

Title (en)
METHOD FOR PRODUCING A CAST COMPONENT WITH A CAST-IN PIPE

Title (de)
VERFAHREN ZUM HERSTELLEN EINES GEGOSSENEN BAUTEILES MIT EINEM EINGEGOSSENEN ROHR

Title (fr)
PROCÉDÉ DE FABRICATION D'UN COMPOSANT COULÉ AVEC UN TUBE COULÉ

Publication
EP 1919644 B1 20090408 (DE)

Application
EP 07785637 A 20070713

Priority
• DE 2007001265 W 20070713
• DE 102006034341 A 20060723

Abstract (en)
[origin: US2009233116A1] The invention relates to a method for producing a cast component 1 of an internal combustion engine with a cast-in pipe 3 in a casting process with expendable moulds and a permanent pattern or in a casting process with permanent moulds in which a solid core mould 4 is mounted in a split outer mould. To solve the problem of the pipe changing its position during the casting of the component 1, it is proposed according to the invention that a separat pipe holder 5 is integrated into the outer mould or the core mould 4. The pipe 3 is inserted into a retaining section 6 of the pipe holder 5 that is configured in such a manner that it locally surrounds the outer circumference 8 of the pipe 3 at least in part and with little play so that the pipe 3 can expand in the axial direction during casting but is secured against displacements in radial directions caused by buoyancy forces of the liquid casting material. Subsequently the component 1 is cast by the respective method.

IPC 8 full level
B22C 21/14 (2006.01); **B22D 19/00** (2006.01); **F02F 1/26** (2006.01)

CPC (source: EP US)
B22C 21/14 (2013.01 - EP US); **B22D 19/0009** (2013.01 - EP US); **B22D 19/0072** (2013.01 - EP US); **F02F 1/243** (2013.01 - EP US); **Y10T 428/12** (2015.01 - EP US)

Designated contracting state (EPC)
AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HU IE IS IT LI LT LU LV MC MT NL PL PT RO SE SI SK TR

DOCDB simple family (publication)
US 2009233116 A1 20090917; **US 8176967 B2 20120515**; AT E427800 T1 20090415; BR PI0714670 A2 20130326; BR PI0714670 B1 20160308; DE 102006034341 A1 20080131; DE 502007000583 D1 20090520; EP 1919644 A1 20080514; EP 1919644 B1 20090408; ES 2323097 T3 20090706; MX 2009000630 A 20090128; WO 2008011863 A1 20080131

DOCDB simple family (application)
US 30938107 A 20070713; AT 07785637 T 20070713; BR PI0714670 A 20070713; DE 102006034341 A 20060723; DE 2007001265 W 20070713; DE 502007000583 T 20070713; EP 07785637 A 20070713; ES 07785637 T 20070713; MX 2009000630 A 20070713