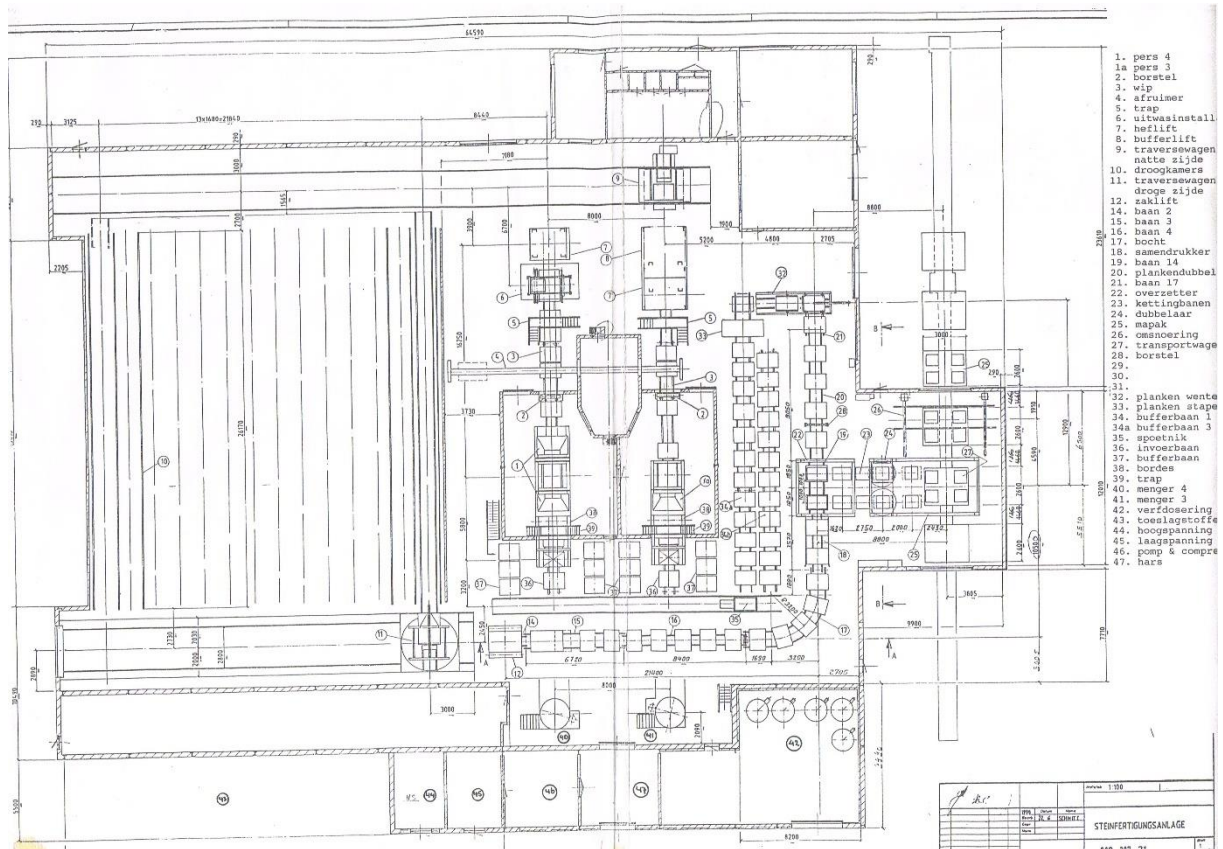


## Information document double Vibroblock plant

Machine 1	Vibroblock
Machine 2	Vibroblock
Year of built	1989
Controls	Blockmachine and fingercar : Siemens S5 Packingline : Siemens S7-314 Rest of the wet & dry line : Siemens S5
Boardsize	1.450x1.100x50 mm
Number of boards	n/a. Boards are not available
Vibrationsystem	Vibro 1: Gearbox with two motors Vibro 2: Masa system with 4 x MSE50-2
Max product height	8 cm pavers without having to adjust the fingercar. Curbstones up to 1 meter long and 30 cm high can be held between the fingers without adjustment of the fingercar. Longer products higher than 14 cm require manual adjustment of the fingers.
Board buffer	2.880 boards. 24 boards per stack. 120 stacks
Curing chamber	Rotho. Freestanding
Height curing chamber	28 stories. Highest board is at 630 cm. Total height chamber: 765 cm.
Storyheight	20 cm
Fingercar adjustable?	Yes
Number of chambers	14
Positions per chamber	21
Total positions	8.232
Mixer 1	Demler MDL 120. 1500 litres
Mixer 2	Demler MDL 120. 1500 litres
Pigment dosing	Finke granulate
Additive dosing	2 types
Aggregate silo's	6 silo's: 40, 60, 80, 100, 120 and 140 m <sup>3</sup>
Cement silo's	3 silos 180 tonnes each
Cycle time pavers	16 sec.
Output per 8 hrs	1.500 m <sup>2</sup> of regular pavers 10,5x21x8 cm @80%
Pallet system	Automatic pallet destacker
Horizontal strapping	Sander variomaster 9490
Product transport	automatic placement onto 4-cart system
Moulds included	Pavers 10,5x21x8, 10 and 12 cm Pavers 21x7x8 cm 20x30x6 cm 30x30x4,5 cm and numerous other sizes

