

Title (en)  
METHOD AND APPARATUS FOR CASTING OBJECTS MADE OF ALUMINUM, ALUMINUM ALLOYS, LIGHT ALLOYS, BRASS AND THE LIKE

Title (de)  
VERFAHREN UND VORRICHTUNG ZUM GIESSEN VON GEGENSTÄNDEN AUS ALUMINIUM, ALUMINIUMLEGIERUNGEN, LEICHTLEGIERUNGEN, MESSING UND DERGLEICHEN

Title (fr)  
PROCÉDÉ ET APPAREIL DE MOULAGE D'OBJETS EN ALUMINIUM, ALLIAGES D'ALUMINIUM, ALLIAGES LÉGERS, LAITON ET MATIÈRES ANALOGUES

Publication  
**EP 3603851 B1 20220615 (EN)**

Application  
**EP 19187763 A 20190723**

Priority  
IT 201800007754 A 20180802

Abstract (en)  
[origin: EP3603851A1] A method for casting objects made of aluminum, aluminum alloys, light alloys, brass and the like, by way of a casting apparatus (100) which comprises a lower platen (1) adapted to support a lower die (3) which is connected to a duct (10) for feeding liquid metal (20), an upper platen (2) at which an upper die (4) is arranged, a compactor punch (8) which is arranged so that it can move coaxially with respect to the upper die (4), and a flow control element (9) which is arranged concentrically inside the compactor punch (8), the method comprising the steps of:- closing the upper die (4) onto the lower die (3) in order to define a casting cavity;- introducing liquid metal (19) through the duct (10) into the casting cavity;- placing the compactor punch upward at a preset height with respect to the lower rim of the upper die;- accumulating a quantity of liquid metal which is equal to 6-10% of the weight of the piece to be cast in a chamber (18) for accumulating liquid metal (19) for forging;- closing the duct (10) for supplying liquid metal (19) by moving the flow control element (9) downward and depressurizing the liquid metal supply duct (10), thus causing the return of the liquid metal (19) into the duct (10);- forging the liquid metal inside the casting cavity by moving the compactor punch downward.

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