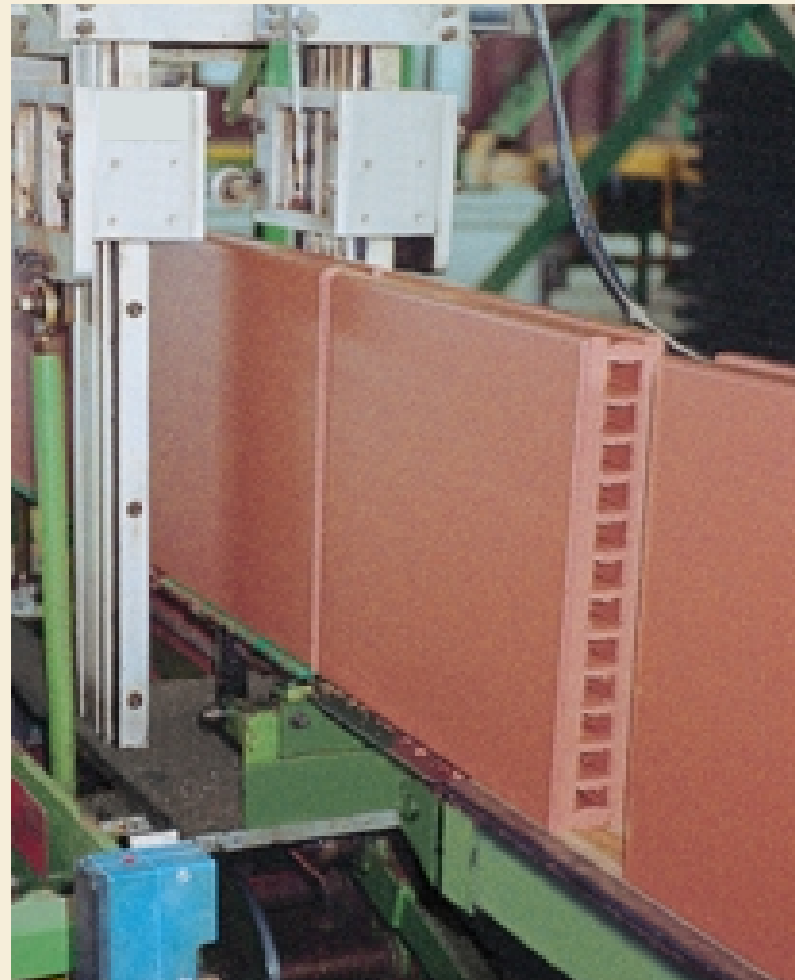


Information

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Split Tile Production



Lingl Split Tile Technology

For more than 60 years now, we have been developing and modernizing the manufacture of extruded tiles. LINGL was one of the pioneers in this technique, and helped prepare and consolidate the high performance standards of the split tile industry.

