

Premoldal Industria e Comercio de Artefatos de Cimento Ltda., 07600-000 São Paulo, Brazil

Concrete pipe manufacturer Premoldal in Brazil invests in new production plants

There is a constantly increasing demand in Brazil for the production of concrete jacking pipes. For this reason Premoldal Industria e Comercio de Artefatos de Cimento specialises in this product range and focuses on high quality for maximum customer satisfaction. For that reason Premoldal recently invested in a new production line. The scope of this modernisation mainly includes a BSM-250-R wire cage welding machine from MBK, a Jumbo 2030 Duo concrete pipe machine from BFS and a concrete mixer of the type THZ 2250 from Teka. All three companies supplied Premoldal with a plant solution that guarantees the company high capacities together with very high product quality.

The Premoldal pipe-making works were newly built in 2011 near Sao Paulo. The founder of the company, Paulo Sergio Stanzani, is well aware that only very high product qualities, fast deliveries and high customer satisfaction can secure orders on a long-term basis. Premoldal was able to impress the market with its products and quickly became one of the leading suppliers of concrete jacking

pipes on the Brazilian market. Hence, the company already supplies its jacking pipes over long distances to its customers today.

The pipe-making machine from BFS – the Jumbo 2030 Duo, which went into service in 2011 at Premoldal, is generally suitable for concrete pipes with diameters from 250 mm to 2,000 mm and lengths of up to 3,000 mm. The required reinforcement is produced with the MBK BSM-250-R wire cage welding machine. The BSM-250-R produces wire cages in diameters ranging from 220 mm to 2,500 mm with up to 24 longitudinal wires. Since jacking pipes require strengthened reinforcement with two reinforcing cages, a smaller cage and a larger cage are manufactured in succession on the MBK BSM-250-R. This is controlled simply via the machine operation at the push of a button. The hydraulic high-speed chain adjustment system enables an immediate changeover.

Teka supplied the high-performance compulsory mixer of the type THZ 2250 with an output of 1.5 m³ per batch. The mixer was installed fast and without problems and was immediately ready for operation. Premoldal will shortly receive a second THZ 2250 mixer, which will be equipped with a feeding elevator. That will further simplify and accelerate the mixing process

MBK BSM-250-R wire cage welding machine

Round and straight cages or cages with a spigot end and socket can be manufactured on the BSM wire cage machine. The cages are programmed on the touch panel and the cage program can thus be retrieved immediately. The machine is fed by the operator with pre-cut longitudinal wires (diameter from 4 - 10 mm), while the winding wire (diameter from 4 - 12 mm) is automatically fed to the machine off the coil. This allows the customer a high flexibility with changing wire sizes during production. The cage can be manufactured with 6, 12 or 24 longitudinal wires, depending on the cage size. The pitch of the winding wire can be set simply via the cage program and varies between 30 and 160 mm. The production output of the machine can be increased further with the additional speed package. Premoldal can thus also produce a larger number of pipes without any problem.

The high number of wire cages produced, the reliability of the MBK machine and the accuracy of the spot-welds convinced Premoldal from the outset.

BFS JUMBO 2030 Duo pipe-making machine

The Jumbo product range consists of flexible production machines for a large number of concrete products for underground construction, such as pipes, jacking pipes, lined pipes, rectangular pipes, manholes and cones. The Jumbo machines likewise consist of dif-



MBK BSM-250-R wire cage welding machine



The BSM-250-R welds a wire cage



Jumbo 2030 Duo concrete pipe-making machine



View of the pipe production

ferent models. A special, individual machine concept is offered on the basis of the customer's wishes and the end product. Depending on equipment, sewer components with diameters from DN 250 mm to DN 4,000 mm and overall lengths of up to 4,000 mm can be manufactured. The maximum dimensions for box culverts are 3,000 mm x 3,000 mm. The Jumbo is universally usable, depending on the version, and reinforced or unreinforced pipes can be manufactured according to international standards. The concrete is compacted by the multi-stage central vibrator, which is supplied with frequency control. The Jumbo Duo enables changing production cycles for two different products or product dimensions, whereby a considerable increase in daily production output is ensured. In addition, the Jumbo has quick-change moulds for short retooling times.

Teka THZ 2250 mixer

One of the technical requirements demanded by Premoldal was the self-cleaning of the mixer after each mixing cycle – one of Teka's standard features. The mixing tools cover the entire mixing chamber with just a single revolution of the rotor; i.e. there are no unreachable areas in the mixing trough. Furthermore, standard equipment



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Teka THZ 2250 high-performance compulsory mixer

includes a hydraulic hand pump that ensures that the mixer can be emptied in the event of a power failure. The mixer was supplied through the Tekbra company, a subsidiary of Teka Maschinenbau GmbH from Germany. Tekbra supplies spare parts and offers service throughout Brazil.



Premoldal Industria e Comercio de Artefatos de Cimento Ltda pipe-making works

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