



US 20100081560A1

(19) **United States**

(12) **Patent Application Publication**
Mechkovsky

(10) **Pub. No.: US 2010/0081560 A1**

(43) **Pub. Date: Apr. 1, 2010**

(54) **GENERAL-PURPOSE METHOD FOR PRODUCING LARGE-SIZED CERAMIC PRODUCTS SUCH AS HOUSES OR ROOMS FROM CLAY, LARGE-SIZED BLOCKS, BRICKS, AND CEILING SLABS (EMBODIMENTS)**

(30) **Foreign Application Priority Data**

Dec. 21, 2006 (RU) 2006145545

Publication Classification

(51) **Int. Cl.**
C04B 33/04 (2006.01)

(52) **U.S. Cl.** 501/141

(57) **ABSTRACT**

The invention relates to the building material industry and to the use of labor saving tools of industrial continuous and batch brick kilns. Said invention makes it possible to develop a process for producing large-sized clay ceramic products consisting in carrying out rapid and high-quality baking and to accelerate a construction process. The inventive method for producing a clay house or another clay construction consists in forming, during construction, through and blind voids in a wall and a ceiling in such a way that they are closed with a noncombustible material from outside, in covering window and door apertures in the ready clay construction with a noncombustible material, and in baking the construction to a ceramic state in such a way that hot gas penetrates into the voids and that the body of the product is uniformly heated. During baking the construction is used in the form of a furnace (combustion chamber).

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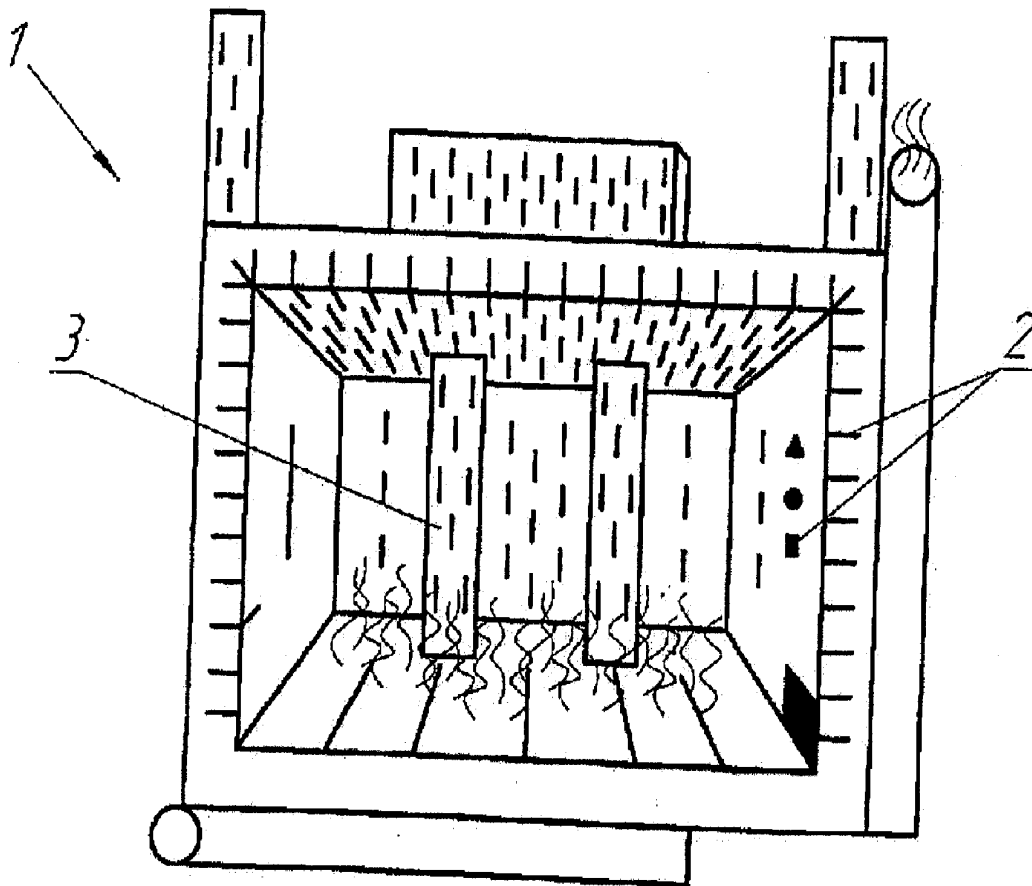
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(21) **Appl. No.: 12/518,947**

