

Adjustments for 5-5/8" High Units on a V-4 or V-4 (26" Deep) Machine

(NOT FOR ULTRAPAC II)

Machine adjustment Besser number 464215-C - dated 25 April 1997

NOTE: This information supersedes all previous machine adjustment sheets number 464215. Please do not reference any of the old number 464215.

This notice is for Ultrapac machine adjustments to produce 5.63" (143 mm) high units in a 6.125" (156 mm) high flat top mold with a 14.19" (360 mm) high stripper head assembly from the 7.625" frame position. (Pallet receiver cam inserts).

PROCESS: The following instructions will put the machine in approximate adjustment without the mold in the machine. Final adjustments will be necessary when concrete masonry units are produced.

Be sure to mechanically lock out all power when working on the concrete products machine. Always follow the safety tips listed in the front of the machine operating instructions.

1. Run machine to first stop and manually lower the auto feed to the lowest position. With the feedbox track support resting on the inner frame boss, disconnect the autofeed linkage at the top.
2. Adjust the inner frame so that the mold throat is 42.75" (1086 mm) above the top of the base plate; 4.375" (111 mm) of frame spacers required. See items 4-9 on page 37 of the Ultrapac operations instructions for detailed procedure.
3. Reconnect autofeed linkage and adjust so that the top of the apron plate is 7.25" (184 mm) above the mold throat at the lowest position of the autofeed.
4. Remove the stripping cam insert from each side of the machine. If pallet receiver inserts part number 460873 and part number 460875 are already installed on the machine then go to Step 7.
5. While at first stop, remove pallet receiver cam inserts part number 460879 and part number 460880 and install part number 460875. Do not change the other pallet receiver cam inserts at this time.
6. Run the machine to second stop and install pallet receiver cam inserts part number 460873 (1st) and part number 460874 (2nd).

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7. If any of the pin positions listed below have to be changed, do so with the machine in the stripped through position (pallet receiver frame resting on the blocking and stripper head frame shock absorbers resting on frame).
 - a. Pallet Receiver Shaft - Position pins in the inside holes (short stroke).
 - b. Stripper Head Shaft - Position pins in the lower holes (short stroke).
 - c. Stripper Head Links - Position pins in the upper holes. Adjust links to obtain approximately 3.74" (95 mm) between link ends.
8. Assemble the finger assemblies to the block moving bars with the fingers above the mounting holes.
9. Run the machine to first stop and remove the pallet receiver frame blocking. Adjust the pallet receiver links to obtain a dimension of 43.375" (1102 mm) from the top of the base plate to the tops of the pallet receiver rubbers.
10. Adjust the upper height stops part number 466804 so that 10.4" (264 mm) extend past the bottom of the castings.
11. Install the 18.5" (470 mm) shock absorbers part number 395992. Adjust the shock absorbers to a dimension of 9.187" (233 mm) from the bottom of the welded clamp block to the bottom of the rubber pad.
12. Install one stripping cam insert part number 464245 on each side of the machine.
13. The Ultracac is now ready for the installation of the mold assembly. Follow the directions for installing a mold attachment (pages 3-6 of the operating instructions). When installing the stripper head, use 14" (317 mm) long bolts part number 087159 and insert 4" (102 mm) of blocking in addition to the 1.5" (38 mm) block already affixed to the stripper head frame.

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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.