

Indian Standard

**GENERAL REQUIREMENTS FOR
VIBRATORS FOR MASS CONCRETING,
IMMERSION TYPE**

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

Indian Standard

GENERAL REQUIREMENTS FOR VIBRATORS FOR MASS CONCRETING, IMMERSION TYPE

0. FOREWORD

0.1 This Indian Standard was adopted by the Bureau of Indian Standards on 29 July 1988, after the draft finalized by the Construction Plant and Machinery Sectional Committee had been approved by the Civil Engineering Division Council.

0.2 The compaction of concrete by vibration has revolutionized the concept of concrete technology, making possible use of low slump stiff mixes for production of high quality concrete with required degree of strength, density, durability and impermeability. Immersion vibrators are most commonly used for compaction of plain and reinforced concrete. With the introduction of centralized batching plant and mass concreting techniques, compaction of concreting by vibration by immersion vibrator up to 90 mm diameter has been found to be inadequate especially while taking into account the speed of pouring of concrete. In mass concreting, aggregates of size up to 150 mm is used. Effective compaction cannot be obtained with smaller diameter needles and as such it has become necessary to use bigger diameter needles. This standard is being prepared for giving guidance in the manufacture and use of immersion vibrators of needles of diameter

over 90 mm. Immersion vibrators of 90 mm and below have already been covered in IS : 2505-1988*.

0.3 Pneumatic and electrically driven motor in head type immersion vibrators are to be advantageous for higher diameter immersion vibrators. Use of petrol/diesel engine prime mover has been found to be unsatisfactory in view of the weight due to higher horse power rating of the unit. For safety reasons, use of high frequency, low voltage electrical drive units are recommended for these vibrators.

0.4 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS : 2-1960†. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*General requirements for concrete vibrators, immersion type (*third revision*).

†Rules for rounding off numerical values (*revised*).

1. SCOPE

1.1 This standard lays down requirements for material, size, construction and performance of immersion vibrators above 90 mm size.

2. TERMINOLOGY

2.0 For the purpose of this standard, the definitions given in IS : 2505-1988* and the following shall apply.

2.1 Driving Shaft — A shaft which connects the motor and the eccentric shaft, and gives the drive to the eccentric shaft.

2.2 Driving Gear — A gear on the motor output shaft and the eccentric shaft.

2.3 Spindle Coupling — Coupling which connects the eccentric shaft and the motor gears through the spindle tube.

2.4 Spindle Tube — A tube which encloses the drive shaft.

2.5 Upper Eccentric Housing Cap — Cap which is on the driving end of the vibrator and connected to the spindle tube.

3. MATERIALS

3.1 The tube of the vibrating needle shall be seamless steel tube or heavy class ERW tube conforming to IS : 1161-1979* or IS : 1239 (Part 1)-1979†.

*Specification for steel tubes for structural purposes (*third revision*).

†Specification for mild steel tubes, tubulars and other wrought steel fittings: Part 1 Mild steel tubes (*fourth revision*).

*General requirements for concrete vibrators, immersion type (*third revision*).

3.2 The bottom cap shall be of carbon steel of grade 35C8 of IS : 1570 (Part 2)-1979* and shall be tempered and hardened to 40 to 50 HRC or cast steel conforming to grade 1 of IS : 1030-1982†.

3.3 The eccentric shaft/rotor shall be made of carbon steel of grade 35C8 of IS : 1570 (Part 2)-1979* and shall be tempered.

3.4 Bearings — The bearings shall be of ball bearing type of suitable capacity and conforming to relevant Indian Standards.

3.5 Drive Shaft — The drive shaft shall be seamless tube with end coupling of carbon steel with internal gear teeth for coupling to the eccentric shaft end and motor end.

3.6 Handle — It shall be of mild steel with rubber covering to suit the site requirements.

4. SIZES

4.1 The size of the vibrator shall be denoted by the outside diameter of the vibrating needle and expressed in mm.

4.1.1 The actual outside diameter of the needle measured anywhere in its length excluding the bottom cap and the top tube shall not differ from the outside diameter by more than ± 2 mm.

4.1.2 The standard outside diameter of the vibrating needle shall be 100, 110 and 150 mm.

4.1.3 Length of Vibrating Needle — The length of vibrating needle shall be measured from the outer end of the bottom cap to the joint between

the needle casing and the upper eccentric housing. Tolerance of the length shall be ± 5 mm.

NOTE — The following standard lengths are recommended for selection of suitable length depending upon the nature of jobs required. These sizes have been recommended arbitrarily, purely with a view to aiding rationalized production by limiting a number of sizes of 600, 625 and 650 mm.

5. CONSTRUCTION

5.1 Vibrating Needle

5.1.1 Tube — The tube should be reinforced at the threaded portion as indicated in Fig. 1 to prevent any failure due to lesser thickness at this point. Suitable bearing blocks have to be welded inside the tube for mounting the bearings of the eccentric shaft. This is necessary because the outer diameter of the bearings of the required capacity may be less than the inside diameter of the needle casing (see Fig. 1).

5.1.2 Bearings — These shall be of adequate size, and suitably mounted and press fitted on the shaft so as to take both radial and axial loads. The bearings and the eccentric shaft assembly shall be such as to enable the removal of shaft for repairs and replacement.

5.1.3 Concentricity — The eccentric shaft or rotor upon assembly shall be such that all components are concentric about their respective centre lines where bearing, journals, housing and drive shaft, etc, are concerned.

