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# **Curve Conveyor Systems**

## **Product, Installation, and Maintenance Manual**

*Type 250, 350, 500, 750 & 1000  
Conveyor Components*



**Manual #: IM-707-00  
04/17**



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## SECTION 1 OVERVIEW

### Conveyor Layouts

#### New Construction

1. A Lubing representative can determine if your conveyor requires a layout. See the General Information section for the salesperson in your area.
2. Layout requests are generated once an order is placed. Engineering will design the system based on information provided. Critical locations, lengths, and other considerations must be as accurate as possible for best system performance.
3. Include any future expansion projects in your request to eliminate as many costly changes to the system once construction is completed.
4. The first page of every layout drawing contains the Layout Acceptance Form or LAF. Before an order ships from the factory, the LAF must be signed and returned according to the instructions provided. LAFs may be returned with a signed approval “as is” or signed with any corrections marked on the layout.
5. Any revisions requested may result in new drawings released for approval and, in some cases, changes to the original order.
6. Installation must follow the layout provided for best performance and warranty.

#### Extensions or Modifications

1. Extensions to existing systems requires the entire finished length be considered in the design. Layouts will be provided based on best performance of the finished system.
2. As stated above, if future expansion projects are known, communicate when placing the initial order.
3. Modifications to existing systems also require the entire design to be considered.

### Conveyor Manuals

1. Manuals are provided with new system orders or at customer request.
2. Manuals are provided to guide the installation and start-up processes as well as the preventive maintenance, troubleshooting, and recommended spare parts of your system.
3. Manuals are provided as a tool for the user’s benefit, however, customer service is available when needed.
4. Contact your Lubing representative if additional copies are needed or visit the website to download.

Curve Conveyor Manual link: [www.lubingusa.com/technical/curve-conveyor.html](http://www.lubingusa.com/technical/curve-conveyor.html)

# Section 1

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## Using this Manual

### Component Details Section

1. Utilize this section for component dimensions and part breakdowns including part numbers for individual parts and sub-assemblies and their respective descriptions for ordering purposes.
2. Part numbers and descriptions aid in communication with technical assistance representatives using common terminology.

### Assembly and Installation Section

1. Utilize this section for the initial installation or replacement of components.

### Start-up and Troubleshooting Section

1. Utilize this section when commissioning new equipment as an entire system installation or the replacement of major components within an existing system.
2. This section is intended to guide through the inspection of components prior to Start-up as well as observing the system during the Break-in period.
3. Use the Troubleshooting steps to systematically work towards a correct diagnosis should issues arise.

### Maintenance Section

1. Utilize this section to maintain your system for optimal performance and efficiency.
2. Decrease unexpected downtime due to component failure and extend the life of wear components by following the provided Preventive Maintenance schedules.
3. Decrease product damage by following the provided Inspection schedules.

### General Information Section

1. Utilize this section for Lubing Systems and OEM contact information.
2. This section also details the submission of layout sketches to your Lubing representative.

# Section 1

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## Component Glossary

### Mini Drive:

Compact primary driving unit located at the front or discharge of the conveyor.  
Does not include integrated floor supports or tensioning.  
Must be used with End Piece (systems less than 100' in length) or Bolt-In Tensioner (any length).  
Transfer plate included.  
Mounted via Floor Supports, suspension, or other customer supplied method.

### Bolt-In Tensioner:

For use with Mini Drive as main tensioning for conveyor.  
Placement varies according to provided Layout Drawing.  
Mounted via Floor Supports, suspension, or other customer supplied method.

### Front Drive:

Primary driving unit located at the front or discharge of the conveyor.  
Integrated free-standing frame and tensioning.  
Transfer plate included.  
Mounted via included feet with anchoring points.

### Intermediate Drive:

Secondary driving unit located as specified in the provided Layout Drawing.  
Quantity varies based on system length and other factors (specified on Layout Drawing).  
Placement is critical (+/- 5' or 1.5m)  
Can be configured as "top drive" or "bottom drive" (specified on Layout Drawing).  
Does not include integrated Floor Supports or tensioning.  
Mounted via Floor Supports, suspension, or other customer supplied method.

### End Drive:

Secondary driving unit located at the rear of the conveyor.  
Does not include integrated Floor Supports.  
Integrated tensioning.  
Mounted via Floor Supports, suspension, or other customer supplied method.

### Transfer Drive:

Primary driving unit located at the front or discharge of one conveyor section.  
Integrated idler serves as end of downstream conveyor.  
Integrated free-standing frame and tensioner (for upstream conveyor system)  
Transfer plate included.  
Mounted via included feet with anchoring points.  
Segregates upstream conveyor from downstream.

Eliminates movement of existing drives to new locations when extending conveyor.  
Segregates existing/new chain in each system.

## **Cantilever Drive:**

Primary driving unit allowing flexibility in location within the system.  
Integrated free-standing frame and tensioning.  
Placement varies according to provided layout drawing.  
Mounted via integrated frame, suspension, or other customer supplied method.  
For use with Idler Unit.

## **End Unit:**

Return unit located at the rear of the conveyor.  
Mounted via Floor Supports, suspension, or other customer supplied method.  
No provision for transfer onto the rear of the conveyor.

## **End Piece:**

Return unit located at the rear of the conveyor.  
Mounted via Floor Supports, suspension, or other customer supplied method.  
No provision for transfer onto the rear of the conveyor.  
Integrated tensioner for systems less than 100' utilizing Mini Drive as primary driving unit.

## **Idler Unit:**

Return unit located at the rear of the conveyor.  
Mounted via Floor Supports, suspension, or other customer supplied method.  
Transfer plate included.  
Allows transfer onto the rear of the conveyor.  
Allows transfer off the front of the conveyor when paired with Cantilever Drive.

## **Connecting Part:**

Straight conveyor sections in 1m, 2m, and 3m lengths.  
Aluminum construction available in all lengths (stainless construction in 1m and 2m lengths).  
Length of aluminum versions can be modified (not recommended for stainless)  
Mounted via Floor Supports, suspension, or other customer supplied method.

## **Bend Unit:**

Curved conveyor sections in 45 and 90 degree angles.  
Custom angles available.  
Mounted via Floor Supports, suspension, or other customer supplied method.  
Allows for directional changes, jogs, and offsets in conveyor path.  
Placement is critical (refer to Layout Drawing).

# Section 1

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## **Pivot Unit:**

Flexible conveyor component allowing a maximum of 20 degrees of incline or decline.  
Maximum angles are dependent on several variables (refer to Layout Drawing).  
Directional component, must be installed correctly.

## **Top/Tandem Oiler:**

Lubrication dispenser for conveyor.  
Quantity/style varies based on system length and other factors (specified on Layout Drawing).  
Placement is critical (refer to Layout Drawing).  
Top Oiler lubricates top chain surface only.  
Tandem Oiler lubricates top and bottom chain surfaces.  
Directional component, must be installed correctly.  
Use with recommended lubricants (see Maintenance and Spare Parts section) .

## **Conveyor Chain:**

Available, in most cases, as Standard, Coated (plastic coated cross rod), and Hybrid (stainless cross rod).  
Supports product through system and allows for elevation changes and bends.  
Joined via Closing Rods and Security Elements.  
Sold in 10m or 32' lengths.

## **Closing Rod:**

Component for joining chain sections.  
Available in same styles as Conveyor Chain.

## **Security Elements:**

Component for locking chain sections into Closing Rod.  
Sold in pairs.

## **Floor Supports:**

Available in short, middle, and long lengths.  
Component for supporting conveyor at each joint.  
Adjustable within ranges provided in Component Details section.  
Short Floor Supports used in suspension (see Assembly and Installation section).  
Mounted via included feet with anchoring points.

## **Extruded Diverter:**

Component mounted to Connecting Part to allow movement of eggs across conveyor.  
Adjustable for various degrees of egg movement.



**Guide Unit:**

Component mounted to Connecting Part to allow movement of eggs across conveyor (usually at collector locations).

**Drip Canopy:**

Optional system to suspend customer-supplied drip paper underneath the conveyor.

**ChainKeeper:**

Optional system to monitor Chain status within the conveyor system.  
Can be installed to alert and/or stop conveyor in the case of chain issues.

**Spray Cabinet/Pump Cart:**

Optional system to disinfect chain during operation or shutdown.  
Injection port for customer-supplied disinfecting agents.

**Accessory Pack:**

Kit including thread plates, fasteners, and couplings typically needed for joining components.  
Available as option when needed or for spares.

**Stober Gearbox Tensioning Tool:**

Kit available for moving slack chain through the system via a customer provided 1/4" drive ratchet (see Assembly and Installation section).

**Chain Lubricant:**

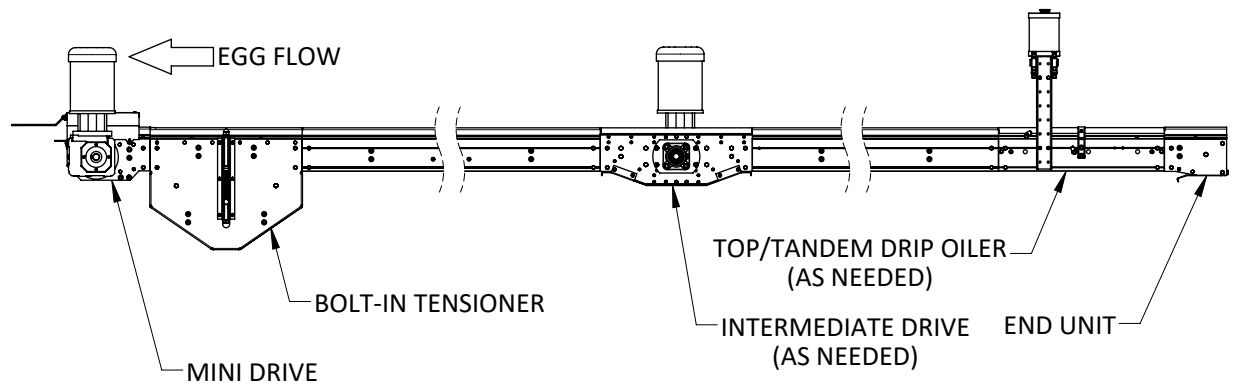
Specifically designed for Lubing Conveyors.  
Contains the appropriate viscosity and additives to apply and stay with the chain as it travels.  
Equivalents available (see General Information section).

**Transfer Complete, 180mm (7")**

Available as option to the standard 95mm Transfers included on specific components.  
Allows for custom length transfers to be cut/fitted by customer.

## Typical System Configurations

### Mini Drive with End Unit

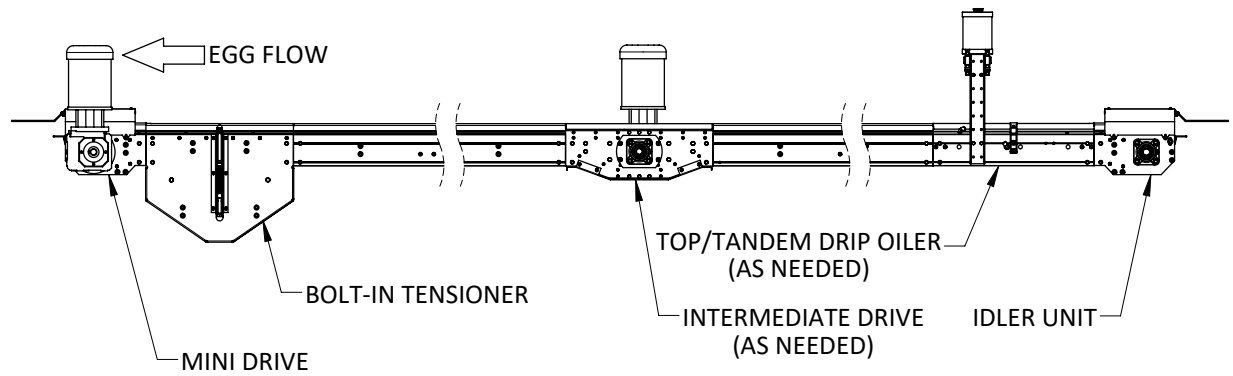


COMPACT TRANSPORTS NOT REQUIRING UPSTREAM TRANSFER

- MINI DRIVE AS MAIN DRIVE UNIT
- TOP/TANDEM OILER(S) POSITIONED AS NEEDED
- BOLT-IN TENSIONER AS MAIN TENSIONING UNIT
- INTERMEDIATE DRIVE(S) POSITIONED AS NEEDED
- UPSTREAM TRANSFER NOT RECOMMENDED

# Section 1

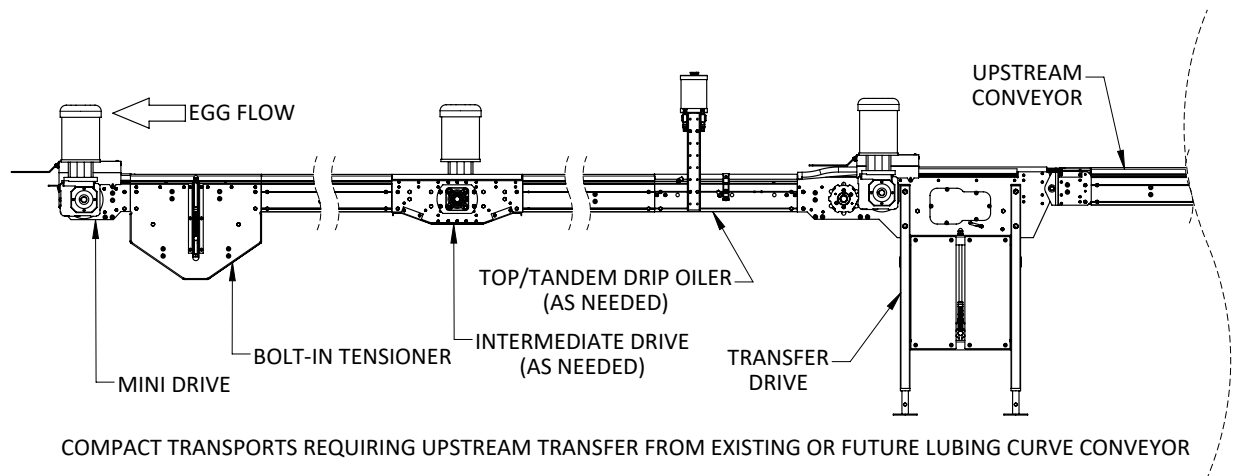
## Mini Drive with Idler Unit



### COMPACT TRANSPORTS REQUIRING UPSTREAM TRANSFER

- MINI DRIVE AS MAIN DRIVE UNIT
- TOP/TANDEM OILER(S) POSITIONED AS NEEDED
- BOLT-IN TENSIONER AS MAIN TENSIONING UNIT
- INTERMEDIATE DRIVE(S) POSITIONED AS NEEDED
- UPSTREAM TRANSFER CAPABILITY

## Mini Drive with Transfer Drive

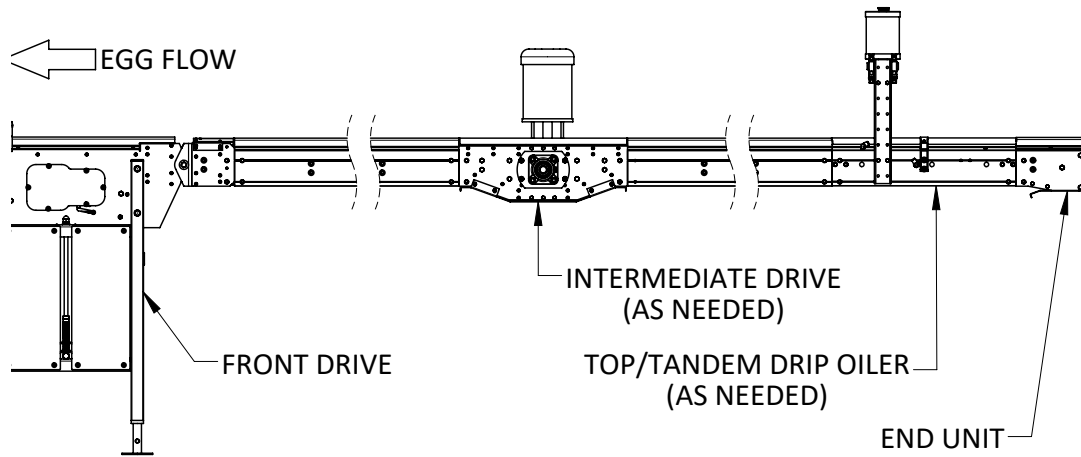


COMPACT TRANSPORTS REQUIRING UPSTREAM TRANSFER FROM EXISTING OR FUTURE LUBING CURVE CONVEYOR

- MINI DRIVE AS MAIN DRIVE UNIT
- TOP/TANDEM OILER(S) POSITIONED AS NEEDED
- BOLT-IN TENSIONER AS MAIN TENSIONING UNIT
- INTERMEDIATE DRIVE(S) POSITIONED AS NEEDED
- UPSTREAM TRANSFER CAPABILITY VIA TRANSFER DRIVE
- TRANSFER DRIVE AS IDLER UNIT FOR MINI DRIVE
- TRANSFER DRIVE AS MAIN DRIVE UNIT FOR UPSTREAM CONVEYOR
- TRANSFER DRIVE AS MAIN TENSIONING UNIT FOR UPSTREAM CONVEYOR
- CONVEYOR SECTIONS UNIQUE, NO SHARED CHAIN
- FIXED TRANSFER WITHIN TRANSFER DRIVE

# Section 1

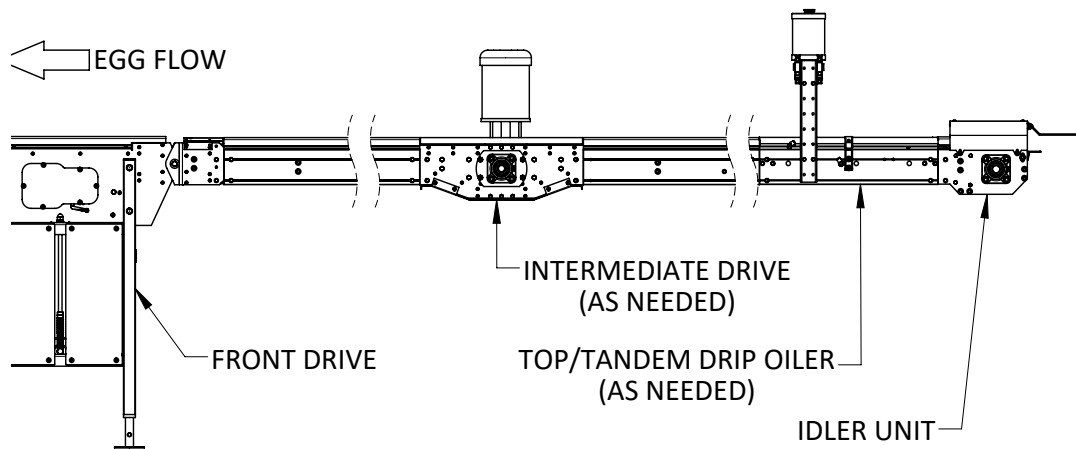
## Front Drive with End Unit



TRANSPORTS NOT REQUIRING UPSTREAM TRANSFER

- FRONT DRIVE AS MAIN DRIVE UNIT
- TOP/TANDEM OILER(S) POSITIONED AS NEEDED
- FRONT DRIVE AS MAIN TENSIONING UNIT
- INTERMEDIATE DRIVE(S) POSITIONED AS NEEDED
- UPSTREAM TRANSFER NOT RECOMMENDED

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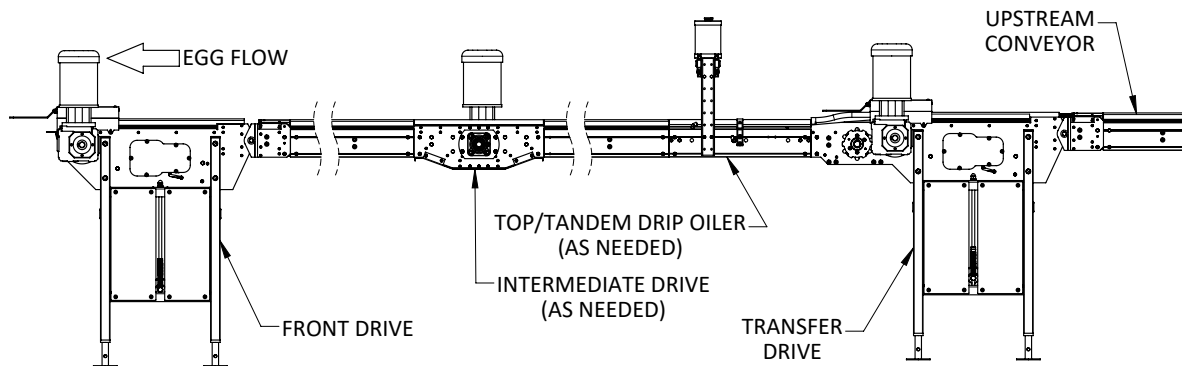
**Front Drive with Idler Unit**

TRANSPORTS REQUIRING UPSTREAM TRANSFER

- FRONT DRIVE AS MAIN DRIVE UNIT
- TOP/TANDEM OILER(S) POSITIONED AS NEEDED
- FRONT DRIVE AS MAIN TENSIONING UNIT
- INTERMEDIATE DRIVE(S) POSITIONED AS NEEDED
- UPSTREAM TRANSFER CAPABILITY

# Section 1

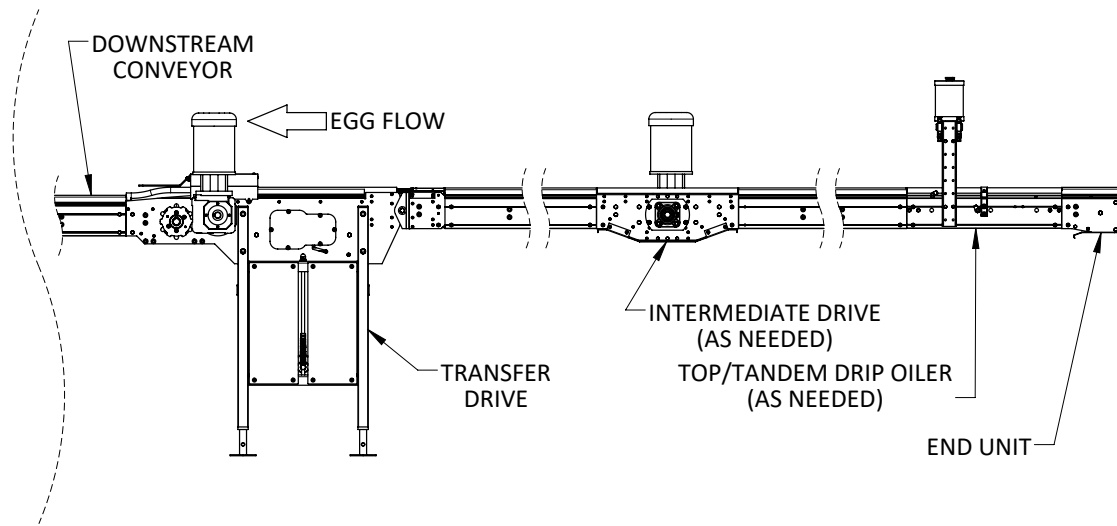
## Front Drive with Transfer Drive



TRANSPORTS REQUIRING UPSTREAM TRANSFER FROM EXISTING OR FUTURE LUBING CURVE CONVEYOR

- FRONT DRIVE AS MAIN DRIVE UNIT
- TOP/TANDEM OILER(S) POSITIONED AS NEEDED
- FRONT DRIVE AS MAIN TENSIONING UNIT
- INTERMEDIATE DRIVE(S) POSITIONED AS NEEDED
- UPSTREAM TRANSFER CAPABILITY VIA TRANSFER DRIVE
- TRANSFER DRIVE AS IDLER UNIT FOR FRONT DRIVE
- TRANSFER DRIVE AS MAIN DRIVE UNIT FOR UPSTREAM CONVEYOR
- TRANSFER DRIVE AS MAIN TENSIONING UNIT FOR UPSTREAM CONVEYOR
- CONVEYOR SECTIONS UNIQUE, NO SHARED CHAIN
- FIXED TRANSFER WITHIN TRANSFER DRIVE

## Transfer Drive with End Unit



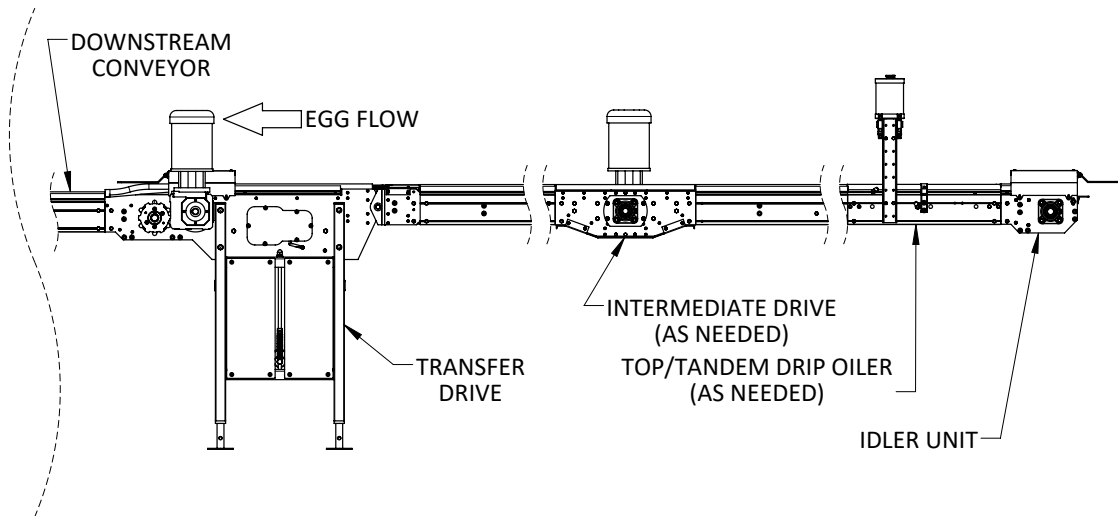
TRANSPORTS REQUIRING DOWNSTREAM TRANSFER FROM EXISTING OR FUTURE LUBING CURVE CONVEYOR

- TRANSFER DRIVE AS MAIN DRIVE UNIT FOR UPSTREAM CONVEYOR
- TOP/TANDEM OILER(S) POSITIONED AS NEEDED
- TRANSFER DRIVE AS MAIN TENSIONING UNIT
- INTERMEDIATE DRIVE(S) POSITIONED AS NEEDED
- UPSTREAM TRANSFER NOT RECOMMENDED
- TRANSFER DRIVE AS IDLER UNIT FOR DOWNSTREAM CONVEYOR
- CONVEYOR SECTIONS UNIQUE, NO SHARED CHAIN
- FIXED TRANSFER WITHIN TRANSFER DRIVE



# Section 1

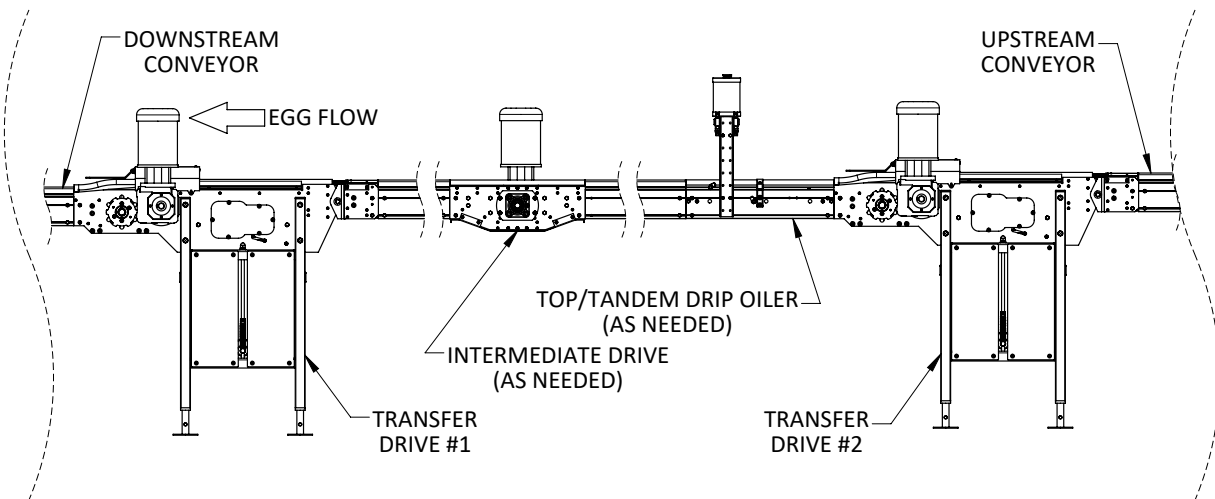
## Transfer Drive with Idler Unit



TRANSPORTS REQUIRING DOWNSTREAM TRANSFER FROM EXISTING OR FUTURE LUBING CURVE CONVEYOR

- TRANSFER DRIVE AS MAIN DRIVE UNIT FOR UPSTREAM CONVEYOR
- TOP/TANDEM OILER(S) POSITIONED AS NEEDED
- TRANSFER DRIVE AS MAIN TENSIONING UNIT
- INTERMEDIATE DRIVE(S) POSITIONED AS NEEDED
- UPSTREAM TRANSFER CAPABILITY
- TRANSFER DRIVE AS IDLER UNIT FOR DOWNSTREAM CONVEYOR
- CONVEYOR SECTIONS UNIQUE, NO SHARED CHAIN
- FIXED TRANSFER WITHIN TRANSFER DRIVE

## Multiple Transfer Drives

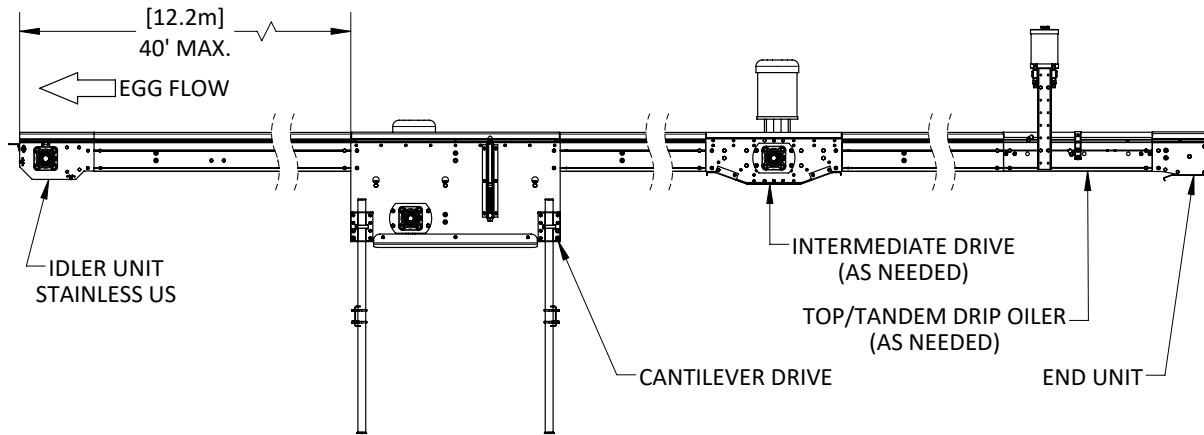


TRANSPORTS REQUIRING UPSTREAM AND DOWNSTREAM TRANSFER FROM EXISTING OR FUTURE LUBING CURVE CONVEYOR

- TRANSFER DRIVE #1 AS MAIN DRIVE UNIT FOR UPSTREAM CONVEYOR
- TOP/TANDEM OILER(S) POSITIONED AS NEEDED
- TRANSFER DRIVE AS MAIN TENSIONING UNIT FOR BOTH SECTIONS
- INTERMEDIATE DRIVE(S) POSITIONED AS NEEDED
- UPSTREAM TRANSFER CAPABILITY
- TRANSFER DRIVE #2 AS IDLER UNIT FOR DOWNSTREAM CONVEYOR
- CONVEYOR SECTIONS UNIQUE, NO SHARED CHAIN
- FIXED TRANSFER WITHIN TRANSFER DRIVE

# Section 1

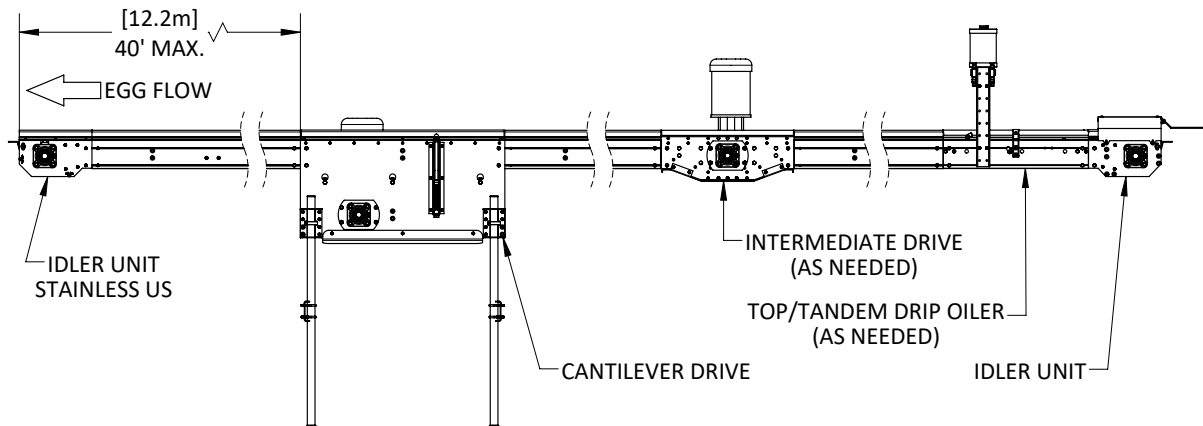
## Cantilever Drive with End Unit



TRANSPORTS REQUIRING OFFSET MAIN DRIVES FOR INCREASED CLEARANCE  
OR RELOCATION OF MAIN DRIVE MOTOR/GEARBOX OUTSIDE WASHDOWN AREA

- CANTILEVER DRIVE AS MAIN DRIVE UNIT
- TOP/TANDEM OILER(S) POSITIONED AS NEEDED
- CANTILEVER DRIVE AS MAIN TENSIONING UNIT
- INTERMEDIATE DRIVE(S) POSITIONED AS NEEDED
- UPSTREAM TRANSFER NOT RECOMMENDED

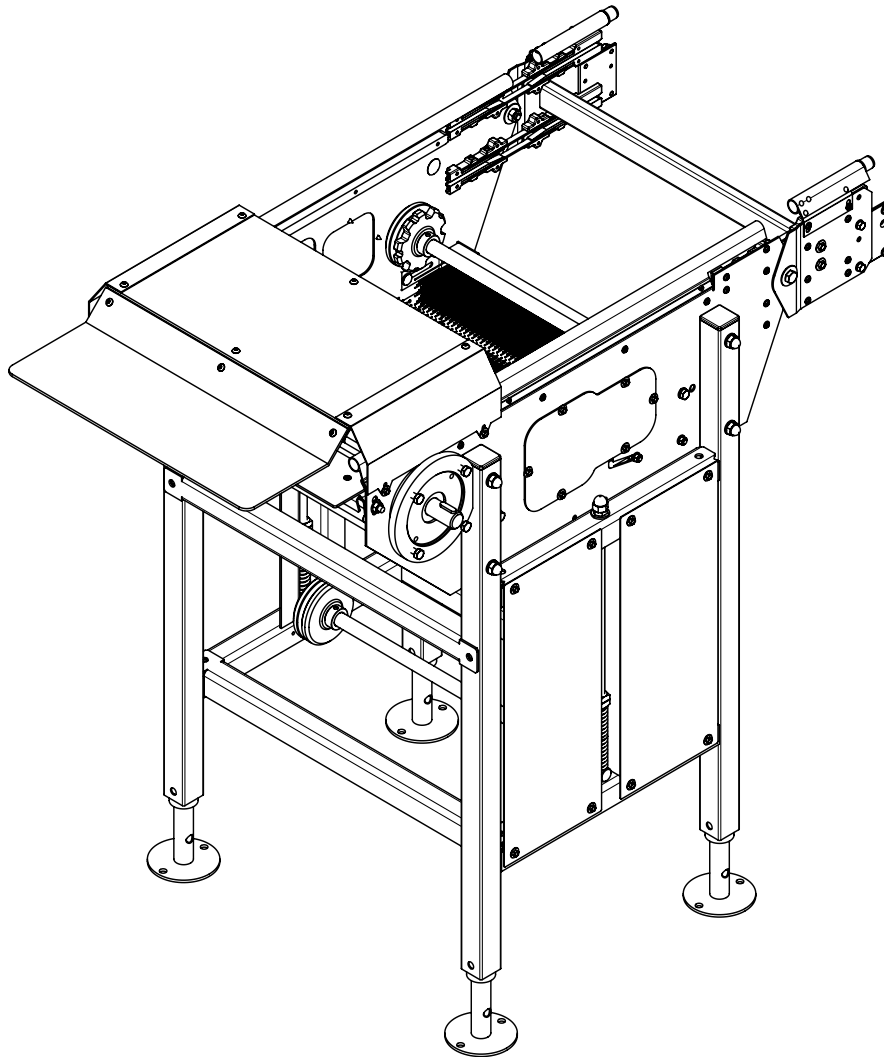
## Cantilever Drive with Idler Unit



TRANSPORTS REQUIRING OFFSET MAIN DRIVES FOR INCREASED CLEARANCE  
OR RELOCATION OF MAIN DRIVE MOTOR/GEARBOX OUTSIDE WASHDOWN AREA

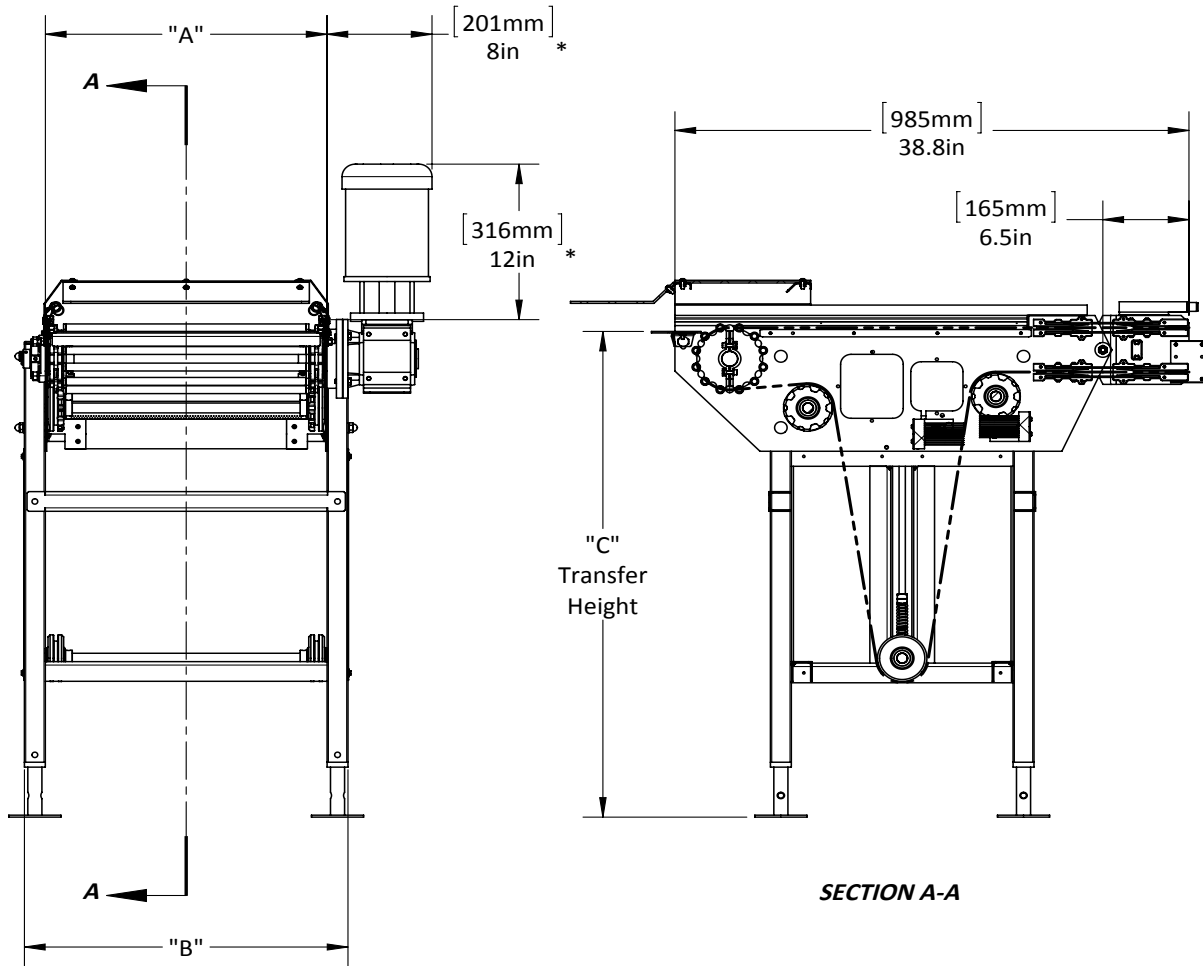
- CANTILEVER DRIVE AS MAIN DRIVE UNIT
- TOP/TANDEM OILER(S) POSITIONED AS NEEDED
- CANTILEVER DRIVE AS MAIN TENSIONING UNIT
- INTERMEDIATE DRIVE(S) POSITIONED AS NEEDED
- UPSTREAM TRANSFER CAPABILITY

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**SECTION 2 COMPONENT DETAILS****Front Drive T350 - T750**

Front Drive			
Conveyor Type	Part Number	Drawing Number	Description
250	--	--	--
350	4840	--	Front Drive T350
500	4801	--	Front Drive T500
750	4870	--	Front Drive T750

# Section 2



SECTION A-A

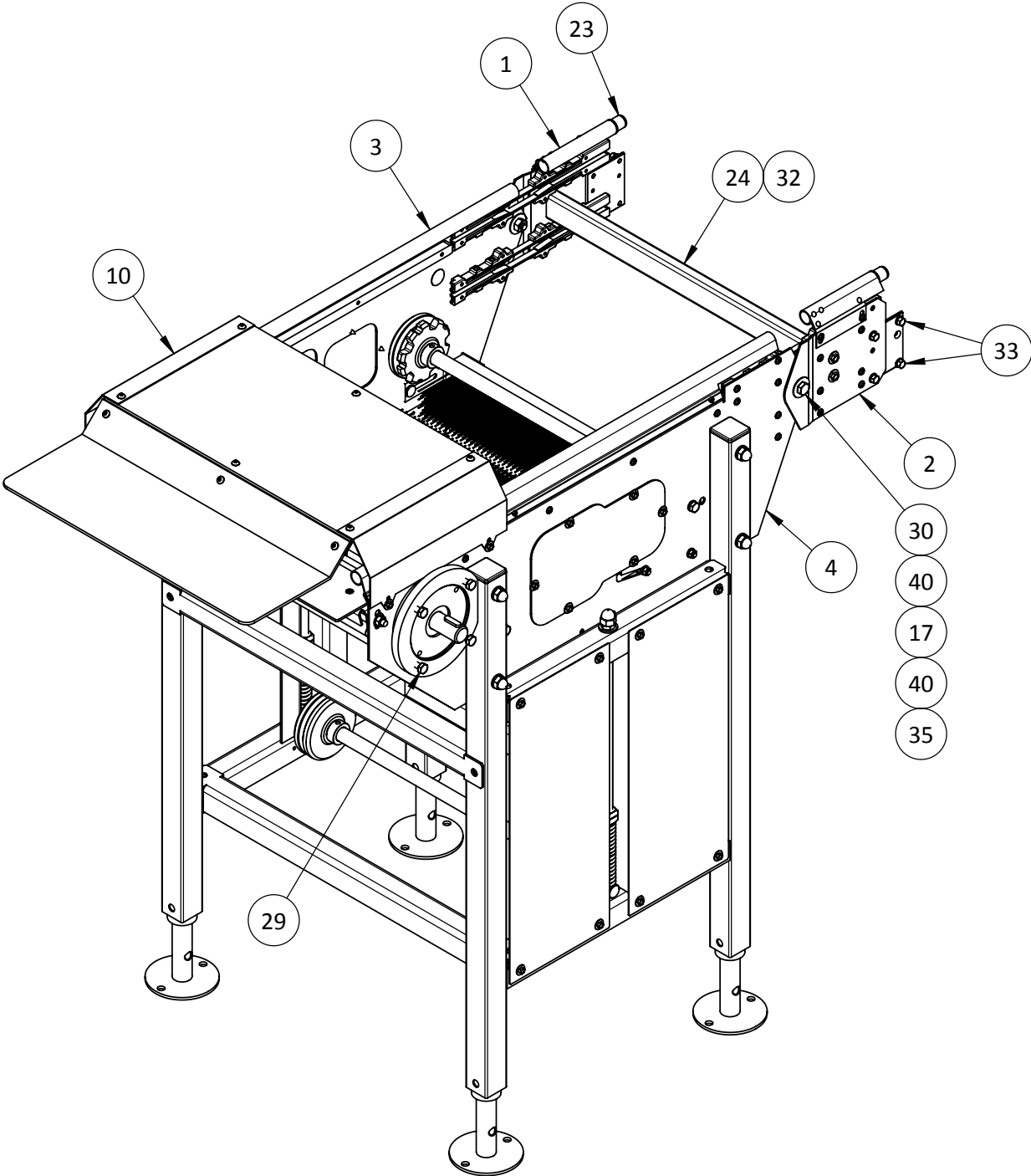
Front Drive						
Part Number	Conveyor Type	A (mm/inches)	B (mm/inches)	C min (mm/inches)	C max (mm/inches)	Chain Length (m/ft)
4840	350	390/15.4	470/18.5	940/37.0	1250/49.2	3/9.7
4801	500	540/21.3	620/24.4			
4870	750	790/31.1	870/34.3			

\*S87.3 Stober Gearbox and G581 Marathon Motor shown, sold separately

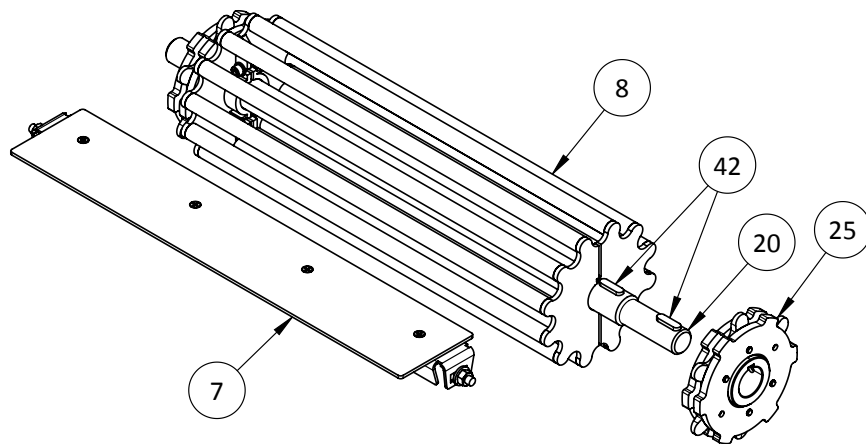
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T350	T500	T750
1	185 100 02 06		Pivot Sidesheet Complete Outer RH	1	1	1
2	185 100 02 07		Pivot Sidesheet Complete Outer LH	1	1	1
3	185 100 03 03		Front Drive Sidesheet Complete RH	1	1	1
4	185 100 03 04		Front Drive Sidesheet Complete LH	1	1	1
5	187 500 02 01		Frame T350	1	-	-
5	185 500 02 01		Frame T500	-	1	-
5	188 500 02 01		Frame T750	-	-	1
6	187 500 05 00		Cleaning Brush Complete T350	2	-	-
6	185 500 05 00		Cleaning Brush Complete T500	-	2	-
6	188 500 05 00		Cleaning Brush Complete T750	-	-	2
7	187 500 10 03		Transfer Complete T350 x 95mm	1	-	-
7	185 500 10 03		Transfer Complete T500 x 95mm	-	1	-
7	188 500 10 03		Transfer Complete T750 x 95mm	-	-	1
8	187 500 11 02		Discharge Wheel Complete T350	1	-	-
8	185 500 11 02		Discharge Wheel Complete T500	-	1	-
8	188 500 11 02		Discharge Wheel Complete T750	-	-	1
9	185 500 22 00		Screw Spindle Main Drive	2	2	2
10	187 500 56 10		Cover Complete T350	1	-	-
10	185 500 56 10		Cover Complete T500	-	1	-
10	188 500 56 10		Cover Complete T750	-	-	1
11	185 510 08 00		Distance Tube	4	4	4
12	185 513 05 00		M6 Square Hole Washer, Zinc	4	4	4
13	187 515 04 02		20mm Axle T350	2	-	-
13	185 515 04 02		20mm Axle T500	-	2	-
13	188 515 04 02		20mm Axle T750	-	-	2
14	185 515 07 00		Pressure Piece	2	2	2
15	187 515 11 02		Tension Axle T350	1	-	-
15	185 515 11 02		Tension Axle T500	-	1	-
15	188 515 11 02		Tension Axle T750	-	-	1
16	185 515 13 00		Distance Washer	2	2	2
17	185 515 13 02		Distance Washer	2	2	2
18	185 515 21 00		Deflection Wheel Grooved 94.7mm	4	4	4
19	185 515 22 00		Deflection Wheel Smooth 94.7mm	2	2	2
20	187 516 01 01		Drive Shaft T350	1	-	-
20	185 516 01 01		Drive Shaft T500	-	1	-
20	188 516 01 01		Drive Shaft T750	-	-	1
21	185 519 09 01		Chain Guard	4	4	4
22	185 519 16 00		Cleaning Brush Cover	2	2	2
23	185 520 18 00		Intermediate Coupling	2	2	2
24	187 524 05 00		Traverse T350	1	-	-
24	185 524 05 00		Traverse T500	-	1	-
24	188 524 05 00		Traverse T750	-	-	1
25	705 001 02 00		Main Drive Sprocket	2	2	2
26		21 28 068	M6 x 16 Carriage Bolt, Zinc	4	4	4
27		21 28 114	M10 x 55 Carriage Bolt, Zinc	8	8	8
28		21 56 087	M8 x 20 Hex Bolt, Zinc	4	4	4
29		21 56 088	M8 x 25 Hex Bolt, Zinc	4	4	4
30		21 56 107	M10 x 20 Hex Bolt, Zinc	2	2	2
31		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	32	32	32
32		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	4	4	4
33		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4	4	4
34		25 15 105	M6 Hex Nut, Zinc	4	4	4
35		25 20 107	M10 Self-Locking Nut, Zinc	2	2	2
36		25 23 107	M10 Cap Nut, Zinc	8	8	8
37		26 02 109	M6 Flat Washer, Zinc	4	4	4
38		26 02 112	M10 Flat Washer, Zinc	8	8	8
39		26 04 111	M8 Lock Washer, Zinc	4	4	4
40		26 34 112	M10 Fender Washer, Zinc	4	4	4
41		26 43 064	Adjusting Ring A20-705	6	6	6
42		27 43 070	8 x 7 x 28 Parallel Key	3	3	3
43		32 02 639	Pressure Spring	4	4	4
44		70 50 008	Plastic Tube Cap	4	4	4

