Research Paper

DEVELOPMENT OF DOUBLE MOULD VIBRATION – COMPACTOR BLOCK MOULDING MACHINE FOR DEVELOPING COUNTRIES

ABSTRACT

This work looked at the design and manufacturing of a low cost and easy to maintain vibration-compaction block moulding machine that can accommodate two different sizes of mould 9 inch ($0.46 \times 0.23 \times 0.22\,m$) and 6 inch blocks($0.46 \times 0.15 \times 0.22m$). It is borne out of the desire to solve housing problem in developing countries through reduction in the cost of the building materials like the block. It was designed to compact sandcrete block with a strength of 0.99N/mm2 which is the same as those made from the universal block making machines but performed better when water absorption was less than 7%. It can produce about 800 blocks in an 8hours working day. With a total space of 0.090m^3. It therefore occupies about 1/3rd the space taken and cost of N50,000 which is ¼ of the price of Universal Block Maker. The Vibrator Compactor Block Moulding Machine (VCBMM) was also used to produce sandcrete blocks which when tested had a strength of 0.95N/mm. The water absorption tests carried out on the sandcrete blocks absorbed 6.5 times more water. Therefore, the use of the sandcrete blocks from the VCBMM is recommended for use in all regions. The VCBMM was designed to be highly versatile and to be power driven by diesel motors. Provision was made on the sandcrete mould for sliding plates to be introduced into the mould holes so that 6 inch blocks ($0.46 \times 0.15 \times 0.22m$) and 9inch blocks ($0.46 \times 0.23 \times 0.22\,m$) are produced interchangeably.

KEYWORD: Mould, Block, Vibration, Compactor, Machine

1.0 INTRODUCTION

Vibrated Sandcrete block is the most important building material in Africa used in for walls and foundations of buildings. As a material for walls, its strength is less than that of clay bricks but sandcrete is much cheaper. Sandcrete blocks comprise of natural sand, water and binder. Cement, as a binder is the most expensive input in the production of this sandcrete vibrated blocks. This has necessitated producers of sandcrete blocks to produce blocks with low OPC content and will be affordable to people and with much gain.

The poverty level amongst West African countries and particularly Nigeria has made this blocks widely acceptable among the populace so as to minimize the cost of construction works. Manufacturers of the Vibration – Compactor Block Moulding Machine have previously produced just a single mould with the Moulding Machine just a producer of a certain size of block hence the need for a Double Mould Vibration – Compactor Block Moulding Machine to reduce the cost of acquiring two machines. The previous machines in use have had problems with their compressive strength affecting the strength of the sandcrete blocks hence the need to produce a machine with a high compressive strength and a more compact sandcrete block.

The problem of affordable housing has been a source of concern to all and sundry especially in developing countries where majority of them live below $1 per day. Shelter represents one of the most basic needs of man and has no doubt a profound impact on the health, welfare and productivity of the individual, and by extension the state. Every Nigerian deserves a roof over his head. The cost of housing can be reduced through reduction in the cost of the building materials. In developing countries like Nigeria, the block is a vital material in building construction as no construction is possible without bricks. Since many centuries brick making has been practiced by human beings. Presently, bricks are easily made by using machines using new technologies. Generally two types of bricks are manufactured by using machines that are concrete block machines and clay block machines (Mohd Ridhwan Bin Ramli, 2010).

1.1 **Aim:** The aim of the work is to develop a Low Cost Interchangeable Block Moulding Machine that can accommodate the two different sizes of Sandcrete blocks. This is a unique design because it can accommodate the different dimensions of sandcrete mold for block making.

1.2 **Objective**: The main objective of this project is to design a new Double Mould Vibration – Compactor Block Moulding Machine with new features and simplifying the machine for one man operation in order to reduce operational cost and maximize the production rate. Furthermore, the purpose of this is to design the Double Mould Vibration – Compactor Block Moulding Machine that suitable for SME entrepreneurs.

1.3 **Motivation of the study**: It is believe that a reduction in the cost of the building materials will crash the cost of housing. This machine will be able to produce two different sizes of block and the cost of the machine is very affordable and low compare to imported ones. And the machine can easily be maintained with little or no engineering experience.

2.1 DESIGN CONSIDERATIONS AND CALCULATIONS

The machine was first designed and modelled using Pro/Engineering software as shown in the diagram and the working drawing taking to the workshop floor for the various manufacturing operation to be perform.

