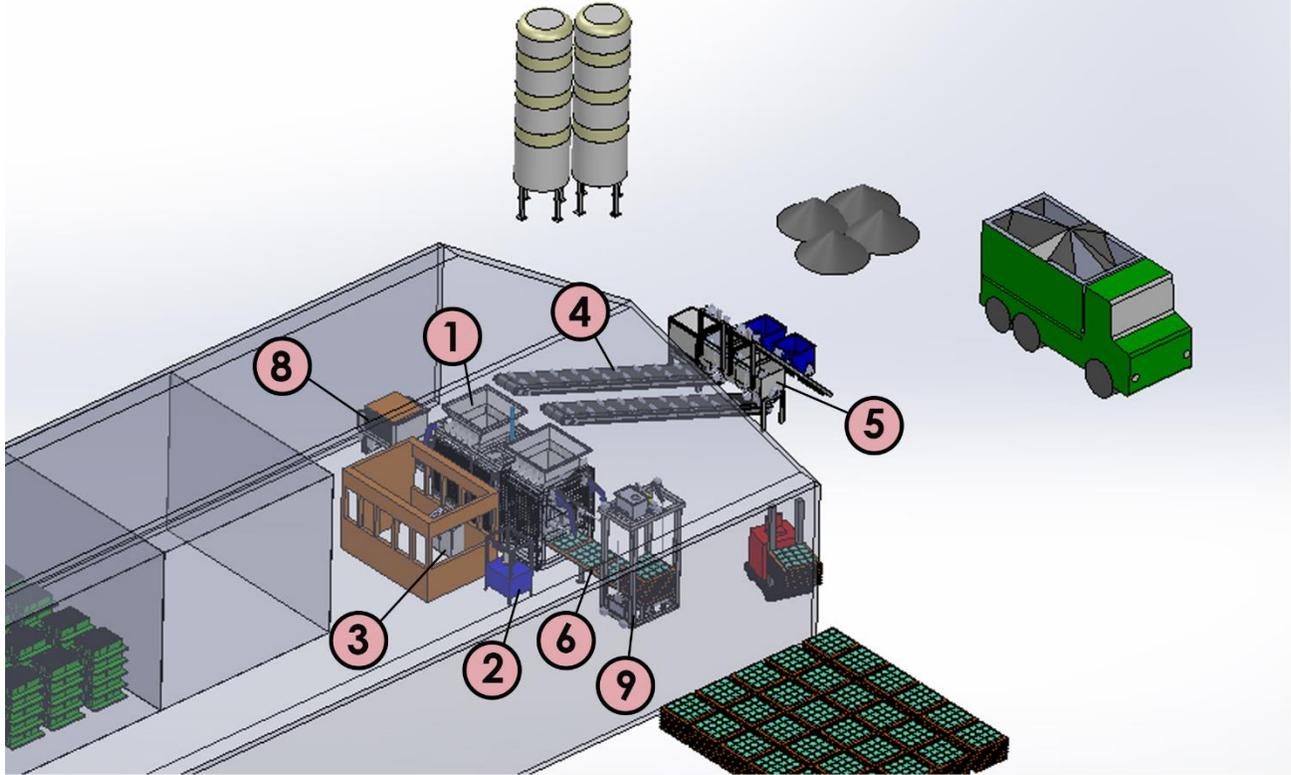


Machine TP.RN -1518 II - Automatic production line

Block-Curbstone-Paver-FlowerBox-Canivo (II-18)S(H.30)(p.s:120*75)

Unit	Description	Page
1	TPRN 1518 (II-18) S (H.30) Pallet Size :120*75	2
2	Machine HYDRAULIC POWER Unit	5
3	Control System	6
4	Quadrated Belt	8
5	Mixer	9
6	Transfer Conveyor	10
7	Mould	11
8	Pallet Carrier	12
9	Lift Robot	13
10	Products	14



1 . Machine TP.RN 1518 II



Automatic Concrete Block Machine TP.RN1518 II Double Packet can produce different kinds of concrete parts (curbstone, block, pavers ,interlocking bricks , flower box). It is presented in two types (single packet and double packet). The production capacity in the single packet system is %10 more than double packet , and the other difference is in the dual-color production capabilities of the double packet system.

