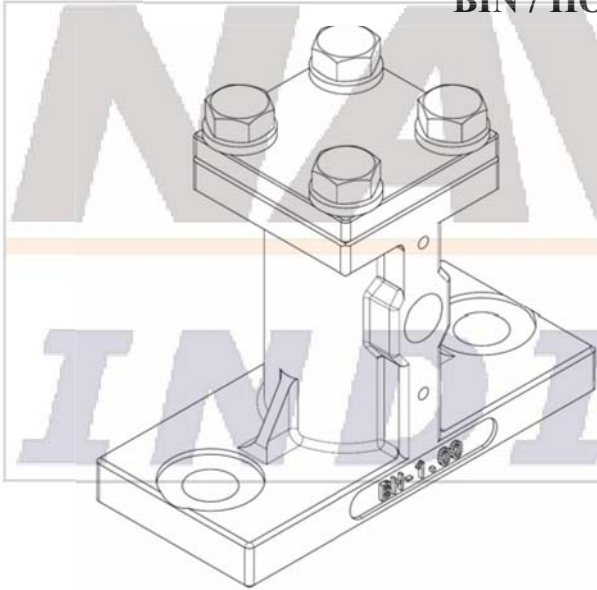


# BH 1

## BIN / HOPPER VIBRATOR



OPERATING CHARACTERISTICS		
	IMPACTING	SILENT
FREQUENCY	7250 VPM	3600 VPM
AIR CONSUMPTION	3.3 C.F.M. @ 50 PSI	3.0 C.F.M. @ 50 PSI
	93.45 L.P.M. @ 3.45 Bar	84.95 L.P.M. @ 3.45 Bar
SOUND LEVEL	87 dbA	75 dbA

HOPPER SIZING CRITERIA	
HOPPER CAPACITY	3 Ft. <sup>3</sup> (0.085 M <sup>3</sup> )
WALL THICKENSS RANGE	1/16" (1.6 mm) - 1/8" (3.2 mm)

The NAVCO BH 1 is a Pneumatic Piston Vibrator designed to provide reliable and effective performance, even when exposed to sever adverse elements. The size and operating characteristics of the BH 1 make it ideally suitable for solving very light duty bulk material flow problems.

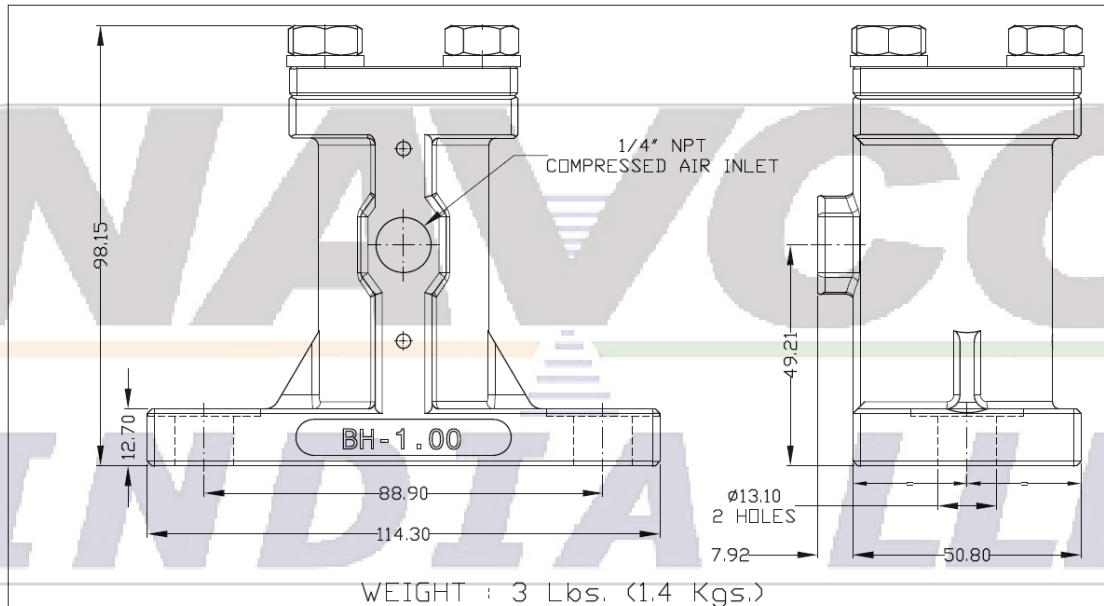
### Operation and Construction

The model BH 1 vibrator incorporates a nominal 1" piston and bore. During operation, compressed air is alternately directed from one end of the piston to the other through a series of internal ports. The piston is the only moving part, which makes the pneumatic piston vibrator a reliable, low maintenance device. *The vibrator housing is a one piece, ductile iron casting. This adds to the durability and reliability of NAVCO Pneumatic Piston Vibrators.*

