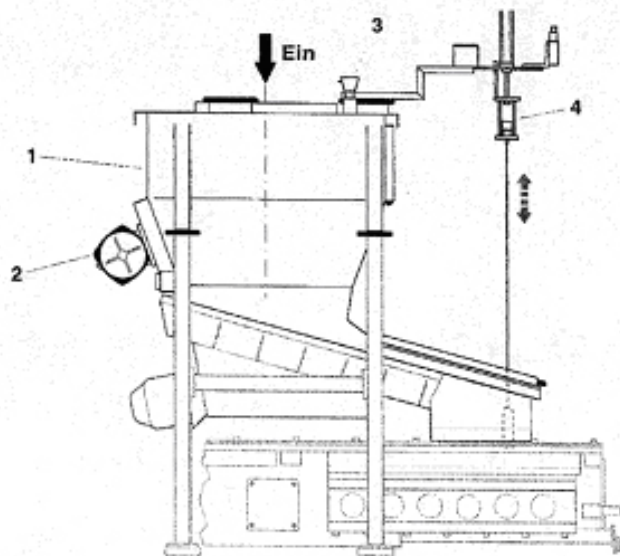


HOPPER- AND DOSING UNIT FOR LIME-SAND MASSES FOR CHARGING PRESSES FOR BRICKS



APPLICATION AND OPERATION:

Up to now the hydraulic presses for lime-sand brick production were charged via belt-conveyors or dosing slides. In order to fulfil the increased quality standards, especially regarding the accuracy of dosing and the reduced labour intensity for cleaning (belt abrasion), the hopper- and dosing unit as shown is in operation at our customer since 1993 instead of using belt-conveyors and dosing slides.

Process description:

The lime-sand masses are transported by means of a belt-conveyor from double shaft mixers into the „mass hopper“ (1). A metal detector, located at the hopper inlet, switches off the material flow of the lime-sand masses when metal is detected. When reaching the maximum hopper level (measured by a level indicator (3)), the electromagnetic feeder is switched on, the lime-sand masses are spread even over the full feeder width and are transported into the feed gates following a preset program. At the jib of the mass hopper another level indicator (4) is arranged, which is lowered down while charging the feed gates, so that no overcharging of the feed gates takes place. After charging the feed gates are driven into the press and the pressing process itself starts.

In order to avoid caking the mass hopper and the electromagnetic feeder are lined with material RCH 1000.

Further on one unbalance motor (2), arranged at the backside of the hopper and which is switched on and off following a preset programme, shall reduce the tendency of caking of the partly moist and warm lime-sand masses to the greatest extent.

TECHNICAL DATA:

Type of machine:	FMF 800 / - 200 x 1.850 FMF 1.000 / - 200 x 2.050, depends on type of press
Product:	lime-sand masses
Feeding capacity:	0,05 m ³ /3 sec up to 0,20 m ³ /6 sec
Bulk density:	approx. 1,8 t/m ³
Moisture:	5 - 6 %
Temperature:	max. + 70 °C

YOUR BENEFIT:

- One compact unit
- Adjustable position of the feeder
- Completely wired on terminal stripe
- Continuously adjustable