5.1.4 Vibrating Needle — It shall be completely sealed against entry of moisture, dust, grout, etc.

6. PERFORMANCE REQUIREMENTS

6.1 It shall be in accordance with IS : 2505-1988*

*Schedules for wrought steels for general engineering purposes: Part 2 Carbon steels (unalloyed steels) (first revision).

†Specification for carbon steel castings for general engineering purposes (third revision).

*General requirements for concrete vibrators, immersion type (third revision).

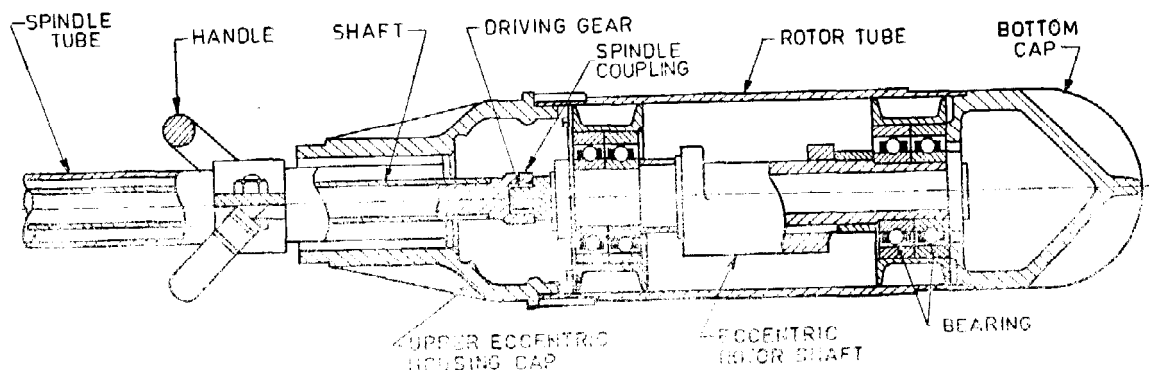


FIG. 1 HEAVY DUTY VIBRATOR

excepting that the frequency of vibration and amplitude should be as follows:

<i>Diameter of Vibrating Needle</i> (mm)	<i>Frequency</i> (Vibrations/minute)	<i>Amplitude</i> (mm)
100 } 110 } 150 }	5 500-8 500	2-1

6.1.1 The normal recommended life of unit is 5000 h except for the wearing parts.

7. INSTRUCTION SHEET

7.1 An instruction sheet containing instructions

relating to installation, maintenance and lubrication of the vibrator and prime mover shall be given.

8. MARKING

8.1 Each vibrator shall have firmly attached to it a mark plate bearing the following information:

- Manufacturer's name or trade-mark;
- Vibrator reference number;
- Type and rating of the power unit to be used;
- Year of manufacture; and
- Frequency and amplitude.

BUREAU OF INDIAN STANDARDS

Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, NEW DELHI 110002

Telephones: 331 01 31, 331 13 75

Telegrams : Manaksanstha
(Common to all offices)

Regional Offices:

Telephone

Central: Manak Bhavan, 9 Bahadur Shah Zafar Marg,
NEW DELHI 110002

331 01 31, 331 13 75

*Eastern: 1/14 C.I.T. Scheme VII M, V.I.P. Road, Maniktola,
CALCUTTA 700054

36 24 99

Northern: SCO 445-446, Sector 35-C, CHANDIGARH 160036

2 18 43, 3 16 41

Southern: C.I.T. Campus, IV Cross Road, MADRAS 600113

41 24 42, 41 25 19, 41 29 16

†Western: Manakalaya, E9 MIDC, Marol, Andheri (East),
BOMBAY 400093

6 32 92 95

Branch Offices:

'Pushpak' Nurmohamed Shaikh Marg, Khanpur, AHMADABAD 380001

2 63 48, 2 63 49

‡Peenya Industrial Area, 1st Stage, Bangalore-Tumkur Road,
BANGALORE 560058

38 49 55, 38 49 56

Gangotri Complex, 5th Floor, Bhadbhada Road, T.T. Nagar,
BHOPAL 462003

6 67 16

Plot No. 82/83, Lewis Road, BHUBANESHWAR 751002

5 36 27

53/5 Ward No. 29, R.G. Barua Road, 5th By-lane, GUWAHATI 781003

3 31 77

5-8-56C L.N. Gupta Marg (Nampally Station Road),
HYDERABAD 500001

23 10 83

R14 Yudhister Marg, C Scheme, JAIPUR 302005

6 34 71, 6 98 32

117/418 B Sarvodaya Nagar, KANPUR 208005

21 68 76, 21 82 92

Patliputra Industrial Estate, PATNA 800013

6 23 05

T.C. No. 14/1421, University P.O. Palayam, TRIVANDRUM 695034

6 21 04, 6 21 17

Inspection Offices (With Sale Point):

Pushpanjali, First Floor, 205A West High Court Road, Shankar Nagar
Square, NAGPUR 440010

2 51 71

Institution of Engineers (India) Building, 1332 Shivaji Nagar,
PUNE 411005

5 24 35

*Sales Office in Calcutta is at 5 Chowringhee Approach, P.O. Princep Street, Calcutta 700072

27 68 00

†Sales Office in Bombay is at Novelty Chambers, Grant Road, Bombay 400007

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‡Sales Office in Bangalore is at Unity Building, Narsimharaja Square, Bangalore 560002

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