

Title (en)

METHOD AND APPARATUS FOR MANUFACTURING A CONCRETE PRODUCT

Title (de)

VERFAHREN UND VORRICHTUNG ZUR HERSTELLUNG EINES BETONPRODUKTES

Title (fr)

PROCEDE ET APPAREIL PERMETTANT DE FABRIQUER UN PRODUIT EN BETON

Publication

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Application

**EP 00954695 A 20000822**

Priority

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Abstract (en)

[origin: WO0114114A1] The invention relates to a method and assembly for manufacturing a concrete product series of hollow-core slabs of at least two different sizes, the products having hollow cores of different heights. According to the method, using at least one feeder auger (4), concrete mix is extruded through a delimited cross section acting as a nozzle section, and to the rear end of each feeder auger (4), within the length of the delimited cross section, is adapted a core-forming tubular member (6) serving to shape a hollow core in the product being manufactured. The core-forming member (6) is selected to be a tubular member having its height adjusted to be at the core-troweling portion of the member equal to the desired height of the hollow core in the product, and the members (7) serving to delimit the top surface of the nozzle section are contoured to conform to the shape of the top surface of the selected tubular member (6) so that the height difference between the ingoing end and the outgoing end of the members (7) in the concrete mix flow direction is within a 50 % tolerance equal to the height difference between the top level of the rotational envelope perimeter of the auger (4) and the top level of the core-forming tubular member (6) that trowels the hollow core of the product.

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