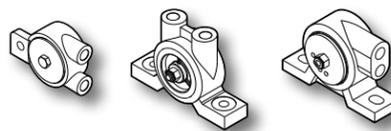




VIBCO INSTRUCTION MANUAL

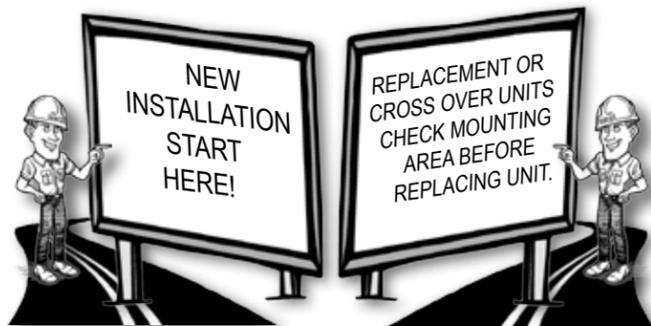


Pneumatic Ball Vibrators

WARNING: Failure to read and follow these installation instructions and safety precautions could result in personal injury, equipment damage, shortened service life or unsatisfactory equipment performance. All information in this document is vital to the proper installation and operation of the equipment. It is important that all personnel who will be coming in contact with this product thoroughly read and understand this manual.

1 START

THANK YOU FOR CHOOSING A VIBCO VIBRATOR!



2 MOUNTING INSTRUCTIONS CHECKLIST

! The warranty is void if vibrator is not properly installed. During installation follow and check off the following steps and your vibrator should provide you with years of trouble-free service.

- FILL OUT WARRANTY CARD!!!!**
- Determine length of channel iron.
- Select thickness of mounting plate & method of mounting.
- STITCH** weld mounting plate to channel iron.
- Determine vibrator placement on bin.
- STITCH** weld channel iron to bin.
- Place vibrator on mounting plate. Secure firmly.
- Install safety chain or wire.
- Connect pneumatics.



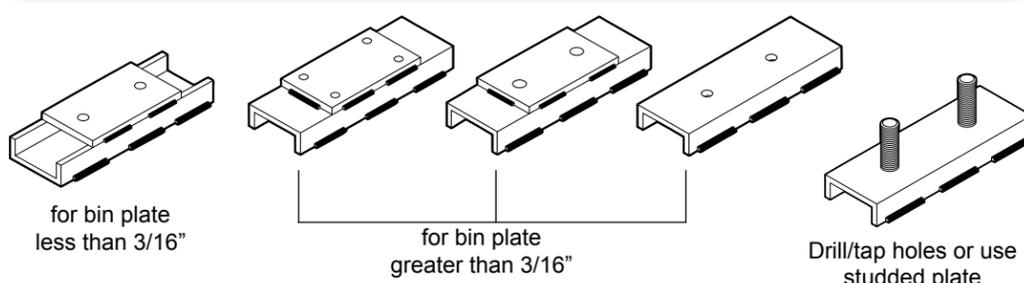
3 PLATES & CHANNEL SELECTION

VIBRATOR FORCE in LBS	MNTNG PLATE THICKNESS	CHANNEL IRON SIZE	FACTOR A
101 - 500	1/4" - 3/8"	3" x 4.1 lbs 3" x 5 lbs	2
501 - 1200	1/2"	4" x 5.4 lbs 4" x 7.5 lbs	3

BIN WALL THICKNESS	FACTOR B
1/8" (10 ga.) or less	6
1/8" - 1/4"	5
1/4" - 3/8"	4
3/8" - 1/2"	3
1/2" & up	2

FACTOR A + B	USE CH. IRON LENGTH
9	5 - 7 FT. (70 - 80%)
8	4 - 6 FT. (60 - 70%)
7	3 - 5 FT. (50 - 60%)
6	2 - 4 FT. (50 - 60%)
5	1 - 2 FT. (50 - 60%)
4	N/A

YOU MUST STITCH WELD MOUNTING PLATE & CHANNEL IRON! NEVER CONTINUOUSLY WELD. STOP WELDS 1" FROM ENDS TO STOP FATIGUE CRACKING.



