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## Complete production plant starts operation in Poland

In the summer of 2007 ZPB Kaczmarek put into operation a facility for the production of the complete range of manhole components in the Polish city Prusice which is close to Breslau. In addition to the production of manhole risers and tapers, custom-made monolithic manhole bases are manufactured with the production system „Perfect“ without the use of secondary labour or material to form the channel. This monolithic execution as well as the use of self-compacting concrete enables ZPB Kaczmarek to establish a complete new level of quality on the Polish market.

Already short time after the commissioning of the complete plant the company was assigned for its innovation with a gold medal at the 13th International Fair for Road Construction in Kielce. “The company ZPB Kaczmarek has always been a supplier of high-quality products throughout its long history. “We do not accept half solutions and when investing in a new plant we chose the latest technology which guarantees highest quality standards in nationwide comparison” says the owner Mr. Krzysztof Kaczmarek.

Before they have decided to make this investment the decision makers of ZPB Kaczmarek have inspected worldwide more than 10 production facilities. One inspection after the other they were more and more encouraged in their opinion that the system Perfect offered by Schlüsselbauer Technology was the only real industrial solution on the market which would exceed all other processes. To customize the manhole base production by a computer controlled prefabrication of the negative moulds convinced ZPB Kaczmarek as well as the monolithic quality that can be achieved with this method, which means stable quality of concrete no matter if wall or bottom or moulded channel. A significant criterion was also the availability of the custom-made manhole bases within less than 24 hours.

In addition to the production system on which manhole bases from a diameter of 1000 mm and a wall thickness of 150 mm up to a diameter of 1200 mm and a wall thickness of 230 can be produced, ZPB Kaczmarek places emphasis on highest quality also with their other manhole components. As the first and only company in Poland ZPB Kaczmarek produces manhole risers in the dimensions 1000 and 1200 mm by using the Exact top pallet system. By using top pallets which remain on the products during their curing process the spigot ends are dimensionally precise and parallel. The maximum tolerance for the required fitting accuracy at ZPB Kaczmarek is 0,5



*The brand-new facility of ZPB Kaczmarek at Prusice – in the front the out feed conveyor of the manufacturing system „Perfect“*



*Monolithic and custom-made – the channel always exactly corresponds to the requirements of the project.*



*The Exact 1500 in operation – fully automatic production of manhole risers with top and bottom pallets*

*The labelling of each custom-made manhole base supports the whole logistic – also the installation on site.*

mm. Thus damage to the gasket or concrete, which so far appeared from time to time and led to leaky or rejected manhole constructions, is avoided. Enormous costs

for repairing or the subsequent exchange of the whole manhole construction can therefore be avoided in the future.

„The road construction is a field where no mistakes are allowed. The least mistake can have severe consequences. The increasing construction requirements obviously lead to higher expenses for the investors for a short term. The customers more and more realize that savings in material are risky and that the purchase of cheap products finally leads to higher costs“ says Krzysztof Kacz-



*Manhole riser – manufactured with bottom and top pallet – for highest precision and stability in the entire manhole construction*



*Efficient and safe product handling by Transexact*

marek who is convinced of his long-term strategy focusing on high quality products.

The new level of quality with the manhole components also influenced the transportation fleet at ZPB Kaczmarek and led to fundamental improvements in loading and unloading technology. In order to serve the customers with products which also maintain their quality when being transported investments in modern trucks with special lifting and gripping systems have been made. The products are precisely unloaded

and in case of a Perfect manhole base the installers can read all data which is necessary for the installation on the construction site directly from the label of the manhole base.

The production plant Exact 1500 installed at ZPB Kaczmarek manufactures manhole components from Ø 800 up to Ø 1500 in single production. The building height of the products ranges from 250 mm up to 1200 mm. The change-over for different product types is made by a quick mould change system in the briefest changeover

time. If step elements are integrated into the manhole riser, they can easily be passed to the core by an automatic manipulator. The user-friendly equipment, called Stepmaster, enables an insertion of the step elements independent from the cycle times. ZPB Kaczmarek requested a fully automated solution. The automation is executed with the TRANSEXACT robot crane which handles fresh and cured product and also manages the curing chamber tops. Further automation includes automated removal of top and bottom pallets, automated cleaning

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Also the car and truck pool was started up – appropriate to the state-of-the-art production

and oiling of all pallets, pallet management, and product conveying. After the curing process of the manhole risers and tapers they are finally – again fully automatic – labelled.

Mr. Krzysztof Kaczmarek concisely summarizes the expectations into this investment in one sentence: „The use of high-tech equipment enables us to achieve highest satisfaction with the customers regarding the delivered products and therefore to achieve that our customers become long-term partners of ours.”

FURTHER INFORMATION



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