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(54) **Riser funnel**

(57) The riser or feeder is a metal storehouse that is attached to pieces with the aim of compensating for the metal contraction phenomenon and of avoiding internal soundness defects known as cavities or porosities, which result in the rejection of pieces in the casting process.

This invention aims at obtaining better feeding head efficiency than is achieved at present, whether coated or

not, the cost of which will be less and which will not need any coating.

The riser is made up of a single element, which is moulded at the same time as the rest of the piece mould. It consists of an upper chamber, vertical or quasi-vertical, a bottom chamber, which is wider, and at least one conduit that stems from the bottom chamber, through which the metal flows from the feeder to the piece.

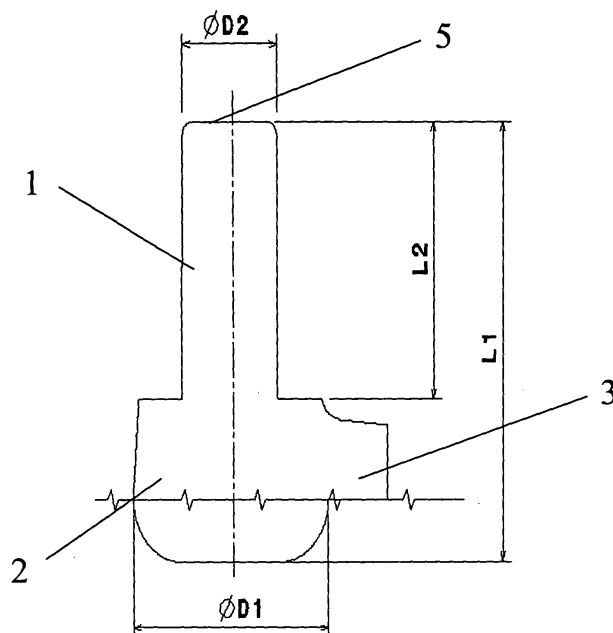


FIGURE 2



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Office

EUROPEAN SEARCH REPORT

Application Number
EP 05 38 5201

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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 3 May 2006	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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EPO FORM 1503 03.82 (P04C01)

**ANNEX TO THE EUROPEAN SEARCH REPORT
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This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
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