent the chill cavity to the atmosphere.

**[0021]** In accordance with another exemplary aspect of the present invention, a mold kit includes a plurality of mold bodies and a chill material. At least one of the mold bodies includes a mold cavity, a chill cavity formed adjacent the mold cavity and separated from the mold cavity by a chill wall, and a fill channel in communication with the chill cavity and with an exterior surface of the mold body. The chill material is to be inserted into the chill cavity through the fill channel and has a thermal conductivity that is greater than the thermal conductivity of the mold body.

**[0022]** In further accordance with any one or more of the foregoing exemplary aspects of the present invention, the mold kit may further include, in any combination, any one or more of the following preferred forms.

**[0023]** In one preferred form, the mold bodies are one of sand mold bodies and 3D printed sand mold bodies.

**[0024]** In another preferred form, the at least one of the mold bodies includes a second chill cavity formed proximate the mold cavity and spaced apart from the chill cavity, the second chill cavity is separated from the mold cavity by a second chill wall, and a second fill channel in communication with the second chill cavity. The mold kit also includes a second chill material to be inserted into the second chill cavity through the second fill channel that has a thermal conductivity that is greater than the thermal conductivity of the mold body.

**[0025]** In another preferred form, the chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand and the second chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand.

**[0026]** In another preferred form, the second chill material is different than the chill material.

**[0027]** In another preferred form, the at least one of the mold bodies includes a vent channel having a first end in communication with the chill cavity and a second end in communication with an exterior surface of the mold body to vent the chill cavity to the atmosphere.

#### BRIEF DESCRIPTION OF THE DRAWINGS

**[0028]** FIG. 1 is a perspective view of an example mold having multiple mold bodies with integral chill cavities;

**[0029]** FIG. 2 is a top view of one of the mold bodies of FIG. 1;

**[0030]** FIG. 3 is a cross-sectional view of the mold body of FIG. 2 taken along line A-A;

**[0031]** FIG. 4 is a cross-section view of the mold body of FIG. 2 taken along line B-B;

**[0032]** FIG. 5 is a cross-section view of the other mold body of FIG. 1, taken along line C-C; and

**[0033]** FIG. 6 is a cross-section view of another example mold having multiple mold bodies and an integral chill cavity.

#### DETAILED DESCRIPTION

**[0034]** The examples described in the present disclosure provide the benefits of a traditional chill while eliminating the need to manufacture a near net shape chill to incorporate into a mold body, such as a 3D sand printed mold body. In the examples described herein, there is no longer any need to produce a near net shape chill via a machining operation and insert the chill into a cavity formed in the mold body. Rather, the molds, mold bodies, and methods described herein use a preformed pocket or chill cavity filled with a chill material such as metallic beads, ceramic beads, or specialty sands, that gives ideal thermal properties in the place of a typical chill. This allows the mold body design to 3D print the chill cavity and create a chill wall or barrier of sand between the casting surface and chill cavity. In addition, this minimizes the need for an inventory of chill blocks and could allow for a reduction in cost and personnel.

**[0035]** Referring to FIG. 1, an example mold **10** has an exterior surface **20** encompassing the complete outer surface of mold **10** and includes first and second mold bodies **100**, **200**. Although mold **10** is shown as having two mold bodies for simplicity, it is understood that mold **10** can have any number of mold bodies as required for a particular casting application.

**[0036]** First mold body **100** can be manufactured using any desired manufacturing technique and can be a sand mold body or a 3D printed sand mold body, made by the 3D sand printing technique described above. As can be seen in FIGS. 2-4, first mold body **100** has a mold cavity **105** formed in first mold body **100** to produce at least a portion of the outer surface of a casting and can include protrusions **140**, which can be received within recesses **240** in second mold body **200** to align first mold body **100** and second mold body **200** during the casting process. As best seen in FIG. 3, a chill cavity **110** is also formed in first mold body **100** adjacent mold cavity **105**. Chill cavity **110** is separated from mold cavity **105** by chill wall **115**, such that the area of chill wall **115** between chill cavity **110** and mold cavity **105** provides the area of the integrated chill. The thickness of chill wall **115** can be determined based on the particular design and application taking into account various factors, such as the thermal conductivity of the material used for first mold body **100**, the thermal conductivity of the chill material **130**, the casting material used, the desired chill effect, etc.

**[0037]** Chill material **130** is disposed in chill cavity **110** and, in order to provide a desired chill effect, chill material **130** has a thermal conductivity that is greater than the thermal conductivity of the material used for first mold body **100** to draw heat through chill wall **115** and cool the casting in the chill area. Chill material **130** acts as a heat sink to draw heat through chill wall **115** and into chill material **130**, which will create a rapid cooling effect in a localized area similar to a common chill. Some examples of materials that could work for chill material **130** are metallic beads, such as ball bearings, zircon sand, chromite sand, ceramic beads, olivine sand, other specialty sands, or any other material that provides the desired thermal conductivity properties.

