

Title (en)

Method of manufacturing intermediate concrete products, formwork for manufacturing said products, and apparatus for carrying out said method.

Title (de)

Verfahren zur Herstellung von Betonkörpern, Schalung für die Herstellung dieser Betonkörper und Vorrichtung zur Durchführung des Verfahrens.

Title (fr)

Procédé de production de produits en béton, coffrage pour produire lesdits produits, et appareil pour exécuter ledit procédé.

Publication

**EP 0437672 A1 19910724 (EN)**

Application

**EP 90114902 A 19900802**

Priority

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Abstract (en)

The invention refers to a method of manufacturing intermediate concrete products, preferably tiles, which consists of casting non-segregable concrete mass of cast consistency into corresponding formworks. The concrete mass is cast by means of a charging head (4) and by discharging nozzles (6) arranged thereon, whereby the pressure of the concrete mass at the outlet of the nozzles (6) is adjusted to the largest cross-section of the product being cast and equals from 0,1 bar to 0,5 bar, preferably 0,2 bar. Nozzles (6) being pushed to the area of the bottom of the formwork (5) in the beginning of casting start to lift up when the concrete mass fills up the formwork (5) for essentially one third by the height. The lifting velocity of the charging head (4) and thereby of the nozzles (6) is adjusted to the cross-section of the product being cast, and equals from 0,05 ms<sup>-1</sup> to 0,2 ms<sup>-1</sup>, preferably 0,1 ms<sup>-1</sup>. The invention also refers to a formwork for manufacturing concrete tiles and to an apparatus for carrying out said method. <IMAGE>

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IPC 8 main group level

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CPC (source: EP)

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Citation (search report)

- [A] DD 259576 A1 19880831 - SAECHSISCHES SERUMWERK [DD]
- [A] GB 1579544 A 19801119 - RECH DE L IND DU BETON CENTRE
- [X] Der Grundbau, ARMIN SCHOKLITSCH, Verlag Julius Springer, Wien, 1932, pages 118-119.
- [X] Die Gruendung von Bauwerken, WOLF PLAGEMANN, WOLFGANG LANGNER, Verlag B.G. Teubner, Leipzig, 1973, page 106.

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US2011183023A1; EP1017552A4; NL1013857C2; CN106703412A; CN115401765A; WO0143930A3

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