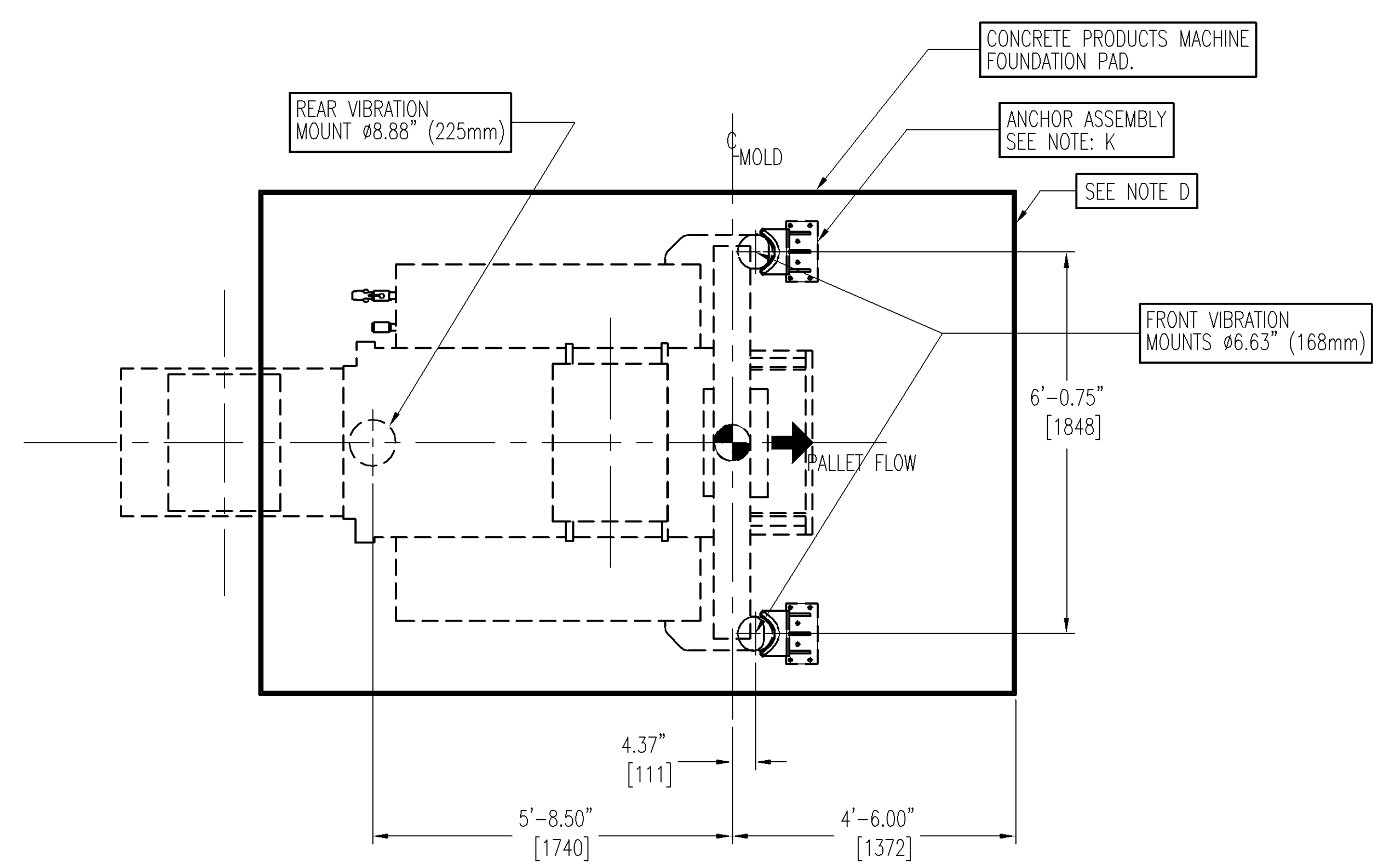


SEE DRAWING 483.10.307 FOR MACHINE MOUNTING AND LEVELING INSTALLATION INSTRUCTIONS.



MAIN CONTROL PANEL/VFD, PUSH-BUTTON STATION, FREE-STANDING VALVE STAND, HYDRAULIC PUMP, CONCRETE PRODUCTS MACHINE & BLOCK MACHINE GUARDING NOT SHOWN IN THIS DRAWING. SEE CUSTOMERS' SPECIFIC LAYOUT.

