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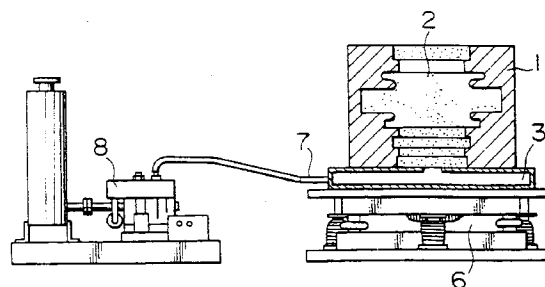
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(54) **Method of manufacturing core and mold.**

- (57) A method of manufacturing a core and a mold using self-hardening molding sand or gas-hardening molding sand, wherein the self-hardening molding sand or the gas-hardening molding sand is charged in a core pattern or a flask while applying three-dimensional jolt, and a method of manufacturing a core and a mold using self-hardening molding sand, wherein air flow is precipitated by sucking the self-hardening molding sand in a core pattern or a flask.

FIG. 1





European Patent
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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)
X	PATENT ABSTRACTS OF JAPAN vol. 11, no. 318 (M-632) 16 October 1987 & JP-A-62 101 345 (DAIDO STEEL CO LTD) 11 May 1987 * abstract *	1-11	B22C15/28 B22C9/00
X	PATENT ABSTRACTS OF JAPAN vol. 12, no. 269 (M-723) 27 July 1988 & JP-A-63 052 741 (SINTOKOGYO LTD) 5 March 1988 * abstract *	1-11	
A	FR-A-2 551 371 (FISCHER) 8 March 1985 * figures *	2,5	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B22C
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 25 MARCH 1993	Examiner RIBA VILANOVA M.
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			

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