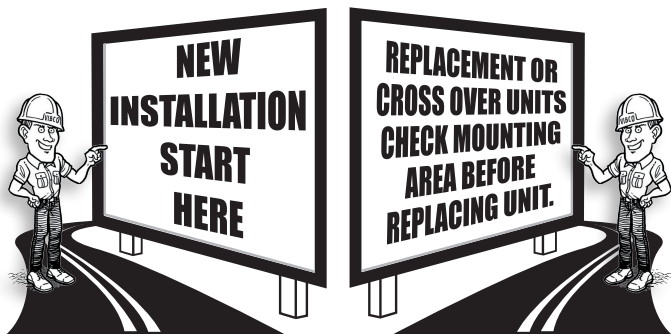


WARNING: Failure to read and follow these installation instructions and safety precautions could result in personal injury, equipment damage, shortened service life or unsatisfactory equipment performance. Personal Protection Equipment is advised. All information in this document is vital to the proper 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.

1 START

**THANK YOU FOR CHOOSING
A VIBCO VIBRATOR!**



2 MOUNTING INSTRUCTION CHECKLIST



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

- ☐ Determine length of channel iron, box 3.
- ☐ Select thickness of mounting plate & method of mounting, box 3-4 & 7.
- ☐ STITCH weld mounting plate to channel iron, box 5.
- ☐ Determine vibrator placement on bin, box 4.
- ☐ STITCH weld channel iron to bin, box 5.
- ☐ Place vibrator on mounting plate, box 8, secure firmly.
- ☐ Install safety chain or wire, box 6.
- ☐ Connect pneumatics & check for leaks box 9-12.
- ☐ FILL OUT WARRANTY CARD & MAIL IN!!!!



**DON'T FORGET TO MAIL
IN YOUR WARRANTY
CARD!**

ADDITIONAL DETAILS AVAILABLE ONLINE AT www.vibco.com

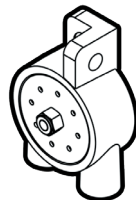
3 MOUNTING PLATES & CHANNEL IRONS

VIBRATOR FORCE	MOUNTING PLATE THICKNESS	CHANNEL WIDTH	BIN/HOPPER WALL THICKNESS			
			1/16" - 1/8"	1/8" - 1/4"	1/4" - 3/8"	3/8" - 1/2"
			SUGGESTED CHANNEL LENGTH*			
Up to 100 lbs.	1/4"	2"	36" - 30"	24" - 20"	18" - 12"	NA
101 to 500 lbs.	3/8" - 1/2"	3"	48" - 40"	36" - 30"	24" - 20"	18" - 12"
Over 500 lbs.	1/2"	4"	60" - 50"	48" - 40"	36" - 30"	24" - 20"

* If sloped wall is shorter than the suggested channel length make the channel length 70% - 80% of wall dimension.

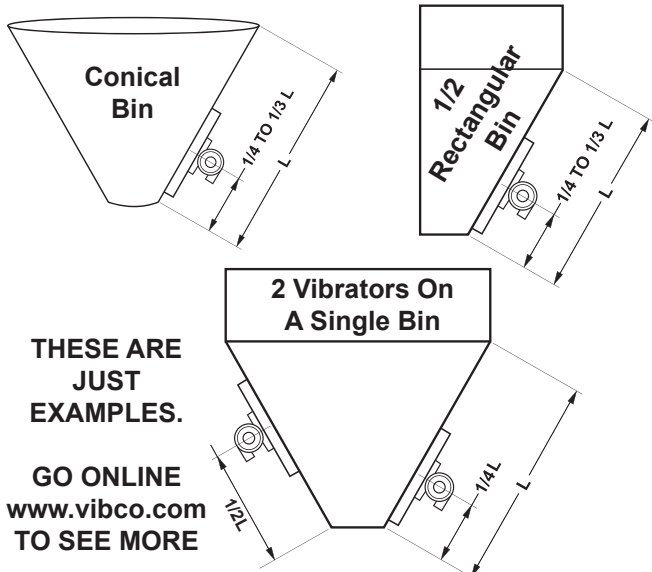


NEVER PLACE VIBRATOR DIRECTLY ON SKIN OF BIN OR HOPPER!



