

Title (en)
Broken mould moulding method

Title (de)
Verlorene Form Giessverfahren

Title (fr)
Procédé de fonderie à cire perdue

Publication
EP 1595620 B1 20110720 (FR)

Application
EP 05103958 A 20050511

Priority
FR 0405143 A 20040512

Abstract (en)
[origin: EP1595620A1] The shell mould is made by dipping a model of wax or similar material in a slip containing ceramic particles and a binding agent, coating it with sand and drying, followed by a series of dipping, sand-coating and drying stages to make a mould with a given thickness. The ceramic particles are of a refractory oxide or a mixture of refractory oxides, such as mullite or aluminium, with no zircon in any layer, while the binding agents are based on mineral colloidal solutions, especially colloidal silicon. The sand particles are of the same refractory oxides, without zircon.

IPC 8 full level
B22C 1/00 (2006.01); **B22C 9/04** (2006.01); **B22C 1/08** (2006.01); **B22C 9/12** (2006.01)

CPC (source: EP US)
B22C 9/04 (2013.01 - EP US); **B22C 9/12** (2013.01 - EP US)

Cited by
EP2208556A1; FR3071423A1; US8307881B2; US11833579B2

Designated contracting state (EPC)
DE FR GB

DOCDB simple family (publication)
EP 1595620 A1 20051116; EP 1595620 B1 20110720; CA 2507170 A1 20051112; CA 2507170 C 20121211; FR 2870147 A1 20051118; FR 2870147 B1 20070914; JP 2005324253 A 20051124; JP 4937528 B2 20120523; US 2005252634 A1 20051117; US 7318466 B2 20080115

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EP 05103958 A 20050511; CA 2507170 A 20050511; FR 0405143 A 20040512; JP 2005138394 A 20050511; US 12709205 A 20050512