**[0038]** To provide a way to fill chill cavity **110** with chill material **130**, a fill channel **120** can be formed in first mold body **100** that is in communication with chill cavity **110** and with an exterior surface **125** of first mold body **100**. As discussed in more detail below, identifiers **300** can also be incorporated in first mold body **100** adjacent each respective

fill channel **120** that can be used to identify the particular chill material **130** to be used in each chill cavity.

**[0039]** During the casting process, expanding gases produced in the chill cavities from increased temperatures may need to be vented. In the event a particular chill cavity cannot be vented through the fill channel, such as chill cavity **110**, a vent channel **135** can be formed in first mold body **100** that has a first end in communication with chill cavity **110** and a second end in communication with exterior surface **20** of mold **10** to vent chill cavity **110** to the atmosphere.

**[0040]** As best seen in FIG. **4**, if an additional chill area is desired in first mold body **100**, a second chill cavity **145** can also be formed in first mold body **100** adjacent mold cavity **105** and spaced apart from chill cavity **110**. Second chill cavity **145** is separated from mold cavity **105** by second chill wall **150**, such that the area of second chill wall **150** between second chill cavity **145** and mold cavity **105** provides a second integrated chill area. The thickness of second chill wall **150** can be determined based on the particular design and application taking into account various factors, such as the thermal conductivity of the material used for first mold body **100**, the thermal conductivity of the second chill material **160**, the casting material used, the desired chill effect, etc.

**[0041]** Second chill material **160** is disposed in second chill cavity **145** and, in order to provide a desired chill effect, second chill material **160** has a thermal conductivity that is greater than the thermal conductivity of the material used for first mold body **100** to draw heat through second chill wall **150** and cool the casting in the chill area. Second chill material **160** acts as a heat sink to draw heat through second chill wall **150** and into second chill material **160**, which will create a rapid cooling effect in a localized area similar to a common chill. Some examples of materials that could work for second chill material **160** are metallic beads, such as ball bearings, zircon sand, chromite sand, ceramic beads, olivine sand, other specialty sands, or any other material that provides the desired thermal conductivity properties. While second chill material **160** may be the same as chill material **130**, second chill material **160** could be different from chill material **130** to provide a different chill effect to the second integrated chill area defined by second chill wall **150** than that provided to the integrated chill area defined by chill wall **115**.

**[0042]** To provide a way to fill second chill cavity **145** with second chill material **160**, a second fill channel **155** can be formed in first mold body **100** that is in communication with second chill cavity **145** and with exterior surface **20** of first mold body **100**.

**[0043]** In this particular example, since second chill cavity **145** cannot be vented through second fill channel **155**, a second vent channel **165** can also be formed in first mold body **100** that has a first end in communication with second chill cavity **145** and a second end in communication with exterior surface **20** of mold **10** to vent second chill cavity **145** to the atmosphere.

**[0044]** Second mold body **200** can also be manufactured using any desired manufacturing technique and can be a sand mold body or a 3D printed sand mold body, made by the 3D sand printing technique described above. As shown in FIG. **5**, second mold body **200** also has a mold cavity **205** formed in second mold body **200** to produce at least a portion of the outer surface of a casting and can include recesses **240**, which can receive protrusions **140** in first mold

body **100** to align first mold body **100** and second mold body **200** during the casting process. A chill cavity **210** is also formed in second mold body **200** adjacent mold cavity **205**. Chill cavity **210** is separated from mold cavity **205** by chill wall **215**, such that the area of chill wall **215** between chill cavity **210** and mold cavity **205** provides the area of the integrated chill. The thickness of chill wall **215** can be determined based on the particular design and application taking into account various factors, such as the thermal conductivity of the material used for second mold body **200**, the thermal conductivity of the chill material **230**, the casting material used, the desired chill effect, etc.

**[0045]** Chill material **230** is disposed in chill cavity **210** and, in order to provide a desired chill effect, chill material **230** has a thermal conductivity that is greater than the thermal conductivity of the material used for second mold body **200** to draw heat through chill wall **215** and cool the casting in the chill area. Chill material **230** acts as a heat sink to draw heat through chill wall **215** and into chill material **230**, which will create a rapid cooling effect in a localized area similar to a common chill. Some examples of materials that could work for chill material **230** are metallic beads, such as ball bearings, zircon sand, chromite sand, ceramic beads, olivine sand, other specialty sands, or any other material that provides the desired thermal conductivity properties. While chill material **230** may be the same as chill material **130** and/or second chill material **160**, chill material **230** could be different from chill material **130** and/or second chill material **160** to provide a different chill effect to the integrated chill area defined by chill wall **215**.

