

Title (en)
METHOD FOR HARDENING A DIE-CAST PART

Title (de)
VERFAHREN ZUR VERGÜTUNG EINES DRUCKGUSSTEILS

Title (fr)
PROCÉDÉ D'AMÉLIORATION PAR TREMPÉ ET REVENU D'UNE PIÈCE COULÉE SOUS PRESSION

Publication
EP 2741874 B1 20190306 (DE)

Application
EP 12740552 A 20120719

Priority
• DE 102011052514 A 20110809
• EP 2012064178 W 20120719

Abstract (en)
[origin: WO2013020786A1] Methods for hardening die-cast parts are known, in which firstly the die-cast part (16) is poured into a casting mould (2) having at least one fixed and one movable mould half (4, 6), then the casting mould (2) is opened by moving out the movable mould half (6), the die-cast part (16) in the movable mould half (6) is quenched, then the die-cast part (16) is ejected from the movable mould half (6) and finally, the die-cast part (16) is aged artificially. To increase the strength, according to the invention, spray tools (14) of a spraying device (8) are inserted between the mould halves (4, 6) immediately after or while the casting mould (2) is opened, with which spray tools a coolant is applied to the die-cast part (16) to quench same.

IPC 8 full level
B22D 17/00 (2006.01); **B22D 27/04** (2006.01); **B22D 30/00** (2006.01); **C22F 1/04** (2006.01)

CPC (source: EP)
B22D 17/00 (2013.01); **B22D 27/04** (2013.01); **B22D 30/00** (2013.01)

Citation (opposition)
Opponent : Nemak Europe GmbH
• DE 102005039049 A1 20070222 - KS ALUMINIUM TECHNOLOGIE AG [DE], et al
• DE 102006057660 A1 20080612 - BAYERISCHE MOTOREN WERKE AG [DE]
• DE 102009010361 B3 20101028 - KS ALUMINIUM TECHNOLOGIE GMBH [DE]
• GB 1148928 A 19690416 - OLIN MATHIESON [US]
• DE 19901508 A1 20000817 - BAYERISCHE MOTOREN WERKE AG [DE]

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

DOCDB simple family (publication)
DE 102011052514 A1 20130214; DE 102011052514 B4 20180419; CN 103717328 A 20140409; EP 2741874 A1 20140618;
EP 2741874 B1 20190306; ES 2728133 T3 20191022; HU E045223 T2 20191230; PL 2741874 T3 20191031; RU 2014109026 A 20150920;
RU 2571978 C2 20151227; WO 2013020786 A1 20130214

DOCDB simple family (application)
DE 102011052514 A 20110809; CN 201280039003 A 20120719; EP 12740552 A 20120719; EP 2012064178 W 20120719;
ES 12740552 T 20120719; HU E12740552 A 20120719; PL 12740552 T 20120719; RU 2014109026 A 20120719