

Bulk sand used both in coatings and for sandblasting is stored in a silo. It can be transported on demand to either the blending area (for coatings) or to the texturing area (for sandblasting). For some products, the column is sandblasted before the wet coating is applied while for others it is sandblasted after the wet coating is applied. The sandblasting is very effective for muting the colors of the coating. All wet coatings are mixed by hand at this time.

After texturing, the column is cut into slugs which go to one of the two cutter banks on the Ceric setter. These cutter banks are the "push up" type. In the cutter banks, pavers go through a set of rollers both horizontally and vertically so that all edges have a slight (3/32") radius. Slugs can also be routed to a special shapes belt that is incorporated in the setter. This belt allows the machine to cut brick for shapes and to automatically convey them to a discharge point for palletizing.

Brick can either be stacked or faced before they are conveyed to the transfer head. This transfer head only moves the brick. It does not spread or separate the units. The two Fanuc M410iWW robots do the spacing and create the patterns since they are much more accurate. The kiln cars are 21' wide (24 brick wide) and 13', 3" long (12 brick long). They hold 8,640 modular units arranged in a 5 over 2 setting (12 high). There are 72 packs on each car.

Drying and Firing

Loaded cars are transferred from the setter to the holding room. The alignment and height of the load and the alignment of the car block are automatically checked as the car leaves the transfer and passes through the door. The holding room is 22 cars long and has a system for heating and humidity control. No more than 1% drying takes place in this area. The brick dry very easily so the holding room is used to slow down or minimize the drying rate.



Automatic Blending System for Dry Coatings



Texturing and Coating Application Equipment



Compact Setting Area