

KVM International A/S, 8620 Kjellerup, Denmark

# New production plant for IBF Århus in Denmark

The large Danish producer of concrete products IBF decided to build a new factory for production of concrete products in Aarhus, the second largest city in Denmark. IBF was already the owner of "Aarhus Betonvarefabrik" situated in Lystrup a suburb of Aarhus. Here they had a suitable site and some existing buildings which could be rebuilt to accommodate the new plant.



IBF's new plant in Århus

The contract for the total supply of the machines for the plant was given to KVM, who are a long-standing business partner with IBF having delivered many plants to IBF over many years.

The design of the plant has taken place in close co-operation with two very experienced operators from another IBF Plant. These two persons are to be operators of

the plant and many small details have been adjusted, during the installation period, so the optimum function can be achieved and at the same optimizing ergonomics and working environment.

The Aggregate to the concrete mixers are supplied via belt conveyors and intermediate hoppers from a row of Bunkers. The three cement silos are of special construction,

IBF have used stacked concrete pipes, with a diameter of 3 m, also produced by IBF. Each concrete silo is equipped with a steel cone with outlet to the cement screws.

To ensure a very high surface quality of the products it was required, that this plant should be supplied with a face-mix mixer with a wibler – ensuring very homogeneous and not lumping concrete for the top layer of the products. This is very important, as just one single spot of unmixed cement on a slab means it is rejected.

The plant is equipped with two mixers, a 1500 l planetary mixer for the main mix and a 500 l planetary mixer with wibler, for the face mix.

Under each mixer there are 3 hoppers with matching dosing belts, which make the plant able to produce multi coloured products, on single and two layer concrete. The individual colour combinations can easily be reproduced, as the dosing of the



1500l planetary mixer for main mix



Concrete dosing from 3 hoppers

# KVM International



## A local and global partner



*Wet line with quality control*

coloured concrete is controlled by the batching computer via recipes. Finally the concrete is transported to the block machine by wide transport conveyors.

The block machine is a KVM type 62/105 DF with a pallet size of 1200 x 750 mm thus producing 0.6 m<sup>2</sup> paving stones per cycle. The machine has a vibrator with variable frequency and amplitude, so the vibration can be controlled dependent on the products.

From the machine the products are transported to the elevator via roller conveyors and can be quality controlled offline by a control unit, allowing the operator to inspect the product while still operating the plant.

The curing takes place in a typical rack storage plant, operated by a KVM turning finger car, which, due to the very low floor-to-ceiling height in the building has only 12 shelves. The racks are situated in both the old building and a new building, constructed as an extension.

After curing, the products are transported on a roller conveyor out to the KVM cuber which is able to receive products from 2 or 3 pallets at a time, to make the optimum transport pallet pack for sale.



*Racking system with finger car*



**United Arab Emirates**



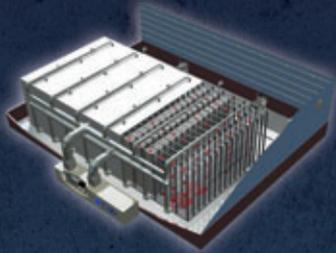
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Cubing line with control system

The transport pallets are transported via a stretch hood wrapper out onto a rubber belt conveyor for collection by a fork lift truck.

After cubing, the empty Wasa Ultraplast pallets are transported to a pallet brush, where they are cleaned and then turned upside down and stacked in a stacker. The pallets are stacked from the bottom so that dust development from stacking from the top is avoided. The finished pallet stack is transported by a transport wagon back to the block machine pallet magazine.

The whole plant is controlled from one central control panel, where the KVM control handles all units in the plant in one overall control unit, where the operator has an excellent survey over the whole process from one screen and can operate the mixer recipes as well as the cuber setting. This integration between the individual plant units is highly appreciated by the operator, operating with the same program and the same operating interface.

The plant is supplied with a very effective sound proof cabin supplied by IBF themselves. The cabin has large windows, giving the operator a fine survey over the machine functions. At the same time good access is achieved, making cleaning very easy.

"The plant has fulfilled our expectations and produces really fine products, and the face-mix mixer with wibler means that our

problems with lumps in the concrete have been reduced considerably, which we are very satisfied with" says the production manager Mogens Rosenkilde, from IBF.

### FURTHER INFORMATION



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