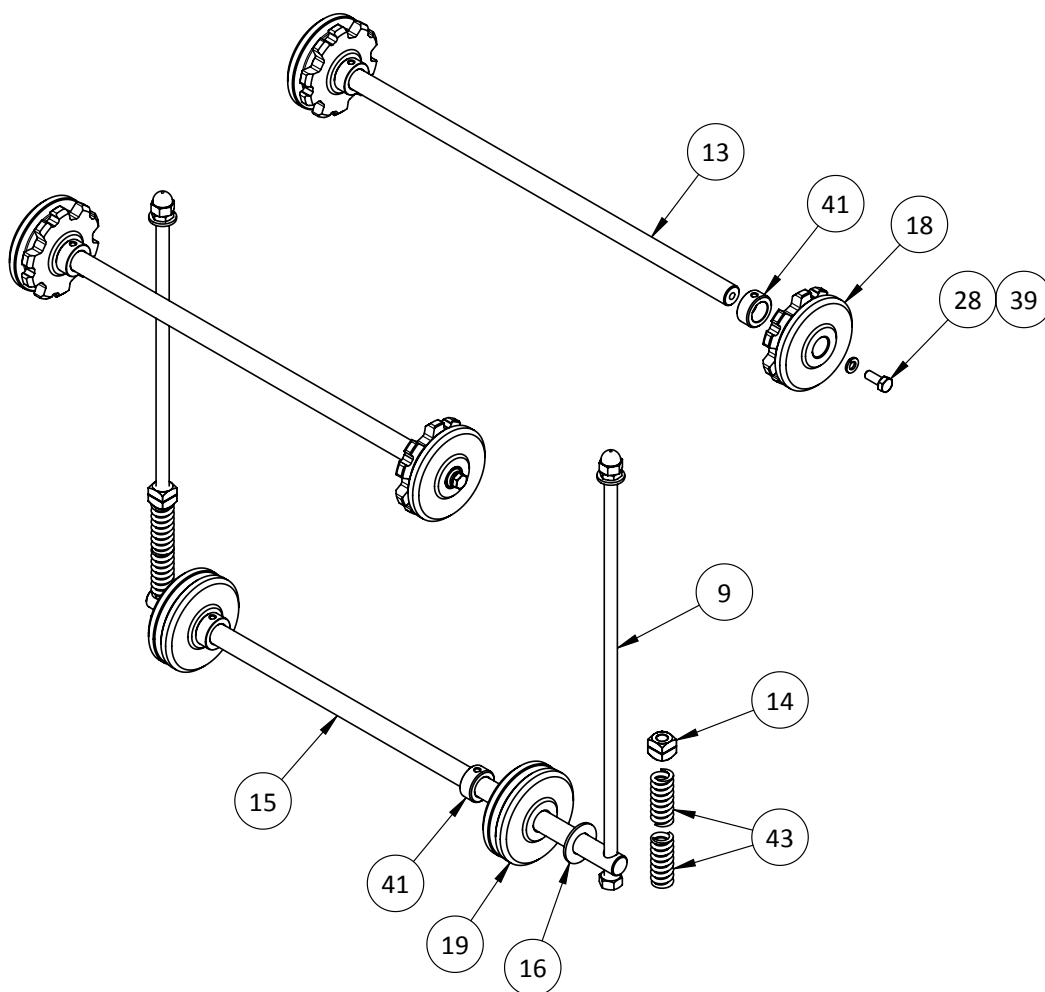
# Section 2





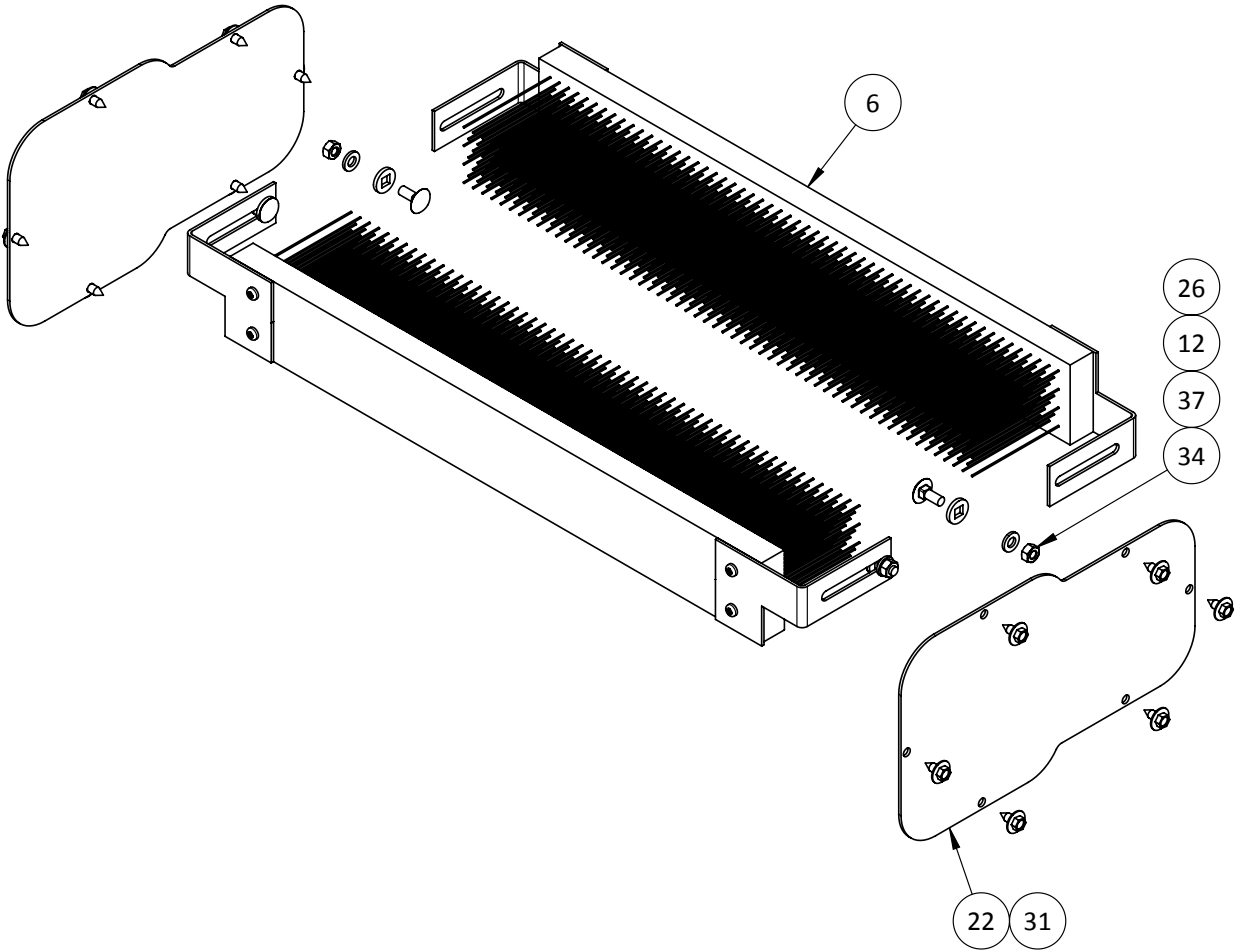


**DRIVE SHAFT COMPONENTS DETAIL**

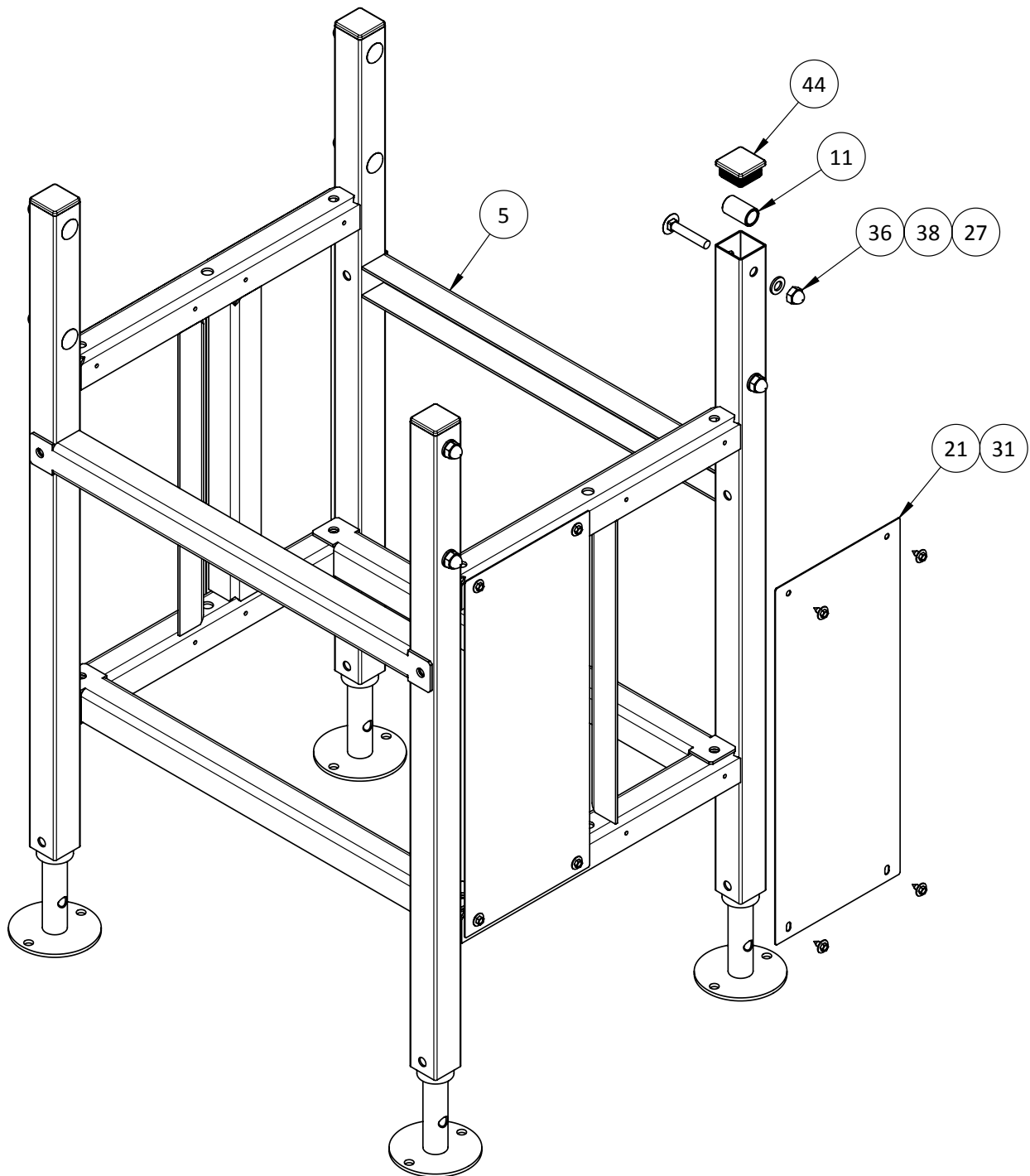


**AXLE COMPONENTS DETAIL**

# Section 2



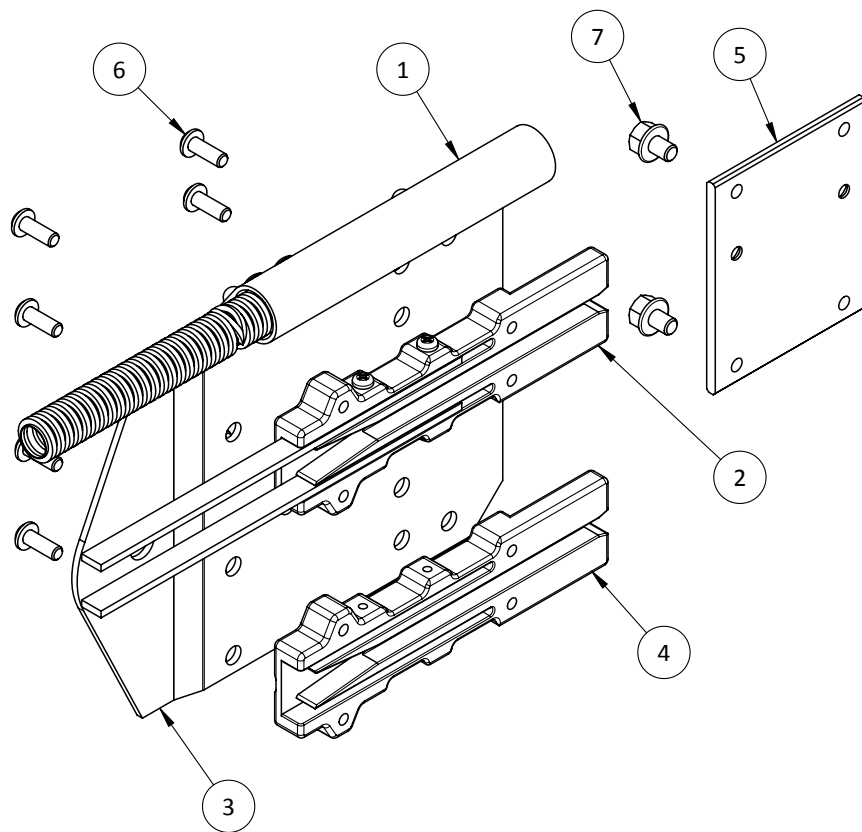
**CLEANING BRUSH COMPONENTS DETAIL**



**FRAME COMPONENTS DETAIL**

## Section 2

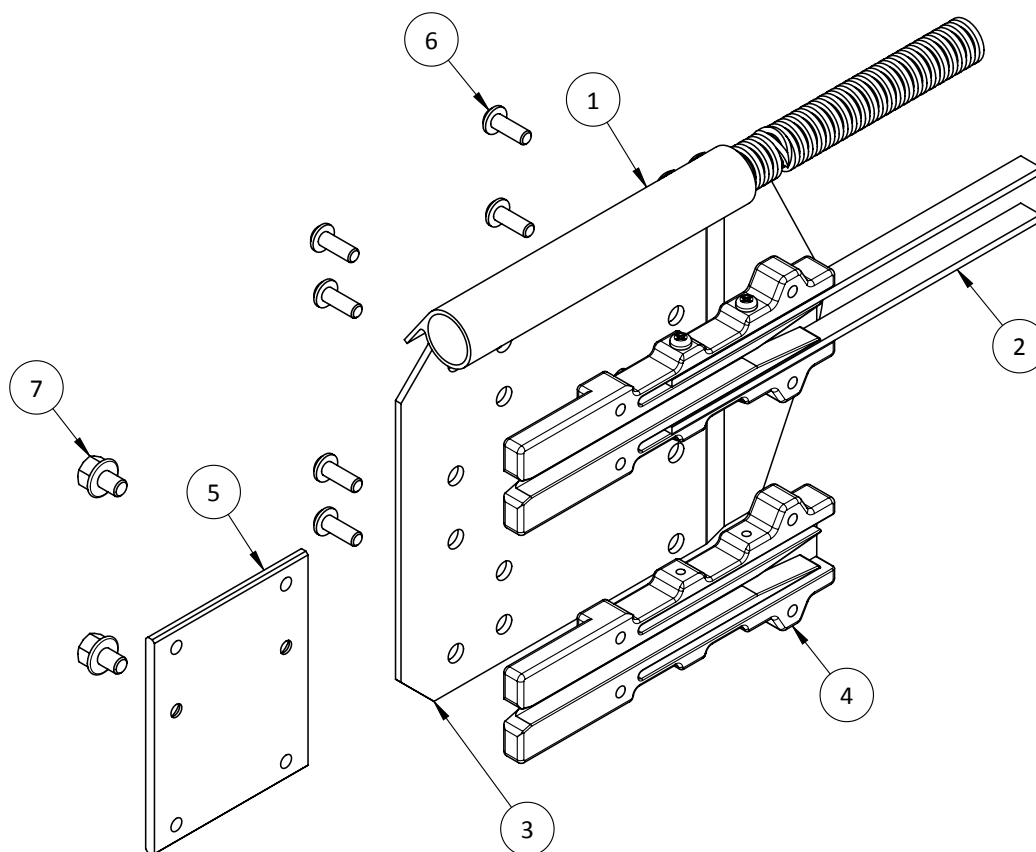
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 09 01		Pivot Flex Capping Complete RH	1
2	185 100 11 00		Sliding Shoe Long Complete	1
3	185 525 01 02		Pivot Outer Sidesheet	1
4	185 525 05 01		Sliding Shoe Long	1
5	185 525 06 00		Thread Plate	1
6		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	8
7		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	2



Pivot Sidesheet Complete Outer RH			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 100 02 06	Pivot Sidesheet Complete Outer RH
350			
500			
750			

## Section 2

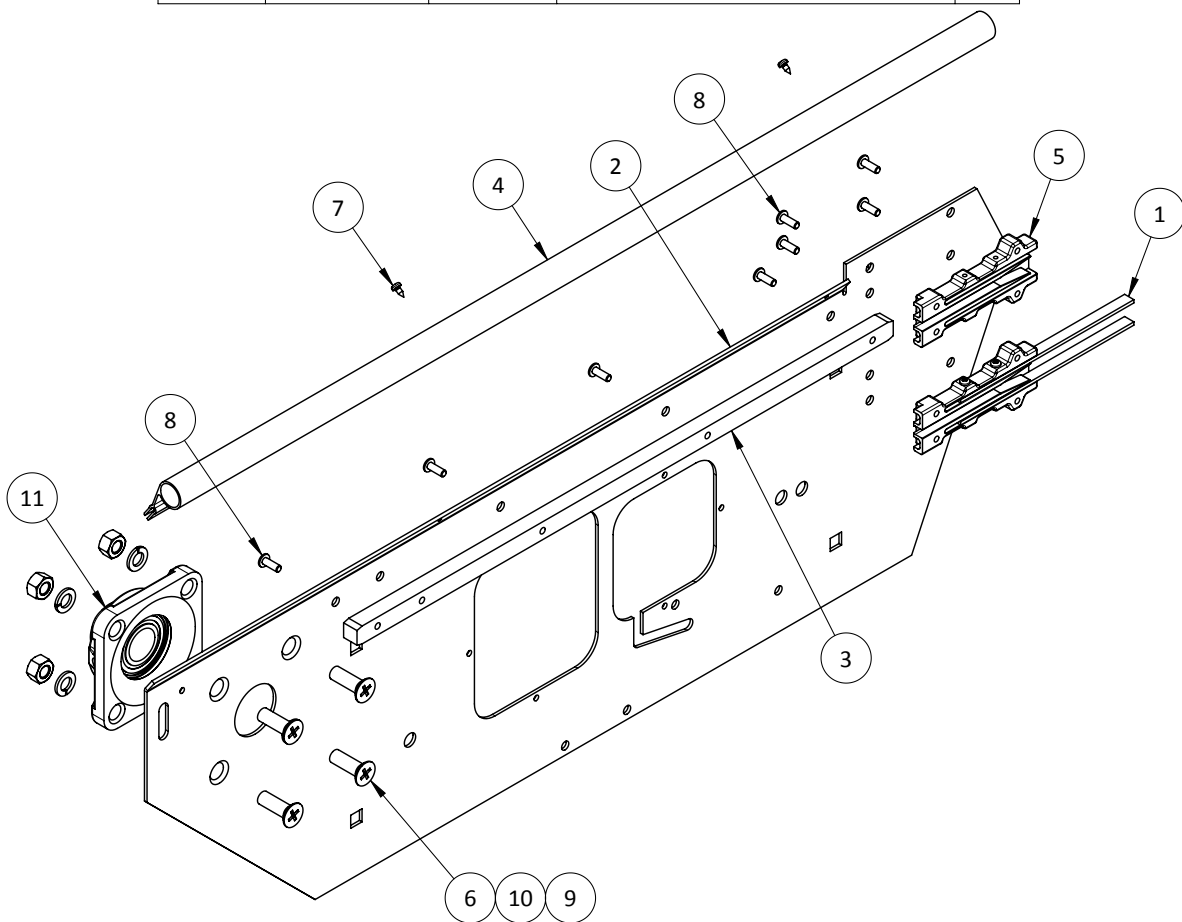
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 09 00		Pivot Flex Capping Complete LH	1
2	185 100 11 00		Sliding Shoe Long Complete	1
3	185 525 01 02		Pivot Outer Sidesheet	1
4	185 525 05 01		Sliding Shoe Long	1
5	185 525 06 00		Thread Plate	1
6		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	8
7		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	2



Pivot Sidesheet Complete Outer LH			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 100 02 07	Pivot Sidesheet Complete Outer LH
350			
500			
750			

## Section 2

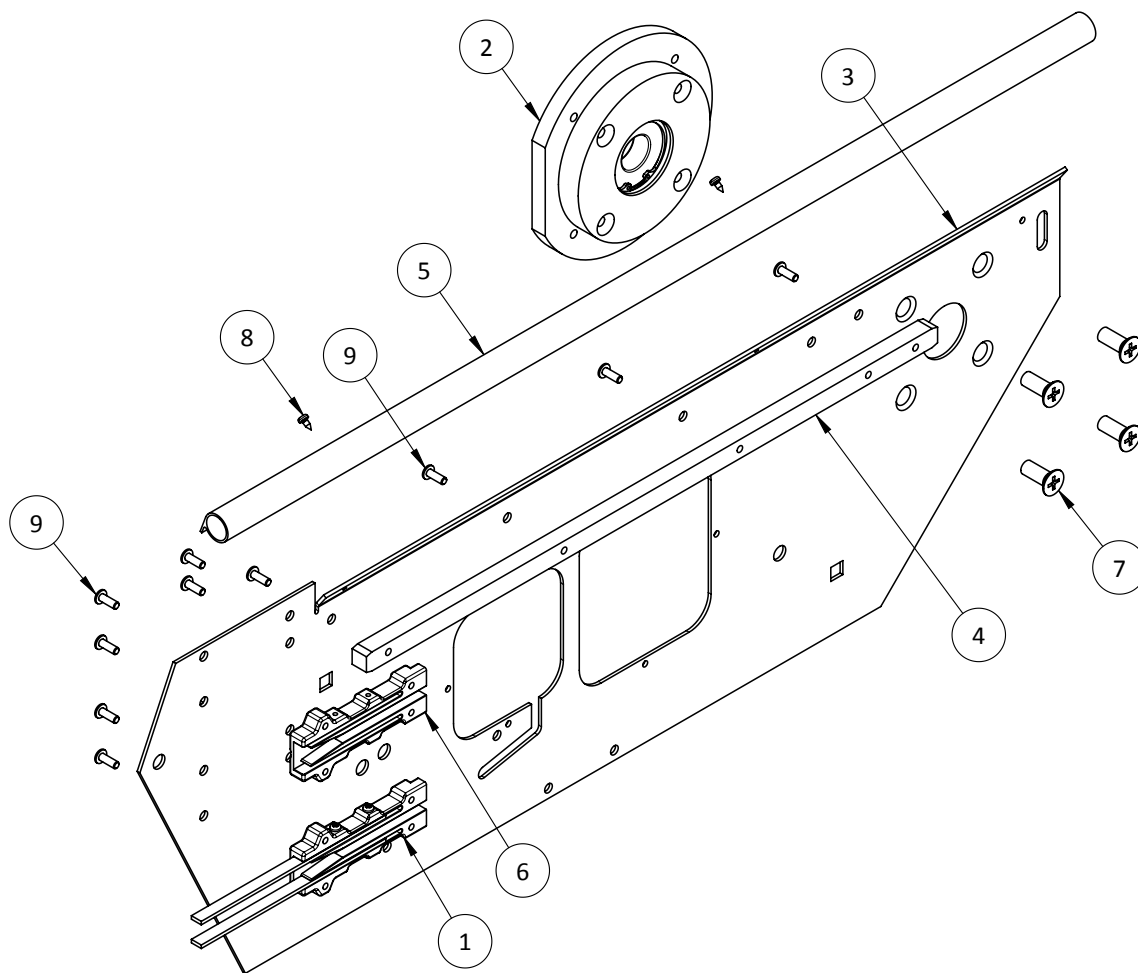
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 13 00		Sliding Shoe Short Complete	1
2	185 511 04 07		Front Drive Sidesheet RH	1
3	185 511 21 00		Guide Rail Front Drive	1
4	185 520 09 16		Front Drive Capping RH	1
5	185 525 05 02		Sliding Shoe Short	1
6		21 63 109	M10 x 30 Countersunk Screw, Zinc	4
7		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	2
8		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	12
9		25 15 107	M10 Hex Nut, Zinc	4
10		26 04 112	M10 Lock Washer, Zinc	4
11		34 10 205	4-Bolt Flange Bearing 25mm	1



Front Drive Sidesheet Complete RH			
Conveyor Type	Part Number	Drawing Number	Description
350	--	185 100 03 03	Front Drive Sidesheet Complete RH
500	--		
750	--		

## Section 2

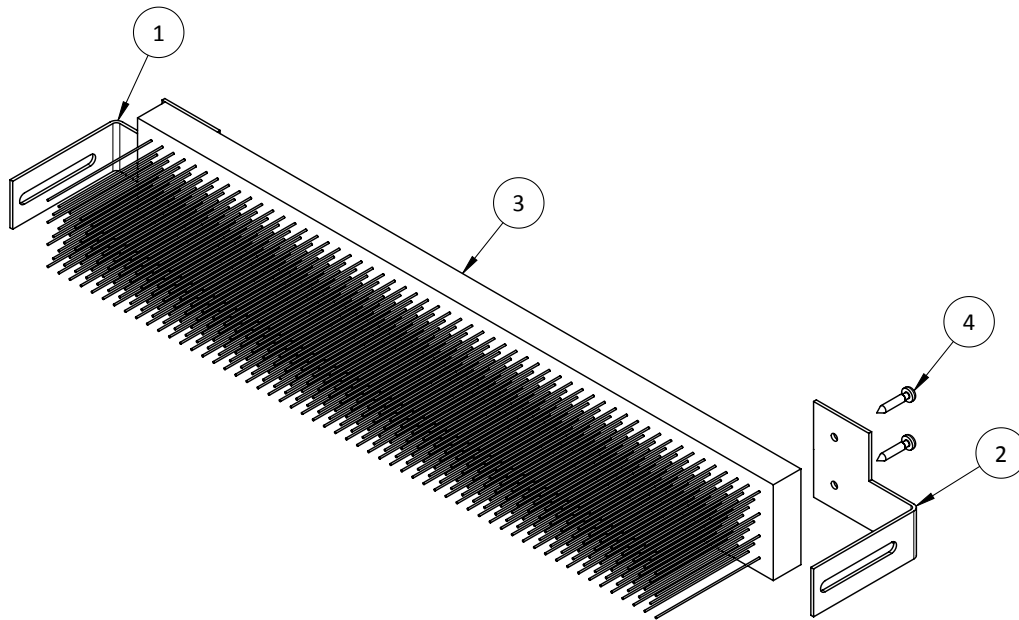
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 13 00		Sliding Shoe Short Complete	1
2	185 500 55 01		Flange Complete Main Drive	1
3	185 511 04 06		Front Drive Sidesheet LH	1
4	185 511 21 00		Guide Rail Front Drive	1
5	185 520 09 15		Front Drive Capping LH	1
6	185 525 05 02		Sliding Shoe Short	1
7		21 63 108	M10 x 25 Countersunk Screw, Zinc	4
8		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	2
9		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	12



Front Drive Sidesheet Complete LH			
Conveyor Type	Part Number	Drawing Number	Description
350	--	185 100 03 04	Front Drive Sidesheet Complete LH
500	--		
750	--		

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T350	T500
1	185 513 03 00		Cleaning Brush Angle Bracket LH	1	1
2	185 513 03 01		Cleaning Brush Angle Bracket RH	1	1
3	187 513 04 00		Cleaning Brush T350	1	-
3	185 513 04 00		Cleaning Brush T500	-	1
4		21 80 020	M4.2 x 22 Self-Tapping Screw, Zinc	4	4

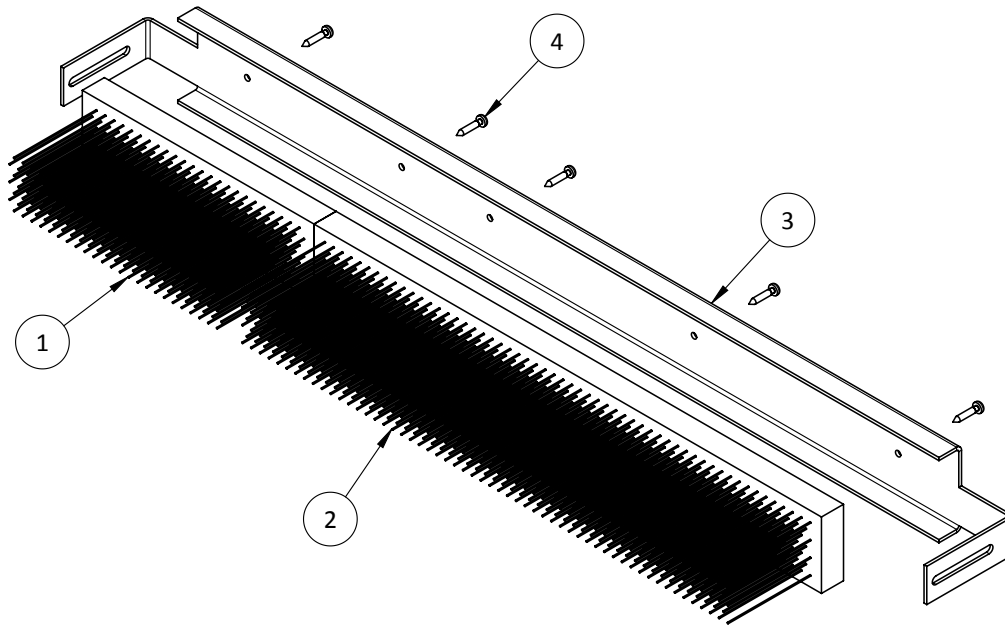


Cleaning Brush Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	--	--
350	--	187 500 05 00	Cleaning Brush Complete T350
500	--	185 500 05 00	Cleaning Brush Complete T500



## Section 2

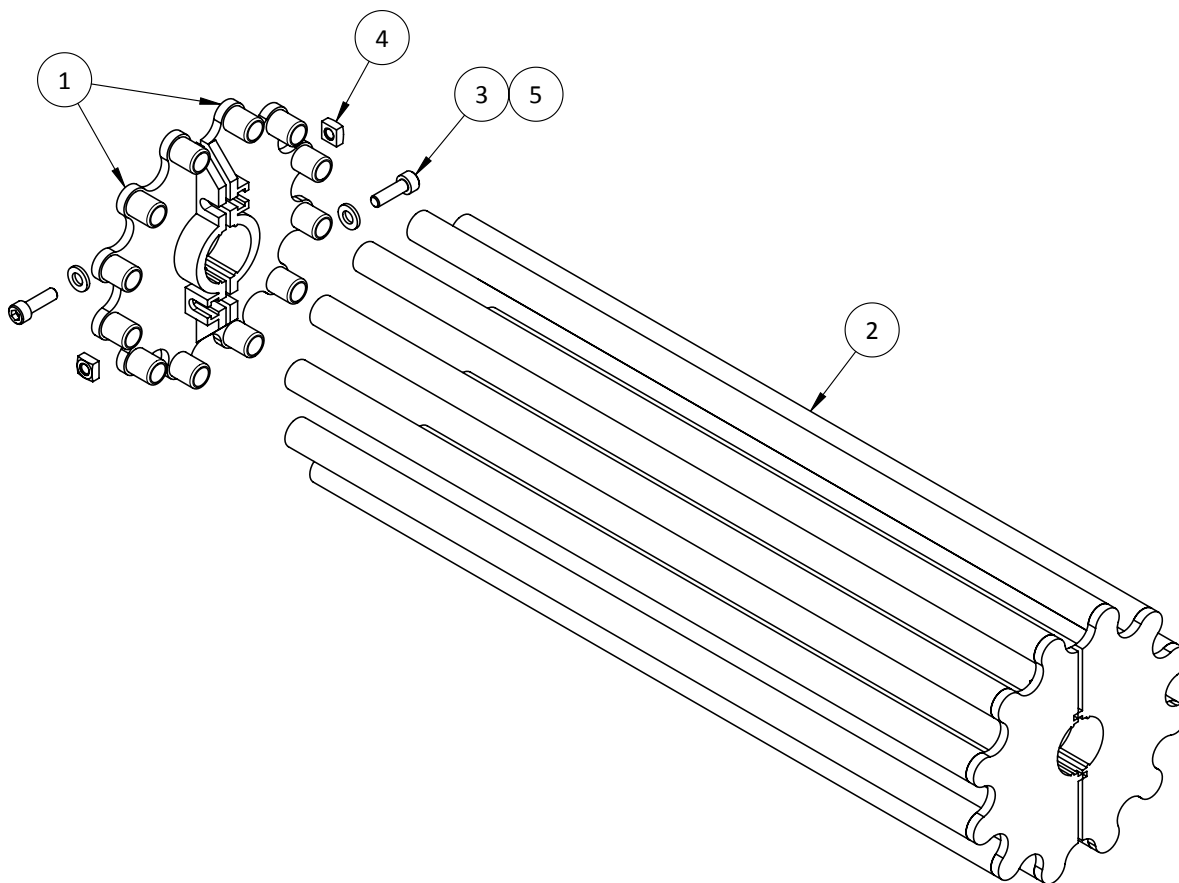
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T750
1	186 513 04 00		Cleaning Brush T250	1
2	185 513 04 00		Cleaning Brush T500	1
3	188 513 01 00		Brush Support Channel T750	1
4		21 80 020	M4.2 x 22 Self-Tapping Screw, Zinc	5



Cleaning Brush Complete			
Conveyor Type	Part Number	Drawing Number	Description
750	--	188 500 05 00	Cleaning Brush Complete T750

## Section 2

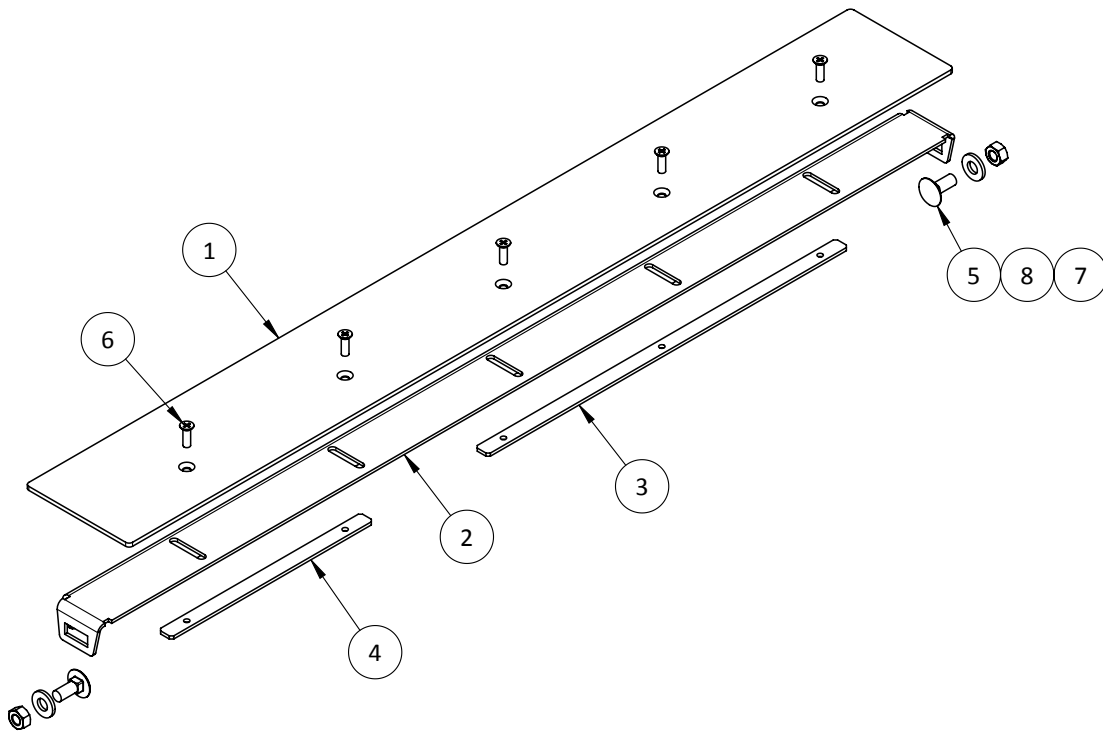
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 518 03 01		Driving Plate	4	4	4	4
2	186 518 05 01		Discharge Tube T250	12	-	-	-
2	187 518 05 01		Discharge Tube T350	-	12	-	-
2	185 518 05 01		Discharge Tube T500	-	-	12	-
2	188 518 05 01		Discharge Tube T750	-	-	-	12
3		21 42 069	M6 x 20 SHCS, Zinc	4	4	4	4
4		25 09 105	M6 Square Nut, Zinc	4	4	4	4
5		26 02 109	M6 Flat Washer, Zinc	4	4	4	4



Discharge Wheel Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 11 02	Discharge Wheel Complete T250
350	--	187 500 11 02	Discharge Wheel Complete T350
500	--	185 500 11 02	Discharge Wheel Complete T500
750	--	188 500 11 02	Discharge Wheel Complete T750

## Section 2

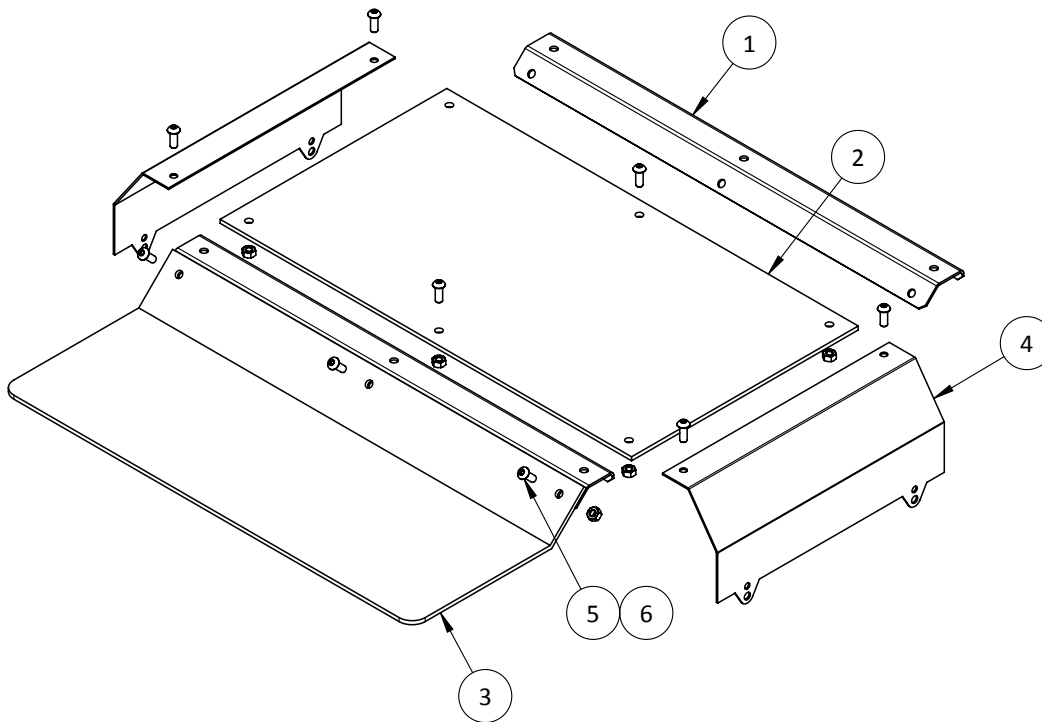
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	186 518 02 00		Transfer Plate T250 x 95mm	1	-	-	-
1	187 518 02 00		Transfer Plate T350 x 95mm	-	1	-	-
1	185 518 02 00		Transfer Plate T500 x 95mm	-	-	1	-
1	188 518 02 00		Transfer Plate T750 x 95mm	-	-	-	1
2	186 518 43 00		Transfer Angle T250	1	-	-	-
2	187 518 43 00		Transfer Angle T350	-	1	-	-
2	185 518 43 00		Transfer Angle T500	-	-	1	-
2	188 518 43 00		Transfer Angle T750	-	-	-	1
3	187 518 44 00		Thread Plate T350	-	1	-	1
4	189 518 44 00		Thread Plate T200	1	-	2	1
5		21 28 087	M8 x 20 Carriage Bolt, Zinc	2	2	2	2
6		21 63 049	M5 x 16 Countersunk Screw, Zinc	2	3	4	5
7		25 15 106	M8 Hex Nut, Zinc	2	2	2	2
8		26 02 111	M8 Flat Washer, Zinc	2	2	2	2



Transfer Complete 95mm				
Conveyor Type	Part Number	Drawing Number	Description	
250	--	186 500 10 03	Transfer Complete T250 x 95mm	
350	--	187 500 10 03	Transfer Complete T350 x 95mm	
500	--	185 500 10 03	Transfer Complete T500 x 95mm	
750	--	188 500 10 03	Transfer Complete T750 x 95mm	

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T750	T500
1	186 510 07 00		Cover U-Profile T250	2	-	-	-
1	187 510 07 00		Cover U-Profile T350	-	2	-	-
1	188 510 07 00		Cover U-Profile T750	-	-	2	-
1	185 510 07 00		Cover U-Profile T500	-	-	-	2
2	186 510 10 00		Top Cover T250	1	-	-	-
2	187 510 10 00		Top Cover T350	-	1	-	-
2	188 510 10 00		Top Cover T750	-	-	1	-
2	185 510 10 00		Top Cover T500	-	-	-	1
3	186 510 10 02		Transfer Cover T250	1	-	-	-
3	187 510 10 02		Transfer Cover T350	-	1	-	-
3	188 510 10 02		Transfer Cover T750	-	-	1	-
3	185 510 10 02		Transfer Cover T500	-	-	-	1
4	185 510 26 00		Cover Sidesheet	2	2	2	2
5		21 90 068	M6 x 16 BHCS, Zinc	9	6	9	9
6		25 15 105	M6 Hex Nut, Zinc	9	9	9	9

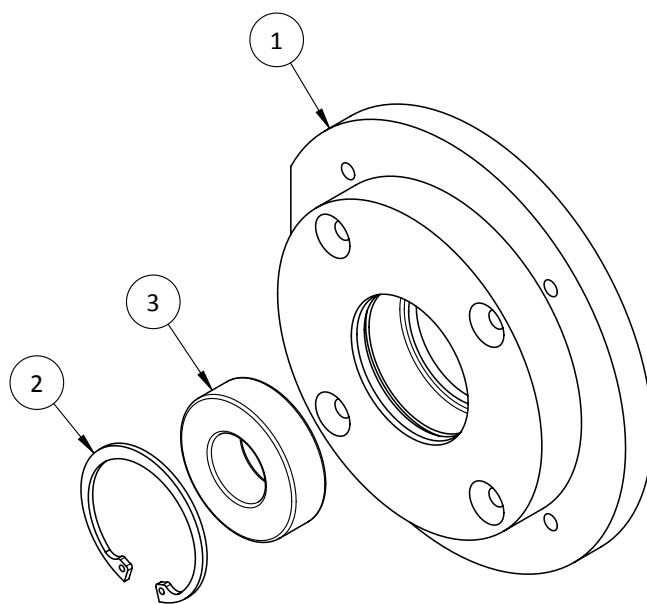


Cover Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 56 10	Cover Complete T250
350	--	187 500 56 10	Cover Complete T350
500	--	185 500 56 10	Cover Complete T500
750	--	188 500 56 10	Cover Complete T750

## Section 2

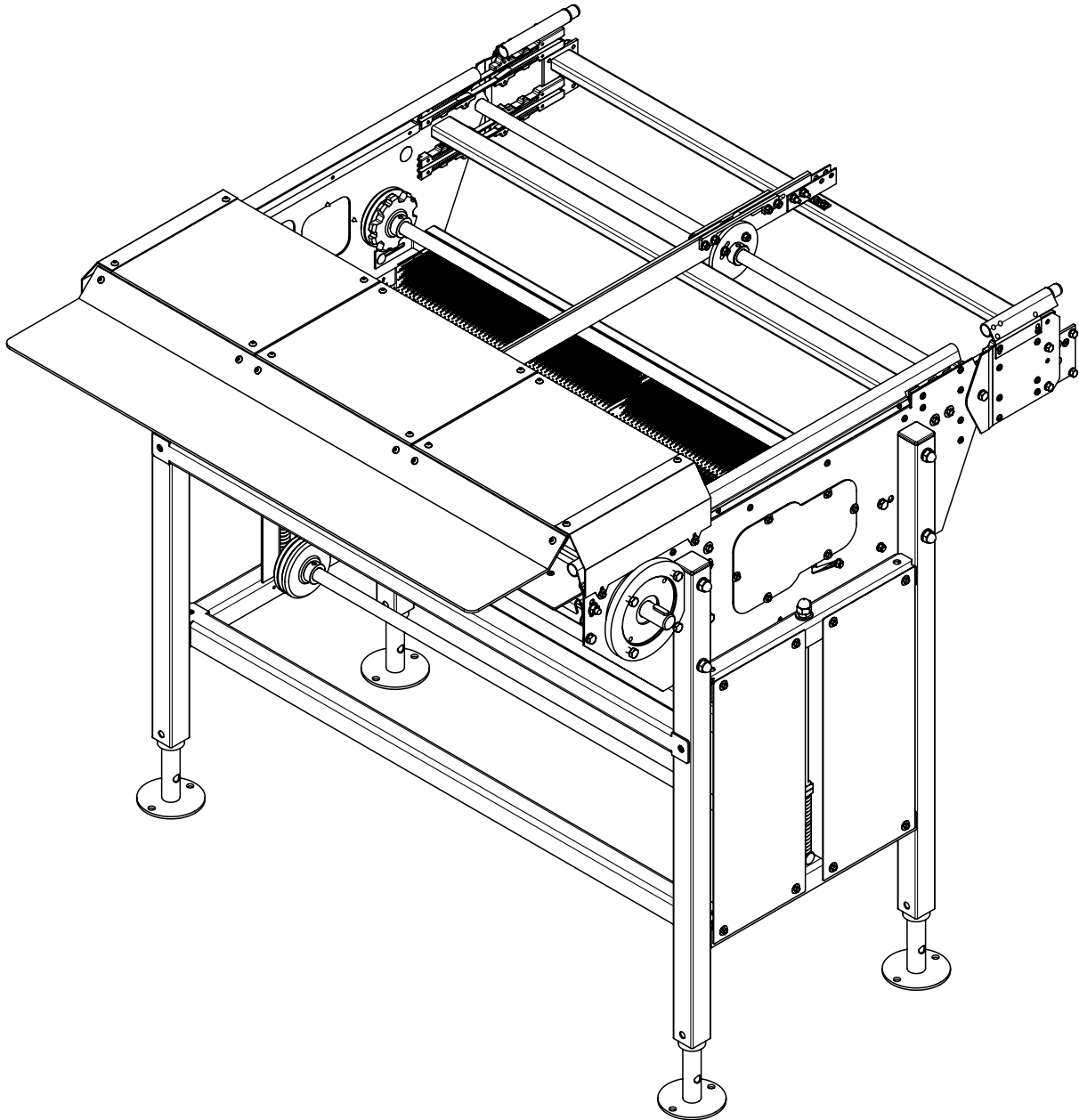
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 511 30 01*		Flange	1
2		26 36 075	Internal Retaining Ring 52x2	1
3		6205.2RSR	Bearing 25mm	1

\*ITEM NOT AVAILABLE INDIVIDUALLY, IF NEEDED ORDER COMPLETE ASSEMBLY (SEE CHART BELOW)

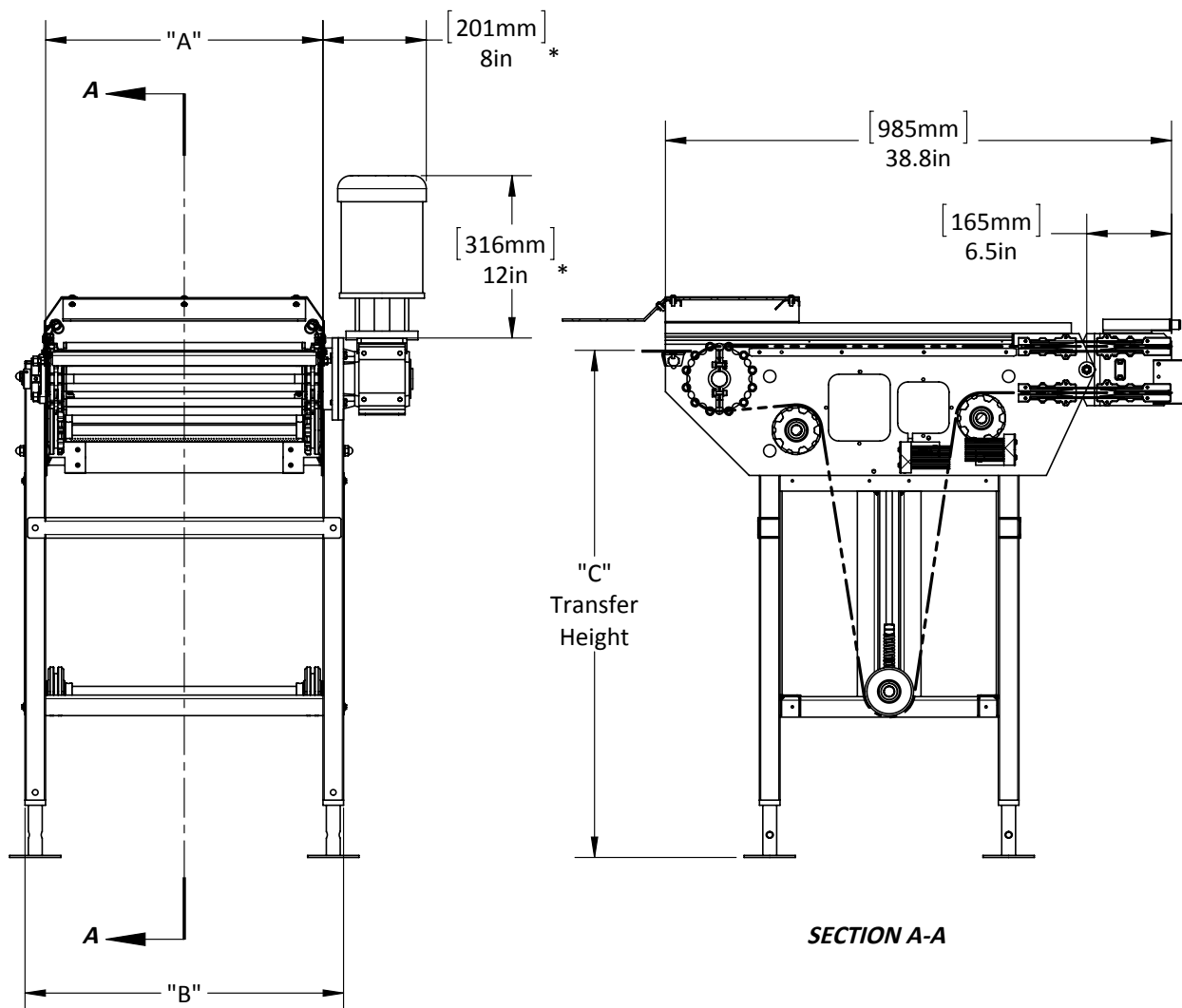


Flange Complete Main Drive			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 500 55 01	Flange Complete Main Drive
350	--		
500	--		
750	--		

Front Drive T1000



Front Drive			
Conveyor Type	Part Number	Drawing Number	Description
1000	5401	--	Front Drive T1000



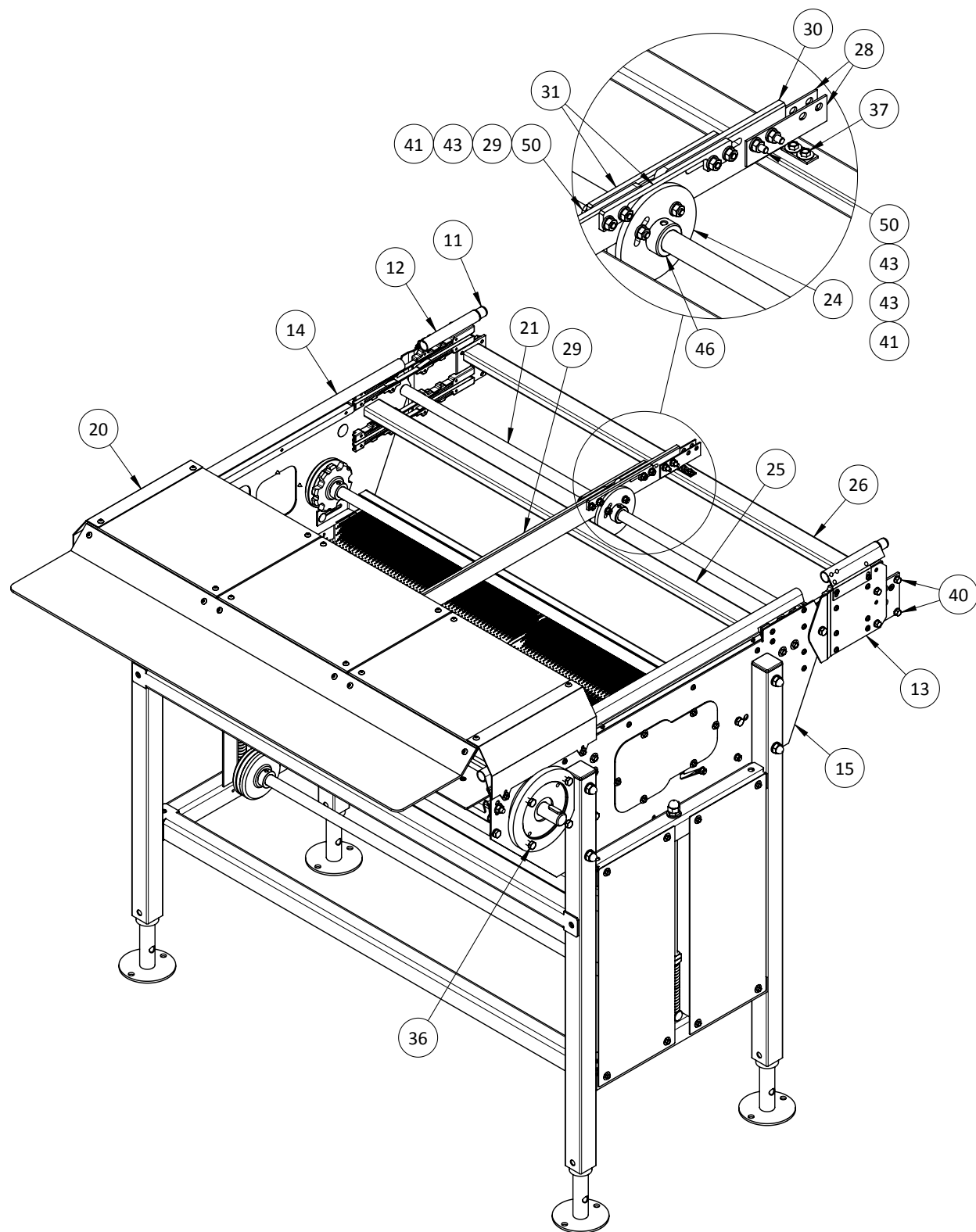
Front Drive						
Part Number	Conveyor Type	A (mm/inches)	B (mm/inches)	C min (mm/inches)	C max (mm/inches)	Chain Length (m/ft)
5401	1000	1040/41.0	1120/44.1	940/37.0	1250/49.2	3/9.7

\*S87.3 Stober Gearbox and G581 Marathon Motor shown, sold separately

## Section 2

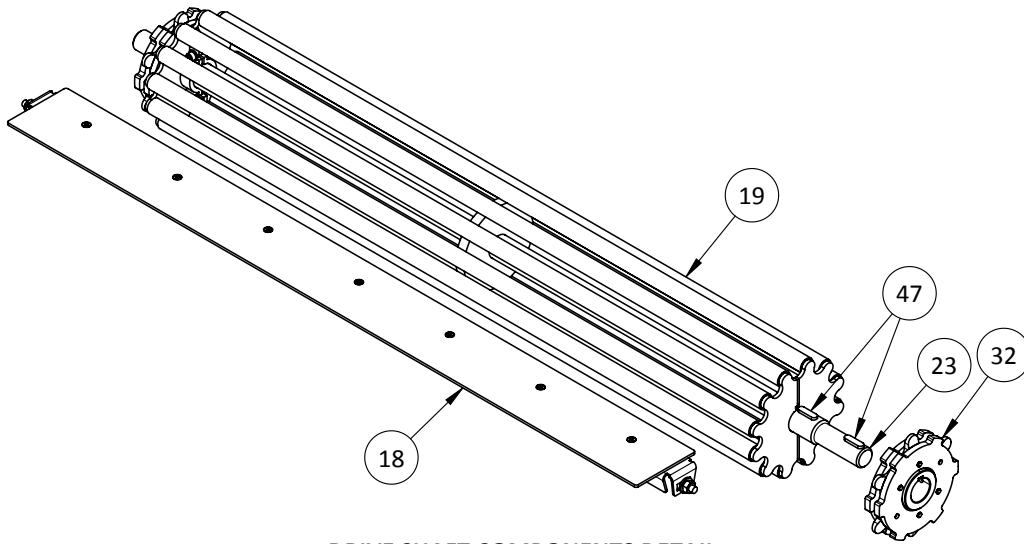
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	185 500 22 00		Screw Spindle Main Drive	2
2	185 510 08 00		Distance Tube	4
3	185 513 05 00		M6 Square Hole Washer, Zinc	4
4	185 515 07 00		Pressure Piece	2
5	185 515 13 00		Distance Washer	2
6	185 515 13 02		Distance Washer	2
7	185 515 21 00		Deflection Wheel Grooved 94.7mm	4
8	185 515 22 00		Deflection Wheel Smooth 94.7mm	2
9	185 519 09 01		Chain Guard	4
10	185 519 16 00		Cleaning Brush Cover	2
11	185 520 18 00		Intermediate Coupling	2
12	191 100 02 06		Pivot Sidesheet Complete Outer RH T1000	1
13	191 100 02 07		Pivot Sidesheet Complete Outer LH T1000	1
14	191 100 03 03		Front Drive Sidesheet Complete RH T1000	1
15	191 100 03 06		Front Drive Sidesheet Complete LH T1000	1
16	191 500 02 01		Frame T1000	1
17	191 500 05 00		Cleaning Brush Complete T1000	2
18	191 500 10 03		Transfer Complete T1000 x 95mm	1
19	191 500 11 02		Discharge Wheel Complete T1000	1
20	191 500 56 10		Cover Complete T1000	1
21	191 515 04 02		20mm Axle T1000	4
22	191 515 11 02		Tension Axle T1000	1
23	191 516 01 01		Drive Shaft T1000	1
24	191 518 14 00		Fastening Disk	1
25	191 524 05 00		Traverse T1000 (No Holes)	1
26	191 524 05 06		Traverse NarrowT1000 (Wide Side Holes)	1
27	191 524 05 07		Traverse T1000 (Thin Side Holes)	1
28	191 524 07 00		Connecting Angle	4
29	191 525 20 00		Sliding Profile	1
30	191 525 22 00		Sliding Profile	1
31	191 525 25 00		Slide Strip	2
32	705 001 02 00		Main Drive Sprocket	2
33		21 28 068	M6 x 16 Carriage Bolt, Zinc	4
34		21 28 114	M10 x 55 Carriage Bolt, Zinc	8
35		21 56 087	M8 x 20 Hex Bolt, Zinc	8
36		21 56 088	M8 x 25 Hex Bolt, Zinc	4
37		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	40
38		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	8
39		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	4
40		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4
41		25 15 105	M6 Hex Nut, Zinc	16
42		25 23 107	M10 Cap Nut, Zinc	8
43		26 02 109	M6 Flat Washer, Zinc	28
44		26 02 112	M10 Flat Washer, Zinc	8
45		26 04 111	M8 Lock Washer, Zinc	8
46		26 43 064	Adjusting Ring A20-705	8
47		27 43 070	8 x 7 x 28 Parallel Key	3
48		32 02 639	Pressure Spring	4
49		70 50 008	Plastic Tube Cap	4
50		F8-7-46-2-171	M6 x 30 Hex Bolt, Zinc	10
51		F8-7-46-2-176	M6 x 35 Hex Bolt, Zinc	2



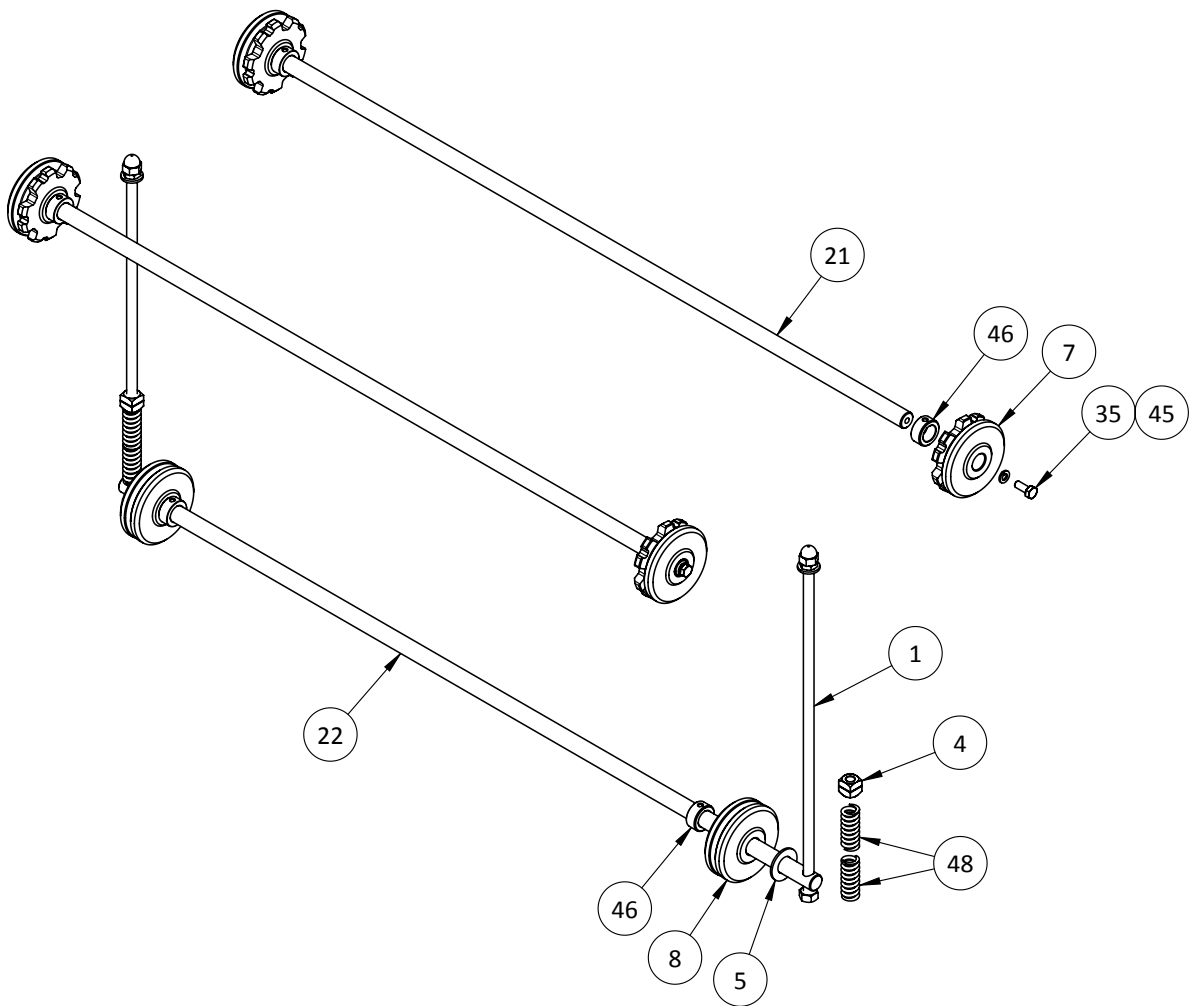


## Section 2

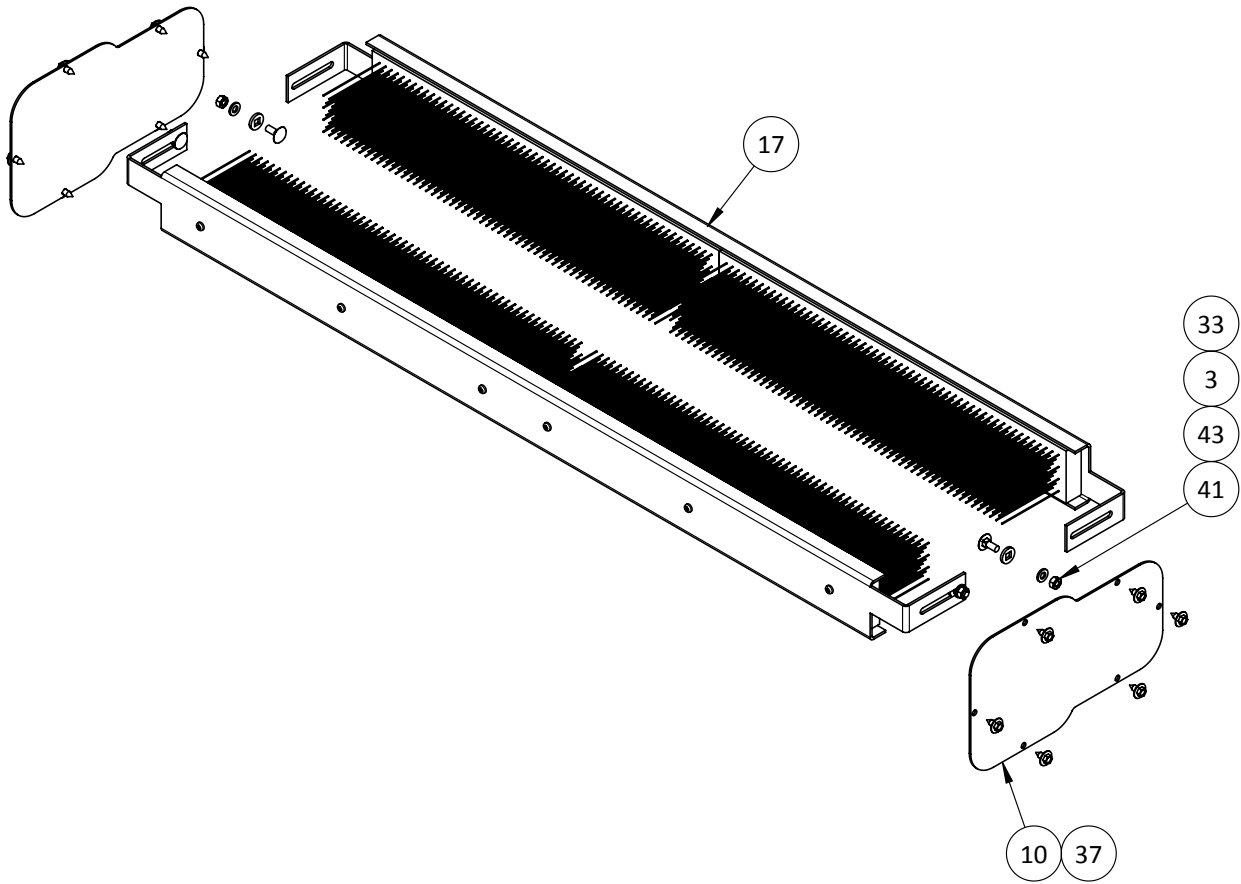
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**DRIVE SHAFT COMPONENTS DETAIL**