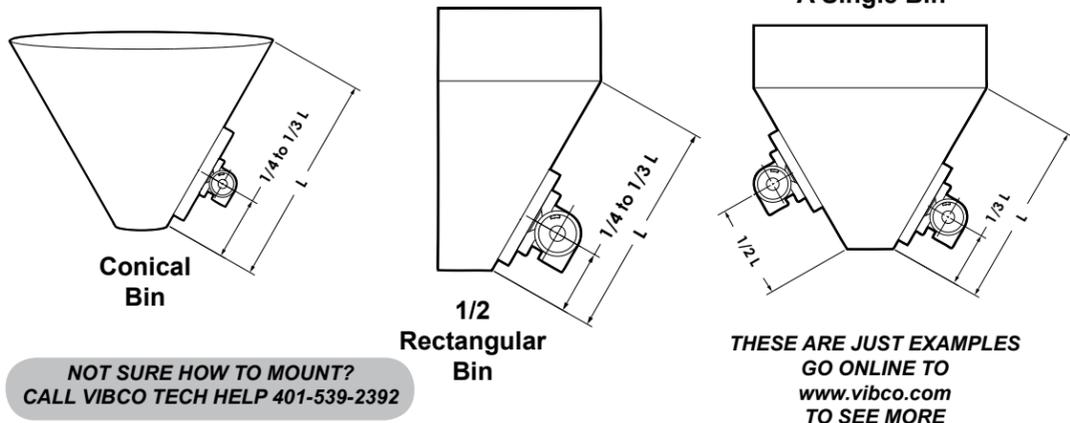
THESE PLATES & CHANNEL LENGTHS ARE FOR MOST COMMON APPLICATIONS. ADDITIONAL INFO FOR OTHER APPLICATIONS AVAILABLE IN FULL DETAIL VERSION OF INSTRUCTIONS ONLINE AT www.vibco.com

NEVER PLACE VIBRATOR DIRECTLY ON SKIN OF BIN OR HOPPER!

NOTE:
1. Longer channel iron will not affect vibrator performance, but total channel length should not exceed length of bin wall.
2. Percentages shown indicate % of bin wall height your channel iron should be for shorter bins.
3. To match your vibrator on chart above, model number suffixes generally correspond to pounds of force generated. For any questions, consult VIBCO.

800-633-0032 for Mounting Plates & Brackets, Spare & Replacement Parts and 24/7 Technical Support

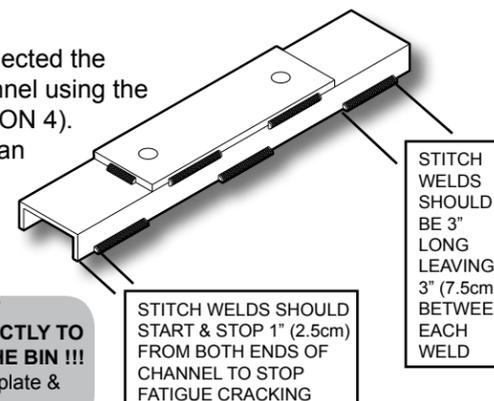
4 VIBRATOR PLACEMENT



THESE ARE JUST EXAMPLES GO ONLINE TO www.vibco.com TO SEE MORE

5 STITCH WELD MOUNTING

Be sure you have selected the proper length of channel using the tables above (SECTION 4). Improper mounting can result in failure of unit or damage to equipment.



! DO NOT MOUNT VIBRATOR DIRECTLY TO SURFACE OF THE BIN !!! Always use mounting plate & channel iron

STITCH WELDS SHOULD START & STOP 1" (2.5cm) FROM BOTH ENDS OF CHANNEL TO STOP FATIGUE CRACKING

STITCH WELDS SHOULD BE 3" LONG LEAVING 3" (7.5cm) BETWEEN EACH WELD

ADDITIONAL DETAILS AVAILABLE ONLINE AT www.vibco.com

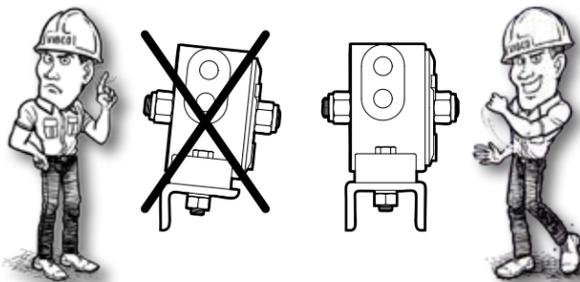
6 BOLTING PROCEDURE

GRADE 5 BOLT SIZE	MAX TORQUE ft-lbs
1/4"	9
5/16"	18
3/8"	32
1/2"	78
5/8"	160
3/4"	260

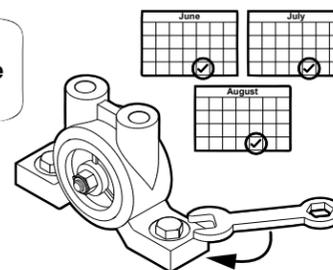
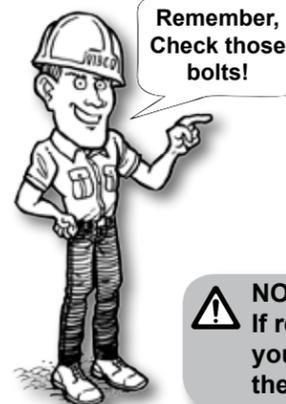
For other bolt grades, please consult VIBCO.

