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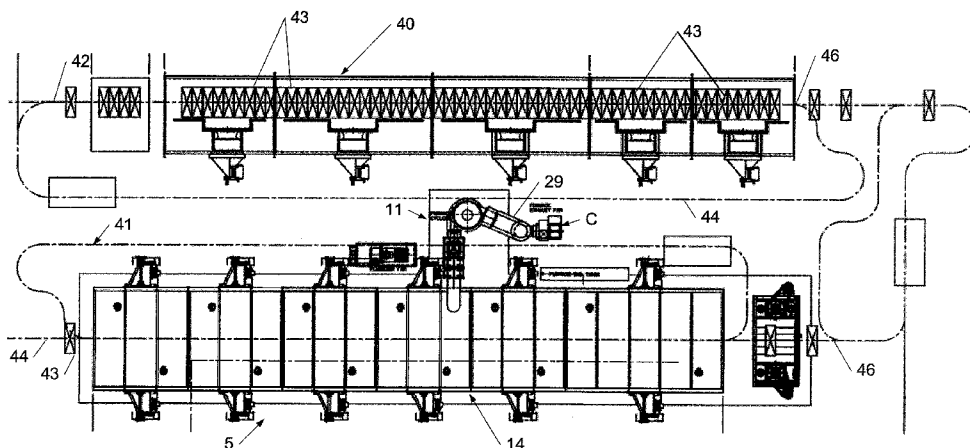
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(54) Title: METHODS AND SYSTEM FOR MANUFACTURING CASTINGS UTILIZING AN AUTOMATED FLEXIBLE MANUFACTURING SYSTEM



(57) Abstract: A method and system for generating a production sequence for the control of resources and production for metal castings of a manufacturing plant. The system employs a transport system to transfer the castings between a series of processing stations, which could include heat treatment, quenching, decoring, demolding, cleaning, machining, inspection, storage, etc., served by the transport system. A series of guided vehicles moving along the transport carry the castings between the processing stations. Each guided vehicle includes an identifier monitored by a controller to direct the castings to the next required processing station according to a predetermined production sequence for the castings thereon.

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INTERNATIONAL SEARCH REPORT

International application No

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A. CLASSIFICATION OF SUBJECT MATTER
INV. B22D47/02

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 practical, 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.
X	JP 03 226355 A (MITSUBISHI MATERIALS CORP) 7 October 1991 (1991-10-07) the whole document -----	1-14
X	JP 03 226359 A (MITSUBISHI MATERIALS CORP) 7 October 1991 (1991-10-07) the whole document -----	1-14
A	US 2005/022957 A1 (CRAFTON SCOTT P [US] ET AL CRAFTON SCOTT P [US] ET AL) 3 February 2005 (2005-02-03) the whole document -----	1-14
A	DE 90 05 691 U1 (DANSK INDUSTRI SYNDIKAT A/S, HERLEV, DK) 20 September 1990 (1990-09-20) page 10, line 20 - page 11, line 2 -----	1-14

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Date of the actual completion of the international search

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No PCT/US2007/071276

Patent document cited in search report	Publication date	Patent family member(s)	Publication date																					
JP 3226355	A	07-10-1991	NONE																					
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DE 9005691	U1	20-09-1990	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">DE</td> <td style="width: 35%;">4016112 A1</td> <td style="width: 50%;">29-11-1990</td> </tr> <tr> <td>DK</td> <td>245389 A</td> <td>20-11-1990</td> </tr> <tr> <td>JP</td> <td>1979103 C</td> <td>17-10-1995</td> </tr> <tr> <td>JP</td> <td>3174970 A</td> <td>30-07-1991</td> </tr> <tr> <td>JP</td> <td>7000228 B</td> <td>11-01-1995</td> </tr> <tr> <td>RU</td> <td>2053861 C1</td> <td>10-02-1996</td> </tr> <tr> <td>US</td> <td>5069267 A</td> <td>03-12-1991</td> </tr> </table>	DE	4016112 A1	29-11-1990	DK	245389 A	20-11-1990	JP	1979103 C	17-10-1995	JP	3174970 A	30-07-1991	JP	7000228 B	11-01-1995	RU	2053861 C1	10-02-1996	US	5069267 A	03-12-1991
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