

Title (en)

Casting process, upper mold assembly and method of securing core to upper mold

Title (de)

Gießverfahren, Oberformanordnung und Verfahren zum Befestigen des Kerns an der Oberform

Title (fr)

Procédé de coulée, ensemble de moule supérieur et procédé de fixation du noyau sur le moule supérieur

Publication

**EP 1927415 B1 20130410 (EN)**

Application

**EP 07120818 A 20071115**

Priority

- JP 2006325303 A 20061201
- JP 2007152473 A 20070608

Abstract (en)

[origin: EP1927415A1] The casting process includes the steps of: preparing an upper mold assembly (20) by securing a core to an upper mold; pouring a necessary minimum amount of a molten metal for obtaining a casting in the hollow of the lower mold; moving downwardly the upper mold assembly at a predetermined first speed to a predetermined height level just before the upper mold assembly comes into contact with a surface of the molten metal in the hollow of the lower mold; further moving downwardly the upper mold assembly, from the predetermined height level, at a predetermined second speed by changing the descending speed of the upper mold assembly from the first speed to the second speed; detecting a status information of the upper mold assembly in a state when the upper mold assembly is superimposed on the lower mold, or arrived at the lower mold; and stopping the descending movement of the upper mold assembly after detecting that the status information comes at a predetermined state. The upper mold assembly is prepared by securing the core to the upper mold with a mechanical means, an adhesive, frictional engagement of a projection (24a,24b) with a recess (22a,22b) or engagement of a projection (24C) with stamped molding sand of the upper mold.

IPC 8 full level

**B22D 18/02** (2006.01); **B22C 9/10** (2006.01); **B22C 21/14** (2006.01)

CPC (source: EP KR US)

**B22C 9/108** (2013.01 - EP US); **B22C 21/14** (2013.01 - EP US); **B22D 18/02** (2013.01 - EP US); **B22D 23/00** (2013.01 - KR)

Cited by

CN104439119A; CN102814485A; CN113828760A

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)

**EP 1927415 A1 20080604**; **EP 1927415 B1 20130410**; BR PI0705825 A 20080715; CN 101573195 A 20091104; CN 101573195 B 20121121; EA 012717 B1 20091230; EA 200702259 A1 20080630; JP 4991755 B2 20120801; JP WO2008068947 A1 20100318; KR 20080050307 A 20080605; US 2010018664 A1 20100128; WO 2008068947 A1 20080612

DOCDB simple family (application)

**EP 07120818 A 20071115**; BR PI0705825 A 20071114; CN 200780044258 A 20070927; EA 200702259 A 20071116; JP 2007068855 W 20070927; JP 2008548186 A 20070927; KR 20070116217 A 20071114; US 51609207 A 20070927