

Title (en)

METHOD FOR PRODUCING A FEEDER HAVING AN EXOTHERMIC FEEDER BODY AND AN INSULATING EXTERNAL SHELL

Title (de)

VERFAHREN ZUR HERSTELLUNG EINES EINEN EXOTHERMEN SPEISERKORPUS SOWIE EINE ISOLIERENDE AUSSENSCHALE AUFWEISENDEN SPEISERS

Title (fr)

PROCÉDÉ DE FABRICATION D'UNE MASSELOTTE COMPORTANT UN CORPS DE MASSELOTTE EXOTHERMIQUE AINSI QU'UNE COQUE EXTÉRIEURE ISOLANTE

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Application

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Abstract (en)

[origin: WO2014083155A1] The invention relates to a method for producing a feeder configured for use in a casting mould used for casting metals, wherein the feeder has a feeder body (14) enclosing a feeder cavity (15) and a through opening (19) in its base region (18) for connecting the feeder cavity (15) to the casting mould and the feeder body (14) consists of an exothermic material and is enclosed on its outer side at least in regions by an outer shell (27) consisting of insulating refractory material, and wherein the feeder is provided with a feeder foot (20) arranged externally in its base region (18) and having an opening (21) flush with the through opening (19). The feeder is characterized in that the feeder body (14) produced in a first step in a conventional method from an exothermic material is used together with the feeder foot (20) associated with the base region (18) to form the outer shell (27) into a shooting mould (10) having a mould cavity (30) and feeder body and feeder foot are shot simultaneously with the insulating material, wherein the feeder body (14) including the feeder foot (20) is positioned in the mould cavity (30) of the shooting mould (10) in such a manner that the insulating material shot into the mould cavity (30) of the shooting mould (10) fills out a gap (25) left between the feeder foot (20) and the base of the mould cavity (30) at least on a part of the circumference of the feeder foot (20) and extending over at least a part of the height of the feeder foot (20), and the shot outer shell (27) thereby extends at least partially under the feeder foot (20) saving its opening (21) and is attached to the base region (18) of the feeder body (14) without the use of auxiliary means.

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