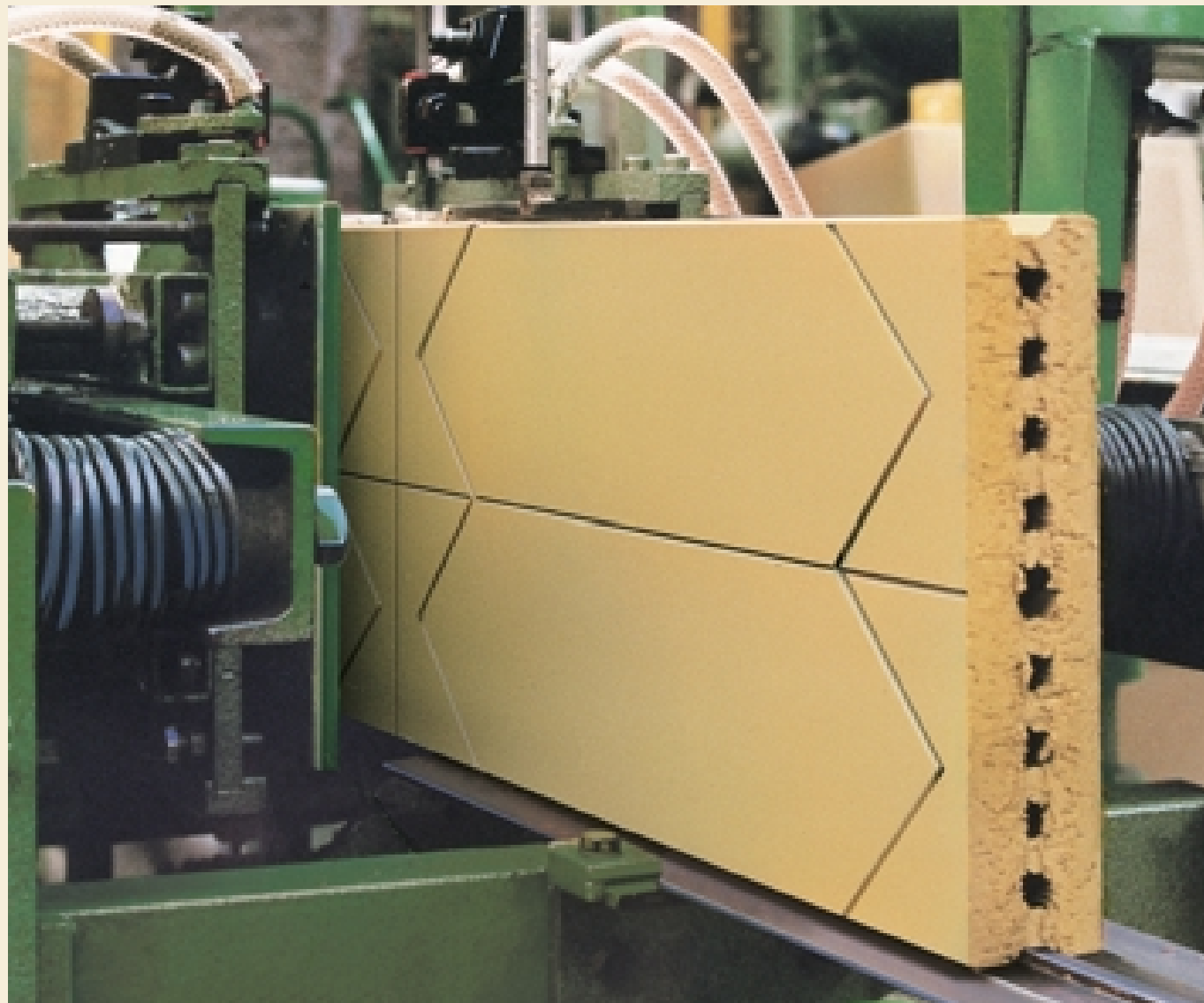
The most important step was firstly the development of a suitable cutting system to permit the manufacture of clean and smooth-edged tiles. Depending on the tile size and requirements, LINGL provides for that purpose cutters with scissor cut or with vertical cut, both with and without chamfering, and also punches for navettes, for example, and with changeable cutting frame.

For drying, the split tiles are placed on one or more drying supports. However, we have also equipped systems with direct setting for drying and subsequent firing on the kiln car, depending on the tile thickness and surface treatment requirements.

Engobing and glazing, profiling or sanding, spraying with abrasive grit and similar surface treatments can be provided for the wet column, for example before the cutter. As a rule, however, engobing and glazing takes place after drying. The world-famous and widely used centrifugal process is a LINGL development from the early years.

▼ Split tile cutter with punching device for ornamental tiles

This development of the split tile cutter using the scissor cut for the ornamental tile punch has opened up for the split tile industry new markets that were previously reserved for dry pressed tiles. The navette in particular has made inroads on many markets.



Setting and unloading of the kiln car are fully automatic. A wide range of different settings can be selected, for example with or without spacers, all sizes aligned in the same direction, or in herringbone-style setting, but also in crosswise setting.

Automatic splitting prior to grading and packaging is performed vertically, gently and with high output, yet very simply.