**[0046]** To provide a way to fill chill cavity **210** with chill material **230**, a fill channel **220** can be formed in second mold body **200** that is in communication with chill cavity **210** and with an exterior surface **225** of second mold body **200**, which in the example shown is also part of exterior surface **20** of mold **10**. As discussed in more detail below, identifiers **300** can also be incorporated in second mold body **200** adjacent fill channel **220** that can be used to identify the particular chill material **230** to be used in chill cavity **210**. In the example shown, since fill channel **220** is in communication with exterior surface **20** of mold **10**, fill channel **220** can be used to vent chill cavity **210** to the atmosphere and a separate vent channel is not required. Similarly, a sprue **250** can also be formed in second mold body **200** that is in communication with mold cavity **205** and with an exterior surface **225** of second mold body **200**, which in the example shown is also part of exterior surface **20** of mold **10**, to provide an opening in which molten material can be poured into mold **10** during the casting process.

**[0047]** FIG. **6** shows another an example mold **30** having an exterior surface **40** encompassing the complete outer surface of mold **30** and including first and second mold bodies **400**, **500**. Again, although mold **30** is shown as having two mold bodies for simplicity, it is understood that mold **30** can have any number of mold bodies as required for a particular casting application. In addition, mold **30** and mold bodies **400**, **500** can be manufactured using any desired manufacturing technique and can be a sand mold body or a 3D printed sand mold body, made by the 3D sand printing technique described above. However, the example shown in FIG. **6** may be better suited for traditional sand mold manufacturing techniques.

**[0048]** As can be seen in FIG. **6**, first mold body **400** has a mold cavity **405** formed in first mold body **400** to produce

at least a portion of the outer surface of a casting and can include protrusions **430**, which can be received within recesses **520** in second mold body **500** to align first mold body **400** and second mold body **500** during the casting process. A chill cavity **410** is also formed in first mold body **400** adjacent mold cavity **405** and is positioned near the parting line of mold **30** in communication with an exterior surface **420** of first mold body **400**. Chill cavity **410** is separated from mold cavity **405** by chill wall **415**, such that the area of chill wall **415** between chill cavity **410** and mold cavity **405** provides the area of the integrated chill. The thickness of chill wall **415** can be determined based on the particular design and application taking into account various factors, such as the thermal conductivity of the material used for first mold body **400**, the thermal conductivity of the chill material **425**, the casting material used, the desired chill effect, etc.

**[0049]** Chill material **425** is disposed in chill cavity **410** and, in order to provide a desired chill effect, chill material **425** has a thermal conductivity that is greater than the thermal conductivity of the material used for first mold body **400** to draw heat through chill wall **415** and cool the casting in the chill area. Chill material **425** acts as a heat sink to draw heat through chill wall **415** and into chill material **425**, which will create a rapid cooling effect in a localized area similar to a common chill. Some examples of materials that could work for chill material **425** are metallic beads, such as ball bearings, zircon sand, chromite sand, ceramic beads, olivine sand, other specialty sands, or any other material that provides the desired thermal conductivity properties.

**[0050]** Second mold body **500** also has a mold cavity **505** formed in second mold body **500** to produce at least a portion of the outer surface of a casting and can include recesses **520**, which can receive protrusions **430** in first mold body **400** to align first mold body **400** and second mold body **500** during the casting process.

**[0051]** To provide a way to fill chill cavity **410** in first mold body **400**, a fill channel **510** can be formed in second mold body **500** that is in communication with chill cavity **410** when mold **30** is closed and with an exterior surface **515** of second mold body **500**, which in the example shown is also part of exterior surface **40** of mold **30**. Fill channel **510** can also be tapered to allow the mold to draw off. In the example shown, since fill channel **510** is in communication with exterior surface **40** of mold **30**, fill channel **510** can be used to vent chill cavity **410** to the atmosphere and a separate vent channel is not required. Similarly, a sprue **525** can also be formed in second mold body **500** that is in communication with mold cavity **505** and with exterior surface **515** of second mold body **500**, to provide an opening in which molten material can be poured into mold **30** during the casting process. As discussed in more detail below, identifiers can also be incorporated in second mold body **500** adjacent fill channel **510** that can be used to identify the particular chill material **425** to be used in chill cavity **410**.

