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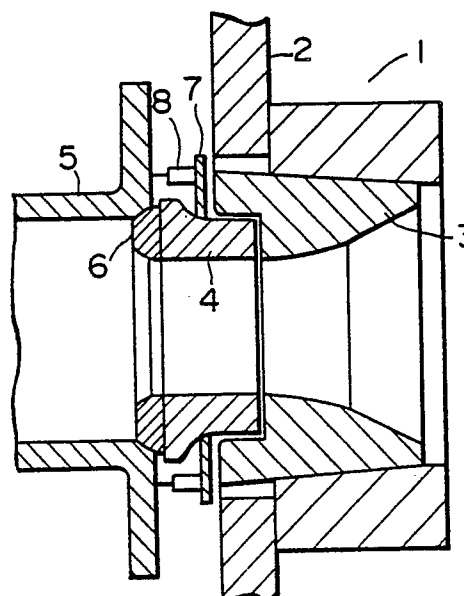
54 **Method for fitting a break ring to mold in horizontal type continuous casting and apparatus therefor.**

57 A method for fitting a break ring (6) between a mold (5) and a feed nozzle (4), the molding being horizontally fitted to the lower part of the side wall of a tundish (1) of a horizontally type continuous casting apparatus through a front nozzle (3) and the feed nozzle, which comprises the steps of:

allowing a movement of a break ring in horizontal direction by a thermal expansion in a beginning stage of horizontal continuous casting; and

imparting a compressive stress to the outer peripheral portion of said break ring for reducing a tensile stress during casting. The compressed force is added by a pull cylinders connected to the mold through piston rod.

**FIG. 1.**





EP 87 11 3970

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	EP-A-0 195 581 (DAVY McKEE (SHIEFFIELD) LTD) * Figure 3; column 2, lines 18-32 *	6	B 22 D 11/04 B 22 D 11/14
A	---	1-5	
A	US-A-4 586 558 (TAKASUKE MORI et al.) * Figure 4; column 1, line 45 - column 2, line 31 *	1-5	
A, D	---	1-5	
	PATENT ABSTRACTS OF JAPAN, vol. 5, no. 57 (M-64)[729], 18th April 1981; & JP-A-56 11 164 (NIPPON KOKAN K.K.) 04-02-1981 * Abstract *		
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The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int. Cl. 4)
			B 22 D
Place of search THE HAGUE		Date of completion of the search 08-02-1989	Examiner DOUGLAS K. P. R.
<b>CATEGORY OF CITED DOCUMENTS</b>			
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	