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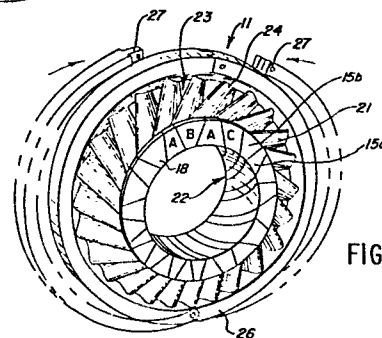
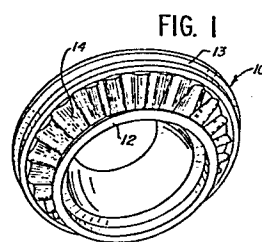
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54 Method of, and pattern for use in, forming a sand mould, and method of producing an annular casting using the mould.

57 A pattern (11) for forming a sand mould for use in producing a one-piece annular casting having a radially inner shell (12), a radially outer blade support (13), and a plurality of angled blades (14) extending in a spaced, annular array (22). The pattern includes a plurality of similar segments, each having an inner end portion (18) defining a portion of the profile of the shell, and an outer end portion (21) defining the profile of the blade. The segments are supported in annular array about a mandrel and are circumscribed by a split ring (26) defining the pattern for the outer blade support portion of the wheel (10). The inner portions of the segments are defined by inclined side surfaces which, in alternate ones of the segments in the annular array, converge and diverge toward the centre of the array. Upon completion of the forming of the sand mould about the pattern, the mandrel and outer ring are removed, permitting the segments having the inwardly diverging side faces to be withdrawn inwardly from the array and permit the remaining segments then to be withdrawn inwardly therefrom.





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EUROPEAN SEARCH REPORT

0036273

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EP 81 30 0927.1

DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int. Cl. ³)
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	
	DE - A - 2 360 339 (TEMPCRAFT TOOL & MOLD INC.) * claim 1 *	1-3	B 22 C 7/00 B 22 C 9/00 B 22 C 9/24 B 22 C 9/28
P	US - A - 4 231 413 (G. BRETZGER) * claims 1, 10 *	1,7	
A	US - A - 3 570 585 (G.V. HARRIS) * abstract *	2,3	
A	US - A - 3 552 480 (G.V. HARRIS) * abstract *	2	TECHNICAL FIELDS SEARCHED (Int. Cl. ³)
A	US - A - 4 043 385 (PETRENCHIK) * abstract *	1,2	B 22 C 7/00 B 22 C 9/00 B 22 D 17/26
			CATEGORY OF CITED DOCUMENTS
			X: particularly relevant A: technological background O: non-written disclosure P: intermediate document T: theory or principle underlying the invention E: conflicting application D: document cited in the application L: citation for other reasons
			&: member of the same patent family, corresponding document
X The present search report has been drawn up for all claims			
Place of search Berlin		Date of completion of the search 08-09-1981	Examiner GOLDSCHMIDT