



A few remarks concerning the layout scheme:

- The two 4-day-curing chambers on the upper left side are not included;
- Instead of a transfer & dog car, a forklift is used;
- On the upper middle part, where it says "pallets to yard" the palletising system is not shown. This automated system has two options:
 - Stack 2 rows and/or 2 columns of products onto a single pallet (very convenient for smaller products);
 - Stack different sized products onto a single pallet;
- The machine can produce different sized products in a single run, thereby eliminating the risk of differences in color.

Main current product measurements:

30x30x4 cm

30x45x4 cm

45x45x4 cm

30x60x4 cm

45x60x4 cm

60x60x4 cm

60x90x4 cm

Circles up to 330 cm in diameter

The CMS machine was commissioned in the year 2000. It has run the equivalent of 3 years production time.

Production

3 carriers/minute. 7 hours per shift = 1260 carriers per shift.

@100% utilisation = 2520 products per shift.

The machine is designed for 2 shift operation.

Carrier size

1500x750 existing wooden boards for both production and 4 day curing system. Total number required: 6300.

Maximum dual product size = 600x600x70 mm thick

Maximum single product size = 1200x600x70 mm thick (this is theoretical; we have never produced products this large and the (packing) installation would require alteration to accommodate such large products).

Sequence of modules

1. Transfer/dog car system carries 2 stacks of 24 carriers each with rails and racking system for one day and four day cure.
2. Demould/fill line comprising
 - Twin stack transport (dry)
 - Lowerator
 - Demoulder
 - Air knife
 - Oiler with fume extraction
 - Twin screw doser
 - 3 vibrating tables with clamps
 - Elevator
 - Twin stack transport (wet)
 - Reciprocating hydraulic carrier transport system
 - Doser hoppers with automatic feed chute from mixer
 - Colour injection system
 - Manual stations for special products
3. Transfer system comprising
 - Feed belt conveyor

- Slab turnover
 - Take off conveyer
 - Vacuum transfer system
4. 4 day curing system comprising
 - Twin stack transport (dry)
 - Lowerator
 - Vacuum take off system
 - Empty pallet transfer
 - Face spray booth with fume extraction
 - Elevator
 - Twin stack transport (wet)
 - Reciprocating carrier transport system
 5. Palletiser system comprising
 - Conveyor system
 - Caliper system
 - On edge stacking system
 - Despatch pallet magazine
 - Reciprocating carrier transport system
 6. Control system – Siemens PLC system with pc and scada control
 7. Guarding and safety to EC standards