All pictures in this document are available in high resolution also.

- 01 Transport of sand and aggregates
- 02 Filling of silo's with sand and aggregates
- 03 Skip with concrete to machine
- 04 Transport of concrete to machine
- 05 Production of 20x30x6 stones
- 06 08 Board handling
- 09 Transportation of cured product and board handling
- 10 Transport of cured stones to rumbling plant





Dumpposition for sand and aggregates





Pit for sand and aggregates with conveyor





Conveyor sand and aggregates



Outside conveyor to inside conveyor for bunker filling





Reversible conveyor for bunker filling







Storage bunkers for sand and aggregates





Conveyor underneath storage bunkers





Motor control cabinet for bunkers



Cement silo's





Filling point for 3 cement silo's





Cement screws to both mixers



Additives to both mixers





Finke pigment dosing system





Finke pigment dosing system



Finke pigment dosing system





Mixer



Mixer





Transport of fresh concrete to machine including 3 color mix hoppers

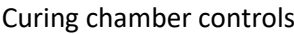


Ludwig water measuring and dosing Vibro 1



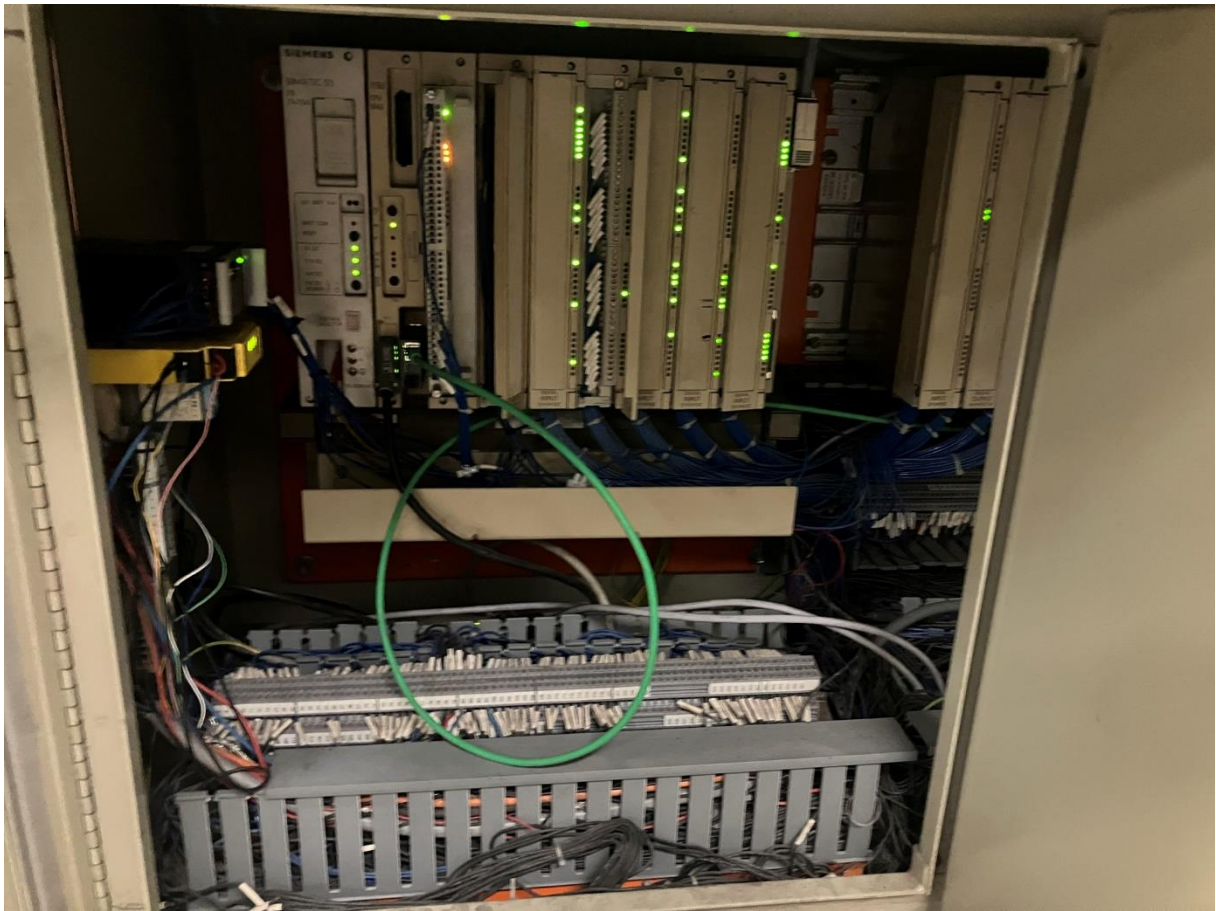


Ludwig water measuring and dosing Vibro 2

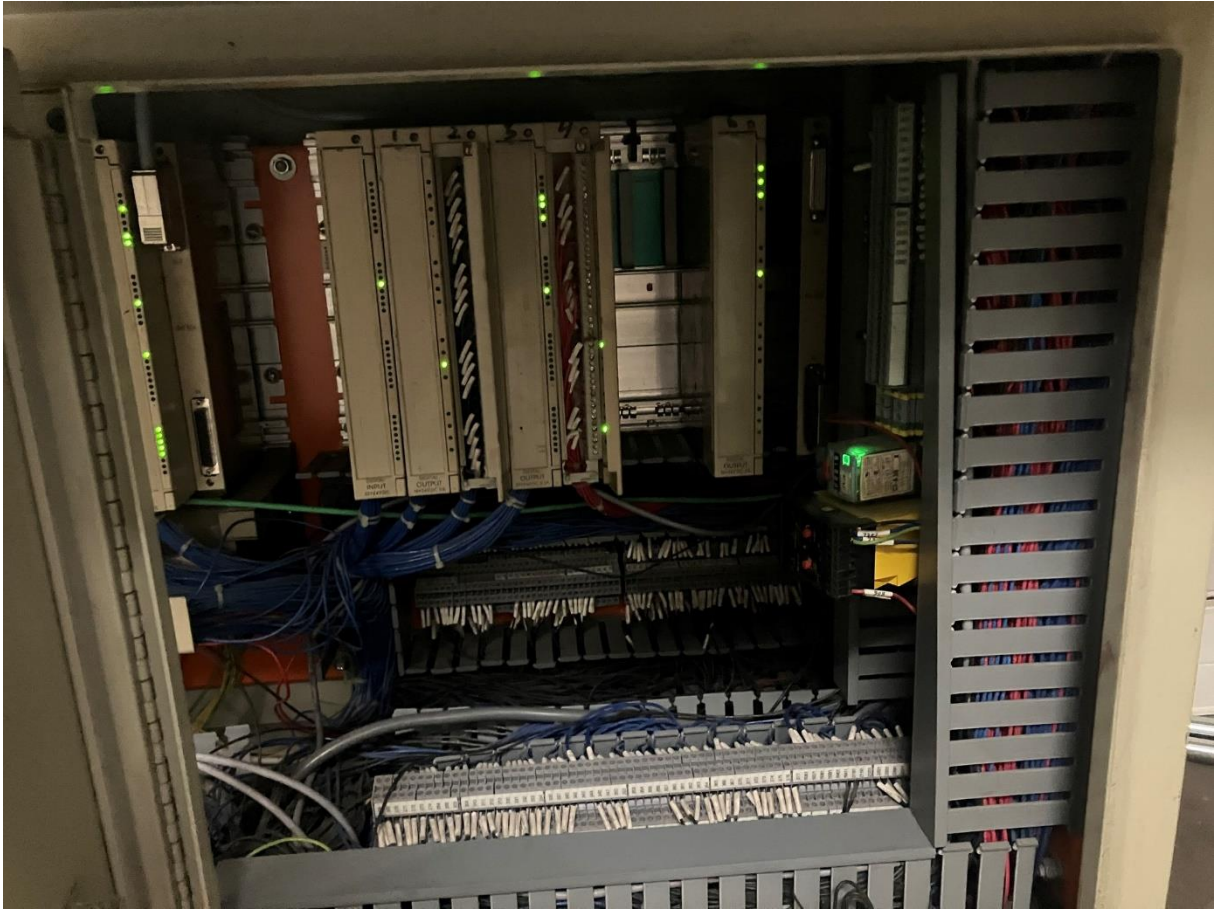


## Curing chamber controls



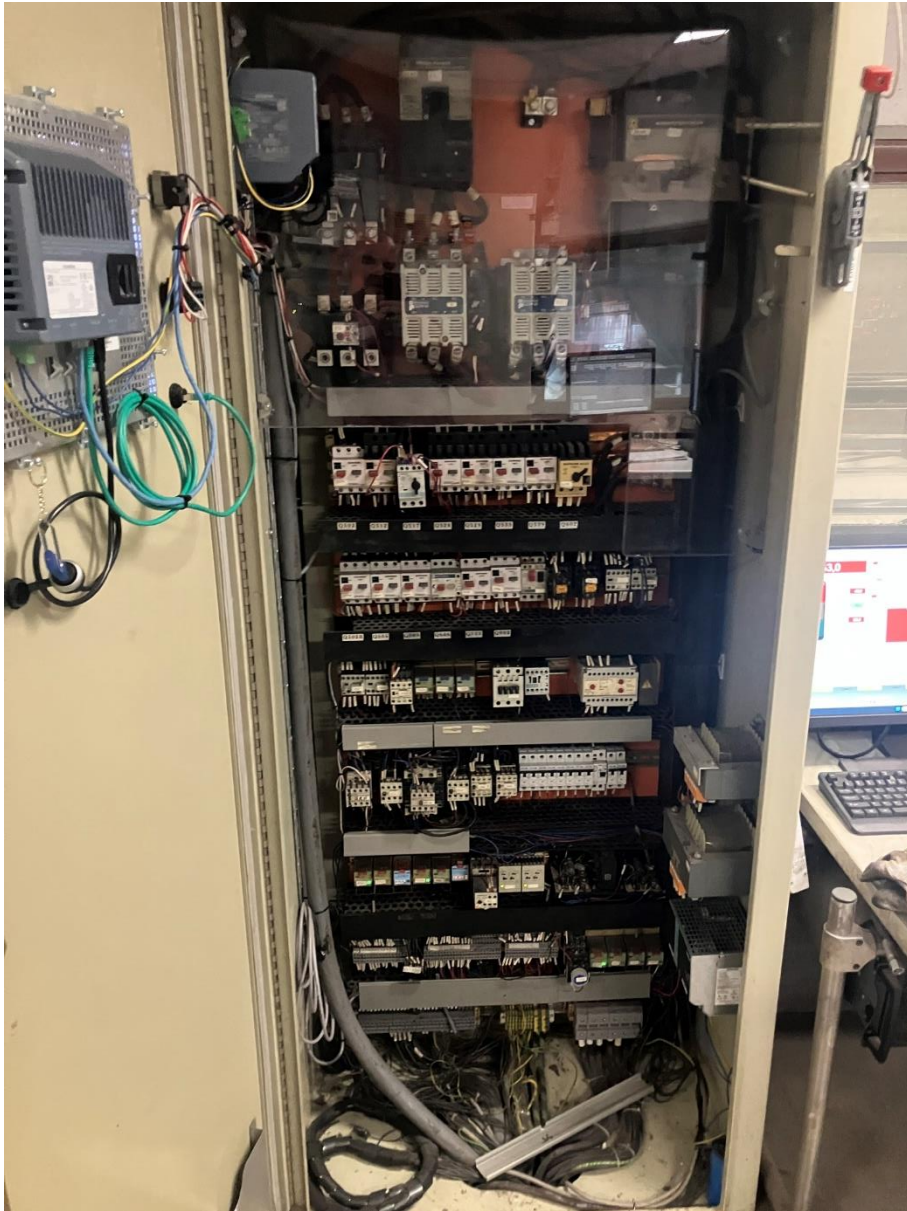


Controls



Controls





