

Block Machine Set-up

Machine Cycle Adjustments		Heavy Weight Block - 40#	Medium Weight Block - 28#	Heavy Weight Paver/Slab/Brick	Heavy Weight SRW <6" High	Heavy Weight SRW >6" High	Notes:
Strike Off Plate	Height	1/8" - 1/4"	1/4" - 1/2"	0 - 1/8"	1/8" - 1/4"	1/4" - 3/8"	With SRW consider if it is solid or cored. May have to restrict in wide areas or over the split
	Shape	Flat Plate	Flat Plate	Pipe / Angle on Back	Flat Plate or Angle back	Flat Plate	Can be shaped or segmented for various product mix. It can also be slanted side to side
Agitator Design	Speed	Fast	Medium	Slow or Not Run, Multi-Tier	Medium	Fast	With Slab and Paver product consider a stationary agitator with flat bars to carry the material forward. Angle bars slightly forward. Each row successively higher
	Shape	Standard	Standard	Consider not using or use to carry Material forward	Consider not using	Consider not using	
Agitator Stop	Time (Sec.)	run all way back	Run all the way back	Run a little on way back	Run a little on way back	Run all the way back	Need to experiment with this especially on pavers.
Feed Drawer	Back Speed	Fast / or Slowed	Fast	Slowed	Medium	Slow Slightly Good front Fill	Largely depends on the material flowability. On pavers and slabs this is not as critical as the vibration time and speed For slabs and Pavers consider a short oscillation to better fill the front and create a break plane in the material
	Dwell Time (Sec.)	1.4 - 1.7	1.4 - 1.7	Short not critical, .5 - 1.0	1.2 - 1.5	1.2 - 1.5	
	Oscillation (Y/N)	No	No	Consider a short one	No	If more material is needed	
	Type of Oscillation						

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Double Start	(Y/N)	Sometimes	Likely	Yes	Sometimes	Sometimes	Depending on the down speed of the Compression Cylinder set the restart time (2nd vib.) as the shoes just touch the material
	Vib. Time - Fill (Sec.)	1.0 - 1.5	1.0 - 1.5	Short Burp Critical!	1.0 - 1.5	1.0 - 1.5	
Vibrator Delay Time (Sec.)	Vib. Time - Restart	FD Started over the mold	Slight Delay, FD Started over the mold	FD Fully Forward	FD Fully Forward	FD Started over the mold	If mold front is under filled consider letting the FD get further forward before starting the Vibrator.
Agitator Delay Time (Sec.)		FD Started over the mold	Slight Delay, FD Started over the mold	Slight Delay, FD Fully Forward	FD Fully Forward	FD Started over the mold	Vary as needed to get even fill
Release Time (Sec.)		.3 - .5	.3 - .5	0.01 - 0.1	.2 - .4	.3 - .5	Short, Solid needs less. If block are blowing out increase time by 0.1 sec increments. Should never go above .7 sec.
Pallet Table Air Settings							Low enough for block product to see the air escape from the mold and the pallet. Pallet and Mold should separate rattle Try to stay on the low side to vibrate the material together as long as there are not leaks at the bottom. No separation mold to pallet
	Fill (PSI) Front Back	25 - 40 35 40	25 - 40 35 40	High Air Both	35 - 40, consider High Air	35 - 40	
	Compression (PSI)	60 - 80	60 - 80	60 - 80	60 - 80	60 - 80	

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Compression Beam Air Settings	Compaction (PSI)	40 - 60	40 - 60	40 - 60	40 - 60	60 - 80	Again try to stay on the low side depending on head bounce. Vibrate the material together and do not lock it into Roman Arches.
	Strip (PSI)						
Vibrator Speed (RPM)	Fill	2800 - 3000	2400 - 2800	2000 - 2400	2000 - 2600	2400 - 2800	For low height open molds lower the vib. Speed to avoid boiling of the material. Do testing to determine optimum speed with material and shape parameters determined Maximum Vibrator Speed for shortest compression time.
	Compaction	3000	3000	3000	3000	3000	
Height Release	Height Stops	HS	HS	Timed and/or HS / Use timer as an upper limit	HS	HS	If timed release is used for pavers and slabs you can use the HS to just touch before release for better height control. Note: It is very important that both height stops touch at exactly the same time. Adjust as needed.
	Timed (Slump)						
Push Back Pan Operation	Bottom of Mold						Test to see what works best for the product and material used
	Top Front of Mold	Both	Both	Depends	Top if lip, bottom if not	Top if lip, bottom if not	
	Both						

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Machine Cycle Adjustments		Heavy Weight Block	Light Weight Block	Heavy Weight Paver/Slab/Brick	Heavy Weight SRW <6" High	Heavy Weight SRW >6" High	Notes:
Material Height in Feed Drawer				Lower level works best			Adjust probe to use the least amount of material necessary for every fill cycle.
Desired Compression Time		1.0 - 1.5	1.0 - 1.5	1.0 - 1.5	1.2 - 1.5 consider longer if needed	1.2 - 1.5	Again test and use the lowest compression time that gives the strength required. It may be 1.0 or less
Mold Over Height				consider adding flat bar to front of mold Consider a taller paver mold grid if it is found necessary to add a flat bar to the front or back of the mold.			Check to make sure that the height pins are equal, and flat on contact surfaces. Make sure molds are built on a flat machine surface. Vibration tim (starting)
	Mix Design, moisture, admix						
Mix Materials	Material Flow ability Agg/Cement Ratio Color						
Pallet Table Adjustments	Pallet Table bolt to bushing Adj.						Experiment with settings: Some customers like to set the bolt & bushing so they just touch with the mold in upper most position. Use low pallet table air pressure and fill vibrator speed to vibrate pallet against bottom of mold to enhance fill. Others like to keep a small gap of possible .003 thousands and keep a tight table setting, but lowering the low air for more pallet movement during fill.

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Die Supports & Mold alignment	Die Supports Level Mold alignment with outside and shoes						
Green Conveyor	Pallet Delivery Speed						