

Title (en)

PROCESS FOR HARDENING SAND CASTINGS, ESPECIALLY FOR FOUNDRIES.

Title (de)

VERFAHREN ZUM AUSHÄRTEN VON SANDFORMKÖRPERN, INSBESONDERE FÜR GIESSEREIEN.

Title (fr)

PROCEDE DE DURCISSEMENT DE CORPS MOULES EN SABLE, NOTAMMENT POUR FONDERIES.

Publication

EP 0544863 B1 19940112 (DE)

Application

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Priority

DE 4120928 A 19910625

Abstract (en)

[origin: US5325909A] PCT No. PCT/DE92/00506 Sec. 371 Date Feb. 23, 1993 Sec. 102(e) Date Feb. 23, 1993 PCT Filed Jun. 19, 1992 PCT Pub. No. WO93/00187 PCT Pub. Date Jan. 7, 1993. A primary gas supply circuit and a secondary gas supply circuit are provided with the primary circuit having a part in common with the secondary circuit. The primary circuit is provided with a source of hardening gas. A sand foundry part containing a binding agent is provided in the part in common with the primary and secondary gas supply circuits. Through the primary gas supply circuit a hardening gas/carrier gas is circulated through the sand foundry part containing the binding agent. The primary gas supply circuit is closed when the quantity of hardening gas present in the part of the primary gas supply circuit common to the secondary gas supply circuit is an amount corresponding to, or slightly exceeding, the theoretical quantity for a complete hardening reaction. The secondary supply circuit is opened and the hardening gas/carrier gas is circulated through the secondary supply circuit until the hardening reaction has been completed.

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