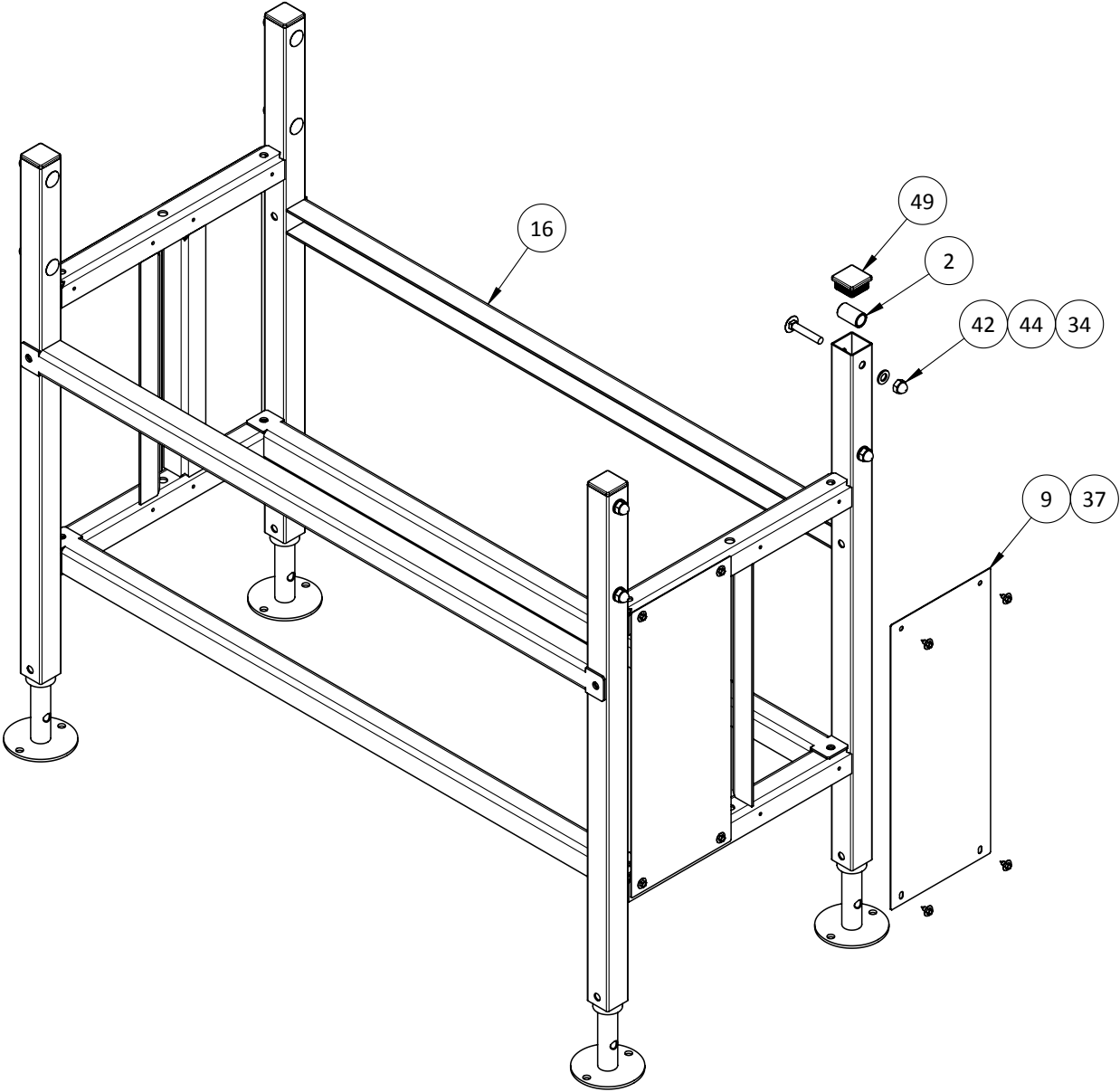
**AXLE COMPONENTS DETAIL**



**CLEANING BRUSH COMPONENTS DETAIL**

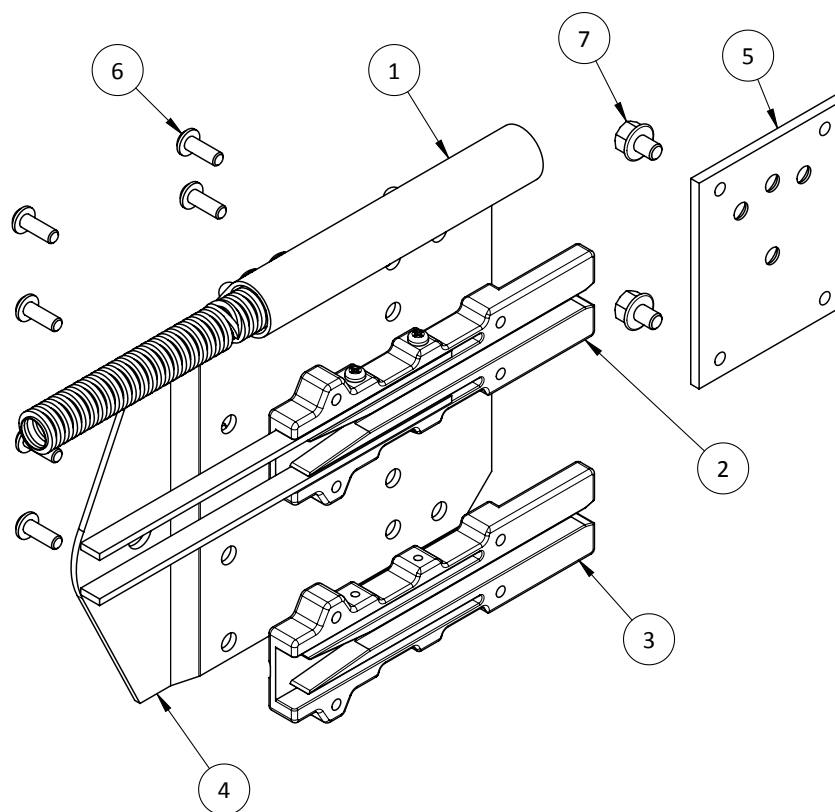
# Section 2

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**FRAME COMPONENTS DETAIL**

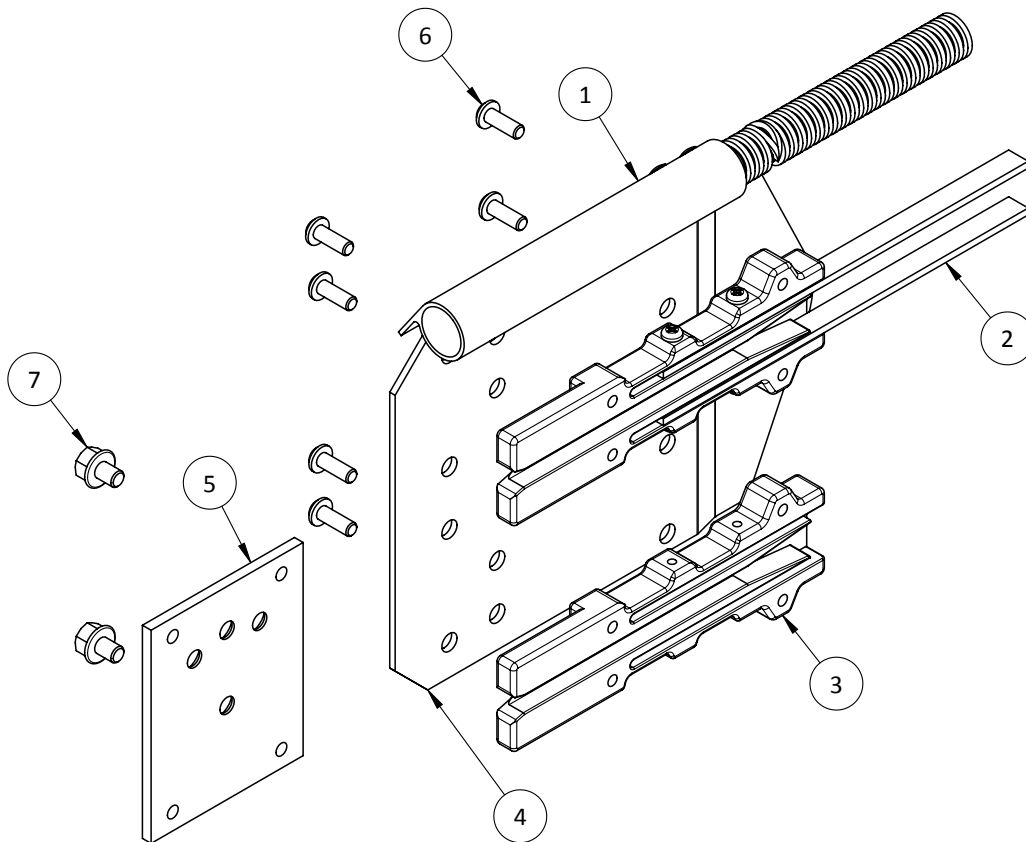
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 09 01		Pivot Flex Capping Complete RH	1
2	185 100 11 00		Sliding Shoe Long Complete	1
3	185 525 05 01		Sliding Shoe Long	1
4	191 525 01 02		Pivot Outer Sidesheet T1000	1
5	191 525 06 00		Thread Plate	1
6		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	8
7		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	2



Pivot Sidesheet Complete Outer RH			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 100 02 06	Pivot Sidesheet Complete Outer RH T1000

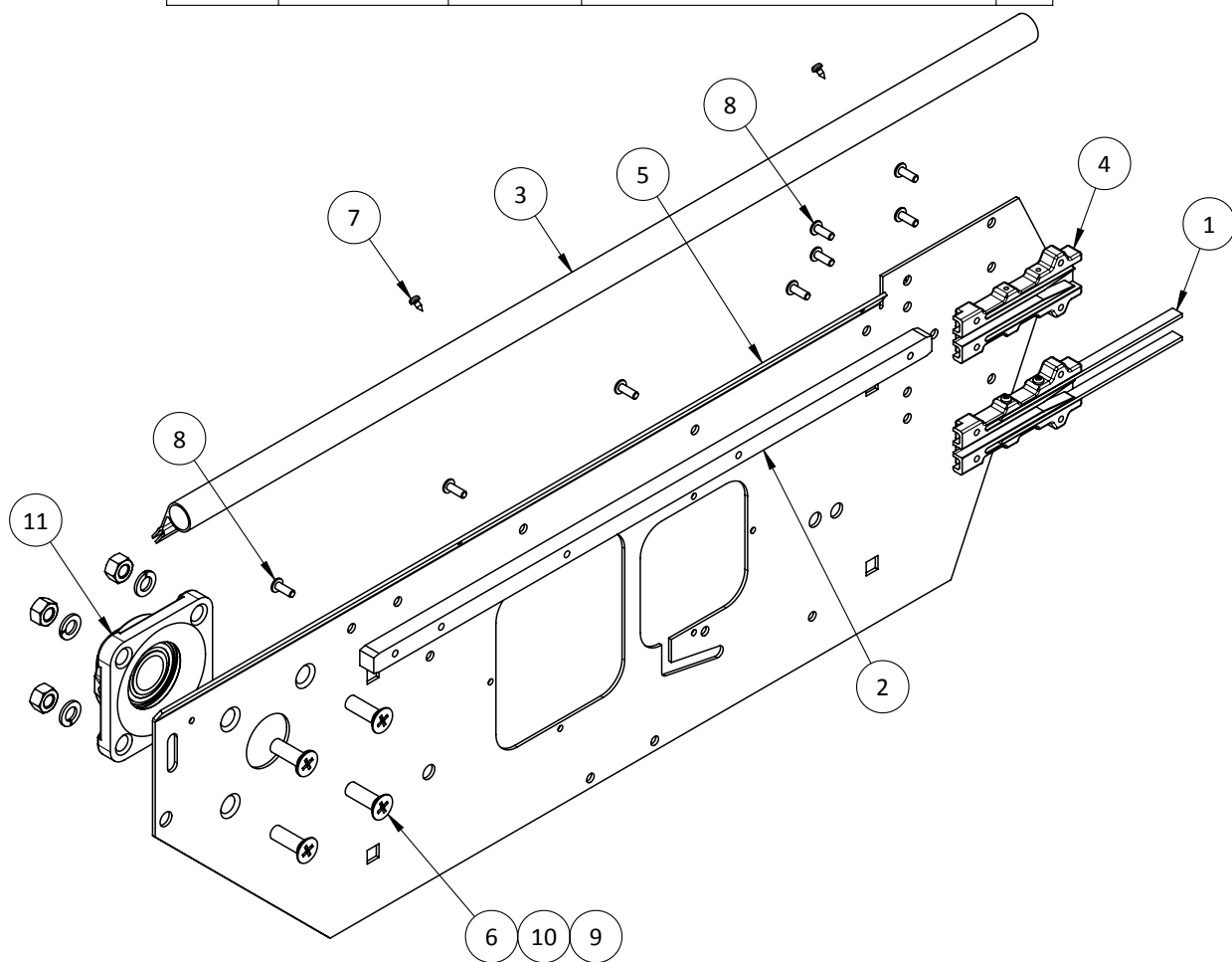
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 09 00		Pivot Flex Capping Complete LH	1
2	185 100 11 00		Sliding Shoe Long Complete	1
3	185 525 05 01		Sliding Shoe Long	1
4	191 525 01 02		Pivot Outer Sidesheet T1000	1
5	191 525 06 00		Thread Plate	1
6		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	8
7		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	2



Pivot Sidesheet Complete Outer LH			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 100 02 07	Pivot Sidesheet Complete Outer LH T1000

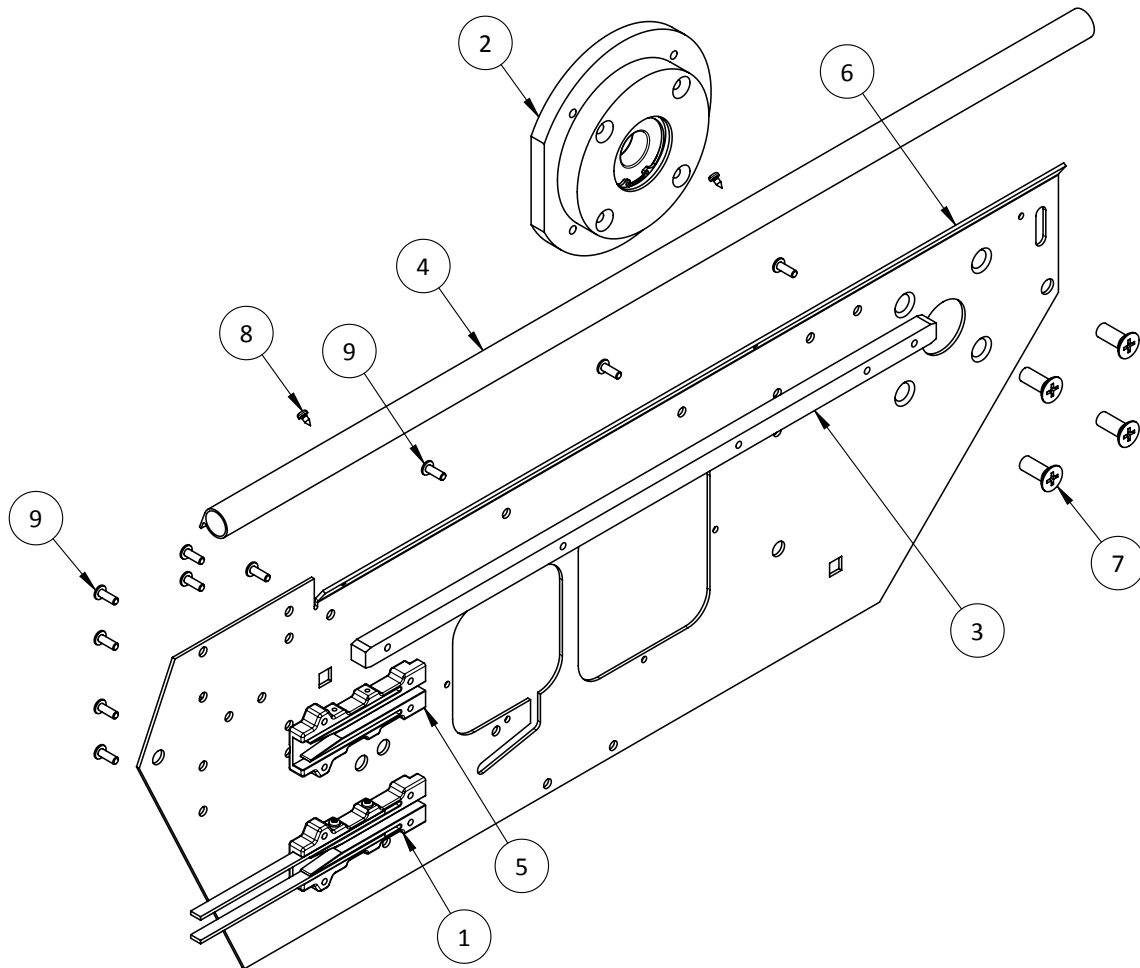
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 13 00		Sliding Shoe Short Complete	1
2	185 511 21 00		Guide Rail Front Drive	1
3	185 520 09 16		Front Drive Capping RH	1
4	185 525 05 02		Sliding Shoe Short	1
5	191 511 04 03		Front Drive Sidesheet RH T1000	1
6		21 63 109	M10 x 30 Countersunk Screw, Zinc	4
7		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	2
8		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	12
9		25 15 107	M10 Hex Nut, Zinc	4
10		26 04 112	M10 Lock Washer, Zinc	4
11		34 10 205	4-Bolt Flange Bearing 25mm	1



Front Drive Sidesheet Complete RH			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 100 03 03	Front Drive Sidesheet Complete RH T1000

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 13 00		Sliding Shoe Short Complete	1
2	185 500 55 01		Flange Complete Main Drive	1
3	185 511 21 00		Guide Rail Front Drive	1
4	185 520 09 15		Front Drive Capping LH	1
5	185 525 05 02		Sliding Shoe Short	1
6	191 511 04 02		Front Drive Sidesheet LH T1000	1
7		21 63 108	M10 x 25 Countersunk Screw, Zinc	4
8		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	2
9		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	12

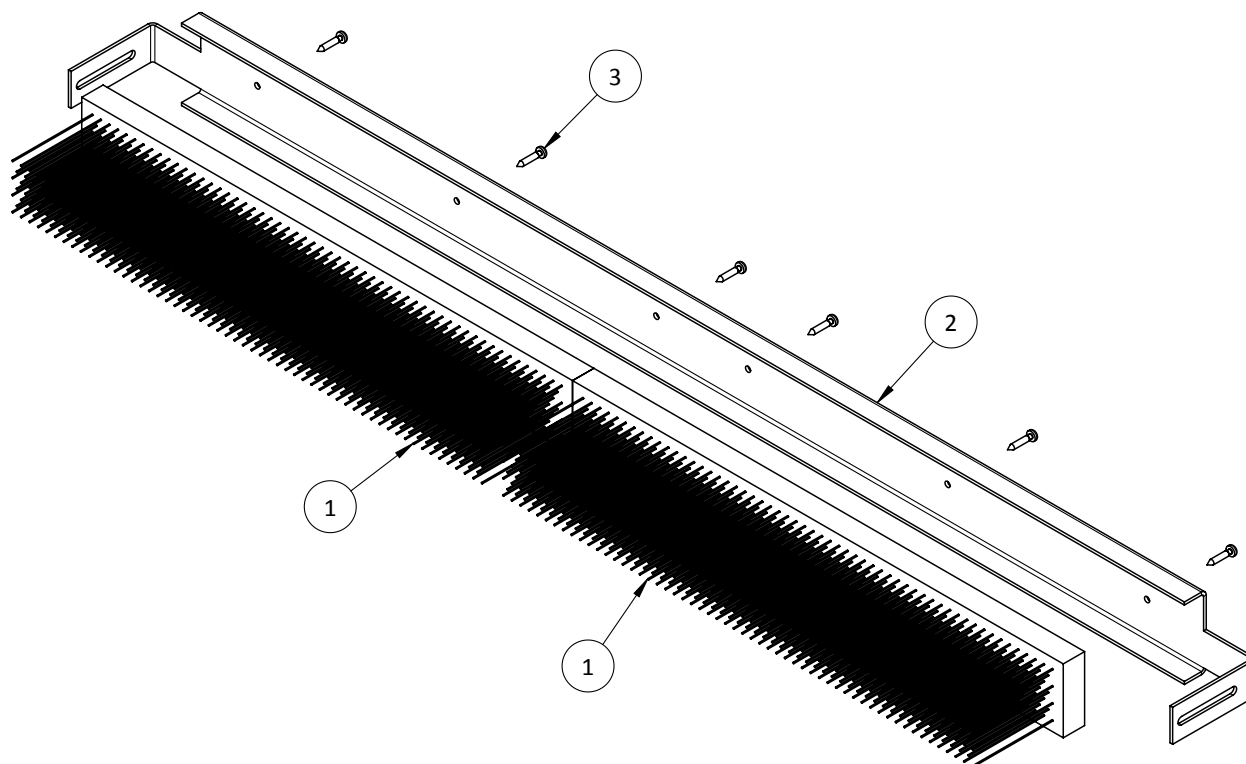


Front Drive Sidesheet Complete LH			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 100 03 06	Front Drive Sidesheet Complete LH T1000



## Section 2

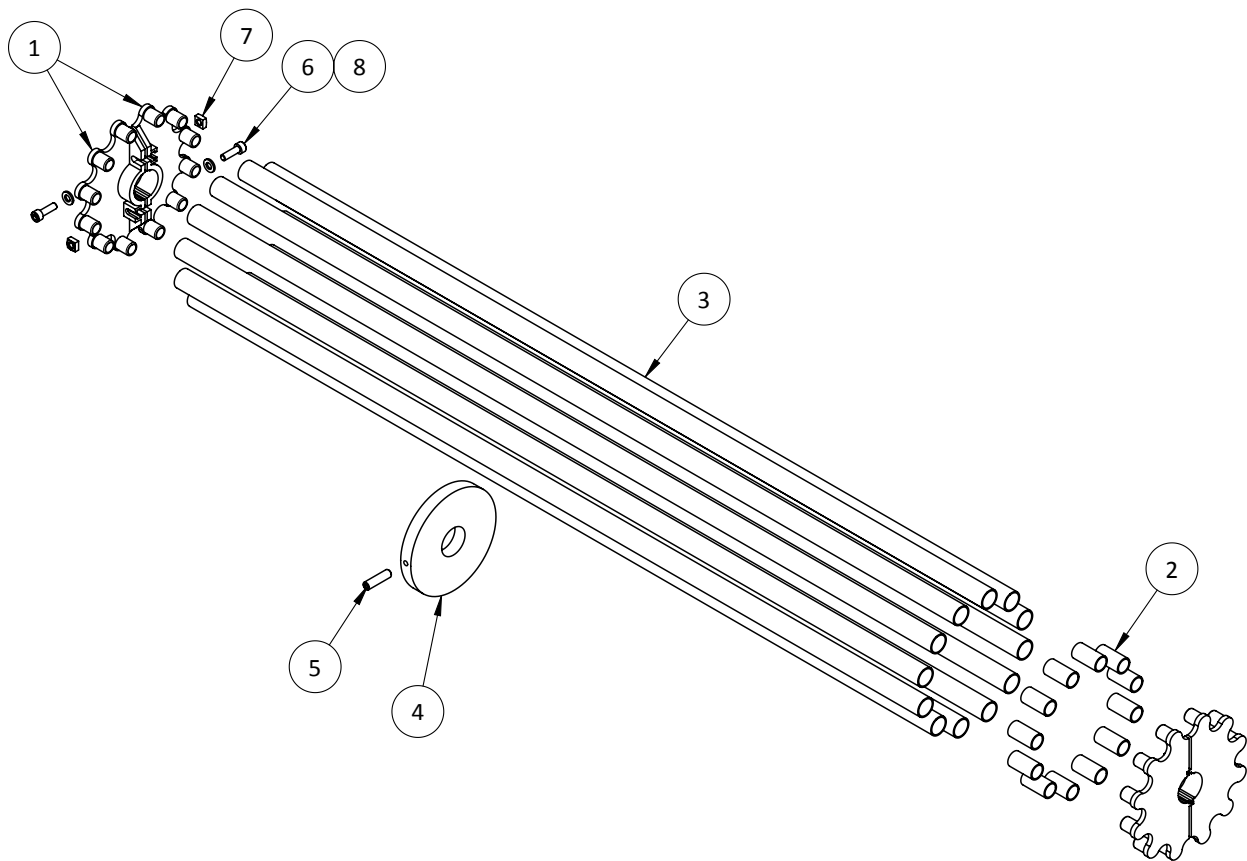
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	185 513 04 00		Cleaning Brush T500	2
2	191 513 01 00		Brush Support Channel T1000	1
3		21 80 020	M4.2 x 22 Self-Tapping Screw, Zinc	6



Cleaning Brush Complete			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 05 00	Cleaning Brush Complete T1000

## Section 2

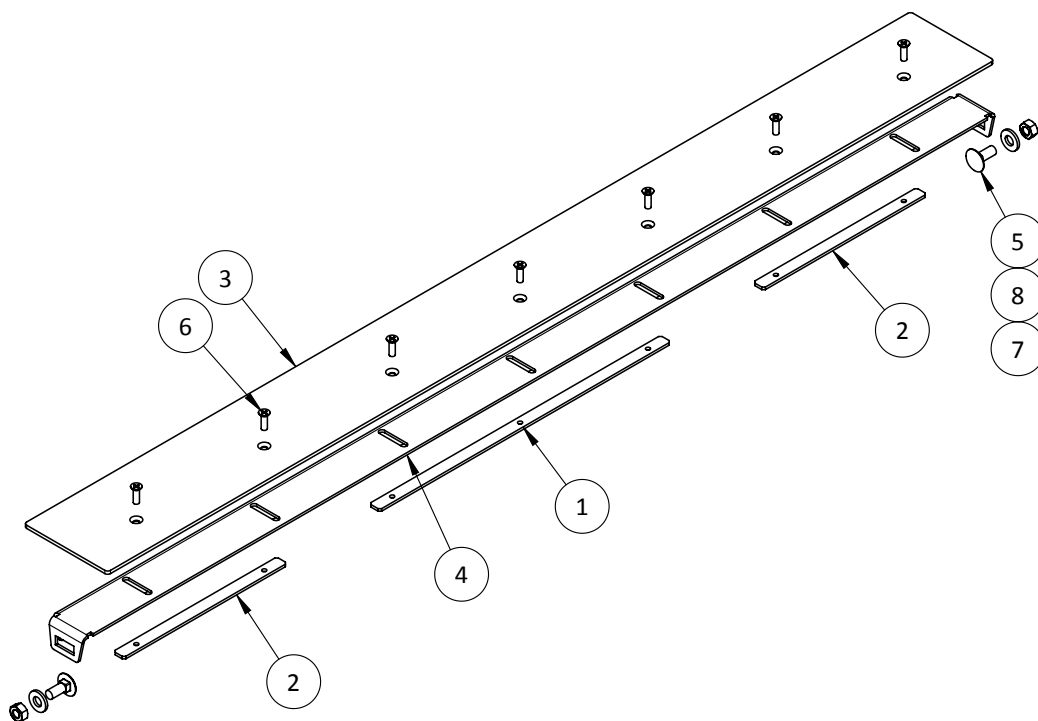
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 518 03 01		Driving Plate	4
2	191 518 04 01		Discharge Tube Plug T1000	24
3	191 518 05 01		Discharge Tube T1000	12
4	191 518 13 00		Center Wheel	1
5		20 46 089	M8 x 30 Grub Screw, Zinc	1
6		21 42 069	M6 x 20 SHCS, Zinc	4
7		25 09 105	M6 Square Nut, Zinc	4
8		26 02 109	M6 Flat Washer, Zinc	4



Discharge Wheel Complete			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 11 02	Discharge Wheel Complete T1000

## Section 2

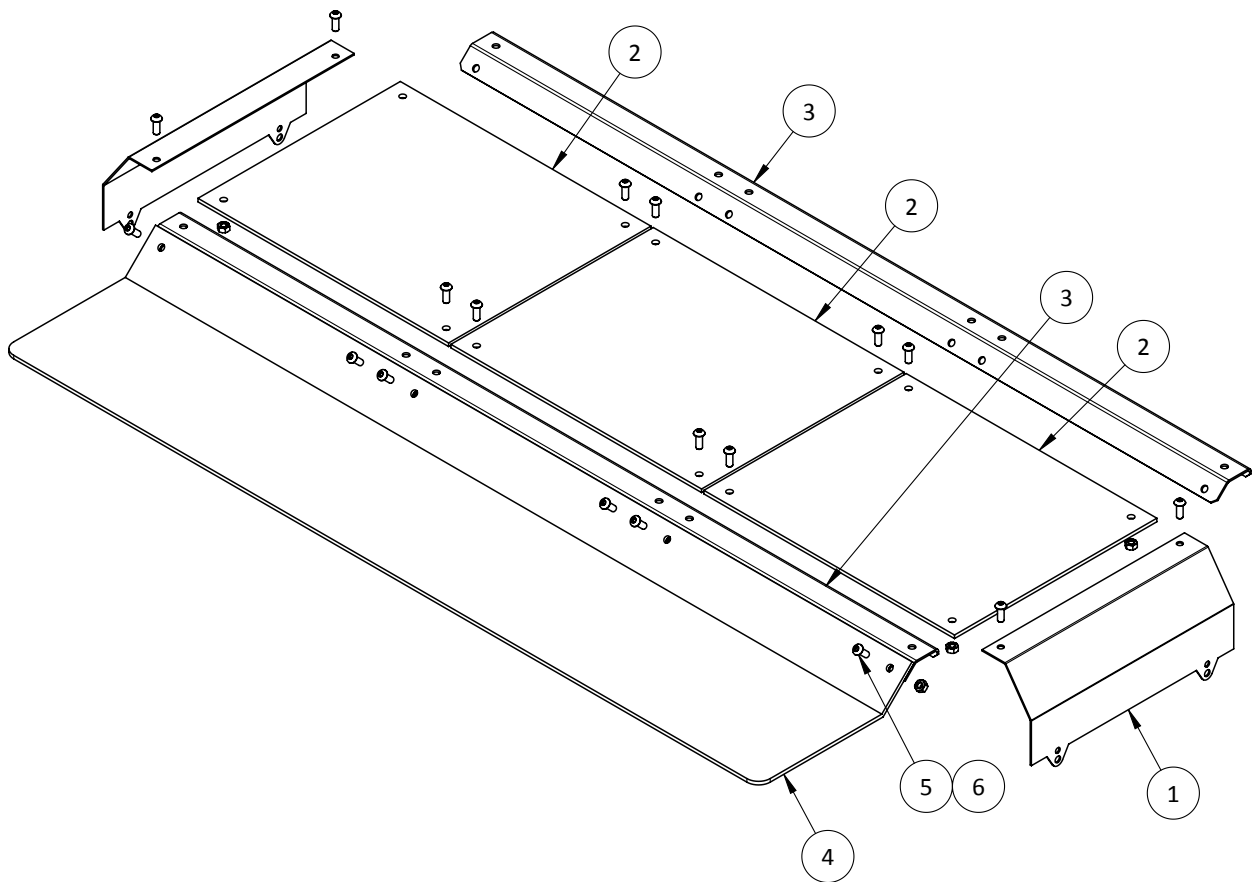
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	187 518 44 00		Thread Plate T350	1
2	189 518 44 00		Thread Plate T200	2
3	191 518 02 00		Transfer Plate T1000 x 95mm	1
4	191 518 43 00		Transfer Angle T1000	1
5		21 28 087	M8 x 20 Carriage Bolt, Zinc	2
6		21 63 049	M5 x 16 Countersunk Screw, Zinc	7
7		25 15 106	M8 Hex Nut, Zinc	2
8		26 02 111	M8 Flat Washer, Zinc	2



Transfer Complete 95mm			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 10 03	Transfer Complete T1000 x 95mm

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	185 510 26 00		Cover Sidesheet	2
2	187 510 10 00		Top Cover T350	3
3	191 510 07 00		Cover U-Profile T1000	2
4	191 510 10 02		Transfer Cover T1000	1
5		21 90 068	M6 x 16 BHCS, Zinc	18
6		25 15 105	M6 Hex Nut, Zinc	18

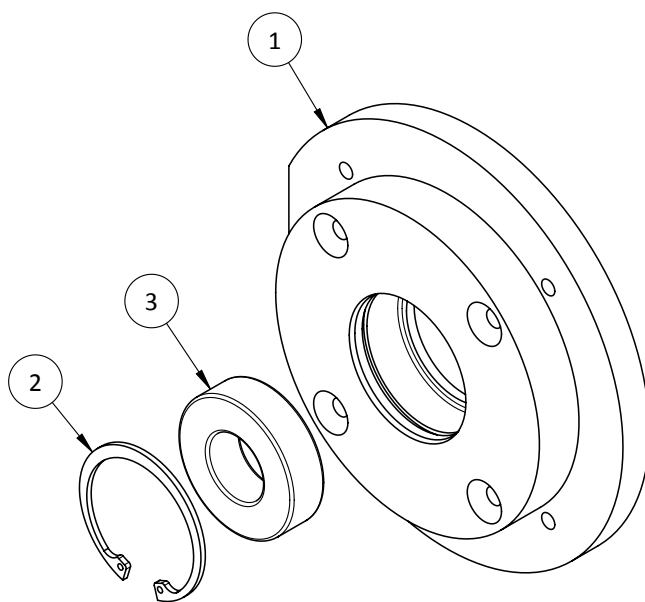


Cover Complete			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 56 10	Cover Complete T1000

## Section 2

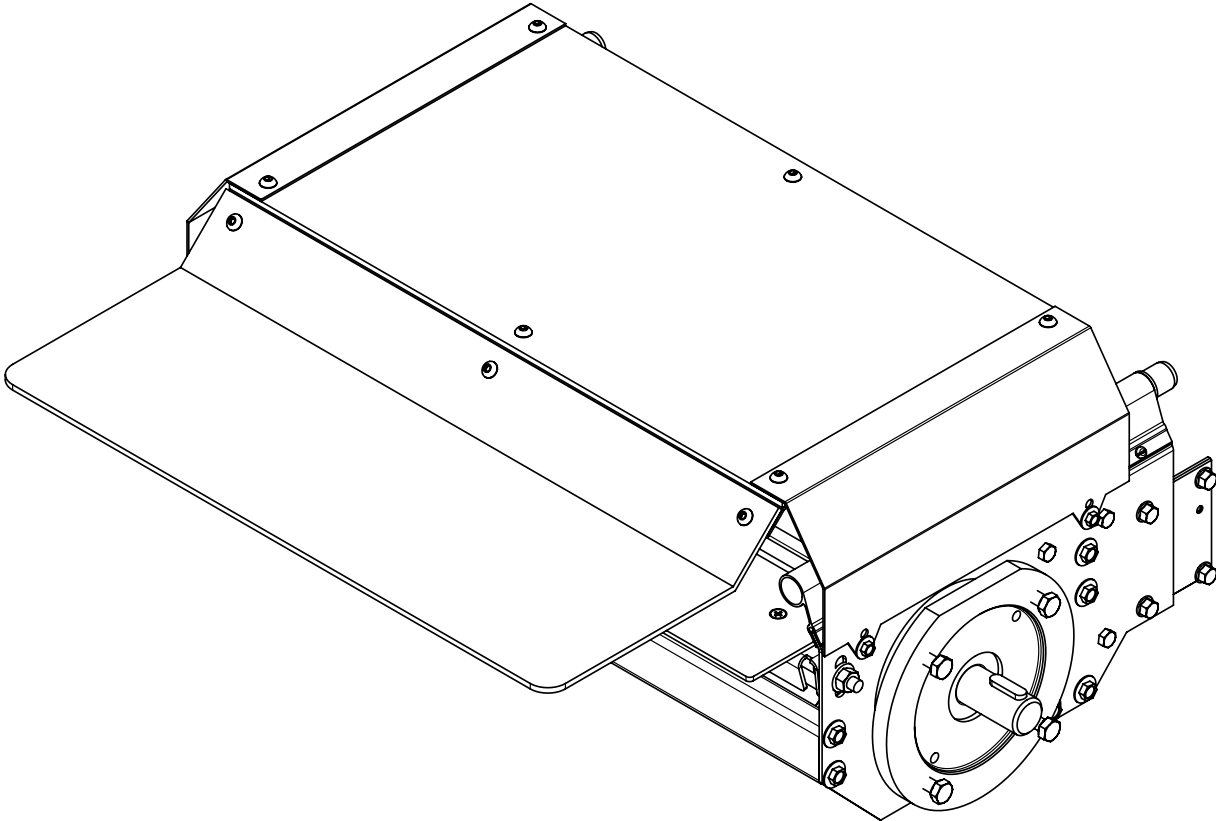
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 511 30 01*		Flange	1
2		26 36 075	Internal Retaining Ring 52x2	1
3		6205.2RSR	Bearing 25mm	1

\*ITEM NOT AVAILABLE INDIVIDUALLY, IF NEEDED ORDER COMPLETE ASSEMBLY  
(SEE CHART BELOW)

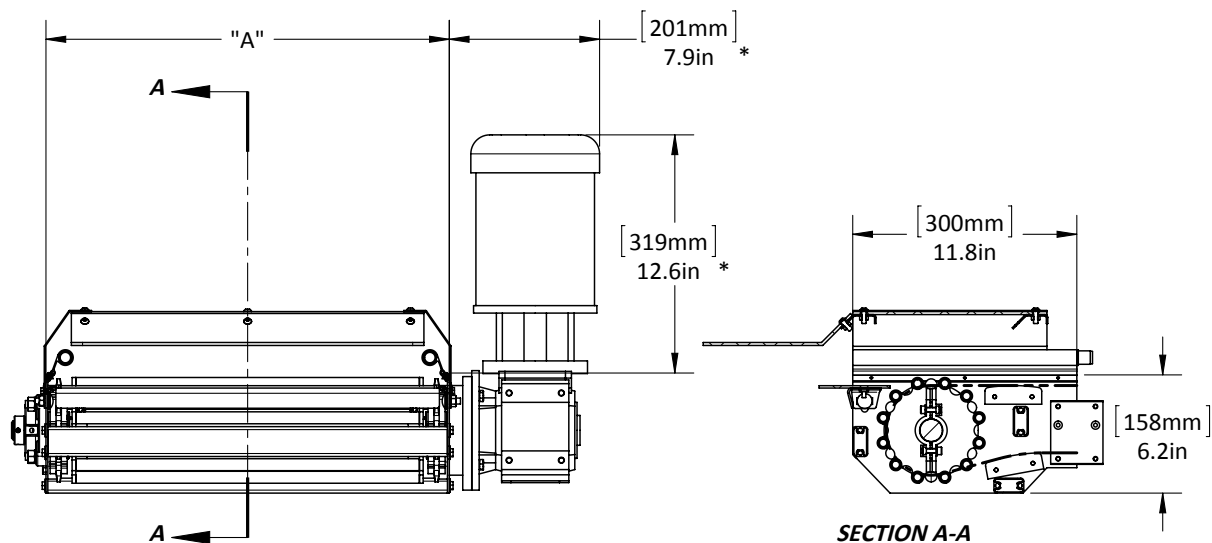


Flange Complete Main Drive			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	185 500 55 01	Flange Complete Main Drive

Mini Drive T250 - T750



Mini Drive			
Conveyor Type	Part Number	Drawing Number	Description
250	4901	--	Mini Drive T250
350	4841	--	Mini Drive T350
500	4802	--	Mini Drive T500
750	4871	--	Mini Drive T750



Mini Drive							
Part Number	Conveyor Type	Description	A (mm/inches)	H1** min/max (mm/inches)	H2*** min/max (mm/inches)	H3**** min/max (mm/inches)	Chain Length (m/ft)
4901	250	Mini Drive T250	290/11.4	190 - 320 7.5 - 12.6	310 - 610 12.2 - 24.0	600 - 1300 23.6 - 51.2	.6/2.0
4841	350	Mini Drive T350	390/15.4				
4802	500	Mini Drive T500	540/21.3				
4871	750	Mini Drive T750	790/31.1				

\*S87.3 Stober Gearbox and G581 Marathon Motor shown, sold separately

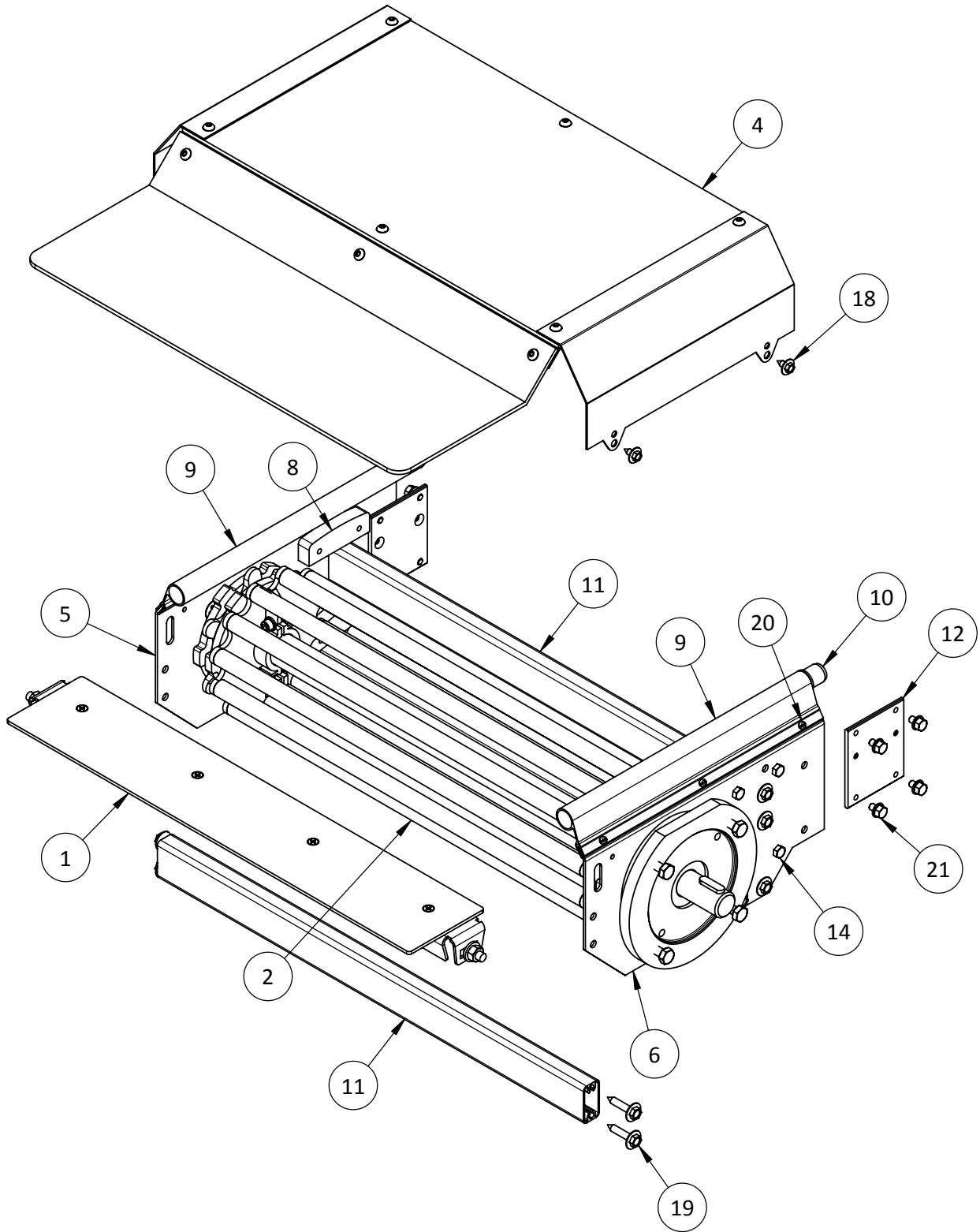
\*\*Height of unit with Floor Support Short

\*\*\*Height of unit with Floor Support Middle

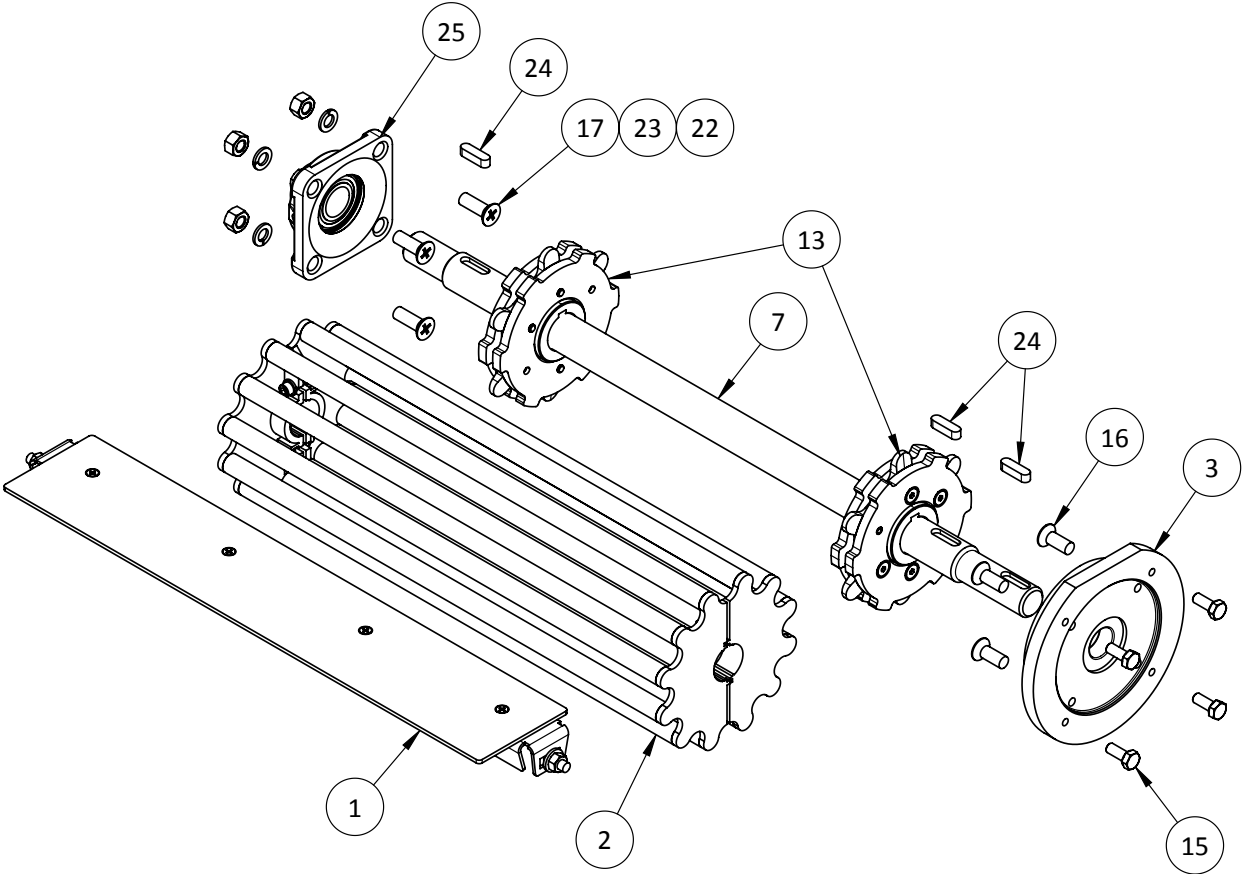
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	186 500 10 03		Transfer Complete T250 x 95mm	1	-	-	-
1	187 500 10 03		Transfer Complete T350 x 95mm	-	1	-	-
1	185 500 10 03		Transfer Complete T500 x 95mm	-	-	1	-
1	188 500 10 03		Transfer Complete T750 x 95mm	-	-	-	1
2	186 500 11 02		Discharge Wheel Complete T250	1	-	-	-
2	187 500 11 02		Discharge Wheel Complete T350	-	1	-	-
2	185 500 11 02		Discharge Wheel Complete T500	-	-	1	-
2	188 500 11 02		Discharge Wheel Complete T750	-	-	-	1
3	185 500 55 01		Flange Complete Main Drive	1	1	1	1
4	186 500 56 10		Cover Complete T250	1	-	-	-
4	187 500 56 10		Cover Complete T350	-	1	-	-
4	185 500 56 10		Cover Complete T500	-	-	1	-
4	188 500 56 10		Cover Complete T750	-	-	-	1
5	185 511 01 00		Mini Drive Sidesheet LH	1	1	1	1
6	185 511 01 01		Mini Drive Sidesheet RH	1	1	1	1
7	186 516 01 01		Drive Shaft T250	1	-	-	-
7	187 516 01 01		Drive Shaft T350	-	1	-	-
7	185 516 01 01		Drive Shaft T500	-	-	1	-
7	188 516 01 01		Drive Shaft T750	-	-	-	1
8	185 520 07 00		Curved Sliding Shoe	4	4	4	4
9	185 520 09 04		Mini Drive Capping	2	2	2	2
10	185 520 18 00		Intermediate Coupling	2	2	2	2
11	186 524 05 00		Traverse T250	3	-	-	-
11	187 524 05 00		Traverse T350	-	3	-	-
11	185 524 05 00		Traverse T500	-	-	3	-
11	188 524 05 00		Traverse T750	-	-	-	3
12	185 525 06 00		Thread Plate	2	2	2	2
13	705 001 02 00		Main Drive Sprocket	2	2	2	2
14		21 56 067	M6 x 12 Hex Bolt, Zinc	8	8	8	8
15		21 56 087	M8 x 20 Hex Bolt, Zinc	4	4	4	4
16		21 63 108	M10 x 25 Countersunk Screw, Zinc	4	4	4	4
17		21 63 109	M10 x 30 Countersunk Screw, Zinc	4	4	4	4
18		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	4	4	4	4
19		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	12	12	12	12
20		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	6	6	6	6
21		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8	8
22		25 15 107	M10 Hex Nut, Zinc	4	4	4	4
23		26 04 112	M10 Lock Washer, Zinc	4	4	4	4
24		27 43 070	8 x 7 x 28 Parallel Key	3	3	3	3
25		34 10 205	4-Bolt Flange Bearing 25mm	1	1	1	1



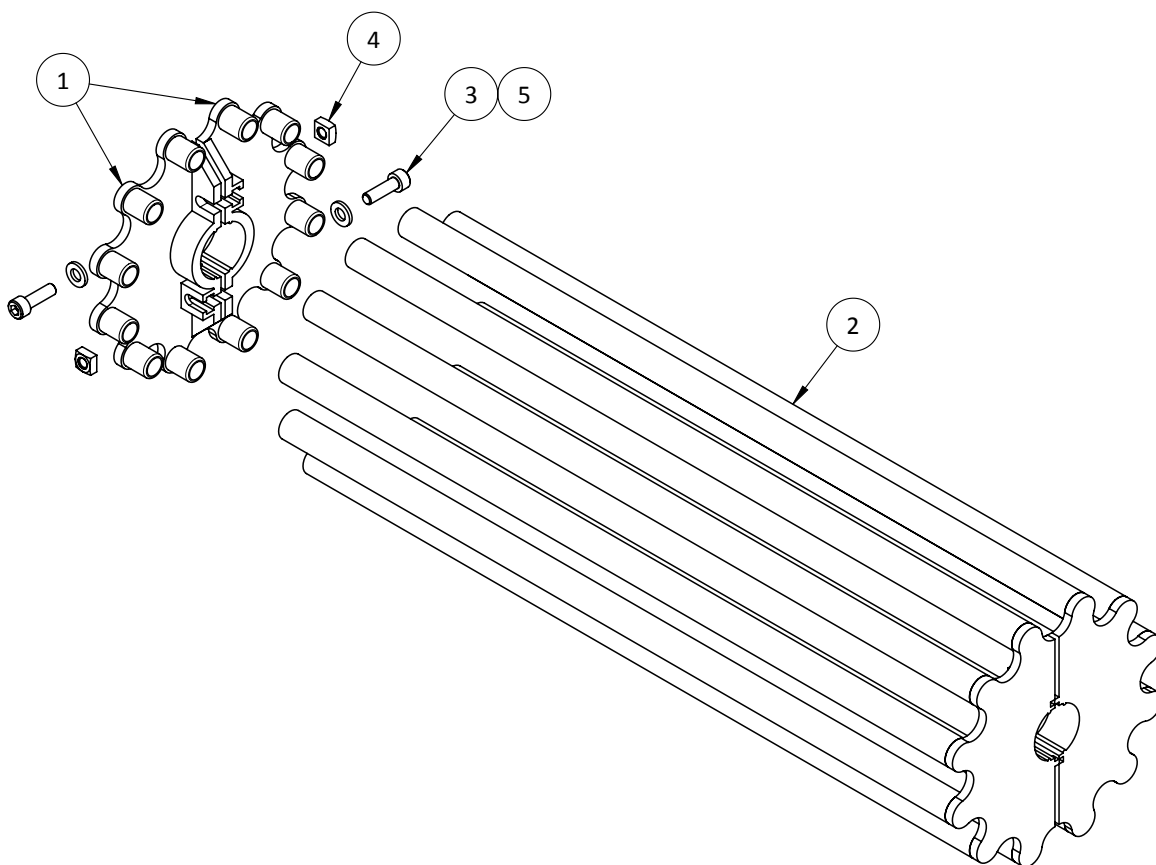


# Section 2



**DRIVE SHAFT COMPONENTS DETAIL**

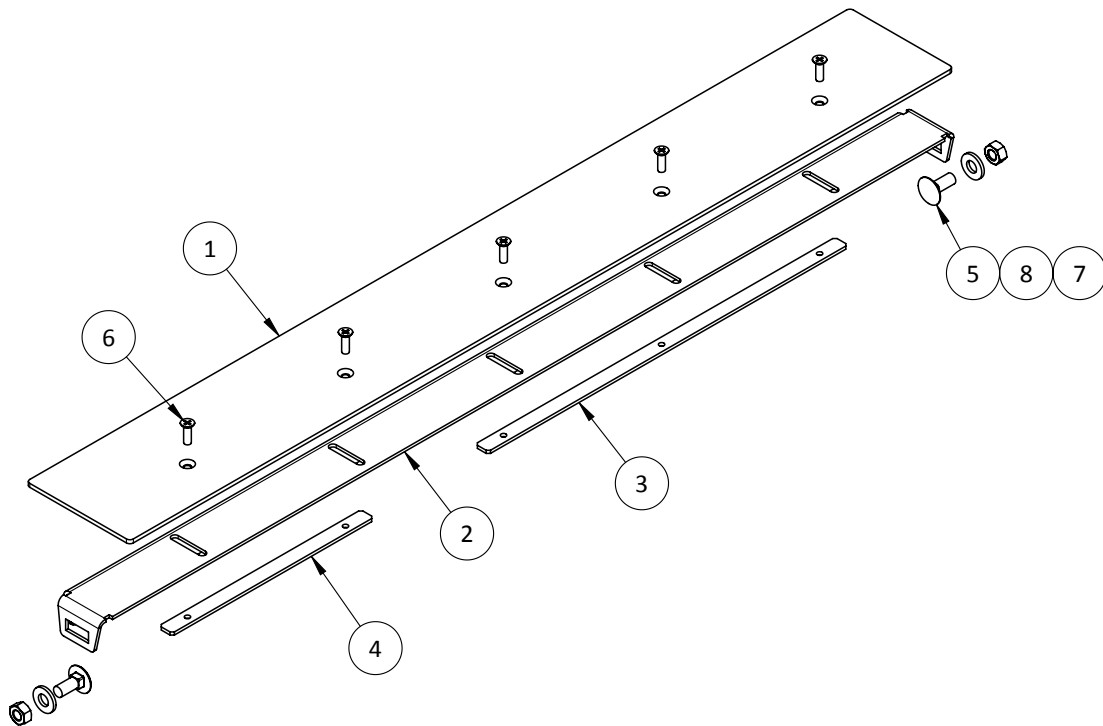
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 518 03 01		Driving Plate	4	4	4	4
2	186 518 05 01		Discharge Tube T250	12	-	-	-
2	187 518 05 01		Discharge Tube T350	-	12	-	-
2	185 518 05 01		Discharge Tube T500	-	-	12	-
2	188 518 05 01		Discharge Tube T750	-	-	-	12
3		21 42 069	M6 x 20 SHCS, Zinc	4	4	4	4
4		25 09 105	M6 Square Nut, Zinc	4	4	4	4
5		26 02 109	M6 Flat Washer, Zinc	4	4	4	4



