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 Tokyo 107-8556 (JP)**

(72) Inventors:

- **Suzuki, Toshimitsu**
c/o Honda R&D Co., Ltd.
Wako-shi
Saitama, 351-0193 (JP)
- **Seki, Yoshitaka**
c/o Honda R&D Co., Ltd.
Wako-shi
Saitama, 351-0193 (JP)
- **Hariu, Jun**
c/o Honda R&D Co., Ltd.
Wako-shi
Saitama, 351-0193 (JP)

- **Watanabe, Shin**
c/o Honda R&D Co., Ltd.
Wako-shi
Saitama, 351-0193 (JP)
- **Ota, Koichi**
c/o Honda R&D Co., Ltd.
Wako-shi
Saitama, 351-0193 (JP)
- **Hirayanagi, Satoshi**
c/o Honda R&D Co., Ltd.
Wako-shi
Saitama, 351-0193 (JP)
- **Doi, Takashi**
c/o Honda R&D Co., Ltd.
Wako-shi
Saitama, 351-0193 (JP)
- **Kurayoshi, Yoshiyuki**
c/o Honda R&D Co., Ltd.
Wako-shi
Saitama, 351-0193 (JP)

(74) Representative: **Liska, Horst et al
 Weickmann & Weickmann
 Patentanwälte
 Postfach 86 08 20
 81635 München (DE)**

(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.

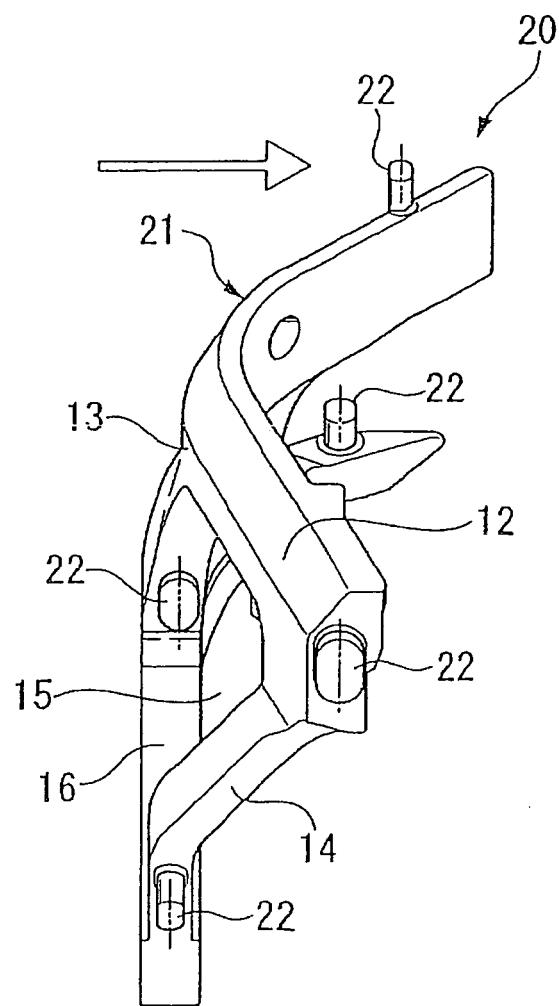


FIG. 4