*Flange style mounting
requires only one bolt to
mount. Mounting locations
will vary depending on
application.*

4 VIBRATOR PLACEMENT

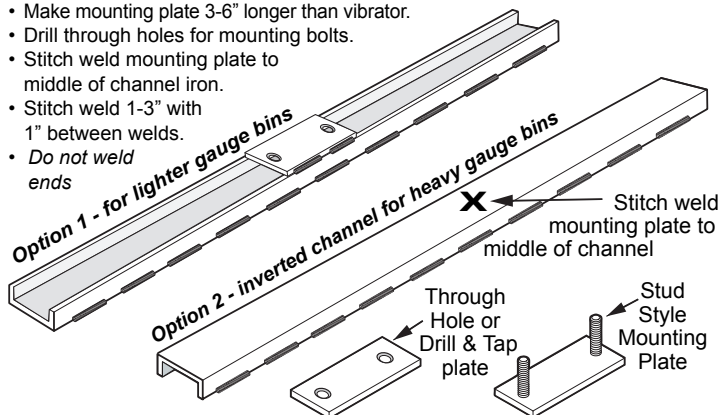


THESE ARE
JUST
EXAMPLES.

GO ONLINE
www.vibco.com
TO SEE MORE

5 STITCH WELD MOUNTING

- Make mounting plate 3-6" longer than vibrator.
- Drill through holes for mounting bolts.
- Stitch weld mounting plate to middle of channel iron.
- Stitch weld 1-3" with 1" between welds.
- Do not weld ends



Use the proper alloy rod or wire when welding channel to bin. Using the wrong alloy can cause stress cracking in the welds. This is really a factor when welding a carbon steel channel to a Stainless Steel hopper. AR plate needs pre heating and proper alloy filler metal.



YOU MUST STITCH WELD
Mounting Plate & Channel Iron!

- **NEVER CONTINUOUSLY WELD** Stitch weld 3"- 6" long with 3" between welds.
- **STOP WELDS 1" FROM ENDS** to avoid the start of weld fatigue cracks.
- **NEVER PLACE VIBRATOR** directly on skin of bin or hopper.
- **NEVER WELD TO HOPPERS FULL** of flammable products
- **NEVER WELD IN DUSTY AREAS.**

Vibco recommends using one of our engineered mounting systems for best force transfer. You must use a mounting plate to avoid cracking out the channel web. The plate should match the width of the channel.

MOUNTING PLATES, CHANNEL IRON & ACCESSORIES AVAILABLE FROM VIBCO OR LOCAL DEALER

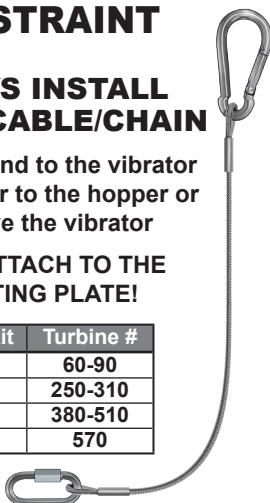
6 RESTRAINT

**ALWAYS INSTALL
SAFETY CABLE/CHAIN**

Mount one end to the vibrator
and the other to the hopper or
bin above the vibrator

**NEVER ATTACH TO THE
MOUNTING PLATE!**

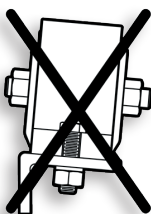
Safety Kit	Turbine #
SCT2	60-90
SCT3	250-310
SCT4	380-510
SCT5	570



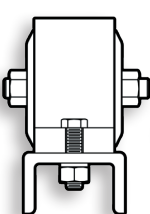
7 MOUNTING OF VIBRATOR



**DAMAGE TO THE BIN AND THE
VIBRATOR CAN OCCUR IF NOT
MOUNTED SECURELY OR IF VIBRATION
RUNS WITH NO PRODUCT IN THE BIN.**



Angle Iron



Channel Iron



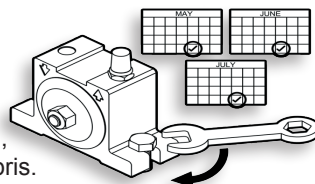
8 BOLTING PROCEDURE

Make sure the vibrator is
secured tightly. Retighten
after the first 10 -15 minutes
of operation & check them
periodically to maintain
proper tightness.

**Remember
Check those
bolts!**



Be sure
surfaces are smooth,
flat & free of any debris.



