

Title (en)  
Method for replacing a filter board of a core shooting assembly

Title (de)  
Verfahren zum Austausch einer Filterplatte einer Kernschiessanlage

Title (fr)  
Procédé d'échange d'une plaque de filtre d'une installation d'écoulement de noyau

Publication  
**EP 2511026 A2 20121017 (DE)**

Application  
**EP 12001336 A 20120229**

Priority  
CH 6802011 A 20110416

Abstract (en)  
Replacing a filter plate of a core shooting machine, which forms the lower end of a sealing cap (9), under which, corresponding to the process steps of the core shooting, alternately a fumigation chamber (6) and a core shooting chamber (5) are insertable, comprises dislodging of a locking (22) between the sealing cap and the filter plate, lifting of the sealing cap from a dirty filter plate, laterally moving out of the fumigation chamber by lifting the filter plate from the core shooting machine, exchanging the soiled filter plate against a purified filter plate. Replacing a filter plate of a core shooting machine, which forms the lower end of a sealing cap (9), under which, corresponding to the process steps of the core shooting, alternately a fumigation chamber (6) and a core shooting chamber (5) are insertable, comprises dislodging of a locking (22) between the sealing cap and the filter plate, lifting of the sealing cap from a dirty filter plate, laterally moving out of the fumigation chamber with lifting the filter plate from the core shooting machine, exchanging the soiled filter plate against a purified filter plate, moving back the fumigation chamber with surface cleaned filter plate into the core shooting machine, lowering of the sealing cap and locking of the cleaned filter plate on the sealing cap, inserting of the filter plate when moving out of the fumigation chamber into a receptacle of a pivotal support, subsequently moving back of the fumigation chamber without the filter plate to the core shooting machine, pivoting the support and thus positioning a second receptacle bearing a cleaned filter plate on storage in the resulting free filter plate position, again moving out of the fumigation chamber for receiving the cleaned filter plate, moving back the cleaned filter plate carrying the fumigation chamber for core shooting machine and locking of the other filter plate at the sealing cover. An independent claim is also included for a core shooting machine for carrying out the method as mentioned above, comprises a vertical sealing cap movable between an open position and a sealed closed position for the supply of compressed air to a core shooting chamber or for sealing a fumigation chamber removable through transverse movement against this, where the filter plate is detachably mounted downstream to the sealing cap, such that they can be detachably stored on the fumigation chamber and is movable into a replacement position with the transverse movement of the side of the sealing cap, where in the transfer position, a filter plate receptacle forming a part of a pivotal mounting (14) is arranged, such that this reaches through this transverse movement with the filter plate, where the filter plate receptacle together with at least one second filter plate receptacle carrying a second filter plate is attached to a pivot axis.

Abstract (de)  
Zum Zeit- und Arbeitsaufwand sparenden Austausch einer an einer Dichthaube (9) einer Kernschiessanlage arretierten, verschmutzten Filterplatte (8) wird diese nach Lösen der Arretierung auf eine Begasungskammer (6) abgelegt und durch deren seitliche Herausbewegung aus der Kernschiessanlage in Eingriff mit einer Aufnahme (15) einer schwenkbaren Plattenhalterung (14) gebracht. Ein anschliessendes Zurückbewegen der Begasungskammer (6) ohne Filterplatte zu der Kernschiessanlage (1) gibt die Bahn frei zum Schwenken der Plattenhalterung (14) und damit Positionieren einer gereinigten Filterplatte (8) tragenden zweiten Aufnahme (17) in die dadurch frei gewordene Position. Ein erneutes Hin- und Herbewegen der Begasungskammer (6) dient der Aufnahme der gereinigten Filterplatte (8) und deren Zurückbewegung zur Dichthaube (9) der Kernschiessanlage (1), um sie an dieser zu arretieren. Durch drei in gegenseitigem Abstand von 120° um eine gemeinsame Achse (19) angeordnete Plattenaufnahmen (15, 16, 17) der Plattenhalterung (14) ergibt sich für den Plattenaustausch eine besonders günstige Arbeitsposition,

IPC 8 full level  
**B22C 15/24** (2006.01)

CPC (source: EP US)  
**B22C 15/24** (2013.01 - EP US); **B22C 15/245** (2013.01 - EP US); **Y10T 29/4973** (2015.01 - EP US)

Cited by  
EP3272441A1; WO2019086159A1; US10471501B2; WO2018015589A1

Designated contracting state (EPC)  
AL 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 RS SE SI SK SM TR

Designated extension state (EPC)  
BA ME

DOCDB simple family (publication)  
**EP 2511026 A2 20121017**; **EP 2511026 A3 20170517**; **EP 2511026 B1 20200506**; CH 704842 A2 20121031; CH 704842 B1 20141231; CN 102728792 A 20121017; CN 102728792 B 20140820; DK 2511026 T3 20200810; ES 2807537 T3 20210223; HU E049966 T2 20201130; IN 722DE2012 A 20150821; MX 2012004465 A 20121026; MX 340273 B 20160704; PL 2511026 T3 20201019; SI 2511026 T1 20200930; US 2012279674 A1 20121108; US 8453710 B2 20130604

DOCDB simple family (application)  
**EP 12001336 A 20120229**; CH 6802011 A 20110416; CN 201210110021 A 20120416; DK 12001336 T 20120229; ES 12001336 T 20120229; HU E12001336 A 20120229; IN 722DE2012 A 20120313; MX 2012004465 A 20120416; PL 12001336 T 20120229; SI 201231817 T 20120229; US 201213445518 A 20120412