(22) **PCT Filed: Jun. 6, 2007**

(86) **PCT No.: PCT/RU2007/000303**

§ 371 (c)(1),
(2), (4) **Date: Jun. 15, 2009**



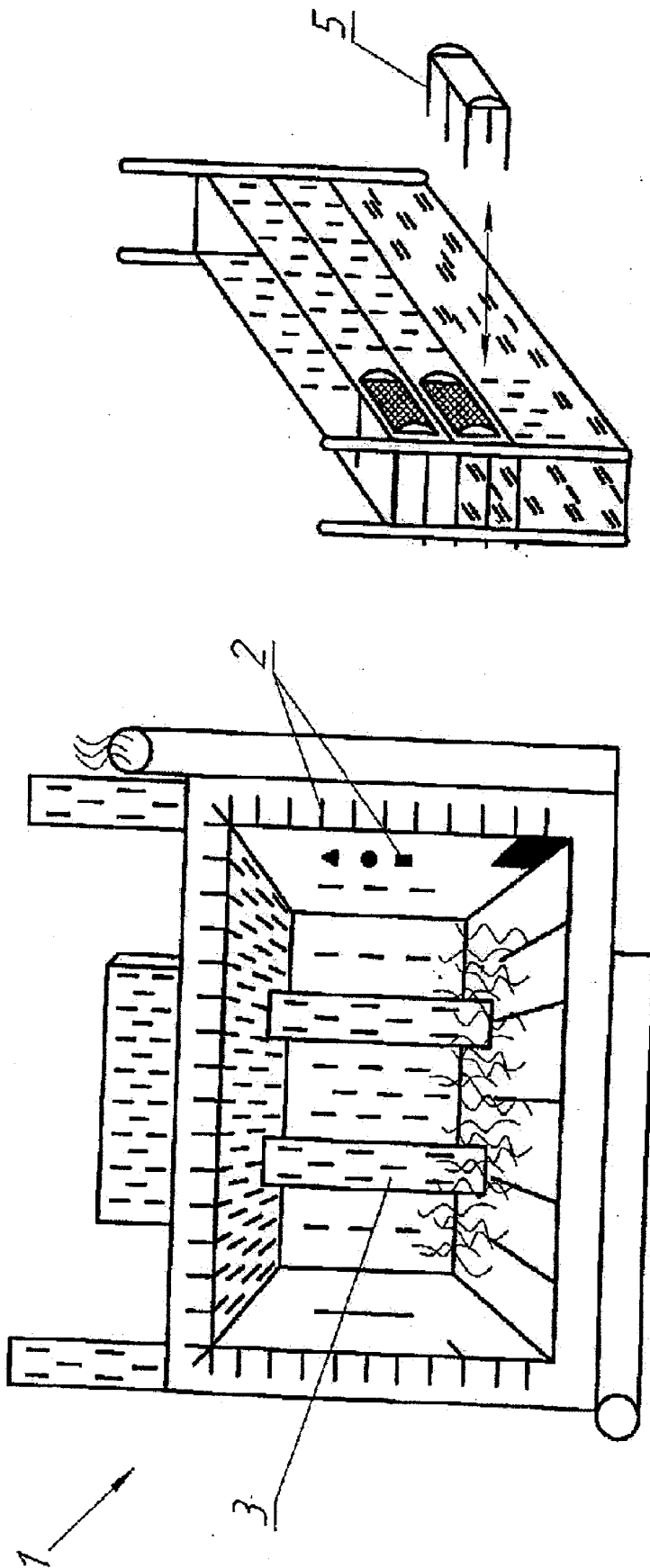


Fig. 2

Fig. 1

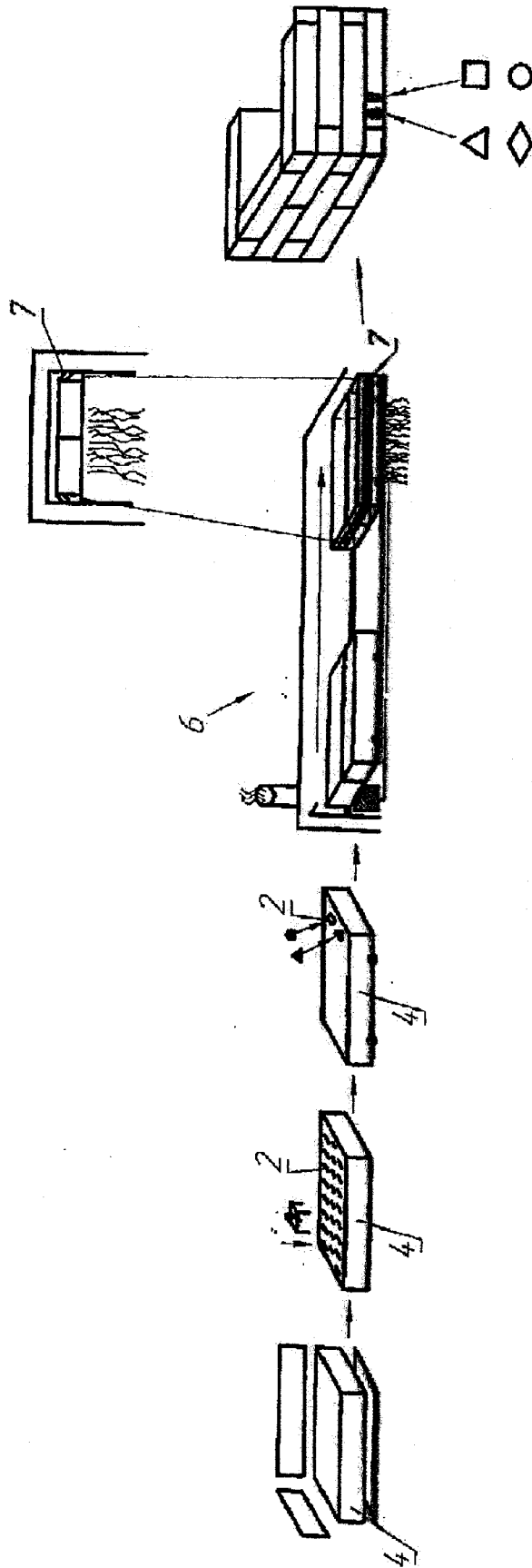


Fig. 3

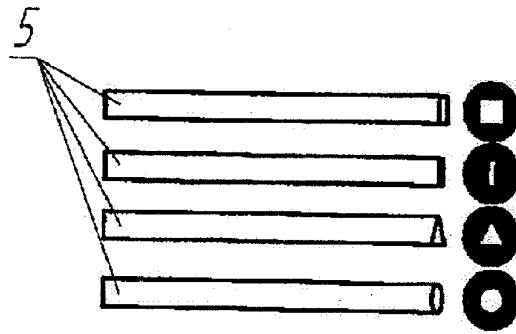


Fig. 4

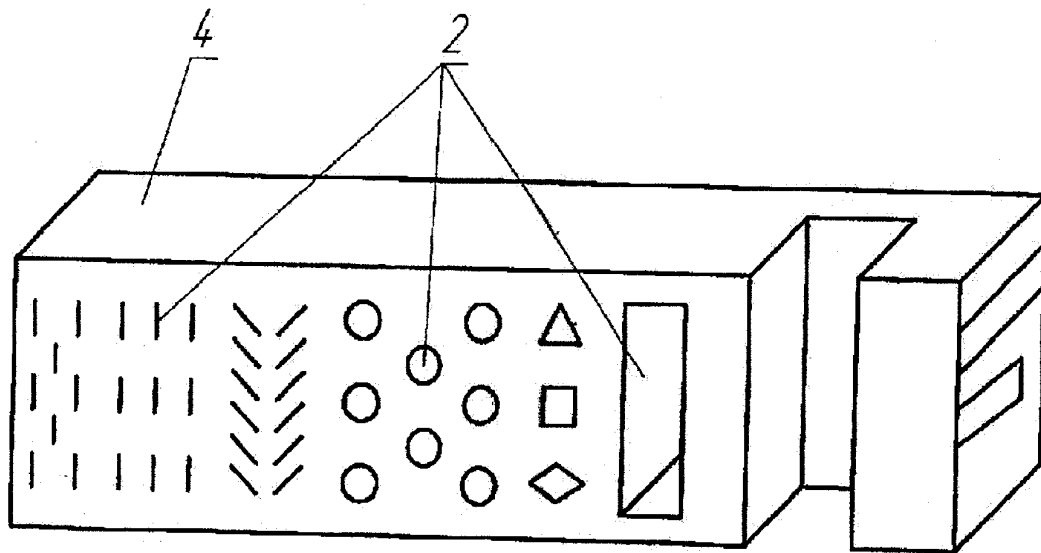


Fig. 5

**GENERAL-PURPOSE METHOD FOR
PRODUCING LARGE-SIZED CERAMIC
PRODUCTS SUCH AS HOUSES OR ROOMS
FROM CLAY, LARGE-SIZED BLOCKS,
BRICKS, AND CEILING SLABS
(EMBODIMENTS)**

FIELD OF THE INVENTION

[0001] The invention relates to the building material industry and to the use of devices and tools of industrial continuous and batch brick kilns.

