

Title (en)

Method of casting in of inserts in a Cylinder head.

Title (de)

Verfahren zum Eingiessen von Einlagen in einen Zylinderkopf.

Title (fr)

Méthode pour insérer à la coulée des pièces renforcées dans une culasse.

Publication

EP 0199311 A2 19861029 (DE)

Application

EP 86105411 A 19860418

Priority

DE 3514121 A 19850419

Abstract (en)

1. A method of casting-in inserts into a cylinder head (1, 1', 1"), in which holes (5, 5', 5") each serving to accommodate a respective cylinder head cap screw (4) are to be worked into the cylinder head (1, 1', 1") and into the inserts, in which each hole is provided with its respective insert, in which each insert is located at the respective hole's end facing the cap of the screw to be accommodated therein, is arranged substantially coaxially with the hole's axis, is made of a material different from that of the cylinder head (1, 1', 1"), and in which the cylinder head (1, 1', 1"), when being cast, will be cast around at least a part of each insert, characterized in that holding devices, one for each insert and securing the latter in a moulding box, extend along the direction of the respective holes (5, 5', 5") to be bored subsequently, and in that at least a section of each holding device has a diameter smaller than that of the respective hole so that, when the cylinder head is machined thereafter, each device will completely be bored out.

Abstract (de)

Es wird ein Zylinderkopf 1, 1', 1", vorgestellt, in dem als Scheiben 2, 2', 2", 3, 3', 3" ausgebildete Einlagen umgossen sind, die die von den Zylinderkopfschrauben 4 auf den Zylinderkopf 1, 1', 1" zu übertragenden Kräfte gleichmäßig in den Zylinderkopf 1, 1', 1" einleiten. Sie sind mit Haltevorrichtungen versehen, die sich koaxial zu den nachträglich anzubringenden Bohrungen 5, 5', 5", 6, 6', 6" erstrecken und in dem Formkörper des Zylinderkopfes 1, 1', 1" festgelegt sind.

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IPC 8 full level

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