

**KNOWLEDGE BASE**Article Type: **Instructions****Mold Installation for: Models
22HF, 16HF, 1600,
Pit Models 10, 12, 22, 16.****Description:**

Instructions on “How to” properly install a mold in machine models;
Floor Level – 22HF, 16HF and 1600, Pit Models – 10, 12, 22, and 16.

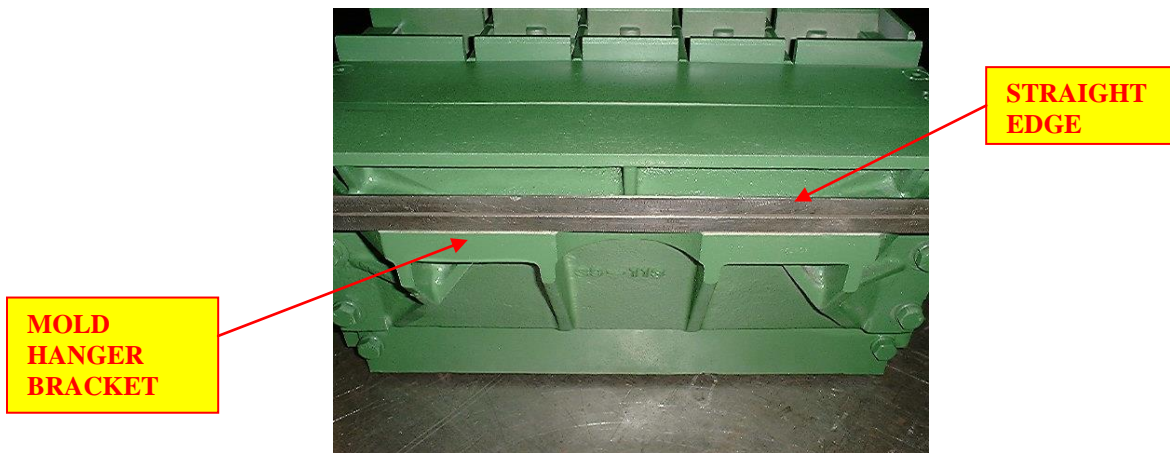
WARNING

Never work on, clean or service this unit, control panel or any machine or open or remove any protective cover, guard, grate, door, or maintenance panel until the power or energy sources has been turned off, locked out / tagged out, and all moving parts have come to a complete stop and or blocked to prevent movement. Machinery is dangerous - avoid personal injury and or death by following manufacture, Local, and OSHA safety procedures. Contact Columbia Machine for safety decals, guards, horns and beacons.

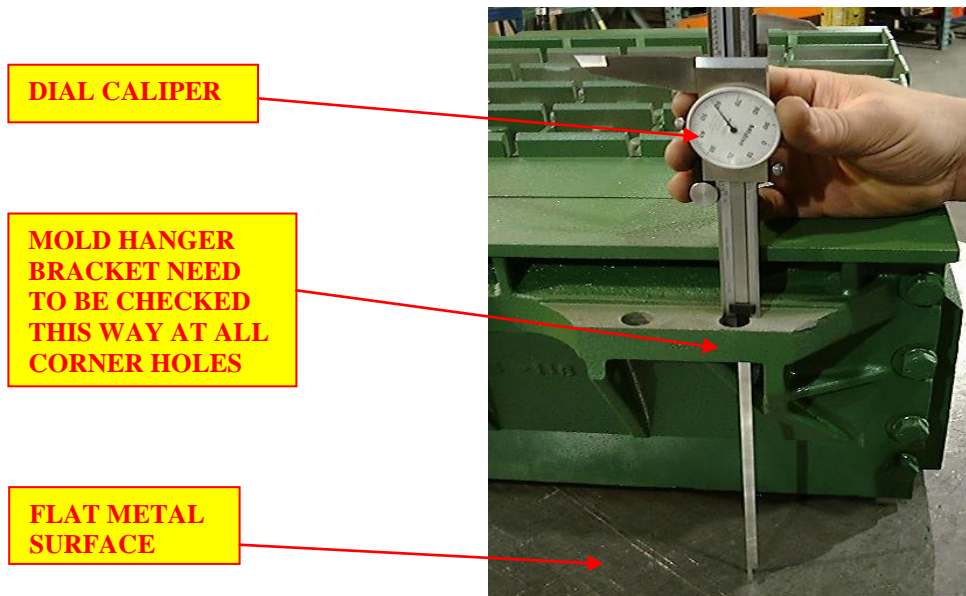
Mold Installation for Model 22,16,1600

We have found in recent months that block machine operators are installing the mold improperly. This improper installation practice will cause unnecessary wear on mold hanger bracket and the die supports.

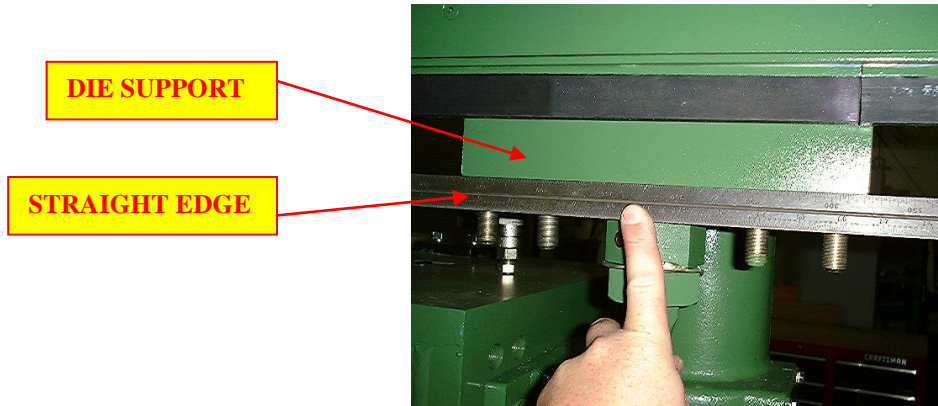
1. Assemble the mold on a very flat surface, such as a machined flat steel table. Do not assemble molds on steel pallets from the machine or on wooden surfaces.
2. Inspect mold hanger brackets for flatness by using a straight edge. Replace any brackets showing signs of wear on mounting surface.



3. To make sure the mold hanger brackets are installed correctly, measure all four corners using a dial caliper, as shown, using the outer holes. Verify measurement of all four corners are the same.



4. Next, using a straight edge, inspect the die supports for flatness. Verify the mounting surfaces are flat; this allows the mold to mount flat against the die supports. If these surfaces are not flat, they can cause the mold to break bolts, or worse, cause the vibrator shaft to fail.



After inspecting the mold, replacing parts, and realign, install the mold.

1. Install the mold box by sliding it past the shaker shafts. Do this without hitting the shaker shafts. Verify the die supports, and mold hanger brackets are clean.
2. Raise the mold slowly up to the die supports with the machine in slow mode.
3. Align mold with mounting bolts and raise mold up to the die support.
4. Install all lock-washers and nuts. Now, tighten all nuts by torquing them to factory specifications;

Torqued to: (Model 22: 1/2" bolts (**grade 8 fine thread**) - 90 foot-pounds),
(Model 16, 1600: 5/8" bolts (**grade 8 fine thread** - 187 foot-pounds),
(Nuts are: (**grade 8 fine thread "high nuts"**))

WARNING

Completely tighten the mold in the machine before operating the vibrator. Operating the vibrator with a loose mold causes damage to die supports and mold hanger brackets.