DESCRIPTION OF THE PRIOR ART

[0002] The existing method for building structures from ceramic bricks is costly and labor-intensive, and carries numerous risks. The risks include inconsistent brick quality, wastage (such as breakage, overburning, and underburning), and loss in carriage and construction.

[0003] A prior art method for building houses from adobe (clay mixed with straw) is advantageous because of its simple techniques and low costs (local materials are used in construction). Houses built with the use of this method have drawbacks such as low moisture resistance and low bearing capacity. These drawbacks are corrected by subjecting a structure to heat treatment (at 700-4,000° C.) that is used to fire ceramic products.

[0004] Another prior art method is used for building houses from clay (adobe) in a sliding formwork by building up the walls. It is disadvantageous, however, because of slow clay drying.

[0005] The traditional process for producing ceramic items comprises shaping an adobe brick, drying it, and firing it. Standard bricks, however, have small dimensions, and building houses from them requires considerable labor inputs and much time.

[0006] A further prior art method for making large-sized cast-in-place ceramic blocks and panels with voids comprises preparing a plastic mass, shaping a bar, cutting up the bar into raw blanks, placing the blanks on a fireproof tray, the blanks in the first row being placed in close contact with one another, their contacting surfaces being covered with a mortar such as cream-like clay, and the blanks in the next row being placed crosswise out of contact with one another so as to produce voids between them, whereupon the rows are alternated until the panel or block attains the required thickness, the tray being then advanced through the passage of a tunnel kiln (see: U.S. Pat. No. 2,035,301, published on May 20, 1995). It takes much time and large labor inputs to place the blanks in position, and the firing process requires a considerable length of time as the blanks have a heavy weight and the voids are closed on all sides to hot air.

SUMMARY OF THE INVENTION

[0007] It is an object of this invention to develop a general-purpose process for producing large-size ceramic items from clay, both houses and other structures, and also very large blocks and slabs, which process allows rapid and high-quality firing to be effected and construction to be accelerated.

[0008] The technical result of this invention consists in simplifying formation of a raw product and accelerating the firing thereof by allowing heated air to enter the product voids.

[0009] This technical result is achieved in a method for producing large-sized ceramic items in a first embodiment of the invention relating to the construction of a house or another structure from clay, wherein blind or through voids covered from outside with a noncombustible material and extending through the body of the walls and ceiling of a clay structure are provided from inside during construction thereof, the windows, doors, and other openings are closed, and the item is fired from inside until it acquires a ceramic condition by allowing hot gas to enter the voids and heating the product body evenly. The voids are spaced at 5 to 15 cm. The exhaust pipe is to be positioned during the firing process so that the inlet end thereof is 50 cm above the floor level.

[0010] This technical result is also achieved in a method for producing large-sized ceramic items according to a second embodiment of this invention relating to the production of large-sized blocks, bricks, and floor slabs, wherein blind or through voids covered from top with a noncombustible material and extending through the item body are provided, and the item is positioned in such a manner that the voids are facing down above the fire so that the item serves as the ceiling of the kiln and is fired by allowing hot gas to enter the voids and heat the item body evenly, the voids being spaced at 5 to 15 cm from one another.

DESCRIPTION OF THE DRAWINGS

[0011] FIG. 1 shows diagrammatically the firing of a house of clay.

[0012] FIG. 2 shows diagrammatically the making of voids during construction of a house.

[0013] FIG. 3 shows diagrammatically the process for producing a large-sized block.

[0014] FIG. 4 shows different types of rods used to make voids.

[0015] FIG. 5 shows a part of a large-sized block provided with voids of different shapes.

DESCRIPTION OF AN EMBODIMENT OF THE
INVENTION

[0016] The method for producing large-sized ceramic items is carried out as follows:

[0017] According to the first embodiment of the invention, a house is constructed from clay in a sliding formwork by building up a wall (see: FIG. 2). As a clay structure 1 (a house or another structure) is built, voids 2, either blind or through, closed on the outside with a noncombustible material, are provided in the body of the walls and ceiling. Once the clay structure is finished, its windows, doorways, and other openings are also closed off with a noncombustible material. The ceiling may rest on supports 3 such as refractory metal girders, although the best supports are clay items (such as large-sized bricks, columns, and the like) that are, upon completion of the firing, removed outside, to the second floor.

[0018] The firing process is carried out from inside. The structure becomes a kiln (combustion chamber) for the duration of the firing process. The exhaust pipe has its inlet at a distance of approximately 50 cm from the floor level (kiln hearth). It is common knowledge that hot air rises while cold air goes down. Accordingly, cooler air will enter the exhaust pipe, so fuel economies will be achieved. The exhaust pipe may be of a knockdown type, or made from metal sheets, asbestos or other noncombustible materials. The pipe is 100

cm in diameter and over 500 cm in height, depending on the quantity of fuel burned per time unit.

