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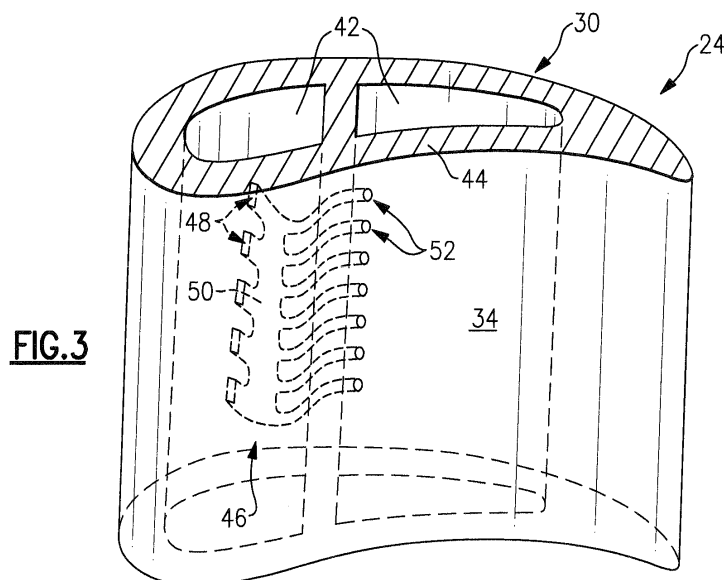
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(54) **Airfoil with nonlinear cooling passage**

(57) An example method of manufacturing an airfoil (30) includes providing a ceramic core (64) corresponding to an interior cooling channel (42). A refractory metal core (66) is provided that corresponds to a cooling passage (46). The cores are arranged in a mold (60). An airfoil structure (30) is cast about the cores to provide a turbine engine airfoil. The turbine engine airfoil (30) includes a wall (44) providing the interior cooling channel (42) and an exterior airfoil surface (34). The cooling pas-

sage (46) is provided in the wall (44) and fluidly connects the interior cooling channel (42) to the exterior airfoil surface (34). The cooling passage (46) includes multiple inlets (48) and multiple outlets (50) respectively adjoining the interior cooling channel (42) and the exterior airfoil surface (34). At least one of a first inlet (48) and outlet (50) has a different structural flow characteristic than at least one of a second inlet and outlet (48,50).





EUROPEAN SEARCH REPORT

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The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 28 July 2016	Examiner Robelin, Bruno
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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**ANNEX TO THE EUROPEAN SEARCH REPORT
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