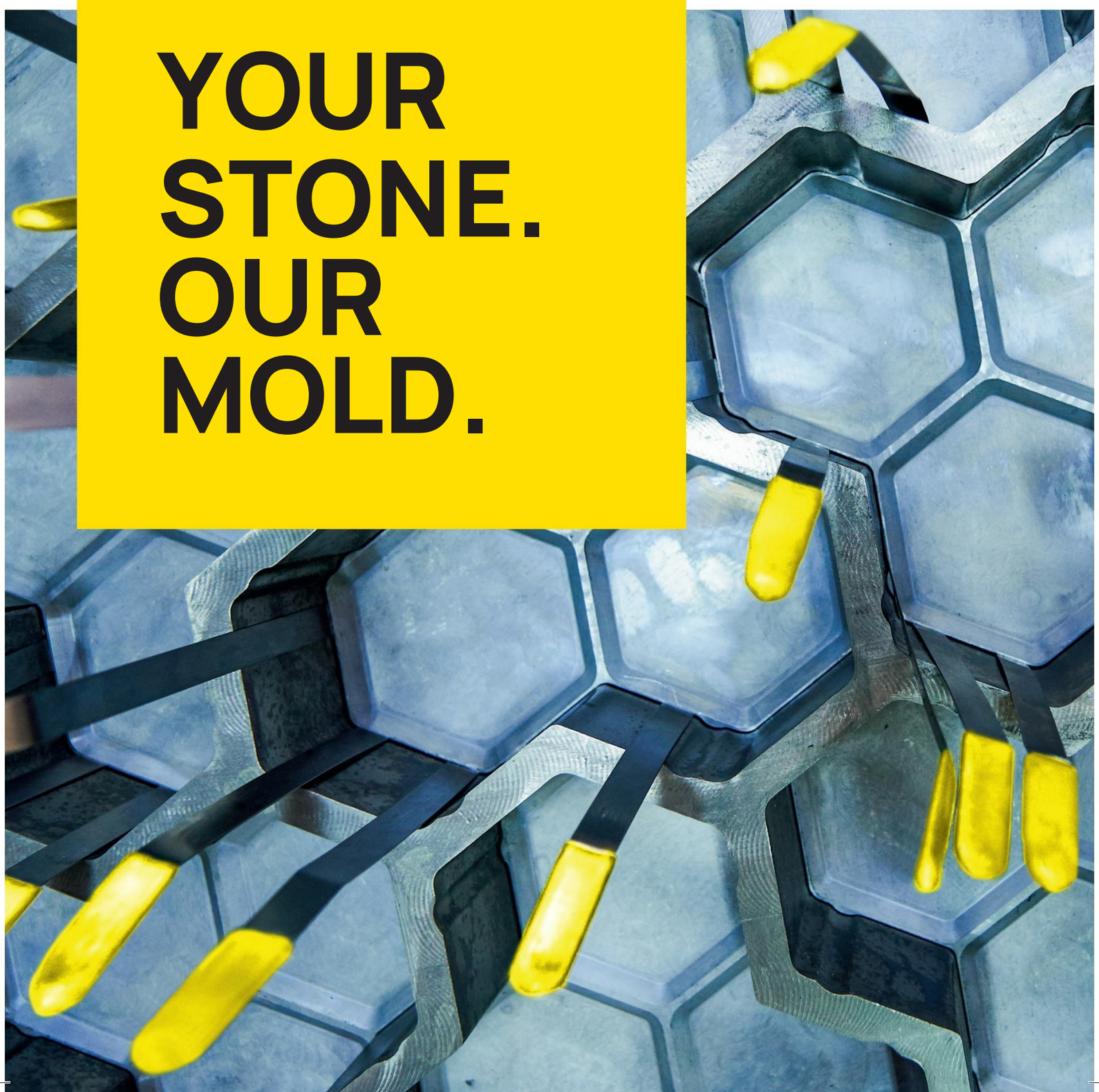
RAMPF®
SINCE 1926

www.rampf.com

YOUR STONE. OUR MOLD.



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YOUR STONE. OUR MOLD.

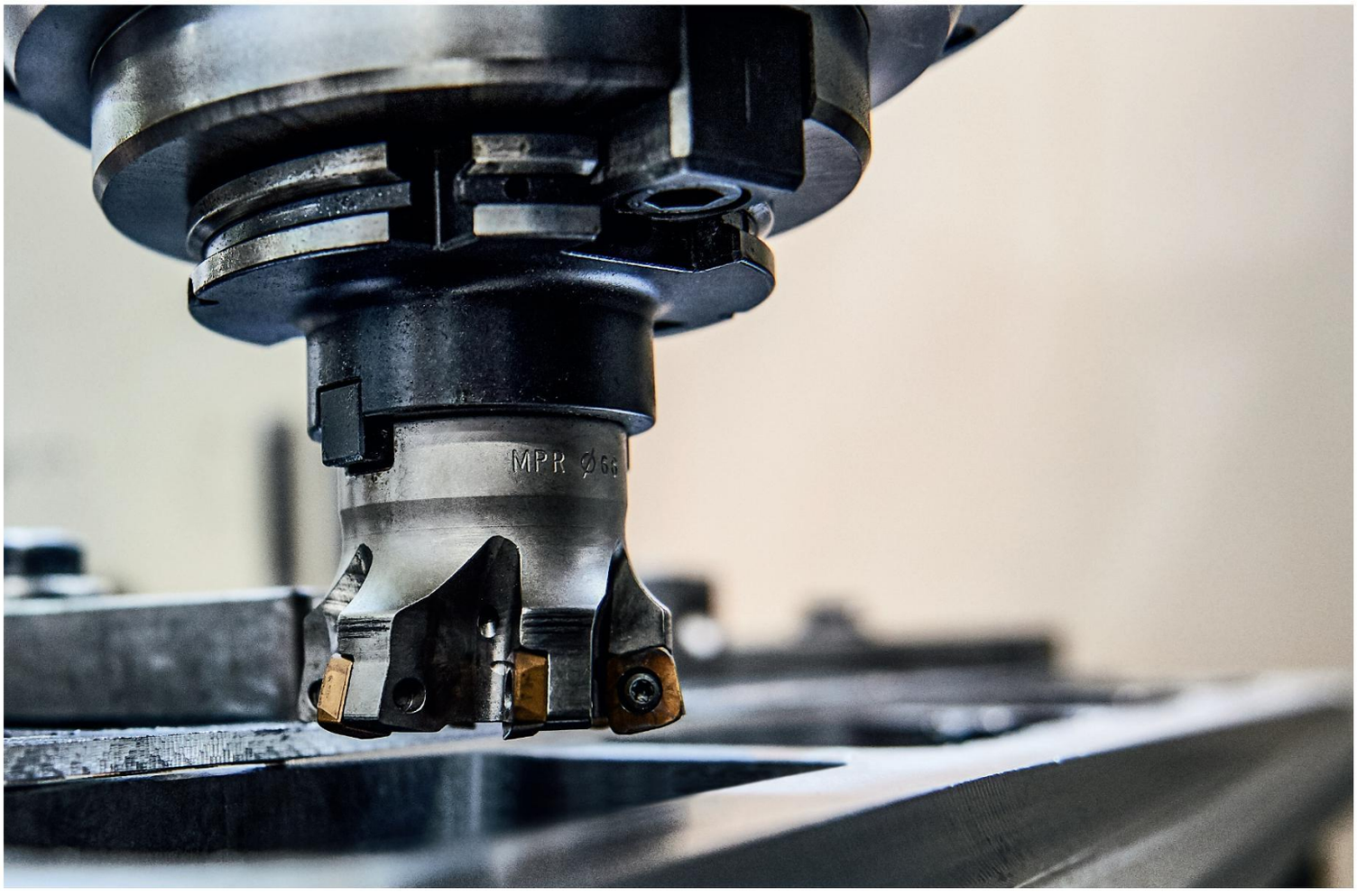
BEST CHOICE FOR MOLDS.

