

Title (en)
PROCESS AND APPARATUS FOR PRESSURE CASTING FUSIBLE METALS

Publication
EP 0033901 B1 19831221 (DE)

Application
EP 81100594 A 19810128

Priority
CH 82680 A 19800201

Abstract (en)
[origin: EP0033901A1] The die-cast pieces are cast in a mold shell (4, 5) of a metallic material having a high heat conductivity. A refrigerating chamber (8) is connected to the shell. A refrigerating agent cools down the shell to the temperature of withdrawing from the mold. The refrigerating agent can be preheated and compressed to a pressure greater than the air pressure and during the cooling it can be vaporized. In order to obtain the greatest freedom in the choice of the solidification direction, the melted metal is supplied from a cavity avoiding a heating of the mold and the thinwalled shell of the mold is heated by the metal at a temperature close to the temperature of withdrawing from the mold. In the cooling phase during the filling of the mold, the vaporization of the liquid refrigerating agent takes place on the outer walls of the thin-walled shell.

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IPC 8 full level
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CPC (source: EP)
B22D 17/00 (2013.01); **B22D 17/2218** (2013.01)

Citation (examination)
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