There are Two (2) forces activated in the Machine:

1. Compressive Force that will be needed to compress the sand mix in the Mould Box

$$F = mg$$

$$where\ m = Mass\ of\ the\ Head\ Rammer = 15kg\ and$$

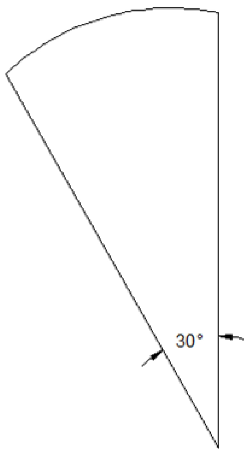
$g = acceleration\ due\ to\ gravity$ = 9.81m/s^2

$$F = 15 * 9.81$$

$$= \mathbf{147.15N}$$

2. Force due to wet block

$$\boldsymbol{F_b = Mass\ of\ wet\ block * g}$$



$$Mass\ of\ wet\ block = 27.5kg\ and\ g = 9.81ms^{-2}$$

$$F_b = 27.5 * 9.81$$

$$\boldsymbol{F_b = 269.78N}$$

** The wet block is 18% heavier than the dry block

Torque (τ) is the tendency of a Force to rotate an object about an axis, fulcrum or pivot. It is dependent on the Force (F), the lever-arm length(r) and the angle between the Force and the lever-arm

$$\tau = F\, r * \sin\theta$$

$$where\ F = 147.15N$$

$$r = Length\ of\ the\ Hand\ lever = 1100mm = 1.1m$$

$$and\ \theta = 30^{\circ}$$

$$\tau = 147.15 * 1.1 * \sin 30^{\circ}$$

$$\tau = 147.15 * 1.1 * 0.5$$

$$\boldsymbol{\tau = 80.93Nm}$$

Pressure acting directly in the Mould Box is dependent on the Compressive Force and the area of compression which is the Internal Feature of the Mould Box

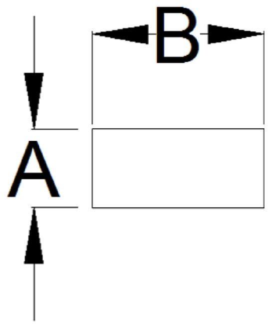
$$P = \frac{F}{A}$$

P is the Pressure needed for Compression

F is the Compressive Force and A is the Area of Compression

The view below shows the cross-sectional area of application and it’s an enclosure that contains the sand. it’s the point of compression of sand that results into the formation of Sandcrete blocks of different inches. The size of block depends on the internal dimension of the sandcrete mold.

Top View of the Mould Box:



To Find the Area of side A;

Length = 250mm and Breadth = 230mm

$$A_a = (250 * 230)\ mm^2$$

$$\mathbf{A_a = 57500\ mm^2}$$

To find Area of Side B;

Length = 470mm and Breadth = 250mm

$$\mathbf{A_b} = (470 * 250)\ mm^2$$

$$\mathbf{A_b = 117500}\ mm^2$$

Total Area, A = 2 ($\mathbf{A_b}$ + A_a)

= 2 * (117500 + 57500) mm^2

A= 350000 mm^2

Since the Unit is m^2,

$$Total\ Area;\ A = \left(\frac{350000}{10^6}\right)$$

$$A = 0.35m^2$$

To calculate the Pressure;

$$P = \frac{F}{A}$$

$$P = \frac{147.15}{0.35}$$

$$P = 420.43Pa$$

<u>Design of the Hopper Volume</u>

Since the machine was designed for small and Medium scale users, the hopper was designed in uniformity with these dimensions.

$$\text{Hopper Volume} = l\ x\ b\ x\ h$$

Where l $= Length\ of\ the\ hopper$

b $= breadth\ of\ the\ hopper$

h $= height\ of\ the\ hopper$

***** Using the 9’’ block mold as a Case study:**

$$\text{Hopper Volume} = 470\ x\ 230\ x\ 250$$

$$\text{Hopper Volume} = 27025000mm^3$$

$$\text{Hopper Volume} = 0.027025m^3$$

$$\text{Mass of the Mix} = Density\ x\ Volume$$

$$= \rho_m\ x\ V$$

$$= 1350\ kg/m^3\ \ x\ 0.027025m^3$$

$$= 36.484kg$$

Operating Stress (σ);

$$\sigma = \frac{\text{Force of Wet Block}}{\text{Area of Compact drive shaft}}$$

$$\sigma = \frac{F_{wb}}{\pi (D_{cds})^2}$$

$$\sigma = \frac{269.78}{\pi (0.024)^2}$$

$$\sigma = \frac{269.78}{0.001809557}$$

$$\sigma = 148.1KN/m^2$$

Diameter of Eccentric Weight and Compactor Drive Shaft (cds)

The cds carried the weight of wet brick mix in bending under minimum tension with a combined shock and fatigue of 1.5 (Gupta and Khurmi 2006). The drive torque, T, was given in,

$$P = \frac{P * 60}{2\pi N}$$

Where P = Power rating of the prime mover

N = Number of revolution in rpm

$$P = \frac{745.7 * 60}{2\pi * 1800}$$

$$P = \frac{44742}{11309.73}$$

$$P = 3.96\text{Nm}$$

The cds in bending was expressed as;

$$(m_{wb} * g \times r_s) \times 1.5 = 3.96$$

Where r_s = radius of cds

$$r_s = \frac{3.96}{(27.5 * 1.2) \times 9.81 \times 1.5}$$

$$r_s = \frac{3.96}{485.595}$$

$$\boldsymbol{r_s = 0.0082m}$$

For the Eccentric Weight,

$$r_e = 2r_s$$

$$r_e = 2 * 0.0082$$

$$\boldsymbol{r_e = 0.0164}$$

r_e is the radius of the eccentric weight, given wet brick mix as 18% heavier than dry brick of weight 27.1kg. Chose $r_e =$ 0.0165m.

