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this simulation shows the flow of liquid alloy in the mold and the pattern of solidification around the nozzles. in this simulation, a grid of 1mm in the horizontal direction and 1mm in the vertical direction was used. a mesh of 1mm was used throughout the geometry and an order of millions of elements were used in simulation of both the top-gated and bottom gated systems. the simulation was performed for a cycle of 5 seconds. the simulation results show the ingress of the alloy into the mold and the solidification of the alloy around the injection nozzles. the flow of the alloy in the mold and the pattern of solidification around the nozzles are shown in the simulation. the result tab will show the output of the simulation. in this case, the simulation was carried out with two cavities, both having a volume of 20cm3. the top gated system has a smaller cavity at the top with a side wall thickness of 1mm and a bottom gated system with a larger cavity with a side wall thickness of 2mm. both systems have a side wall thickness of 0.5mm. the top gated system is a better predictor than the bottom gated system of the amount of solidification in the melt due to the greater contact area between liquid and solid. the permeability has been set to 10 for both systems. for the top gated system, the melt flow is blocked by the top of the cavity due to the small contact area with the walls of the cavity. the top gated system also has a lower melt temperature due to the longer feeding distance. the measurement tab will display the measured properties of the solidifying melt. the simulation has been run for 10,000 time steps. the solidification front is clearly visible in the measurement tab. also the permeability of the melt can be calculated. by comparing the permeability of the top gated system with that of the bottom gated system, the difference between the two systems can be determined.

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the percolation threshold is the percolation concentration at which the solid fraction at the melt surface increases from 0% to 100% (see the part near the bottom center of the bottom-gated system). for the bottom-gated system, the value was set to 50%. the percolation threshold for the top-gated system was 25%. the system is an open-ended part where more melt will flow into the mold with the rotation. the mold height is approximately 40mm. in simulation, the mold height is kept at a constant value. the mold-filling time was kept constant at 3.5 seconds to allow the system to settle. the bottom-gated system is well below the percolation threshold, indicating that melt flows easily through the mold. the top-gated system needs more time to fill the mold due to the presence of the weir. the weir is part of the system that is added in the simulation to prevent the melt from flowing into the bottom of the mold. the weir is kept at a constant height of 5 mm to ensure that the melt is always at the level of the weir. the surface tension of the melt and mold wall were taken to be 72.5 and 31.3mn/m, respectively. these values are estimated based on the mold wall material (here) as well as the melt material. the values are calculated based on the values reported by the manufacturer (here). the melt-mold wall interface is a polymer material and thus the surface tension of the interface is reported as 28.4 mn/m. the primary factor influencing the selection of a

minimum value for the weber number (we) is the wetting angle of the melt in the mold. any wetting angle at the interface will cause a friction force between the melt and the mold wall. the friction force will result in a pressure gradient and will be proportional to the level of surface tension. in this particular case, the surface tension values are not sufficient to describe the friction force between the mold wall and the melt. the interface friction force will be proportional to the wetting angle of the melt. the wetting angle of the melt is however not known in this particular case. in simulation, the wetting angle of the melt at the interface is estimated by the solid fraction at the melt free surface. the value for the wetting angle has a lower limit which is set to the minimum value of the solid fraction at the interface. 5ec8ef588b

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