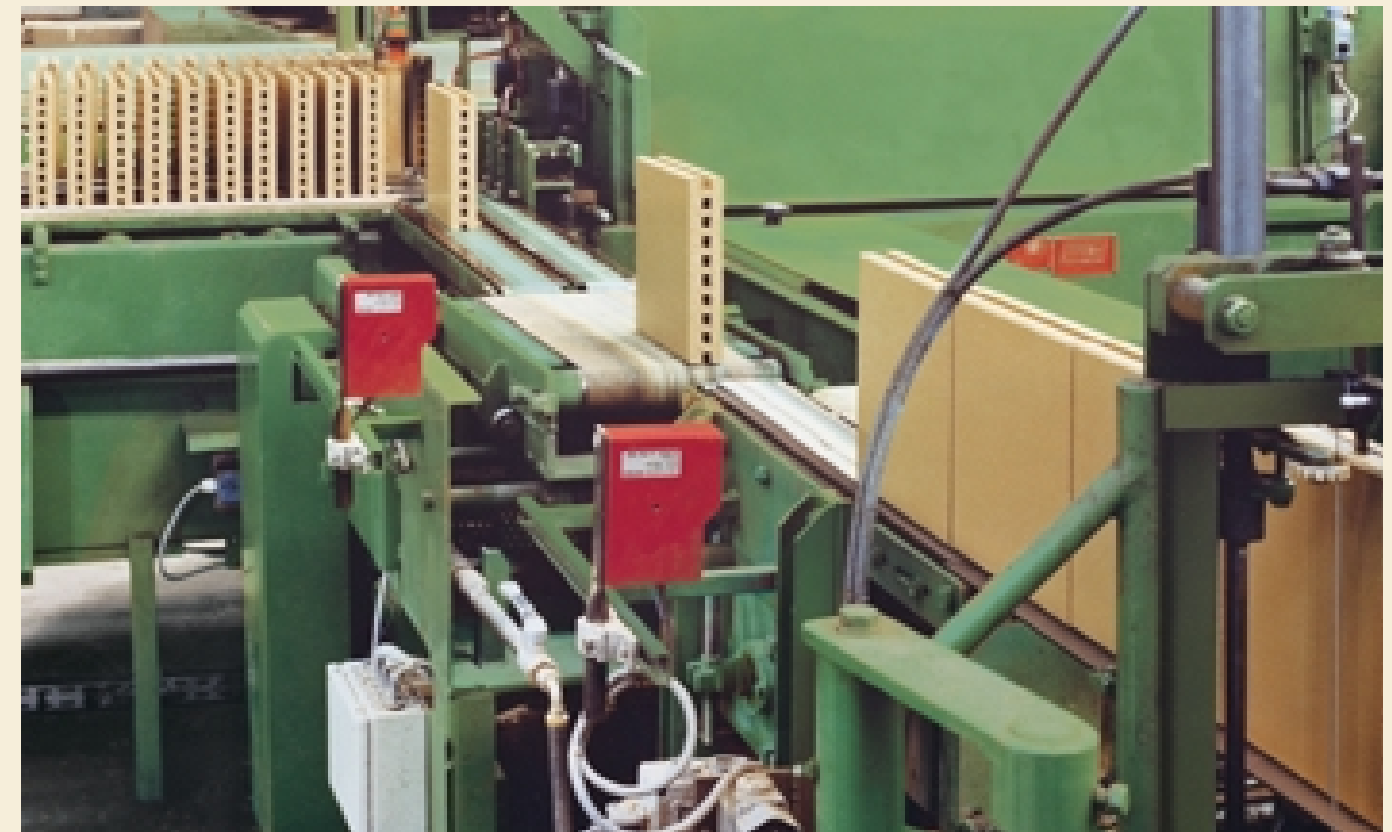
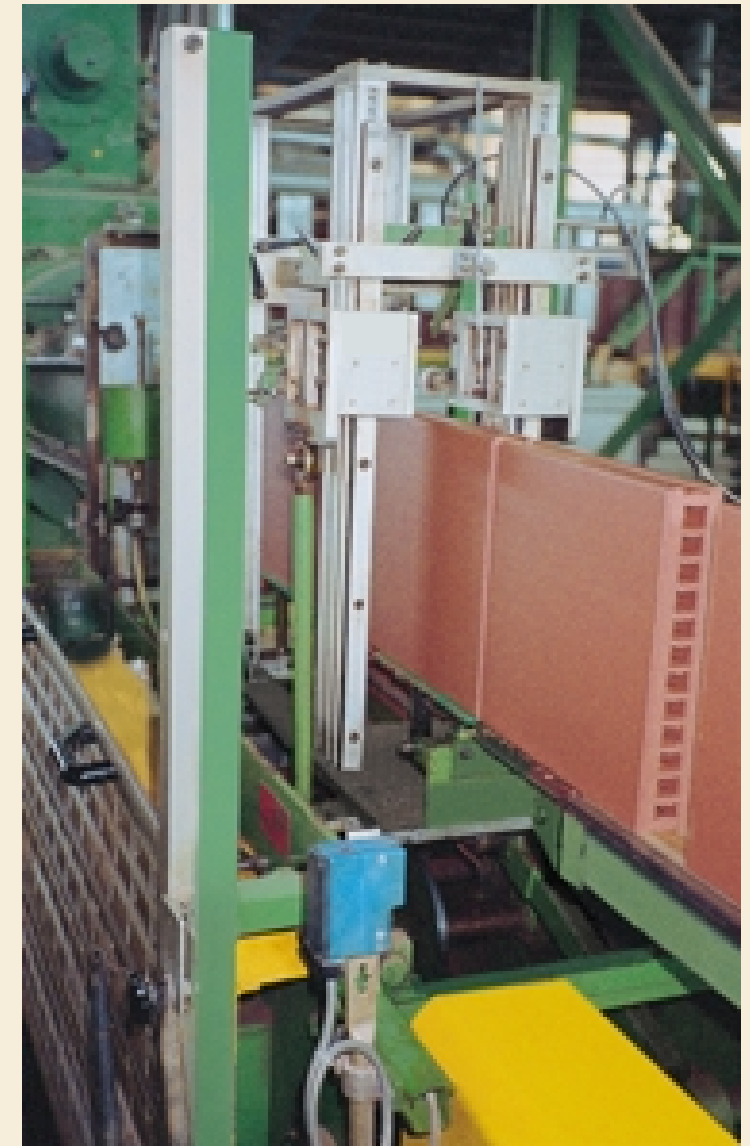
It goes without saying that the standard of handling, with and without robots depending on requirements, and also of the control technology, is excellent.

