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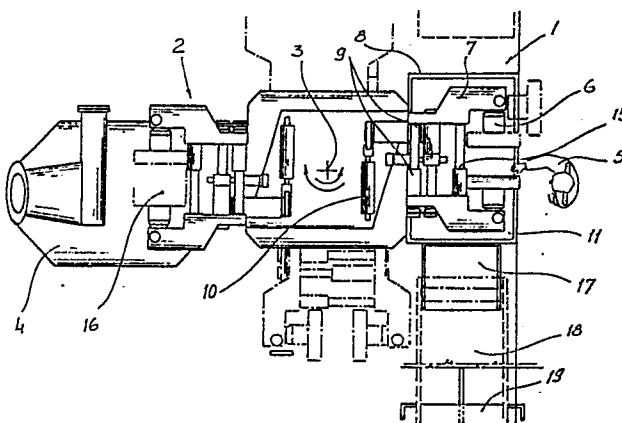
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54 **Die-casting apparatus for die-casting non ferrous alloys, in particular brass, with a low pressure process.**

57 Die-casting apparatus has two pairs of die-carrier heads (1, 2) which can be turned through 180° about a central vertical axis (3) in such a way as to be able to face either a furnace (4) or an operator (5).

Each die-carrier head (1, 2) is controllable independently of the other in such a way as to be able to perform the operations of:

- graphiting of each die half;
- inclination of the die-carrier heads (1, 2) for the introduction of mould cores;
- rotation of the said heads (1, 2) for cleaning of the dies;
- closure of the dies with adjustable damping;
- rotation and coupling of the dies to the casting nozzle of the furnace;
- automatic ejection of castings directly onto a receptacle provided with suitable conveyors.





European Patent
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EUROPEAN SEARCH REPORT

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Application number

EP 84 83 0303

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.4)
X	DE-A-2 009 196 (SCHUBERT & SALZER MASCHINENFABRIK) * Figures 1,2; pages 7,8 *	1,2,6	B 22 D 18/04
X	FR-A-2 179 159 (GRAVICAST PATENTVERWERTUNGSGESELLSCHAFT) * Figures 1,2; pages 6-9 *	1,2	
A	AT-A- 320 887 (GRAVICAST PATENTVERWERTUNGSGESELLSCHAFT) -----		
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			B 22 D
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 25-07-1986	Examiner STEIN K.K.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	