For decades, RAMPF has been one of the leading manufacturers of steel molds for the concrete block industry. Whether it is paving stones, slabs, masonry blocks, kerbstones, eco-blocks, or elements for landscaping, we design and build the perfect mold for each stone. Our highly qualified teams continuously work to refine and develop new technical solutions for concrete block molds. In close cooperation with our customers, we also develop high-tech solutions for their unique challenges in stone production. Our expertise and decades of experience make us a renowned, reliable partner. RAMPF molds are being used successfully around the world. As an international group of companies headquartered in Germany, RAMPF also has facilities in the USA, France, Poland and Hungary. We employ around 500 people worldwide, and 240 at our company headquarters in Allmendingen, Germany, alone.

YOUR STONE. OUR MOLD.

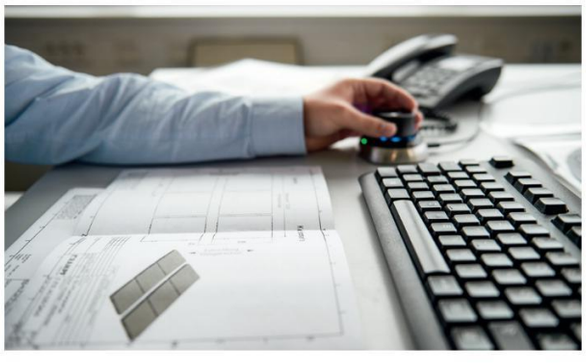
RAMPF doesn't just build you any mold, we design and form the exact mold you need for your stone, precisely tailored to the technical requirements of the machines and materials you use. Whether milled, welded, bolted or studded. Whether case-hardened or nitrided in our hardening shops. Whether with or without addtional features, such as heated tamper shoes, filling equalizer or tamper head centring system. We bring shape to your stone, with economical production of premium concrete blocks.

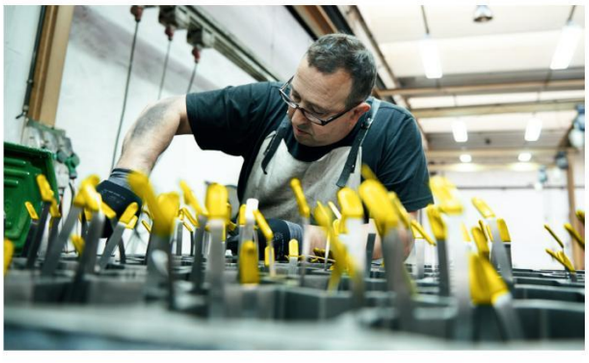
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RAMPF
THE MOLD



PRIME-TEC
Paving stones

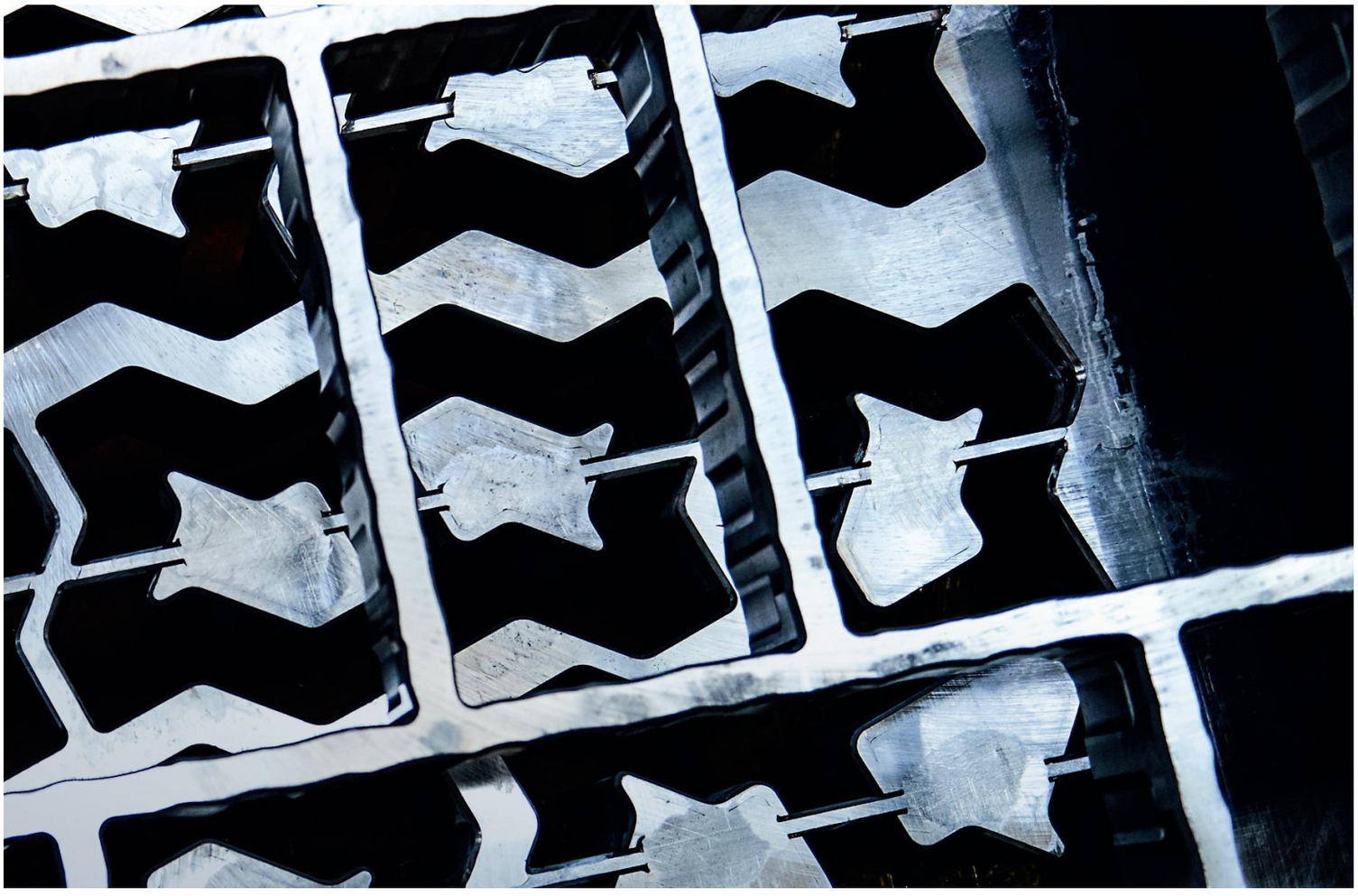


DURO-TEC
Slabs



QUICK-TEC
Kerbstones

YOUR STONE. OUR MOLD.





TOP-TEC
Masonry blocks & landscaping



GREEN-TEC
Eco-blocks and grass pavers



HIGH-TEC
Special solutions

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PRIME-TEC

PAVING STONES. TO MEET YOUR DEMANDS.

PRIME-Tec enhances both the look and performance of paving stones. They withstand the enormous everyday stress of weather and the seasons much better. Over decades, we constantly developed and improved this technology to offer you the highest quality of paving stone production.