The Automatic Concrete Block Machine TP.RN1518 I (single Packet) can produce only one color products and the Automatic Concrete Block Machine TPRN1518 II (double packet) can produce one color and two color products.

The advantage of double hopper is that the downward part of pavers consist of the coarse-grained materials to increase the compressive strength of the flooring and the upper part consist of fine-grained materials because of the beauty of the product.

This machine is automatic.It is also possible to upgrade to full-automatic machine .

Machine 1518 II with 12 ton weight- single layer pallet

1/1: Heavy machine frame was made from special industrial box that can tolerate pressure from jacks and shakes of vibrators.

1/2: Specification of tools that was used in TP.RN model 1518- II :

Vibration's generator: Siemens (Germany)

The piston jack's tube: Bosch or Bohler (Germany or Italy)

The moulds are made of seven different types of sheet, each of which is used in different parts of the mould .The parts exposed to friction are used by Dillidur (Germany) or Hardox (Italy).

The parts exposed to tension are used by ST52 which are resistant to stretching.

Controlling valves: Galtech (Italy)

Hydraulic hose: FLEX or SEL

Electronic automation system: Siemens (Germany)

Jack's shaft: Hard chrome (Italy)

Micro switch and sensors: Telemecanique (French) – Muller (Germany)

The sheets of block and pavers moulds are ST52 or ST60 and the parts exposed to friction is anti-friction.

The frame of machines is made of special Belgium boxes (12 mm) which are designed to withstand the pressure of the jacks with safety coefficient (above 3).

The system is designed and constructed to fit the environment and working conditions in different geographic locations and is fully compatible with different working conditions.

The buffers which are designed to prevent vibration transmission to the frame is Moeller, Neoperan (Germany)

1/3: Production Capacity :

Products	Dimension	Capacity
Paver 16*20* 6 cm	160*200*60 mm	800 M2
interlock 10 *20*6 cm	100*200*60 mm	1000 M2
Curbstone	300*350*150 mm	4000 Pcs
Hollow Block	400*200*200 mm	8000 Pcs

1/4 : Technical Specifications :

Machine function System	Hydraulic -Vibration
Control System	Manual
Generators Power	31 KW
Hydraulic pump generator	20 KW
Pump pressure amount	320 BAR
Oil tank capacity	500 LIT
Packets capacity	1300 LIT
Capacity	165 LIT
Pallet size	120 * 75
Effective size	110 * 65
Minimum height	50 mm
Maximum height	300 mm
Machine dimensions (Meter)	Width 2/30 - high 3/12 - length 8
Weight	12000 KG
Time cycle	15 - 30 sec

2 . Machine HIDRAULIC POWER UNIT



3 . Control System

TP.RN. 1518 II Electrical Control System:



