

Concrete Block Machines And Full Automatic Production Lines

Linyi Brick Mate Machinery Co., Ltd., building construction machinery in Linyi since 1999. Ten machines, from a three-worker manual press to a line moulding twelve hollow blocks every fifteen seconds.



The Range At A Glance

Model	Type	Vibration force	Cycle	Output per 8 hours
QT40-2	Manual Block Machine	30 KN	40 s	2880-3600
QT40-1	Semi Automatic Block Machine	35.5 KN	30 s	5040-6720
QT4-24	Semi Automatic Block Machine	35.5 KN	30 s	5040-6720
QT4-25	Automatic Block Machine	70-90 KN	25 s	4608
QT4-15	Full Automatic Block Machine	-	15-20 s	5000-7000 standard blocks
QT5-15	Full Automatic Block Machine	45-65 KN	15-20 s	9600
QT6-15	Full Automatic Block Machine	50-70 KN	15-20 s	11520
QT8-15	Full Automatic Block Machine	90 KN	15-20 s	15360
QT10-15	Full Automatic Production Line	-	12-25 s	28800-38400
QT12-15	Full Automatic Production Line	102 KN	15-20 s	23040

Output is quoted for the first block size in each machine's own capacity table.

Automatic Concrete Block Machine

Hydraulic, PLC controlled machines and full production lines that mould four to twelve blocks per cycle for plants producing thousands of blocks a shift.



QT4-15 Automatic Concrete Hollow Block Making Machine

Full hydraulic automatic machine producing 5000 to 7000 standard blocks per 8 hour shift from sand, fly ash, slag, gangue or construction waste.

Moulding cycle	15-20 s
Output per 8 hour shift	5000-7000 standard blocks
Moulding system	Full hydraulic with high-frequency vibration
Control	Industrial PLC with colour touch screen and fault self-diagnosis
Control switches	Omron or Schneider
Main motor	Siemens or ABB

QT5-15 Automatic Paver And Block Making Machine

Medium scale automatic plant at 1200 blocks per hour, with a colour machine option for two-layer paving blocks.

Machine overall size	7400 x 1950 x 2800 mm
Power	26.5 KW
Vibration force	45-65 KN
Moulding cycle	15-20 s

Vibration frequency	4600-5200 times/min
Pallet size	1070 x 550 mm

QT6-15 Medium Large Scale Cement Brick Machine

Hydraulic automatic press moulding six hollow blocks per cycle at 40.5 kW, for plants moving into medium large scale output.

Machine overall size	7100 x 1600 x 2610 mm
Power	40.5 KW
Vibration force	50-70 KN
Moulding cycle	15-20 s
Vibration frequency	4600 times/min
Pallet size	900 x 700 mm

QT8-15 Automatic Hollow Block Making Machine

90 kN hydraulic automatic machine moulding eight hollow blocks per cycle, 15360 blocks per 8 hour shift.

Machine overall size	9400 x 2660 x 2880 mm
Power	40.5 KW
Vibration force	90 KN
Moulding cycle	15-20 s
Vibration frequency	2500-4000 times/min
Pallet size	960 x 870 mm

QT10-15 Full Automatic Concrete Block Production Line

Large production line with Siemens, Omron and Yuken components, 90 kN vibration and a published output table across seven block types.

Overall dimension	3500 x 2300 x 2930 mm
Total main machine power	41.25 KW
Single pallet moulding cycle	12-25 s
Vibration frequency	3000-5200 times/min
Excitation vibration force	90 KN
Vibration form	Table integrated vibration

QT12-15 Full Automatic Concrete Block Production Line

Largest line in the range: twelve blocks per cycle, 102 kN vibration and 96000 standard bricks per 8 hour shift.

Machine overall size	9400 x 3060 x 2980 mm
Power	52 KW
Vibration force	102 KN
Moulding cycle	15-20 s
Vibration frequency	2500-4000 times/min
Pallet size	1380 x 880 mm

Semi Auto Concrete Block Machine

Manual and semi automatic presses for a three to four worker crew, shipped assembled and producing as soon as power is connected.



QT40-2 Manual Cement Block Machine

Entry level manual block machine that presses hollow blocks, solid bricks and pavers with three workers and no site installation.

Overall size	1350 x 1460 x 1500 mm
Host machine power	8.8 KW
Production cycle	40 s
Vibration force	30 KN
Pallet size	850 x 450 x 20 mm
Pallet quantity supplied	600 pcs

QT40-1 Semi Auto Cement Block Machine

Conveyor-fed electrical vibration press with a 30 second cycle, sized for a 60 square metre workshop and three to four workers.

Overall size	2060 x 1730 x 1850 mm
Host machine power	13.45 KW
Moulding period	30 s
Vibration force	35.5 KN
Pallet size	850 x 550 x 30 mm
Pallet quantity supplied	600 pcs

QT4-24 Semi Auto Concrete Block Machine

Panel-controlled semi automatic press shipped in a plywood case, built for small scale hollow block, solid block and interlocking paver production.

Overall size	2060 x 1730 x 1850 mm
Host machine power	13.45 KW
Moulding period	30 s
Vibration force	35.5 KN
Pallet size	850 x 550 x 30 mm
Pallet quantity supplied	600 pcs

QT4-25 Automatic Electrical Vibration Block Machine

PLC controlled press combining flat, mould and compression vibration for even density, with automatic plate supply and brick discharge.