All torque specs are listed as a **WET TORQUE** recommendation. **Loctite 243 Blue** or equal should be used to ensure bolts do not come loose.

! DAMAGE TO THE BIN OR THE VIBRATOR WILL OCCUR IF NOT MOUNTED SECURELY!



Make sure the vibrator is secured tightly. Retighten after the first 10 -15 minutes of operation & check them periodically to maintain proper tightness.



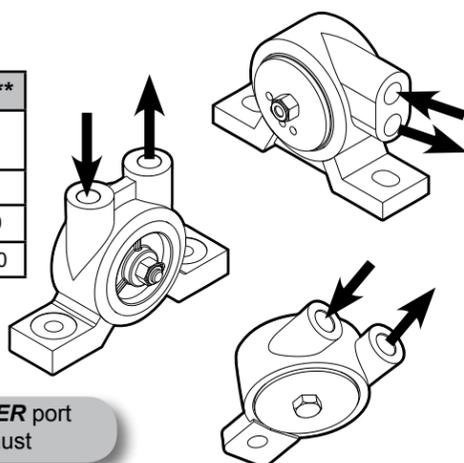
! NOTE: If replacement installation, you **MUST** check the weld on the existing mount first!

7 PNEUMATIC HOOK UP

TO DETERMINE CORRECT AIR HOSE SIZE**			
BALL MODEL NUMBER	MIN AIR HOSE DIA	MIN FRL* THREAD DIA	CFM
100-130	1/8"	1/4"	4 - 6
160-250	1/4"	1/4"	7 - 10
320-380	3/8"	3/8"	10 - 20

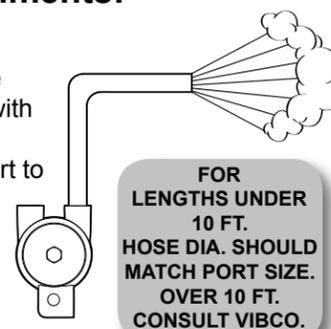
*F=filter R=regulator L=lubricator
**these for installation of single unit; for multiple units adjust to maintain CFM

NOTE: On BB, BV and V models, the smaller **INNER** port is the air inlet and the larger port is the exhaust



NOTE for Clean or Sanitary Environments:

BB & BV models are equipped with a threaded exhaust port to allow for exhaust air to be piped off remotely.



FOR LENGTHS UNDER 10 FT. HOSE DIA. SHOULD MATCH PORT SIZE. OVER 10 FT. CONSULT VIBCO.

8 RESTRAINT

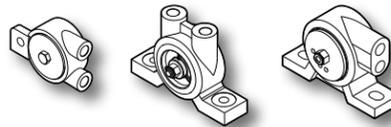


ALWAYS INSTALL SAFETY CHAIN

Mount one end to the vibrator and the other to the hopper or bin **above** the vibrator **NEVER ATTACH CHAIN TO THE MOUNTING PLATE**



VIBCO INSTRUCTION MANUAL



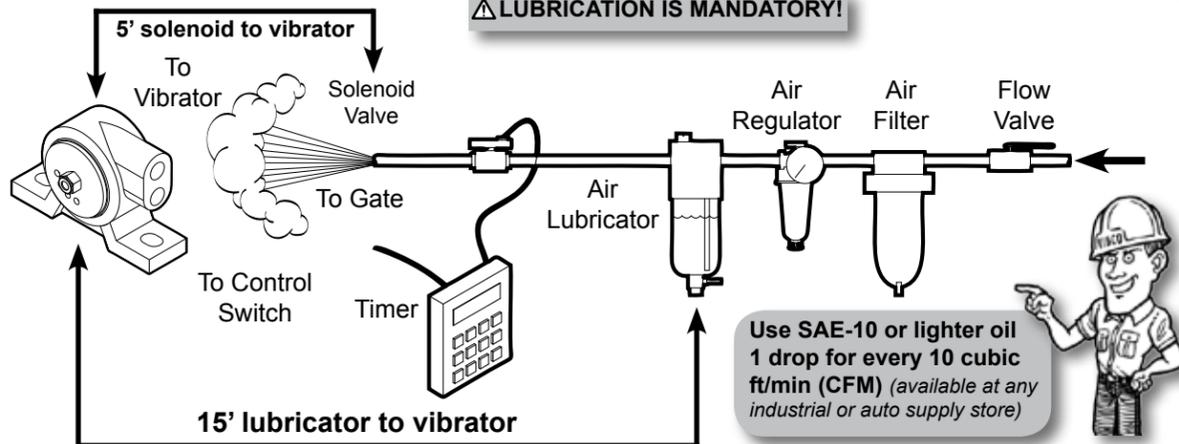
Pneumatic Ball Vibrators

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9 PNEUMATIC INSTALLATION

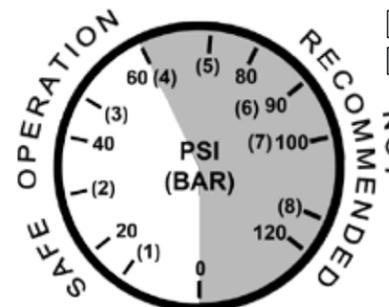
For best performance **DO NOT RUN** vibrators in series off one hose

⚠ LUBRICATION IS MANDATORY!