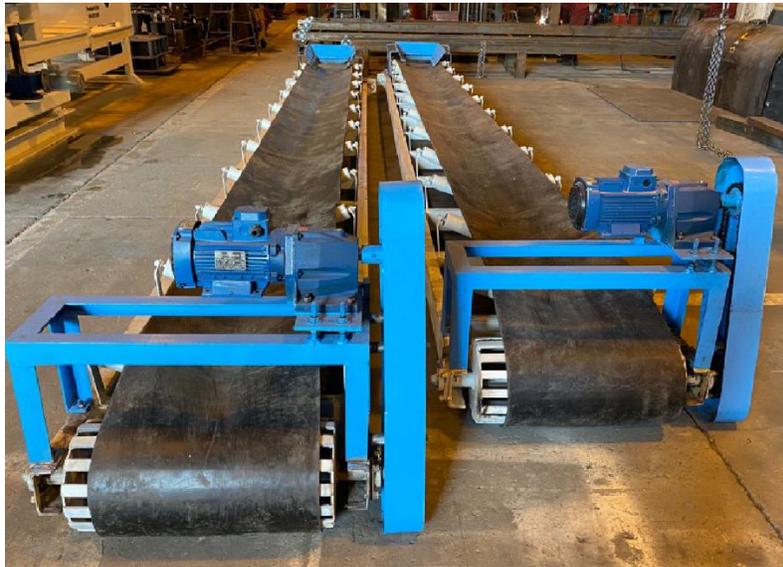
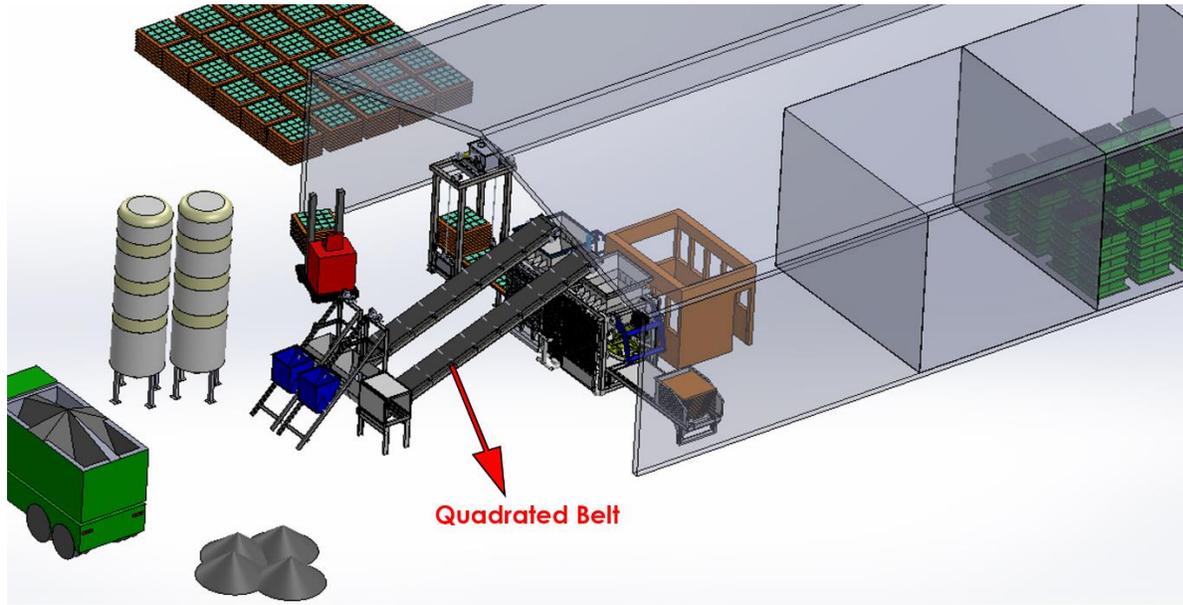
Piece name	Type	Mark / model	Electro motor power	Head banding type	no	utility
Automatic key	100 A	Merlin Grine	-----	-----	1	Total system cut off and connecting
Temperature key	37-50 A	Telemecanique	22 kw	Star Triangle	1	To protect and cut off and connecting hydraulic electro motor
Temperature key	23-32 A	Telemecanique	11 kw	Triangle	1	To protect and cut off and connecting alleviator electro motor robot
Temperature key	6-10 A	Telemecanique	4 kw	Star	2	To protect and cut off and connecting up vibrate electro motor
Temperature key	6-10 A	Telemecanique	4 kw	Star	4	To protect and cut off and connecting down vibrate electro motor
Temperature key	4-6 A	Telemecanique	2/2 kw	Star	2	To protect and cut off and connecting line 1 electro motor feeder
Temperature key	4-6 A	Telemecanique	2/2 kw	Star	2	To protect and cut off and connecting line 2 electro motor feeder
Temperature key	4-6 A	Telemecanique	2/2 kw	Star	1	To protect and cut off and connecting line 2 electro motor
Temperature key	4-6 A	Telemecanique	2/2 kw	Star	1	To protect and cut off and connecting chain band electro motor
Contactora	D 65	Telemecanique	22 kw	Star Triangle	1	To start hydraulic electro motor
Contactora	D 40	Telemecanique	11 kw	Star	1	To start alleviator electro motor robot
contactora	D 18	Telemecanique	4 kw	Star	1	To start up vibrate electro motor
Contactora	D 18	Telemecanique	4 kw	Star	1	To start down vibrate electro motor
Contactora	D 12	Telemecanique	2/2 kw	Star	1	To start line 2 electro motor feeder
Contactora	D 12	Telemecanique	2/2 kw	Star	1	To start line 2 electro motor feeder
Contactora	D 12	Telemecanique	2/2 kw	Star	1	To start line 2 electro motor
Contactora	D 12	Telemecanique	2/2 kw		1	To start chain band electro motor
Digital representation	PM 500	Telemecanique	-----	-----	1	To show all of related parameters

