Title (en)

METHOD FOR THE CORE REMOVAL OF CAST PARTS

Title (de)

VERFAHREN ZUM ENTKERNEN VON GUSSTEILEN

Title (fr)

PROCÉDÉ DE DÉNOYAUTAGE DE PIÈCES COULÉES

Publication

EP 3463717 B1 20201209 (DE)

Application

EP 17731262 A 20170530

Priority

- DE 102016109893 A 20160530
- IB 2017000652 W 20170530

Abstract (en)

[origin: WO2017208065A1] The invention relates to a method, with which the core can be removed from cast parts in a more efficient manner in series production, said cast parts having a core made of moulding material which breaks into fragments when applied with impulses. According to the invention, the following working steps are carried out for this purpose: providing a core removal machine (1) having an impact unit (9), wherein, as parameters of the impulse application, the impact position, the shape of the impact surface, the impact direction, the duration of the impulse application, the stroke frequency, the stroke force, the impact speed, the geometry or mass of the impact unit (9) can each be varied individually or as a combination of all or certain parameters; carrying out a pre-investigation to determine adjustment values for the parameters of an impulse application, wherein the impulse application is carried out within a predetermined maximum duration in order to break the core into fragments of a size that guarantees a free loosening of the fragments out of the cast part; arranging the impact unit (9), taking into consideration the adjustment values determined in the pre-investigation, in such a way that the parameters of the impulse application are observed; commencing the series operation, wherein the impact unit (9) is operated in compliance with the determined adjustment values for each of the similar cast parts (G).

IPC 8 full level

B22D 29/00 (2006.01); **B22D 46/00** (2006.01)

CPC (source: EP)

B22D 29/005 (2013.01); **B22D 46/00** (2013.01)

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)

WO 2017208065 A1 20171207; EP 3463717 A1 20190410; EP 3463717 B1 20201209

DOCDB simple family (application)

IB 2017000652 W 20170530; EP 17731262 A 20170530