

Title (en)
METHOD FOR CASTING CASTINGS

Title (de)
VERFAHREN ZUM GIESSEN VON GUSSTEILEN

Title (fr)
PROCÉDÉ SERVANT À COULER DES PIÈCES EN FONTE

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Application
EP 15738697 A 20150720

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Abstract (en)
[origin: CA2948750A1] The invention relates to a method for casting castings, wherein a casting mold is provided, which consists of one or more casting mold parts or casting mold cores, which are produced from a mold material, which consists of core sand, binder, and optional additives. The casting mold (2) is encased in a housing in such a way that a filling space (10) is formed between an inner surface segment of the housing and an associated outer surface segment of the casting mold (2). The filling space (10) is then filled with a free-flowing filling material (F) and metal melt is poured into the casting mold (2). In conjunction with the pouring in of the metal melt, the casting mold begins to radiate heat. As a result of the input of heat by means of the metal melt, the binder of the mold material begins to evaporate and to burn. The binder thus loses the effect thereof and the casting mold (2) disintegrates. According to the invention, the filling material (F) has such a low bulk density that a gas flow (S1, S2) can flow through the filling material packing formed from the filling material (F) in the filling space. During the filling of the filling space, the filling material (F) has a minimum temperature, proceeding from which the temperature of the filling material (F) rises due to process heat, which is formed by the heat radiated by the casting mold (2) and by the heat released during the burning of the binder, to above a limit temperature at which the binder evaporating out ignites and burns.

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