

Title (en)
VERTICAL TYPE PRESSURE CASTING METHOD

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Application
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Priority
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Abstract (en)
[origin: EP0095513A1] The gist of the construction, casting conditions and program for a casting method capable of attaining the above object of the present invention resides in a method comprising the steps of closing gates (4) with a counter tip (7) after lower and upper molds (1, 2) heated to a predetermined temperature have been clamped, pouring melt into a sleeve (5) in which a plunger tip is lifted a predetermined distance, lowering the plunger tip (9) while displacing the counter tip to a predetermined position to open the gates, which are formed such that the ratio of the volume of products to the cross-sectional area of the gates is 20-40 (the volume of products/cross-sectional area of gates = 20-40), to allow the melt to flow into cavities (3) via the gates by the force of gravity alone with the plunger tip reaching the upper surface of the melt (15) the moment a percentage of the melt placed in the cavities has reached a value between 20 and 70%, and pressure-filling the cavities with the melt by the plunger tip with the melt passing through the gates at 0.4-0.8 m/sec.

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Cited by
GB2286786A; ES2774396A1; GB2299534B; GB2283445A; GB2283445B; AU665015B2; US5611387A; WO9402271A1; WO2021170894A1

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