Hence, the design diameters of the cds and eccentric weight were 16.4mm and 33mm respectively

CONCLUSION

This project work has actually gone within the limits of its scope to design and fabricate a Double Mould Vibration – Compactor Block Moulding Machine for small scale indigenous Sandcrete Vibrated Block Industry through the historical development of the VCBMM and the sand mix preparation processes. This design analysis, material selection, construction, maintenance and performance evaluation of the machine was also checked. The machine is simple and designed in such a way that it can be easily transported from one building site to another by careful selection of durable and locally sourced raw materials for its fabrication. As a result of this, the cost of maintenance is low and its all at a reduced cost for the small and medium scale entrepreneurs.

The objectives of this work have been considerably achieved, as we have been able to:

a. Reduce the time spent on sandcrete block production as it takes 8 working hours to produce 800blocks, hence increase the rate of production

b. Produce a machine that is easy to assemble and disassemble using a mounting support so each unit can be considered separately during maintenance.

c. Produce a machine that is safe to use by using cover and guard to guard the transmission parts, thereby, protecting the operator from hazards of unguarded rotating parts.

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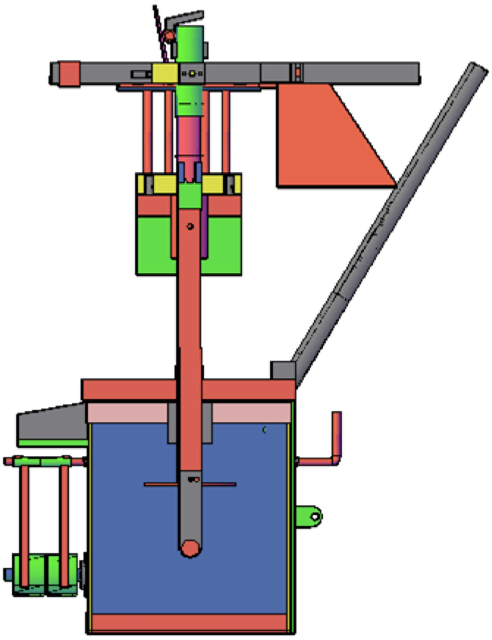

Figure 1: Side View of the Machine

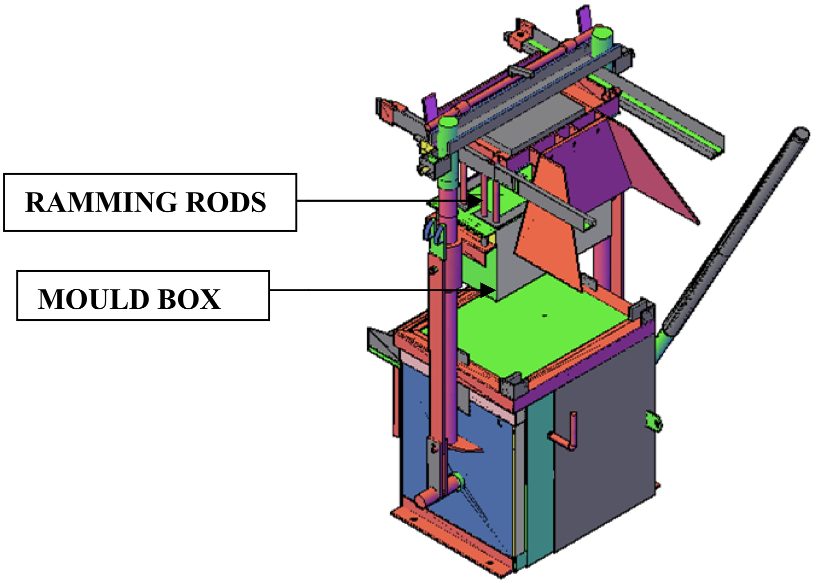

Figure 2: 3D Isometric View of the Machine

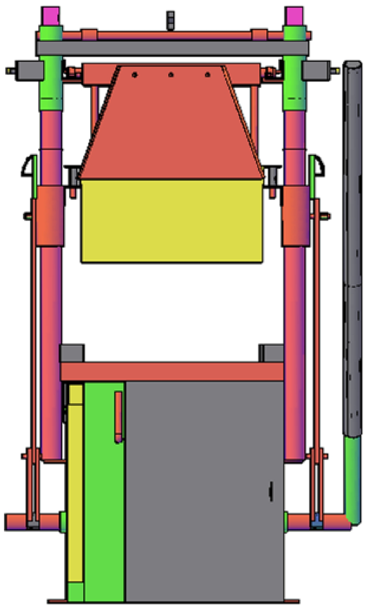

Figure 3: Front View of the Machine

Picture of the Fabricated Machine

Pictures showing different side views of the Fabricated Machine

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