

Title (en)  
METHOD FOR PRODUCING A NEGATIVE MOLD FOR CASTING A TURBINE BLADE AND MOLD FOR PRODUCING A WAX MODEL OF A TURBINE BLADE

Title (de)  
VERFAHREN ZUM HERSTELLEN EINER NEGATIVFORM ZUM GIESSEN EINER TURBINENSCHAUFEL UND FORM ZUM HERSTELLEN EINES WACHSMODELLS EINER TURBINENSCHAUFEL

Title (fr)  
PROCÉDÉ DE FABRICATION D'UN MOULE NÉGATIF POUR LA COULÉE D'UNE AUBE DE TURBINE ET MOULE POUR LA FABRICATION D'UN MODÈLE À LA CIRE D'AUBE DE TURBINE

Publication  
**EP 2419229 A1 20120222 (DE)**

Application  
**EP 10713890 A 20100331**

Priority  
• EP 2010054327 W 20100331  
• EP 09005327 A 20090414  
• EP 10713890 A 20100331

Abstract (en)  
[origin: EP2241391A1] The process for producing a negative mold for casting a turbine blade (1) with blade platform (11) and fastening element (7) to fasten the turbine blade to a blade holder (3), comprises producing a wax model of the turbine blade to be produced, creating the negative mold of the turbine blade based on wax model, after which the wax model is hardened, and melting off the wax model after completing the negative mold. During storage and/or transportation of the wax model, a distance holder is arranged between a platform surface (15) of the blade platform and a surface of the fastening element. The process for producing a negative mold for casting a turbine blade (1) with a blade platform (11) and a fastening element (7) for fastening the turbine blade to a blade holder (3), comprises producing a wax model of the turbine blade to be produced, creating the negative mold of the turbine blade based on the wax model, after which the wax model is hardened, and melting off the wax model after completing the negative mold. During storage and/or transportation of the wax model, a distance holder is arranged between a platform surface (15) of the blade platform and a surface of the fastening element of the wax model, where the surface of the fastening element lies against the platform surface of the blade platform with a distance (d). The distance holder is removed from the wax model by producing the negative mold, completely fills out a space between the platform surface of the blade platform and the surface of the fastening element of the wax model, adjoins onto a further surface of the fastening element of the wax model, has a reception adapted to the shape of the fastening element of the wax model and provided for receiving a part of the fastening element, is a part of a mold for producing the wax model, and is made of metal or ceramic. An independent claim is included for a method for producing a turbine blade with a blade platform and a fastening element.

IPC 8 full level  
**B22C 9/04** (2006.01); **B22C 7/02** (2006.01); **B22D 23/00** (2006.01)

CPC (source: EP US)  
**B22C 7/02** (2013.01 - EP US); **B22C 9/04** (2013.01 - EP US); **B22D 23/00** (2013.01 - EP US)

Citation (search report)  
See references of WO 2010118960A1

Designated contracting state (EPC)  
AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO SE SI SK SM TR

DOCDB simple family (publication)  
**EP 2241391 A1 20101020**; EP 2419229 A1 20120222; US 2012031579 A1 20120209; WO 2010118960 A1 20101021

DOCDB simple family (application)  
**EP 09005327 A 20090414**; EP 10713890 A 20100331; EP 2010054327 W 20100331; US 201013263871 A 20100331