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F. J. STRAUB

METHOD OF MOLDING BUILDING BLOCKS

Filed Nov. 16, 1926

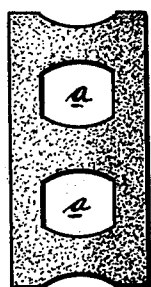


Fig. 1.

Fig. 3.

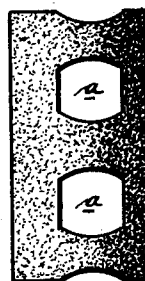
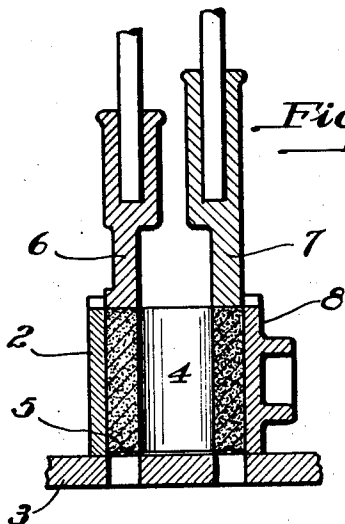


Fig. 2.

Fig. 4.

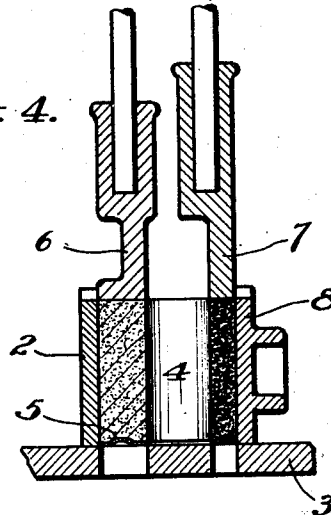
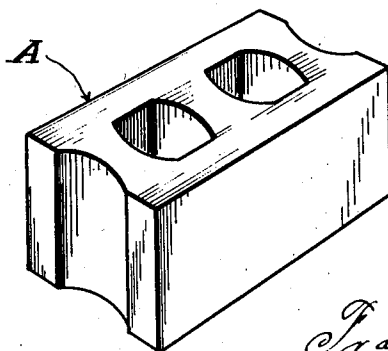


Fig. 5.



WITNESSES
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METHOD OF MOLDING BUILDING BLOCKS.

Application filed November 16, 1926. Serial No. 148,676.

My invention relates to an improvement in building blocks, and more particularly of the kind known as concrete blocks.

The object in view is to provide a block in which the wall surface at one side is denser or more compact than the other, so that such dense wall will have a more compact consistency, improved appearance, and may be exposed to the weather for resistance and durability. The other side, being less dense and more porous, will retain the desirable characteristics of a porous wall.

The invention is particularly useful and valuable where the material or aggregate used is sufficiently light and porous to admit of the application directly upon it of plaster or stucco, or the application of wooden trim etc., by nailing, as may be done in the well known cinder block construction.

The block of the present invention is capable of manufacture on a machine equipped with a double row of tamps, one row tamping the material or aggregate in the mold at the front of the cores, the other tamps working at the back thereof. The tamps are also preferably varied in weight to effect variation in the tamped density, and when desired the density of the wall portion formed by the heavier tamps may be further improved by the use of a vibrating plate or wall like that shown in my co-pending application, Serial No. 148,674 filed Nov. 16, 1926.

Referring to the drawings illustrating one preferred method of carrying out my invention—

Fig. 1 shows in plan view a characteristic form of building block, indicating the relative density at front and back respectively;

Fig. 2 is a vertical sectional view showing the mold of a molding machine and its tamps adapted to produce said block;

Fig. 3 is a view similar to Fig. 1, showing a modified construction with a thinner front wall;

Fig. 4 is a view similar to Fig. 2, showing the mold and its tamps for producing such block;

Fig. 5 is a perspective view of the building block of Fig. 1.

Referring to the drawings, 2 is the usual mold of a standard block press mounted upon

the supporting plate 3, having the cores 4 for formation of the usual core openings *a* of the block, as shown in Fig. 1.

The material for the block A is filled into the molding space in the usual way, a pallet 5 having been first inserted for removal of the finished block, and the block is tamped within the walls and around the cores by a plurality of tamps 6 and 7 of well known construction.

For the purpose of effecting the densifying action, tamps 7 are materially heavier than tamps 6, so that, as they fall in the tamping operation, they will crowd the material at that side of the mold closer together, during the time the lighter tamps 6 are doing the same work at the other side.

In order to bring the final tamped body portion of the block up to a final common level the aggregate is supplied in a proportionately increased amount at the denser side before or during the tamping operation. Such operation continues until the mold is completely filled and tamped up to the desired level, after which any surplus material is removed by shifting it laterally across the top of the mold in the usual way.

For the purpose of imparting a smooth finished surface to the denser face of the block, one of the side walls of the mold 2 may be in the form of a longitudinally vibrating plate 8.

Such vibration or alternating movement of the plate will tend to "trowel" such face, giving it a substantially smooth finished surface, in the manner more fully described in the said co-pending application.

The block may be of any desired dimensions, and the proportions of the walls may be made to suit the conditions of use, or other variations may be adopted, within the scope of the invention, as hereinafter claimed.

Having described my invention, what I claim is:

1. The process of making a concrete block of a dense consistency at one side consisting in applying relatively heavy and light tamping to opposite sides of the entire block while in the mold.

2. The process of making a concrete block of a dense consistency at one side consisting in simultaneously filling and tamping con-

crete aggregate of normally uniform consistency in a mold with a relatively greater amount of condensation at one side.

3. The process of making a concrete block
5 of a dense consistency at one side consisting in simultaneously filling and tamping concrete aggregate of normally uniform con-

sistency in a mold with a relatively greater amount of condensation and a relatively thinner wall at one side.

In testimony whereof I hereunto affix my signature.

FRANCIS J. STRAUB.