

Title (en)

METHOD FOR PRODUCING A LOST CASTING CORE

Title (de)

VERFAHREN ZUM HERSTELLEN EINES VERLORENEN GIESSKERNS

Title (fr)

PROCÉDÉ DE FABRICATION D'UN NOYAU DE FONDERIE PERDU

Publication

EP 3976290 B1 20230705 (DE)

Application

EP 20729191 A 20200519

Priority

- DE 102019114493 A 20190529
- IB 2020054721 W 20200519

Abstract (en)

[origin: WO2020240342A1] The invention provides a method for producing a lost casting core (G) having a side face (S1, S2) in a core box (1), which is divided in a dividing plane (T) into two core-box parts (2, 3) and delimits a mould cavity (8), provided in which is an inner surface (14, 15) which replicates the side face (S1, S2) of the cast core (G) and through which the parting plane (T) passes. To avoid flash in a critical portion of the side faces (S1, S2) of the casting core (G), the following working steps are performed: (a) creating a casting-core insert (E) having a side-face portion (SF1, SF2), which is identical to a corresponding portion of the side face of the casting core (G), from a casting-core moulding material (F); (b) positioning the casting-core insert (E) in the mould cavity (8) of the core box (1) in such a way that the side-face portion (SF1, SF2) of the casting-core insert (E) is located at the place of the corresponding portion of the side face (S1, S2) of the finished casting core (G), wherein the dividing plane (T) passes through the side-face portion (SF1, SF2); (c) introducing a casting-core moulding material (F) into the mould cavity (8) of the core box (1) in order to form the remaining casting core (G), wherein the casting-core moulding material (F) that is introduced comes into contact with the casting-core insert (E); (d) solidifying the casting-core moulding material (F) to form a form-fitting and/or material-bonding connection between the casting-core moulding material (F) introduced and the casting-core insert (E).

IPC 8 full level

B22C 7/06 (2006.01); **B22C 9/10** (2006.01); **B22C 13/16** (2006.01)

CPC (source: EP US)

B22C 7/06 (2013.01 - EP US); **B22C 9/10** (2013.01 - EP); **B22C 9/103** (2013.01 - EP US); **B22C 13/16** (2013.01 - EP US)

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 2020240342 A1 20201203; CN 114126781 A 20220301; CN 114126781 B 20240329; DE 102019114493 A1 20201203; EP 3976290 A1 20220406; EP 3976290 B1 20230705; EP 3976290 C0 20230705; MX 2021014511 A 20220106; PL 3976290 T3 20231009; US 11890669 B2 20240206; US 2022234096 A1 20220728

DOCDB simple family (application)

IB 2020054721 W 20200519; CN 202080039899 A 20200519; DE 102019114493 A 20190529; EP 20729191 A 20200519; MX 2021014511 A 20200519; PL 20729191 T 20200519; US 202017614872 A 20200519