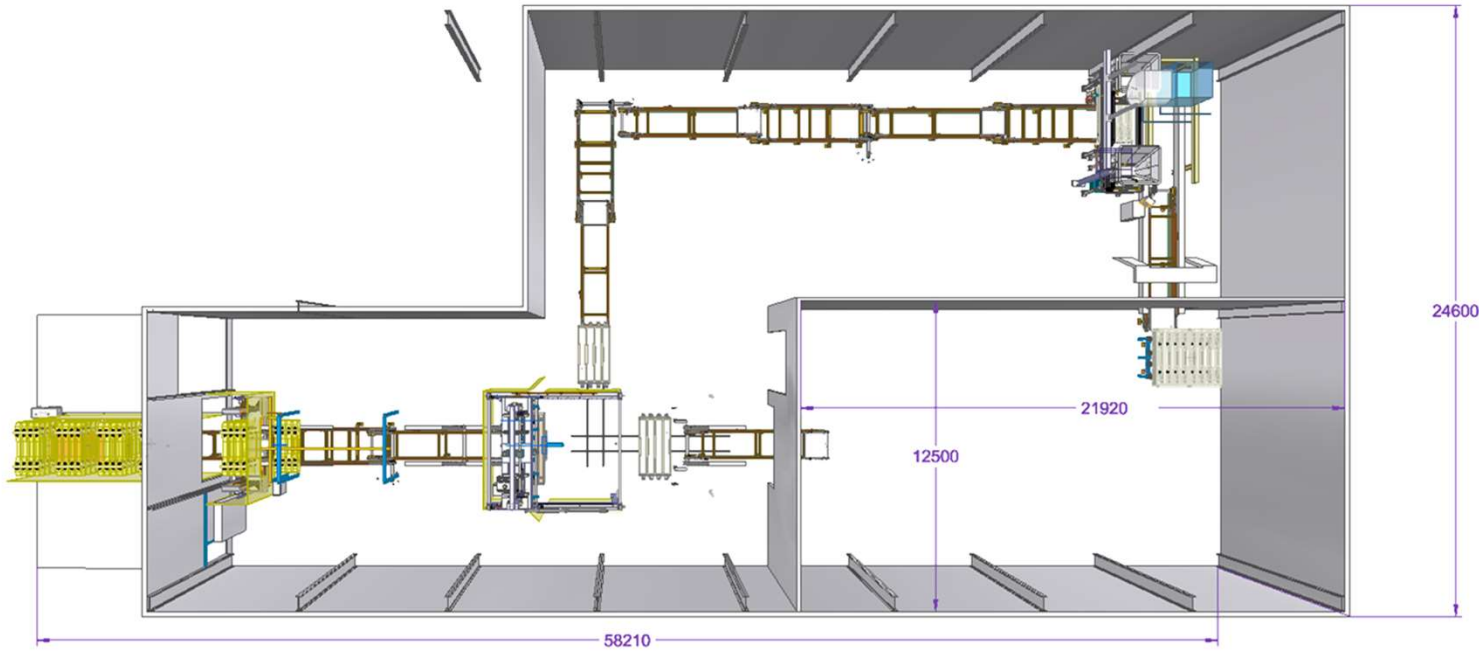


SLEEPERS MANUFACTURING

Process with automatical filling, curing and demoulding



Manufacturing data

- Manufacturing cycle:** 3min30
- Annual productivity: 130 000 sleepers per year (with one shift of 7h00)
- Mold with 4 sleepers
- Number of molds on process and curing room: about 130
- Staff: 5-6 persons

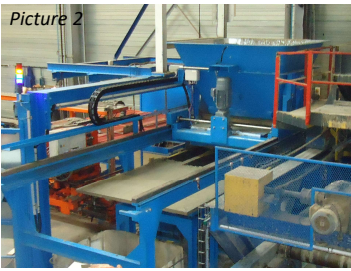


Automatical operations

- Concrete filling - EM-FA machine:** Concrete dispensing drawer with agitators and front and rear scrapers (picture 2). Concrete call to the concrete batching plant automatically and regulated by the level of the hoppers.
- Curing room – Automatical crane:** Using of automatical crane to handling molds (picture 3). Control of curing room with touch-sensitive screen (picture 1) with view of stocks. No regulation of temperature and air in curing room.
- Demoulding:** Handling, rotating and demoulding gantry for molds (picture 4) with checking of products' exit.
- Tensionning:** using of dedicated machine for these operations.
- Transfert and handling:** transfert trolley, chains and rollers conveyors, lifts...

Manual operations

- Preparation of sleepers before exit
- Cleaning of molds before concrete filling
- Exit pack of sleepers with forklift



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