9 AIR HOSE



**TAPERED THREADS!!
DO NOT OVER TIGHTEN FITTINGS.**

TO DETERMINE CORRECT AIR HOSE SIZE***

TURBINE MODEL #	MIN. HOSE OR TUBING I.D.*	MIN FR** THREAD DIA.	CFM
100 - 130	1/8"	1/4"	4 - 6
160 - 250	1/4"	1/4"	7 - 10
320 - 380	3/8"	3/8"	10 - 18
440 - 510	1/2"	1/2"	18 - 21
570	3/4"	3/4"	21 - 30

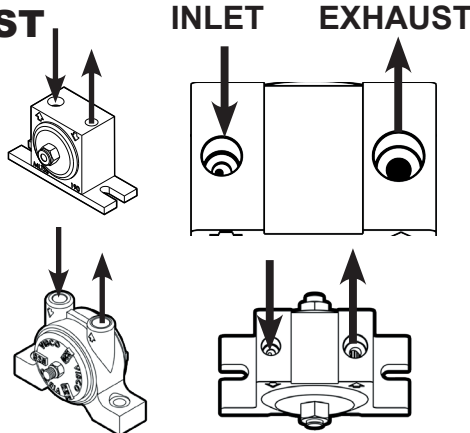
* Inside Diameter - Note: Hose is typically sized by INSIDE diameter, Tubing is sized by OUTSIDE diameter

** F=filter *** these specs are for the installation of a single unit; for multiple units, varying hose lengths, etc. adjust air to maintain CFM. Call technical support for more details.

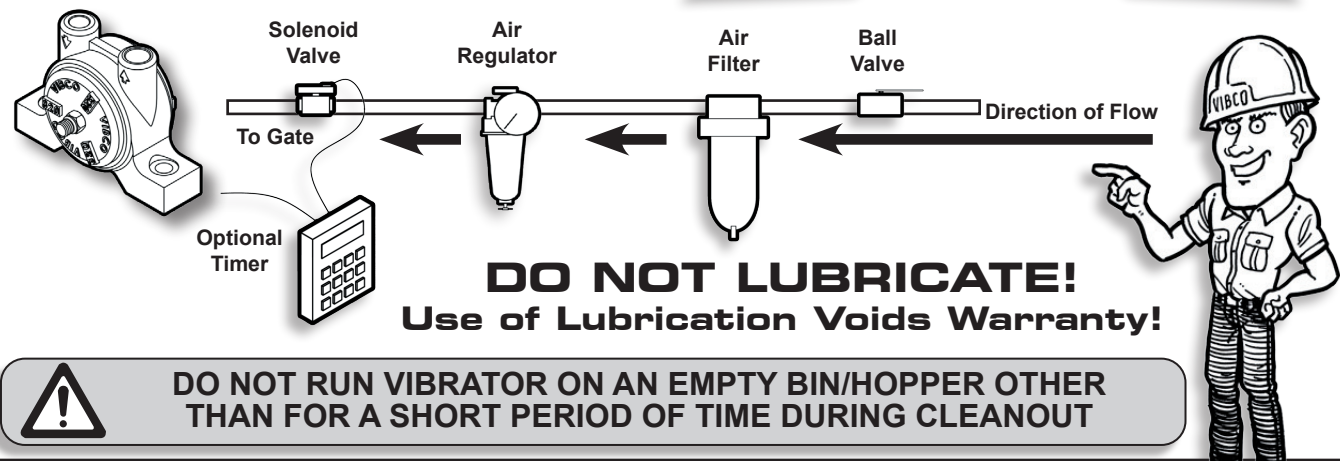
10 INLET & EXHAUST



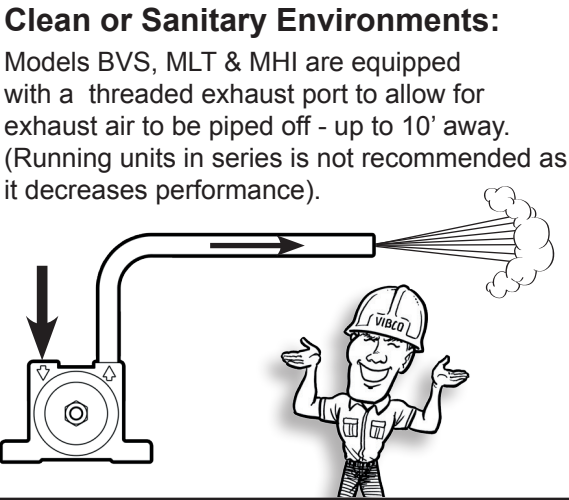
If the threaded
ports are the
same size, look into the
opening to see the inner
orifice. On BVS, BBS, MLT
& MHI models, the smaller
INNER orifice is the air
inlet and the larger **INNER**
orifice is the exhaust.



