

Title (en)  
METHOD AND DEVICE FOR THE WEIGHT-CONTROLLED FILLING OF INGOT MOLDS IN NON-IRON CASTING MACHINES

Title (de)  
VERFAHREN UND VORRICHTUNG ZUM GEWICHTSKONTROLLIERBAREN BEFÜLLEN VON KOKILLEN AN NICHT-EISEN-GIESSMASCHINEN

Title (fr)  
PROCEDE ET DISPOSITIF DE REMPLISSAGE AVEC UN POIDS PRECIS DE COQUILLES DE MACHINES DE COULEE POUR METAUX NON FERREUX

Publication  
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Application  
**EP 03708217 A 20030312**

Priority

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Abstract (en)  
[origin: WO03092928A1] The invention relates to a method for the weight-accurate filling of ingot molds in a non-iron casting machine, e.g. a copper anode casting machine or a zinc anode casting machine, which is configured in the form of casting wheels that are used for production in a fully mechanized casting operation and are provided with the ingot molds. The aim of the invention is to obtain the desired precise-weight quality of a piece and exact plane parallelism of the bordering surfaces thereof. Said aim is achieved by carrying out the following steps: first, a liquid metal is introduced into an intermediate trough (4, 4') at a regulated mass flow rate, the continuous dynamic weight increase being simultaneously determined; second, liquid metal is fed into a dosing trough (4, 4') which is located on each side of the intermediate trough (4, 4') by alternately tilting the intermediate trough (4, 4') on one side followed by the other. After filling the first dosing trough (5), the intermediate trough (4) is tilted in the direction of the second dosing trough (5') while the mass of an anode is cast from the first filled dosing trough into one of the ingot molds (10, 10') that are arranged on the casting wheel (9, 9') by means of a controlled tilting movement. Also disclosed is a device for carrying out the inventive method.

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