THE PREMIUM MOLD

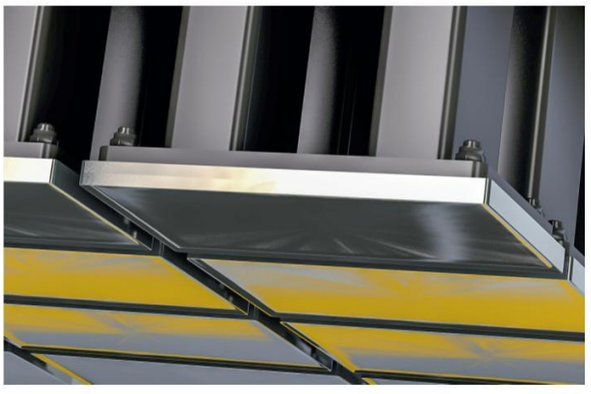
Constantly high quality for the production of paving stones

- Milled mold insert
- CSI Diamond hardening
- For small- to middle-sized stone formats

YOUR STONE. OUR MOLD.







ADVANTAGES

Perfect results from the first cycle

- Long life span due to high dimensional stability and optimized vibration characteristics
- Little wear due to CSI Diamond hardening
- Highest precision in length, width, and angle dimensioning
- Easy mold handling

ADDITIONAL FEATURES

That extra something

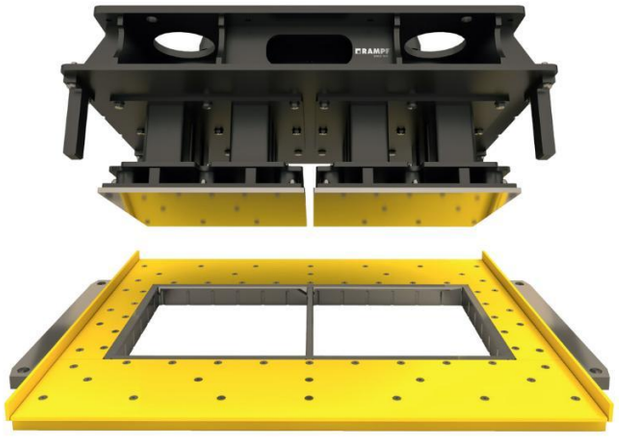
- PRIME-Tec-S
- Heated tamper shoes
- Flex Way
- Filling equalizer
- Rubber buffers in tamper head
- Tamper head centering system
- Double acting tamper head
- Frame / insert bolted

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SLABS. FOR EXCELLENT DESIGNS.

Concrete slabs from RAMPF DURO-Tec molds come in all different sizes and surfaces to create a very special atmosphere for your green oasis – be it large slabs or a pathway through dense greenery. Although large size slabs with unique designs are a challenge for production, RAMPF DURO-Tec gladly embraces this challenge to live up to the most demanding customers' needs.

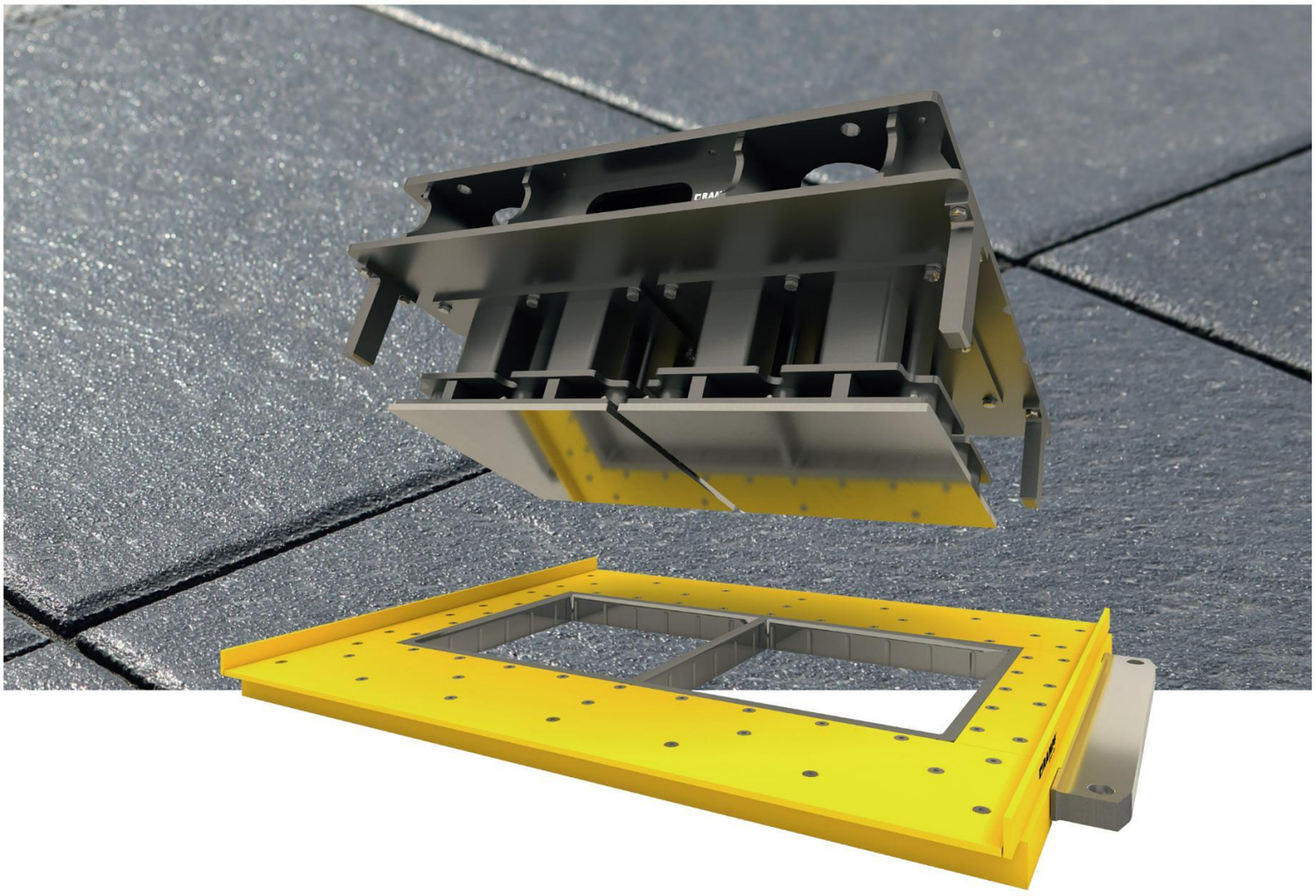


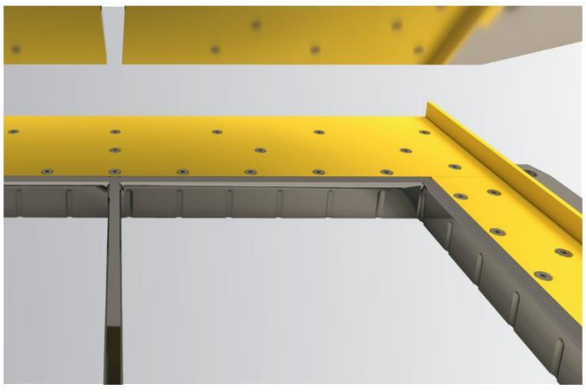
THE ACCURATE MOLD

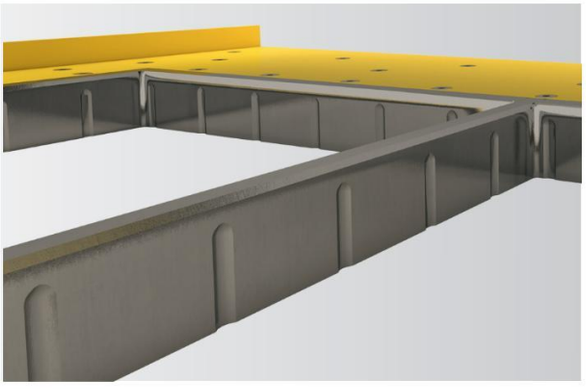
For the production of dimensionally accurate slabs and paving stones

- Milled mold insert
- CSI Diamond hardening
- Cover plates from abrasion-resistant special steel
- For large sized slabs

YOUR STONE. OUR MOLD.







