

Title (en)

PROCESS FOR MANUFACTURING MOULD PARTS ACCORDING TO THE COLD-BOX METHOD AND MOULDING APPARATUS USED

Publication

**EP 0143954 B1 19900801 (DE)**

Application

**EP 84112344 A 19841013**

Priority

DE 3342225 A 19831123

Abstract (en)

[origin: ES8603305A1] Polyurethane bonded sand cores for foundry operations are produced by a cold box process using a gaseous catalyst to provide the hardening and binding reaction necessary to ensure sharply contoured cores, with the required strength and surface wear resistant characteristics. The core box is heated to a temp. pref. between 60 - 80 deg.C by means of hot water circulation through the embedded pipes in the core box. The cores are blown and after a pause of between 20 and 90 seconds, the gaseous catalyst is admitted to provide the hardening action to ensure solid binding of the core. The cores produced provide durable outer surface characteristics combined with less durable friable interiors. [origin: ES8603305A1] Mold parts are produced in accordance with a cold box procedure with passing a gaseous catalyst during curing, wherein for improvement of the application characteristics before/during curing, a gradient of properties within the mold part is caused such that the resistance of the surface layer of the mold part is increased relative to the resistance of the interior of the mold part.

IPC 1-7

**B22C 9/10; B22C 9/12**

IPC 8 full level

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