

Title (en)

METHOD OF PRODUCING LARGE SIZE GREEN SAND MOULDING PARTS (MOULD AREA 1-3 M2) FOR POURING INTO FLASKLESS MOULDS

Publication

EP 0098405 B1 19860115 (DE)

Application

EP 83105691 A 19830610

Priority

DE 3225197 A 19820706

Abstract (en)

[origin: EP0098405A1] 1. Process for producing large format green sand moulded parts by means of boxless moulding, whereby sand is filled in a mould and compressed by applying pressure via a film is that during a first filling stage I, the green moulding sand (5) is applied on a pattern (1) on all sides in one layer in a moulding box (4), which limits the sand surface on the pattern plate (2) and via a spinner (7) which rotates at reduced speed in order to protect the pattern, and is then covered with a flexible film and compressed and during a second filling stage II the back-up (6) is finally applied and the mould subject to final compression.

IPC 1-7

B22C 5/12; **B22C 9/00**; **B22C 9/02**; **B22C 11/10**; **B22C 25/00**

IPC 8 full level

B22C 9/02 (2006.01); **B22C 11/00** (2006.01); **B22C 11/10** (2006.01); **B22C 15/08** (2006.01); **B22C 15/20** (2006.01); **B22C 21/14** (2006.01)

CPC (source: EP)

B22C 11/10 (2013.01); **B22C 15/08** (2013.01); **B22C 21/14** (2013.01)

Cited by

EP0144727A1; CN102548685A; CN111299502A; FR2575946A1; EP1880781A4; US8056605B2; WO8501899A1

Designated contracting state (EPC)

FR GB LU SE

DOCDB simple family (publication)

EP 0098405 A1 19840118; **EP 0098405 B1 19860115**; DE 3225197 A1 19840112; JP S5921447 A 19840203; JP S6159811 B2 19861218

DOCDB simple family (application)

EP 83105691 A 19830610; DE 3225197 A 19820706; JP 12171983 A 19830706