ADVANTAGES

Precise dimensions and edges right from the first cycle

- Highest mold cavity precision in length, width and angle dimensioning
- Long life span and optimum vibration characteristics due to high dimensional stability
- Optimum compaction results due to highly dynamic mold insert resilience
- CSI hardening standard for low abrasion and extended life span

ADDITIONAL FEATURES

That extra something

- Heated tamper shoes
- FlexWay
- Filling equalizer
- Oscillator
- Rubber buffers in tamper head
- Tamper head centering system
- Double-acting tamper head
- Frame / insert bolted

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QUICK-TEC

KERBSTONES. UNLIMITED BOUNDARIES.

RAMPF's QUICK-Tec guiding chamfer, with its easy interchangeability, allows efficient and high-quality production of kerbstones. It saves time and money in maintenance and increases the life span significantly.



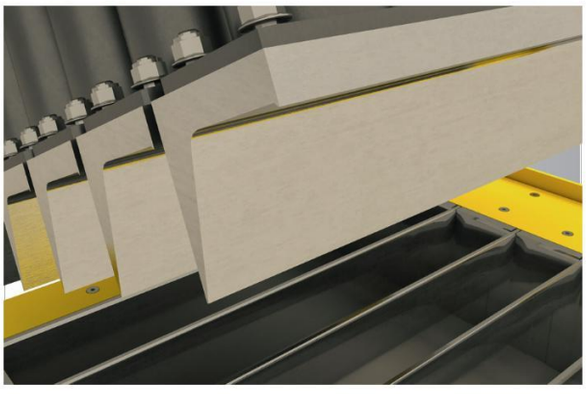
THE SMART MOLD

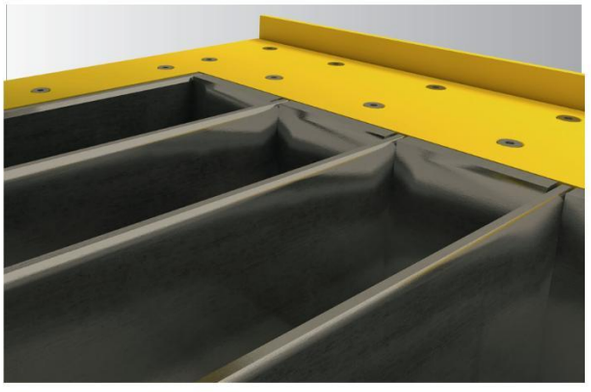
Highly efficient production of kerbstones

- Milled mold insert
- CSI Diamond hardening
- Guiding chamfer to avoid wear and damage
- Tightly closed vertical sides due to easily interchangeable, CSI hardened lateral walls
- Cover plates from highly abrasion-resistant special steel

YOUR STONE. OUR MOLD.







ADVANTAGES

Stone after stone: Simply perfect results

- Perfect stones due to the highest accuracy of mold cavities
- Consistent top quality due to high dimensional stability with optimum vibration characteristics
- Reusable mold frame
- Efficient care and maintenance due to easy replacement of worn parts
- Significant cost reduction due to short set-up times
- Sustainable and resource-saving

ADDITIONAL FEATURES

That extra something

- Height control
- Retractable side walls
- Pneumatic tamper head alignment
- Double-acting tamper head

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TOP-TEC

MASONRY BLOCKS & LANDSCAPING. SHAPING YOUR DEMANDS.

Precise dimensions and consistent weight are crucial factors in the production of hollow blocks. RAMPF TOP-Tec considers both factors to create a perfect match between mold and machine. Depending on your type of machine, we supply a solid, rigid structure or a lightweight version in order to boost the mold's vibration behaviour and improve the block's density.