11 PNEUMATIC HOOK-UP



12 AIR DISCHARGE



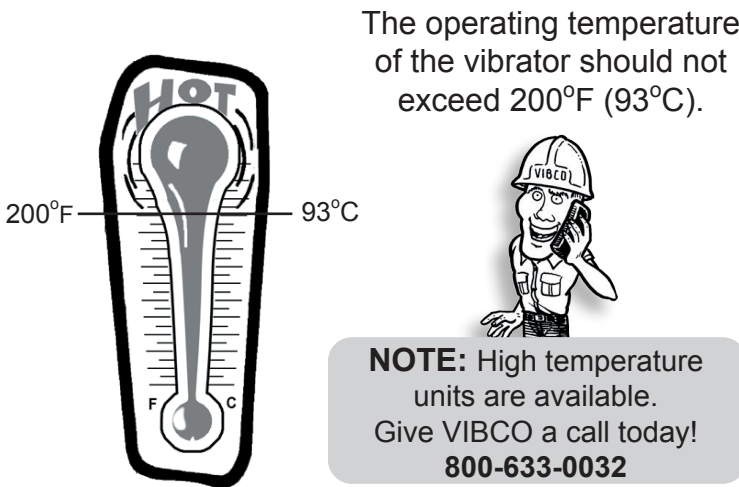
13 OPERATION SPECIFICATIONS

Maximum Air Pressure

MODEL	Maximum Air Pressure (PSI)	
	Safe Operation	Not Recommended
BBS-100, BVS-60, VS-100, & MLT-100	up to 60 PSI	pressure over 60 PSI
All Other Units	up to 80 PSI	pressure over 80 PSI
FBS - Intermittent duty	up to 80 PSI	pressure over 80 PSI

☐ Safe Operation ☐ Not Recommended

Maximum Temperature



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

14 TROUBLE SHOOTING

THE VIBRATOR WON'T START!

1. Check for dirt in the airline OR inlet opening.
- NOTE:** The inlet has a small orifice in the bottom of the hole. Check for debris, Teflon tape, pipe dope, etc.,
2. Check for dirt or debris clogging the exhaust muffler.
3. Double check the size of your air line - is it large enough to give you the correct cubic feet per minute (CFM) and correct air pressure (minimum required = 20 PSI)?
4. Double check to see if the air line is connected to the correct port (see box #10).

NOTE: Bearings may require a short "break-in" period to run at maximum pressure shown in Box 13.

Warranty

All warranty claims must be submitted to VIBCO for approval prior to any repairs being done. Failure to do so will void any and all warranty coverage. All repairs will be done at the VIBCO factory.

Errors, Shortages & Complaints

Complaints concerning goods received or errors should be made at once. Claims must be made within five days after receipt of goods. Clerical errors are subject to correction. Damage during shipping must be reported to the carrier, not VIBCO.

Returning Parts **

Parts should not be returned to VIBCO without prior authorization. Call VIBCO's customer service department at 800-633-0032 (800-465-9709 in Canada) for a Return Goods Authorization (RGA) number. A return authorization will be e-mailed or faxed to you. Use this as your packing slip. Return shipping must be prepaid. Material returned may be subject to repair costs (if any) and a restocking fee (0% if returned during 10 day trial period, 10% if returned within 30 days, or 25% if returned after 30 days). All returned shipments should clearly display the RGA #, your name, address and original invoice number to ensure proper credit. Returns are credited for use on future purchases of equipment from VIBCO.

** Orders for custom equipment built to customer's specifications and electronic components are not returnable.

Product Changes

VIBCO reserves the right to make changes in pattern, design or materials when deemed necessary, without prior notice or obligation to make corresponding changes in previous models. To be sure of exact mounting dimensions, it is recommended that you obtain a certified dimensional drawing from the factory.

Ordering Spare Parts

Parts can be ordered through authorized distributors or from VIBCO's Spare Parts Department. The following data should be provided when placing your spare parts order:

- ☐ Model of unit from the label
- ☐ Reference number, part number, description and quantity required from the spare parts list
- ☐ Shipping instructions: Specify shipping point and method of shipping.

For custom mounting applications or any other questions:



vibrators@vibco.com
or
800-633-0032



Use this handy QR Code to get any of our Product Catalogs

YOU CAN FIND ADDITIONAL DETAILS & INSTRUCTIONS ONLINE AT
<http://www.vibco.com/service-manuals>