

Title (en)

Method and apparatus for manufacture of embossed fibre cement board and said embossed fibre cement board

Title (de)

Verfahren und Vorrichtung zur Hertsellung von

Title (fr)

Procédé et appareil de fabrication

Publication

**EP 2687346 A1 20140122 (EN)**

Application

**EP 12177352 A 20120720**

Priority

EP 12177352 A 20120720

Abstract (en)

The method of manufacturing profiled fibre cement sheets includes the stages of preparing raw materials and preparing a mixture, forming and shaping the fibre cement sheets, cold pressing of the sheets, preliminary hardening of the sheets, follow-up hardening of the sheets and finishing the sheets. The equipment for manufacturing the profiled fibre cement sheet includes a device for forming and shaping the fibre cement sheets, a conveyor for preliminary hardening of the fibre cement sheets, a flow-through shelf for follow-up hardening of the fibre cement sheets, and a template painting system for finishing the fibre cement sheets. The stage of forming and shaping the fibre cement sheet utilises a seven-step device including a slurry bath 1, a mixer 2 added to the slurry bath, oil sprayers 11 and a formwork which comprises a shell 4, a vacuum chamber 5 located inside the shell 4, a covering sieve 6 which covers the outside of the work surface of the formwork, water removal channels 7 between the covering sieve 6 and the vacuum chamber 5, a vacuum pipe 8, fastening eyes 9 of the formwork, and a counterpart 10 of the formwork. The profiled fibre cement sheet has a thickness in range 1.5 to 3 mm and a relief depth in range 10 to 120 mm and includes an imitation pattern 33, an imitation edge 34, an imitation vertical joint 35, an imitation horizontal joint 36, and also a fastening opening 37, grooves 38 hindering lateral movement of water, grooves 39 ensuring proper positioning of fibre cement sheets to each other or an overhang 40.

IPC 8 full level

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CPC (source: EP)

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Citation (search report)

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- [I] JP S54106532 A 19790821 - SEKISUI CHEMICAL CO LTD
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