Title (en)

Cooling agent jacket core and method for manufacturing a cylinder crankcase with narrow web thickness

Title (de)

Kühlmittelmantelkern sowie Verfahren zur Herstellung eines Zylinderkurbelgehäuses mit schmaler Stegbreite

Title (fr)

Noyau à chemise de refroidissement et procédé de fabrication d'un carter de vilebrequin à faible nervure

Publication

EP 2772325 A3 20171018 (DE)

Application

EP 14151922 A 20140121

Priority

DE 102013101942 A 20130227

Abstract (en)

[origin: EP2772325A2] Coolant jacket core (16) for producing a cylinder crank housing (10) with a narrow ridge width, comprises at least an integral base core (20), which comprises at least two adjacently arranged core body in hollow cylindrical section form, and a bar core (18), which interconnects the opposite radial ends of each core body in the cutting plane. Each of the two adjacently arranged core body exhibits a common axially extending cutting plane, which forms a connection surface between radial ends of the adjacent core body. The bar core comprises many axially superimposed removable single bar cores. Coolant jacket core (16) for producing a cylinder crank housing (10) with a narrow ridge width, comprises at least an integral base core (20), which comprises at least two adjacently arranged core body in hollow cylindrical section form, and a bar core (18), which interconnects the opposite radial ends of each core body in the cutting plane. Each of the two adjacently arranged core body exhibits a common axially extending cutting plane, which forms a connection surface between radial ends of the adjacent core body. The bar core comprises many axially superimposed removable single bar cores. The single bar cores are attached to the base core at the opposite radial ends of the core body arranged in the cutting plane. An independent claim is also included for producing the coolant jacket core for cylinder crank housing, comprising firing the base core, producing many single bar cores separately, and attaching single bar cores in the base core in an axially superimposed manner in the cutting plane between the two adjacent hollow cylindrical section shaped core body of the base core at the opposite radial ends of the core body.

IPC 8 full level

B22C 9/10 (2006.01); **F02F 1/00** (2006.01); **F02F 1/14** (2006.01); **F02F 7/00** (2006.01)

CPC (source: EP)

B22C 9/10 (2013.01); **B22C 9/103** (2013.01); **B22C 9/105** (2013.01); **B22C 9/108** (2013.01); **F02F 1/14** (2013.01)

Citation (search report)

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CN107947498A

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)

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DOCDB simple family (application)

DE 102013101942 A 20130227; EP 14151922 A 20140121; ES 14151922 T 20140121; HU E14151922 A 20140121; PL 14151922 T 20140121