LUBRICATION IS MANDATORY!

1/4 to 1/3 LL

prematurely if the body should be clear of any surfaces are smooth and free from debris. The immediate area

For coarse materials: mount vibrator 1/3 of the distance from the discharge opening to the top of the sloped portion of the bin.

For fine materials: mount two vibrators one on each sloping wall 180° opposite each other for best flow results.

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

1. Check the mounting plate for warping. Secure firmly.
2. Select thickness of mounting plate & method of mounting.
3. STITCH weld mounting plate to channel iron.
4. Determine impactor placement on bin.
5. Weld channel iron to bin.
6. Place impactor on mounting plate.
7. Check the mounting plate for warping. Secure firmly.
8. Install safety chain or wire.
9. Determine length of channel iron.
10. Weld mounting channel & plates
11. Determine impactor placement on bin.
12. Use SAE-10 or lighter oil
13. For Alternate Mounts

NOTE: NEVER PLACE IMPACTOR DIRECTLY ON SKIN OF BIN OR HOPPER!

FOR ALTERNATE MOUNTS refer to full detail instruction manual online at www.vibco.com or call 800-633-0032

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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.

10 OPERATION

Maximum Air Pressure
Operating pressure should not exceed 90 psi unless specially constructed for higher pressure standards by VIBCO.

Maximum Temperature
Operating and ambient temperature should not exceed 200°F (93°C). High temperature units are available, contact VIBCO for specific part number.

Required Lubrication
Lubrication is REQUIRED for the operation of pneumatic piston vibrators. The lubricator should be set to deliver 1 drop for every 10 CFM the vibrator requires. Use SAE-10 oil or lighter.

11 TROUBLESHOOTING

<table>
<thead>
<tr>
<th>PROBLEM</th>
<th>CAUSE</th>
<th>SOLUTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>Inconsistent Start</td>
<td>Dirt causes periodic sticking</td>
<td>Clean thoroughly, install port protectors &amp; air line filters</td>
</tr>
<tr>
<td></td>
<td>Duty cycle too fast for pressure to dissipate</td>
<td>Decrease duty cycle</td>
</tr>
<tr>
<td></td>
<td>Broken spring</td>
<td>Replace spring</td>
</tr>
<tr>
<td></td>
<td>Solenoid valve too far from impactor</td>
<td>Relocate solenoid valve within 5' of piston</td>
</tr>
<tr>
<td></td>
<td>Impactor worn</td>
<td>Consult VIBCO</td>
</tr>
<tr>
<td>Insufficient air</td>
<td>Change spring or change angle of mounting so the piston travels at 30° off horizontal, eliminating the need for spring</td>
<td></td>
</tr>
<tr>
<td>Broken spring</td>
<td>Relocate solenoid valve within 5' of piston</td>
<td></td>
</tr>
<tr>
<td>Solenoid valve too far from impactor</td>
<td>Test by disconnecting air line at impactor, turn on air, then replace line</td>
<td></td>
</tr>
<tr>
<td>Obstruction in air line</td>
<td>Consult VIBCO about High Temp Units</td>
<td></td>
</tr>
<tr>
<td>High ambient heat can expand piston</td>
<td>1. Put approx. 1 tbsp. Kerosene into inlet port, run for 10-15 seconds</td>
<td></td>
</tr>
<tr>
<td></td>
<td>2. Clean thoroughly, rod out piston air passage</td>
<td></td>
</tr>
<tr>
<td>Insufficient Force</td>
<td>Air pressure is set to low</td>
<td>Check accessories &amp; connections for leaks, increase air pressure, confirm cfm with chart in panel 8</td>
</tr>
<tr>
<td></td>
<td>Impactor to small</td>
<td>Use larger model</td>
</tr>
<tr>
<td></td>
<td>Impactor worn</td>
<td>Consult VIBCO</td>
</tr>
<tr>
<td>Mounting Bolt Breakage</td>
<td>Air pressure set too high</td>
<td>Reduce to a maximum of 80 psi</td>
</tr>
<tr>
<td></td>
<td>Incorrect size &amp; type of bolts</td>
<td>Replace with grade #5 bolt, NF, Shank of bolt equal to mounting hole size</td>
</tr>
<tr>
<td></td>
<td>Bolts not tight</td>
<td>Tighten to recommended torque reference chart in section 6</td>
</tr>
<tr>
<td></td>
<td>Irregular mounting surface</td>
<td>Inspect for cracks around the mounting area &amp; repair as needed</td>
</tr>
</tbody>
</table>

Troubleshooting Guide

PROBLEM CAUSE SOLUTION
Inconsistent Start
- Dirt causes periodic sticking
  - Clean thoroughly, install port protectors & air line filters
- Duty cycle too fast for pressure to dissipate
  - Decrease duty cycle
- Broken spring
  - Replace spring
- Solenoid valve too far from impactor
  - Relocate solenoid valve within 5' of piston
- Impactor worn
  - Consult VIBCO

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