**[0052]** Molds using the above described integrated chills can also be provided as mold kits. For example, a mold kit could be provided that contained first and second mold bodies **100**, **200** described above and various packages of chill material, such as chill materials **130**, **160**, **230** described above, to fill chill cavities **110**, **145**, **210** through fill channels **120**, **155**, **220**. First and second mold bodies **100**, **200** can include identifiers **300** adjacent fill channels **120**, **155**, **220** to identify which chill material **130**, **160**, **230**

goes into which fill channel **120**, **155**, **220** and the mold kit could include instructions as to which chill material to be used and how much to fill each chill cavity. Identifiers **300** could be any recognizable text or symbol and could be incorporated into or onto first and second mold bodies **100**, **200** in a variety of ways, such as forming or etching identifiers **300** directly into the mold bodies, printing identifiers **300** directly on the mold bodies, printing identifiers **300** on labels that are adhered to the mold bodies, etc.

**[0053]** While the present invention has been described with reference to specific examples, which are intended to be illustrative only and not to be limiting of the invention, it will be apparent to those of ordinary skill in the art that changes, additions or deletions may be made to the disclosed embodiments without departing from the spirit and scope of the invention.

What is claimed is:

1. A mold body for use in a mold, comprising:
  - a mold cavity;
  - a chill cavity formed adjacent the mold cavity and separated from the mold cavity by a chill wall;
  - a fill channel in communication with the chill cavity and with an exterior surface of the mold body; and
  - a chill material disposed within the chill cavity, the chill material having a thermal conductivity that is greater than the thermal conductivity of the mold body.
2. The mold body of claim 1, wherein the mold body is one of a sand mold body and a 3D printed sand mold body.
3. The mold body of claim 1, wherein the chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand.
4. The mold body of claim 1, further comprising:
  - a second chill cavity formed adjacent the mold cavity and spaced apart from the chill cavity, the second chill cavity separated from the mold cavity by a second chill wall;
  - a second fill channel in communication with the second chill cavity and with the exterior surface of the mold body; and
  - a second chill material disposed within the second chill cavity, the second chill material having a thermal conductivity that is greater than the thermal conductivity of the mold body.
5. The mold body of claim 4, wherein the second chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand.
6. The mold body of claim 4, wherein the second chill material is different than the chill material.
7. The mold body of claim 1, further comprising a vent channel having a first end in communication with the chill cavity and a second end in communication with an exterior surface of the mold to vent the chill cavity to atmosphere.
8. A method of producing a mold body for use in a mold, comprising the steps of:
  - forming a mold cavity;
  - forming a chill cavity adjacent the mold cavity and separated from the mold cavity by a chill wall;
  - forming a fill channel in communication with the chill cavity and with an exterior surface of the mold body; and
  - filling the chill cavity with a chill material, the chill material having a thermal conductivity that is greater than the thermal conductivity of the mold body.



9. The method of claim 8, wherein the mold body is produced by 3D sand printing.

10. The method of claim 8, wherein the chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand.

11. The method of claim 8, further comprising the steps of:

forming a second chill cavity adjacent the mold cavity and spaced apart from the chill cavity, the second chill cavity separated from the mold cavity by a second chill wall;

forming a second fill channel in communication with the second chill cavity and with the exterior surface of the mold body; and

filling the second chill cavity with a second chill material, the second chill material having a thermal conductivity that is greater than the thermal conductivity of the mold body.

12. The method of claim 11, wherein the second chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand.

13. The method of claim 11, wherein the second chill material is different than the chill material.

14. The method of claim 8, further comprising the step of forming a vent channel having a first end in communication with the chill cavity and a second end in communication with an exterior surface of the mold to vent the chill cavity to atmosphere.

15. A mold kit, comprising:

a plurality of mold bodies, at least one of the mold bodies comprising:

a mold cavity;

a mold cavity;

a chill cavity formed adjacent the mold cavity and separated from the mold cavity by a chill wall; and

a fill channel in communication with the chill cavity and with an exterior surface of the mold body; and a chill material to be inserted into the chill cavity through the fill channel, the chill material having a thermal conductivity that is greater than the thermal conductivity of the mold body.

16. The mold kit of claim 15, wherein the mold bodies are one of sand mold bodies and 3D printed sand mold bodies.

17. The mold kit of claim 15, wherein:

the at least one of the mold bodies further comprises: a second chill cavity formed proximate the mold cavity and spaced apart from the chill cavity, the second chill cavity separated from the mold cavity by a second chill wall; and a second fill channel in communication with the second chill cavity; and

the mold kit further comprises: a second chill material to be inserted into the second chill cavity through the second fill channel, the second chill material having a thermal conductivity that is greater than the thermal conductivity of the mold body.

18. The mold kit of claim 17, wherein:

the chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand; and the second chill material is one of metallic beads, zircon sand, chromite sand, ceramic beads, or olivine sand.

19. The mold kit of claim 17, wherein the second chill material is different than the chill material.

20. The mold kit of claim 15, wherein the at least one of the mold bodies further comprises a vent channel having a first end in communication with the chill cavity and a second end in communication with an exterior surface of the mold body to vent the chill cavity to atmosphere.

\* \* \* \* \*