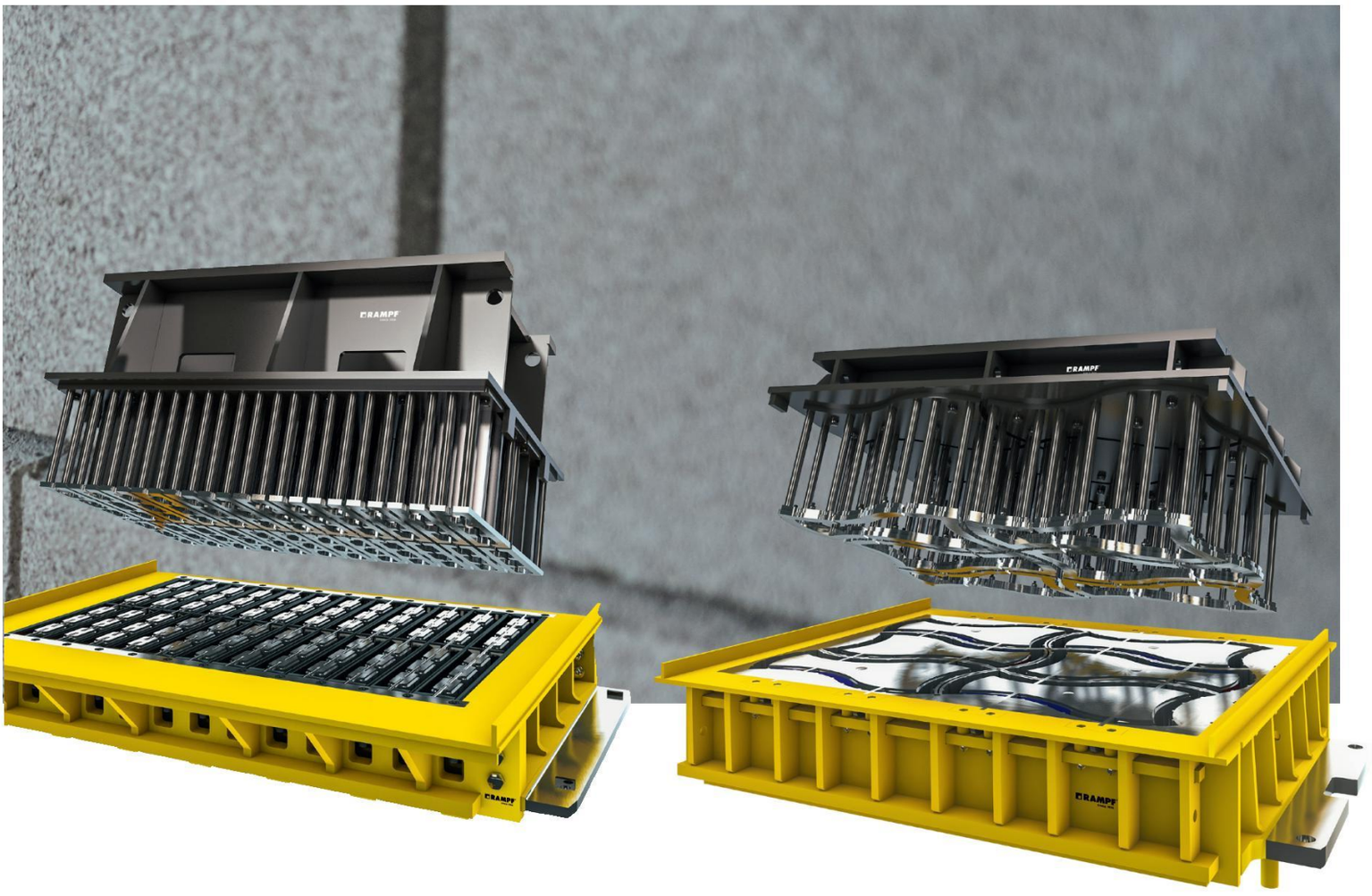


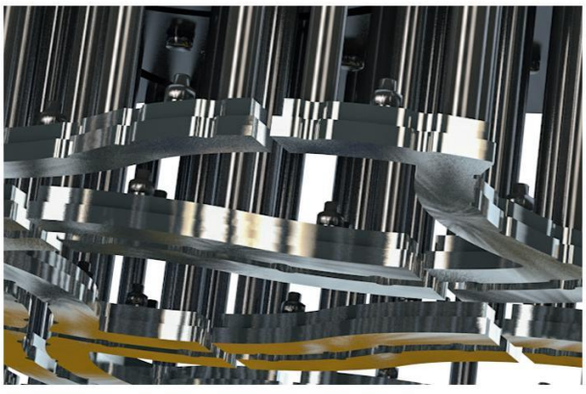
THE PRECISION MOLD

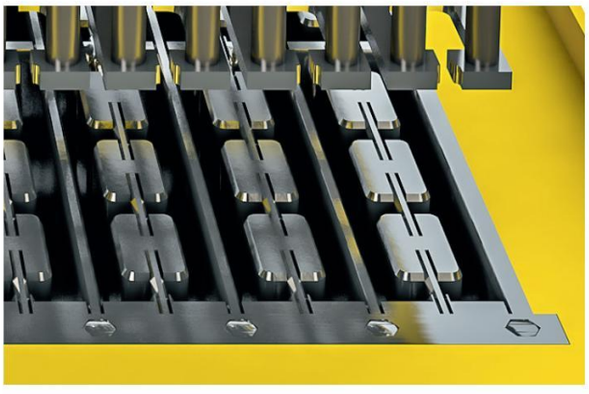
Highly accurate production of hollow blocks and solid blocks

- Milled mold insert
- Tamper head with a bolted plunger and tamper shoes, CSI Nitro hardened
- CSI Nitro hardened cores and bolted cover plates

YOUR STONE. OUR MOLD.







ADVANTAGES

Top results from the first to the last block

- No warp, high dimensional accuracy due to modular construction
- Balanced vibration characteristics for improved compaction
- Modular construction for an uncomplicated and quick exchange of elements
- Extremely long life span due to low wear
- Easy care and maintenance due to quick replacement of worn parts

ADDITIONAL FEATURES

That extra something

- Retractable side walls
- Double-acting tamper head
- Polystyrene insertion device
- Frame / insert bolted
- Core puller device / core puller / draw plate

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ECO-BLOCK MOLDS.
GREAT LOOKS. GREAT BALANCE.

Rainwater is crucial part of the water cycle, required for the replenishment and recharge of inshore waters and groundwater. Permeable eco-blocks contribute significantly to a city's natural ecosystem. RAMPF GREEN-Tec is the innovative solution to fulfill exactly this high-demand specification.

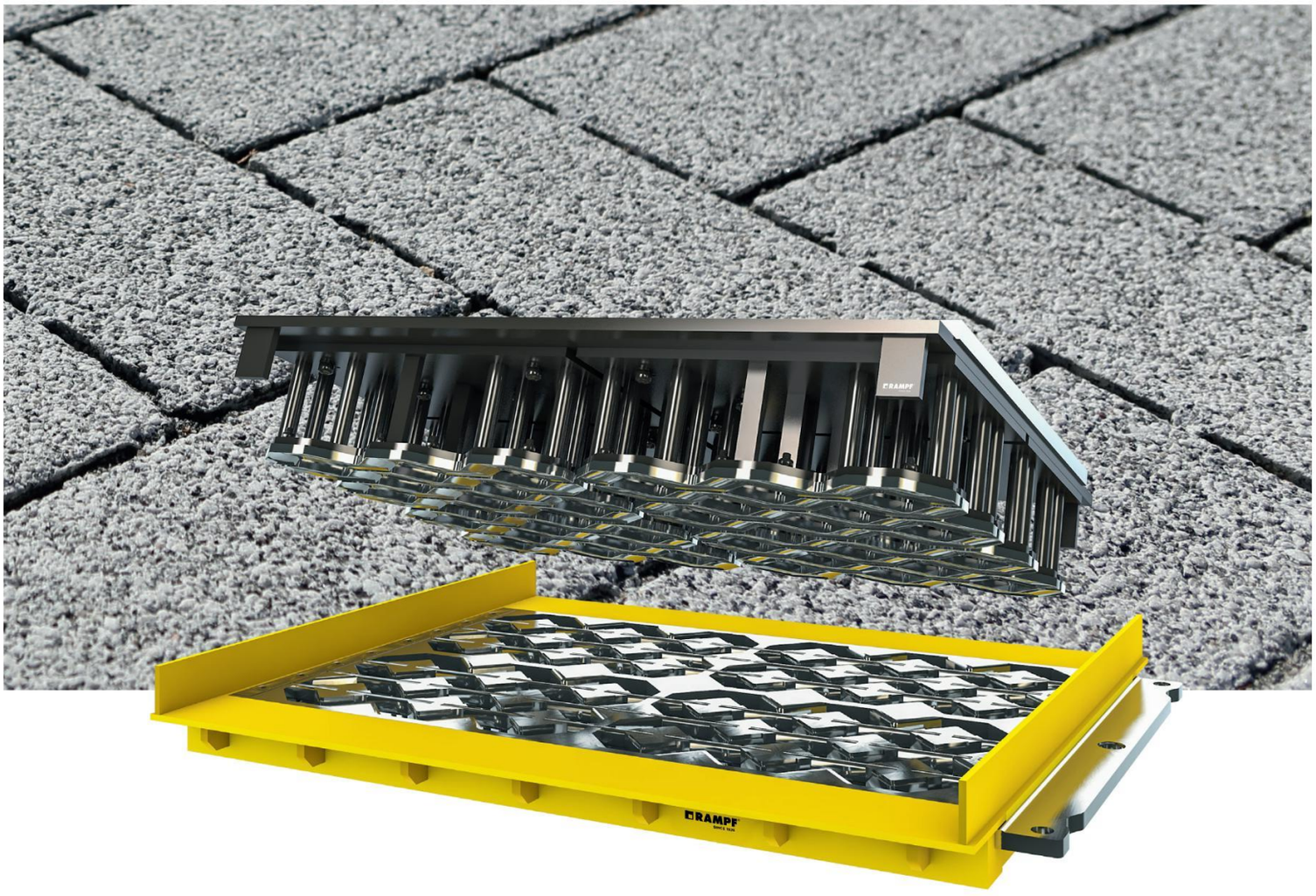


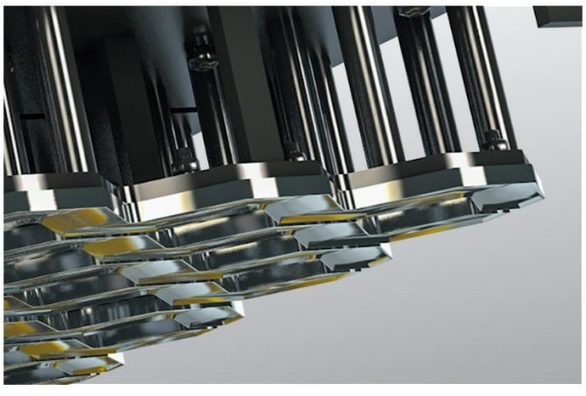
THE ECO MOLD

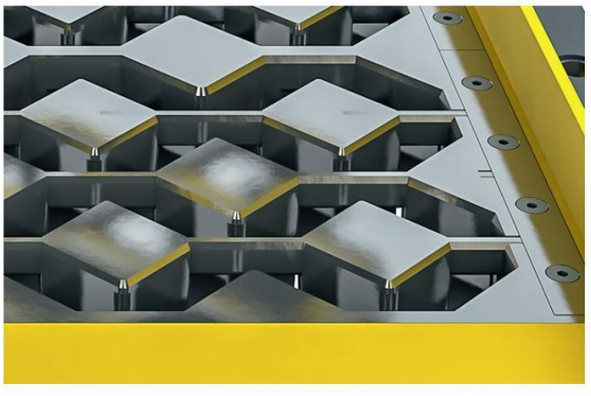
For the production of sophisticated eco blocks and grass pavers

- Milled mold insert
- CSI hardening
- Cover plates from highly abrasion-resistant special steel
- All core bars are clamped and bolted for quick replacement
- Tamper head with removable plungers

YOUR STONE. OUR MOLD.







