

providing a castpart wiper configured to conform around an outer surface of the castpart and thereby direct the flow of coolant away from the outer surface of the castpart;

5 positioning the castpart wiper sufficiently below the casting mold and castpart starting block to avoid mis-directing coolant during a startup phase of the casting;

initiating the casting and providing coolant to the casting mold;

rapidly moving the castpart wiper to a position immediately at or below the mold cavity during a transition heat-up phase of the casting; and

10 moving the castpart wiper away from the mold cavity during a second transitory stage of the casting at a rate determined to result in a predetermined castpart solidification effect.

6. A continuous casting mold coolant wiper control process as recited in 15 claim 5, and further wherein during the second transitory stage of the casting, the castpart wiper is moved away from the casting mold at a rate approximately equal to movement of the castpart.

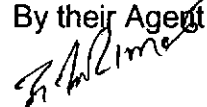
7. A continuous casting mold coolant wiper control process as recited in 20 claim 5, and further wherein during the second transitory stage of the casting, the castpart wiper is moved away from the casting mold at a rate less than the movement of the castpart.

8. A continuous casting mold coolant wiper control process as recited in 25 claim 5, and further wherein during the second transitory stage of the casting, the castpart wiper is moved away from the casting mold at a rate greater than the movement of the castpart.

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By their Agent

  
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