

Concrete Products Production Schedule

A.) MODEL 15

Pallet Size (Front to Back)	Cycles / Min. (Production)	Sec. / Cycle (Production)
19"	5.0	12.0

B.) MODEL 22HF, 22HFB

Pallet Size (Front to Back)	Cycles / Min. (Production)	Sec. / Cycle (Production)
18"	7.8	7.7
22"	7.2	8.3

C.) MODEL 16HF

Pallet Size (Front to back)	Cycles / Min. (Production)	Sec. / Cycle (Production)
18 - ½"	7.5	8.0
21 - 5/8"	7.0	8.6
26"	6.4	9.4

D.) MODEL 1600HF

Pallet Size (Front to Back)	Cycles / Min (Production)	Sec. / Cycle (Production)
18 - ½"	7.5	8.0

E.) MODEL 30 (Discontinued in 96' Price Book)

Pallet Size (Front to Back)	Cycles / Min (Production)	Sec. / Cycle (Production)
18 - ½"	7.0	8.5
21 - 5/8"	6.5	9.2
26"	6.0	10.0

F.) MODEL 40 (Discontinued in 96' Price Book)

Pallet Size (Front to Back)	Cycles / Min. (Production)	Sec. / Cycle (Production)
18 - ½"	7.0	8.5
21 - 5/8"	6.5	9.2
26"	6.0	10.0

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G.) MODEL 50 (Discontinued in 96' Price Book)

Pallet Size (Front to Back)	Cycles / Min. (Production)	Sec. / Cycle (Production)
18- ½ "	6.6	9.0
21-5/8"	6.1	9.8
26"	5.5	10.8

H.) MODEL 60 (Discontinued in '96 Price Book)

Pallet Size (Front to Back)	Cycles / Min. (Production)	Sec./ Cycle (Production)
18 – ½"	6.6	9.0
21 - 5/8"	6.1	9.8
26"	5.5	10.8

I.) MODEL CPM40

Pallet Size (Front to Back)	Cycles / Min. (Production)	Sec. / Cycle (Production)
18 – 1/2 "	8.0	7.5
21 – 5/8"	7.5	8.0
26"	7.0	8.6

J.) MODEL CPM50

Pallet Size (Front to Back)	Cycles / Min. (Production)	Sec. / Cycle (Production)
18 – ½"	8.0	7.5
21 – 5/8"	7.5	8.0
26"	7.0	8.6

K.) MODEL CPM60

Pallet Size (Front to Back)	Cycles / Min. (Production)	Sec. / Cycle (Production)
18 – ½"	8.0	7.5
21 – 5/8"	7.5	8.0
26"	7.0	8.6

Production Output @ 100 % efficiency, no core puller, no front feed drawer, no feed drawer oscillations, producing standard 8" x 8" x 16" (200mm x 400) hollow block. Additions for front feed drawer and core puller are at the end of this document.

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SPECIALS: The following times should be added when making a typical with the following equip.:

Cycle Time with **Core Puller:**

Pallet Size	Cycle Time Increase (Sec. / Cycle)
18 – ½"	1.5 Sec.
21 – 5/8"	1.8 Sec.
26" / 27"	2.2 Sec.

Cycle Time with **Front Feed Drawer:**

Pallet Size	Cycle Time Increase (Sec. / Cycle) w/o Compaction	Cycle Time Increase (Sec. / Cycle) with Compaction
18 – ½"	1.5 sec.	4.5 sec.
21-5/8"	1.8 sec.	5.0 sec.
26" / 27"	2.2 sec.	5.6 sec.