***** IMPORTANT SAFETY NOTICE *****

DEAR SIR / MADAM,
 WE KNOW YOU WANT TO PROVIDE AS SAFE A WORK ENVIRONMENT AS POSSIBLE FOR YOUR EMPLOYEES. BECAUSE COLUMBIA HAS CHANGED AND IMPROVED THE SAFETY FEATURES OF ALL OUR EQUIPMENT OVER THE YEARS, IT IS HIGHLY LIKELY THAT THE EQUIPMENT IN YOUR FACILITY MAY NOT HAVE THE MOST CURRENT SAFETY FEATURES AVAILABLE, DUE TO ITS VINTAGE. COLUMBIA STANDS READY TO ASSIST YOU WITH UPGRADES THAT ARE DESIGNED TO ENHANCE WORKING CONDITIONS ON OR AROUND YOUR COLUMBIA EQUIPMENT. THIS COULD INCLUDE A VARIETY OF POTENTIAL UPGRADES INCLUDING, BUT NOT LIMITED TO, SOME OF THE FOLLOWING:

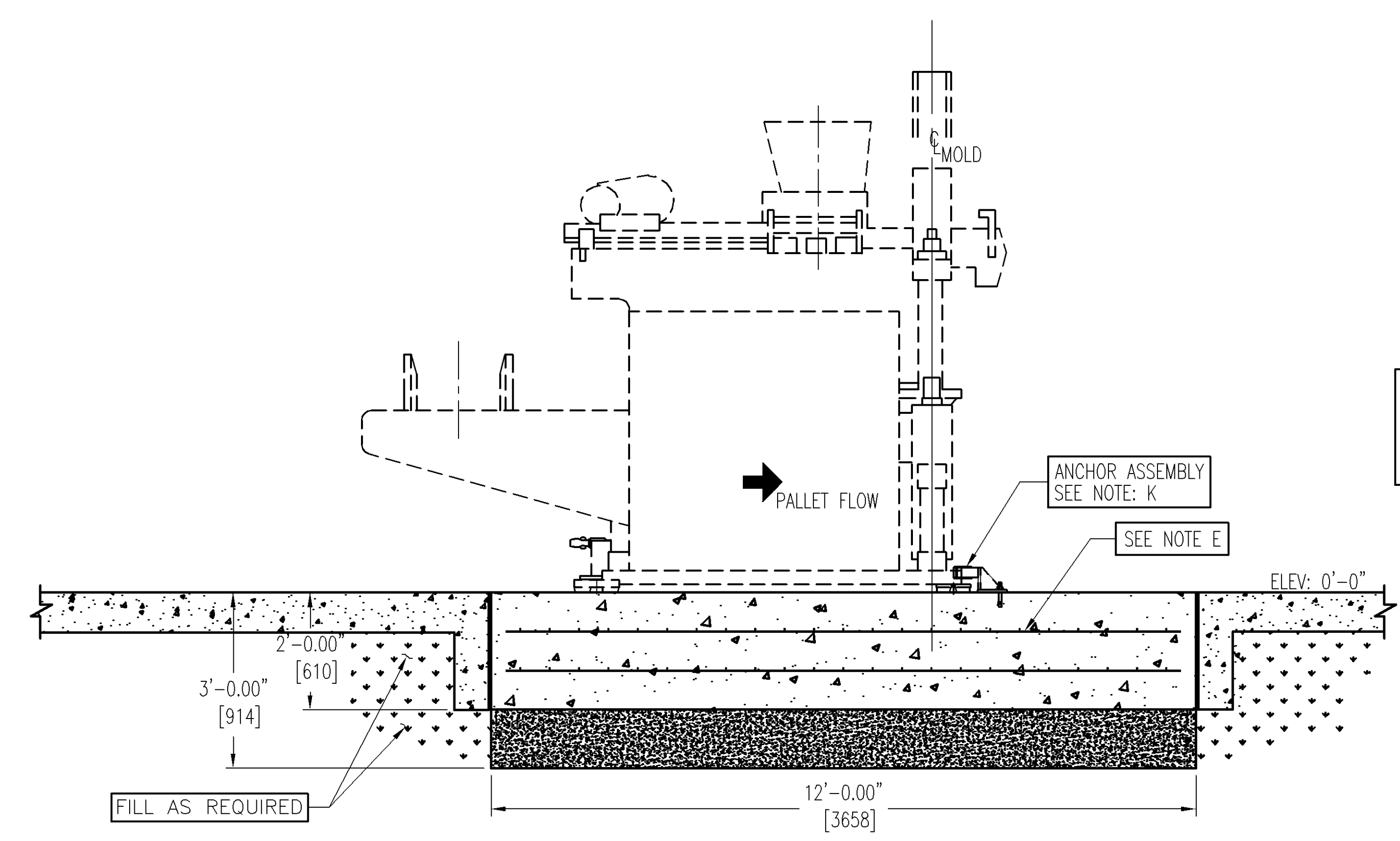
- PERIMETER GUARDING WITH ELECTRICAL INTERLOCKS
- WARNING BEACONS
- LIGHT CURTAINS
- ELECTRICAL DISCONNECTS FOR LOCKOUT/TAGOUT
- SAFETY ACCESS
- NEW SAFETY DECAL SETS