Discharge Wheel Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 11 02	Discharge Wheel Complete T250
350	--	187 500 11 02	Discharge Wheel Complete T350
500	--	185 500 11 02	Discharge Wheel Complete T500
750	--	188 500 11 02	Discharge Wheel Complete T750

## Section 2

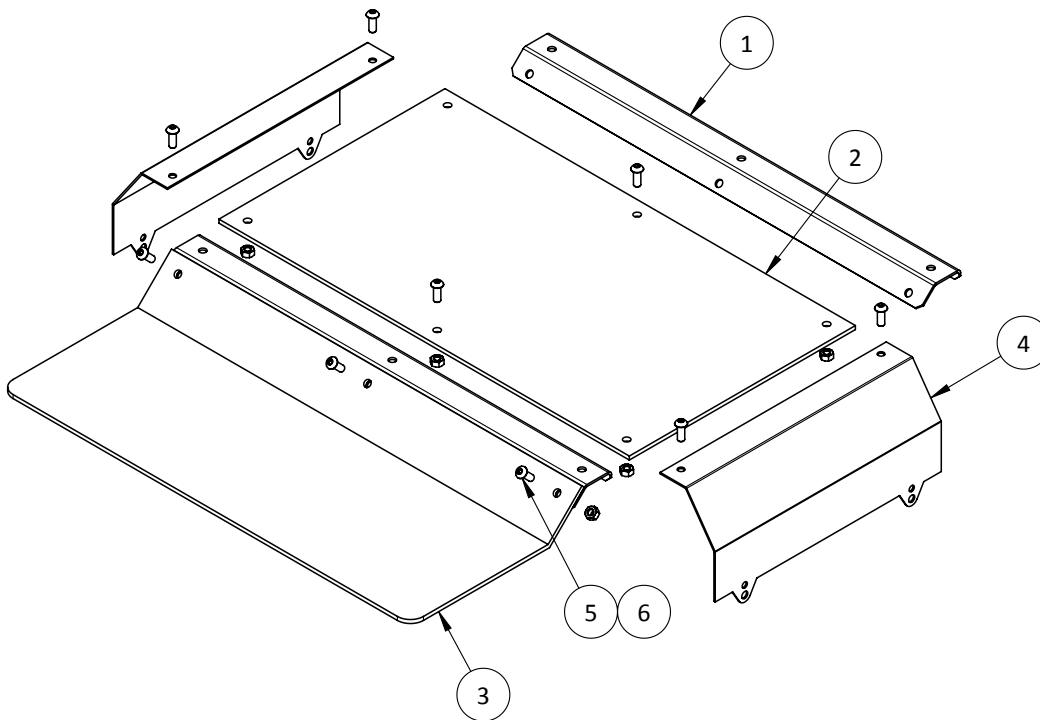
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	186 518 02 00		Transfer Plate T250 x 95mm	1	-	-	-
1	187 518 02 00		Transfer Plate T350 x 95mm	-	1	-	-
1	185 518 02 00		Transfer Plate T500 x 95mm	-	-	1	-
1	188 518 02 00		Transfer Plate T750 x 95mm	-	-	-	1
2	186 518 43 00		Transfer Angle T250	1	-	-	-
2	187 518 43 00		Transfer Angle T350	-	1	-	-
2	185 518 43 00		Transfer Angle T500	-	-	1	-
2	188 518 43 00		Transfer Angle T750	-	-	-	1
3	187 518 44 00		Thread Plate T350	-	1	-	1
4	189 518 44 00		Thread Plate T200	1	-	2	1
5		21 28 087	M8 x 20 Carriage Bolt, Zinc	2	2	2	2
6		21 63 049	M5 x 16 Countersunk Screw, Zinc	2	3	4	5
7		25 15 106	M8 Hex Nut, Zinc	2	2	2	2
8		26 02 111	M8 Flat Washer, Zinc	2	2	2	2



Transfer Complete 95mm			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 10 03	Transfer Complete T250 x 95mm
350	--	187 500 10 03	Transfer Complete T350 x 95mm
500	--	185 500 10 03	Transfer Complete T500 x 95mm
750	--	188 500 10 03	Transfer Complete T750 x 95mm

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T750	T500
1	186 510 07 00		Cover U-Profile T250	2	-	-	-
1	187 510 07 00		Cover U-Profile T350	-	2	-	-
1	188 510 07 00		Cover U-Profile T750	-	-	2	-
1	185 510 07 00		Cover U-Profile T500	-	-	-	2
2	186 510 10 00		Top Cover T250	1	-	-	-
2	187 510 10 00		Top Cover T350	-	1	-	-
2	188 510 10 00		Top Cover T750	-	-	1	-
2	185 510 10 00		Top Cover T500	-	-	-	1
3	186 510 10 02		Transfer Cover T250	1	-	-	-
3	187 510 10 02		Transfer Cover T350	-	1	-	-
3	188 510 10 02		Transfer Cover T750	-	-	1	-
3	185 510 10 02		Transfer Cover T500	-	-	-	1
4	185 510 26 00		Cover Sidesheet	2	2	2	2
5		21 90 068	M6 x 16 BHCS, Zinc	9	6	9	9
6		25 15 105	M6 Hex Nut, Zinc	9	9	9	9

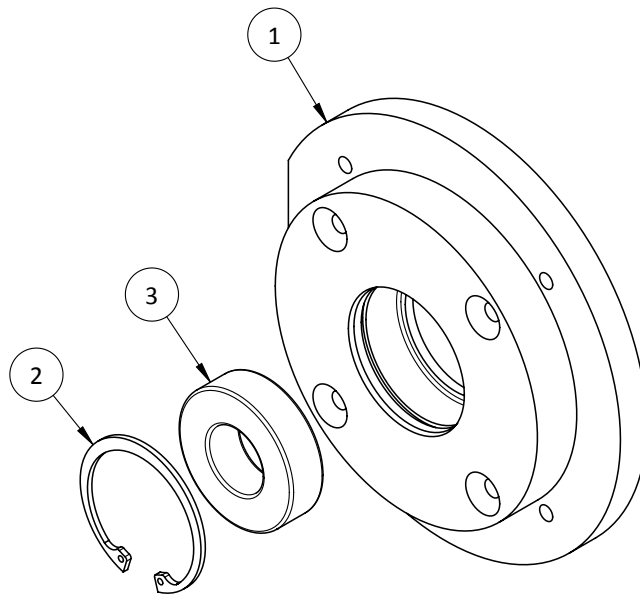


Cover Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 56 10	Cover Complete T250
350	--	187 500 56 10	Cover Complete T350
500	--	185 500 56 10	Cover Complete T500
750	--	188 500 56 10	Cover Complete T750

## Section 2

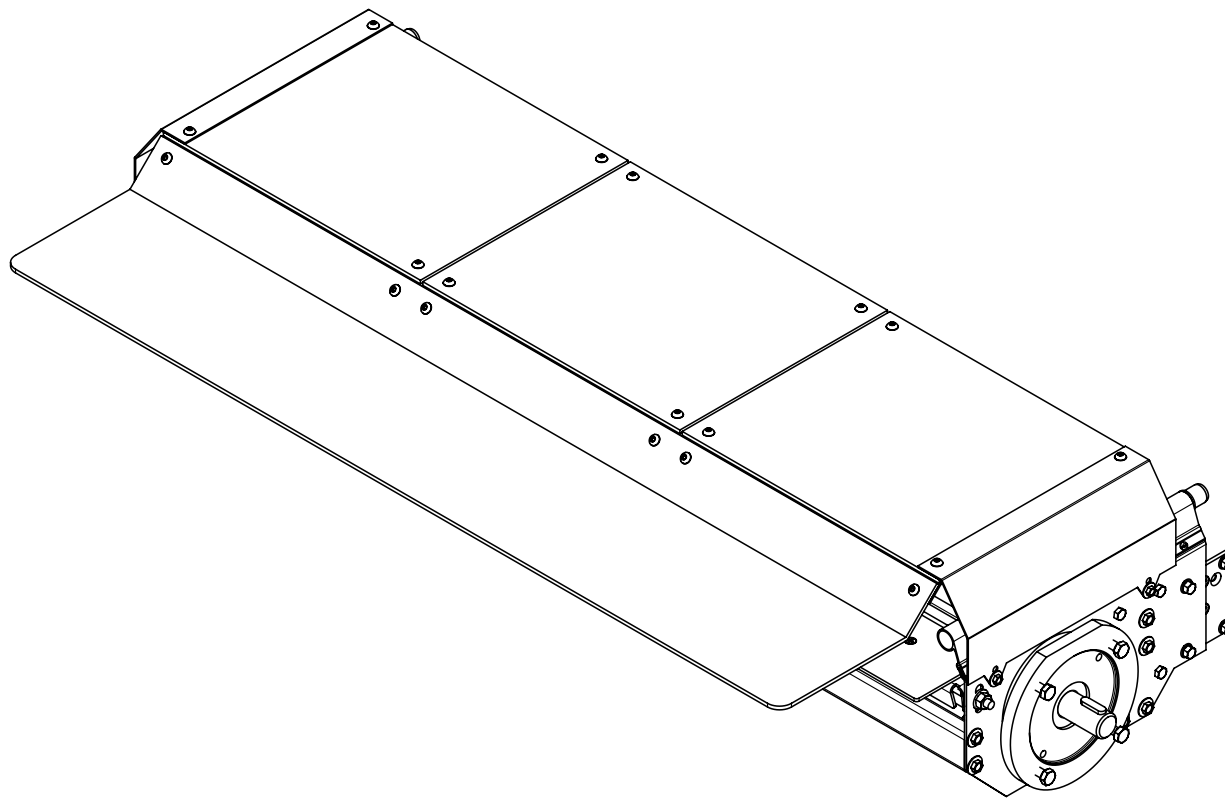
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 511 30 01*		Flange	1
2		26 36 075	Internal Retaining Ring 52x2	1
3		6205.2RSR	Bearing 25mm	1

\*ITEM NOT AVAILABLE INDIVIDUALLY, IF NEEDED ORDER COMPLETE ASSEMBLY (SEE CHART BELOW)



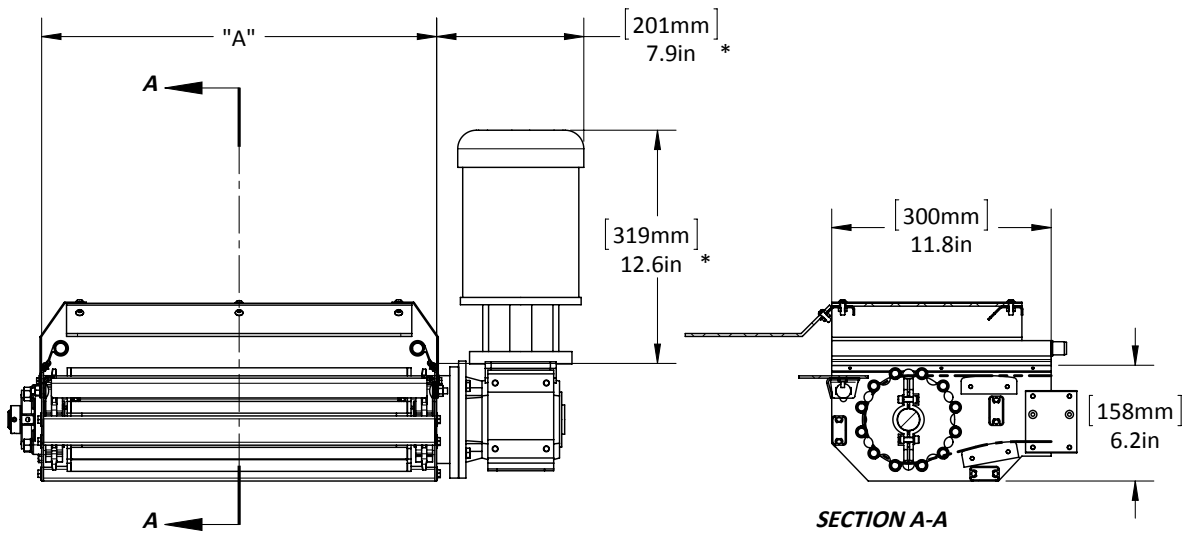
Flange Complete Main Drive			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 500 55 01	Flange Complete Main Drive
350	--		
500	--		
750	--		

---

**Mini Drive T1000**

Mini Drive			
Conveyor Type	Part Number	Drawing Number	Description
1000	5402	--	Mini Drive T1000

## Section 2



Mini Drive							
Part Number	Conveyor Type	Description	A (mm/inches)	H1** min/max (mm/inches)	H2*** min/max (mm/inches)	H3**** min/max (mm/inches)	Chain Length (m/ft)
5402	1000	Mini Drive T1000	1040/41.0	190 - 320 7.5 - 12.6	310 - 610 12.2 - 24.0	600 - 1300 23.6 - 51.2	.6/2.0

\*S87.3 Stober Gearbox and G581 Marathon Motor shown, sold separately

\*\*Height of unit with Floor Support Short

\*\*\*Height of unit with Floor Support Middle

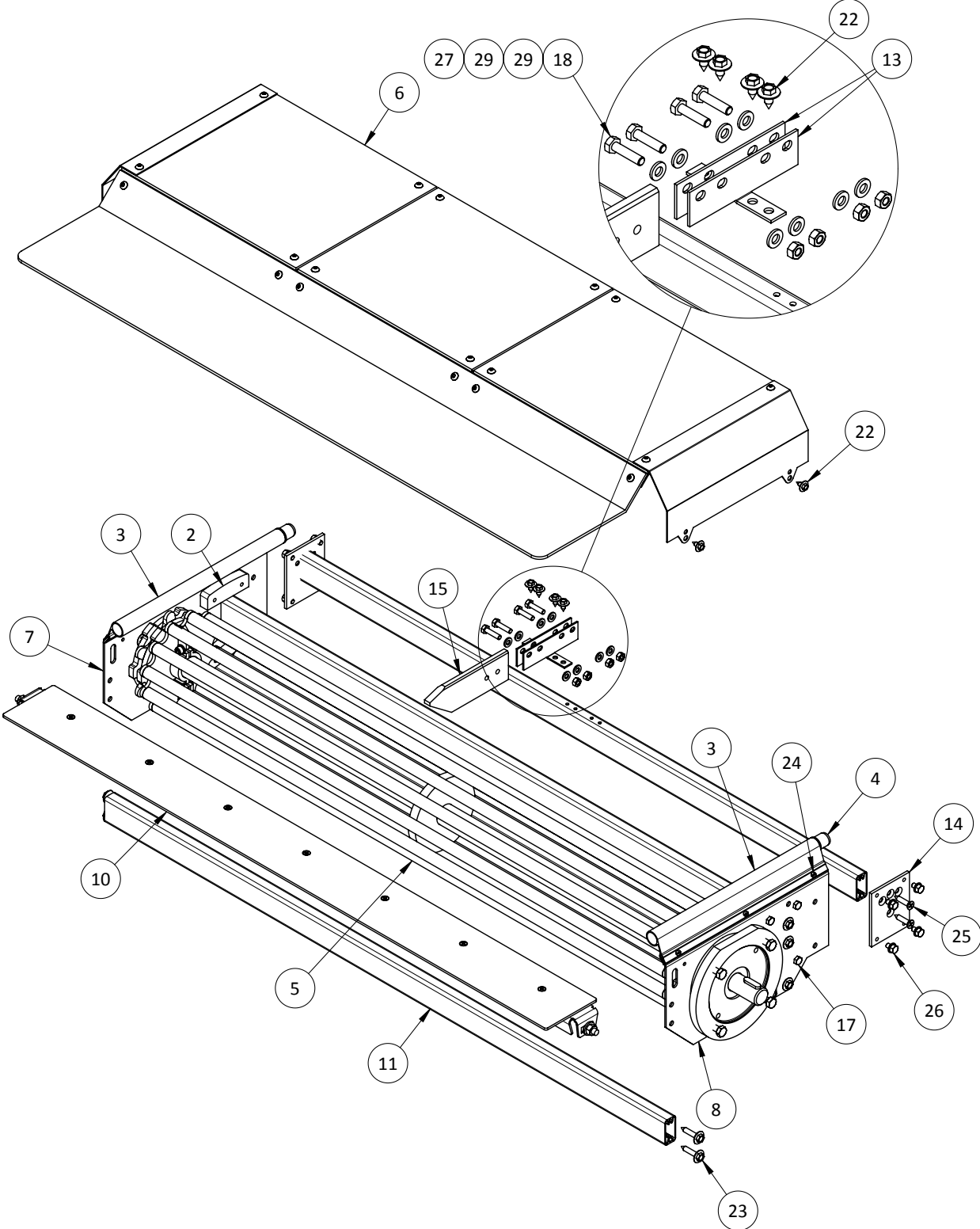
\*\*\*\*Height of unit with Floor Support Long

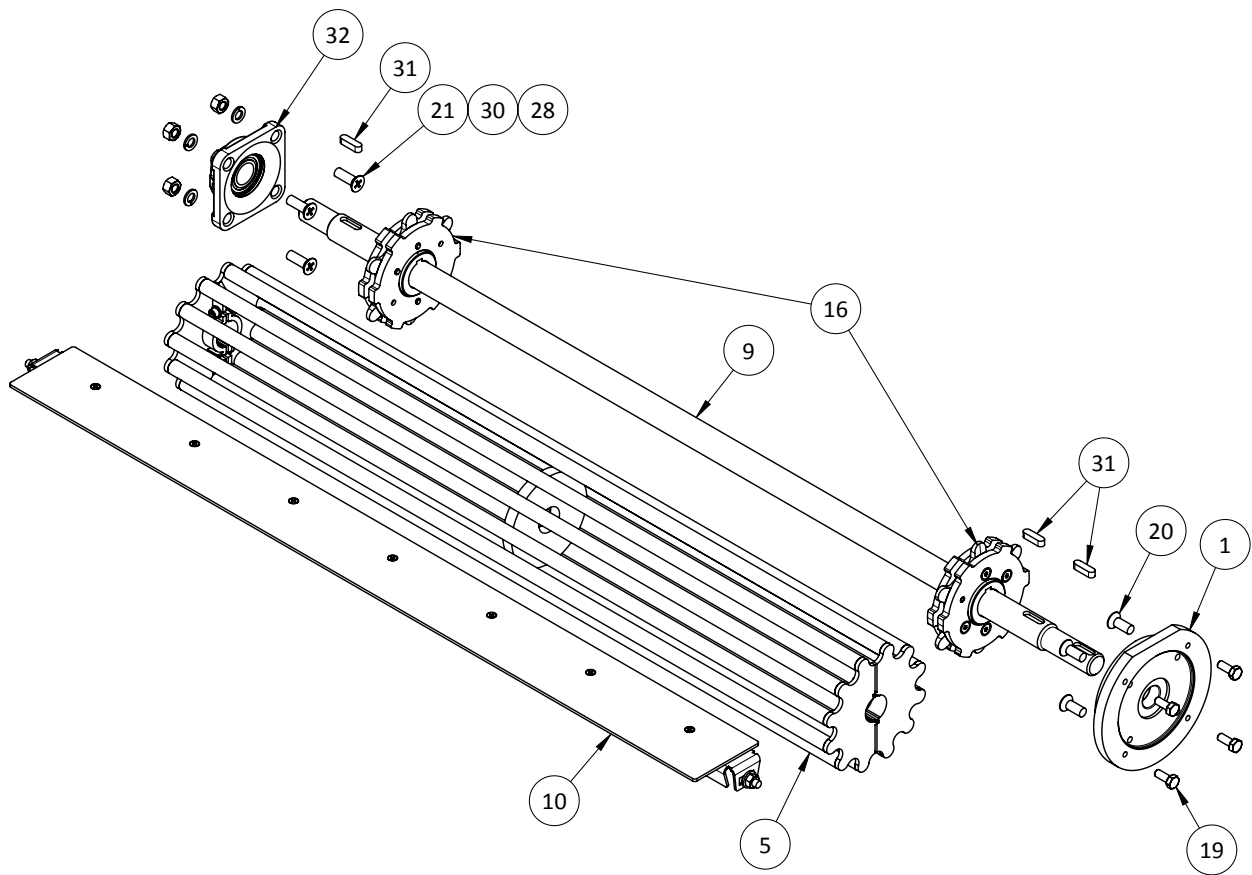


## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	185 500 55 01		Flange Complete Main Drive	1
2	185 520 07 00		Curved Sliding Shoe	4
3	185 520 09 04		Mini Drive Capping	2
4	185 520 18 00		Intermediate Coupling	2
5	191 500 11 02		Discharge Wheel Complete T1000	1
6	191 500 56 10		Cover Complete T1000	1
7	191 511 01 00		Mini Drive Sidesheet LH T1000	1
8	191 511 01 01		Mini Drive Sidesheet RH T1000	1
9	191 516 01 01		Drive Shaft T1000	1
10	191 500 10 03		Transfer Complete T1000 x 95mm	1
11	191 524 05 00		Traverse T1000 (No Holes)	3
12	191 524 05 08		Traverse Narrow T1000 (Thin Side Holes)	1
13	191 524 07 00		Connecting Angle	2
14	191 525 06 00		Thread Plate	2
15	191 525 19 00		Sliding Profile	1
16	705 001 02 00		Main Drive Sprocket	2
17		21 56 067	M6 x 12 Hex Bolt, Zinc	8
18		21 56 070	M6 x 25 Hex Bolt, Zinc	4
19		21 56 087	M8 x 20 Hex Bolt, Zinc	4
20		21 63 108	M10 x 25 Countersunk Screw, Zinc	4
21		21 63 109	M10 x 30 Countersunk Screw, Zinc	4
22		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	8
23		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	12
24		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	6
25		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	4
26		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8
27		25 15 105	M6 Hex Nut, Zinc	4
28		25 15 107	M10 Hex Nut, Zinc	4
29		26 02 109	M6 Flat Washer, Zinc	8
30		26 04 112	M10 Lock Washer, Zinc	4
31		27 43 070	8 x 7 x 28 Parallel Key	3
32		34 10 205	4-Bolt Flange Bearing 25mm	1

# Section 2

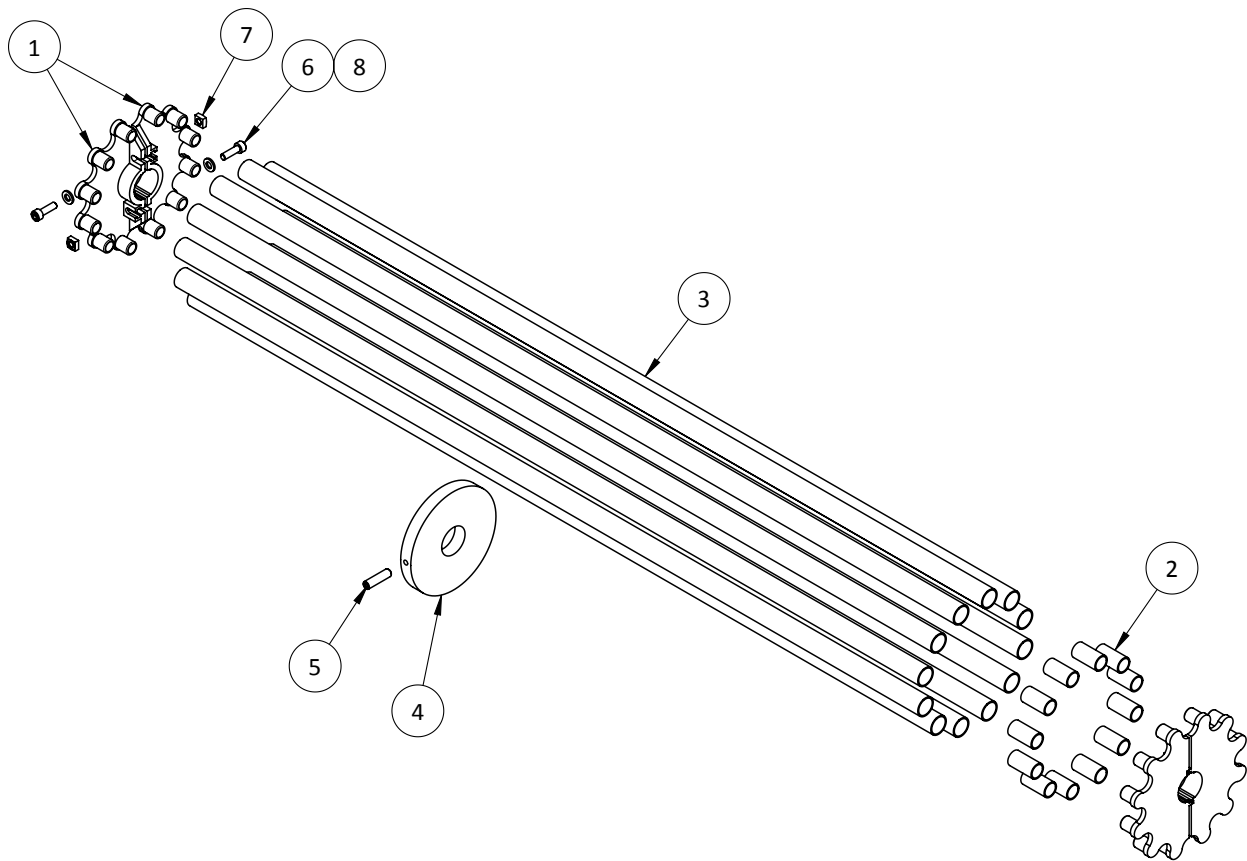




**DRIVE SHAFT COMPONENTS DETAIL**

## Section 2

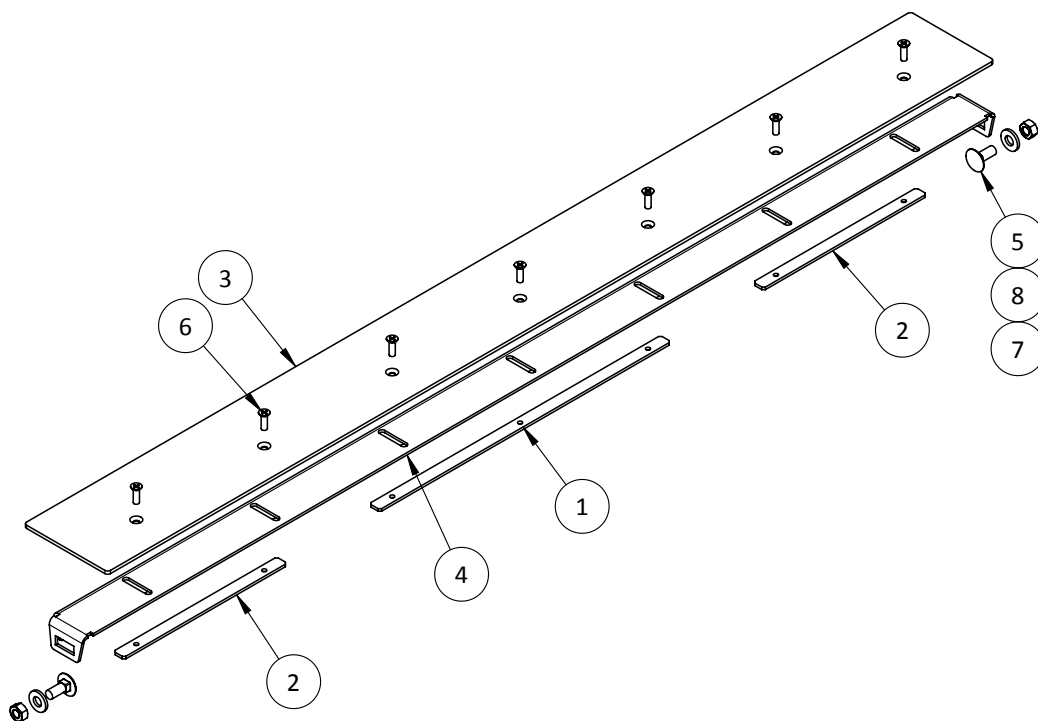
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 518 03 01		Driving Plate	4
2	191 518 04 01		Discharge Tube Plug T1000	24
3	191 518 05 01		Discharge Tube T1000	12
4	191 518 13 00		Center Wheel	1
5		20 46 089	M8 x 30 Grub Screw, Zinc	1
6		21 42 069	M6 x 20 SHCS, Zinc	4
7		25 09 105	M6 Square Nut, Zinc	4
8		26 02 109	M6 Flat Washer, Zinc	4



Discharge Wheel Complete			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 11 02	Discharge Wheel Complete T1000

## Section 2

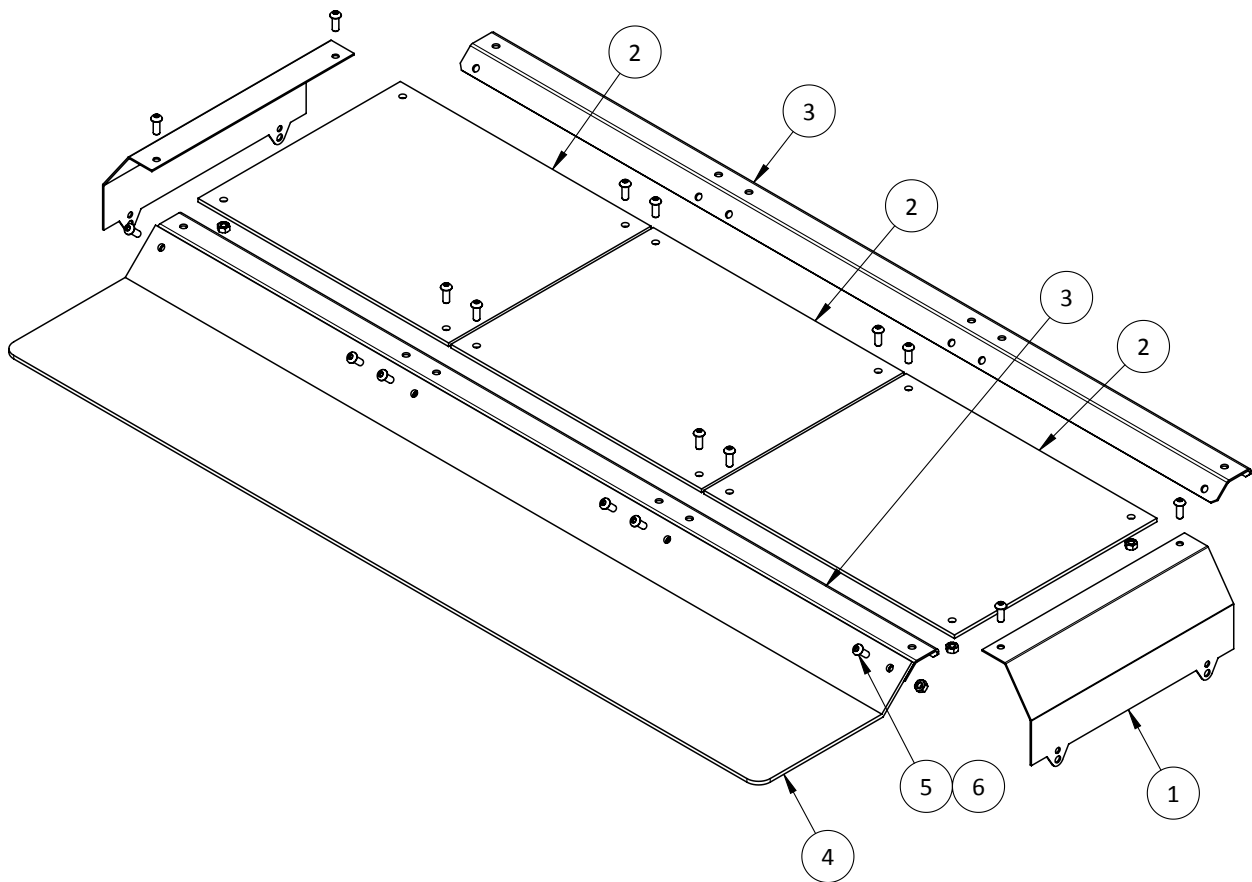
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	187 518 44 00		Thread Plate T350	1
2	189 518 44 00		Thread Plate T200	2
3	191 518 02 00		Transfer Plate T1000 x 95mm	1
4	191 518 43 00		Transfer Angle T1000	1
5		21 28 087	M8 x 20 Carriage Bolt, Zinc	2
6		21 63 049	M5 x 16 Countersunk Screw, Zinc	7
7		25 15 106	M8 Hex Nut, Zinc	2
8		26 02 111	M8 Flat Washer, Zinc	2



Transfer Complete 95mm			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 10 03	Transfer Complete T1000 x 95mm

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	185 510 26 00		Cover Sidesheet	2
2	187 510 10 00		Top Cover T350	3
3	191 510 07 00		Cover U-Profile T1000	2
4	191 510 10 02		Transfer Cover T1000	1
5		21 90 068	M6 x 16 BHCS, Zinc	18
6		25 15 105	M6 Hex Nut, Zinc	18

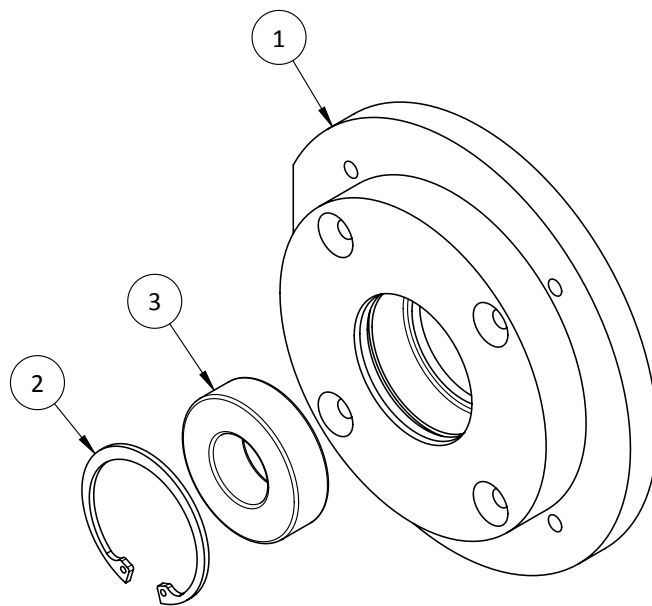


Cover Complete			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 56 10	Cover Complete T1000

## Section 2

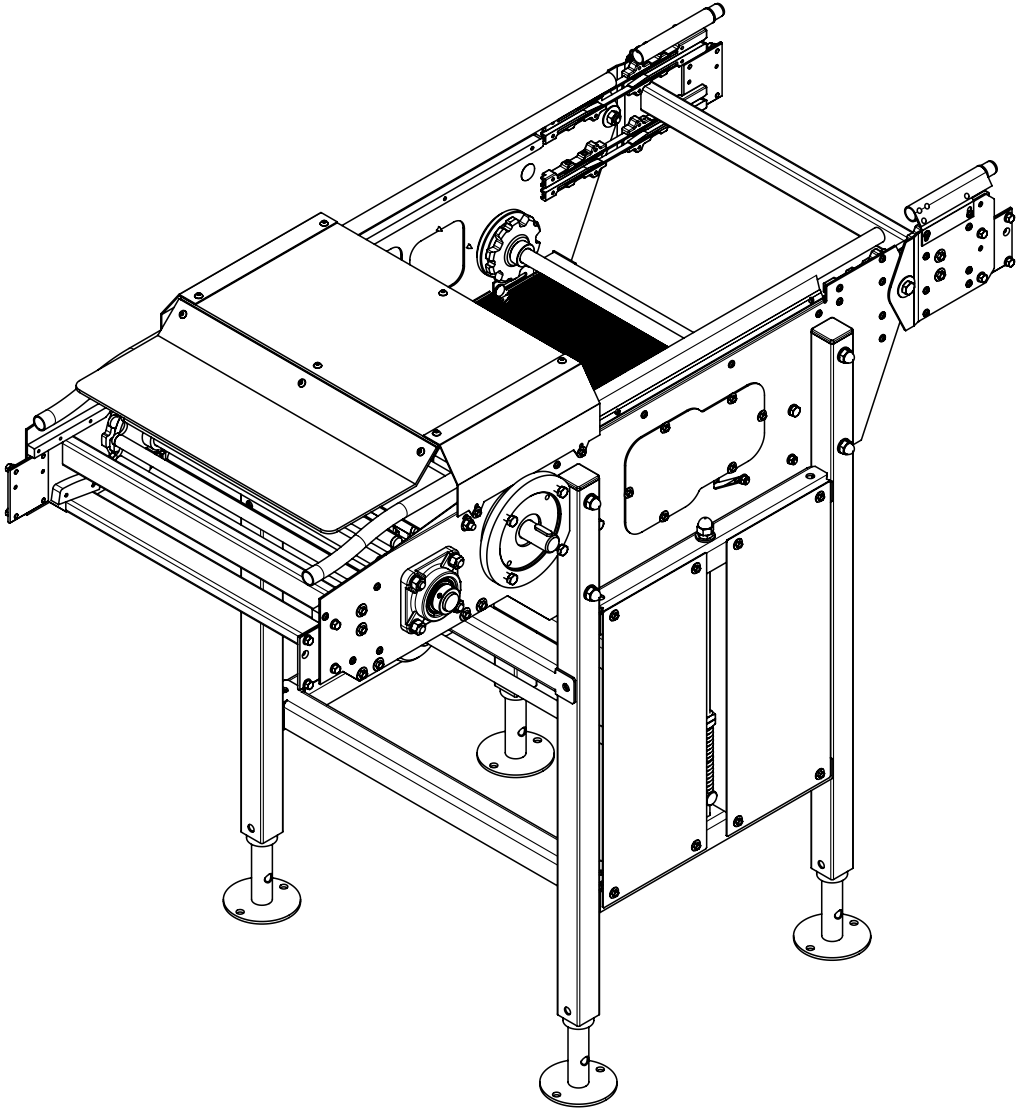
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 511 30 01*		Flange	1
2		26 36 075	Internal Retaining Ring 52x2	1
3		6205.2RSR	Bearing 25mm	1

\*ITEM NOT AVAILABLE INDIVIDUALLY, IF NEEDED ORDER COMPLETE ASSEMBLY (SEE CHART BELOW)



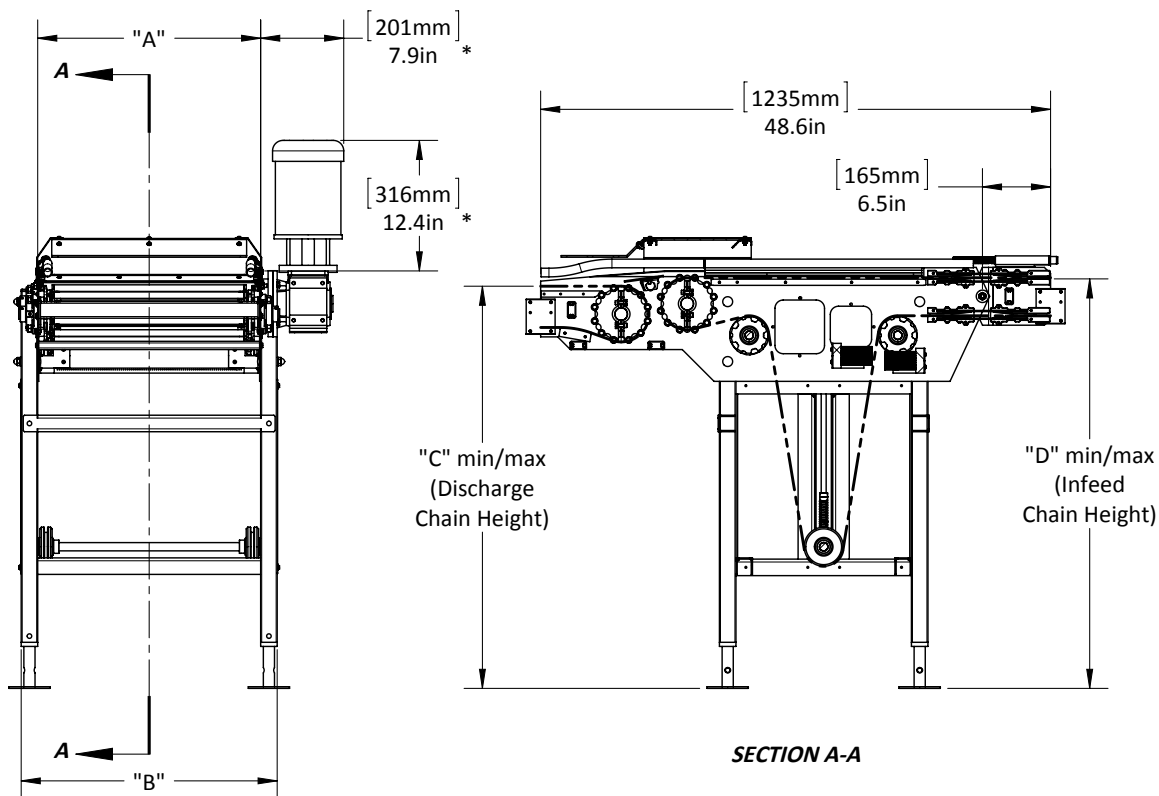
Flange Complete Main Drive			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	185 500 55 01	Flange Complete Main Drive

Transfer Drive T350 - T750



Transfer Drive			
Conveyor Type	Part Number	Drawing Number	Description
250	--	--	--
350	4869	--	Transfer Drive T350
500	4839	--	Transfer Drive T500
750	4899	--	Transfer Drive T750



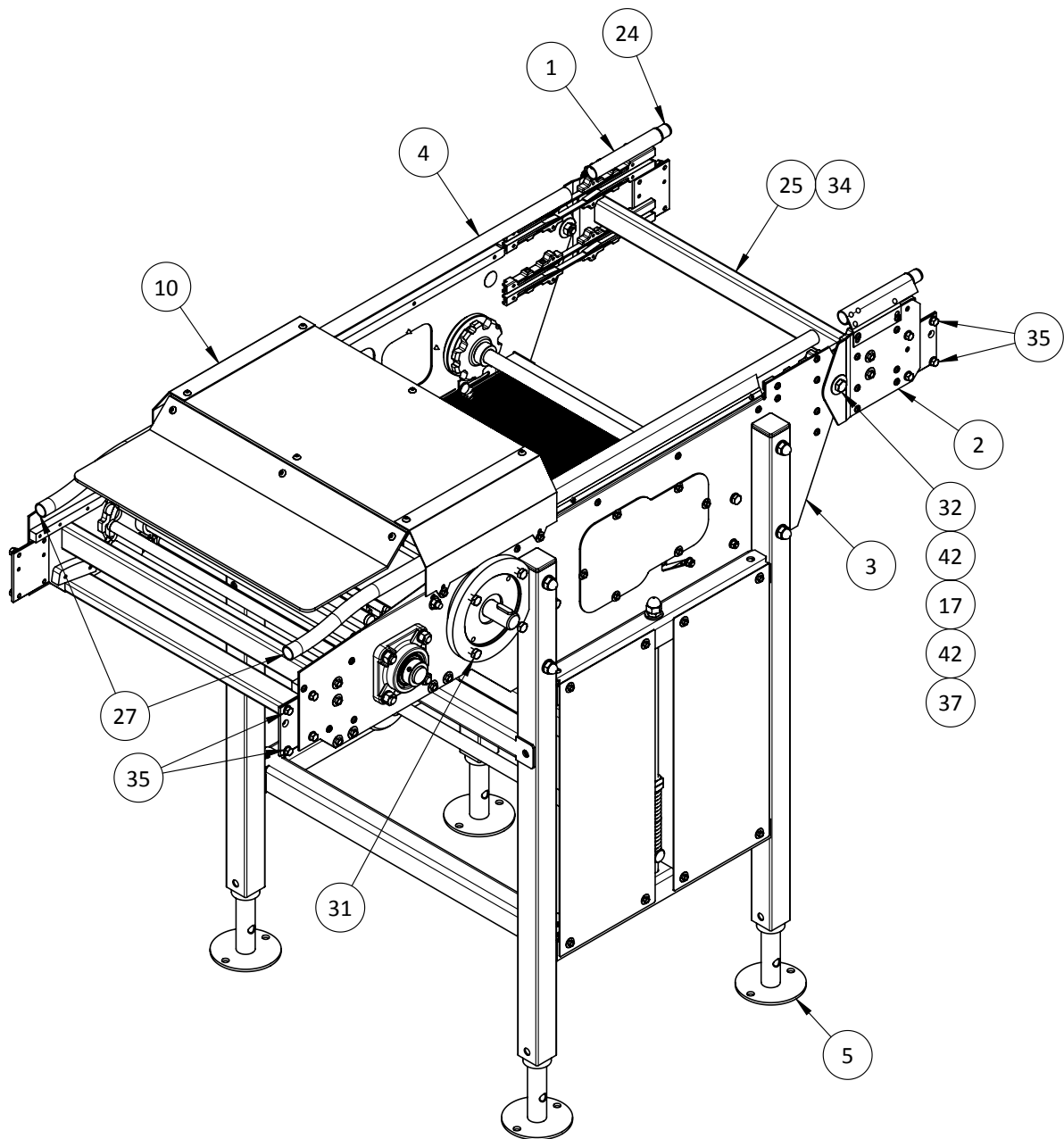


Transfer Drive								
Part Number	Conveyor Type	Description	A (mm/inches)	B (mm/inches)	C min (mm/inches)	C max (mm/inches)	D (mm/inches)	Chain Length (m/ft)
--	250	--	--	--	960/38.0	1270/50.0	"C" + 25mm "C" + 1IN	--
4869	350	Transfer Drive T350	390/15.4	470/18.5				3.5/11.6
4839	500	Transfer Drive T500	540/21.3	620/24.4				
4899	750	Transfer Drive T750	790/31.1	870/34.3				

\*S87.3 Stober Gearbox and G581 Marathon Motor shown, sold separately

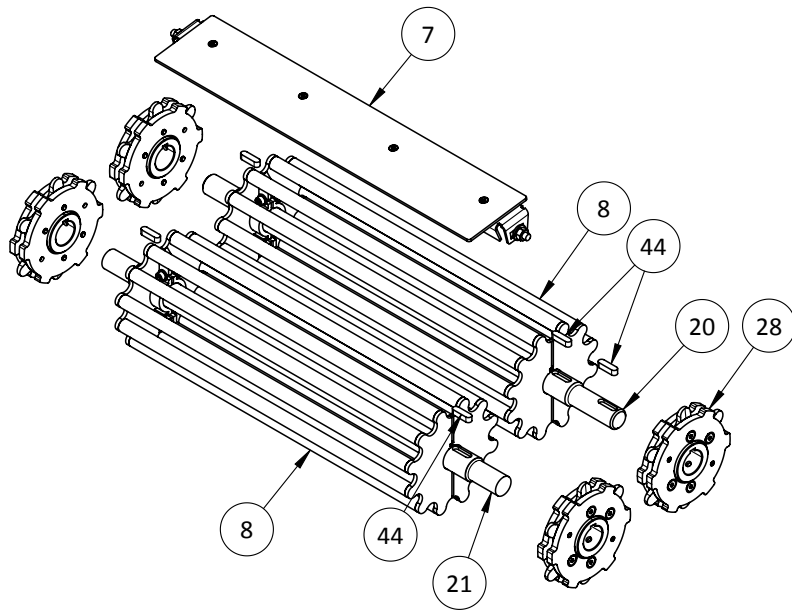
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T350	T500	T750
1	185 100 02 06		Pivot Sidesheet Complete Outer RH	1	1	1
2	185 100 02 07		Pivot Sidesheet Complete Outer LH	1	1	1
3	185 100 03 07		Transfer Drive Sidesheet Complete LH	1	1	1
4	185 100 03 08		Transfer Drive Sidesheet Complete RH	1	1	1
5	187 500 02 01		Frame T350	1	-	-
5	185 500 02 01		Frame T500	-	1	-
5	188 500 02 01		Frame T750	-	-	1
6	187 500 05 00		Cleaning Brush Complete T350	2	-	-
6	185 500 05 00		Cleaning Brush Complete T500	-	2	-
6	188 500 05 00		Cleaning Brush Complete T750	-	-	2
7	187 500 10 03		Transfer Complete T350 x 95mm	1	-	-
7	185 500 10 03		Transfer Complete T500 x 95mm	-	1	-
7	188 500 10 03		Transfer Complete T750 x 95mm	-	-	1
8	187 500 11 02		Discharge Wheel Complete T350	2	-	-
8	185 500 11 02		Discharge Wheel Complete T500	-	2	-
8	188 500 11 02		Discharge Wheel Complete T750	-	-	2
9	185 500 22 00		Screw Spindle Main Drive	2	2	2
10	187 500 56 10		Cover Complete T350	1	-	-
10	185 500 56 10		Cover Complete T500	-	1	-
10	188 500 56 10		Cover Complete T750	-	-	1
11	185 510 08 00		Distance Tube	4	4	4
12	185 513 05 00		M6 Square Hole Washer, Zinc	4	4	4
13	187 515 04 02		20mm Axle T350	2	-	-
13	185 515 04 02		20mm Axle T500	-	2	-
13	188 515 04 02		20mm Axle T750	-	-	2
14	185 515 07 00		Pressure Piece	2	2	2
15	187 515 11 02		Tension Axle T350	1	-	-
15	185 515 11 02		Tension Axle T500	-	1	-
15	188 515 11 02		Tension Axle T750	-	-	1
16	185 515 13 00		Distance Washer	2	2	2
17	185 515 13 02		Distance Washer	2	2	2
18	185 515 21 00		Deflection Wheel Grooved 94.7mm	4	4	4
19	185 515 22 00		Deflection Wheel Smooth 94.7mm	2	2	2
20	187 516 01 01		Drive Shaft T350	1	-	-
20	185 516 01 01		Drive Shaft T500	-	1	-
20	188 516 01 01		Drive Shaft T750	-	-	1
21	187 516 01 07		Return Shaft T350	1	-	-
21	185 516 01 07		Return Shaft T500	-	1	-
21	188 516 01 07		Return Shaft T750	-	-	1
22	185 519 09 01		Chain Guard	4	4	4
23	185 519 16 00		Cleaning Brush Cover	2	2	2
24	185 520 18 00		Intermediate Coupling	4	4	4
25	187 524 05 00		Traverse T350	4	-	-
25	185 524 05 00		Traverse T500	-	4	-
25	188 524 05 00		Traverse T750	-	-	4
26	185 525 06 00		Thread Plate	2	2	2
27	185 535 06 00		Transfer Drive Discharge Capping	2	2	2
28	705 001 02 00		Main Drive Sprocket	4	4	4
29		21 28 068	M6 x 16 Carriage Bolt, Zinc	4	4	4
30		21 28 114	M10 x 55 Carriage Bolt, Zinc	8	8	8
31		21 56 087	M8 x 20 Hex Bolt, Zinc	8	8	8
32		21 56 107	M10 x 20 Hex Bolt, Zinc	2	2	2
33		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	32	32	32
34		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	16	16	16
35		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	12	12	12
36		25 15 105	M6 Hex Nut, Zinc	4	4	4
37		25 20 107	M10 Self-Locking Nut, Zinc	2	2	2
38		25 23 107	M10 Cap Nut, Zinc	8	8	8
39		26 02 109	M6 Flat Washer, Zinc	4	4	4
40		26 02 112	M10 Flat Washer, Zinc	8	8	8
41		26 04 111	M8 Lock Washer, Zinc	4	4	4
42		26 34 112	M10 Fender Washer, Zinc	4	4	4
43		26 43 064	Adjusting Ring A20-705	6	6	6
44		27 43 070	8 x 7 x 28 Parallel Key	5	5	5
45		32 02 639	Pressure Spring	4	4	4
46		70 50 008	Plastic Tube Cap	4	4	4

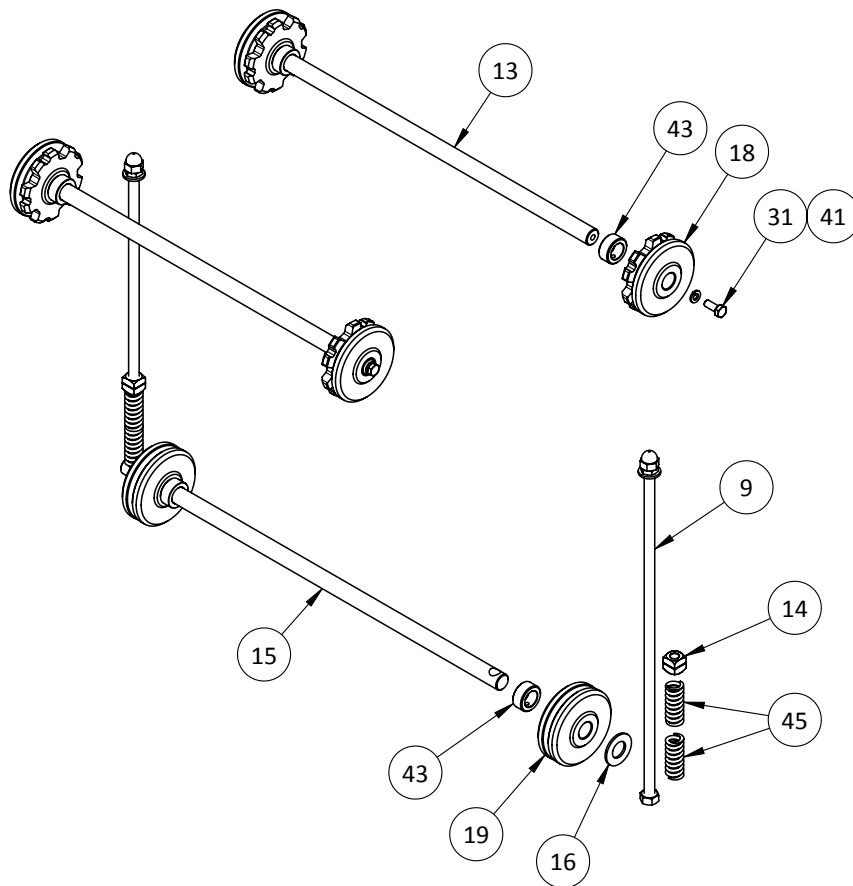


## Section 2

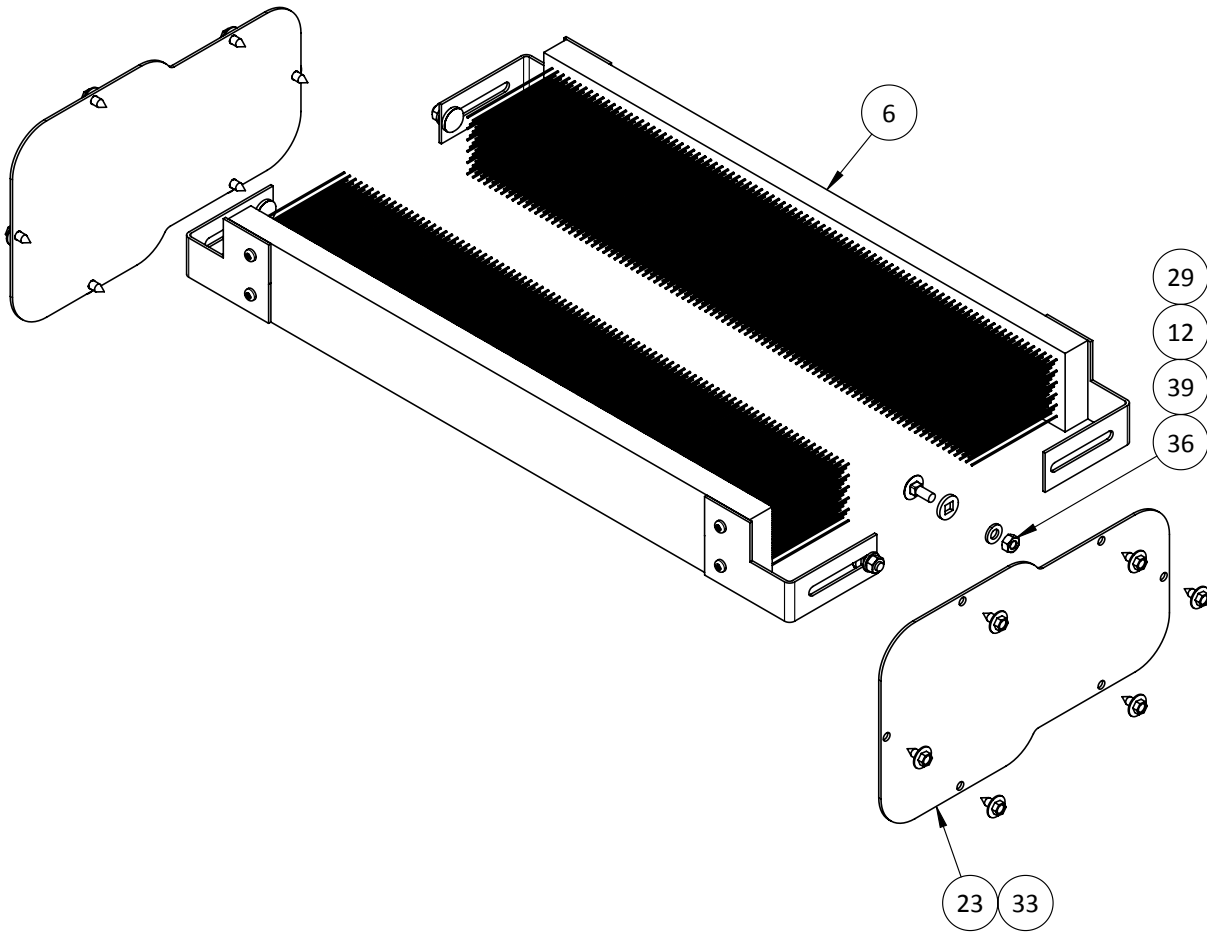
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**DISCHARGE WHEEL COMPONENTS DETAIL**

