

Title (en)

METHOD AND APPARATUS FOR STEPWISE ADVANCING MOULDS IN A MOULD-STRING FOUNDRY PLANT

Title (de)

VERFAHREN UND VORRICHTUNG ZUM SCHRITTWEISE VORRÜCKEN VON KOKILLEN IN EINER GIESSANLAGE

Title (fr)

PROCEDE ET DISPOSITIF DE PROGRESSION PAS A PAS DE MOULES DANS UNE USINE DE FONDERIE A CHAINE DE MOULES

Publication

**EP 1326726 B1 20040602 (EN)**

Application

**EP 00962251 A 20000927**

Priority

DK 0000528 W 20000927

Abstract (en)

[origin: WO0226427A1] The stepwise advancing of moulds (5) in a mould-string foundry plant, comprising a mould-making station (A), a pouring station (B) and a conveyor (C) for stepwise advancing the moulds (5), comprises the steps of: a) producing moulds (5) one at a time in the mould-making station (A) for delivery to the conveyor (C); b) stepwise advancing the produced moulds (5) on the conveyor (C) through the pouring station (B) in closely juxtaposed position, forming a mould-string (F) with casting cavities at mainly vertical parting surfaces between successive moulds (5); d) pouring metal (7) into the casting cavities in the pouring station (B), while the moulding string (F) is kept stationary. By separately producing and discharging a first mould (5) without moving the mould string (F) and producing and discharging a second mould (5), and simultaneous delivery of the first and second moulds (5) to the conveyor (C) and advancing the mould string (F) over a distance corresponding to the length occupied by two moulds (5) from the mould-making station (A), and simultaneously pouring metal (7) into two casting cavities while the mould string (F) is kept stationary, the time for pouring the moulds can be increased, thereby avoiding turbulence in the liquid metal during pouring.

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