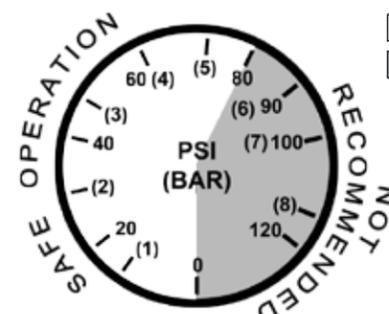


10 OPERATING SPECS

Maximum Air Pressure



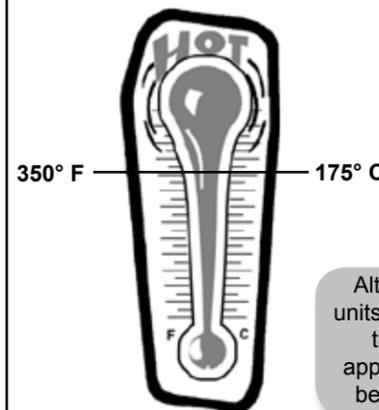
Operating pressure should **not** exceed **60 psi** for BB-100, BB-130, BB-160, BB-190, BV-60, BV-130, V-100 and V-130.



Operating pressure should **not** exceed **80 psi** for V-190, V-250, V-320, V-380, BV-190, BV-250, BV-320 and BV-380 units.



Maximum Temperature



The operating temperature of the vibrator should not exceed **350°F (175°C)**.

Alternative HIGH TEMP units are available. Consult the factory with your application information for best recommendations.

11 TROUBLESHOOTING

MY MATERIAL STILL ISN'T MOVING!

1. Did you put your vibrator in the right location? Did you mount your vibrator properly?
2. Do you have the right vibrator for the job? Does it provide enough force? Is it the right frequency? Still not sure? Call VIBCO Technical Support at 800-633-0032.
3. Do you run the vibrator when the process is stopped? Over running the vibrator can pack material in the bin or hopper. Send us some digital photos to - info@vibco.com - we can help!

THE VIBRATOR WON'T START!

1. Check for dirt, Teflon tape, pipe dope, etc. in the airline, inlet opening or exhaust muffler.
2. Check air line for leakage. Quick disconnect air fittings can leak as well as restrict air flow.
3. Double check the size of your air line - is it large enough to give you the correct cubic feet per minute (CFM) and correct air pressure (minimum required = 20 PSI)? See panel 7
4. Double check to see the air line is attached to the correct port (see #9).

Warranty

All warranty claims must be submitted to VIBCO for approval prior to any repairs being done. Failure to do so will void any and all warranty coverage. All repairs will be done at the VIBCO factory.

Errors, Shortages & Complaints

Complaints concerning goods received or errors should be made at once. Claims must be made within five days after receipt of goods. Clerical errors are subject to correction. Damage during shipping must be reported to the carrier, not VIBCO.

Returning Parts **

Parts should not be returned to VIBCO without prior authorization. Call VIBCO's customer service department at 800-633-0032 (800-465-9709 in Canada) for a Return Goods Authorization (RGA) number. A return authorization will be emailed or faxed to you. Use this as your packing slip. Return shipping must be prepaid. Material returned may be subject to a 10% restocking fee. All returned shipments should clearly display your name, address and original invoice number to ensure proper credit.

** Orders for custom equipment built to customer's specifications are not returnable.

800-633-0032 for Mounting Plates & Brackets, Spare & Replacement Parts and 24/7 Technical Support

Product Changes

VIBCO reserves the right to make changes in pattern, design or materials when deemed necessary, without prior notice or obligation to make corresponding changes in previous models. To be sure of exact mounting dimensions, it is recommended that you obtain a certified dimensional drawing from the factory.

Ordering Spare Parts

Parts can be ordered through authorized distributors or from VIBCO's Spare Parts Department. The following data should be provided when placing your spare parts order:

- From label: Model number of unit.
- From spare parts list: Reference number, part number, description & quantity required.
- Shipping instructions: Specify shipping point and method of shipping.

For custom mounting applications or any other questions:



800-633-0032 or vibrators@vibco.com