Controls



Vibro 1



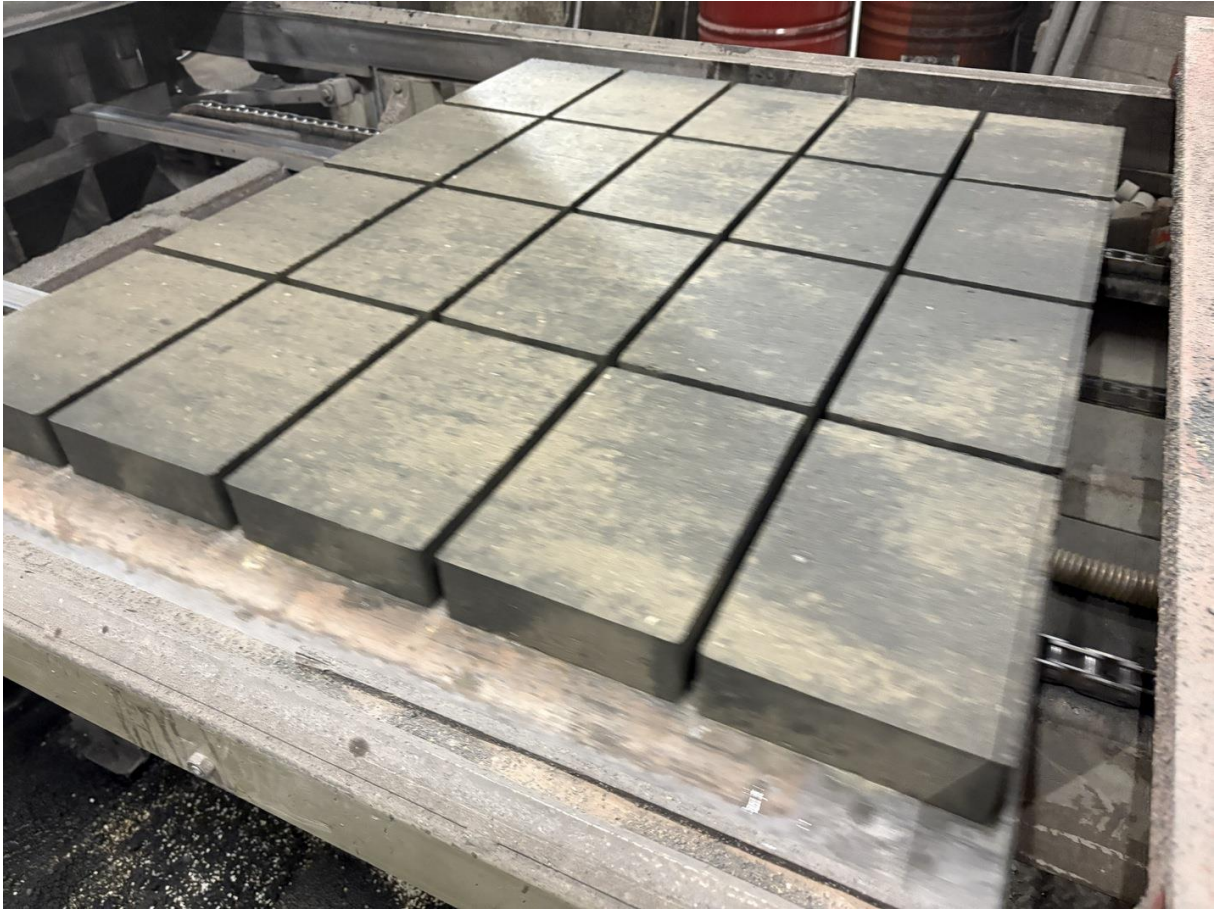


Vibro 1



Vibro 1





20x30x6 from Vibro 1



Controls Vibro 1





Vibro 2



Vibro 2



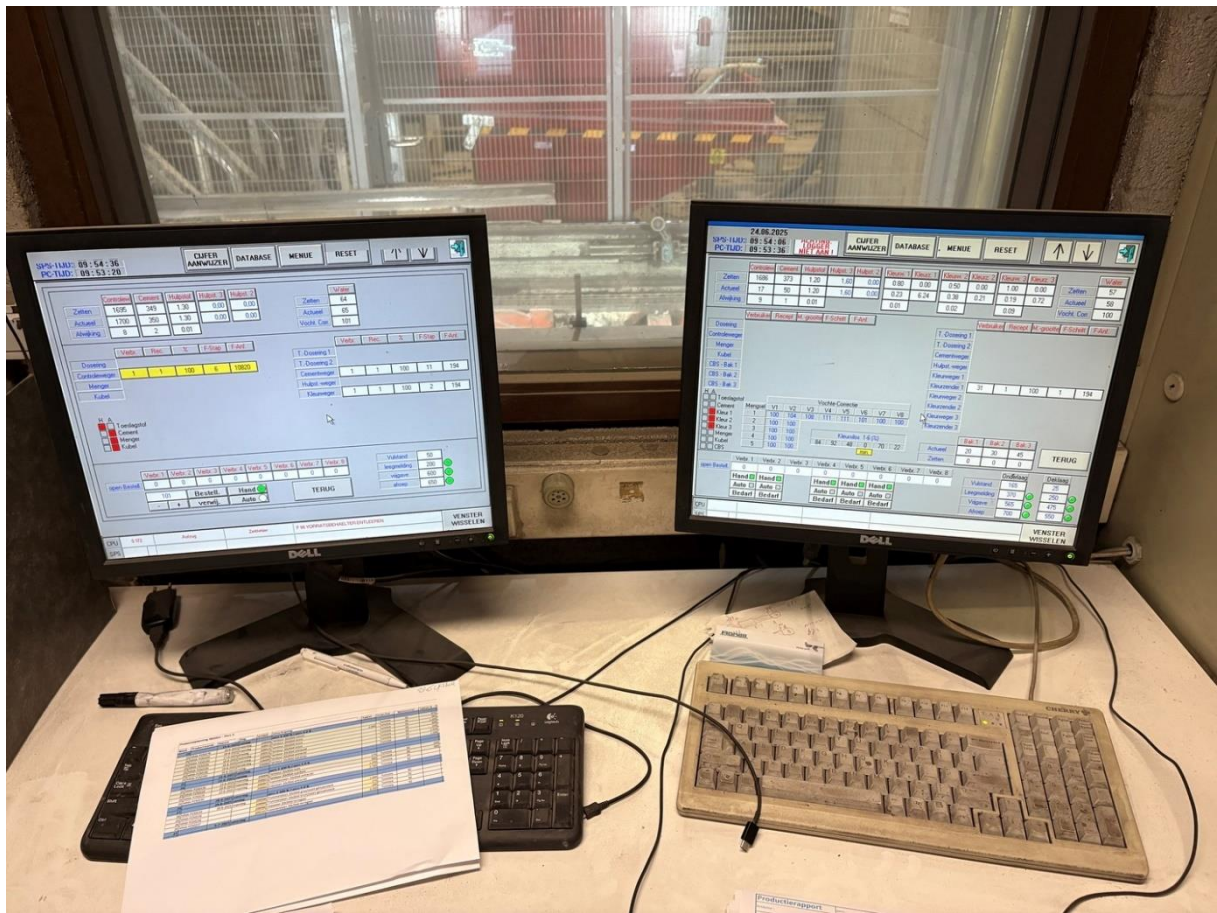


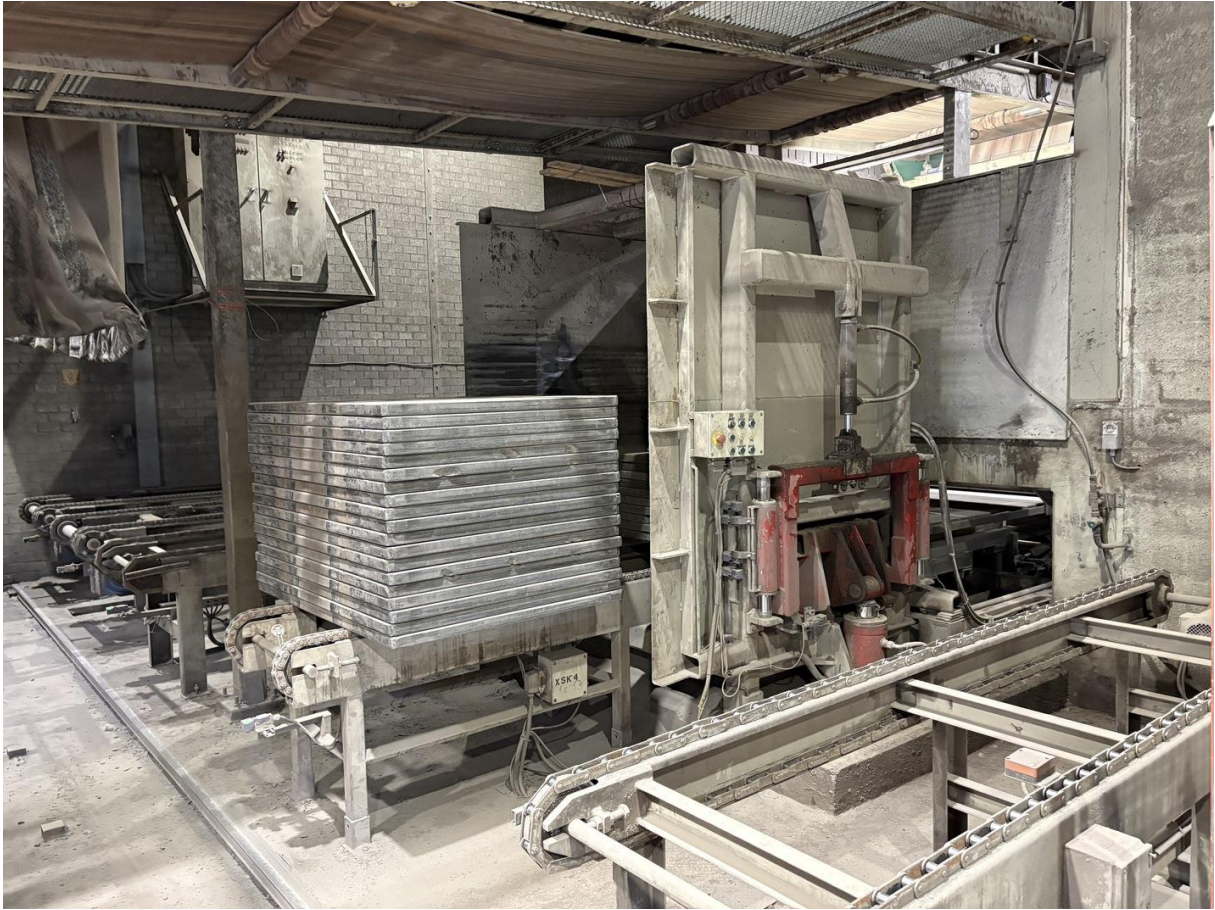
Vibro 2



Controls Vibro 2





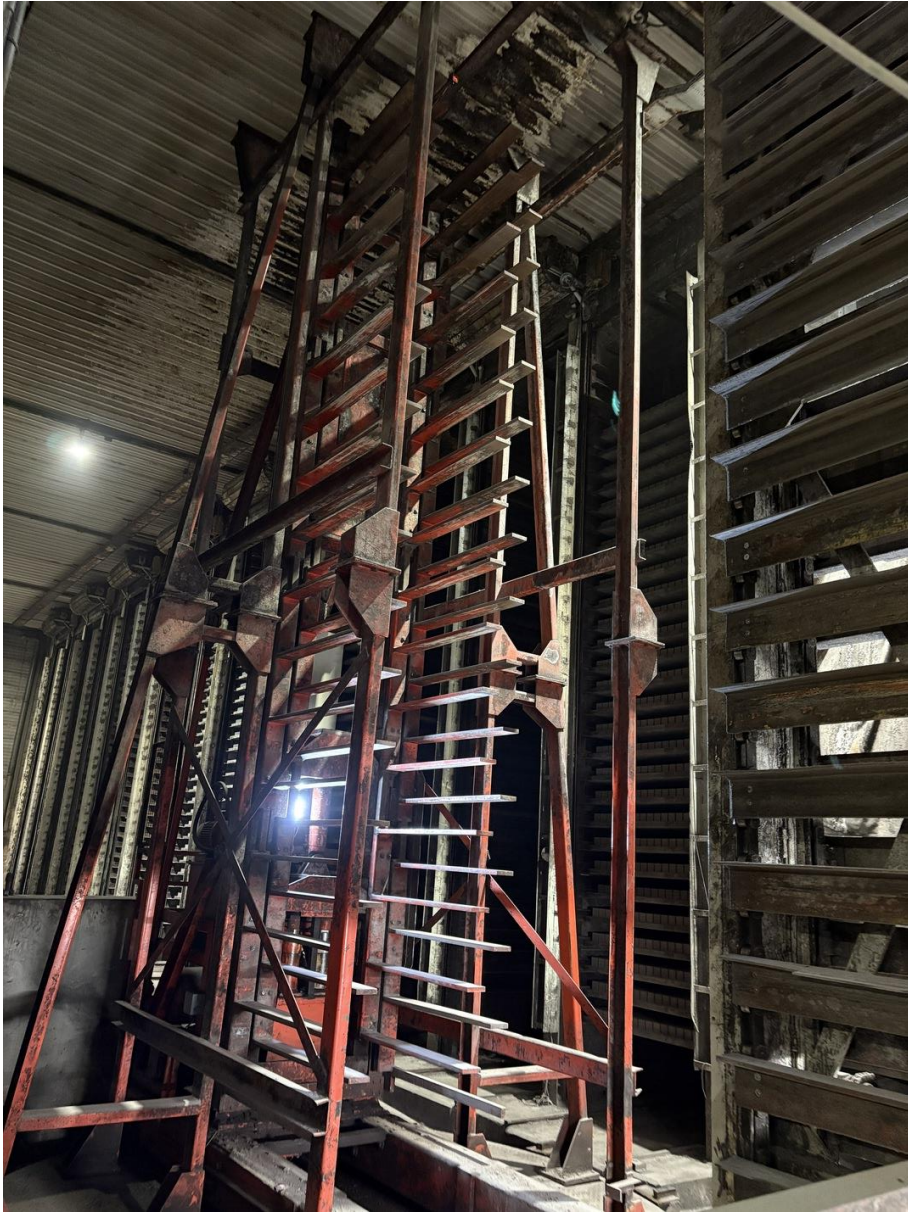


Ingoing boards to machine





