

The invention relates to the production of building materials and products, particularly of wall blocks, made of rigid concrete mixes by volumetric vibrocompression, which can be used for the erection of outside walls of residential, industrial, public buildings and other structures.

The process for manufacture of the wall block includes the simultaneous preparation of rigid concrete mixes, ordinary and at least one decorative. Before filling the matrix with these mixes into it, vis-a-vis at least one wall of the matrix, shaping the front surface of the block, is installed a removable partition device, which separates the matrix into cavities, one of which, formed between the matrix wall and removable partition device for the creation of the vertical facade layer, whose outer surface is the front surface of the block, is filled with a decorative mix, and the other cavity of the matrix – with ordinary mix. After filling the matrix with mixes, from it is removed the removable partition device, are precipitated therein the mixes by short-term vibration, then is filled up with a decorative mix, is carried out molding of the block by vibrocompression of mixes into the matrix, the immediate stripping and removal of the block.

The molding equipment of the vibropress for manufacture of the wall block of compact or hollow form of rigid concrete mixes contains a bottomless matrix (11), mounted on a removable tray (12) and a punch (7). The matrix (11) is made box-shaped with rigidly connected to each other shaping walls – two end walls (13) with fasteners (14) of matrix (11) on the vibropress, and two longitudinal walls (15). The matrix (11) of the vibropress molding equipment is additionally equipped with at least one removable partition device (18), which includes a separating element (19) with a flap cover (21) and stops (20), mounted inside the matrix (11) vis-a-vis at least one of its walls, shaping the front surface of the block, with a gap equal to the length of the stop (20).

Claims: 9

Fig.: 12

