

The invention relates to the construction, particularly to the manufacture of building units with relief surface of harsh concrete mix and manufacturing devices thereof.

The process for manufacturing building units with relief surface of harsh concrete mix includes mix charging into the bottomless matrix of the vibropress fitment, the matrix being installed on a tray, at least one of the walls of which is made with relief forming surface, formation of units by concrete mix packing into the matrix by vibrocompression, demolding of the formed unit and removal thereof together with the tray from the vibropress. Novelty consists in that before charging the concrete mix into the matrix, it is installed and fixed the matrix wall with relief forming surface, made demountable. The demolding of the formed unit is carried out by misfixation of the demountable wall, and after unit removal from the vibropress it is separated therefrom the demountable wall.

The vibropress fitment for manufacturing building units with relief surface of harsh concrete mix comprises a bottomless matrix, installed on a tray, and a punch. The boxlike matrix is made with lateral shaping walls joined between them, equipped with elements for matrix fastening on the vibropress, at the same time at least one of the matrix walls has relief forming surface. Novelty consists in that the relief forming wall of the matrix is made demountable. The matrix is additionally equipped with at least one unmoulding wall, placed from the end of the relief surface formation on the mouldable unit and distant from the ends of the adjacent thereto walls. The demountable wall is freely placed between the unmoulding wall and the ends of the adjacent walls. On the unmoulding wall there are fixed supports for rigid fixation of the demountable wall by pressing it to the ends of the adjacent thereto walls of the matrix and forming a closed shaping surface inside the matrix.

Claims: 5

Fig.: 13