



(12) **CORRECTED EUROPEAN PATENT APPLICATION**

(15) Correction information:

Corrected version no 1 (W1 A1)
Corrections, see
Bibliography INID code(s) 30

(51) Int Cl.:

B22D 18/02 (2006.01) **B22D 18/04** (2006.01)
B22D 18/08 (2006.01) **B22D 17/20** (2006.01)
B22D 17/22 (2006.01) **B22D 27/11** (2006.01)

(48) Corrigendum issued on:

19.07.2017 Bulletin 2017/29

(43) Date of publication:

24.05.2017 Bulletin 2017/21

(21) Application number: **16002450.1**

(22) Date of filing: **17.11.2016**

(84) Designated Contracting States:

AL AT BE BG CH CY CZ DE DK EE ES FI FR GB
GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO
PL PT RO RS SE SI SK SM TR

Designated Extension States:

BA ME

Designated Validation States:

MA MD

(72) Inventors:

- **Boni, Roberto**
25128 Brescia (IT)
- **Ferri, Ruggero**
25038 Rovato BS (IT)

(74) Representative: **Forattini, Amelia**

Internazionale Brevetti
Ingg. ZINI, MARANESI & C. S.r.l.
Piazza Castello 1
20121 Milano (IT)

(30) Priority: **19.11.2015 IT UB20155732**

(71) Applicant: **IDRA S.R.L.**

25039 Travagliato BS (IT)

(54) **METHOD AND APPARATUS FOR MOLDING OBJECTS MADE OF ALUMINUM, ALUMINUM ALLOYS, LIGHT ALLOYS, BRASS AND THE LIKE**

(57) A method for molding objects made of aluminum, aluminum alloys, light alloys, brass and the like, includes the steps of: starting from a molding apparatus which includes a lower platen adapted to support a lower mold part connected to a duct for feeding liquid metal, an upper platen at which an upper mold part is arranged, a compaction plug arranged so that it can move coaxially with respect to the upper mold part and a flow control element that is arranged concentrically inside the compaction plug, closing the upper mold part onto the lower mold part in order to form a mold cavity; introducing liquid metal through the duct within the mold cavity; moving the compaction plug upward, in order to obtain an accumulation of liquid metal within the mold cavity and in a chamber formed by the space freed by the upward movement of the compaction plug; closing the duct for feeding liquid metal by moving downward the flow control element and depressurizing the liquid metal supply hole, causing the return of the liquid metal within the duct; forging the liquid metal within the mold cavity by feeding downward the compaction plug.

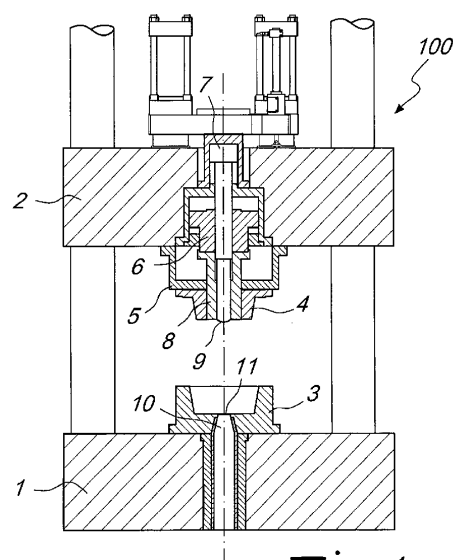


Fig. 1