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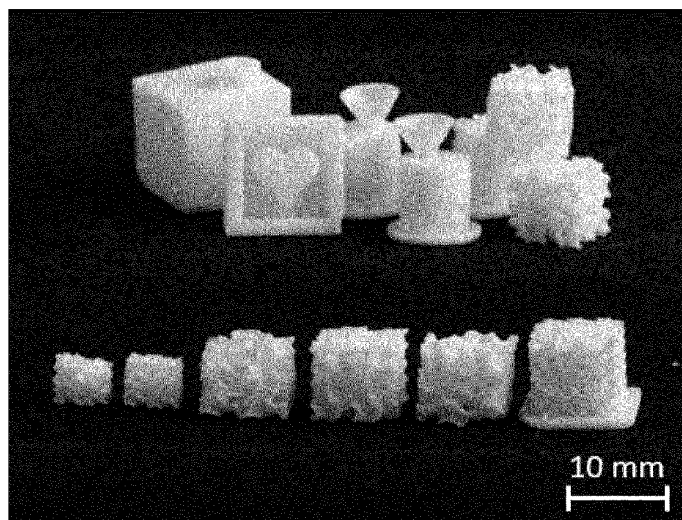
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(54) Title: METHOD FOR THE ADDITIVE MANUFACTURING OF CASTING MOLDS

Fig. 4



(57) **Abstract:** A method for manufacturing a photopolymerizable slurry comprises the steps of: providing a plurality of particles of an inorganic salt in the form of a powder; wherein at atmospheric pressure the inorganic salt has a melting point of above 250 °C; and wherein at room temperature the inorganic salt has a solubility in water above 9 %w/w; providing at least one radiation curable monomer; the at least one radiation curable monomer being in the liquid phase; and adding the inorganic salt particles to the liquid composition and mixing the inorganic salt particles with the liquid composition; obtaining a photopolymerizable slurry, selectively curing the photopolymerizable slurry to obtain a green body article; debinding the green body article to obtain a binderless body article; and sintering the binderless body article to obtain a sintered ceramic article; providing a first template mold (1); wherein the first template mold comprises the sintered ceramic article; providing a second mold (2, 2', 2''); wherein the second mold comprises a compartment

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into which said first template mold can be placed; mounting the first template mold into the compartment of the second mold, thereby obtaining an operative mold (1, 2, 2'); casting a fluid casting material (3, 3', 3'') into said operative mold to obtain after solidification of said casting material an infiltrated template mold (8) comprising a solid article (9) that is at least partially located within the first template mold (1); and separating said solid article from the first template mold by dissolving the sintered ceramic article of the first template mold with a suitable solvent, for example water.