4. Quadrated Belt

It has capability for dry and wet concrete production for curbstone and concrete paver and blocks

Production capacity is 90 m³ in 8 hour

Outer sheet is 10 mm and inner sheet is 10 mm (Sweden Hardox or Divides sheets) Pillars are of non corrosion sheets (ST60)



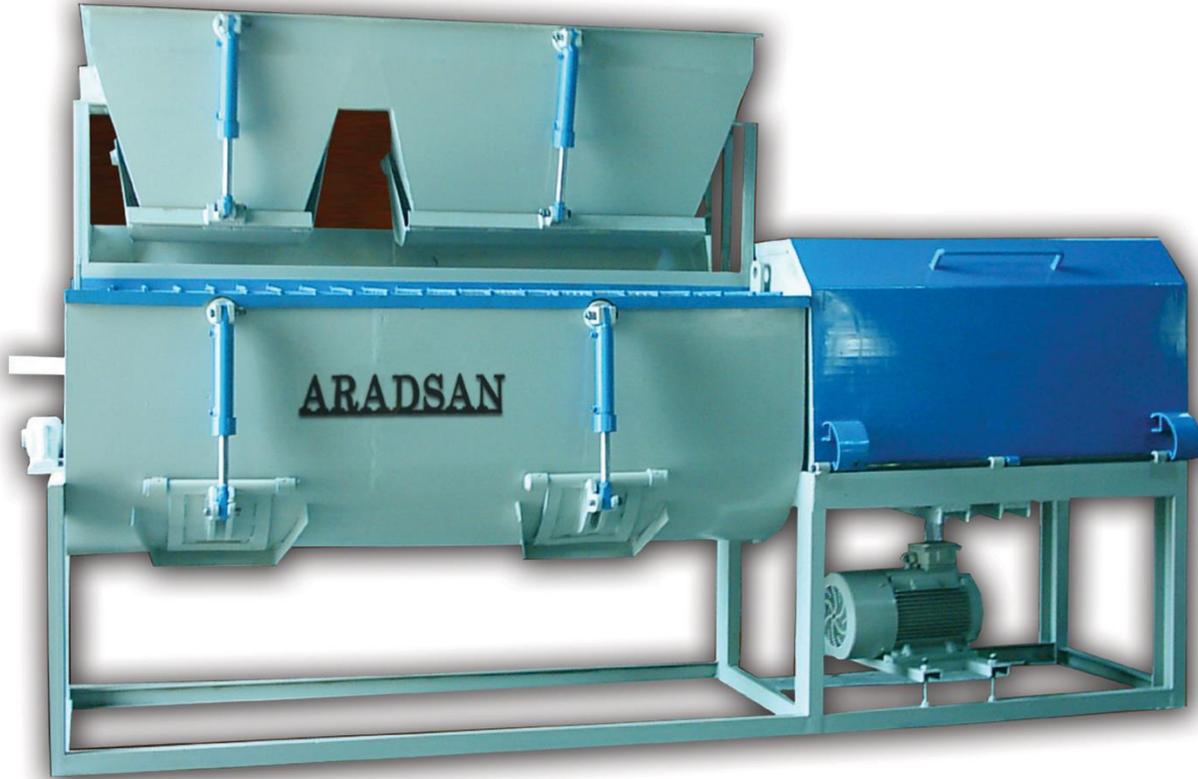
5 . Mixer

It has capability for dry and wet concrete production for curbstone and concrete paver and blocks

Production capacity is 90 m3 in 8 hour

Outer sheet is 10 mm and inner sheet is 10 mm (Sweden Hardox or Divides Sheets)