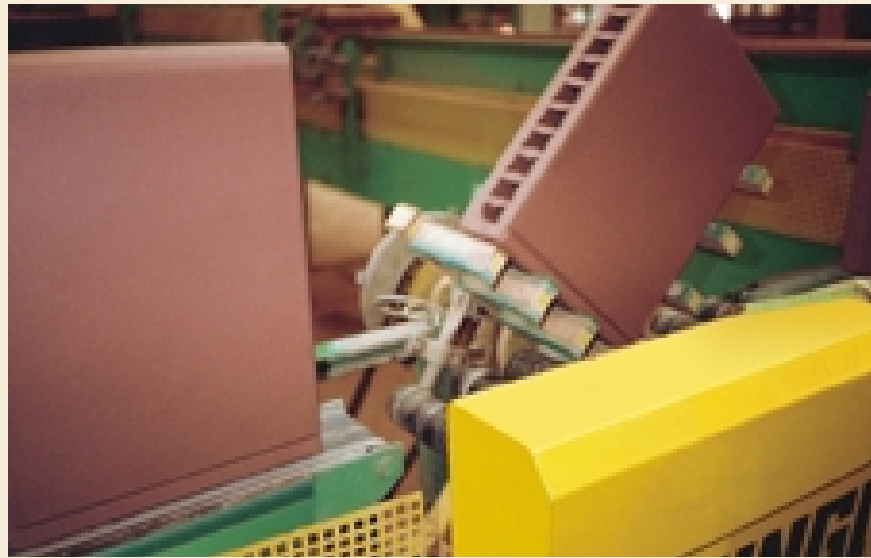
► Split tile cutter with vertical cut

Large tiles of 400 to 600 mm, for example, are cut vertically, in combination with chamfering. A very short wire is employed here. The cut is angular and neat.

▼ Split tile cutter with scissor cut

This cutting method, with or without chamfering, is suitable for smaller tiles, for example 300 mm and less, and particularly also for high cutting rates of, for example, 80 cuts per minute. The stroke of the cutting wire holder is short. Thanks to the low tile height, overlapping of the cutting wires is also assured.





▲ *Tilting of the green tiles after cutting*
Stairway step tiles, corner tiles and tiles for similar purposes are tilted after cutting, in preparation for their later setting onto the kiln car.

▼ *Stairway step double tiles are set down on the drying supports.*



► *Stairway step tiles in the dryer car*



▼ *Multi-line glazing stations for two-sided dry glazing using the Lingl centrifugal process for high-quality glazes, also with special colour effects and different coating layers. In combination with compressed air spray systems and special drives, specific shading effects can be produced and even the most demanding glazing requirements met.*





Automatic setting unit

Lingl automatic setting machines for split tiles, with capacities of up to 105 double tiles per minute, with grippers or with robots depending on requirements, are used for a wide range of setting methods. The most common setting for split tiles is in rows with spacers, with all tiles aligned identically. The spacers are automatically inserted and removed.

The usual setting for stiff-extruded tiles is in rows or turrets, and for brick and steel bottom tiles also herringbone-stype or crosswise.

Lingl drying and firing technology is available, depending on the material and size, with fast or conservative throughput times, in chamber or continuous dryers, with combined top and side firing tunnel kilns, with reduced firing or flashing for different colour effects, also with salt glazed surface.



▲ Split tiles are unloaded in rows from the kiln car, separated and passed to the splitting unit

▼ Tunnel kiln cars with skirting strips, Lingl tunnel kiln with side firing facility



▼ Tile splitting unit for vertical splitting and setting down with the visible surfaces upwards





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