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(54) **Vehicle body frame, die-cast product, mold for die-cast product and die-cast method**

(57) It is an object of the present invention to provide a vehicle body frame, a die-cast product, and a mold and a die-cast manufacturing method for the die-cast product which facilitates the measurement of the positional accuracy of splints, can decrease a clearance between the splint and the mold by increasing the dimensional accuracy of splint mounting portions of the mold based on sizes of the splints, and can manufacture the die-cast product of high dimensional accuracy.

According to the invention, in a mold for a die-cast

product in which a main frame which is contiguously formed with a head pipe constitutes a portion of a hollow light-weight-metal-made vehicle-body frame, a core 20 which serves to form an inner space of the die-cast product includes a core body 21 and a plurality of splints 22 which is mounted on the core body 21 and have an approximately elliptical cross-sectional shape, and a long axis direction of an ellipse of the splint 22 is set parallel to a mold split surface of the mold.

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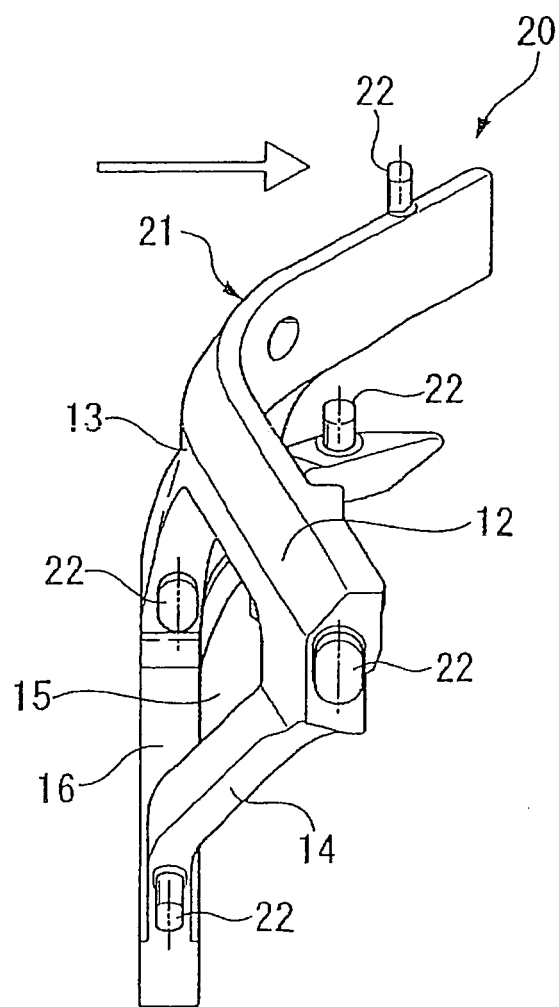


FIG. 4