

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 B1 19940608 (EN)**

Application

**EP 90114902 A 19900802**

Priority

YU 7290 A 19900116

Abstract (en)

[origin: EP0437672A1] 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<-><1> to 0,2 ms<-><1>, preferably 0,1 ms<-><1>. The invention also refers to a formwork for manufacturing concrete tiles and to an apparatus for carrying out said method. <IMAGE>

IPC 1-7

**B28B 1/14**

IPC 8 full level

**B28B 7/24** (2006.01); **B28B 13/02** (2006.01)

IPC 8 main group level

**B28B 1/00** (2006.01); **B28B 5/00** (2006.01)

CPC (source: EP)

**B28B 7/243** (2013.01); **B28B 13/021** (2013.01)

Cited by

US2011183023A1; CN106703412A; NL1013857C2; CN115401765A; EP1017552A4; WO0143930A3

Designated contracting state (EPC)

AT DE FR GB IT

DOCDB simple family (publication)

**EP 0437672 A1 19910724**; **EP 0437672 B1 19940608**; AT E106792 T1 19940615; CA 2025840 A1 19910717; DE 69009724 D1 19940714; DE 69009724 T2 19941215; FI 903951 A0 19900809; FI 903951 A 19910717; SI 9010072 A 19971031; YU 7290 A 19920907

DOCDB simple family (application)

**EP 90114902 A 19900802**; AT 90114902 T 19900802; CA 2025840 A 19900920; DE 69009724 T 19900802; FI 903951 A 19900809; SI 9010072 A 19900116; YU 7290 A 19900116