

## Recommendations for Use of Vibrator Weights

Besser Company engineering department suggests that users of 3-at-a-time concrete products machines start out with the following Posapac Weight/Mold combinations. Variations might have to be considered for unusual mold weights or aggregate types.

### **FOR 3-at-a-time POSAPAC USERS**

1. 7500 Lb. weights (ORANGE) for units below 3-5/8" (3.265") high.
2. 7500 Lb. weights for 3-5/8" (3.265") high units (standard weight concrete).
3. 9400 Lb. weights (BLUE) for 3-5/8" (3.265") high units (light weight concrete).
4. 9400 Lb. weights for units between 3-5/8" (3.265") and 7-5/8" (7.625") high.
5. 10200 Lb. weights (YELLOW) for units above 7-5/8" (7.625") high

POSAPAC WEIGHT	2800 RPM CENTRIFUGAL FORCE	COMPARABLE TO
No. 283177 (ORANGE)	7495 Lbs.	Two 3" square x 4-3/4" long eccentric weights
No. 278328 (BLUE)	9400 Lbs.	Two 3" square x 5" long eccentric weights
No. 278329 (YELLOW)	10200 Lbs.	Three 3" square x 4-3/4" long eccentric weights
No. 301697 (WHITE)	6365 Lbs.	Two 3" square x 4-3/4" long eccentric weights
No. 301699 (GREY)	9113 Lbs.	Two 3" square x 4-3/4" long and One 3" square x 4-1/2" long eccentric weights
No. 342539 (GREEN) V-6	13794 Lbs.	Three 3-1/2" square x 5" long eccentric weights
No. 389578 (RED) V-6	15145 Lbs.	Comparison data not available

### **FOR 3-at-a-time SMARTPAC USERS**

1. 6500 Lb. weights (WHITE) for units below 3-5/8" (3.625") high units.
2. 9000 Lb. weights (BLUE) for units between 3-5/8" (3.625") and 7-5/8" (7.625") high units.
3. 11000 Lb. weights (YELLOW) for units above 7-5/8" (7.625") high units.

### **OTHER GUIDELINES**

1. If the weights are too light you may see:
  - a. Longer feed times.
  - b. Lower strength.
2. If the weights are too heavy you may see:
  - a. "Boiling" of the material during feed time.
  - b. Segregation of material within each cavity.

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### **SAFETY BULLETIN**

This notice is issued to advise you that some previously accepted shop practices may not be keeping up with changing Federal and State Safety and Health Standards. Your current shop practices may not emphasize the need for proper precautions to insure safe operation and use of machines, tools, automatic loaders and allied equipment and/or warn against the use of certain solvents or other cleaning substances that are now considered unsafe or prohibited by law. Since many shop practices may not reflect current safety practice and procedures, particularly with regard to the safe operation of equipment, it is important that you review your practices to ensure compliance with Federal and State Safety and Health Standards.

### **IMPORTANT**

The operation of any machine or power-operated device can be extremely hazardous unless proper safety precautions are strictly observed. Observe the following safety precautions:

#### **ALWAYS:**

- ✓ Be sure proper guarding is in place for all pinch, catch, shear, crush, and nip points.
- ✓ Be sure that all personnel are clear of the equipment before starting it.
- ✓ Be sure the equipment is properly grounded.
- ✓ Turn the main electrical panel off and lock it out in accordance with published lockout/tagout procedures prior to making adjustments, repairs, and maintenance.
- ✓ Wear appropriate protective equipment such as safety glasses, safety shoes, hearing protection, and hard hats.
- ✓ Keep chemical and flammable material away from electrical or operating equipment.
- ✓ Maintain a safe work area that is free from slipping and tripping hazards.
- ✓ Be sure appropriate safety devices are used when providing maintenance and repairs to all equipment.

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### **NEVER:**

- ✓ Exceed the rated capacity of a machine or tool.
- ✓ Modify machinery in any way without prior written approval of the Besser Engineering Department.
- ✓ Operate equipment unless proper maintenance has been regularly performed.
- ✓ Operate any equipment if unusual or excessive noise or vibration occurs.
- ✓ Operate any equipment while any part of the body is in the proximity of potentially hazardous areas.
- ✓ Use any toxic flammable substance as a solvent cleaner.
- ✓ Allow the operation or repair of equipment by untrained personnel.
- ✓ Climb or stand on equipment when it is in operation.

It is important that you review Federal and State Safety and Health Standards on a continual basis. All shop supervisors, maintenance personnel, machine operators, tool operators, and any other person involved in the setup, operation, maintenance, repair or adjustment of Besser-built equipment should read and understand this bulletin and Federal and State Safety and Health Standards on which this bulletin is based.