

Title (en)  
FEEDING ARRANGEMENT FOR MOULDING BOXES

Title (de)  
ZUFUHRREINRICHTUNG FÜR FORMKÄSTEN

Title (fr)  
CONVOYEUR POUR CHASSIS DE MOULAGE

Publication  
**EP 0697929 B1 19980121 (DE)**

Application  
**EP 94913495 A 19940505**

Priority  
• DE 9400504 W 19940505  
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• DE 4319478 A 19930611

Abstract (en)  
[origin: WO9426441A1] Feeding arrangements for moulding boxes are disclosed. The feeding process cyclically feeds the unfinished moulding boxes filled with moulding sand and models to the sand moulding machines. The moulding machines consolidate the sand, so that negative moulds of the models are created in the moulding boxes. Said negative moulds are assembled into complete sand moulds which are used as casting moulds (lost moulds). In order to shorten the cycle time of state-of-the-art moulding lines, an exchange device exchanges moulded moulding boxes (OK, 1) against not yet moulded moulding boxes (UK, 2). The exchange device lies between two moulding machines arranged one after the other in a moulding line section (F1, F3). Another moulding line section (F2) runs next to both said moulding line sections (F1, F3); upstream of the exchange device (9) it conveys unfinished moulding boxes and downstream of the exchange device (9) it conveys the moulding boxes moulded in the first moulding machine (5). During the exchange, the other not yet moulded moulding boxes (UK, 2) are supplied to the third moulding line section (F3) and to the second moulding machine (6). By simultaneously operating both moulding machines (5, 6) and by reducing the stroke - the distance of displacement (ET) - of the conveyor line sections (F1, F3, F2), the cycle time - the time allotted to each moulded moulding box - may be sharply reduced.

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**WO 9426441 A1 19941124**; AT E162438 T1 19980215; DE 4345470 C2 20010308; EP 0697929 A1 19960228; EP 0697929 B1 19980121; EP 0697929 B2 20030813; ES 2114190 T3 19980516; ES 2114190 T5 20040501

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