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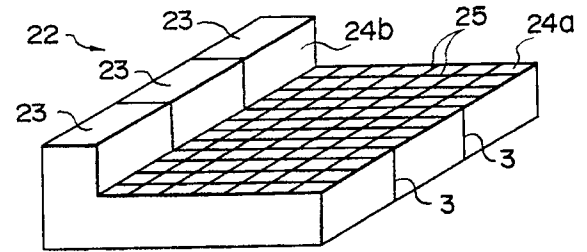
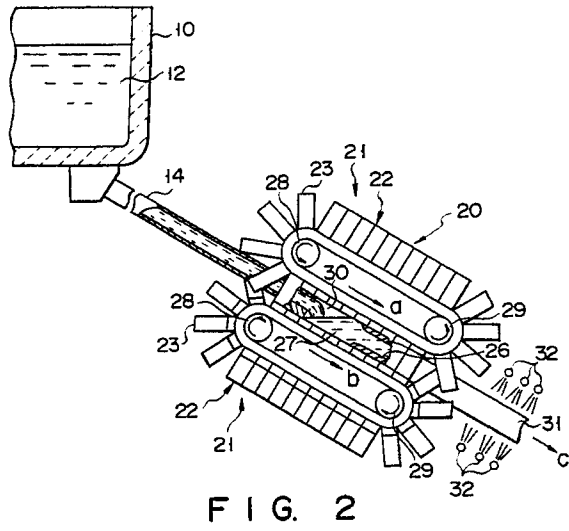
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(54) **Casting machine having a travelling block mold assembly.**

(57) A casting machine comprises a pair of travelling block mold assemblies (22) each having a plurality of block mold members (23) endlessly connected to one another to define a cavity (27), and a mechanism for driving the block mold members (23) such that the block mold members of one travelling block mold assembly (22) move in synchronism with those of the other in a casting direction. Latticed grooves (25, 34, 35, 36) are formed on at least an area of the inner wall of each of the block mold members (23) which combine with one another to form the cavity (27). Delays in the solidification of molten steel in the cavity (27) are intentionally caused by these grooves, with the result that the concentration of contraction stress caused by the solidification delays

at those seams (3) along which the adjacent block mold members (23) are connected to each other to form the cavity (27) can thus be reduced to prevent the creation of cracks on surfaces of cast products.

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EUROPEAN SEARCH REPORT

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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	EP-A-0 237 318 (NIPPON KOKAN) * claims 1-3 * - - -	1	B 22 D 11/06
Y	PATENT ABSTRACTS OF JAPAN vol. 12, no. 381 (M-752)(3228), 12 October 1988; & JP - A - 63132751 (NIPPON KOKAN) 04.06.1988 - - -	1	
A	GB-A-2 034 217 (SWISS ALUMINIUM LTD) * abstract; figure 2 * - - -	1	
A	PATENT ABSTRACTS OF JAPAN vol. 11, no. 241 (M-614)(2688), 7 August 1987; & JP - A - 6254556 (ISHIKAWAJAMA) 10.03.87 - - - - -	1	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B 22 D 11/00
The present search report has been drawn up for all claims			
Place of search Berlin		Date of completion of search 22 August 91	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			