

## Methods of Productions

Written by Administrator

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The Manufacturing of RCC Hume Pipes involves a series of steps to be followed in a sequential manner as mentioned below: -

Storage of Raw Material	Preparing of reinforcement Cage
Assembling of Moulds	Mixing of Concrete
Spinning of Moulds	Demoulding
Curing	Staking of Finished Pipes
Random test of Pipes	Dispatch

### **Storage of Materials**

We have adequate storage facility for Raw Material like Cement, Sand, Chips etc.

### **Assembling of Moulds**

The reinforcement cage is then inserted into a mould, then this half rounds of moulds is then tightened on both sides of the M.S. Rings. the prepared mould is placed to runners made from Railway Wheels.

### **Preparing Reinforcement Cage**

Next Step is preparing Reinforcement cage of appropriate size after providing minimum clear cover & spacing, the steel reinforcement of IS2062 Grade I, mild Steel are made in to longitudinal and spiral of 6mm.

### **Mixing of Concrete**

The concrete of M20 or M35 Grade is mixed in mechanical mixtures as per IS456. The Cement, aggregate, water & reinforcement as of required volume according to mix design are put in a Mechanical Mixture Machine. The Water Cement ratio is maintained at 0.45 with the help of water dozer.

### **Spinning of Moulds**

The Wound cages are placed in position inside the pipes moulds with suitable cover and place over the moulding machine. The mould is then rotated on runners and the concrete is put into the mould from both open ends. The mould is spun with rears gear machine till the pipes gets set.

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### **Demoulding**

The casted mould is demoulded from moulding machine and allowed to set for 24hours till the concrete hardens.

### **Curing**

After 24hours of initial setting, the concrete pipes are removed from the moulds and immersed in curing tank for a minimum period of 7 days for non-pressure pipes.

### **Stacking of Finished Pipes**

The Cured Pipes are then taken out of the curing tank with help of Hydraulic Crance and stacked properly at stock yard.

### **Random Tests Pipes**