

Title (en)

METHOD AND INSTALLATION FOR LOW PRESSURE DIE CASTING IN A MOULD WITH CERAMIC CASTING DIE

Title (de)

VERFAHREN UND NIEDERDRUCKGIESSANLAGE MIT KERAMISCHER KOKILLE

Title (fr)

PROCEDE ET INSTALLATION DE COULEE SOUS BASSE PRESSION DANS UN MOULE A COQUILLE CERAMIQUE

Publication

EP 0968064 A1 20000105 (FR)

Application

EP 98964545 A 19981229

Priority

- FR 9802908 W 19981229
- FR 9800091 A 19980107

Abstract (en)

[origin: FR2773337A1] In a case (1) is arranged a ceramic casting die (21) defining a casting zone (22), surrounded by a sand mass (23) without binder. The casting zone is connected to a metal liquid source (4) below wherein are successively applied a pressure (P1) bringing the metal to the threshold of the casting zone (22), a pressure (P2) slightly higher than what is required to fill said zone, then an outright excess pressure (P3); finally the pressure is brought back to the first value (P1). When the casting zone is filled, the space containing the sand mass (23) is depressurized to prevent deformation of the casting die (21) caused by the excess pressure (P3), at least until a metal crust is formed on the casting die, and at most until the excess pressure start to decrease in the liquid metal source (4).

IPC 1-7

B22D 18/04

IPC 8 full level

B22D 18/04 (2006.01)

CPC (source: EP US)

B22D 18/04 (2013.01 - EP US)

Citation (search report)

See references of WO 9934945A1

Designated contracting state (EPC)

DE ES FI FR GB IT SE

DOCDB simple family (publication)

FR 2773337 A1 19990709; FR 2773337 B1 20000211; CA 2282673 A1 19990715; DE 69808892 D1 20021128; DE 69808892 T2 20030220; EP 0968064 A1 20000105; EP 0968064 B1 20021023; ES 2186248 T3 20030501; US 6422293 B1 20020723; WO 9934945 A1 19990715

DOCDB simple family (application)

FR 9800091 A 19980107; CA 2282673 A 19981229; DE 69808892 T 19981229; EP 98964545 A 19981229; ES 98964545 T 19981229; FR 9802908 W 19981229; US 38046399 A 19991118