

ABSTRACT OF THE DISCLOSURE
TUNNEL LINER, ITS FABRICATION METHOD, AND ITS
FABRICATION APPARATUS

A tunnel liner used for a shield tunneling method for a tunnel having a diameter of 1.5 to 7 m is fabricated by dividing a ring-shaped liner into a plurality of parts in the circumferential direction. The tunnel liner is required to be excellent in the dimensional accuracy with respect to the outer peripheral surface, to be tight, to be high in strength, and to be high in water tightness at the abutment between the adjacent liners. The tunnel liner is fabricated by a method of filling each arcuate enclosed hollow form with concrete, vibro-compacting concrete, molding the end surfaces of the tunnel liner, mounting the forms within a centrifugal molding drum, and tightly molding the outer peripheral surface of the forms by applying of a centrifugal force. According to this fabrication method, it is possible to effectively fabricate an excellent tunnel liner at a low cost.

Fig. 1