

MASONRY AGING SYSTEM (MAS)

Inline Product Aging



The MAS can age the front, back or front and back of units automatically

The MAS will cost-effectively expand your product line by creating unique unit faces and backs. The MAS can age segmental retaining wall units (SRWs), architectural units (split, fluted, scored, stri-face) and standard block in a wide range of sizes.

The inline Masonry Aging System (MAS) automatically gives the face and/or the back of a concrete masonry unit or segmental retaining wall unit an aged appearance. Aging is totally random and adjustable. A variety of aged looks can be created that will appeal to your marketplace. Three machine operations can be easily changed to create the different looks. The speeds of the impactor heads, the rotation speeds of the clamps and the amount of time the unit is held under the impactor heads can each be adjusted to achieve the appearance you desire.



The MAS is engineered and manufactured to excel in the harsh plant environment

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If you prefer, the MAS can be used offline, powered V-wheels allow it to easily be moved out-of-line.

STANDARD FEATURES

Product Size

- Minimum masonry unit/SRW: 12" wide x 4" high x 8" deep (290 mm x 90 mm x 190 mm)
- Maximum masonry unit/SRW: 24" wide x 8" high x 12" deep (590 mm x 190 mm x 290 mm)

Cycle Time

- 12 seconds (based on 3 at-a-time concrete products machine with 2 units/pallet)

Infeed

- Powered feed conveyor with top clamp separates and meters single units onto the bar feed conveyor
- Bar feed conveyor transfers a single unit into the clamp for processing

Rotation and Transfer Station

- A hydraulic clamp secures the unit, rotates it 90 degrees and holds it under the first impactor head which processes one face. When finished the clamp rotates an additional 90 degrees and releases the unit.
 - Clamp rotation is controlled by an electric motor with variable speed control
- A carriage transfers the unit into a second hydraulic clamp
 - The carriage is operated by a hydraulic actuator
- The second clamp secures the unit and rotates it and holds it under the second impactor head which processes the opposite face
- A carriage transfers the finished unit onto the discharge roller conveyor

Impactor Heads

- Each head has multiple steel impactors that oscillate against the unit creating a random, aged appearance
- Heads are powered by electric motors with variable speed control

Enclosure

- Panels and doors are lined with 2" (50 mm) thick acoustical foam and perforated steel to reduce noise
- Large doors swing open 180 degrees providing easy access for maintenance
- Easy access for manual clean-up beneath the machine
- Provision for 12" (290 mm) diameter dust collection duct

Controls

- Allen-Bradley human machine display/operator interface (HMI) for easy set-up and machine diagnostics
 - Stores nine unit profile recipes

SPECIFICATIONS

Hydraulic Requirement

- 750 psi (51.7 bar) @ 12 gallons (45 liters)/minute peak

Voltage

- 460 V, 3 phase, 60 Hz (other voltages available)

Pneumatic Requirement

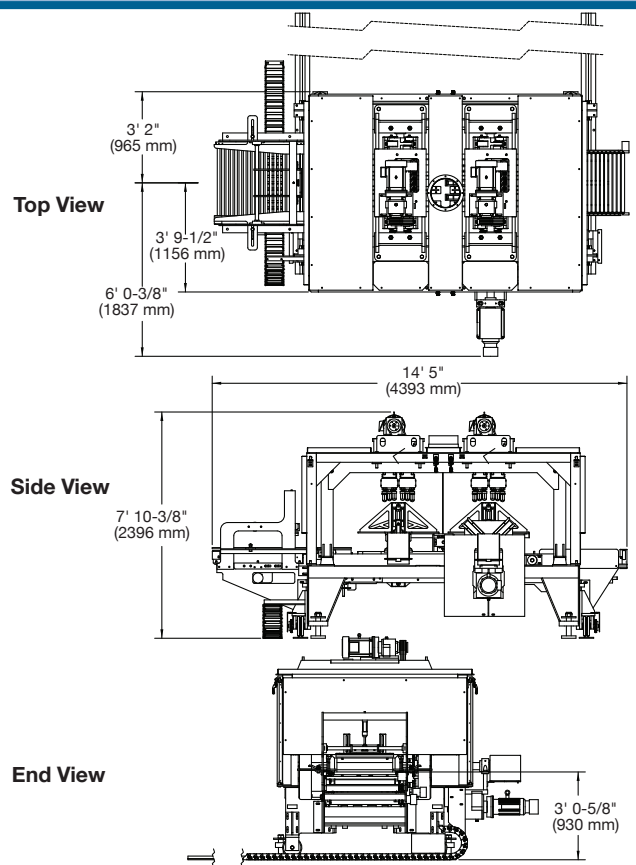
- 80 psi (5.5 bar), 1 cfm (28 lpm)

Shipping Weight

- Estimated, 13,000 lbs (5897 kg)

OPTIONAL ENHANCEMENTS

- Impactors can be manufactured with different designs/shapes on the tip of the heads
 - Changing impactor heads from the standard round tip to an impactor head with a different shaped tip will alter the look of the product being aged. Additional custom appearances can be achieved by intermixing impactor heads with different tip designs.
- Dust collection unit



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