

Title (en)
METHOD AND DEVICE FOR MAKING SINGLE-CASTING MOULDS

Title (de)
VERFAHREN ZUR HERSTELLUNG VON EINMALIG VERWENDBAREN GIESSFORMEN UND VORRICHTUNG ZU SEINER DURCHFÜHRUNG

Title (fr)
PROCEDE ET DISPOSITIF DE FABRICATION DE MOULES A COULAGE UNIQUE

Publication
EP 0432277 B1 19960508 (DE)

Application
EP 90910975 A 19900628

Priority

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Abstract (en)
[origin: US5161603A] PCT No. PCT/SU90/00170 Sec. 371 Date Mar. 29, 1991 Sec. 102(e) Date Mar. 29, 1991 PCT Filed Jun. 28, 1990. A molding chamber (7) accommodating pattern plates (24, 25) is supplied by a stream of air with sand mixture delivered in a direction parallel to the pattern plates (24, 25). After a time delay relative to the start of the sand delivery operation, and sand mixture is preliminarily compacted by delivering a stream of compressed air directly into the molding chamber in a direction parallel to the pattern plates, the delivery of compressed air being continued within a period of time equal to 5 to 30 percent of the duration of the sand mixture delivery operation. As a result of the delivery of compressed air, the delivery of the sand mixture is retarded and even interrupted. The stream of compressed air diverts the sand mixture in the molding chamber towards the pattern plates, thus providing a better filling of narrow deep hollows on pattern surfaces and preliminary compaction of the sand mixture. The sand delivery operation is completed after the end of the preliminary compaction. The sand mixture is finally compacted by mechanical pressing.

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IPC 8 full level
B22C 15/24 (2006.01); **B22C 11/10** (2006.01); **B22C 15/28** (2006.01)

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US 5161603 A 19921110; AT E137694 T1 19960515; DE 59010317 D1 19960613; DK 33891 A 19910429; DK 33891 D0 19910227; EP 0432277 A1 19910619; EP 0432277 A4 19930707; EP 0432277 B1 19960508; ES 2091245 T3 19961101; JP H07506296 A 19950713; RU 1780917 C 19921215; WO 9100156 A1 19910110

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