The action of the piston in a pneumatic piston vibrator generates high amplitude vibration with unidirectional or linear force vectors. High amplitude characteristics enable the vibrating energy to be transmitted in the capacity required to overcome the strength of the bulk material involved in a bridge (arch) or a rathole (pipe). Other advantages of high amplitude, linear vibrators include low utility consumption and minimum bin wall stress.

#### **Linear Vibration offers the following advantages:**

- The work or energy generated by the vibrator can be directed normal or perpendicular to the flow of bulk material to address a specific material flow problem. The vibrator work is used very efficiently to reduce the sliding friction angle of the hopper and to overcome the strength of the bulk material in the hopper. These two factors are the key to promoting the flow of bulk solid materials.
- Vibrators that generate linear vibration do not develop high shearing forces at the bin wall. This allows a simple, more direct approach to mounting these vibrators.
- Linear vibration is ideal for driving vibratory feeders and compaction tables.



**NOTE: External Dimensions of BH 1.00 IGO & BH 1.00 SGO are same.**

## Model Types

The NAVCO BH 1 is available in two model types; **Impacting and Silent.**

### Impacting Vibrator:

The **Impacting Model BH 1.00 IGO** develops a high amplitude repetitive impulse when the piston strikes the base of the bore sharply on each cycle. The piston is air cushioned at the head plate on the upward stroke. Momentum and energy are transmitted through the bin wall and into the material by each elastic collision between the piston and the vibrator base. *The repetitive impacts enable the Vibrator to affect material over a large area of influence overcoming the bulk material strength and reducing the wall friction angle.*

NAVCO Impacting Pneumatic Piston Vibrators are excellent for all bulk material flow problems, especially those involving cohesive materials with marginal to poor flow characteristics.

### Silent Vibrator:

The **Silent Model BH 1.00 SGO** generates a sinusoidal output by creating an air cushion at each end of the piston stroke. *NAVCO Silent Pneumatic Piston Vibrators are effective in applications involving non-cohesive or free flowing materials where a slight increase in energy is required to initiate or maintain flow.* The Silent Units are also ideal as drivers for vibratory tables and feeders.

## Choosing Proper Vibrator

Proper sizing and Installation of vibrators are critical to the success of the flow aid system.

**The three major factors to consider in selecting pneumatic piston vibrators for hopper applications are:**

- The wall thickness of the hopper.
- The volume and mass of material in the hopper.
- The flow characteristics of the bulk material.

The NAVCO BH 1 is a very light duty vibrator. It may be applied to hoppers with 3 Ft<sup>3</sup> (0.085 M<sup>3</sup>) of capacity or less, with a wall thickness of 1/16" (1.6 MM) – 1/8" (3.2 MM). On thinner walls, a reinforcement plate is recommended. On thicker wall, a larger unit should be selected.

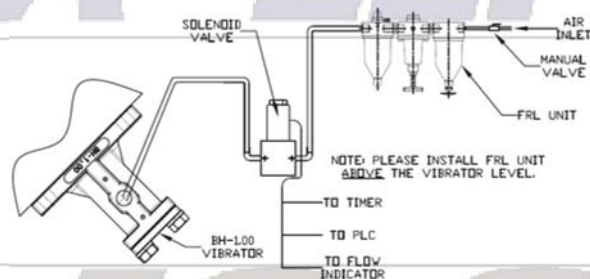
## Installation

The optimal mounting location for a vibrator in a typical hopper application is at the point of the flow restriction.

If the exact position is unknown, the vibrator should be located from 1/4<sup>th</sup> to 1/3<sup>rd</sup> of the height of the hopper from the discharge. For large hoppers, hoppers with unusual geometry, or particularly difficult material flow problems, multiple vibrators may be required.

The vibrator mounting plate should be skip welded to the hopper wall using a low hydrogen welding rod. If reinforcement is required, it should be skip welded, also with a low hydrogen rod.

To ensure proper application and operation of NAVCO vibrators, we offer a complete line of system accessories. The BH 1 has a 1/4" NPT Inlet and therefore utilizes 1/4" NPT accessories.



**For Assistance, please contact**

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