

Title (en)  
WAXLESS PRECISION CASTING PROCESS

Title (de)  
WACHSFREIES PRÄZISIONSGUSSVERFAHREN

Title (fr)  
PROCESSUS DE COULÉE DE PRÉCISION SANS CIRE

Publication  
**EP 3552732 A1 20191016 (EN)**

Application  
**EP 19172041 A 20101208**

Priority  

- US 26771709 P 20091208
- US 96162110 A 20101207
- EP 10793385 A 20101208
- US 2010059377 W 20101208

Abstract (en)  
Alloy products are produced with a waxless casting process. A model of a ceramic casting vessel (34) defining a desired product shape is digitally divided into sections (10, 40, 42). Each section is translated into a soft alloy mater tool (14) including precision inserts (20) where needed for fine detail. A flexible mold (24) is cast from each master tool, and a section of the ceramic casting vessel is cast from the respective flexible mold. The vessel sections are assembled by aligning cooperating precision features (58, 60) cast directly into each section and the alloy part is cast therein. No wax or wax pattern tooling is needed to produce the cast alloy product. Engineered surface features (54) may be included on both the interior and exterior surfaces of the shell sections.

IPC 8 full level  
**B22C 9/02** (2006.01); **B22C 9/10** (2006.01); **B22C 9/24** (2006.01)

CPC (source: EP US)  
**B22C 7/06** (2013.01 - EP US); **B22C 9/02** (2013.01 - EP US); **B22C 9/04** (2013.01 - US); **B22C 9/10** (2013.01 - US); **B22C 9/103** (2013.01 - EP US); **B22C 9/22** (2013.01 - US); **B22C 9/24** (2013.01 - EP US)

Citation (applicant)  

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- US 7438527 B2 20081021 - ALBERT JASON E [US], et al
- US 7141812 B2 20061128 - APPLEBY MICHAEL [US], et al
- US 7410606 B2 20080812 - APPLEBY MICHAEL P [US], et al
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Citation (search report)  

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- [A] US 2003235272 A1 20031225 - APPLEBY MICHAEL [US], et al
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DOCDB simple family (application)  
**US 96162110 A 20101207**; EP 10793385 A 20101208; EP 19172041 A 20101208; US 2010059377 W 20101208; US 201414268391 A 20140502