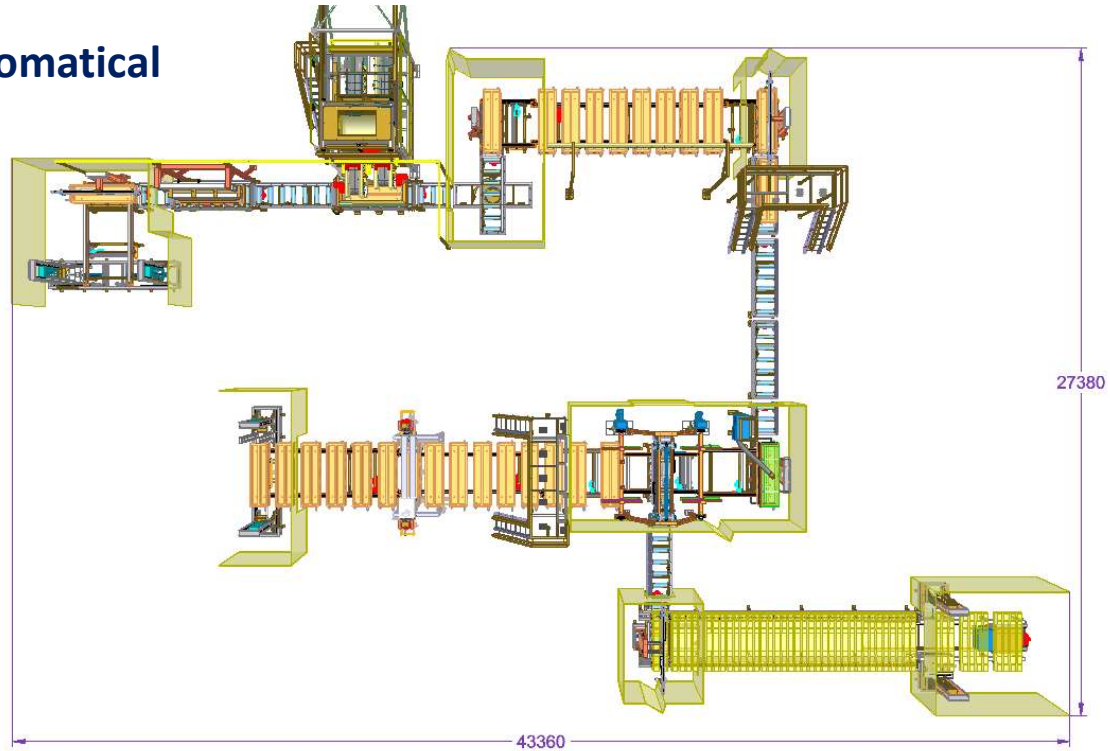


SLEEPERS MANUFACTURING

Process with automatical demoulding



Manufacturing data

Manufacturing cycle: 2min

Annual productivity: 158 000 sleepers per year (1 shift of 7h00)

Mold with 2 sleepers

Number of molds on process and curing room: about 330

Staff: 14 persons

Automatical operations

Demoulding : Handling, rotating and demoulding gantry for molds (picture 2) 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

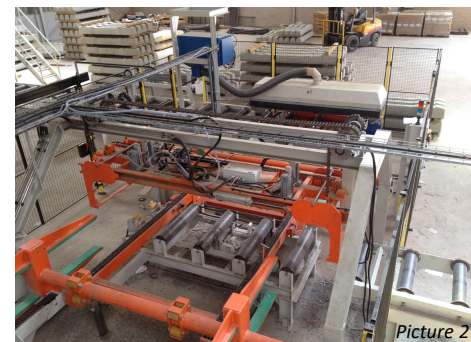
Concrete filling: 2 persons to control and adjust filling concrete on belt conveyors (picture 1).

Transfert in curing room with forklift

Preparation of sleepers before exit

Cleaning of molds before concrete filling

Exit pack of sleepers with forklift



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