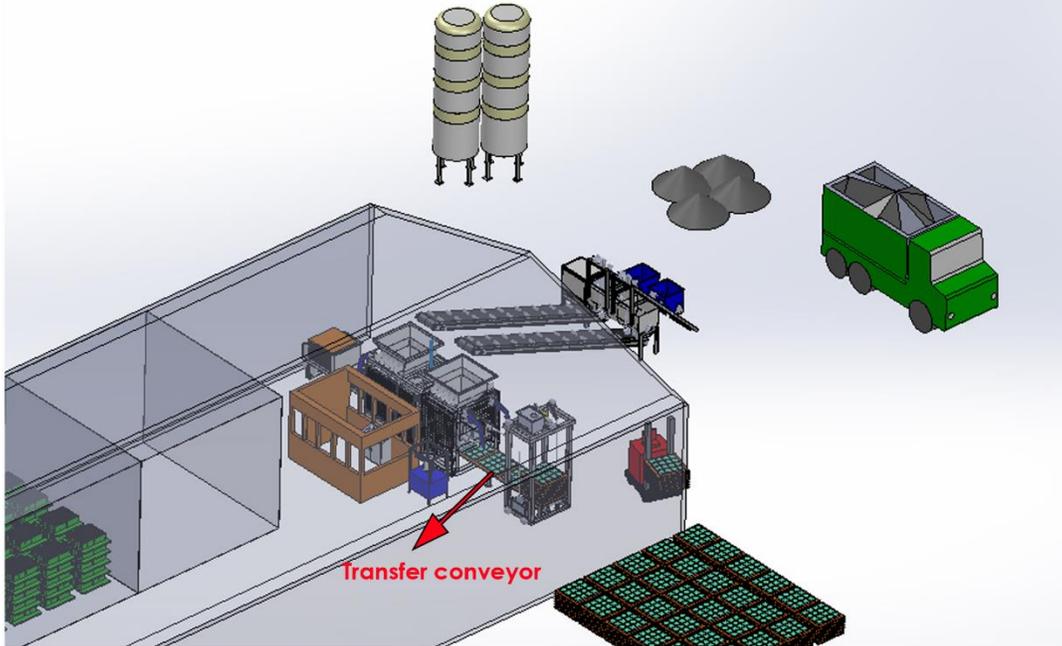
Pillars are of non corrosion sheets (ST52)



6 . Transfer Conveyor

Heavy profile and tube structure, Belt run on height adjustable rollers with bearings. Boards have guides on both sides.

Conveyor :	
Length	10 - 1.5 M
width	60 CM
Generator power	1/5 KW
Chain type	SIZE 60
Machine chassis 14	Belgian
Operation system	Automatic
Power model	Helical
Model	New



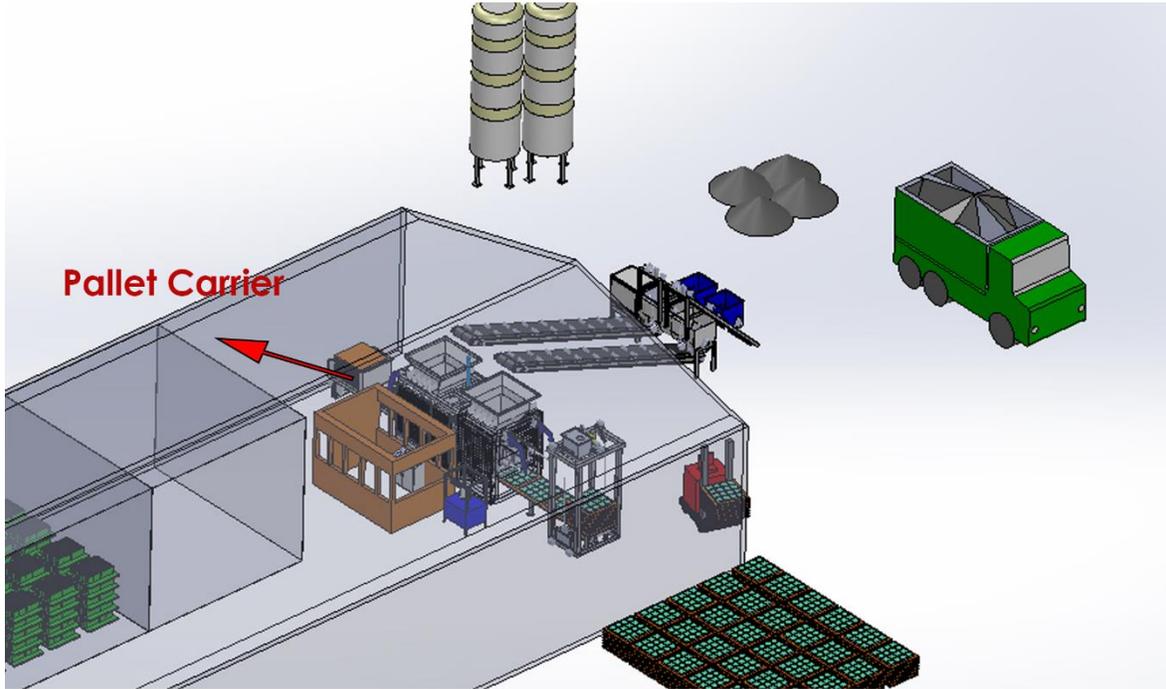
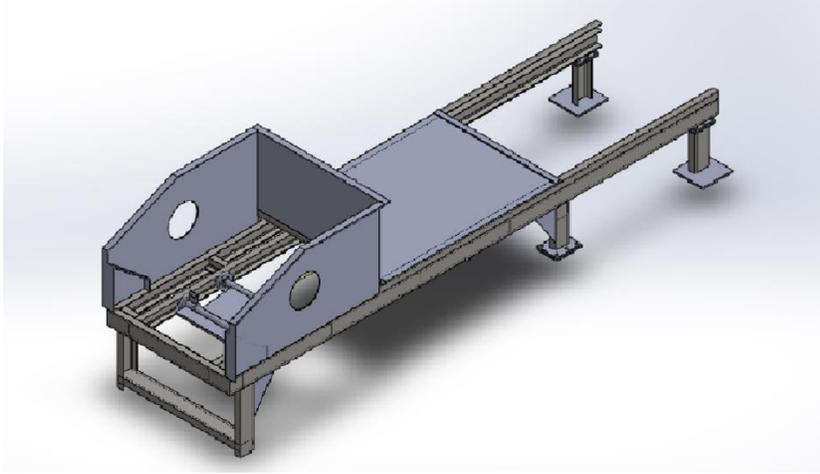
7 . Moulds