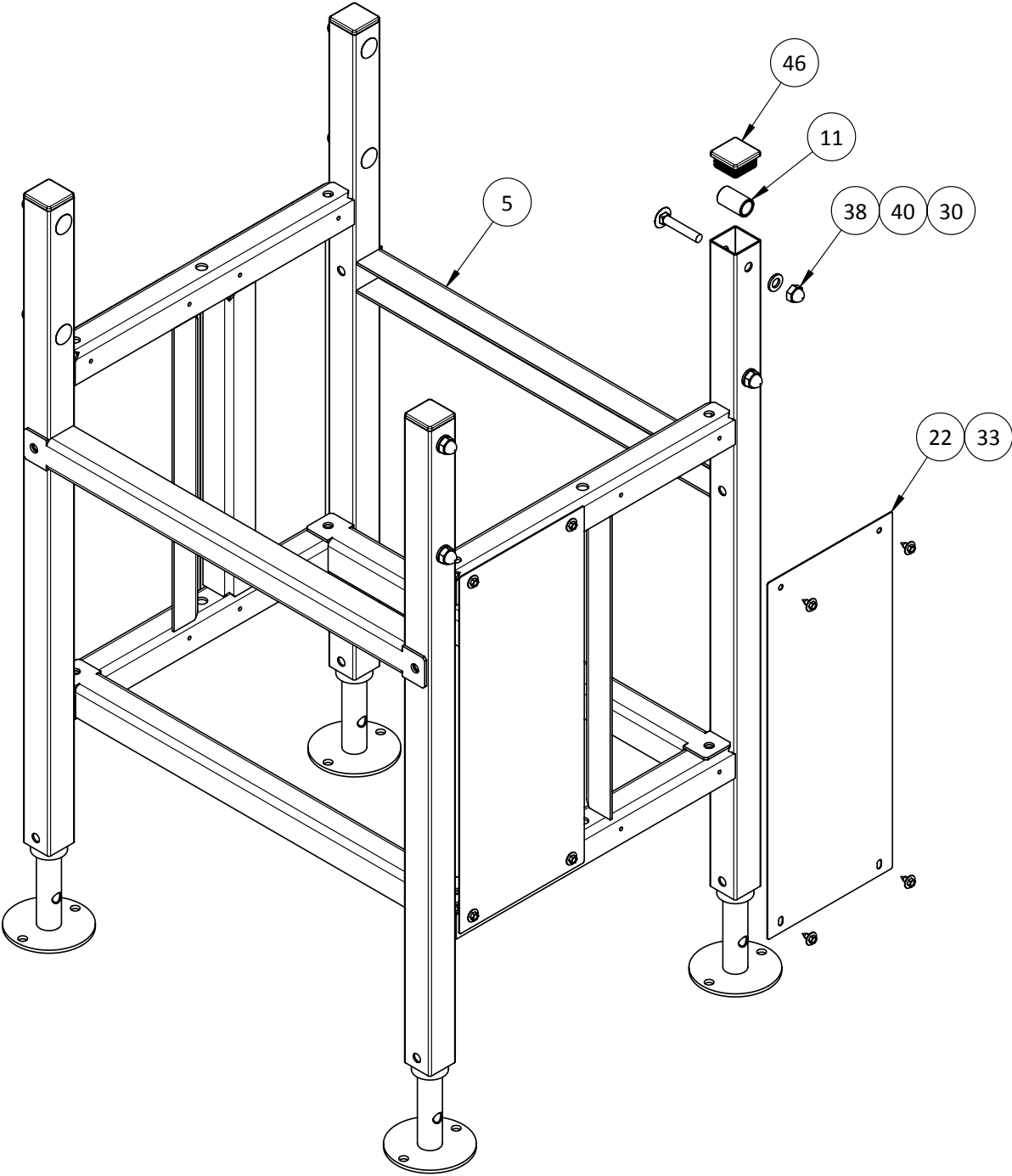


**AXLE COMPONENTS DETAIL**



*CLEANING BRUSH COMPONENTS DETAIL*

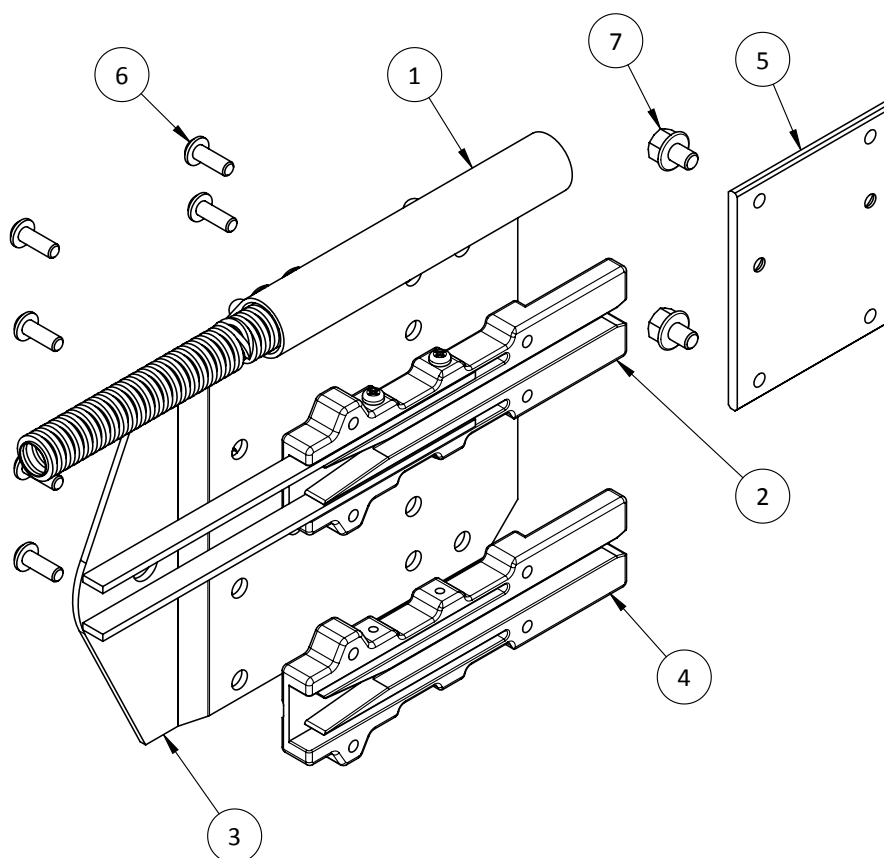
# Section 2



**FRAME COMPONENTS DETAIL**

## Section 2

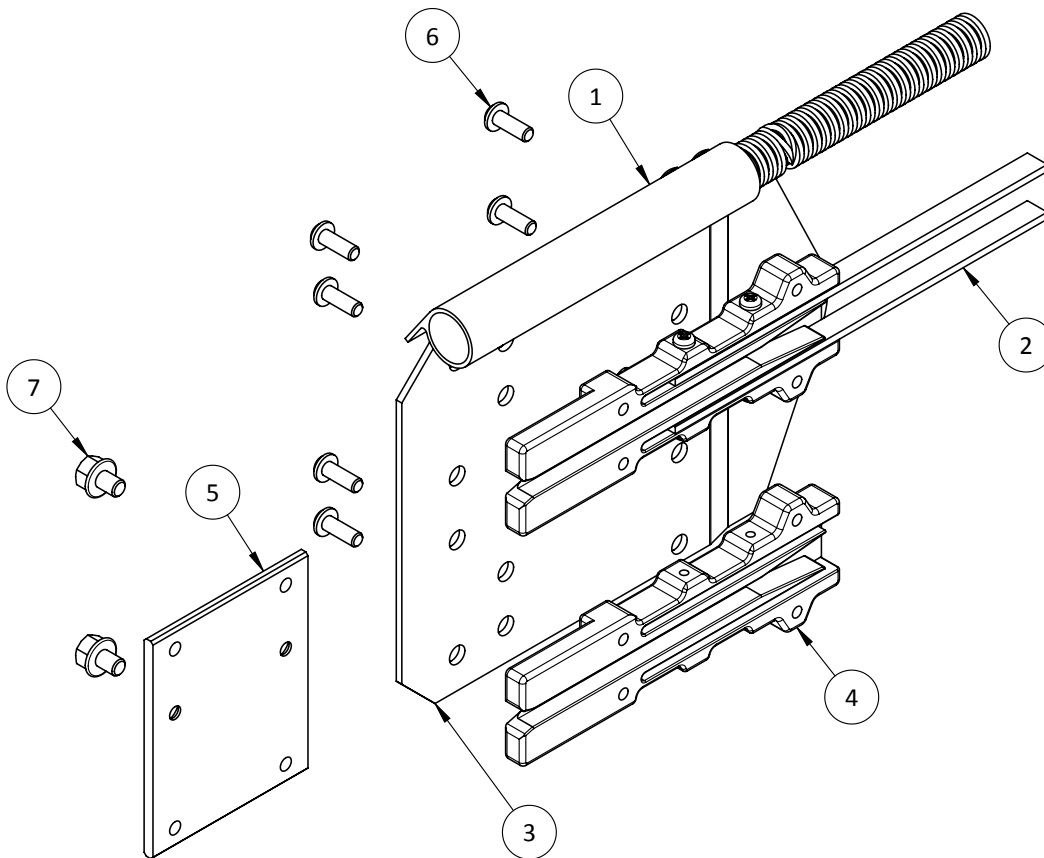
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 09 01		Pivot Flex Capping Complete RH	1
2	185 100 11 00		Sliding Shoe Long Complete	1
3	185 525 01 02		Pivot Outer Sidesheet	1
4	185 525 05 01		Sliding Shoe Long	1
5	185 525 06 00		Thread Plate	1
6		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	8
7		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	2



Pivot Sidesheet Complete Outer RH			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 100 02 06	Pivot Sidesheet Complete Outer RH
350			
500			
750			

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 09 00		Pivot Flex Capping Complete LH	1
2	185 100 11 00		Sliding Shoe Long Complete	1
3	185 525 01 02		Pivot Outer Sidesheet	1
4	185 525 05 01		Sliding Shoe Long	1
5	185 525 06 00		Thread Plate	1
6		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	8
7		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	2

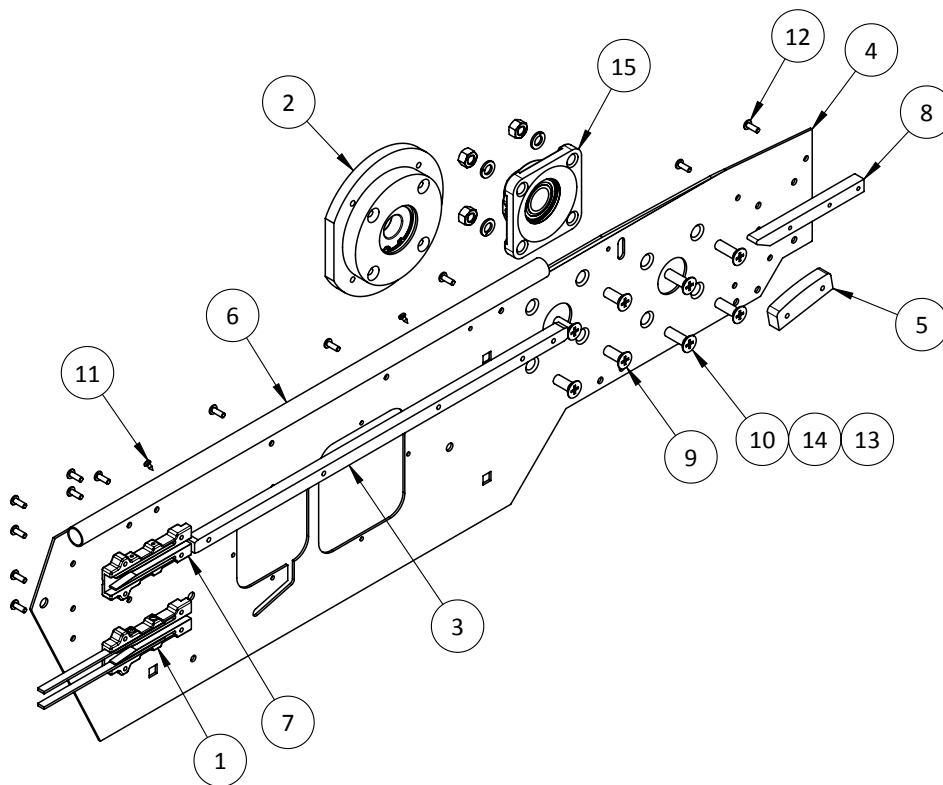


Pivot Sidesheet Complete Outer LH			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 100 02 07	Pivot Sidesheet Complete Outer LH
350			
500			
750			



## Section 2

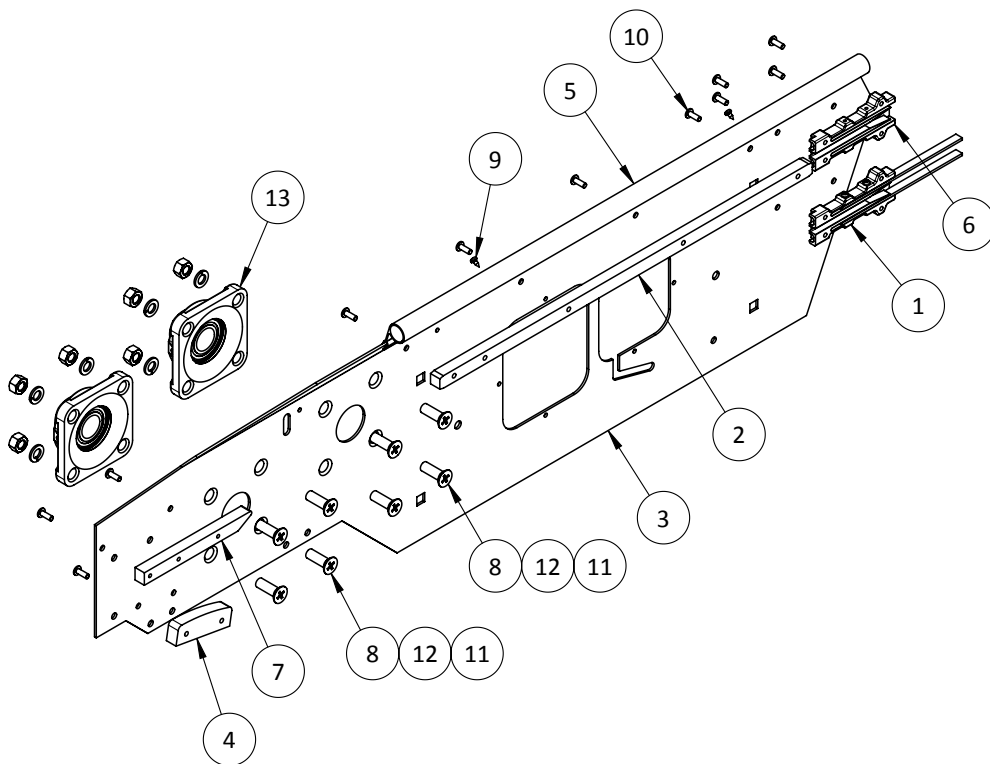
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 13 00		Sliding Shoe Short Complete	1
2	185 500 55 01		Flange Complete Main Drive	1
3	185 511 21 00		Guide Rail Front Drive	1
4	185 511 61 02		Transfer Drive Sidesheet LH	1
5	185 520 07 00		Curved Sliding Shoe	1
6	185 520 09 19		Transfer Drive Capping LH	1
7	185 525 05 02		Sliding Shoe Short	1
8	191 525 24 00		Transfer Drive Sliding Shoe	1
9		21 63 108	M10 x 25 Countersunk Screw, Zinc	4
10		21 63 109	M10 x 30 Countersunk Screw, Zinc	4
11		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	2
12		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	16
13		25 15 107	M10 Hex Nut, Zinc	4
14		26 04 112	M10 Lock Washer, Zinc	4
15		34 10 205	4-Bolt Flange Bearing 25mm	1



Transfer Drive Sidesheet Complete LH			
Conveyor Type	Part Number	Drawing Number	Description
350	--	185 100 03 07	Transfer Drive Sidesheet Complete LH
500			
750			

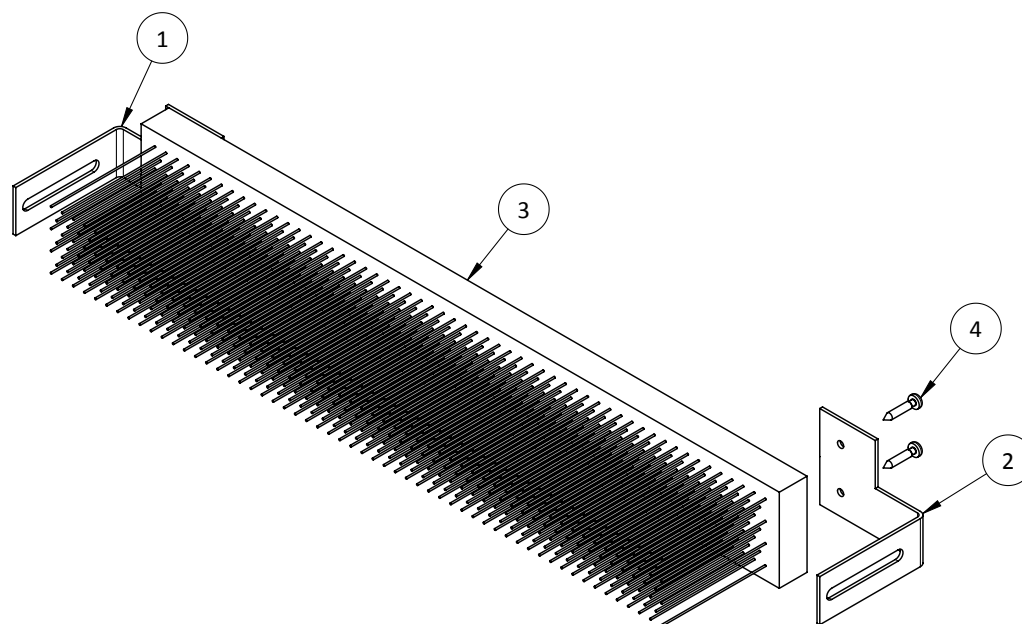
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 13 00		Sliding Shoe Short Complete	1
2	185 511 21 00		Guide Rail Front Drive	1
3	185 511 61 03		Transfer Drive Sidesheet RH	1
4	185 520 07 00		Curved Sliding Shoe	1
5	185 520 09 20		Transfer Drive Capping RH	1
6	185 525 05 02		Sliding Shoe Short	1
7	191 525 24 00		Transfer Drive Sliding Shoe	1
8		21 63 109	M10 x 30 Countersunk Screw, Zinc	8
9		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	2
10		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	16
11		25 15 107	M10 Hex Nut, Zinc	8
12		26 04 112	M10 Lock Washer, Zinc	8
13		34 10 205	4-Bolt Flange Bearing 25mm	2



Transfer Drive Sidesheet Complete RH			
Conveyor Type	Part Number	Drawing Number	Description
350	--	185 100 03 08	Transfer Drive Sidesheet Complete RH
500			
750			

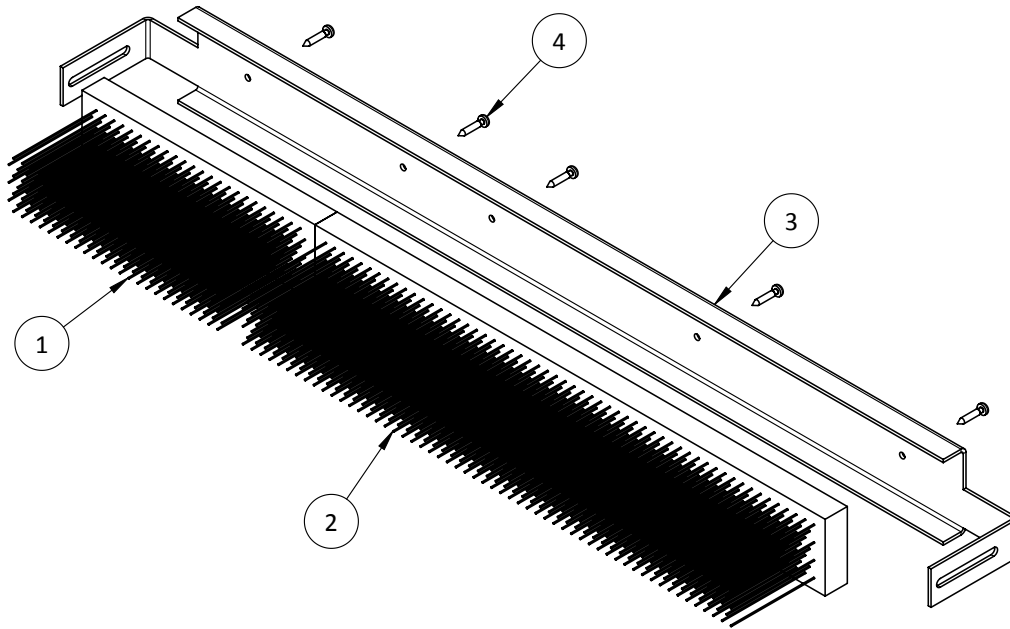
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T350	T500
1	185 513 03 00		Cleaning Brush Angle Bracket LH	1	1
2	185 513 03 01		Cleaning Brush Angle Bracket RH	1	1
3	187 513 04 00		Cleaning Brush T350	1	-
3	185 513 04 00		Cleaning Brush T500	-	1
4		21 80 020	M4.2 x 22 Self-Tapping Screw, Zinc	4	4



Cleaning Brush Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	--	--
350	--	187 500 05 00	Cleaning Brush Complete T350
500	--	185 500 05 00	Cleaning Brush Complete T500

## Section 2

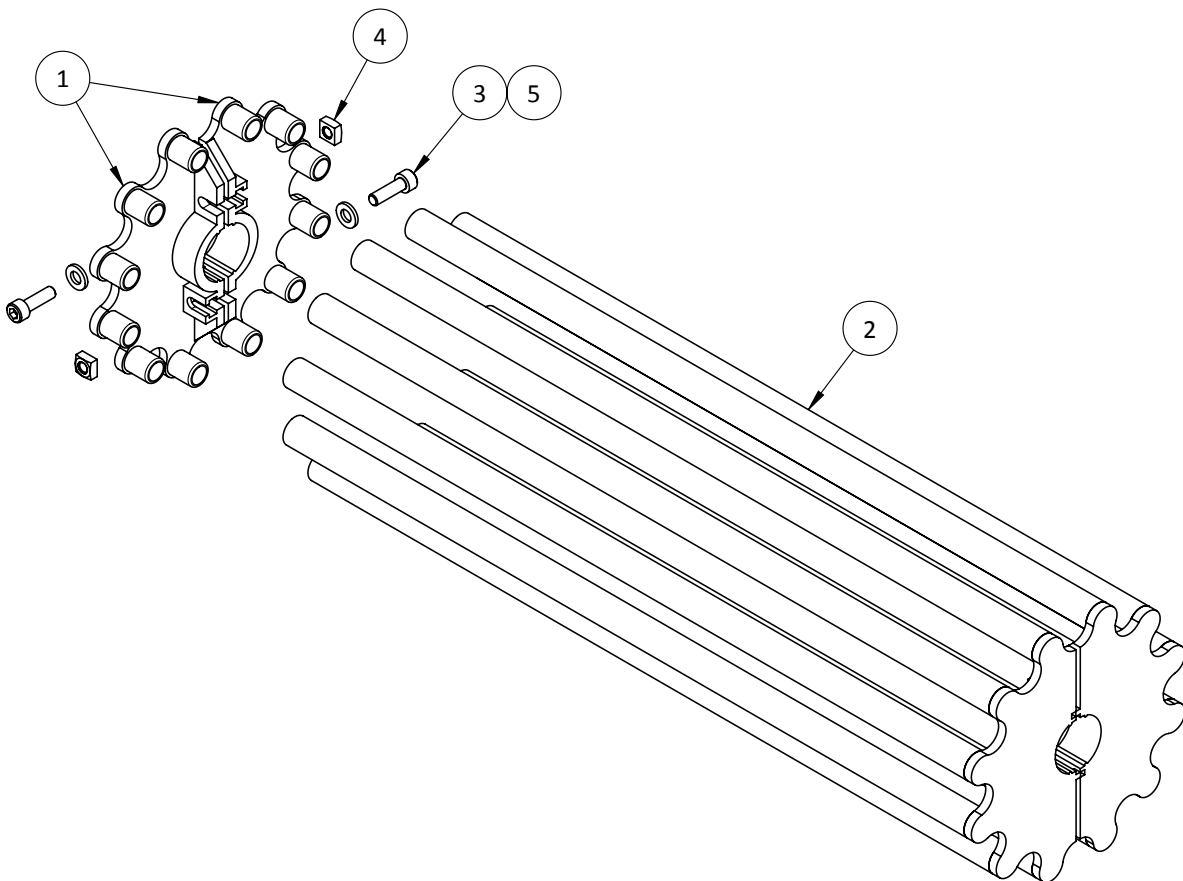
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T750
1	186 513 04 00		Cleaning Brush T250	1
2	185 513 04 00		Cleaning Brush T500	1
3	188 513 01 00		Brush Support Channel T750	1
4		21 80 020	M4.2 x 22 Self-Tapping Screw, Zinc	5



Cleaning Brush Complete			
Conveyor Type	Part Number	Drawing Number	Description
750	--	188 500 05 00	Cleaning Brush Complete T750

## Section 2

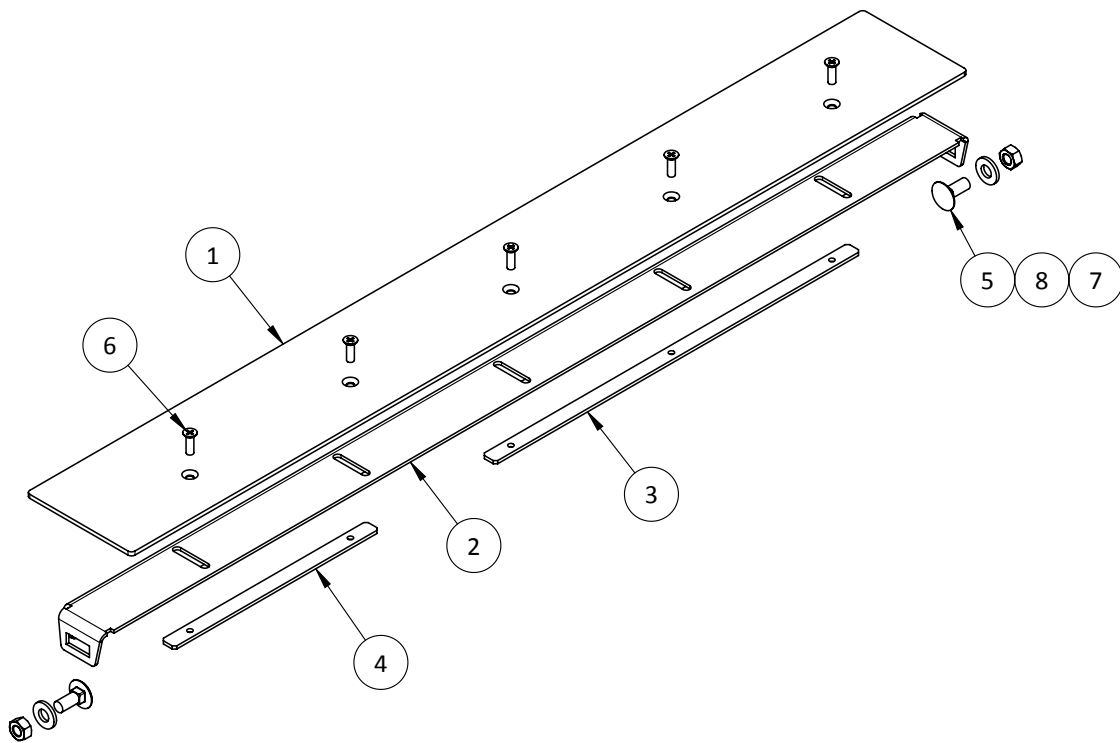
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 518 03 01		Driving Plate	4	4	4	4
2	186 518 05 01		Discharge Tube T250	12	-	-	-
2	187 518 05 01		Discharge Tube T350	-	12	-	-
2	185 518 05 01		Discharge Tube T500	-	-	12	-
2	188 518 05 01		Discharge Tube T750	-	-	-	12
3		21 42 069	M6 x 20 SHCS, Zinc	4	4	4	4
4		25 09 105	M6 Square Nut, Zinc	4	4	4	4
5		26 02 109	M6 Flat Washer, Zinc	4	4	4	4



Discharge Wheel Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 11 02	Discharge Wheel Complete T250
350	--	187 500 11 02	Discharge Wheel Complete T350
500	--	185 500 11 02	Discharge Wheel Complete T500
750	--	188 500 11 02	Discharge Wheel Complete T750

## Section 2

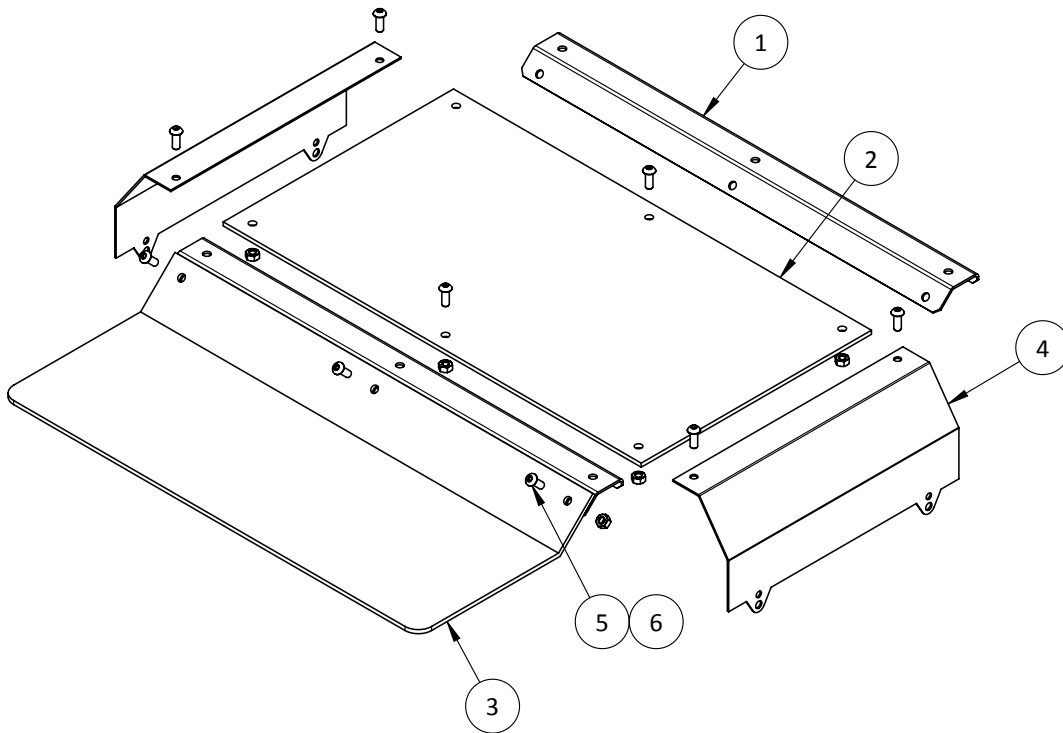
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	186 518 02 00		Transfer Plate T250 x 95mm	1	-	-	-
1	187 518 02 00		Transfer Plate T350 x 95mm	-	1	-	-
1	185 518 02 00		Transfer Plate T500 x 95mm	-	-	1	-
1	188 518 02 00		Transfer Plate T750 x 95mm	-	-	-	1
2	186 518 43 00		Transfer Angle T250	1	-	-	-
2	187 518 43 00		Transfer Angle T350	-	1	-	-
2	185 518 43 00		Transfer Angle T500	-	-	1	-
2	188 518 43 00		Transfer Angle T750	-	-	-	1
3	187 518 44 00		Thread Plate T350	-	1	-	1
4	189 518 44 00		Thread Plate T200	1	-	2	1
5		21 28 087	M8 x 20 Carriage Bolt, Zinc	2	2	2	2
6		21 63 049	M5 x 16 Countersunk Screw, Zinc	2	3	4	5
7		25 15 106	M8 Hex Nut, Zinc	2	2	2	2
8		26 02 111	M8 Flat Washer, Zinc	2	2	2	2



Transfer Complete 95mm			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 10 03	Transfer Complete T250 x 95mm
350	--	187 500 10 03	Transfer Complete T350 x 95mm
500	--	185 500 10 03	Transfer Complete T500 x 95mm
750	--	188 500 10 03	Transfer Complete T750 x 95mm

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T750	T500
1	186 510 07 00		Cover U-Profile T250	2	-	-	-
1	187 510 07 00		Cover U-Profile T350	-	2	-	-
1	188 510 07 00		Cover U-Profile T750	-	-	2	-
1	185 510 07 00		Cover U-Profile T500	-	-	-	2
2	186 510 10 00		Top Cover T250	1	-	-	-
2	187 510 10 00		Top Cover T350	-	1	-	-
2	188 510 10 00		Top Cover T750	-	-	1	-
2	185 510 10 00		Top Cover T500	-	-	-	1
3	186 510 10 02		Transfer Cover T250	1	-	-	-
3	187 510 10 02		Transfer Cover T350	-	1	-	-
3	188 510 10 02		Transfer Cover T750	-	-	1	-
3	185 510 10 02		Transfer Cover T500	-	-	-	1
4	185 510 26 00		Cover Sidesheet	2	2	2	2
5		21 90 068	M6 x 16 BHCS, Zinc	9	6	9	9
6		25 15 105	M6 Hex Nut, Zinc	9	9	9	9

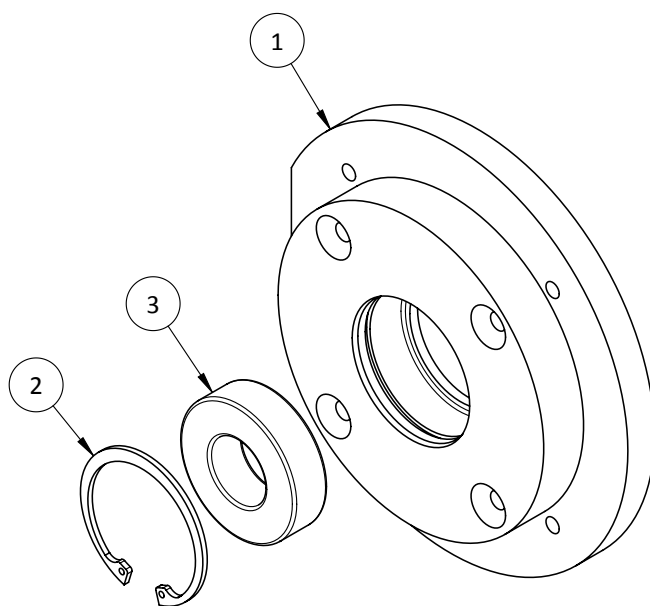


Cover Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 56 10	Cover Complete T250
350	--	187 500 56 10	Cover Complete T350
500	--	185 500 56 10	Cover Complete T500
750	--	188 500 56 10	Cover Complete T750

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 511 30 01*		Flange	1
2		26 36 075	Internal Retaining Ring 52x2	1
3		6205.2RSR	Bearing 25mm	1

\*ITEM NOT AVAILABLE INDIVIDUALLY, IF NEEDED ORDER COMPLETE ASSEMBLY (SEE CHART BELOW)



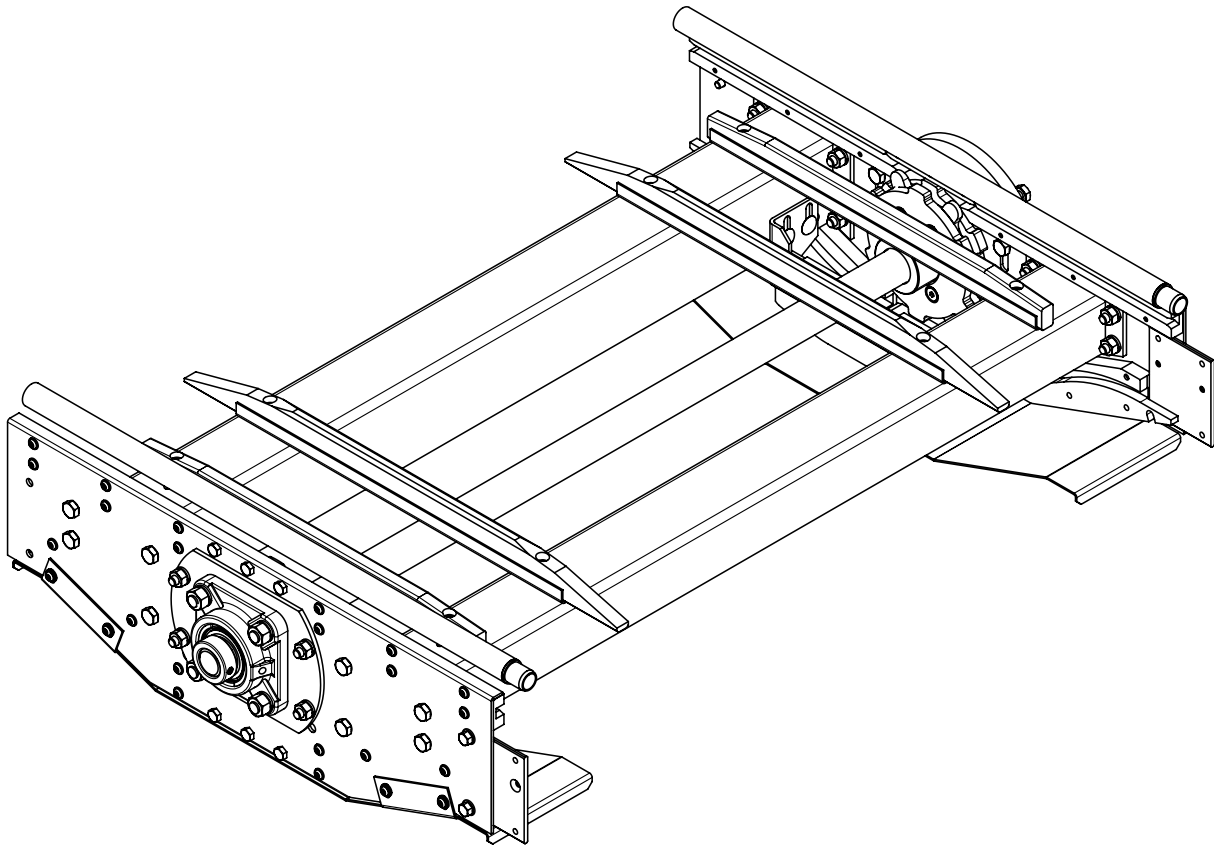
Flange Complete Main Drive			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 500 55 01	Flange Complete Main Drive
350	--		
500	--		
750	--		



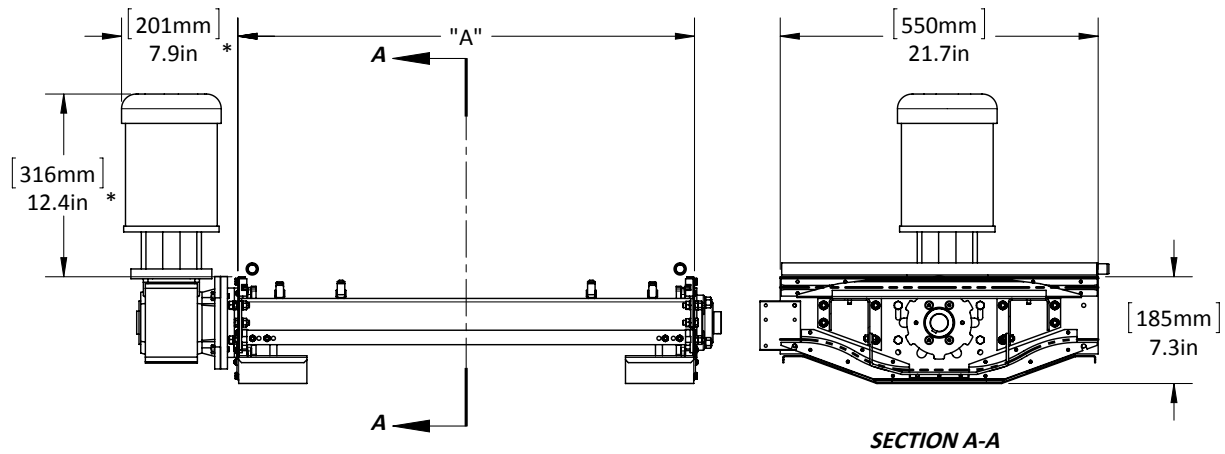
## Section 2

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### Intermediate Drive T250 - T750



Intermediate Drive			
Conveyor Type	Part Number	Drawing Number	Description
250	4935	--	Intermediate Drive T250
350	4868	--	Intermediate Drive T350
500	4835	--	Intermediate Drive T500
750	4898	--	Intermediate Drive T750



Intermediate Drive							
Part Number	Conveyor Type	Description	A (mm/inches)	H1** min/max (mm/inches)	H2*** min/max (mm/inches)	H3**** min/max (mm/inches)	Chain Length (m/ft)
4935	250	Intermediate Drive T250	290/11.4	190 - 320 7.5 - 12.6	310 - 610 12.2 - 24.0	600 - 1300 23.6 - 51.2	1.1/3.7
4868	350	Intermediate Drive T350	390/15.4				
4835	500	Intermediate Drive T500	540/21.3				
4898	750	Intermediate Drive T750	790/31.1				

\*S87.3 Stober Gearbox and G581 Marathon Motor shown, sold separately

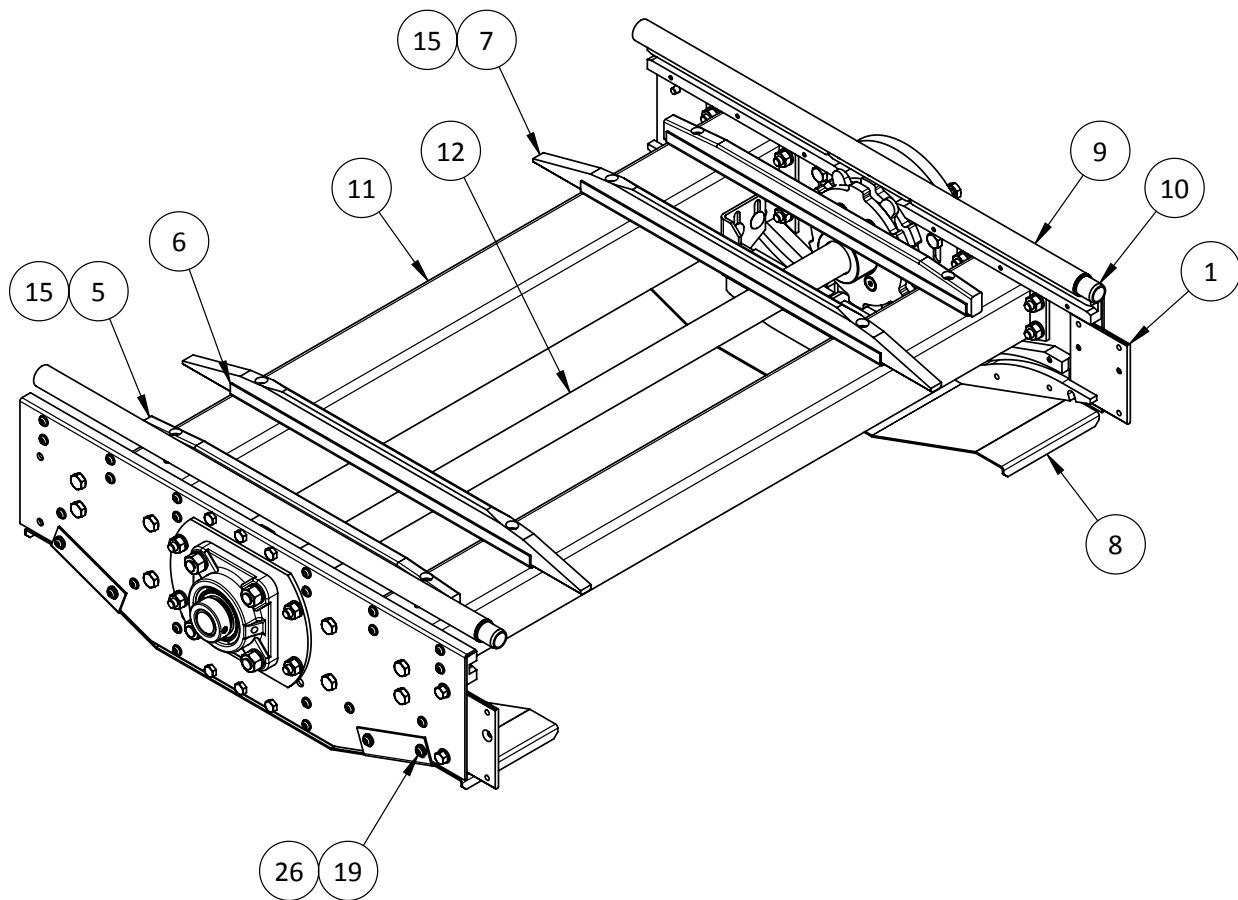
\*\*Height of unit with Floor Support Short

\*\*\*Height of unit with Floor Support Middle

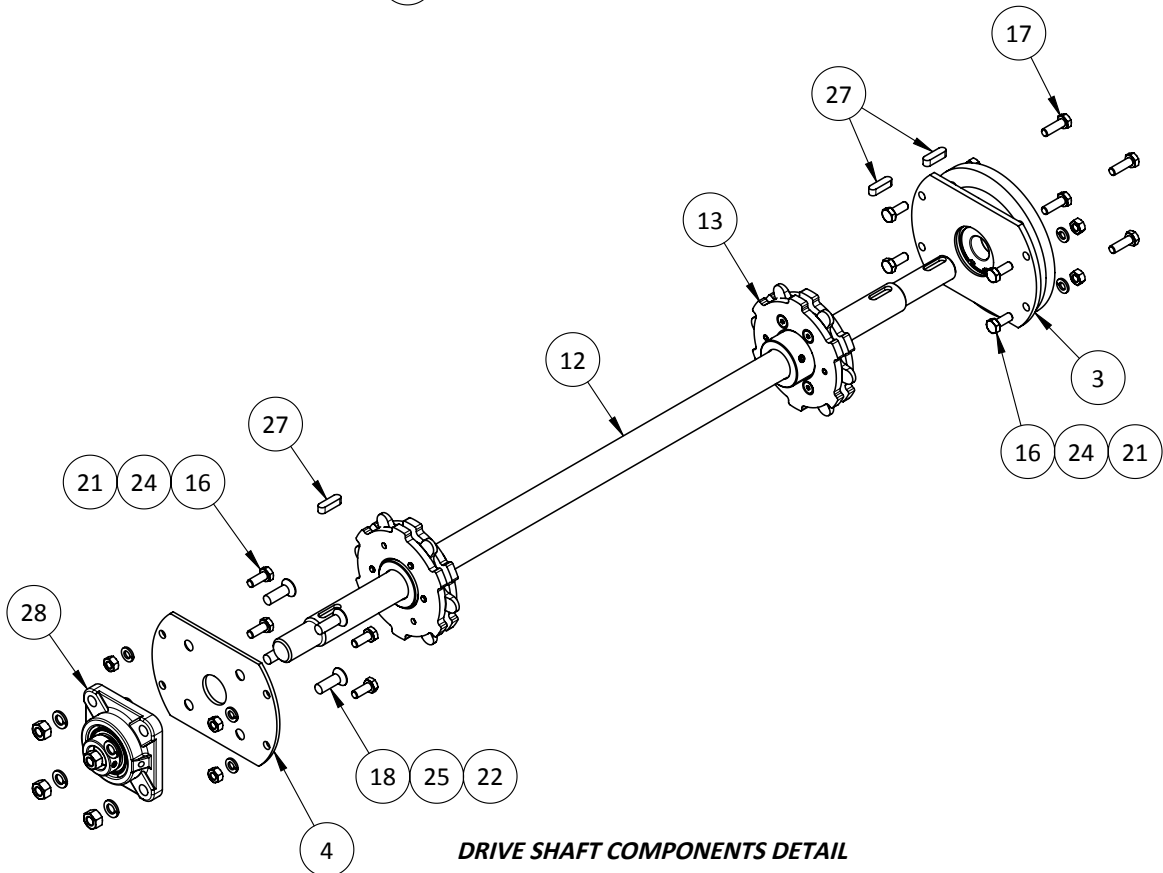
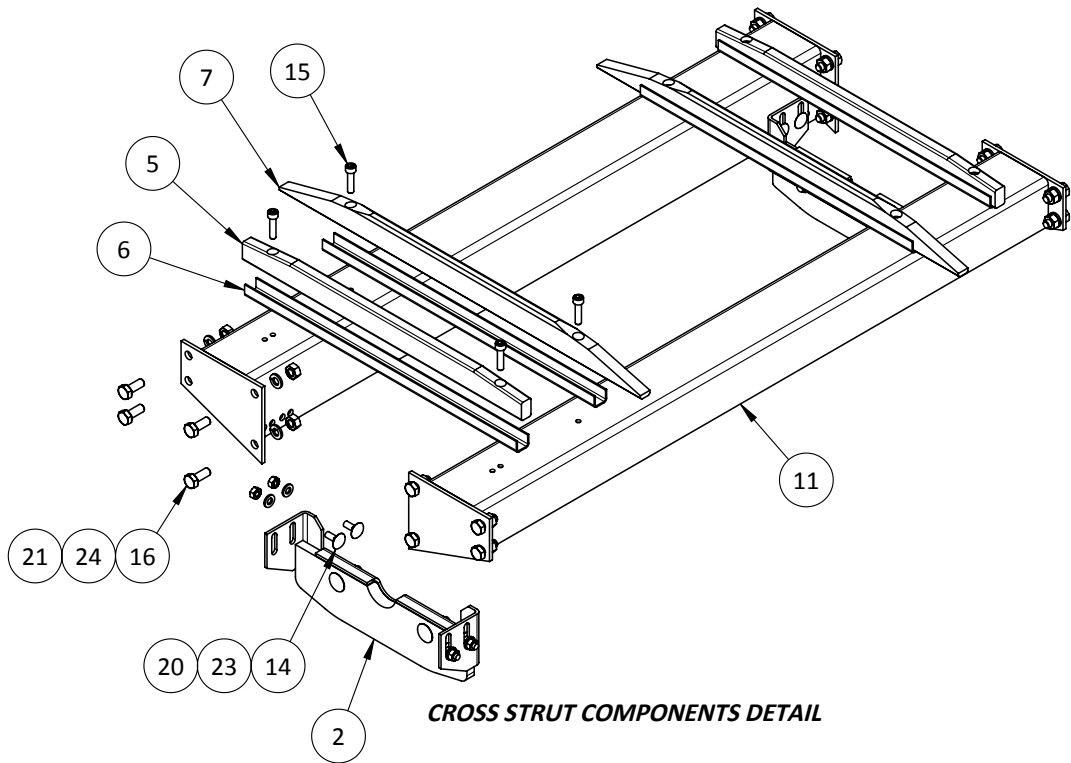
\*\*\*\*Height of unit with Floor Support Long

## Section 2

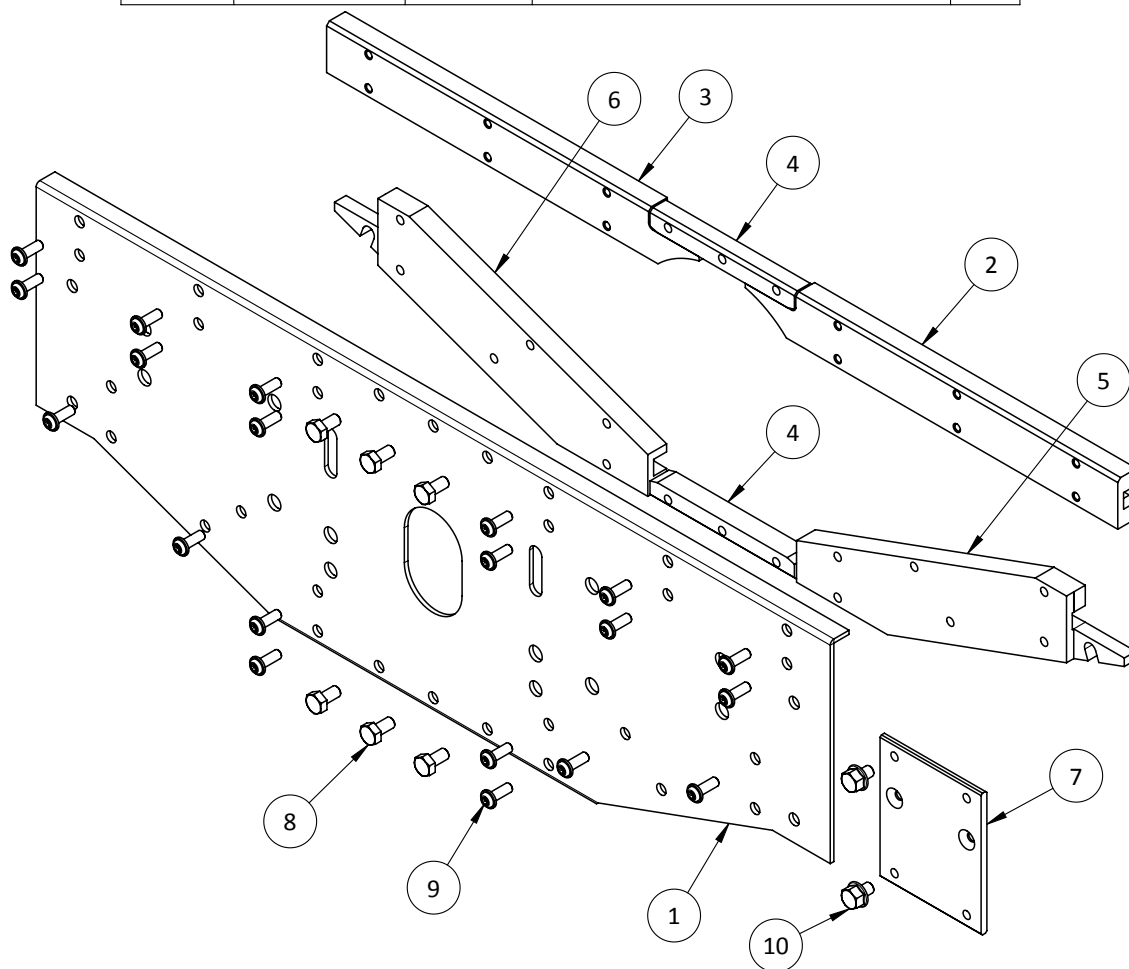
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 100 06 00		Intermediate Drive Sidesheet Complete	2	2	2	2
2	185 500 23 04		Lower Pressure Pad With Profile	2	2	2	2
3	185 500 55 02		Flange Complete Intermediate Drive	1	1	1	1
4	185 511 32 00		Flange Bearing Thread Plate	1	1	1	1
5	185 516 08 02		Outer Pressure Pad	2	2	2	2
6	185 516 08 04		Intermediate Drive U-Profile	2	2	2	4
7	185 516 08 06		Inner Pressure Pad	-	-	-	2
8	185 519 15 00		Intermediate Drive Cover	2	2	2	2
9	185 520 17 00		Intermediate Drive Capping	2	2	2	2
10	185 520 18 00		Intermediate Coupling	2	2	2	2
11	186 500 24 00		Cross Strut T250	2	-	-	-
11	187 500 24 00		Cross Strut T350	-	2	-	-
11	185 500 24 00		Cross Strut T500	-	-	2	-
11	188 500 24 00		Cross Strut T750	-	-	-	2
12	186 516 01 01		Drive Shaft T250	1	-	-	-
12	187 516 01 01		Drive Shaft T350	-	1	-	-
12	185 516 01 01		Drive Shaft T500	-	-	1	-
12	188 516 01 01		Drive Shaft T750	-	-	-	1
13	705 001 03 00		Intermediate Drive Sprocket	2	2	2	2
14		21 28 068	M6 x 16 Carriage Bolt, Zinc	8	8	8	8
15		21 42 070	M6 x 25 SHCS, Zinc	4	4	4	8
16		21 56 087	M8 x 20 Hex Bolt, Zinc	24	24	24	24
17		21 56 088	M8 x 25 Hex Bolt, Zinc	4	4	4	4
18		21 63 109	M10 x 30 Countersunk Screw, Zinc	4	4	4	4
19		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	8	8	8	8
20		25 15 105	M6 Hex Nut, Zinc	8	8	8	8
21		25 15 106	M8 Hex Nut, Zinc	24	24	24	24
22		25 15 107	M10 Hex Nut, Zinc	4	4	4	4
23		26 02 109	M6 Flat Washer, Zinc	8	8	8	8
24		26 04 111	M8 Lock Washer, Zinc	24	24	24	24
25		26 04 112	M10 Lock Washer, Zinc	4	4	4	4
26		26 34 108	M5 Flat Washer, Zinc	8	8	8	8
27		27 43 070	8 x 7 x 28 Parallel Key	3	3	3	3
28		34 10 205	4-Bolt Flange Bearing 25mm	1	1	1	1



## Section 2



ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 511 03 04		Intermediate Drive Sidesheet	1
2	185 516 04 10		Chain Guide, Upper LH	1
3	185 516 04 11		Chain Guide, Upper RH	1
4	185 516 05 01		Chain Slideway, Metal	2
5	185 516 07 08		Chain Slideway, LH	1
6	185 516 07 09		Chain Slideway, RH	1
7	185 525 06 00		Thread Plate	1
8		21 56 067	M6 x 12 Hex Bolt, Zinc	6
9		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	20
10		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	2

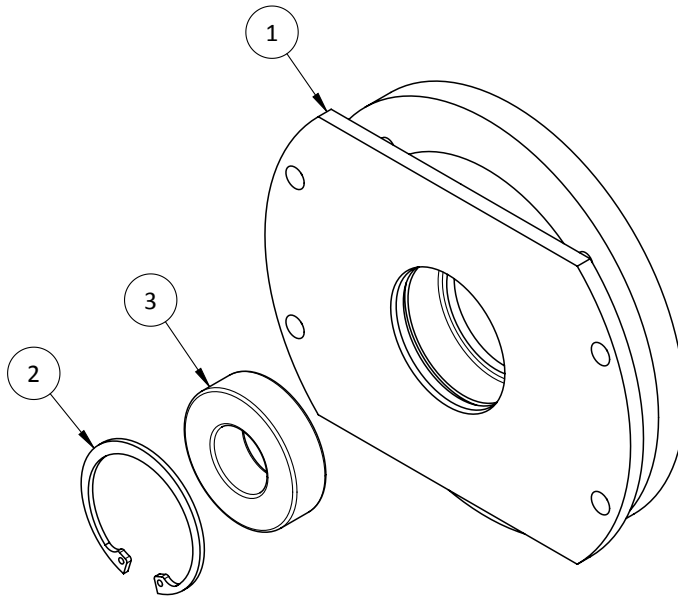


Intermediate Drive Sidesheet Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 100 06 00	Intermediate Drive Sidesheet Complete
350			
500			
750			

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 511 30 02*		Intermediate Flange	1
2		26 36 075	Internal Retaining Ring 52x2	1
3		6205.2RSR	Bearing 25mm	1

