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[Continued on next page]

(54) Title: METHOD AND SYSTEM FOR PRODUCING SAND MOULDS

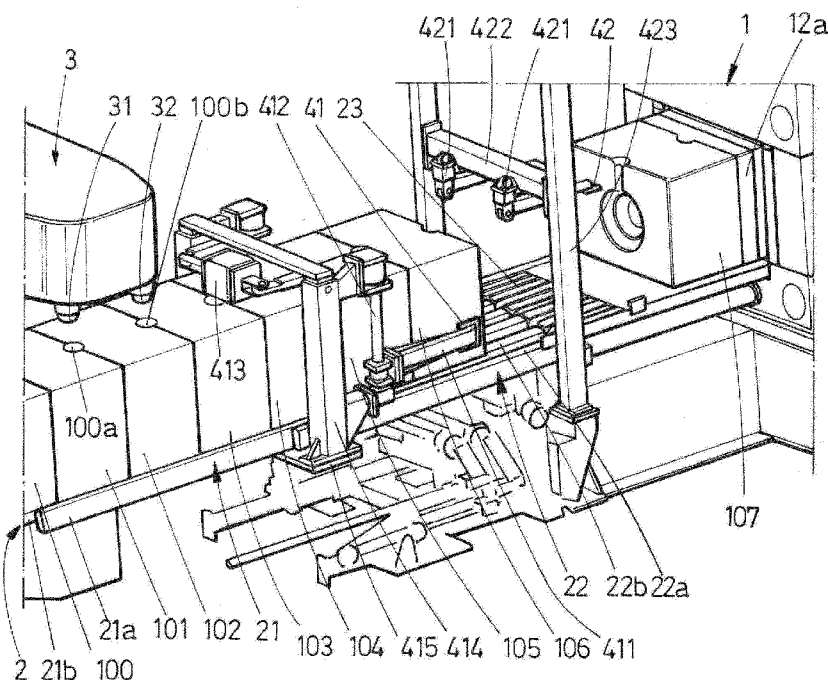


FIG. 3A

(57) Abstract: The method for the stepwise production and advancing of sand mould parts in a mould-string foundry plant comprising a station (1) for making mould parts, a pouring station (3) and a conveyor (2) for stepwise advancing of mould parts (101-109) from said station (1) for making mould parts towards said pouring station (3), includes the step of double indexing the mould parts using a first, moveable, part (21) of the conveyor. By double indexing the mould string, the time during which pouring into the moulds has to be interrupted can be reduced.





EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU,
LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK,
SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ,
GW, KM, ML, MR, NE, SN, TD, TG).

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INTERNATIONAL SEARCH REPORT

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PCT/EP2014/066712

A. CLASSIFICATION OF SUBJECT MATTER
 INV. B22C9/20 B22C15/24 B22C19/02 B22D47/02
 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 B22C
 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.
X	US 7 806 161 B2 (JEZWINSKI ROBERT [US]) 5 October 2010 (2010-10-05) cited in the application	1-3,5,6, 8,13,15
Y	column 1, line 63 - column 11, line 4 figures 1-26	4,7, 9-11,14
Y	----- EP 0 693 337 A1 (FISCHER GEORG GIESSEREIANLAGEN [CH]) 24 January 1996 (1996-01-24) column 2, line 16 - column 3, line 46 figures 1,2	4,7
Y	----- DE 23 11 253 A1 (DANSK IND SYNDIKAT) 11 October 1973 (1973-10-11) page 2 - page 6 figures 1-3	9-11,14
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Further documents are listed in the continuation of Box C. See patent family annex.

* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"E" earlier application or patent but published on or after the international filing date	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"O" document referring to an oral disclosure, use, exhibition or other means	"&" document member of the same patent family
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search 18 May 2015	Date of mailing of the international search report 01/06/2015
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Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016	Authorized officer Zimmermann, Frank
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INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2014/066712

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	WO 96/30140 A1 (GEORG FISCHER DISA AS [DK]; LARSEN JENS PETER [DK]; JESPERSEN EMIL [DK] 3 October 1996 (1996-10-03) the whole document	1-11, 13-15
Y	----- EP 1 326 726 B1 (DISA IND AS [DK]) 2 June 2004 (2004-06-02) cited in the application paragraph [0003] - paragraph [0013] figures 1-6	12,15
Y	----- EP 1 402 976 A1 (LORAMENDI SA [ES]) 31 March 2004 (2004-03-31) paragraph [0012] - paragraph [0024] figures 1-7 -----	12,15

INTERNATIONAL SEARCH REPORT

International application No.
PCT/EP2014/066712

Box No. II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:

2. Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:

3. Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box No. III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.

2. As all searchable claims could be searched without effort justifying an additional fees, this Authority did not invite payment of additional fees.

3. As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:

4. No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- The additional search fees were accompanied by the applicant's protest and, where applicable, the payment of a protest fee.
- The additional search fees were accompanied by the applicant's protest but the applicable protest fee was not paid within the time limit specified in the invitation.
- No protest accompanied the payment of additional search fees.

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. claims: 1-11, 13, 14(completely); 15(partially)

Method of stepwise production and advancing of a sand mold string whereby the molds are displaced by a conveyor a distance corresponding to at least two mold part widths and apparatus for carrying out this method

2. claims: 12(completely); 15(partially)

Method of stepwise production and advancing of a sand mold string whereby the molds are displaced by a conveyor a distance corresponding to one mold part widths and apparatus for carrying out this method

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No
PCT/EP2014/066712

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
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