

Title (en)

Method to generate low pressure in die casting machine

Title (de)

Verfahren zur Unterdruck-Herstellung bei einer Druckgiessmaschine

Title (fr)

Procédé pour l'obtention de pression réduite dans une machine à couler sous pression

Publication

**EP 0600324 B1 19990616 (DE)**

Application

**EP 93118695 A 19931120**

Priority

DE 4239558 A 19921125

Abstract (en)

[origin: EP0600324A1] The invention proposes a method of generating the vacuum in a vacuum diecasting machine, in which the vacuum to be applied to the diecasting die can be subjected to control during the casting process. According to the invention, the pressure characteristic of the vacuum applied via the vacuum valve (11) is controlled in such a way by means of the on-off valve (13) that the pressure in the die cavity (5), in the casting chamber (6) and in the suction pipe (9) varies in accordance with a particular adjustable function per unit time. For this purpose, a computer (16) which acquires a large number of different parameters is provided. Thus, for example, the vacuum in the region of the vacuum valve (11) is acquired by means of an additional measurement line (17) and measured by means of a vacuum measuring probe. This vacuum measuring probe (18) is connected to the vacuum connection line (12) via an additional bypass valve (19). It is thus possible to acquire the pressure (p) in the vacuum connection line (12) and feed it via the line (20) to the computer (16). <IMAGE>

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CPC (source: EP)

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Cited by

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