Machine overall size	6400 x 1500 x 2700 mm
Power	18.7 KW
Vibration force	70-90 KN
Moulding cycle	25 s
Vibration frequency	2800-4500 times/min
Pallet size	850 x 550 mm

Service And Support

From First Message To Commissioned Block Plant

Buying a block plant is not buying a machine. It is a sequence of decisions about raw material, block size, layout, power, freight and training, and getting one of them wrong is expensive after the container has sailed. This is the sequence we work through with every buyer.

- **Technical consultation.** The sales and technical team review your aggregate, cement, fly ash or slag, the block types you want, target daily capacity, workshop dimensions, local voltage and budget, then recommend matching models.
- **Plant layout and foundation drawing.** Equipment layout plans, machine foundation drawings and batching plant layouts are customised to your factory site free of charge.
- **Raw material test and sample blocks.** Send raw aggregate to the Linyi factory for a free moulding test. Finished block samples, test videos and production parameter reports come back before you order.
- **Technical proposal and quotation.** The quotation lists the vibration motor, hydraulic cylinder, mould frame, feeding hopper, mixing system and electrical control cabinet, with overall dimensions and power consumption, and no hidden fees.
- **Factory inspection.** Airport pick-up and accommodation are arranged for customers visiting the workshop to witness assembly, shot blasting and a real trial run.
- **Container loading and freight.** Loading volume is calculated for 20GP and 40HQ containers, with a spare parts packing scheme and an ocean freight estimate for reference.
- **Installation and commissioning.** Field technicians can be dispatched for installation, mould trial moulding, line commissioning and worker training; the buyer covers flights, accommodation and local transport.
- **Operator training and documentation.** Operation manuals, maintenance handbooks, hydraulic diagrams, electrical circuit drawings, mould replacement guides and wear parts catalogues are supplied in English with every machine.
- **Warranty and long-term support.** 12 months on the main frame, vibration system, drive motors and Siemens PLC from the shipment date, then free technical guidance for the life of the equipment.

Mould And Block Size Customisation

A block machine is a frame around a mould. The mould sets the block size, the number of blocks per cycle and therefore the hourly output, and it is the part that wears. This is how a mould specification is agreed and how it is kept accurate through a long production run.

- **Block drawing.** Moulds are designed from your block drawing and the standard you build to, not from a fixed size list.
- **Blocks per mould.** Every published capacity table states pieces per mould alongside pieces per hour, so the arithmetic is visible - the QT12-15 holds twelve 400 x 200 x 200 mm blocks per cycle.
- **Mould manufacture.** Moulds are cut by precision line cutting and carburised. The QT12-15 mould is published at 54-58 HRC and rated for more than 100,000 uses.
- **Trial moulding.** A free moulding test with your own aggregate produces sample blocks, a test video and a production parameter report before the order is confirmed.
- **Pallet matching.** Pallet size is matched to the machine and mould - 850 x 550 mm on the QT4-25, 1070 x 550 mm on the QT5-15, 1100 x 900 mm on the QT10-15, 1380 x 880 mm on the QT12-15.
- **Mould replacement and upgrade.** Mould replacement is an ongoing service, alongside vibration system reinforcement, automatic batching conversion and control system upgrades.

Raw Material Selection And Mix Design

Machine specifications are fixed; raw material is not. Aggregate quality, cement content and moisture are what change between one plant and the next, and they are what a free moulding test is for. This solution covers how material is assessed before a machine is chosen.

- **Material survey.** Aggregate, cement, fly ash and slag are reviewed at the enquiry stage alongside the block types and the target capacity.
- **Sample despatch.** Clients may send raw aggregate to the Linyi factory for free moulding tests.
- **Trial moulding.** The factory returns finished block samples, test videos and a production parameter report for the block production line.
- **Mix adjustment.** Free technical guidance covers formula adjustment of concrete raw materials, output boosting and production line optimisation for the life of the equipment.
- **Waste stream integration.** Published material lists for the automatic machines include fly ash, slag, coal gangue and recycled construction waste.
- **Curing regime.** Finished blocks are cured naturally with regular water spraying, covered and sheltered from rain to prevent surface damage and cracking.

Spare Parts And Long Term Support

A block machine earns its money over years of continuous vibration, which is hard on bearings, hydraulics and moulds. This is what is documented, what is held in stock, and what the warranty does and does not cover.

- **Documentation.** Operation manuals, maintenance handbooks, hydraulic diagrams, electrical circuit drawings, mould replacement guides and wear parts catalogues ship in English with every machine.
- **Remote support.** Engineers give video call support for assembly, wiring, hydraulic debugging, vibration parameter adjustment, mixer operation and operator training.
- **On-site service.** Field technicians can be dispatched for installation, mould trial moulding, commissioning and worker skill training.
- **Spare parts stock.** Vibration boxes, imported bearings, hydraulic pumps and valves, conveyor belts, mixing blades, moulds, PLC touch screens, frequency converters and servo motors are kept in stock and supplied at factory cost.
- **Warranty.** 12 months on the main machine frame, vibration system, drive motors and Siemens PLC control system from the shipment date. Quick-wear parts and damage from improper operation are excluded.
- **Lifetime technical service.** After the warranty expires the technical team still provides free guidance on fault troubleshooting, raw material formula adjustment, output boosting and line optimisation.
- **Reconstruction and upgrade.** Customised upgrading covers mould replacement, vibration system reinforcement, automatic batching system conversion and control system upgrades.

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