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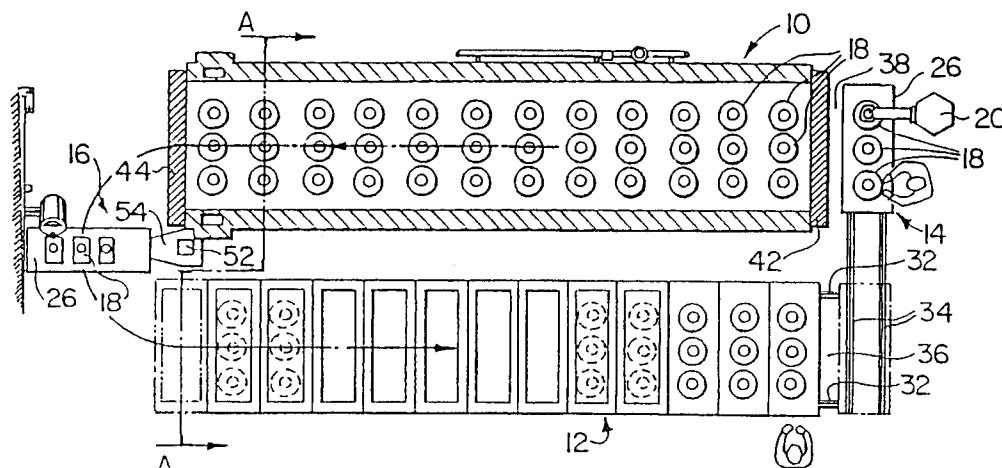
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c/o Shell-O-Matic Inc., 10600 Ste-Gertrude
Blvd.
Montreal North, Ouebec H1G 5N4(CA)(72) Inventor: **Muri, George**
c/o Shell-O-Matic Inc., 10600 Ste-Gertrude
Blvd.
Montreal North, Ouebec H1G 5N4(CA)(74) Representative: **Barre, Philippe**
Cabinet Barre-Gatti-Laforgue 95 rue des
Amidoniers
F-31069 Toulouse Cédex(FR)(54) **Improvements in casting systems.**

(57) A system to receive heated molds on a tray or car at a first point, transfer the tray or car containing the heated molds to a mold pouring and filling stations and transferring the same to a cooling station. The system includes a furnace or heating chamber for empty molds, a cooling chamber for cooling filled molds, and a transfer station for filling and transferring the molds. Additionally, an apparatus for pouring metal from a ladle to a mold includes gripping

means for gripping a ladle and moving the ladle between pouring and non-pouring positions. Also disclosed is a tray that supports at least one mold having at least one bottom member, with surrounding side walls incorporating at least two segmented members of refractory material, and means for retaining these members relative to the bottom member.

**FIG. 1**



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EUROPEAN SEARCH REPORT

Application Number

EP 90 20 0977

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)
A	US-A-4 186 793 (A.T. TEMPLINSKI) * claim 1 * - - -	1	B 22 D 35/00 B 22 D 47/00
A	DE-B-2 138 595 (E. REINHARDT GMBH) * claim 1 * - - -	1	
A	CH-A-397 969 (GRIFFIN WHEEL) * claim 1 * - - -	1	
A	DE-A-2 855 128 (BIBBY FOUNDRY LTD) * claim 1 * - - - - -	1	
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B 22 D 35/00 B 22 D 47/00
Place of search		Date of completion of search	Examiner
Berlin		03 December 91	GOLDSCHMIDT G
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone		E : earlier patent document, but published on, or after the filing date	
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