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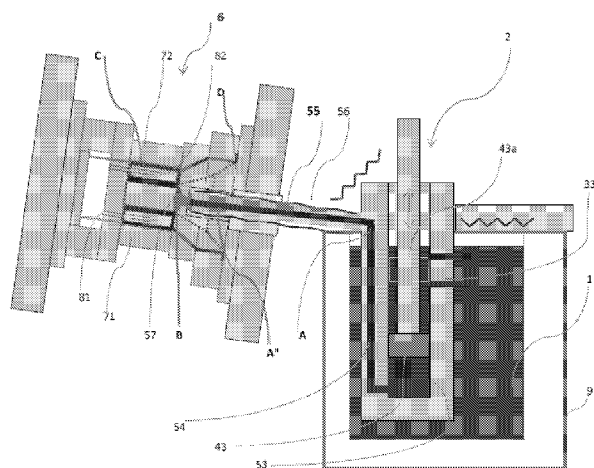


Fig.3

(57) Abstract: A method for manufacturing light alloy castings by die casting with disposable cores (71, 72), including a mold (6) filling phase in which the parameters of pressure and speed of the molten alloy (1) are controlled at levels tolerable by the cores (71, 72) until the cavities around the latter are filled by the molten alloy (1), and thereafter the pressure and speed parameters are controlled at levels suitable for completing and compacting the casting, the alloy (1) being kept at a temperature close to its melting temperature throughout the whole path between the pump (2) that pressurizes it and the entrance to the cavities around the cores (71, 72). The invention relates also to a plant implementing said method by means of a pump (2) connected to a mold (6) through a duct (54, 55, 57) that comes out within the casting envelope at a point close to the centroid of the cores (71, 72).

INTERNATIONAL SEARCH REPORT

International application No
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A. CLASSIFICATION OF SUBJECT MATTER
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ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
B22D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 3 874 440 A (VOISIN ALBERT S) 1 April 1975 (1975-04-01) the whole document	1,6
A	JP S62 34661 A (TOYOTA MOTOR CORP TOYOTA MOTOR CO LTD) 14 February 1987 (1987-02-14) the whole document	1,6



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

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INTERNATIONAL SEARCH REPORT

Information on patent family members

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