Service Bulletin [2026-06]

Vacuum Pressure Adjustment

AT ALL TIMES WHILE MAKING ADJUSTMENTS, THE MACHINE

SHOULD BE LOCKED OUT USING APPROPRIATE PROCEDURES.

-This procedure should be done with the ball valve closed and pump running.

-Do NOT exceed negative 0.40mBar as this will overload the pump and may cause premature failure.

-If you have a dual pump system, then perform this procedure for each pump and try to have each pump vacuum pressure as equal as possible to balance the load. Typically, within +/- negative 0.05mBar.

-Once you have completed the adjustment, open the ball valve(s) and re-check the vacuum pressure.

-With the vacuum pad de-activated pressure should remain fairly close to the valve that was set. When you activated the vacuum pad you should see a momentary drop, but it should return to value that was set, or slightly less. Usually in the range of negative 0.40-0.37.

ADJUSTMENT PROCEDURE

Step 1: Remove the vacuum BCM silencer (FIG 1) if present.

Step 2: Place a wrench on the top of the threaded rod (FIG 2).

Step 3: Place wrench on the relief valve adjustment bolt (FIG 2).

Step 4: Holding the wrench on the threaded rod, turn the adjustment nut (FIG 2). Rotating the nut clockwise will increase vacuum, rotating counterclockwise will reduce vacuum. Monitor your adjustment by viewing the vacuum sensor.

FIG 1: BCM Silencer

FIG 2: Pressure Adjustment Spring

SAFETY BULLETIN

This notice is issued to advise you that some previously accepted shop practices may not be keeping up with changing Federal and State Safety and Health Standards. Your current shop practices may not emphasize the need for proper precautions to ensure safe operation and use of machines, tools, automatic loaders and allied equipment and/or warn against the use of certain solvents or other cleaning substances that are now considered unsafe or prohibited by law. Since many shop practices may not reflect current safety practices and procedures, particularly regarding the safe operation of equipment, it is important that you review your practices to ensure compliance with Federal and State Safety and Health Standards.

IMPORTANT

The operation of any machine or power-operated device can be extremely hazardous unless proper safety precautions are strictly observed. Observe the following safety precautions:

ALWAYS:

- ✓ Be sure proper guarding is in place for all pinch, catch, shear, crush, and nip points.
- ✓ Be sure that all personnel are clear of the equipment before starting it.
- ✓ Be sure the equipment is properly grounded.
- ✓ Turn the main electrical panel off and lock it out in accordance with published lockout/tagout procedures prior to making adjustments, repairs, and maintenance.
- ✓ Wear appropriate protective equipment such as safety glasses, safety shoes, hearing protection, and hard hats.
- ✓ Keep chemical and flammable material away from electrical or operating equipment.
- ✓ Maintain a safe work area that is free from slipping and tripping hazards.
- ✓ Be sure appropriate safety devices are used when providing maintenance and repairs to all equipment.

NEVER:

- ✓ Exceed the rated capacity of a machine or tool.
- ✓ Modify machinery in any way without prior written approval of the Besser Engineering Department.
- ✓ Operate equipment unless proper maintenance has been regularly performed.
- ✓ Operate any equipment if unusual or excessive noise or vibration occurs.
- ✓ Operate any equipment while any part of the body is in proximity of potentially hazardous areas.
- ✓ Use any toxic flammable substance as a solvent cleaner.
- ✓ Allow the operation or repair of equipment by untrained personnel.
- ✓ Climb or stand on equipment when it is in operation.

It is important that you review Federal and State Safety and Health Standards on a continual basis. All shop supervisors, maintenance personnel, machine operators, tool operators, and any other person involved in the setup, operation, maintenance, repair or adjustment of Besser-built equipment should read and understand this bulletin and Federal and State Safety and Health Standards on which this bulletin is based.