ADVANTAGES

From Ecology to Economy

- Highest mold cavity accuracy
- Significantly enhanced filling performance due to vibration optimized, homogeneously shaped mold bottom
- Technologically fitted to your specific machine
- Easy care and maintenance due to quick replacement of wear parts

ADDITIONAL FEATURES

That extra something

- Height control
- Double-acting tamper head
- Oscillator
- Frame / insert bolted

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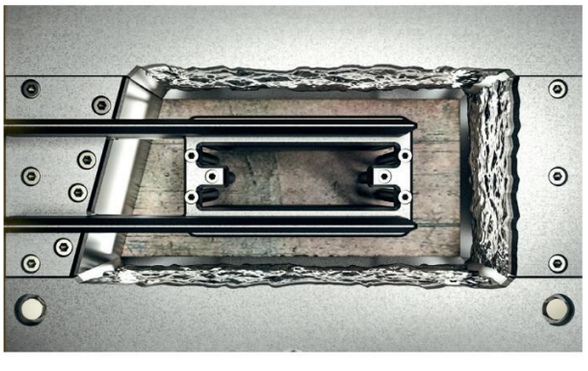


HIGH-TEC

TOPROC. UNLIMITED OPPORTUNITIES.

TOPROC is one of RAMPF's patented innovations. The TOPROC technology enables you to imprint a concrete product on up to four sides. The texture possibilities are nearly endless. These various texture segments can easily be interchanged with other components, creating a flexible solution for multiple structures on the same product.

The TOPROC system is free of hydraulics and pneumatics or other limitations. Gravity is our only driver. This results in no loss of cycle time, additional space in the mold and a high quality product. TOPROC is the revolution that takes away your hesitations to utilize the full potential of side textures.



HIGHEST MOLD TECHNOLOGY

An entirely mechanical system designed to streamline and simplify the production process

- No hydraulics, no pneumatics, just gravity
- No lost cycle time during production maximizes efficiency and output
- Compared to a hydraulic or pneumatic system, TOPROC requires less space in the mold. This allows more products to be produced per cycle
- Suitable for all types of machines

YOUR STONE. OUR MOLD.







ADVANTAGES

Creativity through innovation

- Provides the ability to imprint up to four sides
- Long life span and optimum vibration characteristics due to high dimensional stability
- Highest mold cavity precision in length, width, and angle dimensioning

ADDITIONAL FEATURES

That extra something

- Heated tamper shoes
- Heated liners

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ADDITIONAL FEATURES FOR PERFECT STONES.

YOUR STONE. OUR MOLD.



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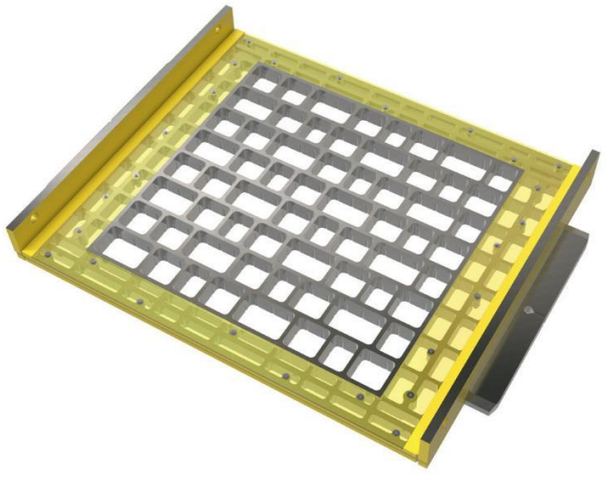
PRIME-TEC-S

GIVE NECESSARY OPEN SPACES. PRIME-TEC-S

With our mold bottom PRIME-Tec-S, less is clearly more. The conventional construction (frame and insert) is replaced by an ingenious combination of a system insert and side elements with this design.

An intricate lattice structure with specific spaces positioned in the system insert optimizes the vibration behaviour and ensures uniform vibration behaviour in the mold and concrete batch.
The system's natural frequency is significantly increased due to a mass reduction of approximately 20%, combined with the intricate design of the mold bottom, the vibrating force can be more efficiently utilized. The mold system and the concrete to be compressed can therefore be subjected to higher acceleration forces, resulting in much betterand faster block compression.

Side parts can be bolted, if desired. Then all bolted side parts match all system inserts of the same height and within the system, regardless of the system itself.

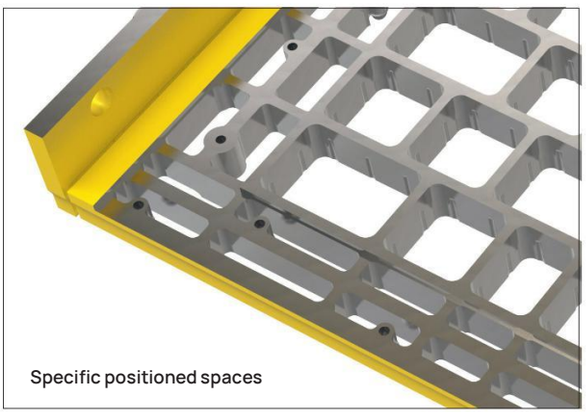


ADVANTAGES

- Higher block strengths due to the optimum vibration behaviour of the insert
- Better block compression
- Excellent filling of the mold cavities
- Reduction in abrasion, longer life cycles
- Shorter cycle times through faster compaction
- Bolted-on side parts can be used several times.

YOUR STONE. OUR MOLD.



