

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)

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