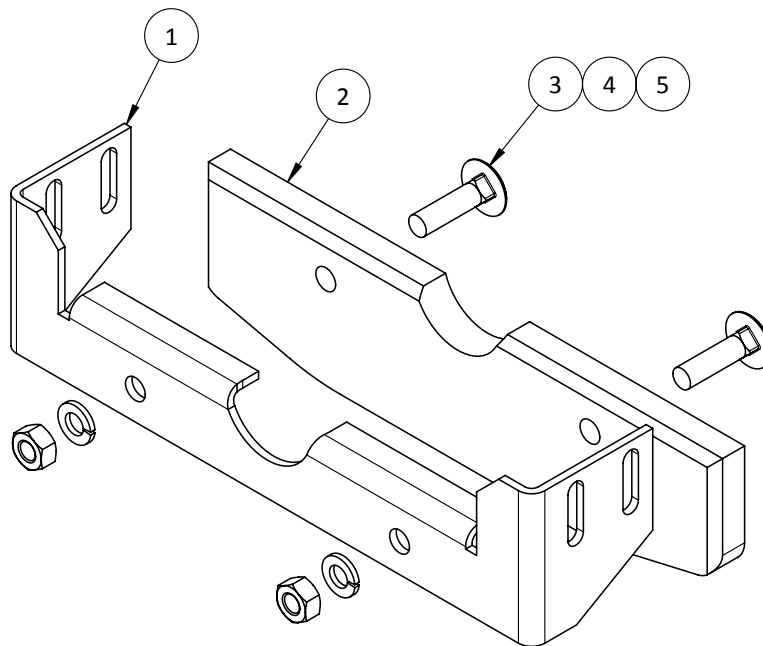
\*ITEM NOT AVAILABLE INDIVIDUALLY, IF NEEDED ORDER COMPLETE ASSEMBLY (SEE CHART BELOW)



Flange Complete Intermediate Drive			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 500 55 02	Flange Complete Intermediate Drive
350			
500			
750			

## Section 2

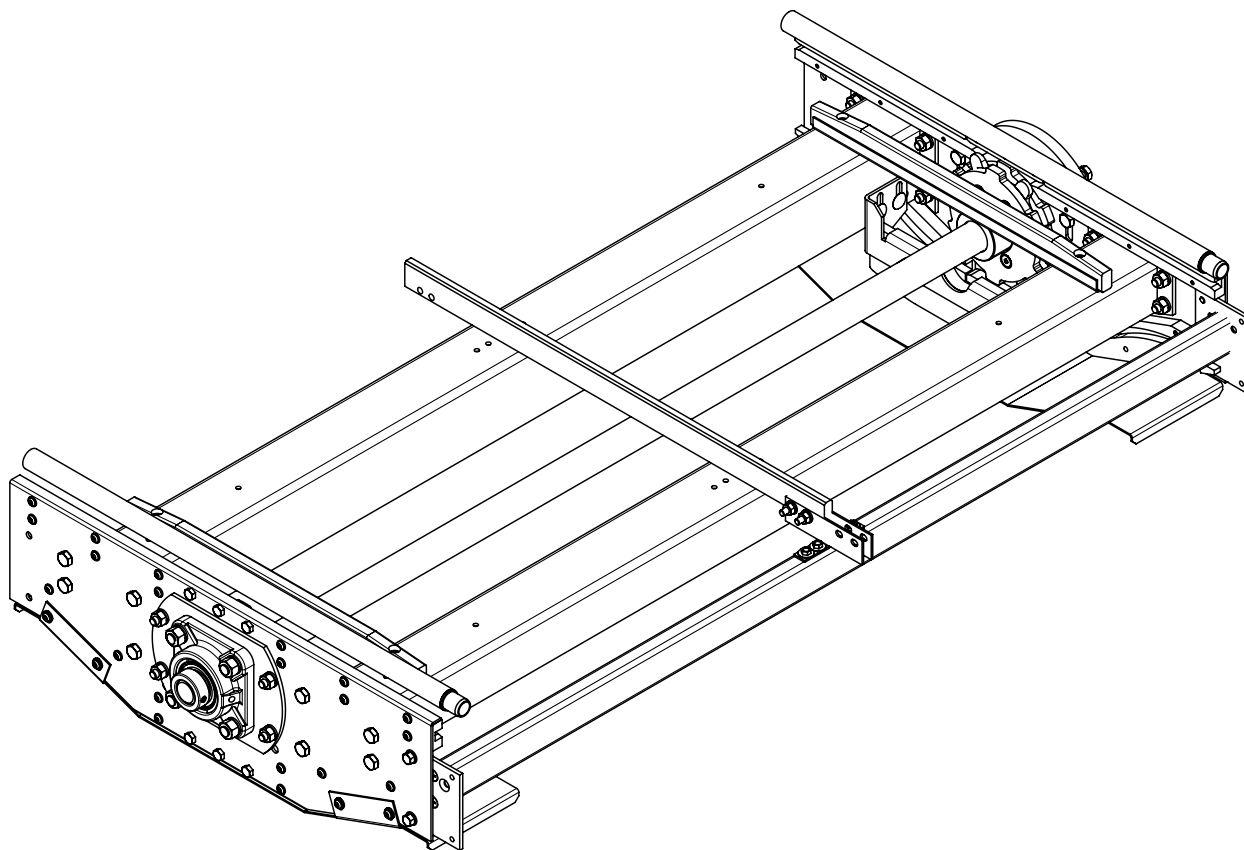
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 516 36 00		Lower Pressure Pad Support	1
2	185 516 37 00		Lower Pressure Pad Profile	1
3		21 28 089	M8 x 30 Carriage Bolt, Zinc	2
4		26 04 111	M8 Lock Washer, Zinc	2
5		25 15 106	M8 Hex Nut, Zinc	2



Lower Pressure Pad with Profile			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 500 23 04	Lower Pressure Pad with Profile
350			
500			
750			

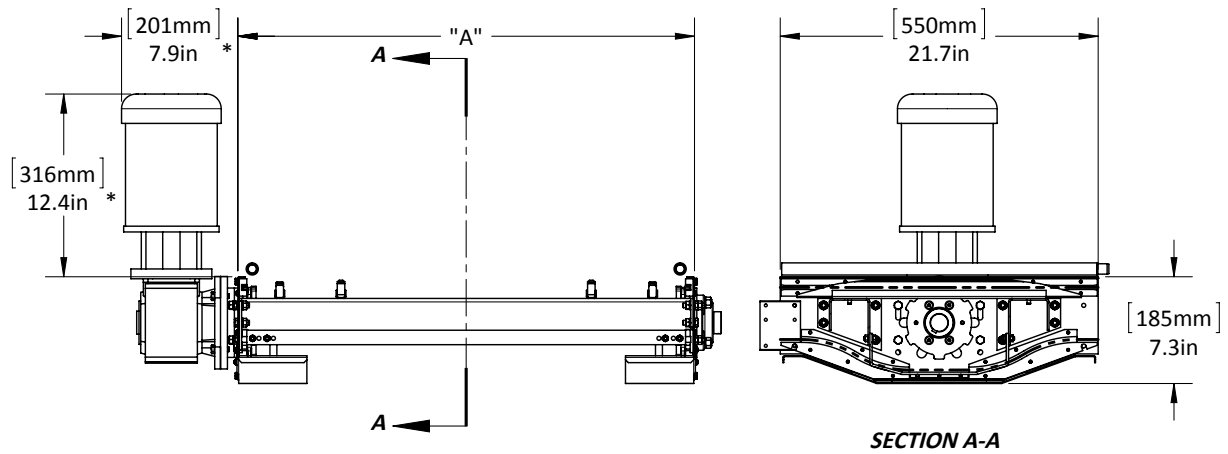


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**Intermediate Drive T1000**

Intermediate Drive			
Conveyor Type	Part Number	Drawing Number	Description
1000	5435	--	Intermediate Drive T1000

## Section 2



Intermediate Drive							
Part Number	Conveyor Type	Description	A (mm/inches)	H1** min/max (mm/inches)	H2*** min/max (mm/inches)	H3**** min/max (mm/inches)	Chain Length (m/ft)
5435	1000	Intermediate Drive T1000	1040/41.0	190 - 320 7.5 - 12.6	310 - 610 12.2 - 24.0	600 - 1300 23.6 - 51.2	1.1/3.7

\*S87.3 Stober Gearbox and G581 Marathon Motor shown, sold separately

\*\*Height of unit with Floor Support Short

\*\*\*Height of unit with Floor Support Middle

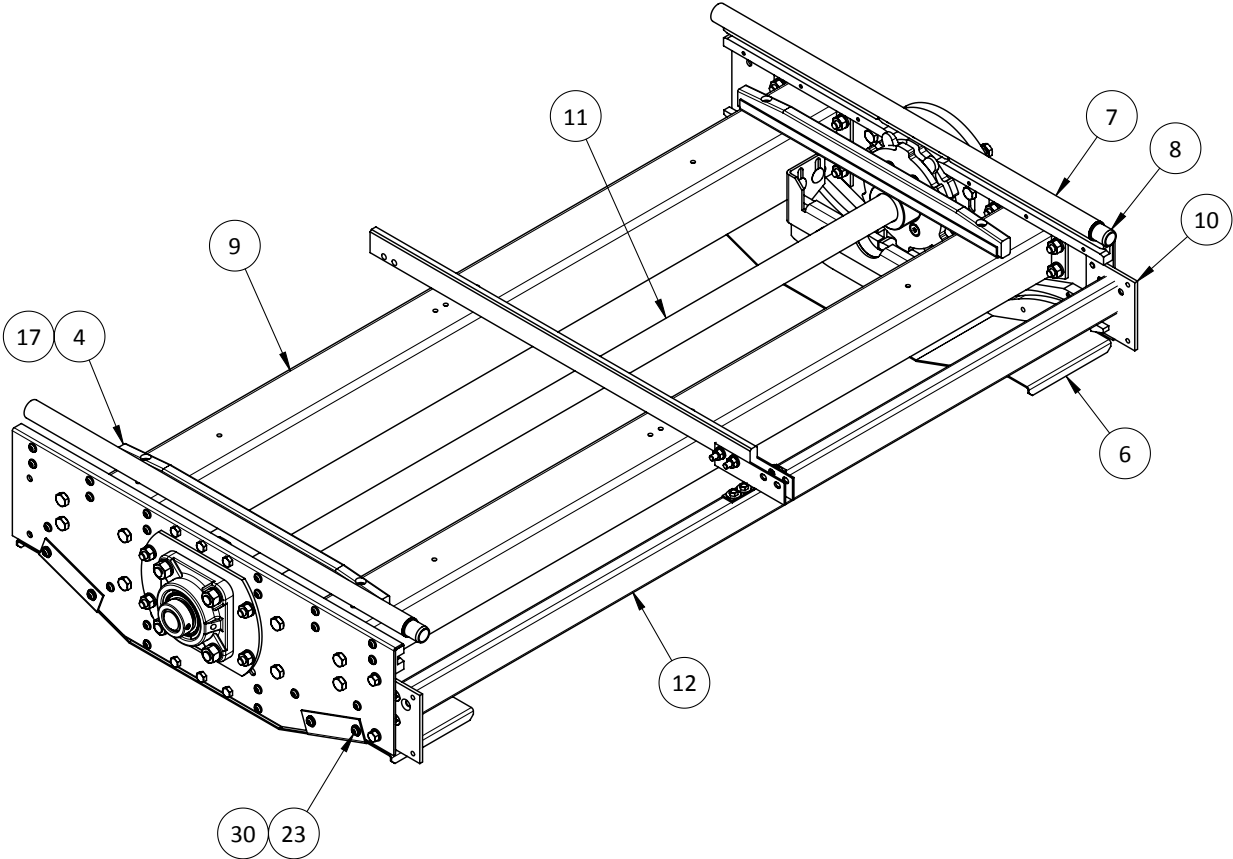
\*\*\*\*Height of unit with Floor Support Long

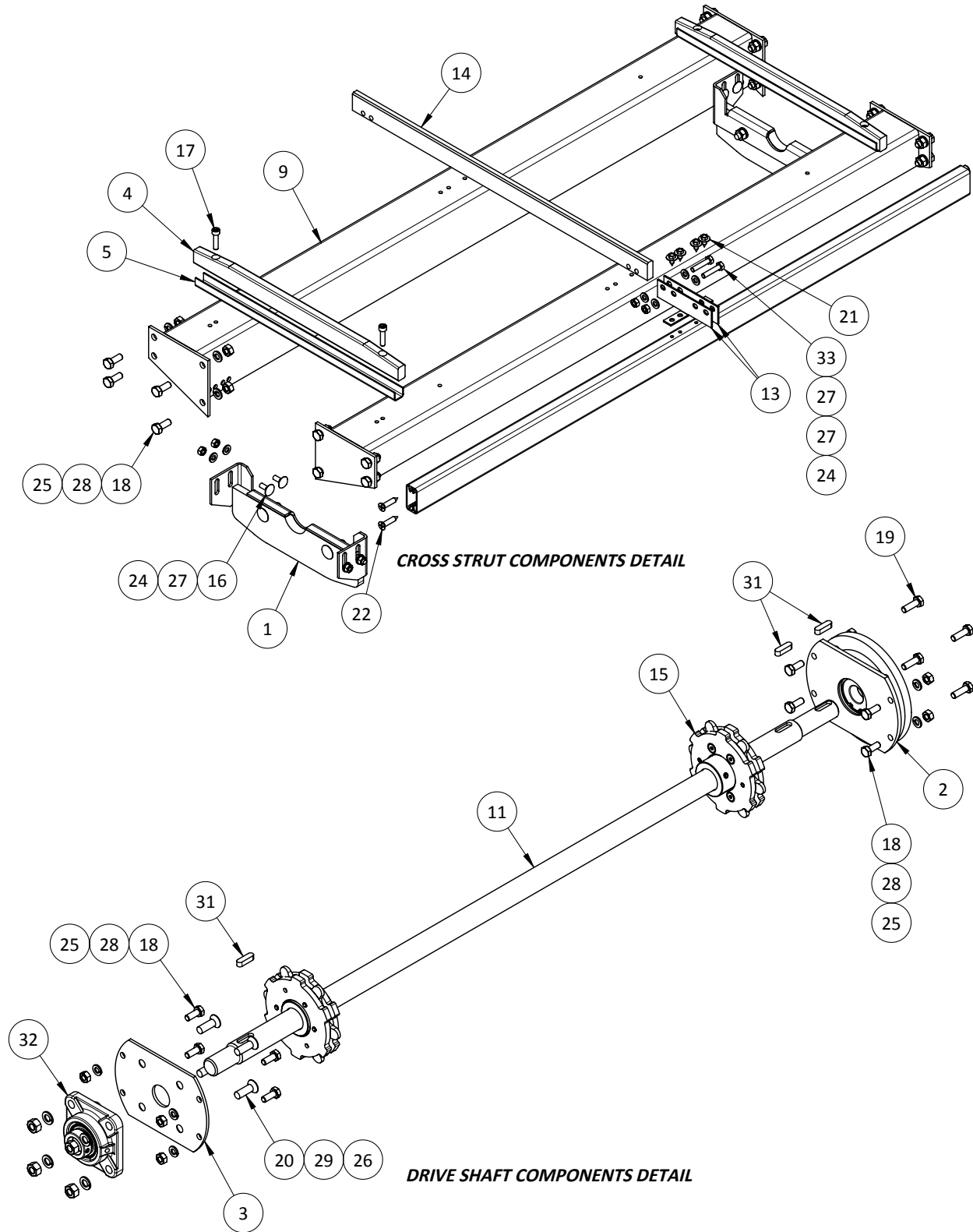
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	185 500 23 04		Lower Pressure Pad With Profile	2
2	185 500 55 02		Flange Complete Intermediate Drive	1
3	185 511 32 00		Flange Bearing Thread Plate	1
4	185 516 08 02		Outer Pressure Pad	2
5	185 516 08 04		Intermediate Drive U-Profile	2
6	185 519 15 00		Intermediate Drive Cover	2
7	185 520 17 00		Intermediate Drive Capping	2
8	185 520 18 00		Intermediate Coupling	2
9	191 500 24 00		Cross Strut T1000	2
10	191 511 03 04		Intermediate Drive Sidesheet Complete T1000	2
11	191 516 01 01		Drive Shaft T1000	1
12	191 524 05 08		Traverse Narrow T1000 (Thin Side Holes)	1
13	191 524 07 00		Connecting Angle	2
14	191 525 27 00		Center Profile Intermediate Drive T1000	1
15	705 001 03 00		Intermediate Drive Sprocket	2
16		21 28 068	M6 x 16 Carriage Bolt, Zinc	8
17		21 42 070	M6 x 25 SHCS, Zinc	4
18		21 56 087	M8 x 20 Hex Bolt, Zinc	24
19		21 56 088	M8 x 25 Hex Bolt, Zinc	4
20		21 63 109	M10 x 30 Countersunk Screw, Zinc	4
21		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	4
22		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	4
23		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	8
24		25 15 105	M6 Hex Nut, Zinc	10
25		25 15 106	M8 Hex Nut, Zinc	24
26		25 15 107	M10 Hex Nut, Zinc	4
27		26 02 109	M6 Flat Washer, Zinc	12
28		26 04 111	M8 Lock Washer, Zinc	24
29		26 04 112	M10 Lock Washer, Zinc	4
30		26 34 108	M5 Flat Washer, Zinc	8
31		27 43 070	8 x 7 x 28 Parallel Key	3
32		34 10 205	4-Bolt Flange Bearing 25mm	1
33		F8-7-46-2-171	M6 x 30 Hex Bolt, Zinc	2

# Section 2

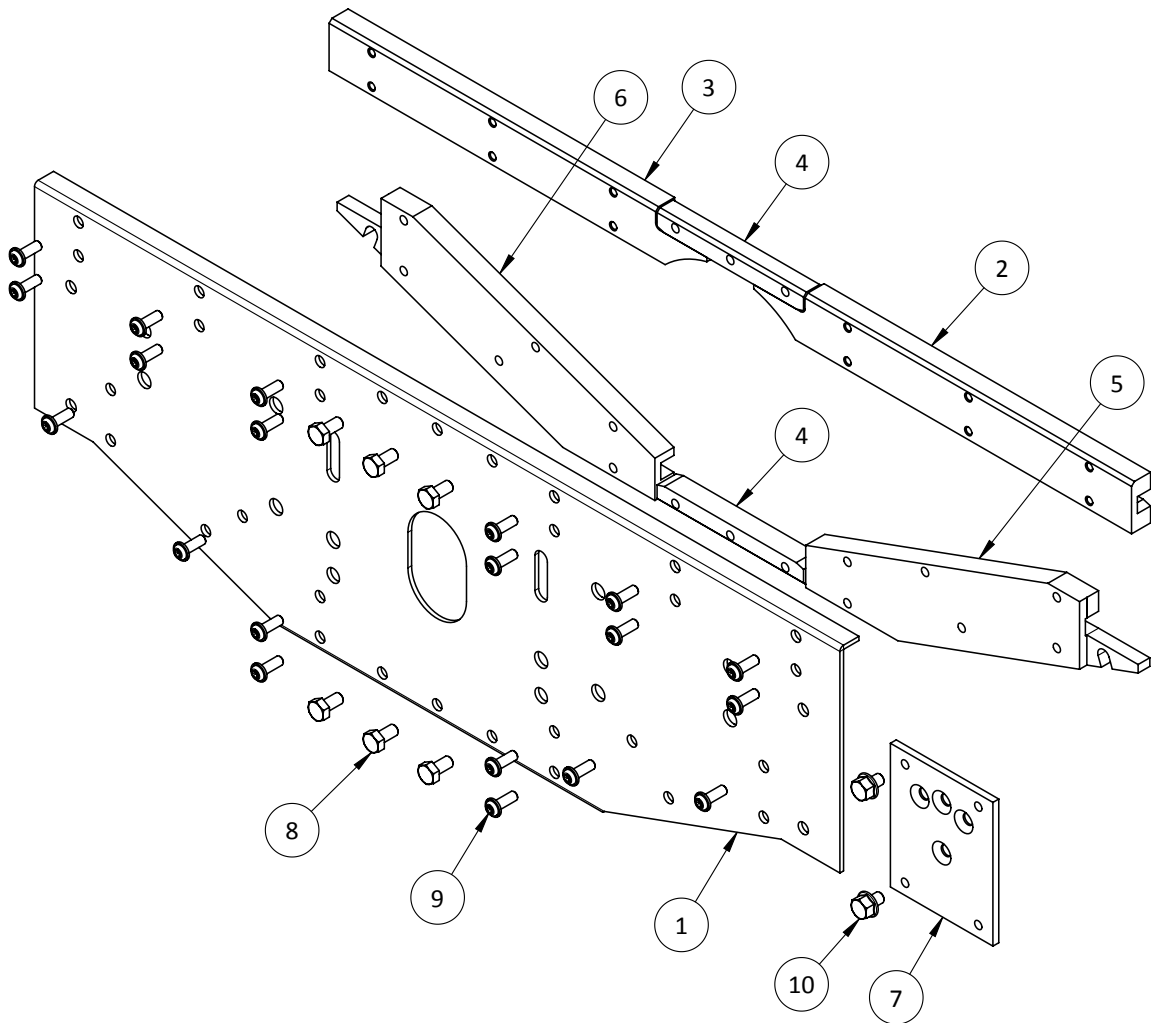
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## Section 2

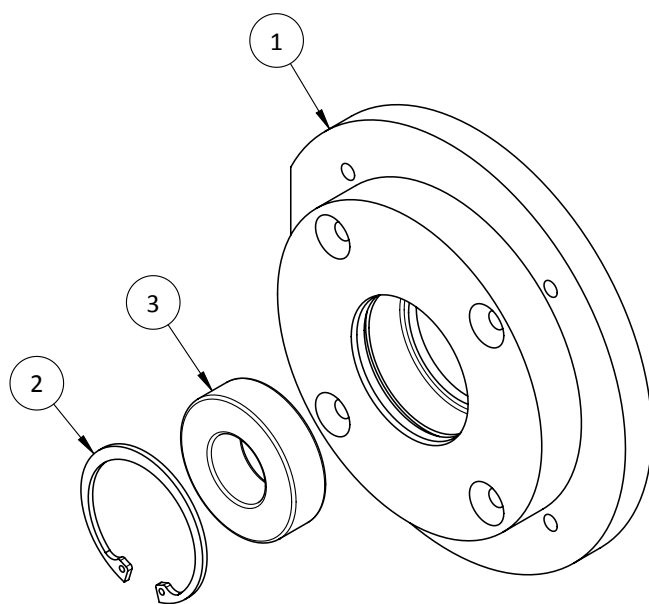
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 511 03 04		Intermediate Drive Sidesheet	1
2	185 516 04 10		Chain Guide, Upper LH	1
3	185 516 04 11		Chain Guide, Upper RH	1
4	185 516 05 01		Chain Slideway, Metal	2
5	185 516 07 08		Chain Slideway, LH	1
6	185 516 07 09		Chain Slideway, RH	1
7	191 525 06 00		Thread Plate T1000	1
8		21 56 067	M6 x 12 Hex Bolt, Zinc	6
9		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	20
10		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	2



Intermediate Drive Sidesheet Complete			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 511 03 04	Intermediate Drive Sidesheet Complete T1000

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 511 30 01*		Flange	1
2		26 36 075	Internal Retaining Ring 52x2	1
3		6205.2RSR	Bearing 25mm	1

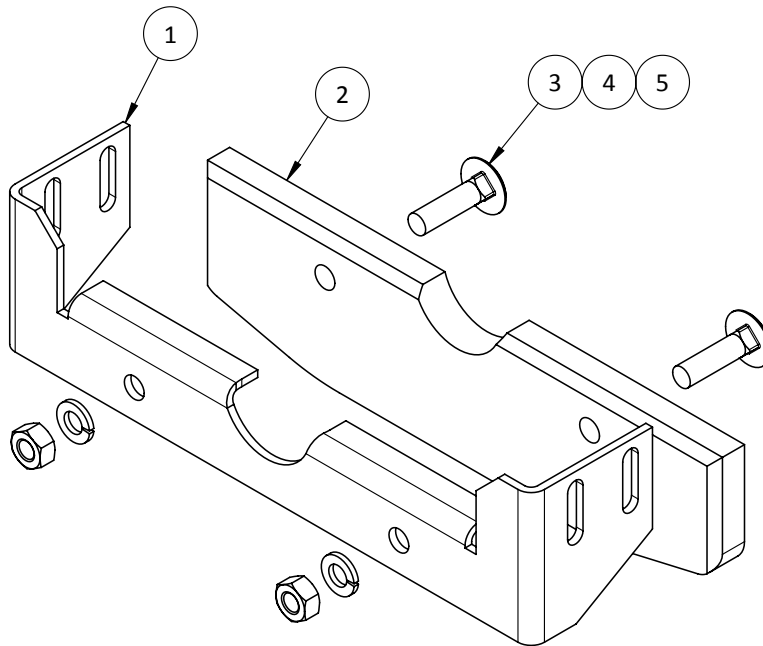
\*ITEM NOT AVAILABLE INDIVIDUALLY, IF NEEDED ORDER COMPLETE ASSEMBLY (SEE CHART BELOW)



Flange Complete Main Drive			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	185 500 55 01	Flange Complete Main Drive

## Section 2

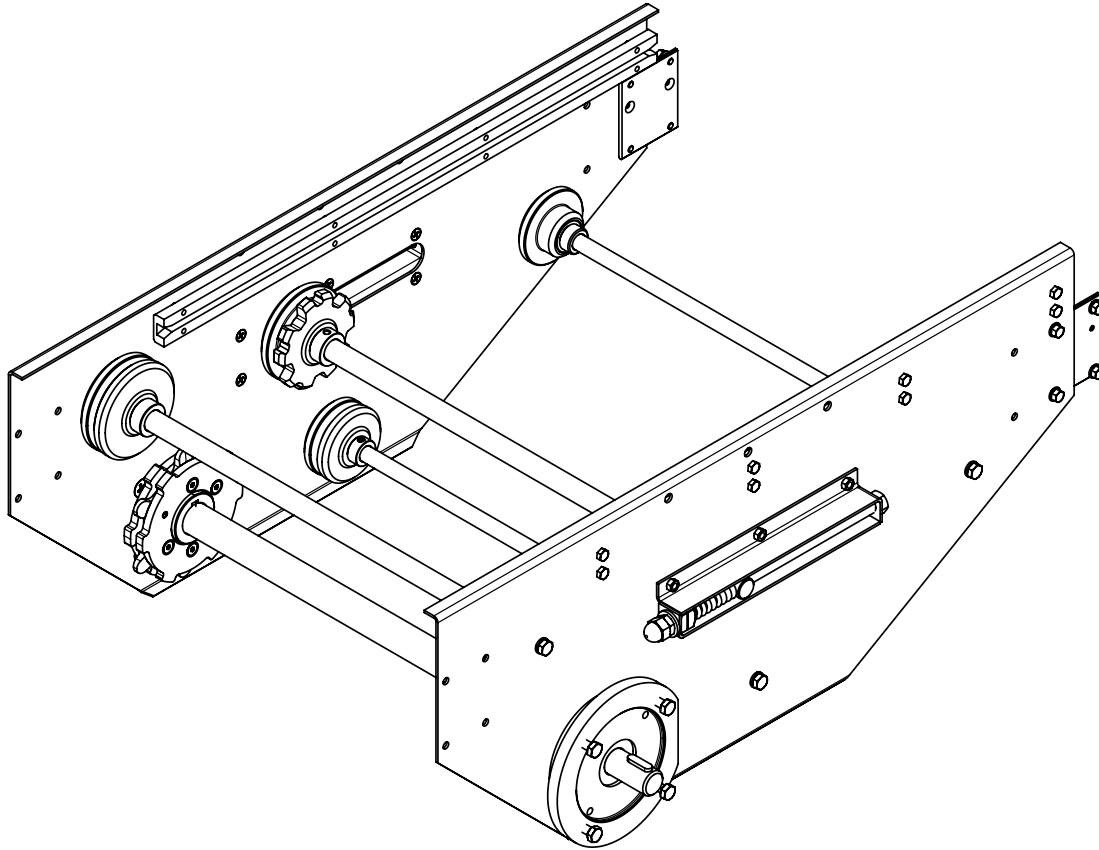
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 516 36 00		Lower Pressure Pad Support	1
2	185 516 37 00		Lower Pressure Pad Profile	1
3		21 28 089	M8 x 30 Carriage Bolt, Zinc	2
4		26 04 111	M8 Lock Washer, Zinc	2
5		25 15 106	M8 Hex Nut, Zinc	2



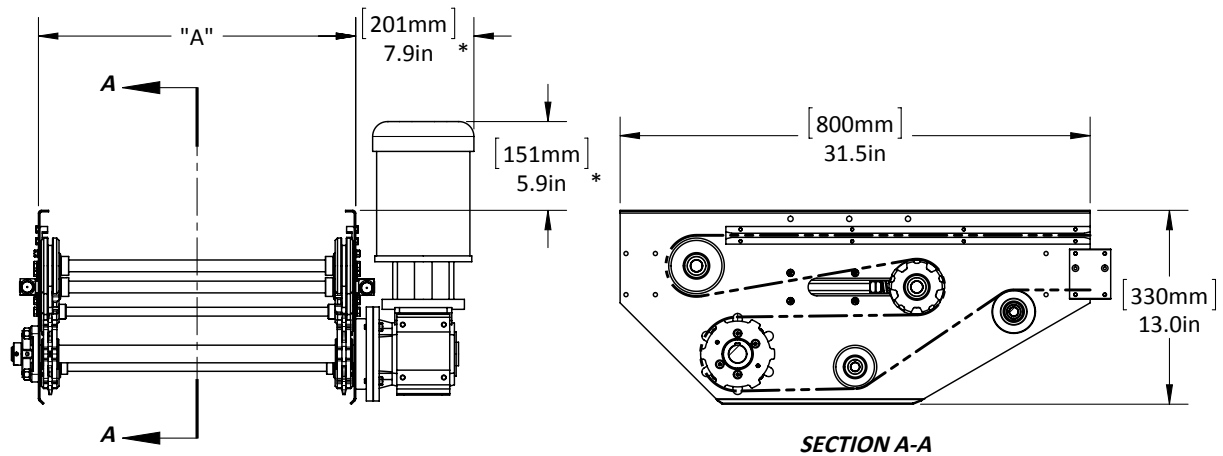
Lower Pressure Pad with Profile			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	185 500 23 04	Lower Pressure Pad with Profile



### End Drive T350 - T750



End Drive			
Conveyor Type	Part Number	Drawing Number	Description
250	--	--	--
350	4842	--	End Drive T350
500	4803	--	End Drive T500
750	4872	--	End Drive T750



End Drive							
Part Number	Conveyor Type	Description	A (mm/inches)	H1** min/max (mm/inches)	H2*** min/max (mm/inches)	H3**** min/max (mm/inches)	Chain Length (m/ft)
4842	350	End Drive T350	390/15.4	190 - 320 7.5 - 12.6	310 - 610 12.2 - 24.0	600 - 1300 23.6 - 51.2	2.5/8.3
4803	500	End Drive T500	540/21.3				
4872	750	End Drive T750	790/31.1				

\*S87.3 Stober Gearbox and G581 Marathon Motor shown, sold separately

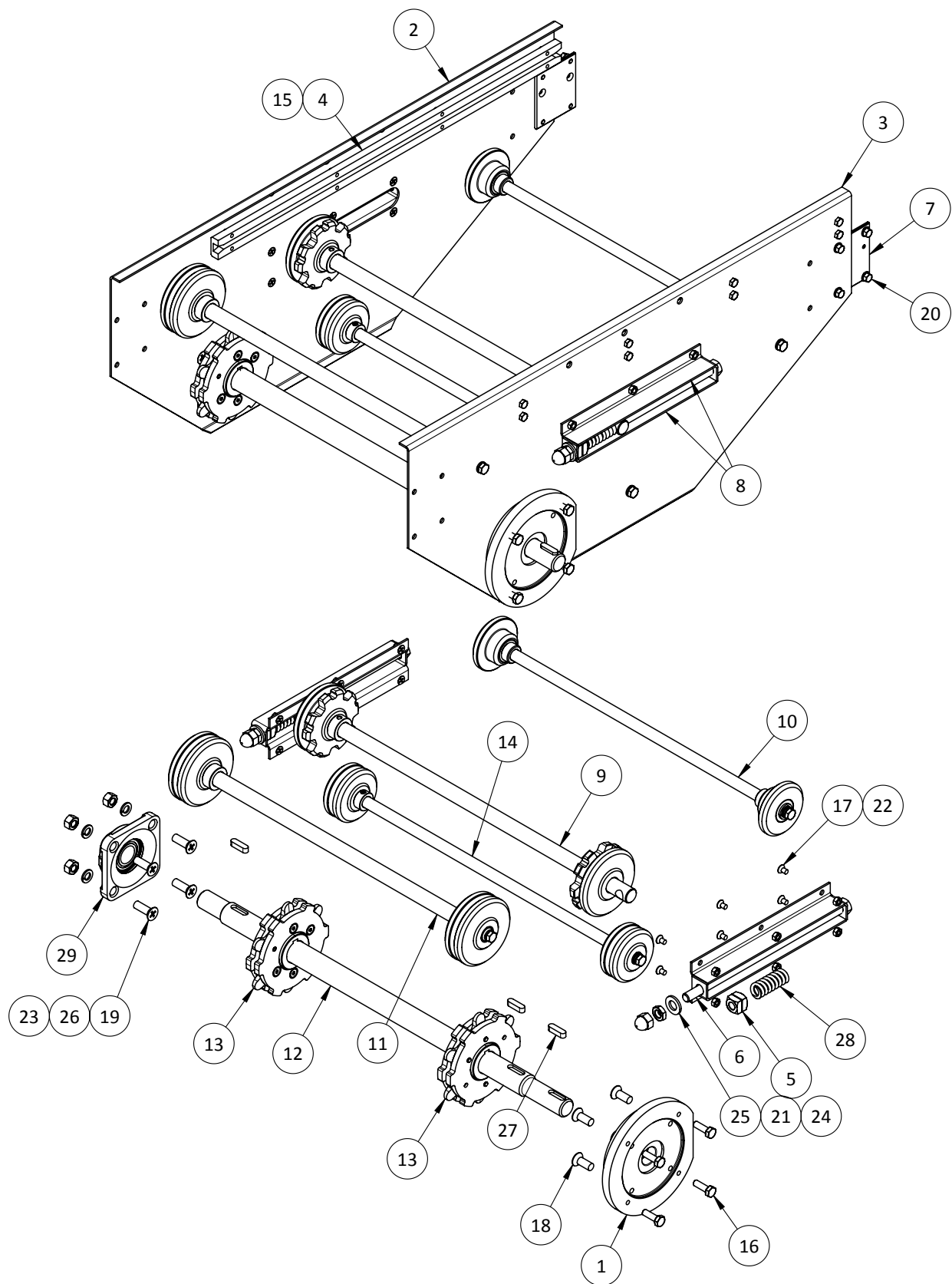
\*\*Height of unit with Floor Support Short

\*\*\*Height of unit with Floor Support Middle

\*\*\*\*Height of unit with Floor Support Long

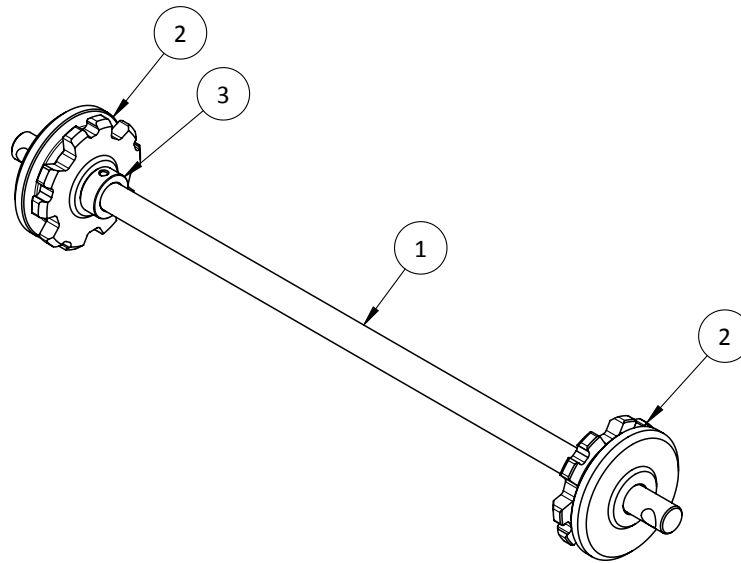
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T350	T500	T750
1	185 500 55 01		Flange Complete Main Drive	1	1	1
2	185 511 02 00		End Drive Sidesheet, LH	1	1	1
3	185 511 02 01		End Drive Sidesheet, RH	1	1	1
4	185 511 22 00		Sliding Profile	2	2	2
5	185 515 07 00		Pressure Piece	2	2	2
6	185 515 10 02		Screw Spindle End Drive	2	2	2
7	185 525 06 00		Thread Plate	2	2	2
8	185 530 11 01		End Drive Take-up Frame	4	4	4
9	187 500 31 02		Tension Axle Complete T350	1	-	-
9	185 500 31 02		Tension Axle Complete T500	-	1	-
9	188 500 31 02		Tension Axle Complete T750	-	-	1
10	187 500 40 01		Steel Deflection Wheel 15mm Axle Complete T350	1	-	-
10	185 500 40 01		Steel Deflection Wheel 15mm Axle Complete T500	-	1	-
10	188 500 40 01		Steel Deflection Wheel 15mm Axle Complete T750	-	-	1
11	187 500 43 02		Smooth Deflection Wheel 20mm Axle Complete T350	1	-	-
11	185 500 43 02		Smooth Deflection Wheel 20mm Axle Complete T500	-	1	-
11	188 500 43 02		Smooth Deflection Wheel 20mm Axle Complete T750	-	-	1
12	187 516 01 01		Drive Shaft T350	1	-	-
12	185 516 01 01		Drive Shaft T500	-	1	-
12	188 516 01 01		Drive Shaft T750	-	-	1
13	705 001 02 00		Main Drive Sprocket	2	2	2
14	706 011 01 00		Smooth Deflection Wheel 15mm Axle Complete T350	1	-	-
14	707 011 01 00		Smooth Deflection Wheel 15mm Axle Complete T500	-	1	-
14	708 011 01 00		Smooth Deflection Wheel 15mm Axle Complete T750	-	-	1
15		21 56 067	M6 x 12 Hex Bolt, Zinc	16	16	16
16		21 56 088	M8 x 25 Hex Bolt, Zinc	4	4	4
17		21 63 066	M6 x 10 Countersunk Screw, Zinc	12	12	12
18		21 63 108	M10 x 25 Countersunk Screw, Zinc	4	4	4
19		21 63 109	M10 x 30 Countersunk Screw, Zinc	4	4	4
20		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8
21		25 03 108	M12 Jam Nut, Zinc	2	2	2
22		25 15 105	M6 Hex Nut, Zinc	12	12	12
23		25 15 107	M10 Hex Nut, Zinc	4	4	4
24		25 24 108	M12 Cap Nut, Zinc	2	2	2
25		26 02 113	M12 Flat Washer, Zinc	2	2	2
26		26 04 112	M10 Lock Washer, Zinc	4	4	4
27		27 43 070	8 x 7 x 28 Parallel Key	3	3	3
28		32 02 639	Pressure Spring	2	2	2
29		34 10 205	4-Bolt Flange Bearing 25mm	1	1	1



## Section 2

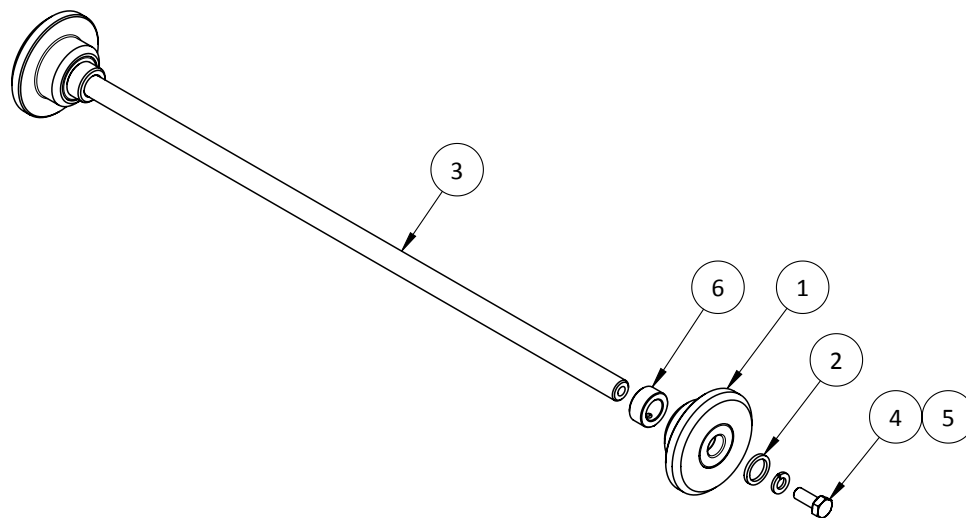
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	186 515 11 02		Tension Axle T250	1	-	-	-
1	187 515 11 02		Tension Axle T350	-	1	-	-
1	185 515 11 02		Tension Axle T500	-	-	1	-
1	188 515 11 02		Tension Axle T750	-	-	-	1
2	185 515 21 00		Deflection Wheel Grooved 94.7mm	2	2	2	2
3		26 43 064	Adjusting Ring A20-705	2	2	2	2



Tension Axle Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 31 02	Tension Axle Complete T250
350	--	187 500 31 02	Tension Axle Complete T350
500	--	185 500 31 02	Tension Axle Complete T500
750	--	188 500 31 02	Tension Axle Complete T750

## Section 2

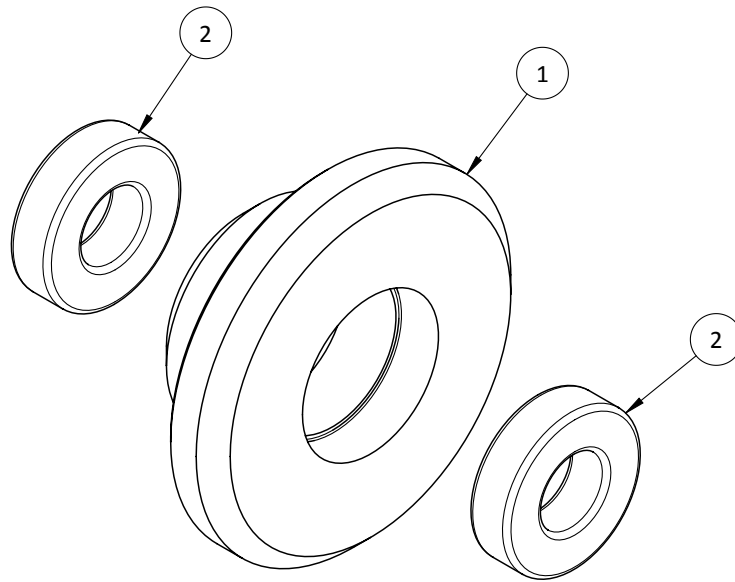
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 100 23 00		Deflection Wheel Steel Complete	2	2	2	2
2	185 511 23 00		Distance Piece	2	2	2	2
3	186 521 08 01		15mm Axle T250	1	-	-	-
3	187 521 08 01		15mm Axle T350	-	1	-	-
3	185 521 08 01		15mm Axle T500	-	-	1	-
3	188 521 08 01		15mm Axle T750	-	-	-	1
4		21 56 087	M8 x 20 Hex Bolt, Zinc	2	2	2	2
5		26 04 111	M8 Lock Washer, Zinc	2	2	2	2
6		26 43 061	Adjusting Ring A15-705	2	2	2	2



Steel Deflection Wheel 15mm Axle Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 40 01	Steel Deflection Wheel 15mm Axle Complete T250
350	--	187 500 40 01	Steel Deflection Wheel 15mm Axle Complete T350
500	--	185 500 40 01	Steel Deflection Wheel 15mm Axle Complete T500
750	--	188 500 40 01	Steel Deflection Wheel 15mm Axle Complete T750

## Section 2

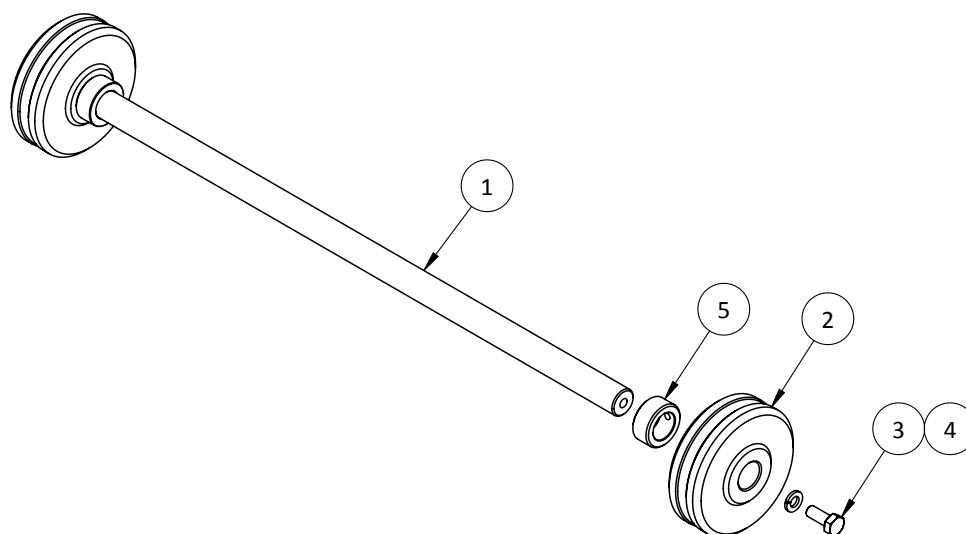
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 525 03 01		Deflection Wheel Steel	1
2		6002.2RSR	Bearing 15mm	2



Steel Deflection Wheel Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 100 23 00	Steel Deflection Wheel Complete
350			
500			
750			

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	186 515 04 02		20mm Axle T250	1	-	-	-
1	187 515 04 02		20mm Axle T350	-	1	-	-
1	185 515 04 02		20mm Axle T500	-	-	1	-
1	188 515 04 02		20mm Axle T750	-	-	-	1
2	185 515 22 00		Deflection Wheel Smooth 94.7mm	2	2	2	2
3		21 56 087	M8 x 20 Hex Bolt, Zinc	2	2	2	2
4		26 04 111	M8 Lock Washer, Zinc	2	2	2	2
5		26 43 064	Adjusting Ring A20-705	2	2	2	2

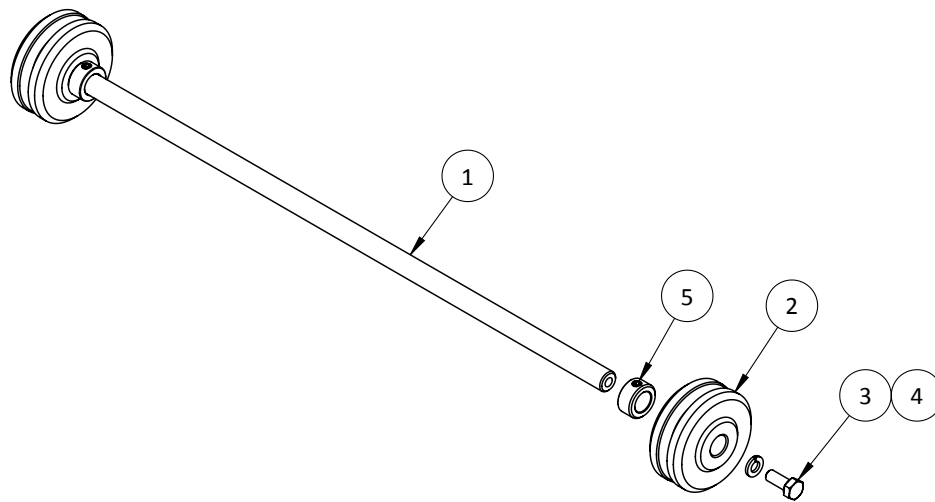


Smooth Deflection Wheel 20mm Axle Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 40 01	Smooth Deflection Wheel 20mm Axle Complete T250
350	--	187 500 40 01	Smooth Deflection Wheel 20mm Axle Complete T350
500	--	185 500 43 02	Smooth Deflection Wheel 20mm Axle Complete T500
750	--	188 500 40 01	Smooth Deflection Wheel 20mm Axle Complete T750



## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	186 521 08 01		15mm Axle T250	1	-	-	-
1	187 521 08 01		15mm Axle T350	-	1	-	-
1	185 521 08 01		15mm Axle T500	-	-	1	-
1	188 521 08 01		15mm Axle T750	-	-	-	1
2	185 525 17 00		Deflection Wheel Smooth 73.7mm	2	2	2	2
3		21 56 087	M8 x 20 Hex Bolt, Zinc	2	2	2	2
4		26 04 111	M8 Lock Washer, Zinc	2	2	2	2
5		26 43 061	Adjusting Ring A15-705	2	2	2	2

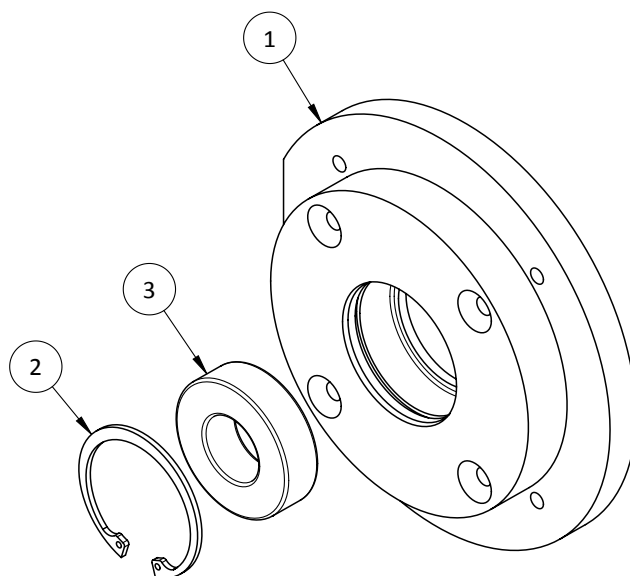


Smooth Deflection Wheel 15mm Axle Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	705 011 01 00	Smooth Deflection Wheel 15mm Axle Complete T250
350	--	706 011 01 00	Smooth Deflection Wheel 15mm Axle Complete T350
500	--	707 011 01 00	Smooth Deflection Wheel 15mm Axle Complete T500
750	--	708 011 01 00	Smooth Deflection Wheel 15mm Axle Complete T750

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 511 30 01*		Flange	1
2		26 36 075	Internal Retaining Ring 52x2	1
3		6205.2RSR	Bearing 25mm	1

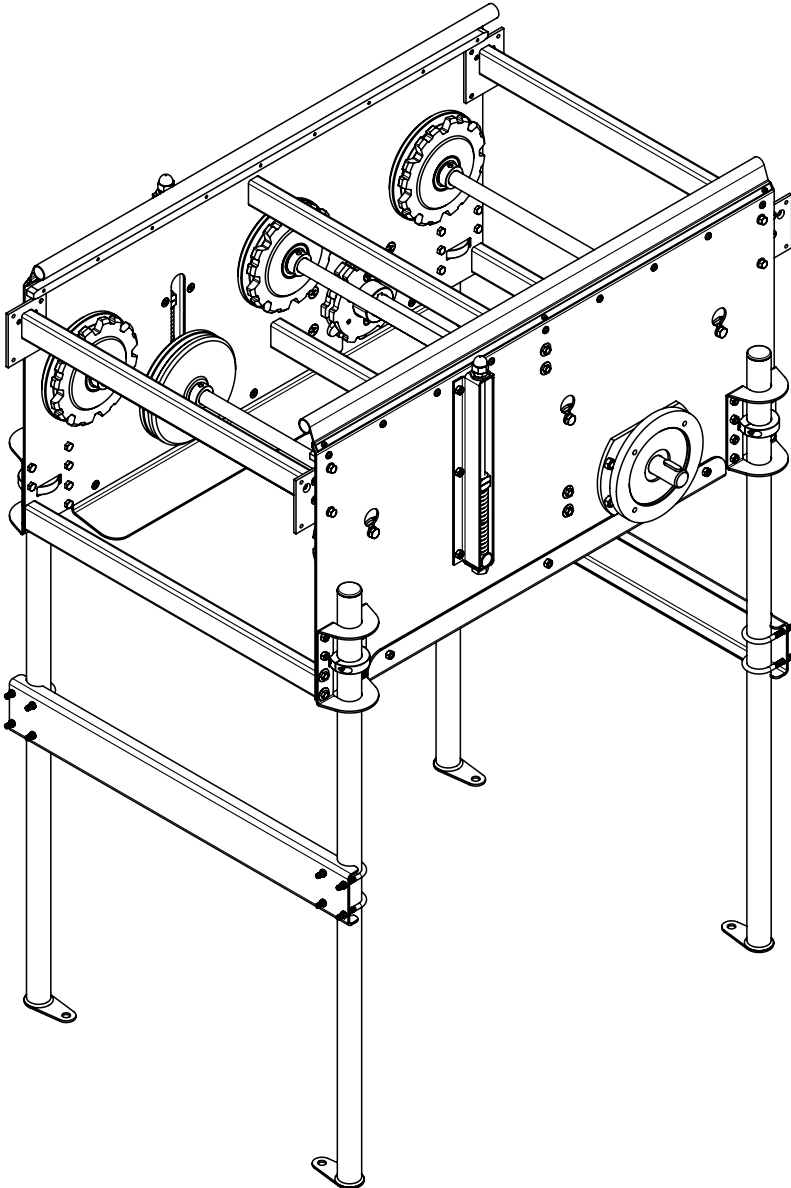
\*ITEM NOT AVAILABLE INDIVIDUALLY, IF NEEDED ORDER COMPLETE ASSEMBLY (SEE CHART BELOW)



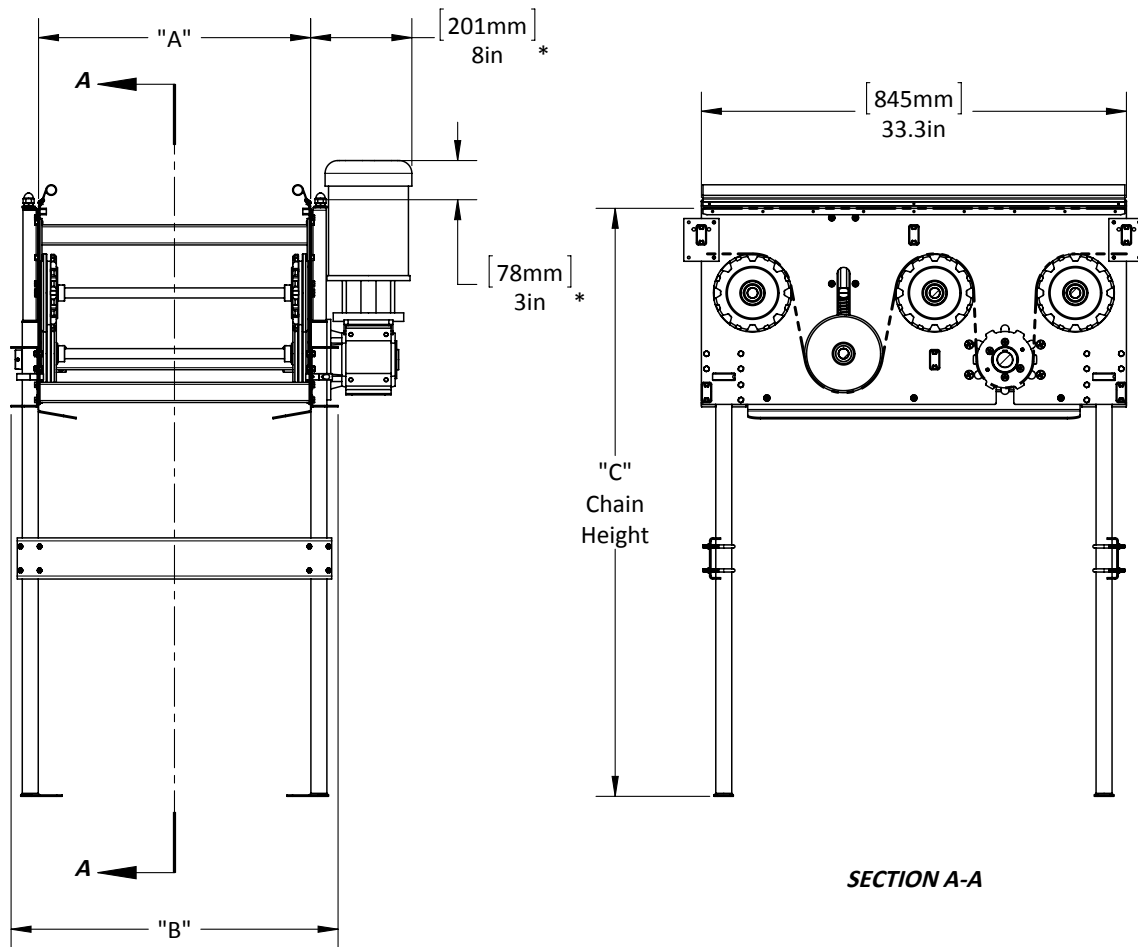
Flange Complete Main Drive			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 500 55 01	Flange Complete Main Drive
350	--		
500	--		
750	--		

# Section 2

## Cantilever Drive T250 - T750



Cantilever Drive			
Conveyor Type	Part Number	Drawing Number	Description
250	C104A	12C B 400 00A	Cantilever Drive T250 US
350	D104A	12C B 300 00A	Cantilever Drive T350 US
500	E104A	12C B 200 00A	Cantilever Drive T500 US
750	F104A	12C B 100 00A	Cantilever Drive T750 US