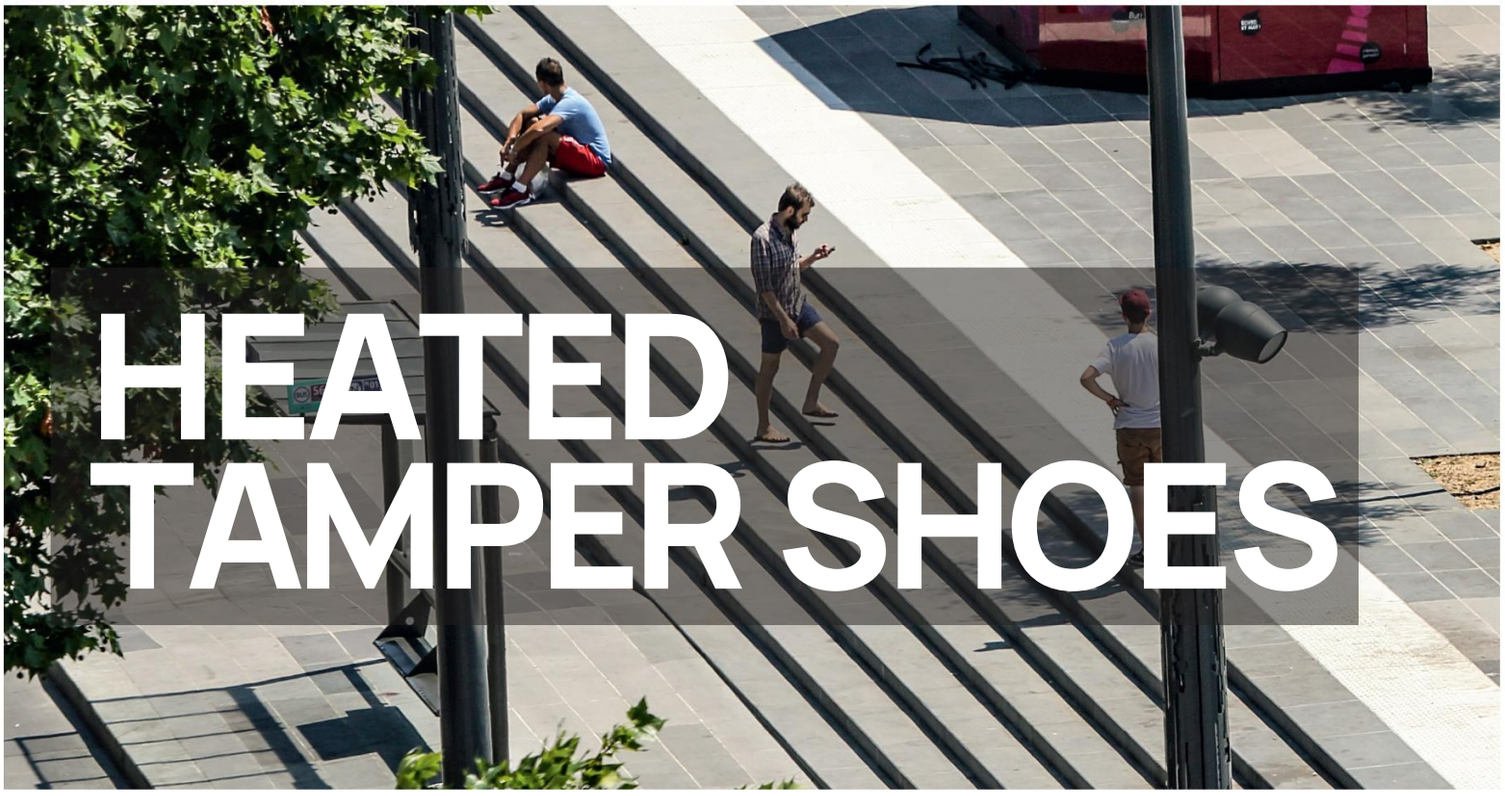


Specific positioned spaces



With bolted side parts, by request

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HEATED TAMPER SHOES

TURN THE HEAT UP.
HEATED TAMPER SHOES

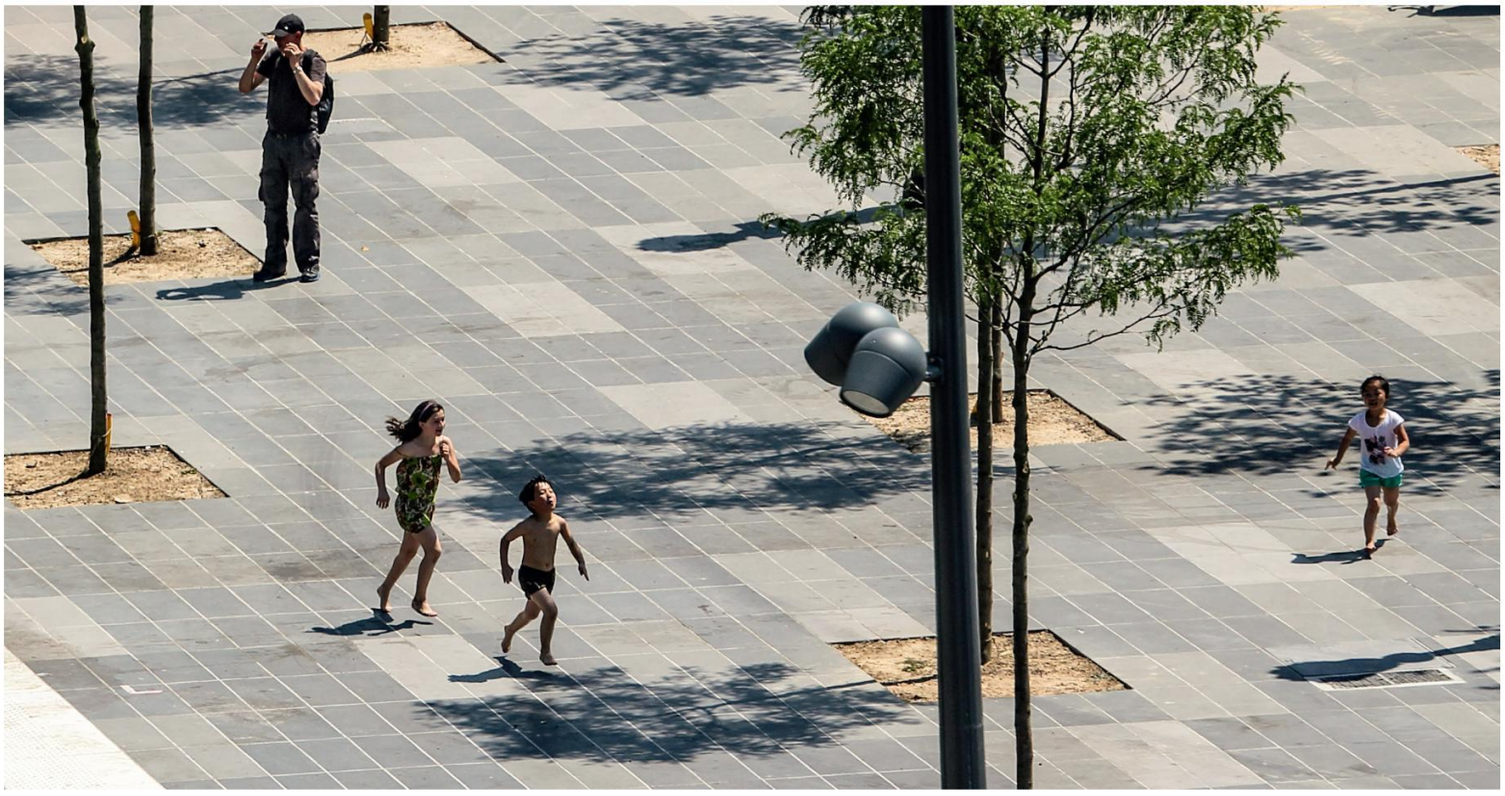
RAMPF heated tamper shoes were specifically developed to produce high-quality paving stones and concrete slabs with a sophisticated surface.

The heating of the tamper shoes reduces the adhesion of concrete to the tamper shoe surfaces. This avoids imperfections on the concrete product and the overall reject rate is significantly reduced. In addition, the w/c ratio of the concrete batch can be increased due to the higher temperatures on the tamper shoes, which leads to an impermeable homogeneous surface and significantly increases the overall quality of the concrete product.