Board destacker



Finger car





Elevator with buffer



Elevator with buffer





Curing chamber with fingercar

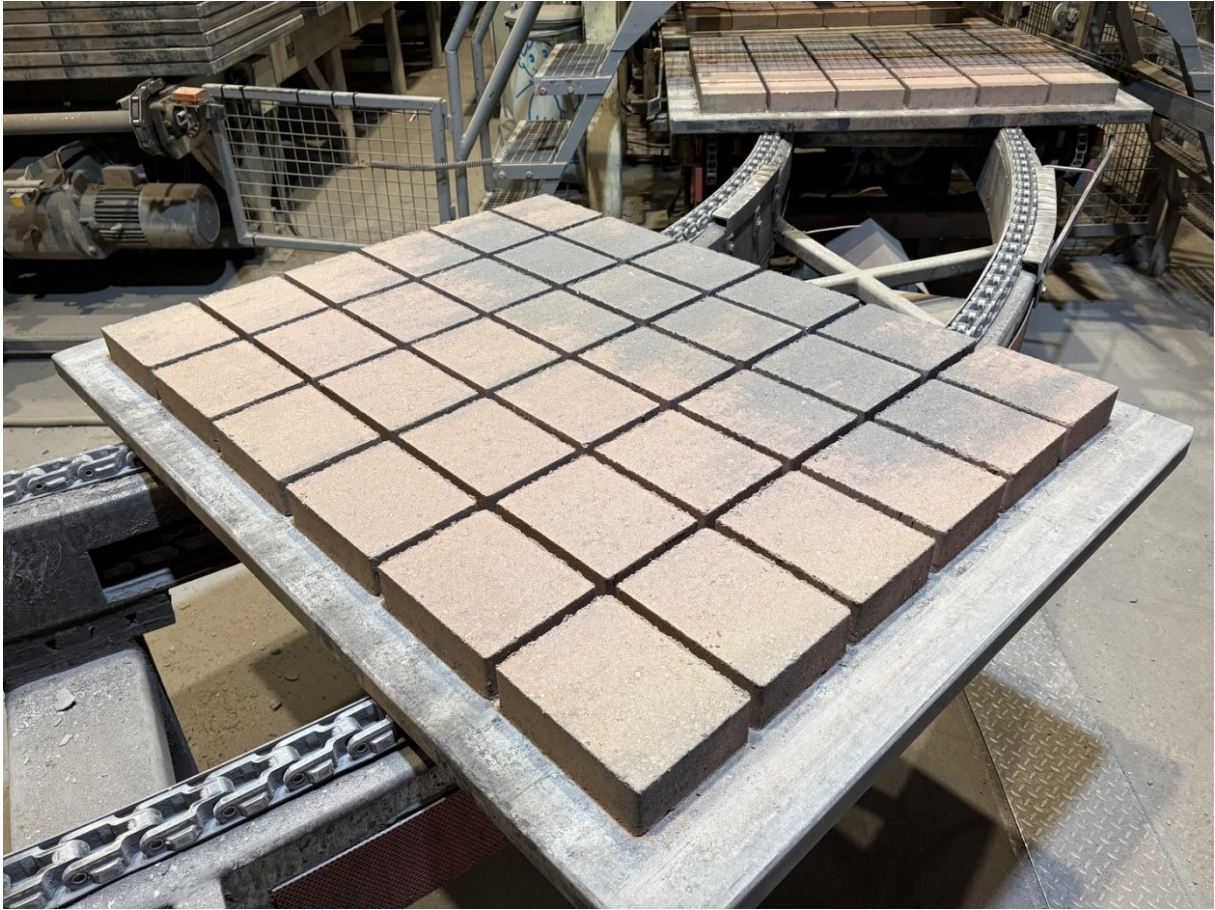


Curing chamber with fingercar





Cured product to packing



Inspection area of finished product





Inspection area of finished product



Finished product to packing





Centering and packing



Cuber with caroussel





Controls of cuber and carousel







Inline transport of cured products to rumbling plant



Spare parts – motors





Spare parts – mechanical



Drawings (Foundation, building, steel constructionz, production plant, electrical, hydraulics)





Spare parts







Spare parts



Various moulds