

Through Eyes of Our Customer



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We made our foray into the market in 2011 when the state government introduced ban on the production of red bricks in West Bengal. After doing an extensive research by visiting many small and big plants and meeting existing Columbia customers across India, we saw

people still manufacturing with an output of 5-10k bricks daily, when there was enough possibility of exceeding 50,000 bricks per day. We could foresee the market potential of flyash bricks in the area and realized it could be a flourishing business. It didn't take us much time to zero on a Columbia's Concrete Block Machine Model SPM20 and installed our 1st plant at Durgapur, West Bengal during the winters of 2011. This idea and conception did not prove me wrong, and the business and products got encouraging response from the market.

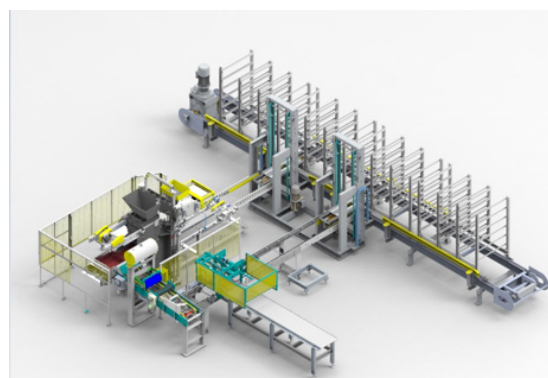
Soon later we purchased three more machines of Columbia and installed at different locations. But this time we did not limit ourselves to flyash bricks. We started purchasing new moulds from Columbia and made variety of products which were not introduced by anyone else in the market. In this way, we made all kinds of products possible on SPM20. Starting with a single flyash plant with a team of 15 to now owning 4 big Concrete Block plants with over 200 people working with us, Columbia Machines has made our dream come true and has helped to attain manifold returns in just 8 years.

Columbia Machines are reliable, their USP is in the wide variety of products which can be manufactured on a single machine. There is no product left that I have not made on Columbia's Concrete Block Machine Model SPM20. From Flyash Bricks to Hollow and Solid Blocks, all kinds of Pavers, Kerbstones and Retaining Wall Blocks, I have tried them all. Our Prime Minister has visioned for 5 trillion economy and this is not possible without considerable growth in infra projects. This will stimulate huge demand in precast and paver industry in near future. Customers are getting more and more time bound now. They need to complete a project in a stipulated time and hence precast will come into picture in a large way. Sky is the only limit.

The largest show in India is here and Columbia is once again excited to showcase the most innovative and latest technology to our customers. Excon, is scheduled from 10th to 14th Dec'19 at BIEC grounds, Bangalore. Come and stop by at our booth to witness UL20, the Automated Pallet Handling system for SPM20 all live in action.

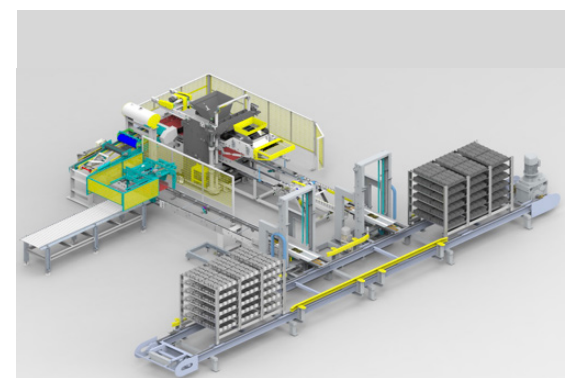
The launch of SPM30 at last Excon brought the significantly new addition to our concrete block machinery range. With SPM30 came the indigenously manufactured and uniquely designed fully automatic Rack Loader/Unloader Model UL30 for automation of Pallet and Rack Handling. Columbia's Rack Loader/ Unloader is designed and engineered to adapt to provide economical, automated product handling to your operation. It is further supplemented by another uniquely designed product cubing equipment, the Plate Style Cuber. Engineered for high productivity, low energy usage, and heavy-duty moving, each of our Cubers will help you lower operating costs for years to come.

This year we are providing the same technology which can be clubbed with our Small Pallet Size Machine Model SPM20. The UL20, Rack Loader and Unloader provides automation in Pallet and Product Handling System at a minimal cost where growing labour cost and getting skilled and reliable labour a challenge throughout India. The growing popularity of small concrete products such as pavers and flyash bricks has led Columbia India's engineers to develop UL20 the fully automated pallet handling and cubing system, the most reliable and viable alternative in the market.



Model UL - 20

Application	: Handling Green / Cured products with pallets
Pallet size	: 508 x 508 x 6 Thk Steel pallets.
Pallet loading	: 2 Deep
Rack configuration	: 3 bay x 6 Tier X 2 Deep
Tier spacing	: 180 mm Min / 300 mm max
Hoist travel	: 1270 mm
Trolley Travel	: 1900 mm
Max weight to handle	: 260 kg with pallet
Connected Power	: 12.37 kW
Operation	: All Electric
Supply voltage	: 415V / 50 Hz / 3 Ph.
Control voltage	: 24 VDC



Model UL - 30

Application	: Handling Green / Cured products with pallets
Pallet size	: 750 x 600 x 8 Thk Steel pallets.
Pallet loading	: 2 Deep
Rack configuration	: 3 Bay x 6 Tier X 2 Deep
Tier spacing	: 180 mm Min / 350 mm max
Hoist travel	: 2200 mm
Trolley Travel	: 1630 mm
Max weight to handle	: 360 kg with Pallet
Connected Power	: 22 kW
Operation	: Hydraulic
Supply voltage	: 415V / 50 Hz / 3 Ph.
Control voltage	: 24 VDC

Recently Concluded Shows:



Addis Build, 9th – 12th October’19, Addis Ababa, Ethiopia



Con Expo Bangladesh, 17th – 19th October’19, Dhaka, Bangladesh

Where we will be Next?

