Title (en)
Method of casting melts of materials, the course of solidification of which comprises an expansion followed by a contraction.

Title (de)
Verfahren zum Vergiessen flüssiger Schmelzen, deren Erstarrungsverlauf eine Expansion aufweist, gefolgt durch eine Zusammenziehung.

Title (fr)
Procédé de coulée de matériaux liquides, présentant une plage de solidification composée d'une expansion suivie d'une contraction.

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Application
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Priority
SE 8007034 A 19801008

Abstract (en)
The invention relates to a method of casting such melts of materials, the course of solidification of which comprises an expansion followed by a contraction, for example grey iron alloys, nodular iron, etc. The molten material is supplied to the mould cavity (2) in a mould (1) via one or more sprues (5) with following inlets (7) in direct communication with the mould cavity (2), after which the connection of the mould cavity (2) to the environment is blocked at a moment selected so that at least some of said expansion and following contraction takes place in the space closed by said blocking. What is characteristic of the inventions is that the blocking is brought about by cooling a portion of the spure (5) so that a solidified plug of material (10) is formed in the spure (5) before the material present in the inlet (7) solidifies.

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Citation (search report)
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