

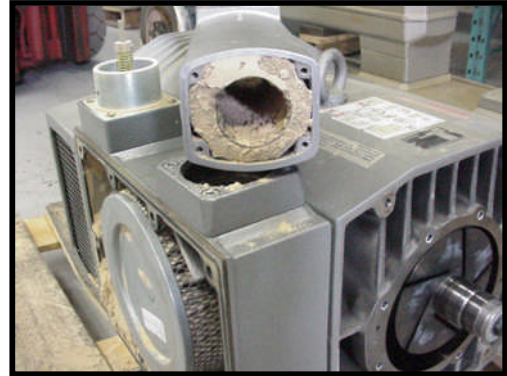
Is it Volume or Vacuum That I Need?

Customer: Audio Speaker Manufacturers

Application: Shoda CNC Router
Table Size 5 x 10
Material - MDF board

Becker Product: Duplex VTLF250

Customer Complaint: "One of my pumps is making a funny noise and smells hot."



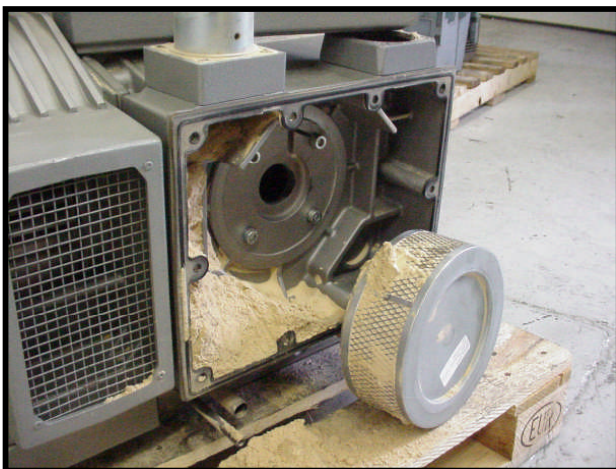
Investigation Report

- Vanes have 50% life, soft on one end
- Grease on rotor end
- Inlet filter and filter housing as well as inlet silencer housing completely clogged

MDF dust was removed from filter by "tapping".
The dust weighed over 500 grams.

What the customer did not complain about:

- The boards moved or won't hold
- Too many rejects
- Rough cuts, frequent tool change
- Reduced production



In order to have drawn dust into the relief valve silencer, a vacuum level of 26" Hg was maintained, through the clogged filter. The board porosity results in 10" to 20" Hg at the table.

"How with one pump completely clogged did this CNC router work?"

Answer: The original manufacturers pump selection was a 12 Hp rotary lobe at 15" Hg.

Was it volume or vacuum?

R. E. Morrison Equipment Inc.