PipePlus

PipePlusPlus • PipePlus180 • PipePlus200 • PipePlus96

Hawkeye Pedershaab
Concrete Technologies Worldwide

• High production output • Quick form changeover
• Telescopes production cycle • Appropriate technology

PipePlus

Rotary three-station turntable delivers versatility and high output

The PipePlus machine series delivers versatility and high output in a simple, dependable, easy to operate machine. With available Multiform modules, the PipePlus can pump out pipe in numbers that rival much more costly machines. Also, with its production flexibility and ten minute form changeovers, it allows producers to schedule in special orders, and keeps yard inventories low. Its flexibility allows producers to manufacture a full range of pipe products including arch, round, elliptical, and jacking pipe, as well as all manhole products and catch basins. The PipePlus is great for start-up and experienced companies alike and offers producers tremendous opportunities.

System Benefits

Telescopes Production Cycle. The three PipePlus manufacturing steps – fill, pressheading, and stripping are performed simultaneously to telescope the production cycle for increased output.

Appropriate Technology. The PipePlus series of pipe machines is totally reliable. The automation is appropriate for the industry and the machines are easy to use and maintain. Standard off the shelf components are used whenever possible. PipePlus is technology for real world producers.

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Ten Minute Form Changeovers. To further enhance the flexibility of the PipePlus, form changeover is quick and easy allowing forms to be switched in as little as ten minutes.

High Output. Output starts with the rotary three station turntable design concept. Depending on machine model and product diameter, the PipePlus can produce up to 103 pipe-per-hour with exclusive Multiform modules.

Production Flexibility and Versatility. The PipePlus rotary turntable allows three different pipe sizes and shapes to be run at the same time. The PipePlus also allows the production of arch, round, elliptical, and jacking pipe, as well as a full range of manhole products and catch basins.

Capacity

Depending on the machine model, a typical PipePlus plant offers an annual production capacity of 60,000 to 70,000 tons of product in a one-shift operation. For production rates, see chart on back page.

Operation

The concrete distributor chute on the PipePlus automatically adjusts to the form size in the fill station, and concrete is fed into the form. Feed rates and vibration settings are stored in the programmable logic controller (PLC) for each product type. After the tongue former is placed in the filled form set, the pressheading cycle automatically commences. The presshead presses the tongue former to form the spigot, trowels the joint surface, and returns to the home position for the next pipe. Pipe are offborne from the machine with an automatic or conventional overhead crane.

Manual control is also available if machine is not equipped with a PLC.

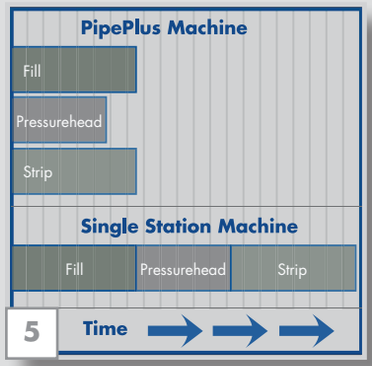
Standard Features

- Three station rotary turntable with built - in operator's platform
- Concrete feed system with adjustable distributor
- Presshead system with built-in header infeed jib
- Quick form changeover components

Optional Features

The PipePlus can be equipped with the following additional features:

- Automatic adjusting feeder chute
- Available PLC control system
- Hydraulic distribution system
- Table mounted form rotator
- Automatic pallet/cage feeder
- Variable vibration frequency control
- Remote lubrication kit
- Hopper load sensors for automatic batching



1. Multiform Modules
Multiform modules are used to increase production output of up to 1200 mm (48") diameter pipe.

2. Production Flexibility
The PipePlus machine manufactures a full range of products, including round, arch, elliptical and jacking pipe. The PipePlus can also produce a full range of manhole products including catch basins.

3. Quick Form Changeover
Just two pins are pulled to change forms. The form is removed and a new form is immediately put into place.

4. High Output
The PipePlus three station rotary turntable telescopes production motions to increase output and permits three different products up to 1800mm (72") or 2400mm (96") diameter to be manufactured at one time.

5. Telescopes Production Cycle
The PipePlus telescopes the three manufacturing steps; fill, pressheading, and stripping into one cycle to increase production output and save time over a conventional single station machine.

6. Form Filling
Concrete is directly fed into the wall of the form set at a predetermined rate to ensure proper consolidation. When equipped with a PLC, vibration and filling is automatic.

7. Pressheading
Products are pressheaded with joint formers pressed into the filled mold to form the product's spigot. When the machine is equipped with a PLC, pressheading is automatic.

Pipe Sizes		PipePlusPlus		PipePlus200		PipePlus180		PipePlus96	
Diameter		Pipe/Hour*	Max./Module	Pipe/Hour*	Max./Module	Pipe/Hour*	Max./Module	Pipe/Hour*	Max./Module
mm	inch								
300	12	68	QuadForm	68	QuadForm	68	QuadForm	103	EightPak
375	15	68	QuadForm	68	QuadForm	68	QuadForm	103	EightPak
450	18	68	QuadForm	68	QuadForm	68	QuadForm	103	EightPak
525	21	34	DuoForm	34	DuoForm	34	DuoForm	77	SixPak
600	24	34	DuoForm	34	DuoForm	34	DuoForm	77	SixPak
675	27	30	DuoForm	30	DuoForm	17	SingleForm	51	QuadForm
750	30	30	DuoForm	30	DuoForm	17	SingleForm	51	QuadForm
825	33	16	SingleForm	16	SingleForm	16	SingleForm	39	TriForm
900	36	16	SingleForm	16	SingleForm	16	SingleForm	39	TriForm
1050	42	15	SingleForm	16	SingleForm	15	SingleForm	26	DuoForm
1200	48	13	SingleForm	13	SingleForm	13	SingleForm	23	DuoForm
1350	54	12	SingleForm	12	SingleForm	12	SingleForm	12	SingleForm
1500	60	10	SingleForm	10	SingleForm	10	SingleForm	10	SingleForm
1650	66	9	SingleForm	9	SingleForm	9	SingleForm	9	SingleForm
1800	72	9	SingleForm	9	SingleForm	9	SingleForm	9	SingleForm
2000	78	x	x	8	SingleForm	x	x	9	SingleForm
2150	84	x	x	x	x	x	x	8	SingleForm
2400	96	x	x	x	x	x	x	7	SingleForm

** For comparative purposes only - effective production rate if an individual pipe size is simultaneously run in each of the three machine production stations.*

Production rates are based on the manufacture of ASTM C76(M) B-Wall x 2.5M (8') concrete pipe. Rates are based on running at 100% efficiency and using the maximum available Multiform module for the machine model. Production rates may vary for specific applications and plants.

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