

Title (en)

Process and wagon for the firing of interlocking tiles

Title (de)

Verfahren und Ofenwagen zum Brennen von Falzdachziegeln

Title (fr)

Procédé et voiture pour cuire des tuiles à emboîtement

Publication

**EP 0786636 A1 19970730 (DE)**

Application

**EP 97101201 A 19970127**

Priority

- DE 19602777 A 19960126
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Abstract (en)

A process for rapidly firing channelled tiles involves loading dried tile mouldings (1) as a single layer charge of spaced-apart inclined mouldings directly on a support (3) which has a large charge width of over 2.5m and which is fixed on a kiln car (2). This is followed by transporting the mouldings through a rapid firing tunnel kiln, and unloading only the fired tiled (i.e. without the supports) from the kiln cars. The tunnel kiln car used is for single layer firing of channelled tiles by the above process. The car has a refractory moulding reception device which is located above a heat insulated car base (4) and below which a heating medium flows. The reception is provided with several moulding supports (3) on or in a support frame (5) mounted on the car structure, the main support faces of the supports being inclined to the vertical. Each support (3) supports at least one tile moulding (1), and consists of refractory material and has heating medium passage openings and support elements and/or faces matching the shape of the tile underside. Preferably, the supports (3) consist of a ceramic-based refractory material such as cordierite or silicon carbide.

Abstract (de)

Die Erfindung betrifft ein Verfahren und Ofenwagen zum Brennen von Dachziegeln im einlagigen Schnellbrand. Erfindungsgemäß wird der Besatz in Einzelunterstützung von reihenweise angeordneten Dachziegel-Formlingen (1) in sogenannter kassettenloser Anordnung direkt auf einen Ofenwagen (2) - welcher wageneigene Stützeinrichtungen besitzt - geladen, wobei die Formlinge (1) aus der Vertikalen geneigt schräggestellt sind.  
<IMAGE>

IPC 1-7

**F27D 3/12**; **F27D 3/00**; **F27D 5/00**

IPC 8 full level

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Citation (search report)

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