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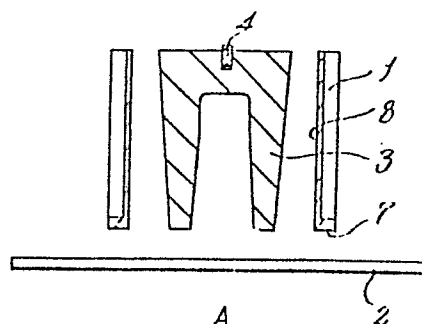
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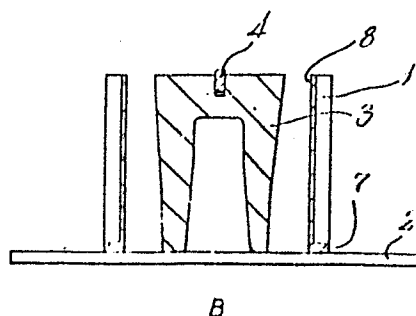
(54) Improvements in or relating to manufacture of building blocks.

(57) An apparatus for manufacturing a building block is of the type having a mould box (1), and at least one core (3) rigidly mounted in the mould box by means of a spacer bar (4). At least a portion of the moulding surface of the core and/or the mould box is formed from a rubbery polymer. The polymer may be used as a coating (8) and/or the core (3) may be a moulding of the polymer. An undercut may be made in a block by providing a core (16) with an expandable resilient portion. The polymer may also be used to provide a cushion (8) under the lower edge of the mould box (1).

In the process using the apparatus the mould box (1) and core (3) are removed from uncured mould blocks after a very short time eg 1 to 60 seconds.



**FIG.2**





European Patent  
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# EUROPEAN SEARCH REPORT

0182619

Application Number

EP 85 30 8308

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
X	US-A-1 584 595 (K. BADER) * Page 1, lines 1-42; page 1, line 88 - page 2, lines 72; page 2, line 114 - page 3, line 85; figures 1-13 * ---	1,2,11- 16	B 28 B 7/36 B 28 B 7/34 B 28 B 7/30
X	DE-A-2 444 715 (KYOKUTO MCGREGOR K.K.) * Page 2, line 6-18; page 4, line 11 - page 8, line 10; page 10, lines 1-22; figures 1-14 * ---	1,2,5- 10,14- 16	
A	BE-A- 387 678 (FOULON) * Pages 1-4; figures 1-4 * ---	1,5,14- 16	
A	DE-B-1 238 829 (E. WIEST) * Column 6, line 35 - column 7, line 42; figures 1,2 * ---	1-10,14 -16	
A	DE-B-1 074 849 (ALWEG-FORSCHUNG GmbH) * Column 1, line 1 - column 2, line 42; column 3, line 7 - column 4, line 8; figures 1-7 * ---	1,11-13	
A	FR-A- 809 116 (GIRARD) * Whole document * -----	1,3,6,7 -10	TECHNICAL FIELDS SEARCHED (Int. Cl.4)  B 28 B
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 31-03-1988	Examiner CUNY J.M.J.C.
<b>CATEGORY OF CITED DOCUMENTS</b> X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document  T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application I : document cited for other reasons ----- & : member of the same patent family, corresponding document			