COLUMBIA IS STRONGLY RECOMMENDING THAT YOU CONSIDER CONTACTING COLUMBIA SO THAT WE CAN WORK WITH YOU TO FIND AN ACCEPTABLE SOLUTION TO ADDRESS THIS VINTAGE EQUIPMENT. WE WILL WORK WITH EACH OF YOU TO FIND THE MOST ECONOMICAL WAY TO UPGRADE YOUR EQUIPMENT WITH THE LATEST SAFETY FEATURES.

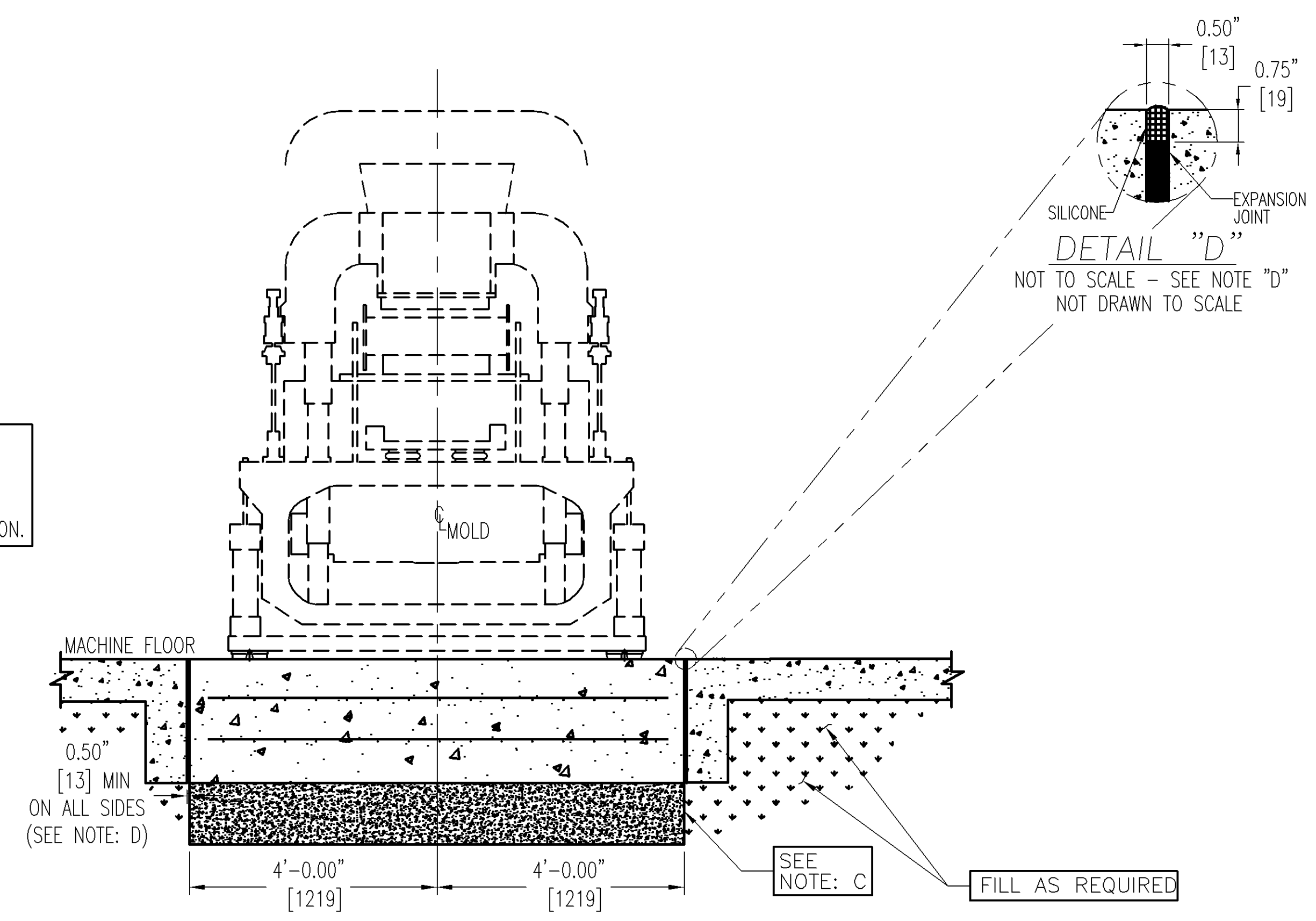
OUR SERVICE AND PARTS DEPARTMENT PERSONNEL ARE READY TO HELP YOU WITH THIS PROCESS, AND WORK THROUGH ALL THE DETAILS. PLEASE CONTACT ANY ONE OF THE PARTS DEPARTMENT TEAM MEMBERS AT (360) 694-1501 AND WE WILL PROVIDE YOU WITH THE QUOTE TO PROPERLY UPGRADE YOUR EQUIPMENT.

