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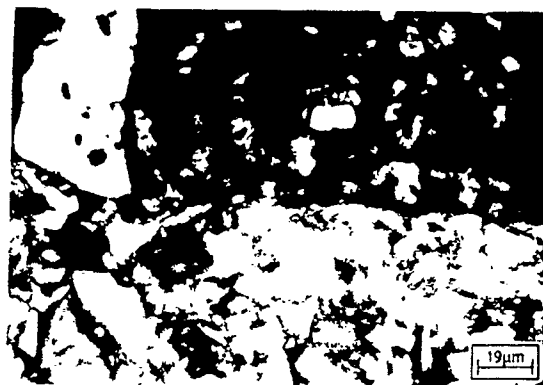
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(54) **Ceramic shell mold for investment casting and method of making the same.**

(57) A ceramic shell mold and method of making the same. The ceramic shell mold includes a facecoat layer comprised of a first ceramic material. A plurality of alternating layers are formed overlaying the facecoat layer. The alternating layers are comprised of a second ceramic material and a third ceramic material, the third ceramic material having thermophysical properties different than the second ceramic material. The second ceramic material and the third ceramic material are preferably a zircon-based material and an alumina-based material, respectively. The resultant ceramic shell mold has a greater high temperature creep resistance than a shell mold formed solely from the second ceramic material or solely from the third ceramic material.

FIG. 1



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EUROPEAN SEARCH REPORT

Application Number

EP 89 42 0208

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.5)
Y	DE-A-3 015 639 (UNITED TECHNOLOGIES CORP.) * claims 1,3,7,11,12 * - - -	1,2,18-23	B 22 C 9/04 B 22 C 13/08
Y	US-A-4 040 845 (D. RICHARDSON et al.) * claims 1-6 * - - -	1,2,18-23	
A	DE-A-2 716 342 (UNITED TECHNOLOGIES CORP.) * claims 1-4 * - - - - -	1-3	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B 22 C 9/00 B 22 C 13/00 C 04 B 35/00
The present search report has been drawn up for all claims			
Place of search Berlin		Date of completion of search 30 November 90	Examiner GOLDSCHMIDT G
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			