

Title (en)

Method for fabrication of turbine blades with cooling channels

Title (de)

Verfahren zum Herstellen von Turbinenschaufeln mit darin angeordneten Kühlkanälen

Title (fr)

Procédé pour la fabrication d'aubes de turbine avec des canaux de refroidissement

Publication

**EP 1398098 B1 20060913 (DE)**

Application

**EP 03015950 A 20030714**

Priority

DE 10236339 A 20020808

Abstract (en)

[origin: DE10236339B3] The method involves making a ceramic core, injecting round it with wax and dipping it and sanding it to produce a ceramic moulding shell. Movement of the core in the shell is prevented by positioning pins (7) embedded in the free end side (6) of the core (1) so as to protrude beyond this end side to bed into the shell. The protruding end of the pin is removed during the mechanical finishing work carried out on the hardened metal blades. The pin is made from a nickel-based alloy, preferably from NiCr 82.

IPC 8 full level

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CPC (source: EP US)

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DE ES FR GB IT

DOCDB simple family (publication)

**DE 10236339 B3 20040219**; DE 50305016 D1 20061026; EP 1398098 A1 20040317; EP 1398098 B1 20060913; ES 2272858 T3 20070501; JP 2004076731 A 20040311; US 2004055736 A1 20040325; US 6896036 B2 20050524

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**DE 10236339 A 20020808**; DE 50305016 T 20030714; EP 03015950 A 20030714; ES 03015950 T 20030714; JP 2003206348 A 20030806; US 63648303 A 20030807