Find us at these Tradeshows :



Cambodia Construction Industry
Booth No. 36
5th – 7th December’19
Phnom Penh, Cambodia



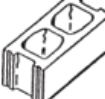
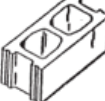
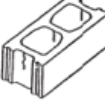
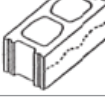
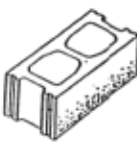
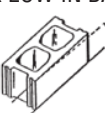
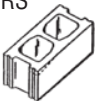
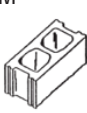
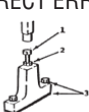
EXCON
Hall 3, Booth No. A63
10th – 14th December’19
Bangalore, India

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SERVICE TIPS

It is very important that each product coming out of the machine is consistent in quality. Check for required dimensions, defects, finish and do required course of action. Read through our troubleshooting section below for more details.

DEFECT	PROBABLE CAUSE	REMEDY
BLOCK SUCKING IN 	- Block mix too wet - Main beam flow valve improperly adjusted - Clogged venting plunger holes in mold core bars	- Check for proper mix composition - Check adjustment - Clean plunger holes
WEB CRACKS 	- Pallet table pressure settings incorrect - Feed drawer dwell too short - Pallet table-to-mold clearance incorrect - Compression beam air pressure too high	- Adjust settings as required - Increase DENSITY setting - Check clearance - Replace mold - Decrease air pressure
WALL CRACKS 	- Pallet feeder start-stop too abrupt - Take-away conveyor elevator improperly aligned with pallet table - Incorrect filling to mold - Weak block mix	- Adjust flow valve cams - Check height alignment - Check DENSITY setting - Check for proper mix composition
CORE BAR CRACKS 	- Incorrect filling of mold - Weak block mix - Pallet table-to-mold clearance incorrect - Mold core bars loose - Residue buildup under core bars	- Check DENSITY setting - Check for proper mix composition - Check clearance - Check and adjust - Clean mold
IRRCGULAR LINES 	- Irregular vibration - Loose mold or shaker shaft - Concrete residue restricting mold movement - Worm mold components	- Check vibrators for defective bearing - Check mounting belts for tightness - Remove residue - Replace mold
UNEVEN TEXTURE 	- Feed drawer dwell too short - Pallet table low pressure too low - Material segregated in hopper - Scrape-off plate improperly adjusted - Pallet table-to-mold clearance incorrect - Irregular vibration - Compression beam air pressure too high	- Increase DENSITY setting - Increase low pressure - Check forproper mix composition - Adjust for proper mold clearance - Check clearance - Check vibrators for defective bearings - Decrease air pressure
BLOCK LOW IN BACK 	- Feed drawer dwell too short - Pallet table pressure setting incorrect - Concrete residue restricting mold movement - Pallet table-to-mold clearance incorrect	- Increase DENSITY setting - Adjust setting as required - Remove residue - Check clearance
LOW FRONT CORNERS 	- Inadequate mold fill - Vibrator delay too short - Residue buildup in feed drawer - Concrete residue restricting free mold movement	- Increase Oscillation setting - Increase Vibrator setting - Clean out feed drawer - Remove residue
BLOCK BULGING 	- Blocks stripped too early - Feed drawer dwell too long - Scrape-off plate improperly adjusted	- Increase RELEASE setting - Decrease DENSITY setting - Adjust for proper mold clearance
FEATHER EDGE ON BOTTOM 	- Pallet table high pressure too low - Hydraulic supply pressure too low - Pallet table-to-mold clearance not correct - Defective stripper check valve	- Increase high pressure air - Check pump output pressure and accumulator charge pressure - Check clearance - Refer to hydraulic system troubleshooting
FEATHER EDGE ON TOP 	- Plunger shoes improperly aligned - Scrape-off plate improperly adjusted	- Check for equal shoe-to-mold clearance - Adjust for proper mold clearance
LOOSE, FLAKY BOTTOM 	- Pallet table high pressure too low - Blocks stripped too early - Pallet table-to-mold clearance incorrect - Block mix too dry	- Increase high pressure - Increase RELEASE setting - Check clearance - Check for proper mix composition
LOOSELY FILLED BOTTOM 	- Pallet table high pressure too low - Scrape-off plate improperly adjusted - Residue buildup around mold - Pallet table-to-mold clearance incorrect - Loose mold, vibrator, or shaker shaft	- Increase loww pressure - Adjust for proper mold clearance - Remove residue - Check clearance - Check vibrators for defective bearings
POROUS BLOCKS 	- Material segregated in hopper - Improper block mix composition - Scrape-off plate improperly adjusted - Loose mold, vibrator, or shaker	- Check for proper mix composition - Add more fines to mix - Adjust for proper mold clearance - Check mounting bolts for tightness
BLOCK HEIGHT INCORRECT ERRATIC 	- Electronic height stops incorrectly adjusted - Insulator(s) (3) defective - Release delay incorrect	- Loosen locknuts (2); adjust contact bolts (1) as required - Replace insulators - Adjust RELEASE setting