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⑤④ **Hydraulic pressure regulator device, typically for ceramic moulds with a mobile bottom die and a counter-die.**

⑤⑦ A hydraulic device, typically for ceramic moulds comprising a vertically mobile bottom die (24) provided with cavities (21) for loading the soft clay and a counter-die (240) provided with corresponding cavities (210), said cavities (21), (210) being closed at their rear by respective punches (20), (200) for forming the laying and exposed faces of the tiles respectively, said punches (20), (200) being connected to the hydraulic circuit of the press which operates the ceramic mould, in such a manner as to be driven independently of said bottom die and counter-die, comprises two intercommunicating chambers (122, 22) with a valve (4) therebetween, the first (122) being connected to the hydraulic circuit (66) for driving the lower punches (20) relative to

the bottom die (24), and the second (22) being connected to at least one hydraulic chamber (280) for driving the upper punches (200) relative to the counter-die (240). The valve (4) is elastically urged towards a forward slidable push rod (5, 6) the seat of which is connected to said first chamber (122) such that when this latter is put under pressure by the hydraulic fluid from said circuit (66) the push rod (5, 6) causes the valve (4) to open with simultaneous fluid entry into said hydraulic chamber (280) and advancement of the upper punches (200). When the upper punches (200) move rearwards during a pressing stage, the valve (4) closes after fluid discharge from said hydraulic chamber (280).

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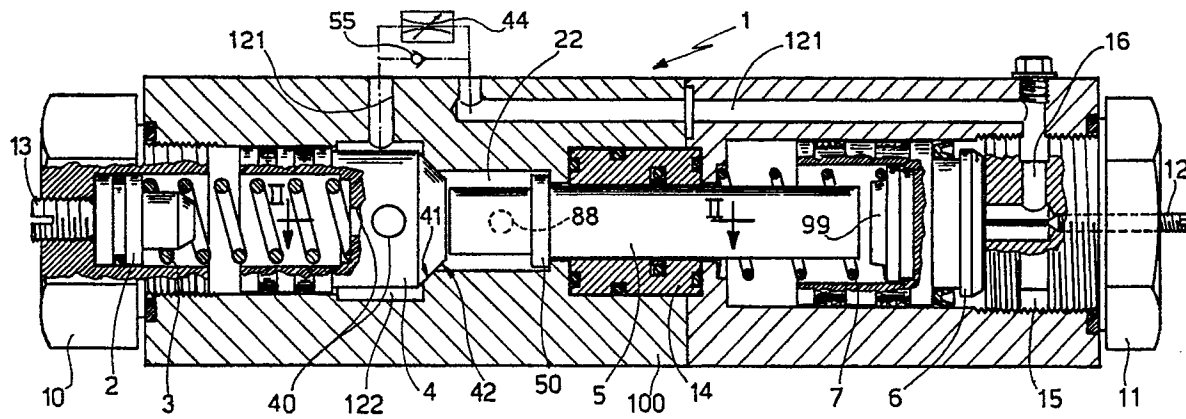


FIG. 1



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EUROPEAN SEARCH REPORT

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EP 90 20 2381

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.5)
A	EP-A-0 211 449 (MASS S.p.A.) * Whole document * - - - -	1,6	B 28 B 3/02
A	DE-A-3 527 594 (S.A.C.M.I. COOPERATIVA MECCANICI IMOLA) * Abstract; figures * - - - -	1	
A	GB-A-2 025 834 (MERISINTER S.p.A.) * page 1, lines 1-105 * - - - -	1	
A	US-A-1 682 172 (HYDRAULIC PRESS MANUFACTURING CO.) * Figure 5 * - - - -	1,2	
A	FR-A-6 413 83 (L. RONCHAIN) * Page 1, lines 1-20 * - - - - -	1	
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B 28 B B 30 B F 15 B F 16 K
Place of search		Date of completion of search	Examiner
The Hague		19 September 91	LANASPEZE J-P.Y.
CATEGORY OF CITED DOCUMENTS			
X: particularly relevant if taken alone		E: earlier patent document, but published on, or after the filing date	
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