THANK YOU FOR YOUR ATTENTION TO THIS IMPORTANT NOTICE, AND IF YOU HAVE ANY QUESTIONS, PLEASE CONTACT US.

- FOUNDATION NOTES:**
- A. CUSTOMER SHALL SUPPLY ALL INSTALLATION LABOR AND MATERIALS. CUSTOMER IS RESPONSIBLE FOR DESIGN AND CONSTRUCTION OF FOUNDATION. CONSULT LOCAL ENGINEER OR ARCHITECT FOR SPECIFIC DETAILS.
 - B. LOCAL SOIL CONDITIONS VARY, CONSULT LOCAL ENGINEER TO SEE IF LARGER OR DEEPER PAD AND/OR BEARING PILES ARE REQUIRED.
 - C. PROPER SOIL COMPACTION IS A MUST, ESPECIALLY IF EXCAVATION HAS BEEN BACKFILLED.
- MACHINE LOADING: (MODEL 16)**
- VIBRATORY LOAD:**
 MASS = 18,600 LB (8,437 KG) (STATIC LOAD)
 FREQUENCY RANGE IS 33HZ TO 50HZ
 MACHINE BASE AMPLITUDE IS 0.010" (0.254mm) PEAK TO PEAK
 (NOTE: MACHINE BASE IS SUPPORTED ON ON ELASTOMERIC MOUNTING PADS)
- IMPACT LOADS:**
 MASS = 2,100 LB (953 KG)
 VELOCITY = 35 IN PER SEC. (88.9 cm/sec.)
 DECELERATION DISTANCE = 1.0" (25.4 mm) UP AND 1.50" (38.1 mm) DOWN
- D. USE VIBRATION ABSORBING EXPANSION JOINT AROUND ENTIRE PERIMETER OF CONCRETE FOUNDATION PAD, ON THE FULL DEPTH OF THE PAD, 1/2" (13mm) MINIMUM THICKNESS. NEOPRENE RUBBER MATERIAL SUGGESTED WITH DUROMETER HARDNESS OF 80. STOP ISOLATION JOINT 3/4" (19 mm) FROM TOP OF PAD TO ALLOW FOR SILICONE FILL AROUND ENTIRE PERIMETER. CONSULT LOCAL ENGINEER FOR SPECIFIC DETAILS.
 - E. REINFORCEMENT BAR IS RECOMMENDED. CONSULT LOCAL ENGINEER FOR DETAILS.
 - F. FOUNDATION PADS TO 3,000 P.S.I. (20,684 kPa) CONCRETE.
 - G. FLOOR IN FRONT AND BACK OF BLOCK MACHINE SHOULD NOT SLOPE MORE THAN 3/8" (10 mm) PER 20'-0" (6,096mm) OF HORIZONTAL RUN.
 - H. SURFACE TEXTURE OF CONCRETE SHOULD HAVE A TROWELED FINISH (NOT SMOOTH)
 - J. ELECTRICAL CONDUITS, AIR SUPPLY LINES, OR HYDRAULIC PIPING SHOULD NOT PASS THROUGH OR UNDER BLOCK MACHINE FOUNDATION PAD.
 - K. MANDATORY, NOT OPTIONAL, 12" (305 mm) @ 95% OF MAXIMUM COMPACTION CRUSHED GRAVEL ONLY, WITH PARTICLE SIZE RANGE OF 1/16" (2 mm) TO 3/8" (10 mm).
 - L. INSTALL ANCHOR ASSEMBLIES AFTER MACHINE HAS BEEN POSITIONED. USE HOLES AS GUIDES TO DRILL 0.63" (16 mm) DIA x 3.38" (86 mm) DEEP HOLES.