[0019] According to the second embodiment of the invention, the same process is used to produce ceramic items of unlimited dimensions and shapes. If the walls of a house plan are divided up into sectors, bricks or blocks, and these large-sized bricks are made and fired separately, the walls of a private house (cottage) can be put up in a single day, provided a crane is used.

[0020] In both embodiments of the invention, voids are formed by wedge rods 5 in low-elasticity (thick) clay.

[0021] As a house is put up, the wedges are inserted into openings of the formwork or forms of desired size, and the formwork is filled with clay that is packed once it has been placed in the formwork. The wedges are withdrawn from the underlying row after another row has been placed over it.

[0022] To make bricks, a form of desired dimensions is filled with clay, whereupon voids are formed in the item body (vertically from top down or from bottom up).

[0023] Voids may be blind, but it is preferred to make them open-ended to accelerate drying. If that is the case, they are covered on top with clay or closed with a metal cap (plug) from outside prior to firing.

[0024] Wedges may be of a replaceable type discarded after use, or be provided with casing rings to prevent deformation of the item when the wedges are removed from clay. Wedges may differ widely in length and shape (circular, square, or triangular in cross-section, or of any other shape). The number and shape of voids may also differ. They may have a vertical and horizontal gradient (10 to 40 degrees).

[0025] A very thick body of clay may create conditions in which the inner layers have not been baked yet while the outer layers have started cracking and melting under the effect of high temperature. For this reason, the thickness of the clay layer between the voids is not to exceed 15 cm. If this condition is met, temperature would be distributed more evenly. As an example, a brick may have a height of 70 cm, thickness between 40 and 50 cm, and length of 210 cm, with voids spaced at 10 cm.

[0026] Voids may also be formed in large-sized bricks by stationary or movable presses.

[0027] After an item 4 has been molded from clay, it is dried in the air for an artistic pattern to be given to it. Molded item 4 (brick, column, or floor slab) is loaded on a truck (wheeled metal frame) and rolled into a kiln 6, in which it continues to be dried, heated, and fired.

[0028] The voids are to face down toward the fire during the firing process. Shutters (flaps) 7 are inserted between the wall of kiln 6 and item 4 to prevent hot kiln air from escaping upward. Moreover, item 4 serves as the kiln ceiling while it is fired. Firing takes place in a natural manner, with hot gas rising from the kiln bottom and penetrating into the voids and heating item 4 evenly.

[0029] This firing method can do without temperature sensors and fans in the kiln. Completion of the firing cycle may be indicated by change in clay color. Clay reddening (whitening) on the outside is a sign that the item has been baked inside and that it can be moved from the firing chamber to the cooling chamber.

[0030] When bricks are placed in position (in a structure), the voids are to be on the face of the wall so that they can be seen from outside. The voids in a fired item may be filled up. If the walls are faced with glass or plastics tiles that transmit solar radiation, the air between the tiles and wall is heated by the radiation and expands into the wall voids, heating the wall body. Heat is, therefore, accumulated and heating energy is saved.

[0031] The invention helps make a building strong (because its components are of a larger size than is accepted as normal) and durable, simplifies the building process, reduces the number of steps needed to put it up, and cuts operating costs.

[0032] The process of this invention suits all purposes since it can be used to build and fire a room, and also to fire large-sized items (bricks) that serve as the kiln ceiling capable of moving when fresh batches of items are to be fired.

What is claimed is:

1. A method for producing large-sized ceramic products comprising making blind or open voids from the inside in the body of the walls and ceiling of a clay house or another structure during construction thereof, said voids being closed from the outside with a noncombustible material; closing the windows, doors, and other openings, and firing the structure from the inside until clay acquires a ceramic condition, hot gas being allowed to expand into the voids and evenly heat the item body.

2. A method as claimed in claim 1, wherein the spaces between the voids are equal to between 5 and 15 cm.

3. A method as claimed in claim 1, wherein the inlet of an exhaust pipe used in the firing process is positioned at 50 cm from the floor level.

4. A method for producing large-sized ceramic products, comprising making blind or open voids in the product body closed on top with a noncombustible material during the production of large-sized blocks, bricks, and ceiling slabs; positioning the item with the voids facing downward over the fire so that the item serves as the kiln ceiling, and firing the item until it acquires a ceramic condition, hot gas being allowed to expand into the voids and evenly heat the item body.

5. A method as claimed in claim 3, wherein the spaces between the voids are equal to between 5 and 15 cm.

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