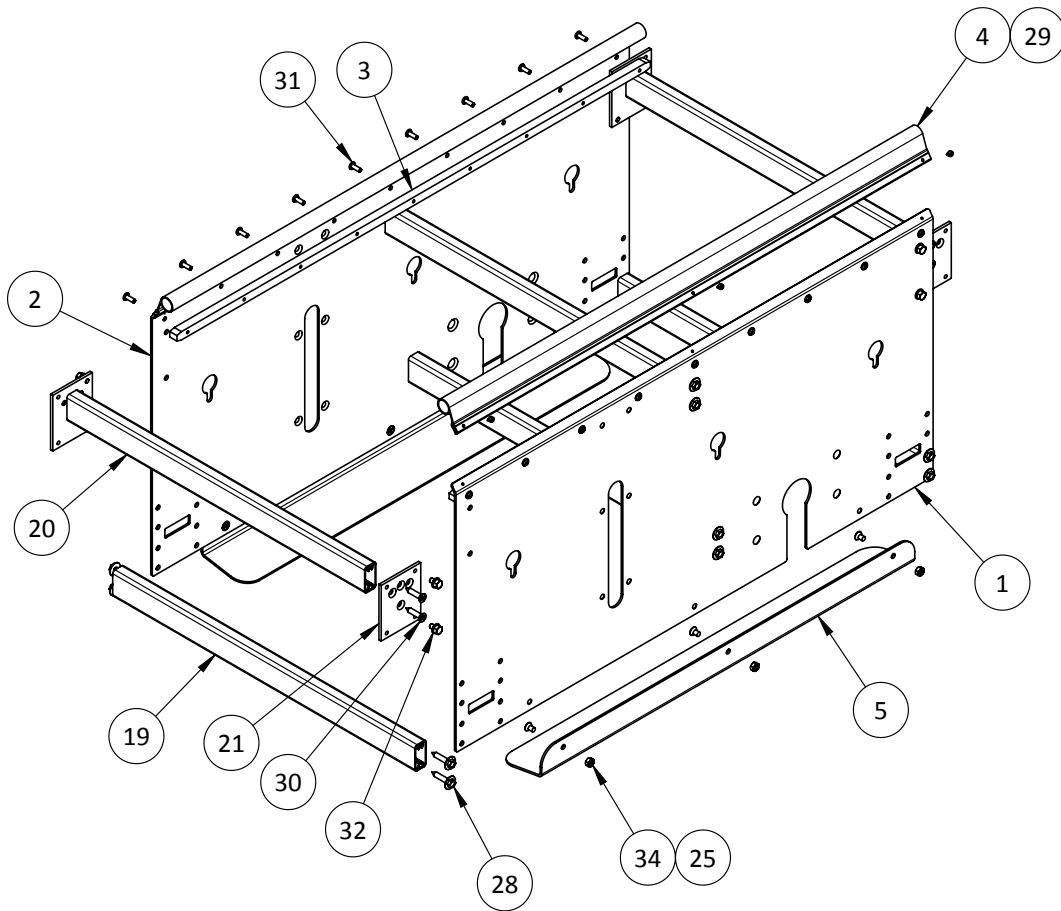
**SECTION A-A**

Cantilever Drive US							
Part Number	Conveyor Type	Description	A (mm/inches)	B (mm/inches)	C min (mm/inches)	C max (mm/inches)	Chain Length (m/ft)
C104A	250	Cantilever Drive T250 US	290/11.4	400/15.7	436/17.2	1235/48.6	2.5/8.1
D104A	350	Cantilever Drive T350 US	390/15.4	500/19.7			
E104A	500	Cantilever Drive T500 US	540/21.3	650/25.6			
F104A	750	Cantilever Drive T750 US	790/31.1	900/35.4			

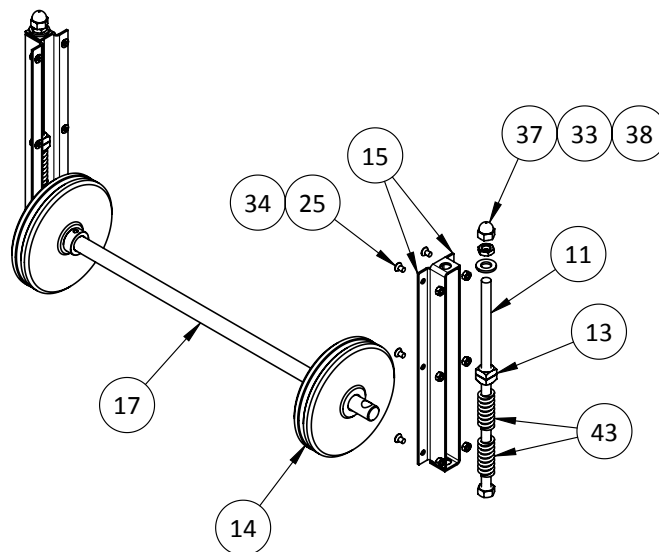
\*S87.3 Stober Gearbox and G581 Marathon Motor shown, sold separately

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	12C B 000 01A		Cantilever Drive Sidesheet RH	1	1	1	1
2	12C B 000 02A		Cantilever Drive Sidesheet LH	1	1	1	1
3	12C B 000 03A		Chain Slideway Top	2	2	2	2
4	12C B 000 05A		Red Capping, Cantilever Drive	2	2	2	2
5	12C B 000 06A		Filler Angle	2	2	2	2
6	12C B 000 07B		Floor Support Channel	4	4	4	4
7	12C B 000 08A		Floor Support Weldment	4	4	4	4
8	12C B 010 00A		Deflection Wheel Complete	6	6	6	6
9	12C B 024 00A		Cross Channel Complete T250	2	-	-	-
9	12C B 023 00A		Cross Channel Complete T350	-	2	-	-
9	12C B 022 00A		Cross Channel Complete T500	-	-	2	-
9	12C B 021 00A		Cross Channel Complete T750	-	-	-	2
10	185 500 55 02		Flange Complete Intermediate Drive	1	1	1	1
11	185 500 77 01		Screw Spindle Bolt-In Tensioner	2	2	2	2
12	185 511 32 00		Flange Bearing Thread Plate	1	1	1	1
13	185 515 07 00		Pressure Piece	2	2	2	2
14	185 515 22 01		Deflection Wheel Smooth 155mm	2	2	2	2
15	185 530 11 02		Tensioner Take-Up Frame	4	4	4	4
16	186 515 04 02		20mm Axle T250	3	-	-	-
16	187 515 04 02		20mm Axle T350	-	3	-	-
16	185 515 04 02		20mm Axle T500	-	-	3	-
16	188 515 04 02		20mm Axle T750	-	-	-	3
17	186 515 11 02		Tension Axle T250	1	-	-	-
17	187 515 11 02		Tension Axle T350	-	1	-	-
17	185 515 11 02		Tension Axle T500	-	-	1	-
17	188 515 11 02		Tension Axle T750	-	-	-	1
18	186 516 01 01		Drive Shaft T250	1	-	-	-
18	187 516 01 01		Drive Shaft T350	-	1	-	-
18	185 516 01 01		Drive Shaft T500	-	-	1	-
18	188 516 01 01		Drive Shaft T750	-	-	-	1
19	186 524 05 00		Traverse T250	4	-	-	-
19	187 524 05 00		Traverse T350	-	4	-	-
19	185 524 05 00		Traverse T500	-	-	4	-
19	188 524 05 00		Traverse T750	-	-	-	4
20	186 524 05 05		Traverse Narrow T250	2	-	-	-
20	187 524 05 05		Traverse Narrow T350	-	2	-	-
20	185 524 05 05		Traverse Narrow T500	-	-	2	-
20	188 524 05 05		Traverse Narrow T750	-	-	-	2
21	191 525 06 00		Thread Plate	4	4	4	4
22	705 001 03 00		Intermediate Drive Sprocket	2	2	2	2
23		21 56 067	M6 x 12 Hex Bolt, Zinc	24	24	24	24
24		21 56 087	M8 x 20 Hex Bolt, Zinc	6	6	6	6
25		21 63 066	M6 x 10 Countersunk Screw, Zinc	18	18	18	18
26		21 63 086	M8 x 16 Countersunk Screw, Zinc	8	8	8	8
27		21 63 109	M10 x 30 Countersunk Screw, Zinc	4	4	4	4
28		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	16	16	16	16
29		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	6	6	6	6
30		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	8	8	8	8
31		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	18	18	18	18
32		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8	8
33		25 03 108	M12 Jam Nut, Zinc	2	2	2	2
34		25 15 105	M6 Hex Nut, Zinc	42	42	42	42
35		25 15 106	M8 Hex Nut, Zinc	8	8	8	8
36		25 15 107	M10 Hex Nut, Zinc	4	4	4	4
37		25 24 108	M12 Cap Nut, Zinc	2	2	2	2
38		26 02 113	M12 Flat Washer, Zinc	2	2	2	2
39		26 04 111	M8 Lock Washer, Zinc	6	6	6	6
40		26 04 112	M10 Lock Washer, Zinc	4	4	4	4
41		26 43 064	Adjusting Ring A20-705	8	8	8	8
42		27 43 070	8 x 7 x 28 Parallel Key	3	3	3	3
43		32 02 639	Pressure Spring	4	4	4	4
44		34 10 205	4-Bolt Flange Bearing 25mm	1	1	1	1
45		6435K21	Shaft Collar, 1-1/4"	4	4	4	4
46		9283K15	Tubing Plug, 1-1/4"	4	4	4	4
47		FWS-D30-V20.5-T7.5	Washer	6	6	6	6



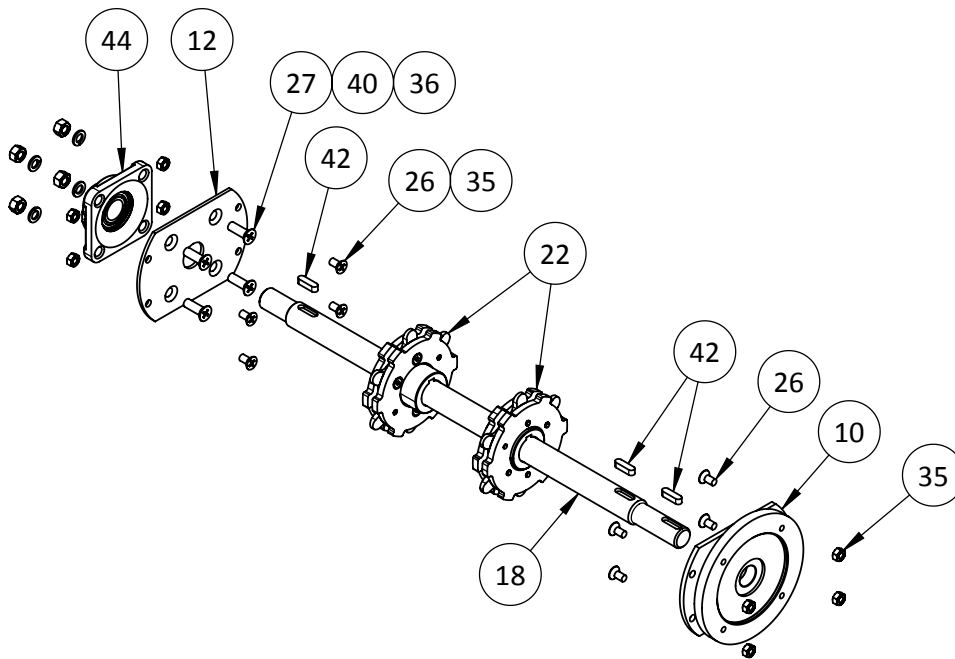
**SIDESHEET COMPONENTS DETAIL**



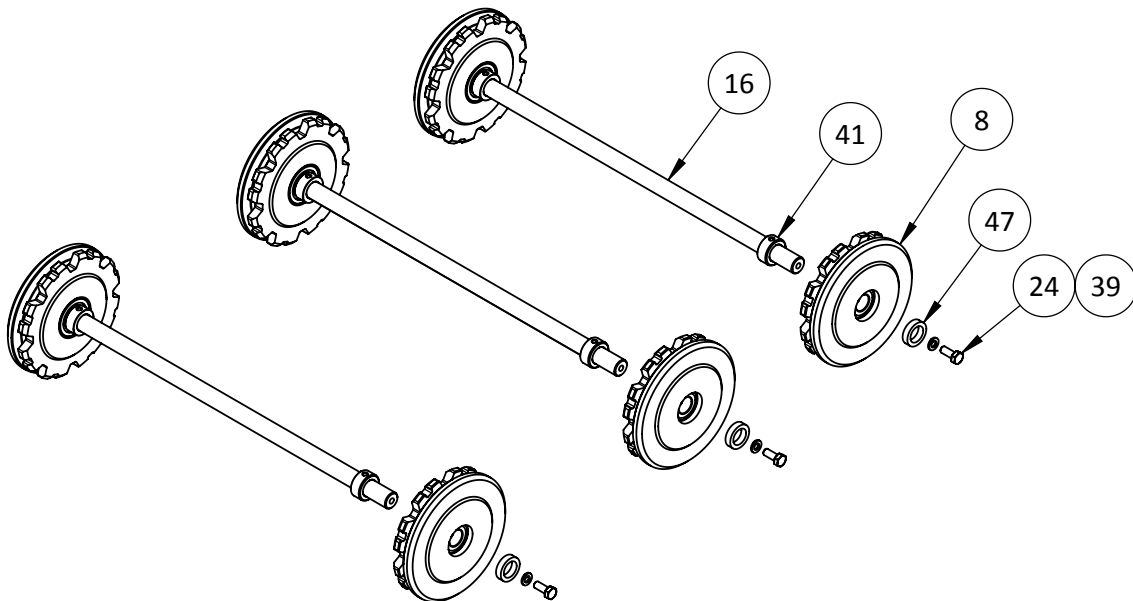
**TENSIONER COMPONENTS DETAIL**

## Section 2

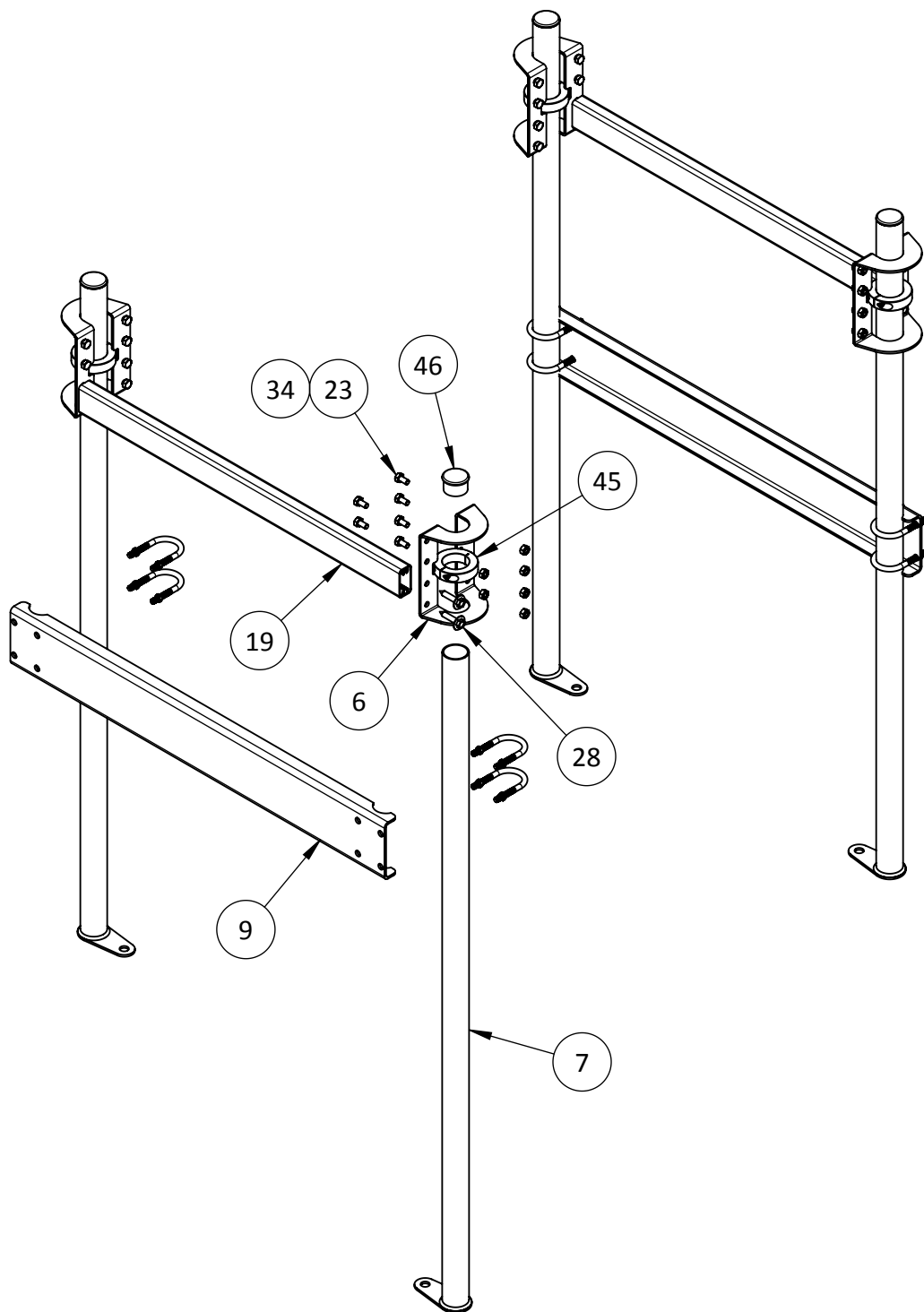
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**DRIVE SHAFT COMPONENTS DETAIL**

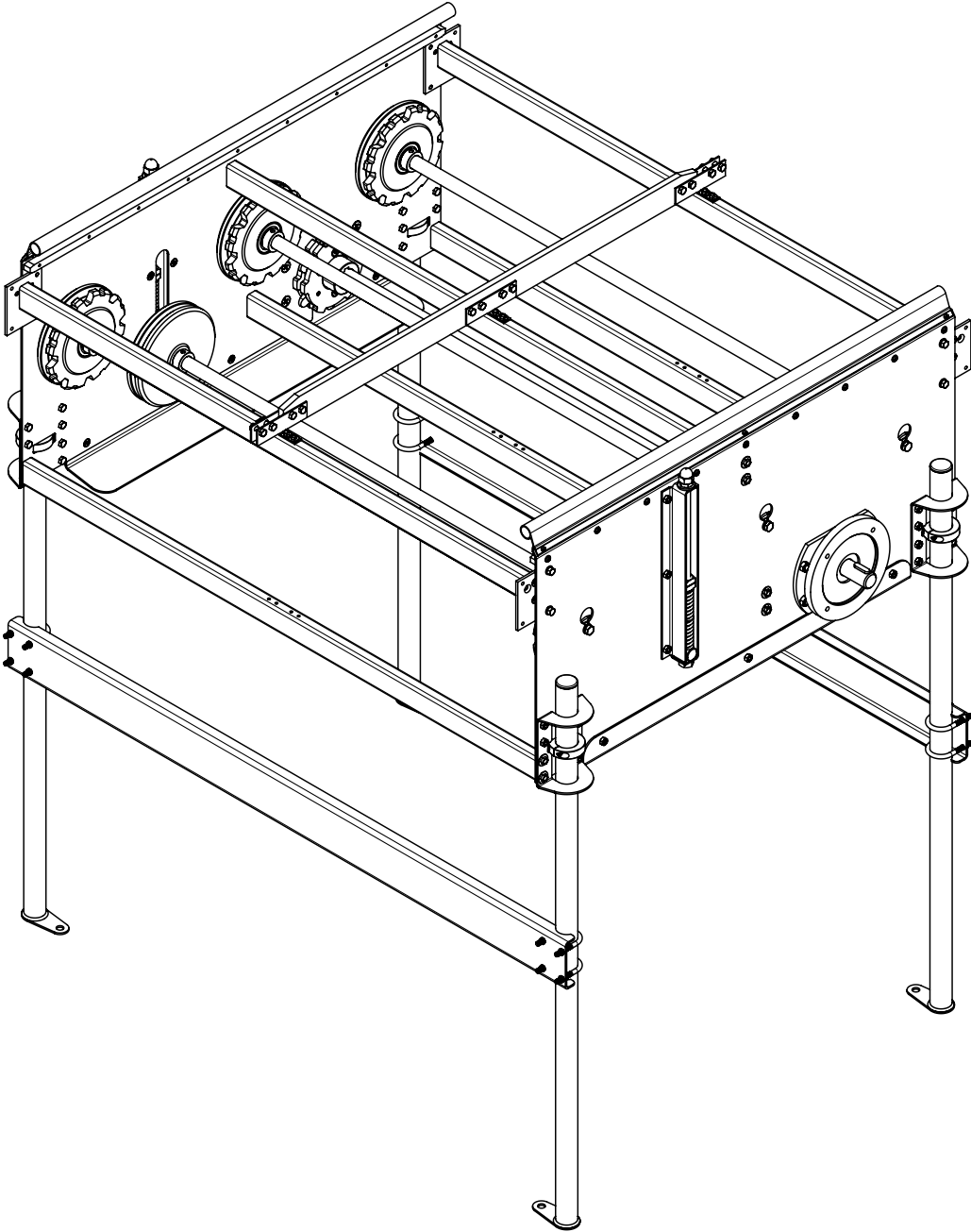


**IDLE AXLE COMPONENTS DETAIL**

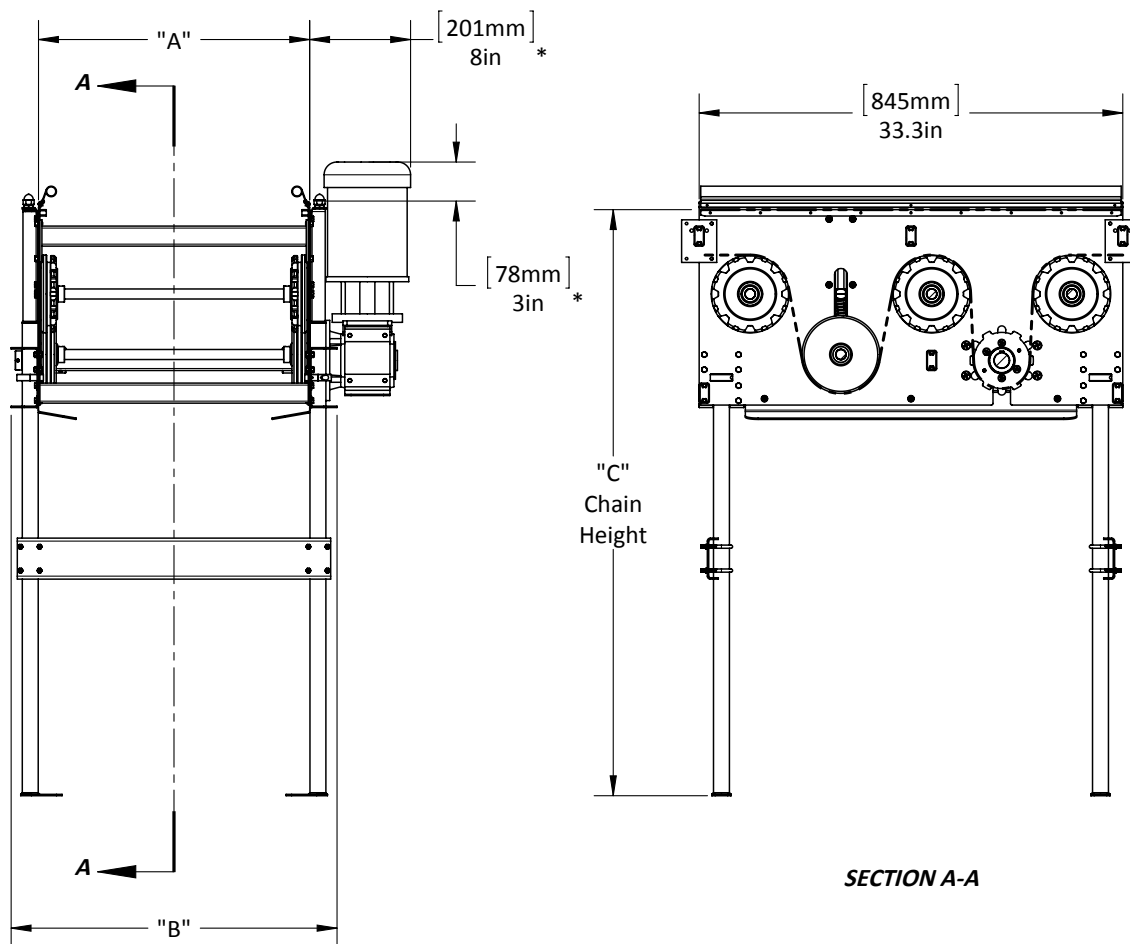




Cantilever Drive T1000



Cantilever Drive			
Conveyor Type	Part Number	Drawing Number	Description
1000	G104A	12C B 000 00A	Cantilever Drive T1000 US



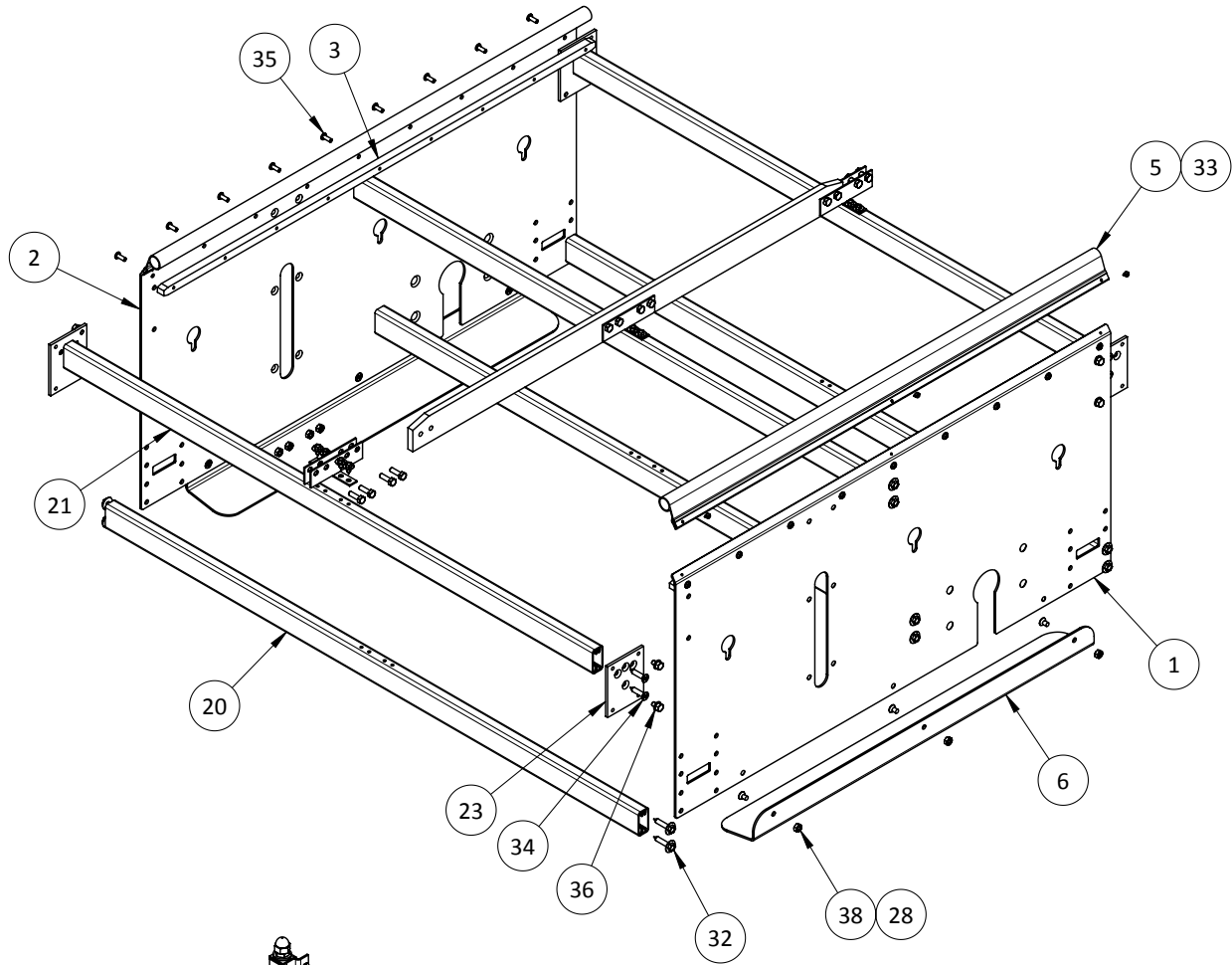
SECTION A-A

Cantilever Drive US							
Part Number	Conveyor Type	Description	A (mm/inches)	B (mm/inches)	C min (mm/inches)	C max (mm/inches)	Chain Length (m/ft)
G104A	1000	Cantilever Drive T1000 US	1040/41.0	1150/45.3	436/17.2	1235/48.6	2.5/8.1

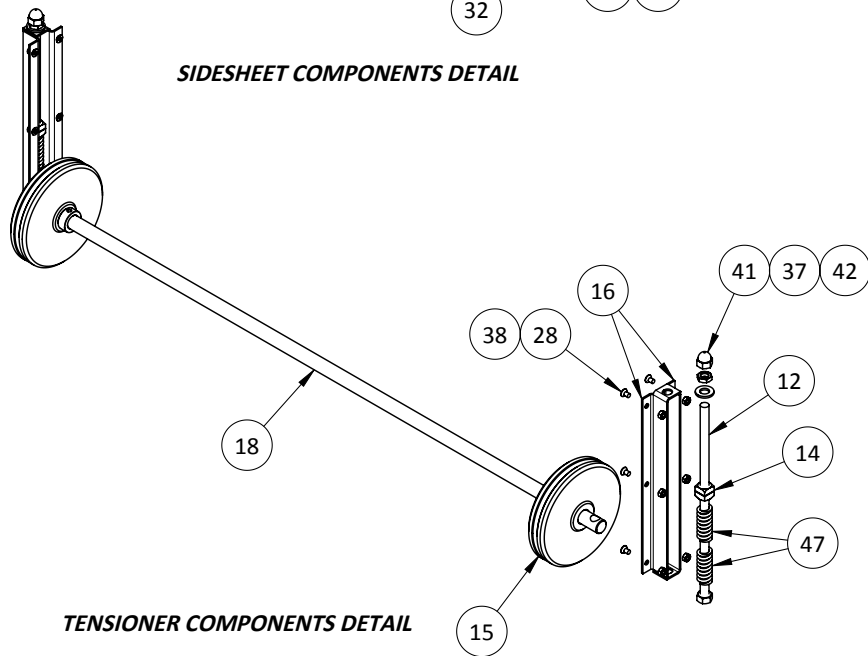
\*S87.3 Stober Gearbox and G581 Marathon Motor shown, sold separately

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	12C B 000 01A		Cantilever Drive Sidesheet RH	1
2	12C B 000 02A		Cantilever Drive Sidesheet LH	1
3	12C B 000 03A		Chain Slideway Top	2
4	12C B 000 04A		Chain Slideway Center	1
5	12C B 000 05A		Red Capping, Cantilever Drive	2
6	12C B 000 06A		Filler Angle	2
7	12C B 000 07B		Floor Support Channel	4
8	12C B 000 08A		Floor Support Weldment	4
9	12C B 010 00A		Deflection Wheel Complete	6
10	12C B 020 00A		Cross Channel Complete T1000	2
11	185 500 55 02		Flange Complete Intermediate Drive	1
12	185 500 77 01		Screw Spindle Bolt-In Tensioner	2
13	185 511 32 00		Flange Bearing Thread Plate	1
14	185 515 07 00		Pressure Piece	2
15	185 515 22 01		Deflection Wheel Smooth 155mm	2
16	185 530 11 02		Tensioner Take-Up Frame	4
17	191 515 04 02		20mm Axle T1000	3
18	191 515 11 02		Tension Axle T1000	1
19	191 516 01 01		Drive Shaft T1000	1
20	191 524 05 07		Traverse T1000 (Thin Side Holes)	4
21	191 524 05 08		Traverse Narrow T1000	2
22	191 524 07 00		Connecting Angle	6
23	191 525 06 00		Thread Plate	4
24	705 001 03 00		Intermediate Drive Sprocket	2
25		21 56 067	M6 x 12 Hex Bolt, Zinc	24
26		21 56 069	M6 x 20 Hex Bolt, Zinc	12
27		21 56 087	M8 x 20 Hex Bolt, Zinc	6
28		21 63 066	M6 x 10 Countersunk Screw, Zinc	18
29		21 63 086	M8 x 16 Countersunk Screw, Zinc	8
30		21 63 109	M10 x 30 Countersunk Screw, Zinc	4
31		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	12
32		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	16
33		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	6
34		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	8
35		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	18
36		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8
37		25 03 108	M12 Jam Nut, Zinc	2
38		25 15 105	M6 Hex Nut, Zinc	54
39		25 15 106	M8 Hex Nut, Zinc	8
40		25 15 107	M10 Hex Nut, Zinc	4
41		25 24 108	M12 Cap Nut, Zinc	2
42		26 02 113	M12 Flat Washer, Zinc	2
43		26 04 111	M8 Lock Washer, Zinc	6
44		26 04 112	M10 Lock Washer, Zinc	4
45		26 43 064	Adjusting Ring A20-705	8
46		27 43 070	8 x 7 x 28 Parallel Key	3
47		32 02 639	Pressure Spring	4
48		34 10 205	4-Bolt Flange Bearing 25mm	1
49		6435K21	Shaft Collar, 1-1/4"	4
50		9283K15	Tubing Plug, 1-1/4"	4
51		FWS-D30-V20.5-T7.5	Washer	6

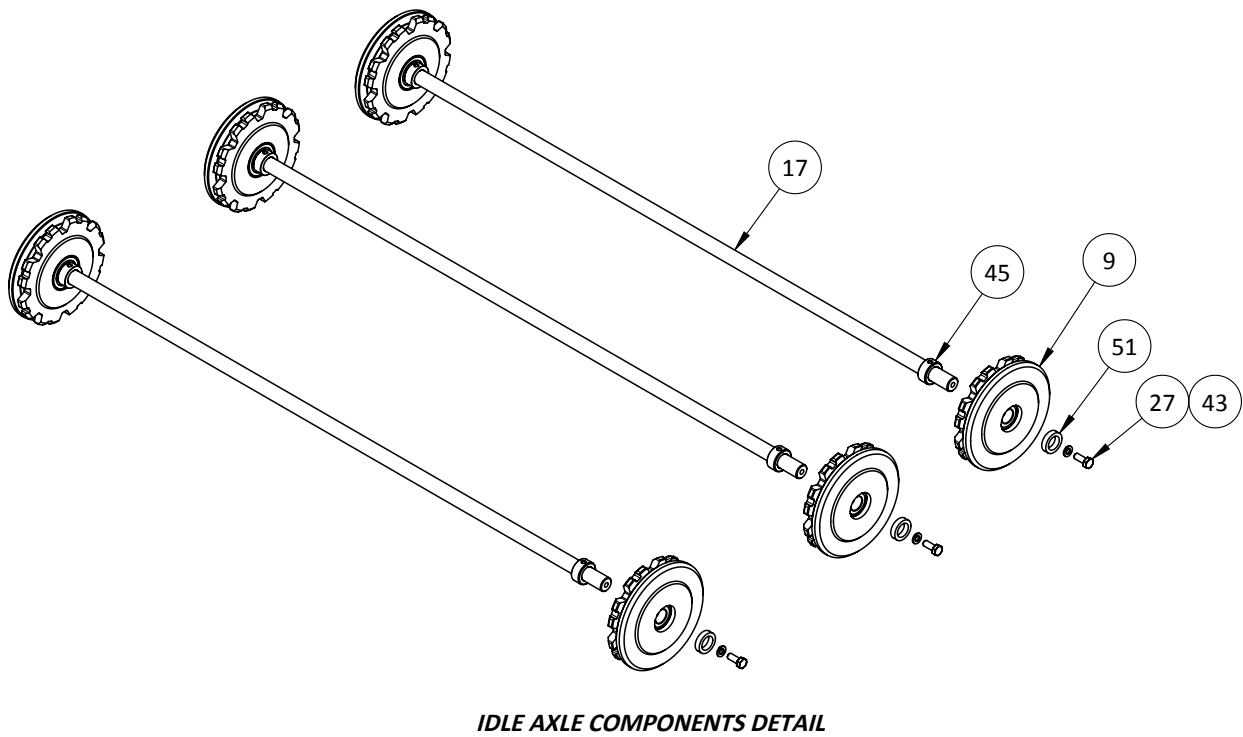
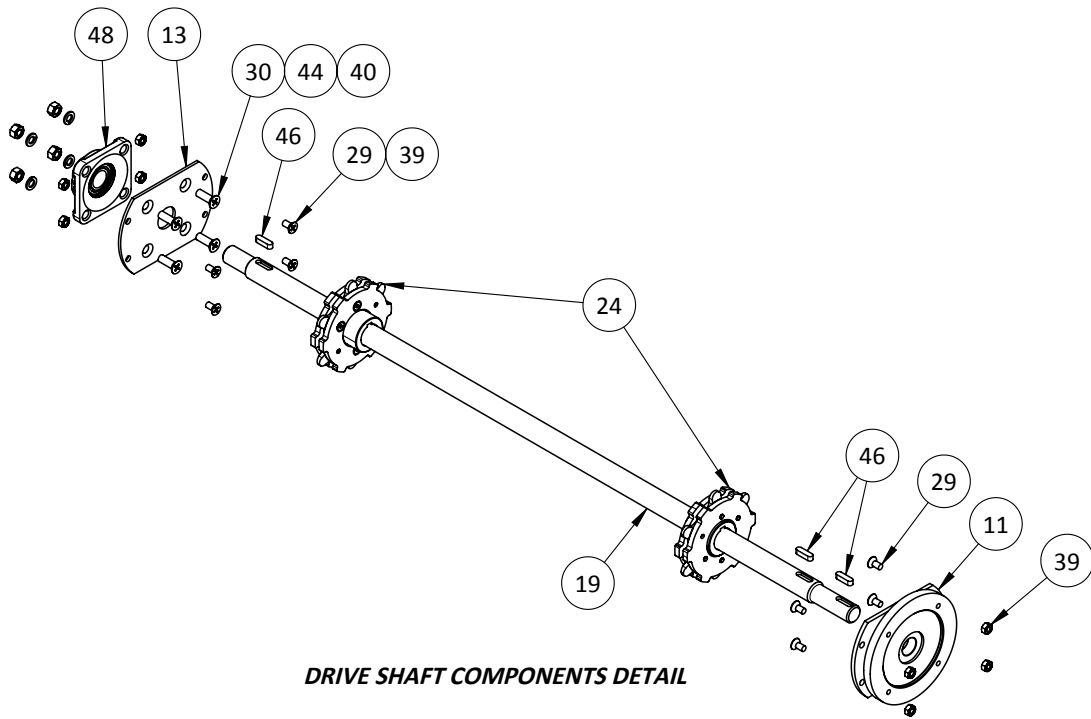


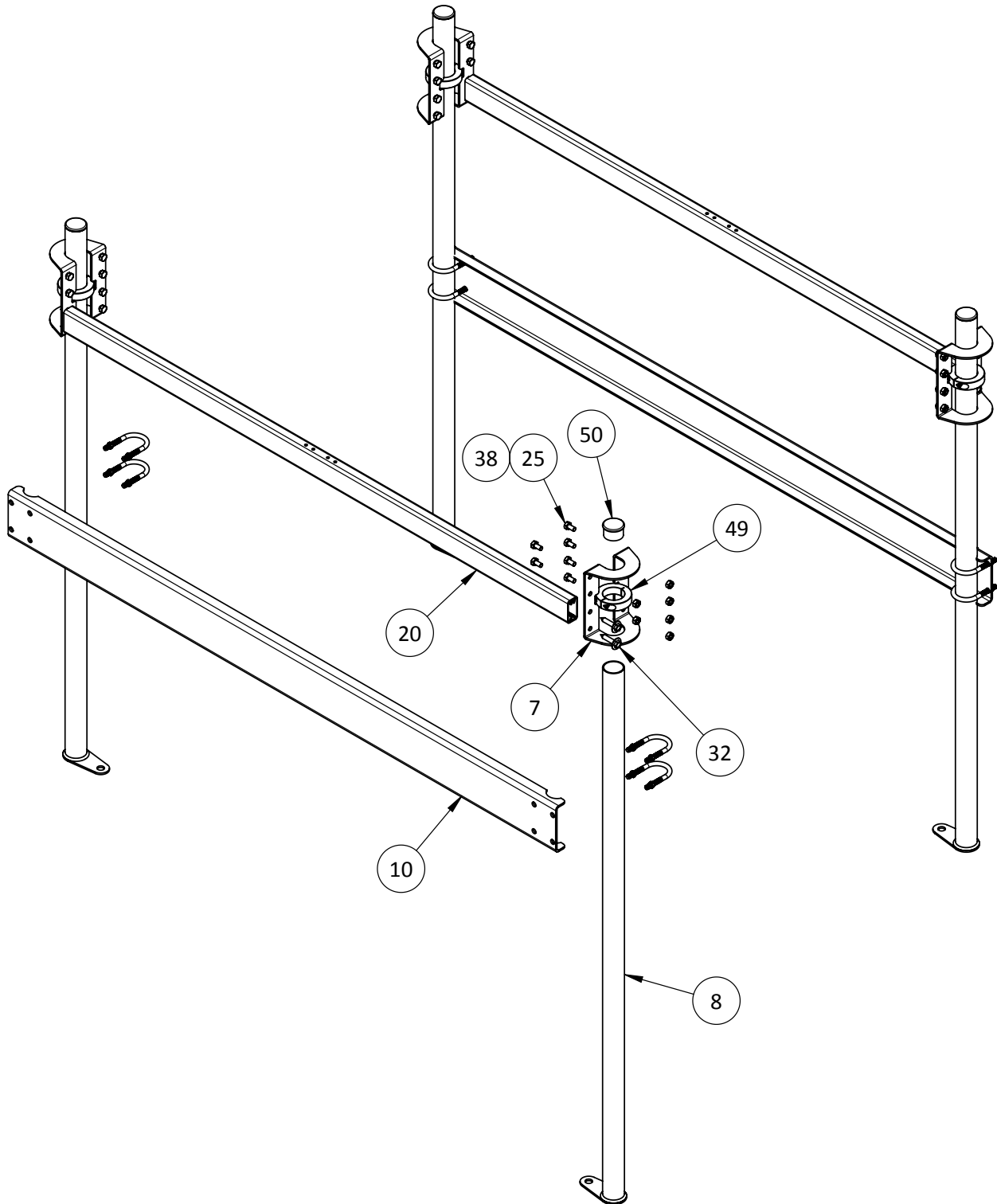
**SIDESHEET COMPONENTS DETAIL**



**TENSIONER COMPONENTS DETAIL**

## Section 2

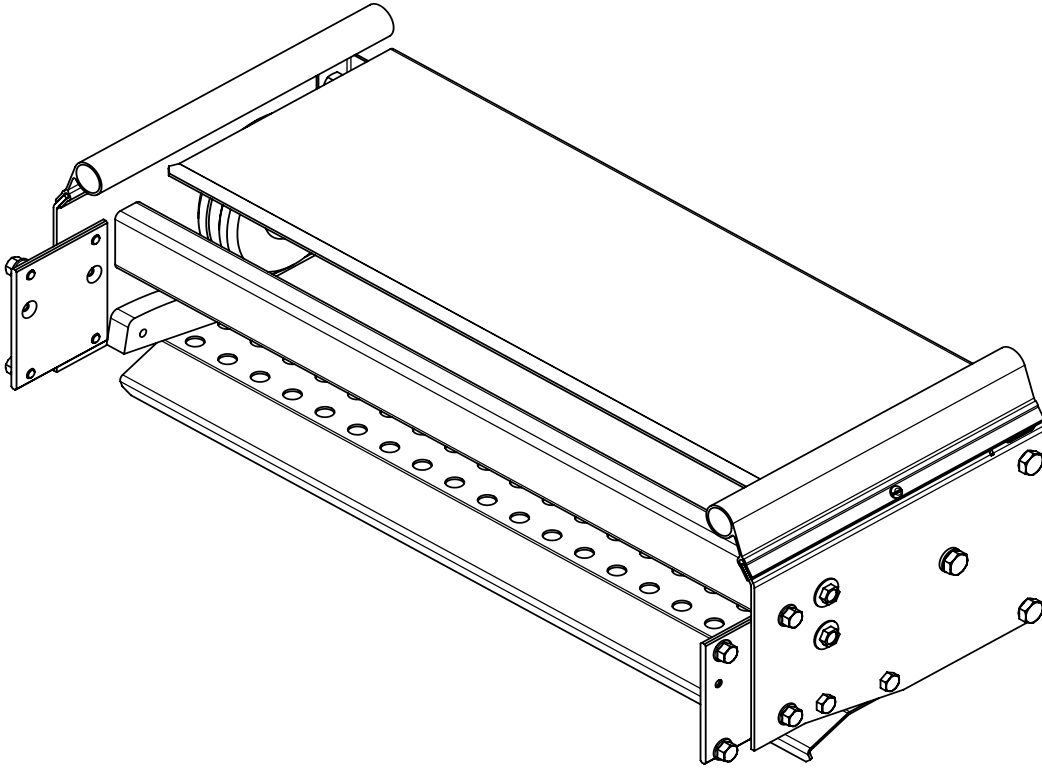




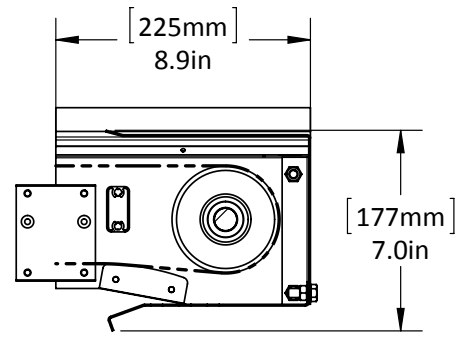
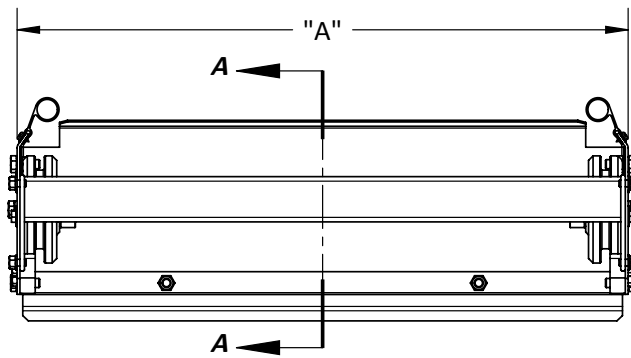
## Section 2

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### End Unit T250 - T750



End Unit			
Conveyor Type	Part Number	Drawing Number	Description
250	4907	--	End Unit T250
350	4846	--	End Unit T350
500	4807	--	End Unit T500
750	4876	--	End Unit T750



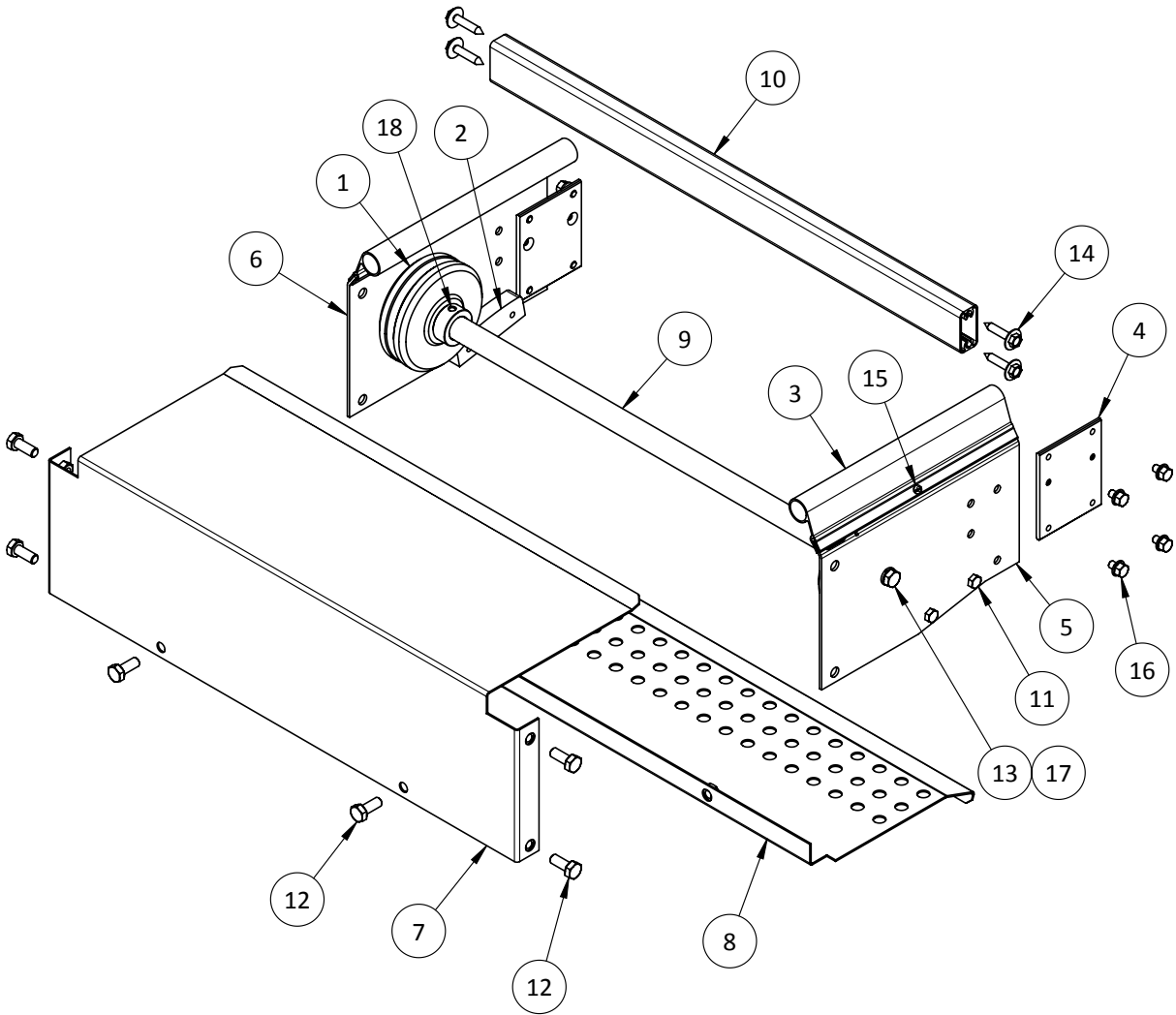
**SECTION A-A**

End Unit				
Part Number	Conveyor Type	Description	A (mm/inches)	Chain Length (m/ft)
4907	250	End Unit T250	290/11.4	.5/1.5
4846	350	End Unit T350	390/15.4	
4807	500	End Unit T500	540/21.3	
4876	750	End Unit T750	790/31.1	



## Section 2

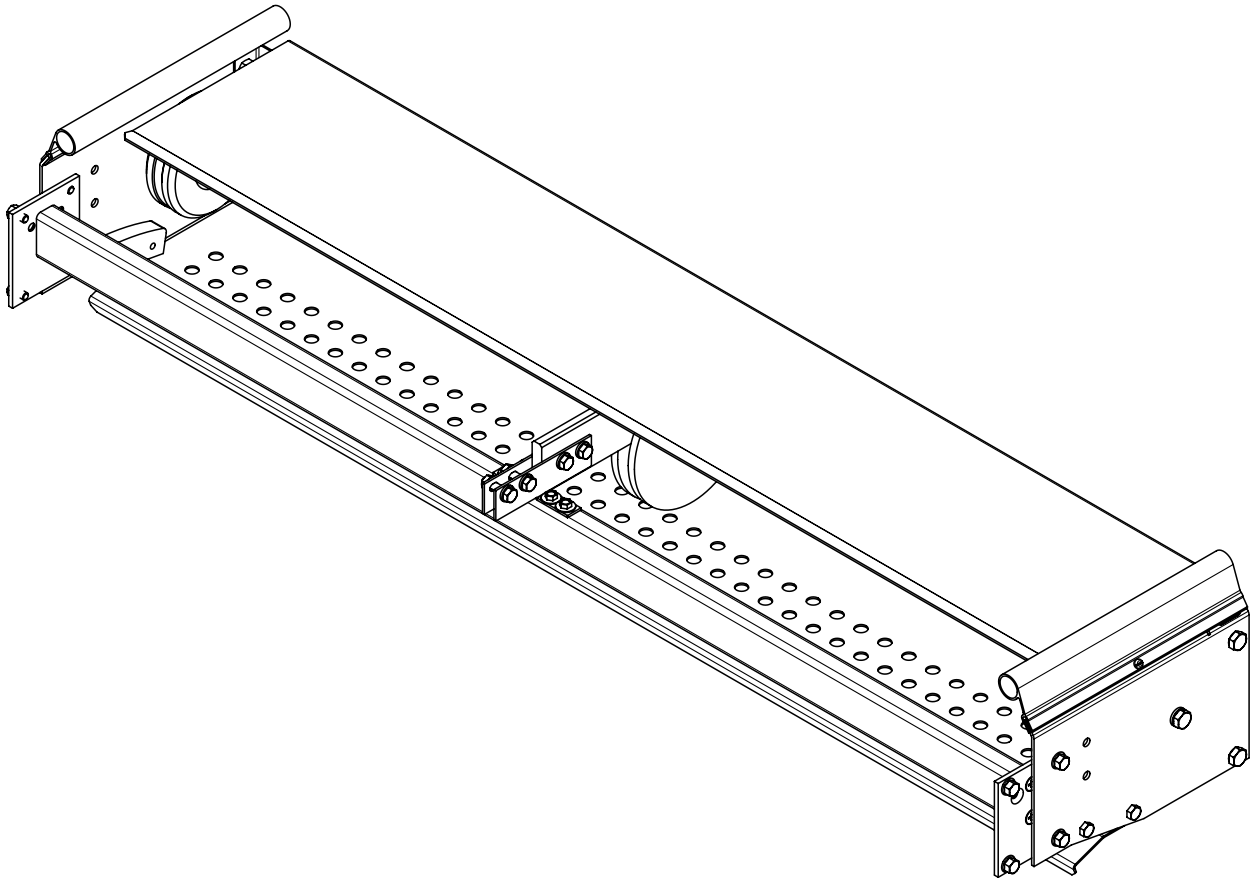
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 515 22 00		Deflection Wheel Smooth 94.7mm	2	2	2	2
2	185 520 07 00		Curved Sliding Shoe	2	2	2	2
3	185 520 09 06		End Unit Capping	2	2	2	2
4	185 525 06 00		Thread Plate	2	2	2	2
5	185 530 01 00		End Unit Sidesheet LH	1	1	1	1
6	185 530 01 01		End Unit Sidesheet RH	1	1	1	1
7	186 500 75 00		End Guard T250	1	-	-	-
7	187 500 75 00		End Guard T350	-	1	-	-
7	185 500 75 00		End Guard T500	-	-	1	-
7	188 500 75 00		End Guard T750	-	-	-	1
8	186 500 76 00		Bottom Guard T250	1	-	-	-
8	187 500 76 00		Bottom Guard T350	-	1	-	-
8	185 500 76 00		Bottom Guard T500	-	-	1	-
8	188 500 76 00		Bottom Guard T750	-	-	-	1
9	186 515 04 02		20mm Axle T250	1	-	-	-
9	187 515 04 02		20mm Axle T350	-	1	-	-
9	185 515 04 02		20mm Axle T500	-	-	1	-
9	188 515 04 02		20mm Axle T750	-	-	-	1
10	186 524 05 00		Traverse T250	1	-	-	-
10	187 524 05 00		Traverse T350	-	1	-	-
10	185 524 05 00		Traverse T500	-	-	1	-
10	188 524 05 00		Traverse T750	-	-	-	1
11		21 56 067	M6 x 12 Hex Bolt, Zinc	4	4	4	4
12		21 56 086	M8 x 16 Hex Bolt, Zinc	6	6	6	6
13		21 56 087	M8 x 20 Hex Bolt, Zinc	2	2	2	2
14		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	4	4	4	4
15		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	2	2	2	2
16		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8	8
17		26 04 111	M8 Lock Washer, Zinc	2	2	2	2
18		26 43 064	Adjusting Ring A20-705	2	2	2	2



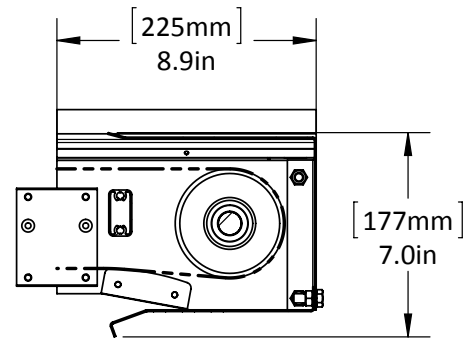
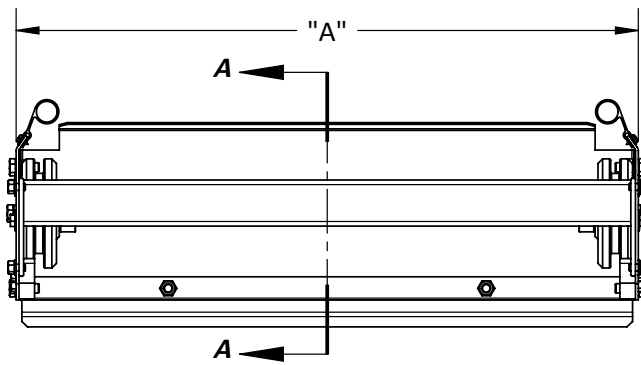
## Section 2

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### End Unit T1000



End Unit			
Conveyor Type	Part Number	Drawing Number	Description
1000	5407	--	End Unit T1000