IMPORTANT:
 PIPING FOR HYDRAULIC LINES AND ELECTRICAL CONDUITS MUST NOT PASS THROUGH OR UNDER CONCRETE PRODUCTS MACHINE FOUNDATION.



VALID FOR ALL PALLET SIZES

MODEL 16 CONCRETE PRODUCTS MACHINE

<table border="1"> <tr> <td>PRELIMINARY DWG: <input type="checkbox"/></td> <td>DWG FOR APPROVAL: <input type="checkbox"/></td> <td colspan="2">THIS DRAWING AND ITS PRINCIPLES OF DESIGN CONTAINS PROPRIETARY AND CONFIDENTIAL INFORMATION OF COLUMBIA MACHINE, INC. DESIGN NOT TO BE USED, COPIED OR DISCLOSED WITHOUT WRITTEN PERMISSION. PROTECTED UNDER U.S. AND FOREIGN COPYRIGHT LAW. ALL RIGHTS RESERVED.</td> </tr> <tr> <td>NOTE: ALL DIMENSIONS ARE PRELIMINARY AND SUBJECT TO FINAL DESIGN CHANGES BY COLUMBIA MACHINE INC. AS WELL AS APPROVAL OF THE DRAWING BY CUSTOMER.</td> <td>SALES ORDER #:</td> <td colspan="2">COLUMBIA MACHINE, INC. VANCOUVER, WA 98661 APPLICATION ENGINEERING</td> </tr> </table>				PRELIMINARY DWG: <input type="checkbox"/>	DWG FOR APPROVAL: <input type="checkbox"/>	THIS DRAWING AND ITS PRINCIPLES OF DESIGN CONTAINS PROPRIETARY AND CONFIDENTIAL INFORMATION OF COLUMBIA MACHINE, INC. DESIGN NOT TO BE USED, COPIED OR DISCLOSED WITHOUT WRITTEN PERMISSION. PROTECTED UNDER U.S. AND FOREIGN COPYRIGHT LAW. ALL RIGHTS RESERVED.		NOTE: ALL DIMENSIONS ARE PRELIMINARY AND SUBJECT TO FINAL DESIGN CHANGES BY COLUMBIA MACHINE INC. AS WELL AS APPROVAL OF THE DRAWING BY CUSTOMER.	SALES ORDER #:	COLUMBIA MACHINE, INC. VANCOUVER, WA 98661 APPLICATION ENGINEERING		<table border="1"> <tr> <td colspan="2">CUSTOMER USE</td> <td colspan="2">INSTALLATION DRAWING</td> <td>DRAWN BY:</td> <td>REFERENCE:</td> <td>APPROVAL DATE:</td> </tr> <tr> <td colspan="2"></td> <td colspan="2">FOUNDATION PAD & VIBRATION MOUNT</td> <td>I.S.</td> <td>326-6413-1</td> <td>*</td> </tr> <tr> <td colspan="2"></td> <td colspan="2">MODEL 16 CONCRETE PRODUCTS MACHINE</td> <td>ENGINEER:</td> <td>DATE:</td> <td>REV. SCALE</td> </tr> <tr> <td colspan="2"></td> <td colspan="2">STANDARD INSTALLATION LAYOUT (1980 TO PRESENT)</td> <td>I.S.</td> <td>MAY 13, 2013</td> <td>DO NOT SCALE</td> </tr> <tr> <td colspan="2"></td> <td>SIZE DWG NO:</td> <td>REV.</td> <td colspan="3">SHEET</td> </tr> <tr> <td colspan="2"></td> <td>D</td> <td>0</td> <td colspan="3">1 OF 1</td> </tr> </table>				CUSTOMER USE		INSTALLATION DRAWING		DRAWN BY:	REFERENCE:	APPROVAL DATE:			FOUNDATION PAD & VIBRATION MOUNT		I.S.	326-6413-1	*			MODEL 16 CONCRETE PRODUCTS MACHINE		ENGINEER:	DATE:	REV. SCALE			STANDARD INSTALLATION LAYOUT (1980 TO PRESENT)		I.S.	MAY 13, 2013	DO NOT SCALE			SIZE DWG NO:	REV.	SHEET					D	0	1 OF 1		
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