

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

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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).

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