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(54) **Die-casting method and die-casting apparatus**

(57) A method of producing a die-cast article by die-casting, the die-cast article having at least one of an inner and an outer circumferential surface, the method comprising the steps of: preparing a mold assembly (224, 226; 400, 402; 500, 502) including a hollow portion (280, 410, 510) having a molding surface (300, 420, 530) for molding one of the inner and outer circumferential surfaces of the die-cast article; closing the mold assembly to define therein a mold cavity (236, 426, 540) having a configuration corresponding to that of the die-cast article; subjecting the hollow portion to an elastic deformation in a direction toward the one of the inner and outer circumferential surfaces of the die-cast article to be produced; introducing a molten metal into the mold cavity while the hollow portion is subjected to the elastic deformation; opening the mold assembly and permitting the elastic deformation to be removed from the hollow portion after the molten metal has solidified; and removing the die-cast article from the mold assembly. An apparatus for practicing the method is also disclosed.

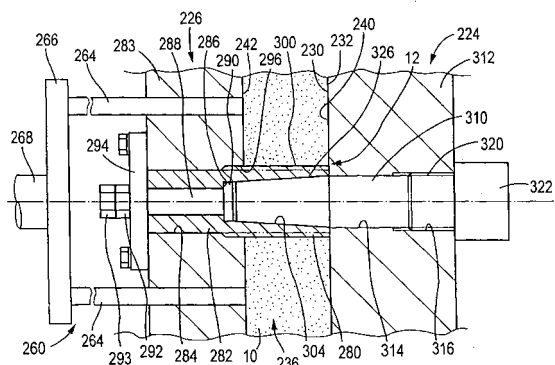


FIG. 4



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EUROPEAN SEARCH REPORT

Application Number
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Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.7)
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The present search report has been drawn up for all claims			
Place of search MUNICH		Date of completion of the search 12 December 2002	Examiner Baumgartner, R
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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**ANNEX TO THE EUROPEAN SEARCH REPORT
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