

■ Schlüsselbauer Technology GmbH & Co KG, 4673 Gaspoltshofen, Austria

Naporni Trubi starts running new production line for concrete pipes and concrete manhole components in Bulgaria

In the Bulgarian border town Rousse, which is 70 km (44 miles) south of Bucharest/Romania, the most modern production plant for large diameter concrete pipes and manhole components has been in operation since April 2007 at Naporni Trubi AB. The investment in this plant was made with the decision to use only the most modern technology available in Europe. Several companies from Austria and Germany including Schlüsselbauer Technology GmbH & Co KG as provider of the production technology have parti-

cipated in the execution of this trend-setting decision. The company Naporni Trubi now meets the updated specifications of construction in the field of infrastructure in Bulgaria. The specifications were modified after joining the European Union (EU) on January 1, 2007. Naporni Trubi is prepared for conducting business within the EU as well as for the handling of construction projects in partnership together with Europe-wide building companies.

The company was founded in 1965 and chose the strategic location on the Bulgarian-Romanian border because of its proximity to a large market and the transportation capability of the Danube River. The company owned harbour on the Danube is still in use and will become vital in serving distant markets as the business develops. As the only pipe producer in Bulgaria for many years, Naporni Trubi is positioned with their workforce of 70 people to effectively serve the nearby

market of Rousse. This decision and investment combined with the close collaboration with Western European technology partners will enable the company to realize its planned strategy of growth by supplying the highest quality products.

Schlüsselbauer provided the production plant Exact XL which consists of two production stations on which pipes, manhole risers, or cones can be produced. The operator works at floor level while pro-

duction is carried out below floor level in two adjacent pits. The range of products includes up to a diameter of 2500 mm (96") at a building height of 2500 mm (96") and a total product weight of 12,5 metric-tons (27,555 lbs.). Naporni Trubi currently produces concrete pipes - with and without reinforcement - from a diameter of 300 mm (12") up to 2000 mm (78") and manhole risers from a diameter of 1000 mm (36") up to 1500 mm (60") in several building heights as well as the



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Two multi-movable feeding strips guarantee an exact insertion of concrete and adjustment to the product being manufactured – the duration of filling is optimized.



Each production station disposes of an independent pressing unit – here you can see it in use to finally shape a concrete pipe Ø 1600 mm.



Already when entering the factory premises Naporni Trubi proudly show their product range manufactured with most modern technology.



The production plant EXACT XL at a glance: In-between the two production stations for pipes and manholes the concrete box with its feeding strips and the operation panel are arranged.



Production plants for pipes, manhole components and special parts



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Outfeed of the filled mould out of the pipe station and its transfer to dismantling.

corresponding cones. Both work stations of the Exact XL receive concrete via two robotic feeding lines and each station is equipped with a dedicated pressing unit configured for the specific product. After the filling and pressing cycles, the product is core stripped and travels to a curing position on the plant floor by an overhead crane. The jacket is stripped from the product and is returned to the production machine in few short minutes.

While one product is being stripped and the jacket is being prepared for the next production cycle, the other production station is filling and pressing. This permits



The products being manufactured on the EXACT XL range from large-sized concrete pipes to a simple riser with building height 250 mm.

continuous production while at the same time minimizing the movement of the overhead crane. Because of this efficient design, two employees can manage the entire operation even during a product changeover. Due to the independent nature of the two production stations, the system can continue production when one station is being modified or changed to a different product. The productivity of the system is maintained by the ability to produce entirely different products in an independent fashion and the adaptability of the system lends itself to a wide range of products.

In addition to the production plant supplied by Schlüsselbauer, Naporni Trubi relies on ball end lifting anchors by Halfen-Deha from Langenfeld as well as on gaskets by DS Dichtungstechnik from Nottuln in Germany. The step rungs for the manhole parts are provided by Eco-technic from Austria. By exclusively using parts approved in the new civil engineering specifications, compared with their competitors of the local market, Naporni Trubi makes a significant step towards meeting the strict European Standards now required in Bulgaria and Romania for new pre-cast concrete products. The decision and investment positions Naporni Trubi to become the leader and

supplier of choice for infrastructure products in Bulgaria and other markets.

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