One set mould , made at the request of the customer , with ntergrated sheet anti wear with a 7 year warranty .



8. Pallet Carrier

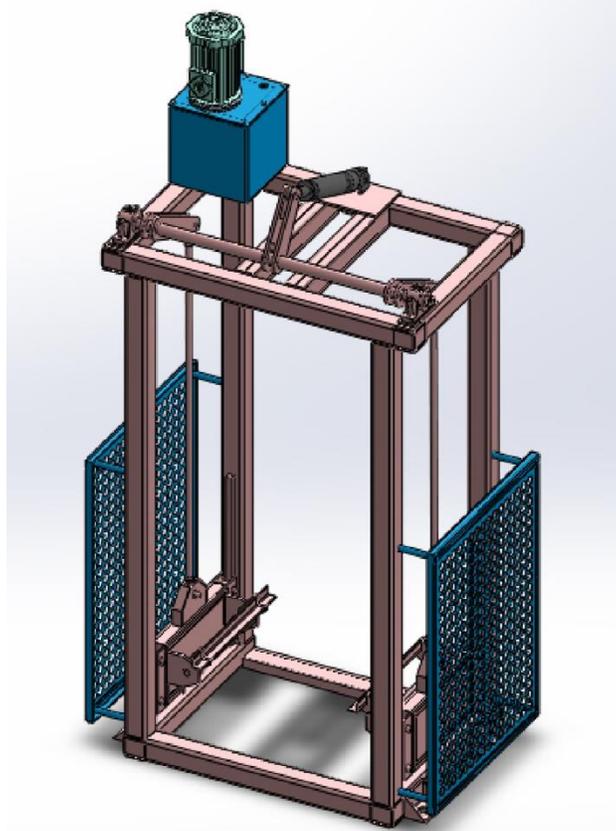
This system after operation of pallets that are suitable with size , dimensions and technical characteristics , guided under the mould through the hydraulic system and finally the manufactured product transferred to the outside on the pallet . In fact this system is defined as pallet rack .



9 . Lift Robot

Robot that collects setting on the pallets to carrier on belt conveyer.

Control system	Full automatic
Hydraulic generator power	10 KW
Axis X dynamic range	50 CM
Pump capacity	37 LIT
Oil tank capacity	60 LIT
Chassis Belgium	14 box
Total capacity of robot	5000 KG
Digital entrance	110 CM



10 . Photo Products