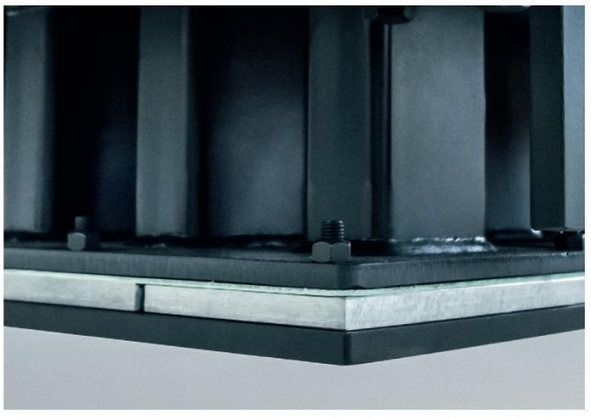
SPECIAL FEATURES

- The output of the heater pads is individually adapted to the different mold cavity sizes.
- Integrated sensors measure the temperature directly on the tamper shoes.
- The target temperature on the tamper shoes is already reached within a few minutes through the use of high-performance heater pads.
- No overheating of the tamper shoes when production is interrupted
- Only one output controller is needed per machine – it can also be used with unregulated, clocked heating systems
- Two temperatures can be independently regulated if this is required for technical reasons.
- All electrical components including the complete wiring are installed in the mold equipment.
- High-quality grounding of floating tamper shoes
- Can also be used in combination with other additional features, such as the filling equalizer

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ADVANTAGES

- Reduction in concrete adhesion to the tamper shoe surfaces, particularly in fine mixes
- Dense and impermeable block surfaces
- Permits the use of wet face mix (higher w/c ratio)
- Less scrap due to imperfections
- High stone quality with a perfect surface



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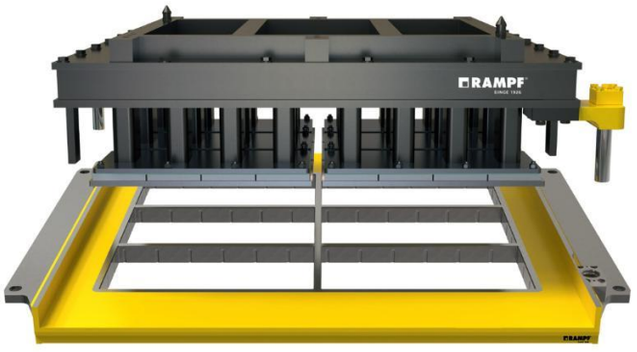


CENTERING SYSTEM

FIND THE PERFECT CENTER. TAMPER HEAD CENTERING SYSTEM

Ugly and uneven chamfered edges on blocks due to centering errors between the tamper head and mold base – who isn't familiar with this problem? The result of these technical centering errors is uneven production and extremely high abrasion on tamper shoes and mold cavities.

The RAMPF tamper head centering system provides a remedy in this situation. It guarantees precise entry of the tamper shoes into the mold cavities. The result: a consistently high block quality and higher life cycles due to significantly reduced abrasion.

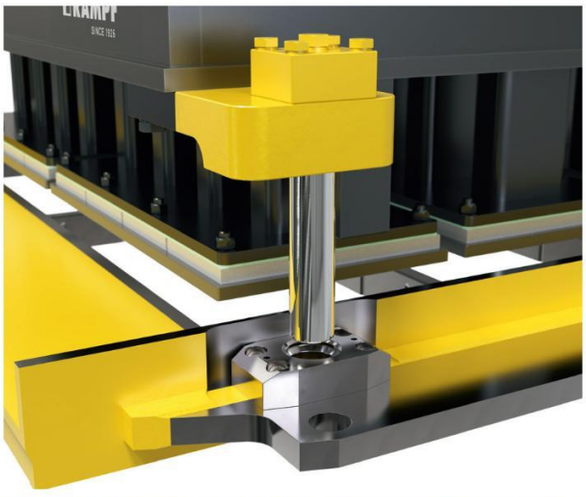


ADVANTAGES

- Perfect centering of the tamper shoe to the mold cavity
- Reduces abrasion on tamper shoes and mold cavities
- Tamper shoes do not touch the mold cavities or lead-in chamfers
- High block quality due to the uniform chamfer pattern (even with abrasion that is already evident)
- Particularly effective for low block heights
- A longer life cycle of the entire mold
- Centering bolt is particularly durable, abrasion resistant and easy to exchange.

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MOLD KNOWLEDGE

Why do centering errors occur?

The mold base requires all-around play in its machine mount to introduce the vibrating energy effectively. This play results in the mold base moving away from the middle of the machine during the production.
The tamper head must now follow the mold base for the block compression. To do this, the quick-change device on the machine side is mounted on the rubber buffers that give the tamper head opportunity to move horizontally and are used to decouple vibrations. The rubber buffers produce high restoring forces that lead to permanent contact between the tamper shoes and the mold cavities.

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FILLING EQUALIZER

ENSURE EQUAL CONDITIONS. FILLING EQUALIZER

The same stone heights and a consistent stone strength are important quality criteria in the manufacture of high-quality concrete stones. All mold cavities of the mold base must be uniformly filled with a homogeneous concrete mass to meet these requirements. The RAMPF pneumatic filling equalizer effectively ensures that concrete products are uniformly compact, very strong and of a consistent height – especially with large concrete products.



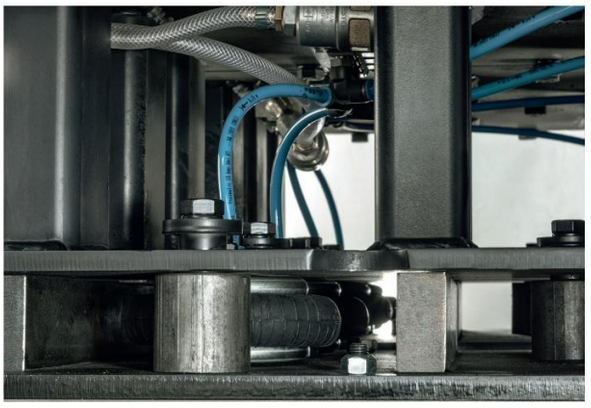
ADVANTAGES

- The same stone heights and consistent strengths
- Consistent filling of the mold cavities over all mold segments
- Smooth and impermeable stone surfaces
- Less scrap, higher productivity
- Reduces concrete adhesion to the tamper shoes
- Fewer cracks in the stone surface
- A significant reduction in the formation of so-called orange peel.

YOUR STONE. OUR MOLD.









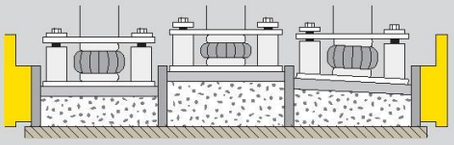


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MOLD KNOWLEDGE

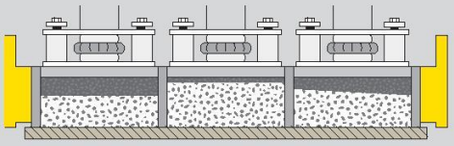
How does the filling equalizer work?

Pneumatic bellow cylinders are used to flexibly mount the tamper shoes to the shoe mounting plates of the tamper head in the integrated filling equalizer. The tamper shoes can move vertically in this mount and level out any inclination simultaneously. The bellow cylinders running at high pressure subject the base mix concrete to uniform pre-compression during the previbration and/or intermediate stamping. The remaining height differences are then evened out by the face mix.

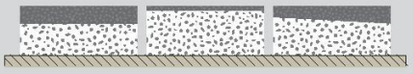


Intermediate compaction of the core concrete mass according to the fill level of the individual stone cavity.

The bellows cylinders are depressurized during the final compression and are compressed when they are in contact with the face mix. The tamper shoes rest on their flat stop faces. Now, all concrete products are compressed to the same height because the tamper shoes rest flat on the impact bars. It gives the concrete products a consistent density and uniform height.



Final compaction to an even stone height and density



Positive side effect – smooth, closed stone surfaces

The result is convincing: concrete blocks with the same height, a uniform block density, strength, and an impeccable block surface. This significantly reduces waste and increases the productivity of the plant.

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