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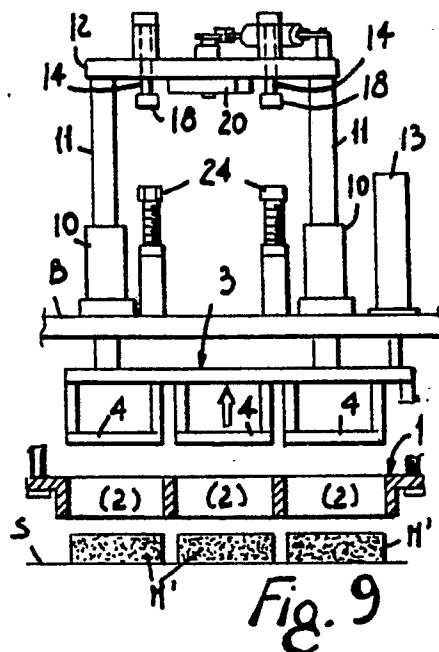
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54. Process and machine for producing blocks of pressed vibrated concrete.

57) Process and machine for producing pressed vibrated concrete blocks, providing for a suitable vertical displacement of the counter mould (3) in its block delivery step, whereby the blocks are delicately laid on the ground. The process comprises the steps of filling the moulds (1), lowering the counter mould (3), pressing and vibrating the concrete, opening the bottom of the mould (1) by removing the bottom plate (5), causing the moulded blocks (M) to be deposited on the ground (S) by lowering the counter mould (3) and lifting the mould (1). The machine is characterized by provisional limit stop means (18-20) so that the counter mould (3) can be lowered for pressing the concrete and during an extra stroke for putting the blocks (M') on the ground (S).





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	FR-A-1 006 673 (SCHNEIDER) * Whole document *	1-2	B 28 B 13/06 B 28 B 1/08 B 28 B 3/06
X	FR-A-2 474 940 (IACONO) * Whole document *	1-2	
X	DE-A-3 420 448 (HESS) * Abstract; page 7, line 20 - page 9, line 21; figures *	1	
Y		3	
Y	FR-A-2 373 371 (OUTINORD) * Page 7, line 16 - page 10, line 7; claims 13-19; figures *	1,3	
Y	DE-B-1 800 182 (RINO) * Whole document *	1	
A	FR-A-1 476 024 (CHIESA) * Figures *	1-2	
A	FR-A-1 138 906 (PORRET-BLANC) * Figures *	1-2	TECHNICAL FIELDS SEARCHED (Int. Cl.4)
A	GB-A-1 604 661 (CALIFORNIAN SCREEN) * Figures 1-8 *	1-2	B 28 B
A	US-A-1 921 003 (ROMIE) * Page 1, lines 31-38; page 3, lines 56-128; figures 12-16 *	1-2	
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 16-03-1990	Examiner VOUTSADOPOULOS C.
CATEGORY OF CITED DOCUMENTS 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 L : document cited for other reasons & : member of the same patent family, corresponding document			