

Bouter Betonexport, 77889 Seebach, Germany



Efficient Production system for semi-dry concrete

The L-3 production system is a simple manufacturing tool with which one can produce nevertheless high quality concrete products. It does not require a big investment, nor highly qualified personal, neither does it require heavy labor. The L-3 production system consists of three moving lifting devices L1, L2 and L3.

The basic machine is the L-1 Drycaster (1,5 tons lifting capacity) for the handling of the mould with or without concrete. With the installation one can manufacture concrete products with a semi-dry mix, while demoulding the product immediately after the mould has been filled, the concrete has been compacted by vibration and the top surface has been finished. The filled mould will be lifted and turned over 180 °. Subsequently the mould is lowered on a wooden pallet, which is laying ready for use on the

demoulding table. The mould is supplied with air pressure, while it is lifted carefully; this way the product is demoulded. After this operation the operator will turn the mould back into its filling position and deposit it on the vibration table.

The fresh demoulded product is transported over the whole storage area. When one layer of products is deposited, then the next layer of pallets with product can be stacked on the previous ones.

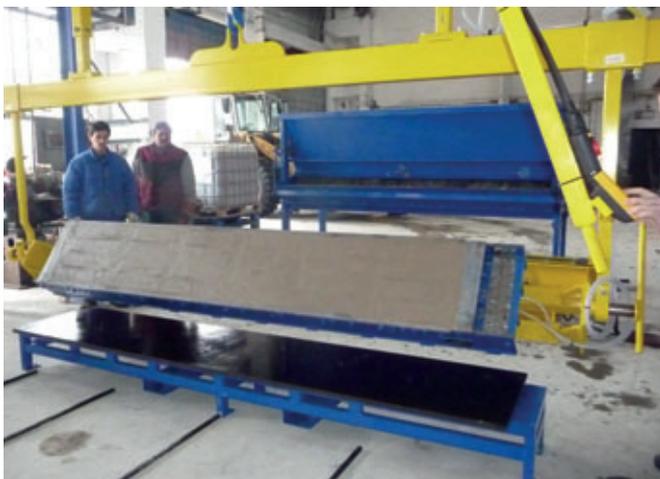
The useful length of the pallets is 3000 mm. The product width varies generally from 400- 600 mm, but other dimensions can be given upon demand. The product weight of the basic version is 500-600 kgs. Other dimensions can be supplied. For the semi-automatic version this can be more: 1000 kgs. or even more. Upon demand taylor made installations can be offered.



L-3 production system with Knauer vibration station; the system was sold in the region around Budapest by the Hungarian company Atillas, for nearly 20 years the professional partner for the concrete industry in Hungary, Ukraine and Romania (www.atillas.hu).



Vibration table with two motors and pneumatic clamping



L-1 Production Lifting / Demoulding crane





L-3 Product lifting unit with hydraulic clamp



The optional trowelling device can also run in automatic mode

Knauer Vibration station

This station consists of a H-beam shaped vibration table, having 2 vibration motors. The centrifugal force of the table is max. 40 kN. The mould + product weight is 1.500 kg. for the simple manual version. Depending on the total weight the average acceleration can reach 4-5 g', but quite higher peak accelerations will be reached. The vibrators are controlled by means of a frequency convertor. There are two pneumatic clamps at the table in order to keep the mould in position on the table. The mould supporting beam can be used to mount various moulds onto it with adjustable length's.

Concrete Hopper

The concrete hopper is standing behind the mould. The concrete is drawn into the mould with simple working tools over a movable steel plate which is connecting to the mould. In the upper position it closes the hopper. The water- content is 1,5 m³.

For the semi-automatic version also a moving hopper with belt can be supplied. This type of hopper has a water- content of 1,0 m³. With a moving belt the concrete mix is brought into the feed-box. With this moving hopper the concrete is brought into the mould regularly when it runs over it.

An optional moving trowelling device with a rotating disk can be provided in order to finish the surface. The operator controls the feed hopper and the disk with joysticks. This guarantees a good flexibility and an easy workability.

The moving frames of the Lifting cranes are running over rails which are suspended at a stabile steel construction. With the simple version the units are simply moved by hand, which is the quickest method with these limited weights. With the semi-automatic version an electric drive is provided.

The L-1 Crane is then also equipped with an electric motor for turning over the mould. The L-2 Crane for the bringing in and taking out of the pallets in the storage area is equipped with an encoder in order to

ensure correct positioning of the pallets. The storage area is protected by some safety fences and electronic curtains. In this area the L-2 stacking Crane is running automatically with the reliable electronic controls of Beckhoff.

The L-3 System can be applied in many cases; it is mature and reliable.

The applications are:

- Concrete products for agricultural buildings for pigs and cows
- Products for infrastructure: concrete slabs, water gulleys, concrete beams, cable channels, inspection chambers
- Products for gardens: concrete fence posts, panels

FURTHER INFORMATION

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After 40 years of experience in the concrete industry, we offer you optimal independent advice on the manufacture of concrete products in direct demoulding and 'wet cast' production.

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First the advice, then the acquisition!

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