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(54) **A machine for the production of flaskless, horizontally divided casting moulds of sand or similar material.**

(57) In a machine for the simultaneous production of a pair of associated upper and lower casting mould parts in pressing chambers (3, 4) which are movable towards and away from an intermediate pattern carrier (5), and for joining the mould parts after drawing off and lateral removal of said carrier, the pressing chamber walls (13, 14) have sand introduction openings (22) as well as evacuation ports (16) which by displacement of the walls in relation to the pattern carrier come into and out of position to communicate with a sand store (2) and a vacuum source, respectively, in order to produce vacuum in the chambers.

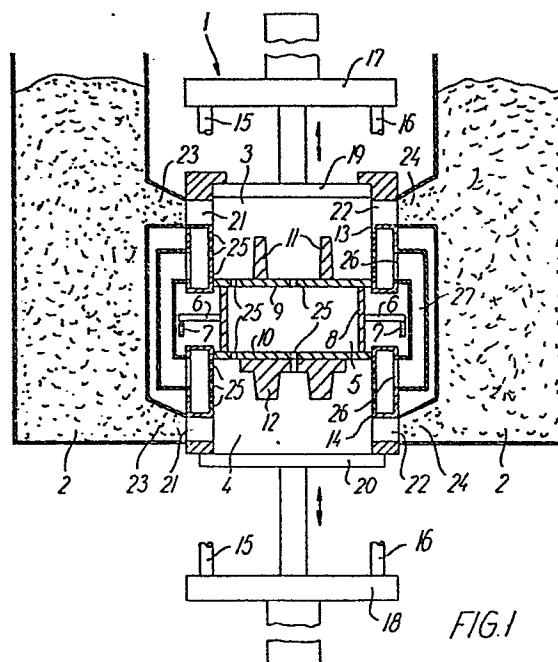


FIG. 1



DOCUMENTS CONSIDERED TO BE RELEVANT															
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. ³)												
D,Y	DE-B-2 653 788 (E. BÜHLER) * figure 3; column 16, lines 39-68; column 17, lines 1-53 *	1-5	B 22 C 15/28 B 22 C 15/22 B 22 C 11/10												
Y	FR-A-2 463 652 (SINTOKOGIO LTD.) * figures 1-3; page 6, line 1 - page 9, line 32 *	1-6													
Y	US-A-3 709 282 (R.W. TACCONE) * figures 1-11; abstract *	6													
			TECHNICAL FIELDS SEARCHED (Int. Cl. ³)												
			B 22 C												
The present search report has been drawn up for all claims															
Place of search THE HAGUE		Date of completion of the search 02-10-1984	Examiner MAILLIARD A.M.												
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