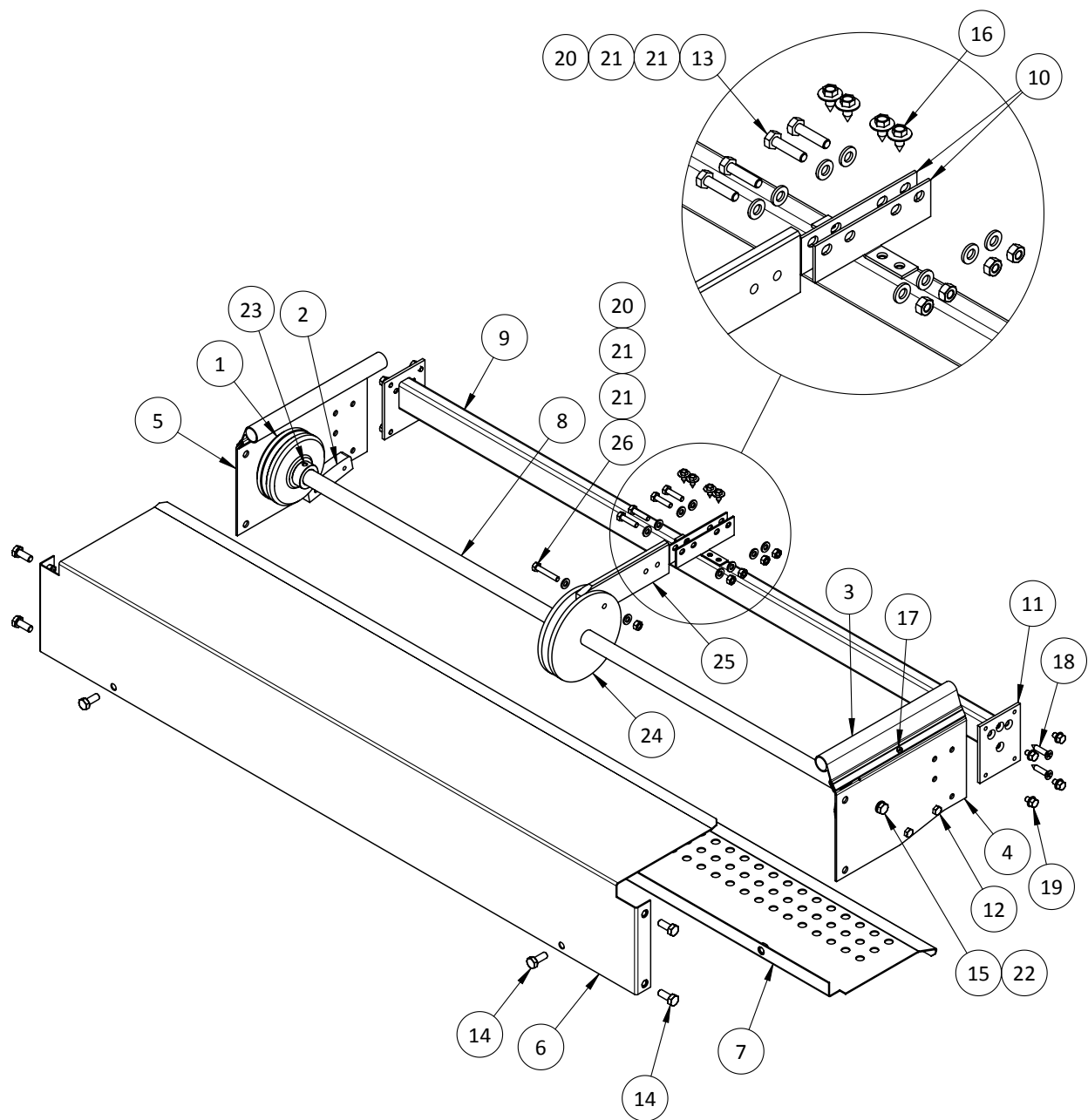


SECTION A-A

End Unit				
Part Number	Conveyor Type	Description	A (mm/inches)	Chain Length (m/ft)
5407	1000	End Unit T1000	1040/41.0	.5/1.5

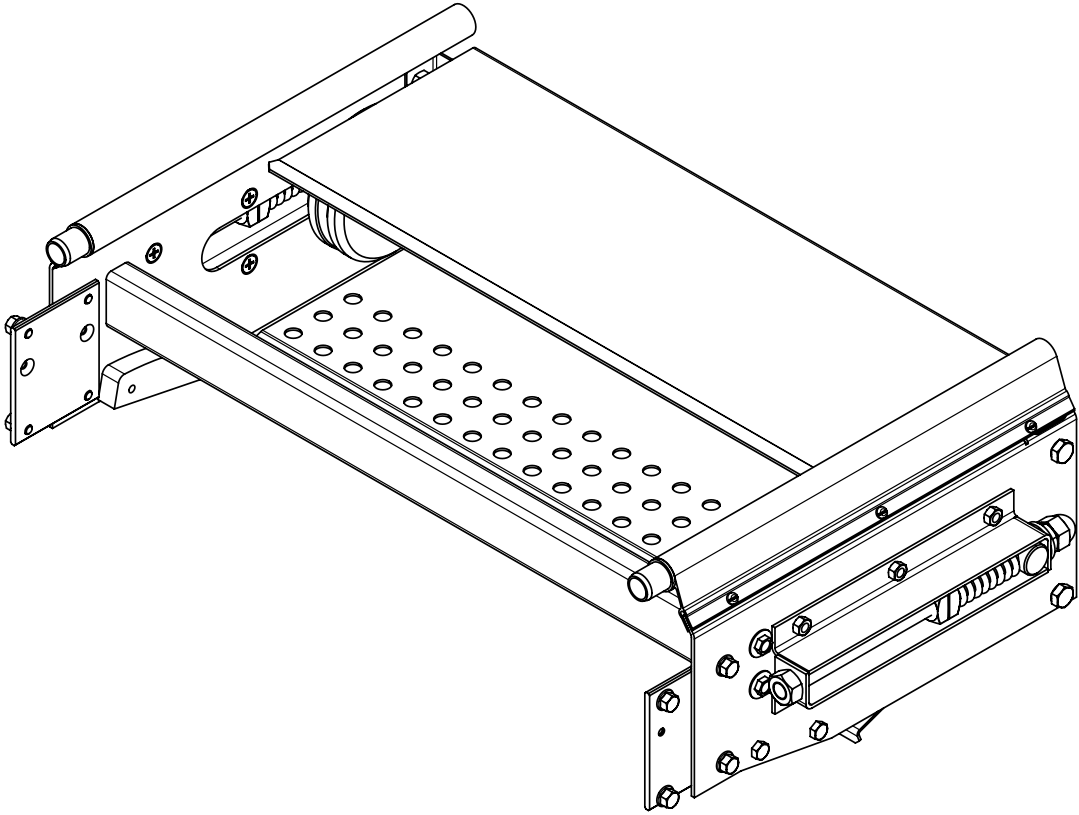
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	185 515 22 00		Deflection Wheel Smooth 94.7mm	2
2	185 520 07 00		Curved Sliding Shoe	2
3	185 520 09 06		End Unit Capping	2
4	185 530 01 00		End Unit Sidesheet LH	1
5	185 530 01 01		End Unit Sidesheet RH	1
6	191 500 75 00		End Guard T1000	1
7	191 500 76 00		Bottom Guard T1000	1
8	191 515 04 02		20mm Axle T1000	1
9	191 524 05 08		Traverse Narrow T1000 (Thin Side Holes)	1
10	191 524 07 00		Connecting Angle	2
11	191 525 06 00		Thread Plate	2
12		21 56 067	M6 x 12 Hex Bolt, Zinc	4
13		21 56 070	M6 x 25 Hex Bolt, Zinc	4
14		21 56 086	M8 x 16 Hex Bolt, Zinc	6
15		21 56 087	M8 x 20 Hex Bolt, Zinc	2
16		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	4
17		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	2
18		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	4
19		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8
20		25 15 105	M6 Hex Nut, Zinc	5
21		26 02 109	M6 Flat Washer, Zinc	10
22		26 04 111	M8 Lock Washer, Zinc	2
23		26 43 064	Adjusting Ring A20-705	2
24		191 518 15 00	Fastening Disk	1
25		191 525 23 00	Sliding Profile	1
26		F8-7-46-2-176	M6 x 35 Hex Bolt, Zinc	1

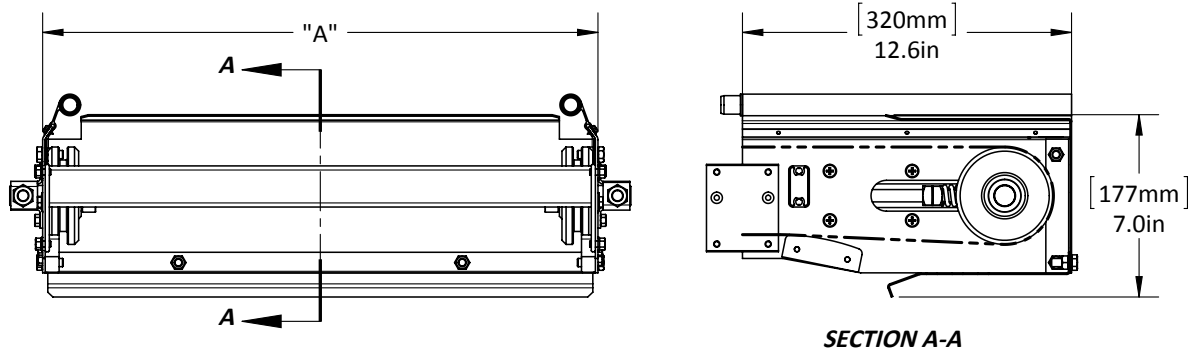


Section 2

End Piece T250 - T750



End Piece			
Conveyor Type	Part Number	Drawing Number	Description
250	4906	--	End Piece T250
350	4845	--	End Piece T350
500	4806	--	End Piece T500
750	4875	--	End Piece T750

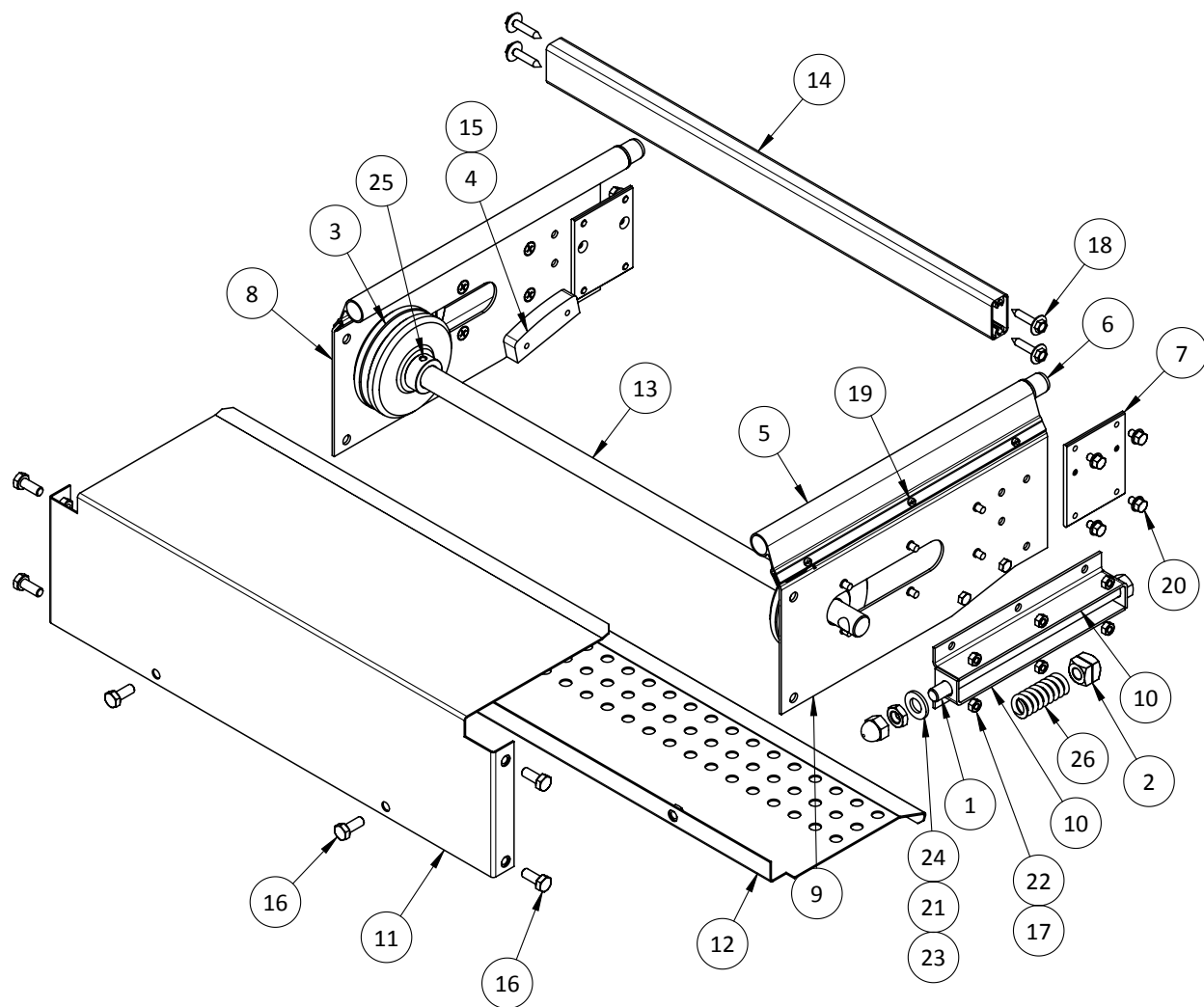


End Piece				
Part Number	Conveyor Type	Description	A (mm/inches)	Chain Length (m/ft)
4906	250	End Piece T250	290/11.4	.7/2.2
4845	350	End Piece T350	390/15.4	
4806	500	End Piece T500	540/21.3	
4875	750	End Piece T750	790/31.1	

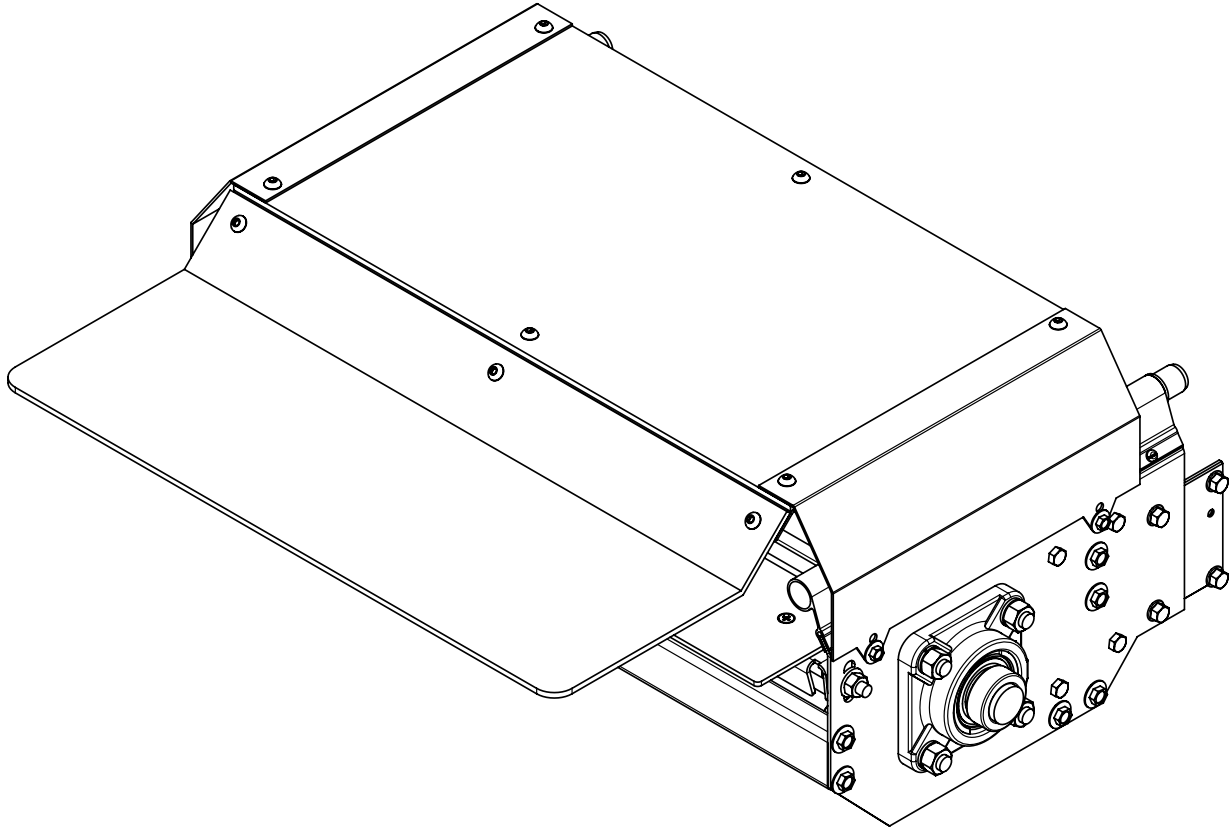


## Section 2

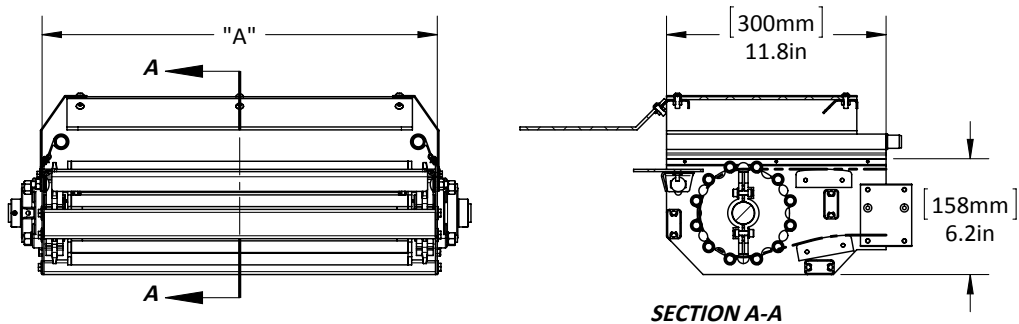
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 500 77 00		Screw Spindle End Piece	2	2	2	2
2	185 515 07 00		Pressure Piece	2	2	2	2
3	185 515 22 00		Deflection Wheel Smooth 94.7mm	2	2	2	2
4	185 520 07 00		Curved Sliding Shoe	2	2	2	2
5	185 520 09 05		End Piece Capping	2	2	2	2
6	185 520 18 00		Intermediate Coupling	2	2	2	2
7	185 525 06 00		Thread Plate	2	2	2	2
8	185 530 10 00		End Piece Sidesheet LH	1	1	1	1
9	185 530 10 01		End Piece Sidesheet RH	1	1	1	1
10	185 530 11 00		End Piece Take-up Frame	4	4	4	4
11	186 500 75 00		End Guard T250	1	-	-	-
11	187 500 75 00		End Guard T350	-	1	-	-
11	185 500 75 00		End Guard T500	-	-	1	-
11	188 500 75 00		End Guard T750	-	-	-	1
12	186 500 76 00		Bottom Guard T250	1	-	-	-
12	187 500 76 00		Bottom Guard T350	-	1	-	-
12	185 500 76 00		Bottom Guard T500	-	-	1	-
12	188 500 76 00		Bottom Guard T750	-	-	-	1
13	186 515 11 02		Tension Axle T250	1	-	-	-
13	187 515 11 02		Tension Axle T350	-	1	-	-
13	185 515 11 02		Tension Axle T500	-	-	1	-
13	188 515 11 02		Tension Axle T750	-	-	-	1
14	186 524 05 00		Traverse T250	1	-	-	-
14	187 524 05 00		Traverse T350	-	1	-	-
14	185 524 05 00		Traverse T500	-	-	1	-
14	188 524 05 00		Traverse T750	-	-	-	1
15		21 56 067	M6 x 12 Hex Bolt, Zinc	4	4	4	4
16		21 56 086	M8 x 16 Hex Bolt, Zinc	6	6	6	6
17		21 63 066	M6 x 10 Countersunk Screw, Zinc	12	12	12	12
18		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	4	4	4	4
19		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	6	6	6	6
20		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8	8
21		25 03 108	M12 Jam Nut, Zinc	2	2	2	2
22		25 15 105	M6 Hex Nut, Zinc	12	12	12	12
23		25 24 108	M12 Cap Nut, Zinc	2	2	2	2
24		26 02 113	M12 Flat Washer, Zinc	2	2	2	2
25		26 43 064	Adjusting Ring A20-705	2	2	2	2
26		32 02 639	Pressure Spring	2	2	2	2



### Idler Unit T250 - T750



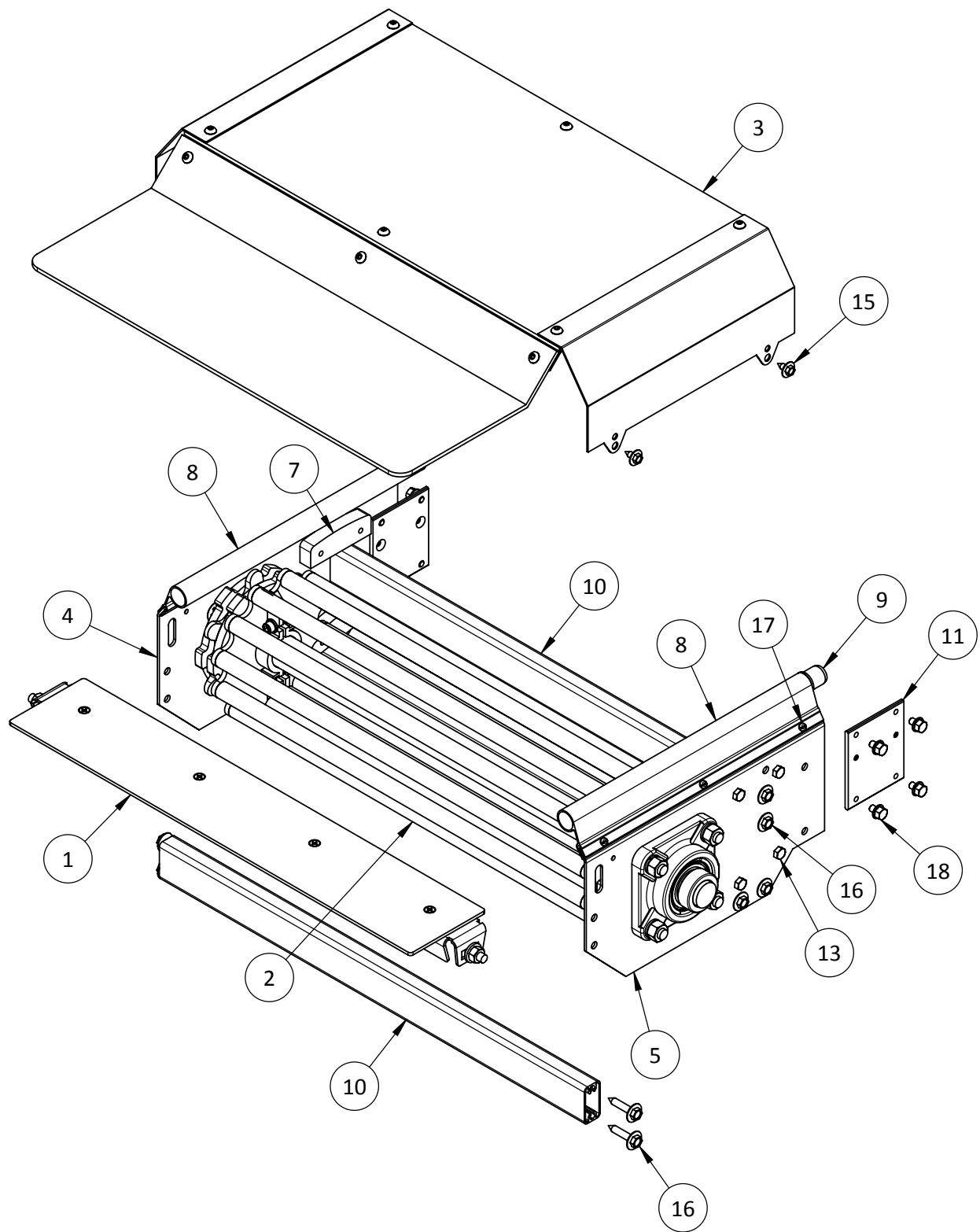
Idler Unit			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 005 02 10	Idler Unit T250
350	--	187 005 02 10	Idler Unit T350
500	--	185 005 02 10	Idler Unit T500
750	--	188 005 02 10	Idler Unit T750



Idler Unit							
Drawing Number	Conveyor Type	Description	A (mm/inches)	H1** min/max (mm/inches)	H2*** min/max (mm/inches)	H3**** min/max (mm/inches)	Chain Length (m/ft)
186 005 02 10	250	Idler Unit T250	290/11.4	190 - 320 7.5 12.6	310 - 610 12.2 - 24.0	600 - 1300 23.6 - 51.2	.6/2.0
187 005 02 10	350	Idler Unit T350	390/15.4				
185 005 02 10	500	Idler Unit T500	540/21.3				
188 005 02 10	750	Idler Unit T750	790/31.1				

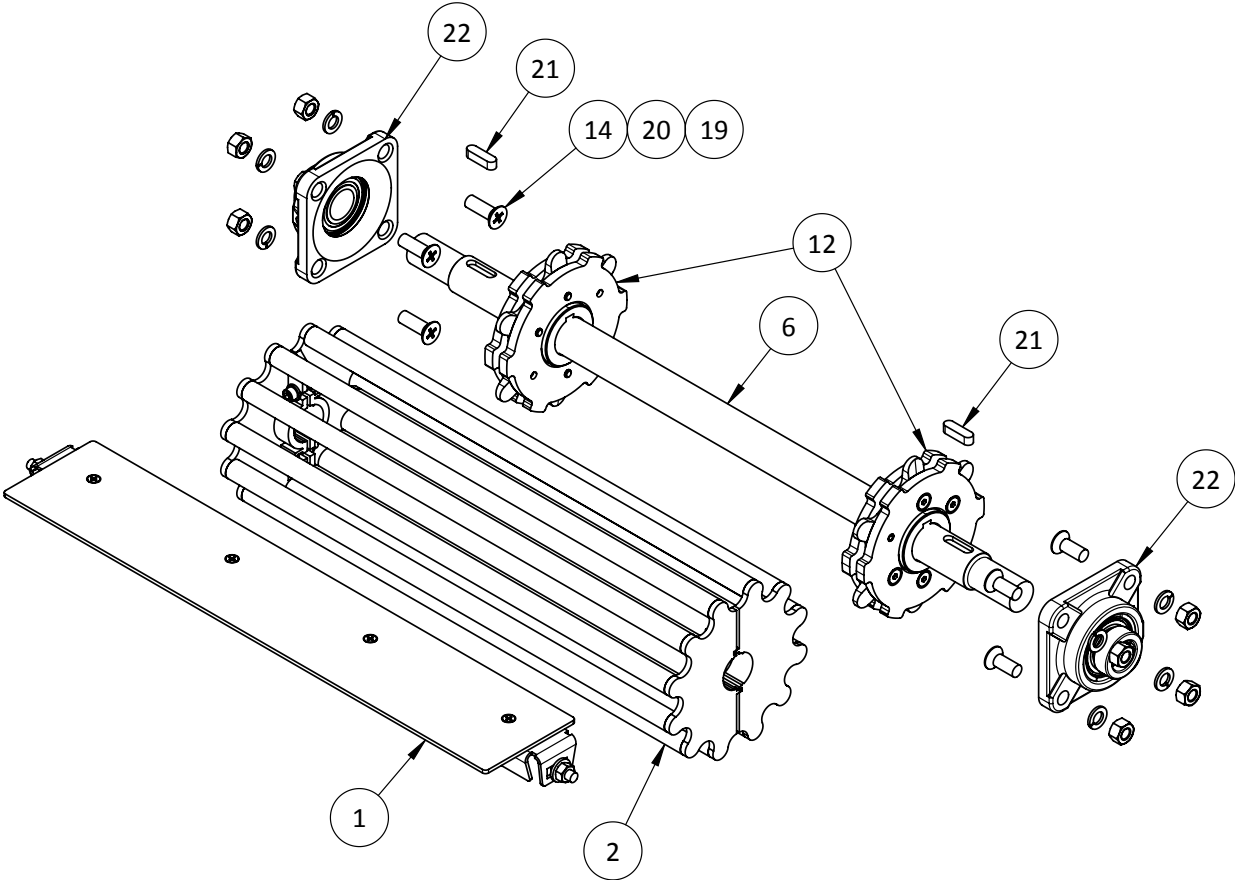
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	186 500 10 03		Transfer Complete T250 x 95mm	1	-	-	-
1	187 500 10 03		Transfer Complete T350 x 95mm	-	1	-	-
1	185 500 10 03		Transfer Complete T500 x 95mm	-	-	1	-
1	188 500 10 03		Transfer Complete T750 x 95mm	-	-	-	1
2	186 500 11 02		Discharge Wheel Complete T250	1	-	-	-
2	187 500 11 02		Discharge Wheel Complete T350	-	1	-	-
2	185 500 11 02		Discharge Wheel Complete T500	-	-	1	-
2	188 500 11 02		Discharge Wheel Complete T750	-	-	-	1
3	186 500 56 10		Cover Complete T250	1	-	-	-
3	187 500 56 10		Cover Complete T350	-	1	-	-
3	185 500 56 10		Cover Complete T500	-	-	1	-
3	188 500 56 10		Cover Complete T750	-	-	-	1
4	185 511 01 00		Mini Drive Sidesheet LH	1	1	1	1
5	185 511 01 01		Mini Drive Sidesheet RH	1	1	1	1
6	186 516 01 07		Return Shaft T250	1	-	-	-
6	187 516 01 07		Return Shaft T350	-	1	-	-
6	185 516 01 07		Return Shaft T500	-	-	1	-
6	188 516 01 07		Return Shaft T750	-	-	-	1
7	185 520 07 00		Curved Sliding Shoe	4	4	4	4
8	185 520 09 04		Mini Drive Capping	2	2	2	2
9	185 520 18 00		Intermediate Coupling	2	2	2	2
10	186 524 05 00		Traverse T250	3	-	-	-
10	187 524 05 00		Traverse T350	-	3	-	-
10	185 524 05 00		Traverse T500	-	-	3	-
10	188 524 05 00		Traverse T750	-	-	-	3
11	185 525 06 00		Thread Plate	2	2	2	2
12	705 001 02 00		Main Drive Sprocket	2	2	2	2
13		21 56 067	M6 x 12 Hex Bolt, Zinc	8	8	8	8
14		21 63 109	M10 x 30 Countersunk Screw, Zinc	8	8	8	8
15		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	4	4	4	4
16		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	12	12	12	12
17		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	6	6	6	6
18		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8	8
19		25 15 107	M10 Hex Nut, Zinc	8	8	8	8
20		26 04 112	M10 Lock Washer, Zinc	8	8	8	8
21		27 43 070	8 x 7 x 28 Parallel Key	2	2	2	2
22		34 10 205	4-Bolt Flange Bearing 25mm	2	2	2	2



# Section 2

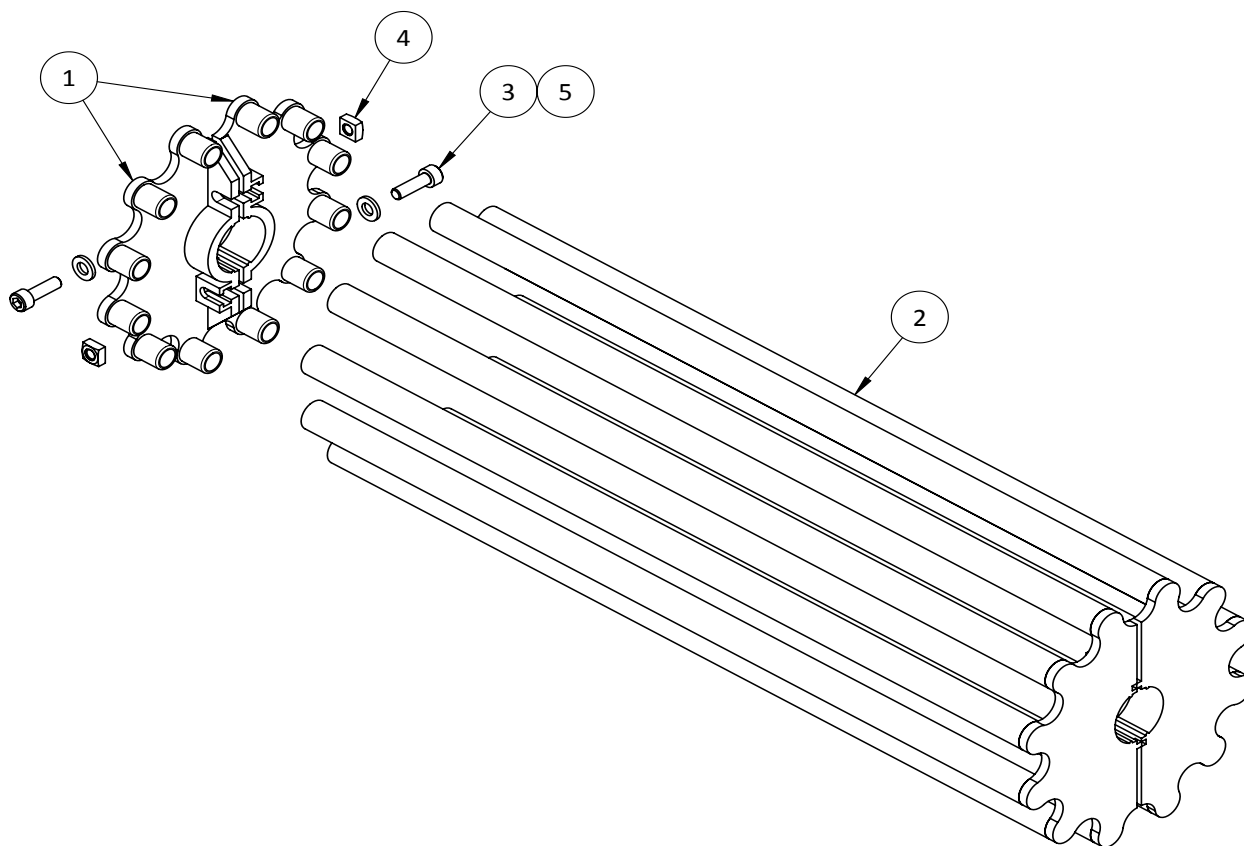
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**RETURN SHAFT COMPONENTS DETAIL**

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 518 03 01		Driving Plate	4	4	4	4
2	186 518 05 01		Discharge Tube T250	12	-	-	-
2	187 518 05 01		Discharge Tube T350	-	12	-	-
2	185 518 05 01		Discharge Tube T500	-	-	12	-
2	188 518 05 01		Discharge Tube T750	-	-	-	12
3		21 42 069	M6 x 20 SHCS, Zinc	4	4	4	4
4		25 09 105	M6 Square Nut, Zinc	4	4	4	4
5		26 02 109	M6 Flat Washer, Zinc	4	4	4	4

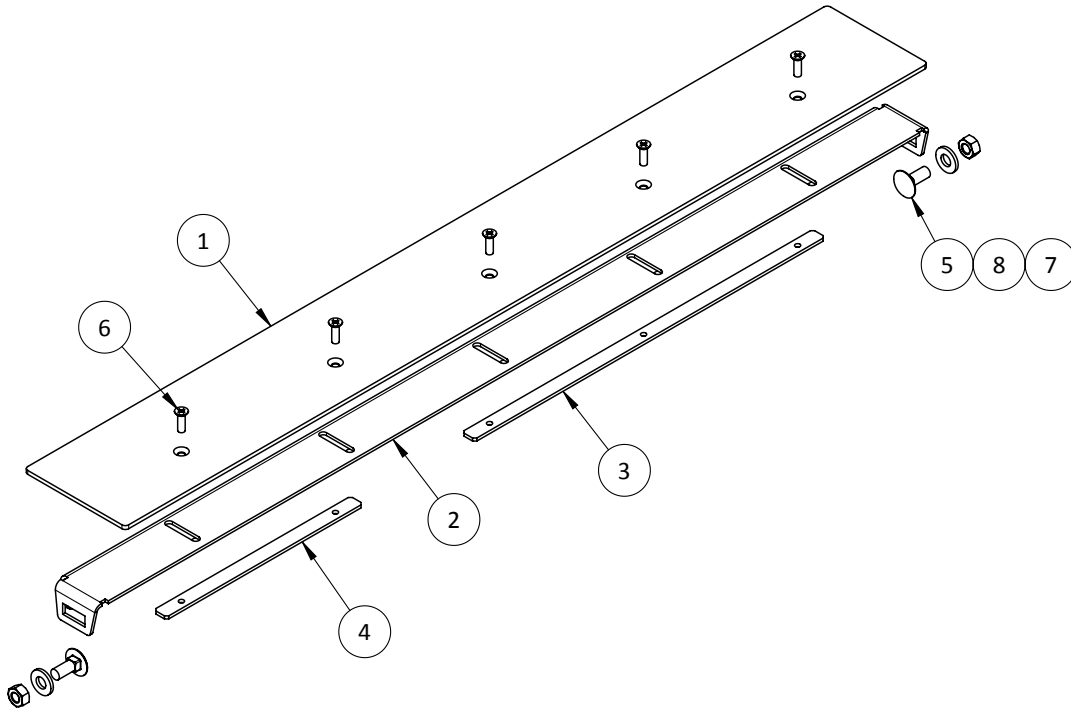


Discharge Wheel Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 11 02	Discharge Wheel Complete T250
350	--	187 500 11 02	Discharge Wheel Complete T350
500	--	185 500 11 02	Discharge Wheel Complete T500
750	--	188 500 11 02	Discharge Wheel Complete T750



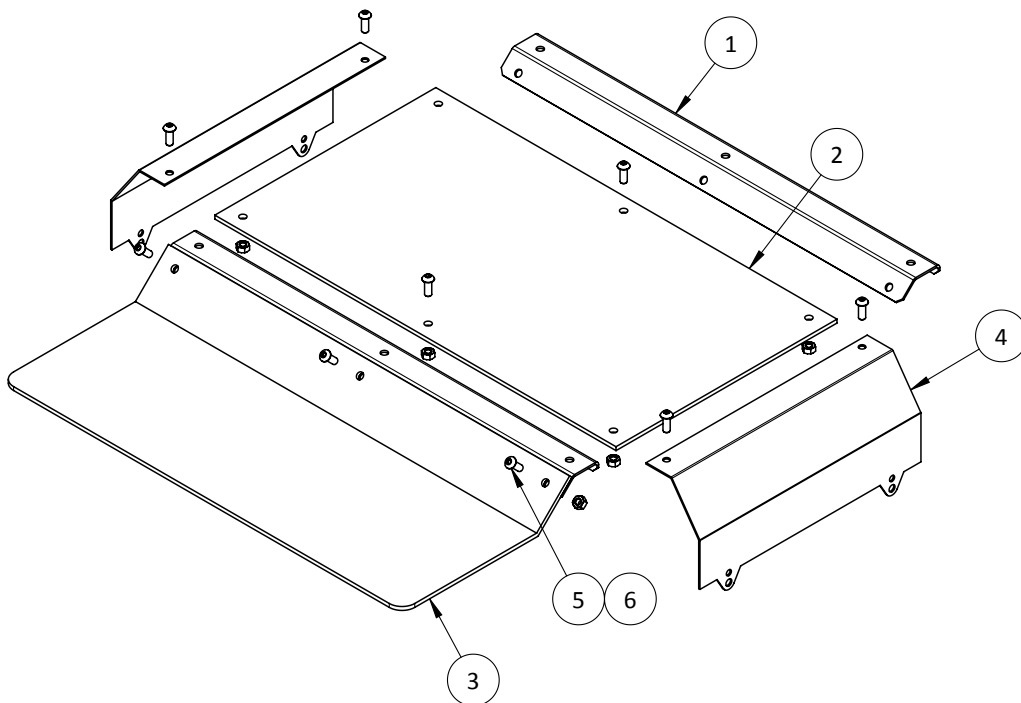
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	186 518 02 00		Transfer Plate T250 x 95mm	1	-	-	-
1	187 518 02 00		Transfer Plate T350 x 95mm	-	1	-	-
1	185 518 02 00		Transfer Plate T500 x 95mm	-	-	1	-
1	188 518 02 00		Transfer Plate T750 x 95mm	-	-	-	1
2	186 518 43 00		Transfer Angle T250	1	-	-	-
2	187 518 43 00		Transfer Angle T350	-	1	-	-
2	185 518 43 00		Transfer Angle T500	-	-	1	-
2	188 518 43 00		Transfer Angle T750	-	-	-	1
3	187 518 44 00		Thread Plate T350	-	1	-	1
4	189 518 44 00		Thread Plate T200	1	-	2	1
5		21 28 087	M8 x 20 Carriage Bolt, Zinc	2	2	2	2
6		21 63 049	M5 x 16 Countersunk Screw, Zinc	2	3	4	5
7		25 15 106	M8 Hex Nut, Zinc	2	2	2	2
8		26 02 111	M8 Flat Washer, Zinc	2	2	2	2



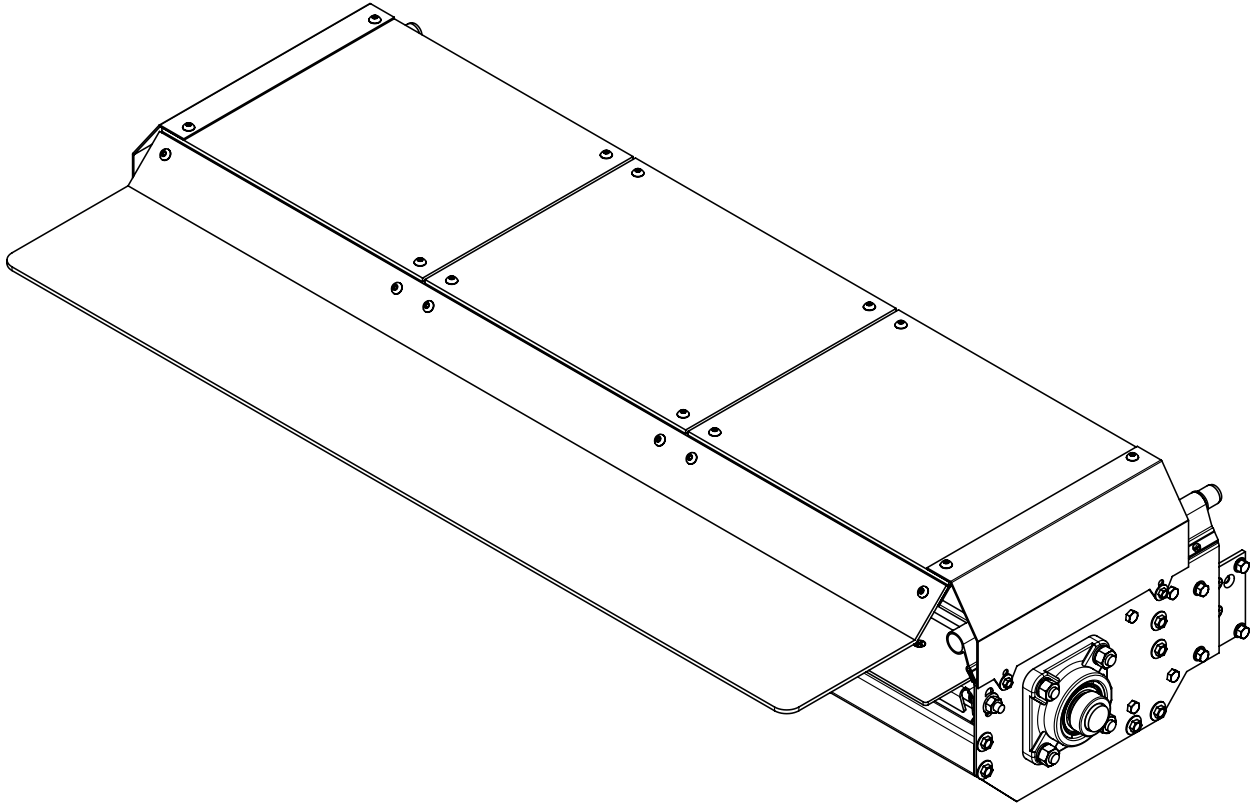
Transfer Complete 95mm			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 10 03	Transfer Complete T250 x 95mm
350	--	187 500 10 03	Transfer Complete T350 x 95mm
500	--	185 500 10 03	Transfer Complete T500 x 95mm
750	--	188 500 10 03	Transfer Complete T750 x 95mm

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T750	T500
1	186 510 07 00		Cover U-Profile T250	2	-	-	-
1	187 510 07 00		Cover U-Profile T350	-	2	-	-
1	188 510 07 00		Cover U-Profile T750	-	-	2	-
1	185 510 07 00		Cover U-Profile T500	-	-	-	2
2	186 510 10 00		Top Cover T250	1	-	-	-
2	187 510 10 00		Top Cover T350	-	1	-	-
2	188 510 10 00		Top Cover T750	-	-	1	-
2	185 510 10 00		Top Cover T500	-	-	-	1
3	186 510 10 02		Transfer Cover T250	1	-	-	-
3	187 510 10 02		Transfer Cover T350	-	1	-	-
3	188 510 10 02		Transfer Cover T750	-	-	1	-
3	185 510 10 02		Transfer Cover T500	-	-	-	1
4	185 510 26 00		Cover Sidesheet	2	2	2	2
5		21 90 068	M6 x 16 BHCS, Zinc	9	6	9	9
6		25 15 105	M6 Hex Nut, Zinc	9	9	9	9

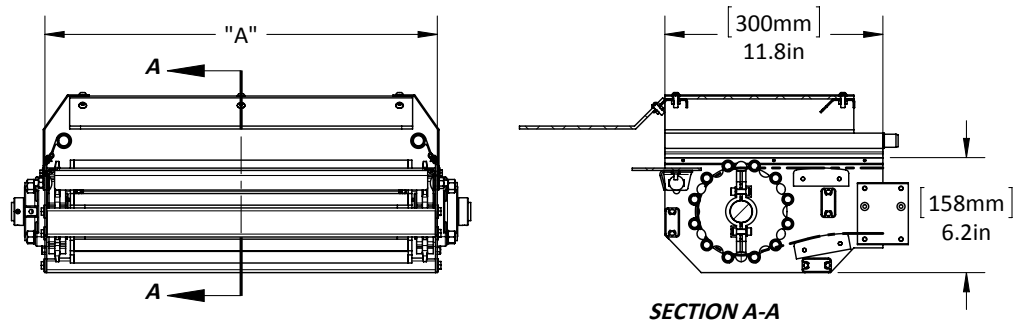


Cover Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 56 10	Cover Complete T250
350	--	187 500 56 10	Cover Complete T350
500	--	185 500 56 10	Cover Complete T500
750	--	188 500 56 10	Cover Complete T750

### Idler Unit T1000



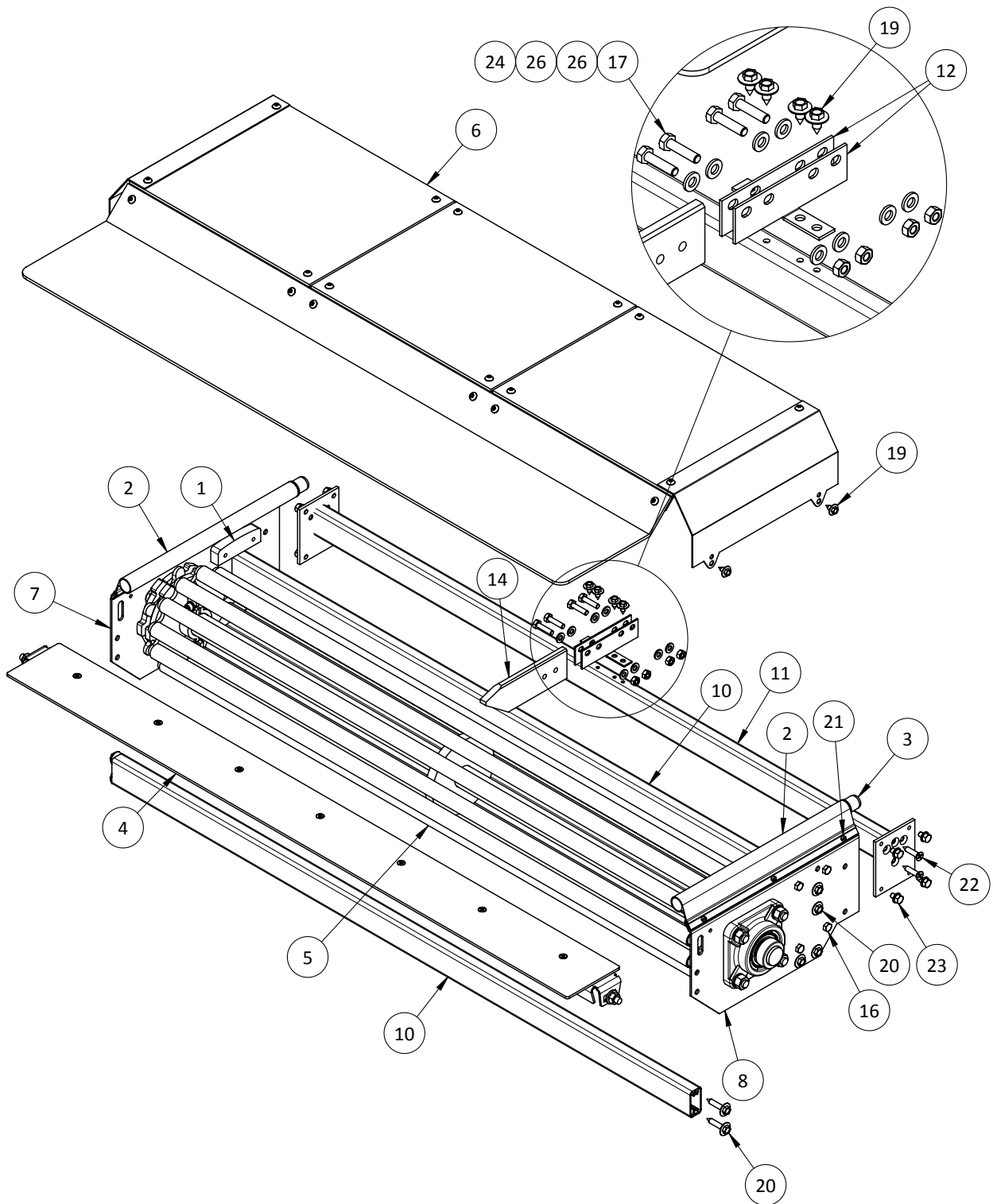
Idler Unit			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 005 02 10	Idler Unit T1000



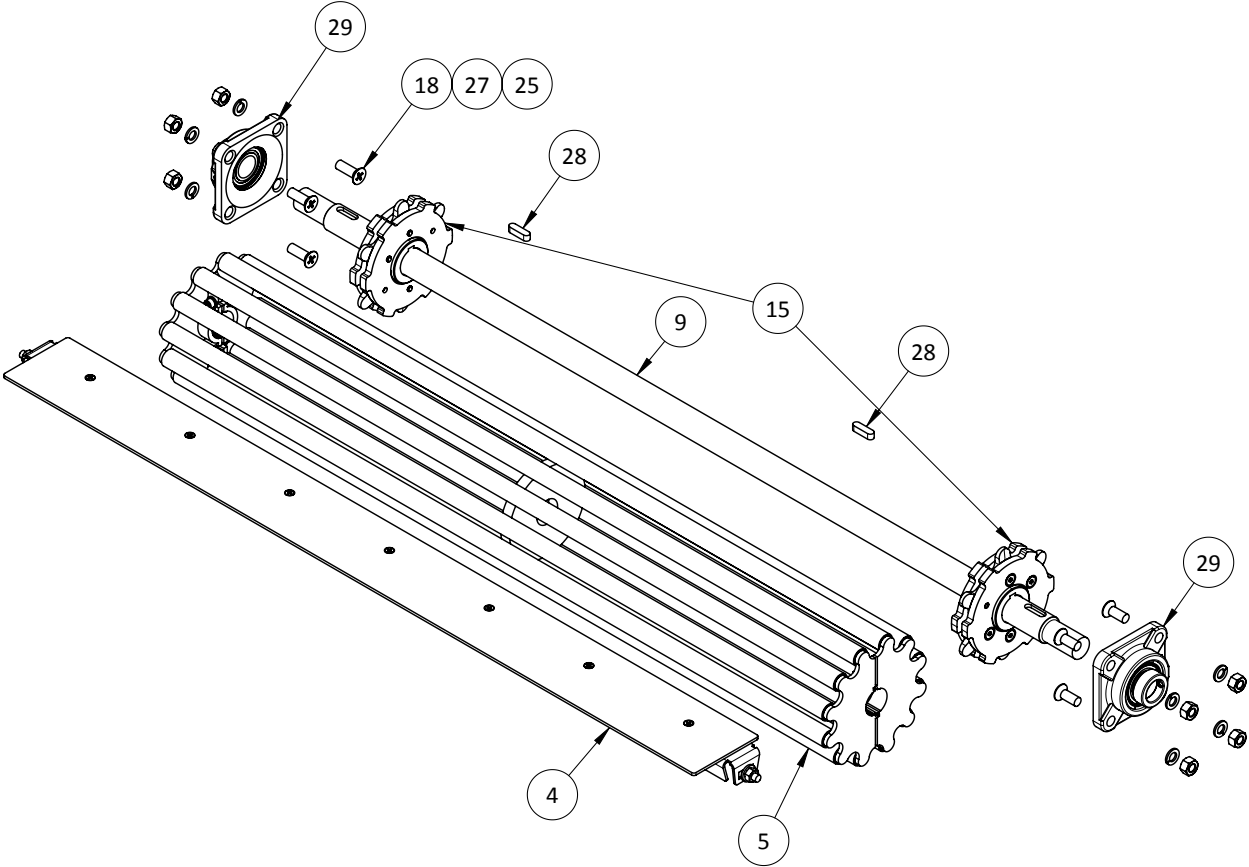
Idler Unit							
Drawing Number	Conveyor Type	Description	A (mm/inches)	H1** min/max (mm/inches)	H2*** min/max (mm/inches)	H3**** min/max (mm/inches)	Chain Length (m/ft)
191 005 02 10	1000	Idler Unit T1000	1040/41.0	190 - 320 7.5 12.6	310 - 610 12.2 - 24.0	600 - 1300 23.6 - 51.2	.6/2.0

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	185 520 07 00		Curved Sliding Shoe	4
2	185 520 09 04		Mini Drive Capping	2
3	185 520 18 00		Intermediate Coupling	2
4	191 500 10 03		Transfer Complete T1000 x 95mm	1
5	191 500 11 02		Discharge Wheel Complete T1000	1
6	191 500 56 10		Cover Complete T1000	1
7	191 511 01 00		Mini Drive Sidesheet LH T1000	1
8	191 511 01 01		Mini Drive Sidesheet RH T1000	1
9	191 516 01 07		Return Shaft T1000	1
10	191 524 05 00		Traverse T1000 (No Holes)	3
11	191 524 05 08		Traverse Narrow T1000 (Thin Side Holes)	1
12	191 524 07 00		Connecting Angle	2
13	191 525 06 00		Thread Plate	2
14	191 525 19 00		Sliding Profile	1
15	705 001 02 00		Main Drive Sprocket	2
16		21 56 067	M6 x 12 Hex Bolt, Zinc	8
17		21 56 070	M6 x 25 Hex Bolt, Zinc	4
18		21 63 109	M10 x 30 Countersunk Screw, Zinc	8
19		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	8
20		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	12
21		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	6
22		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	4
23		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8
24		25 15 105	M6 Hex Nut, Zinc	4
25		25 15 107	M10 Hex Nut, Zinc	8
26		26 02 109	M6 Flat Washer, Zinc	8
27		26 04 112	M10 Lock Washer, Zinc	8
28		27 43 070	8 x 7 x 28 Parallel Key	2
29		34 10 205	4-Bolt Flange Bearing 25mm	2



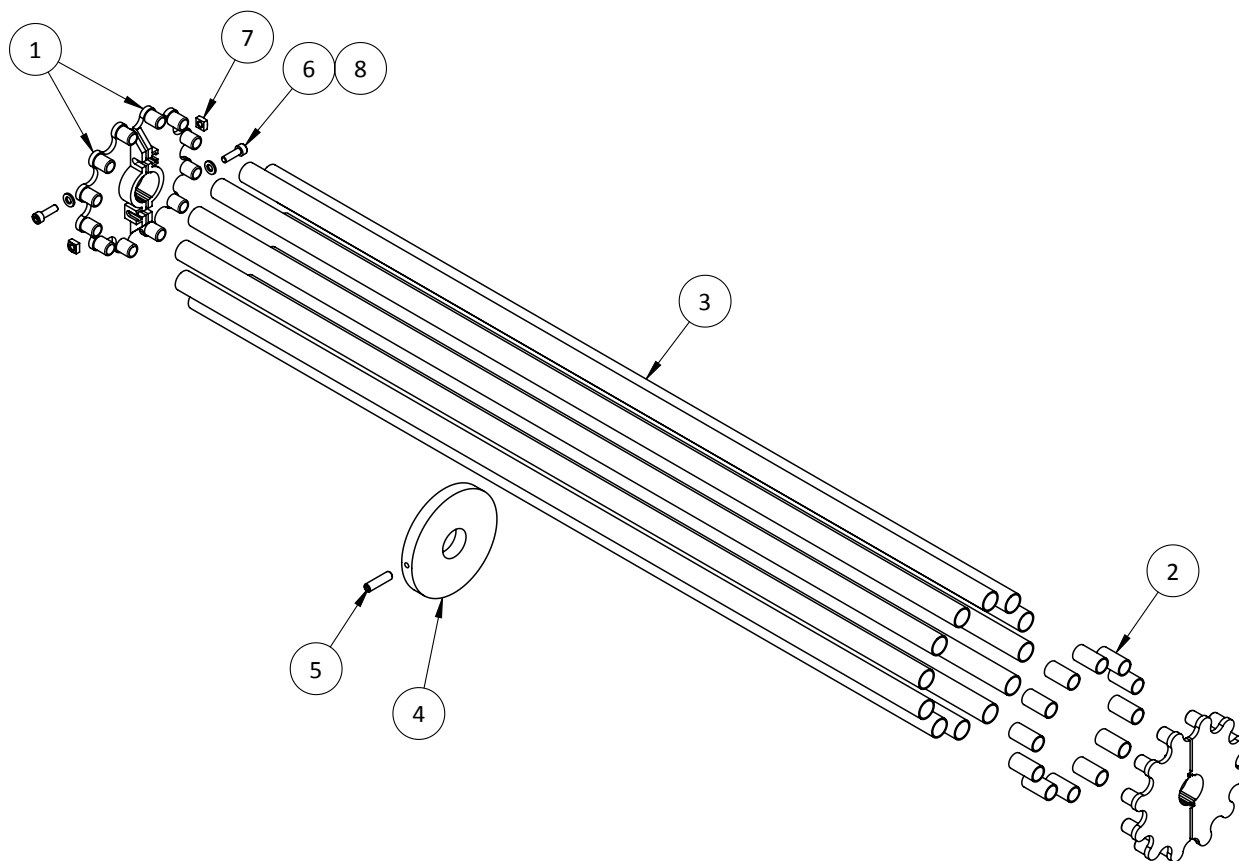
# Section 2



*RETURN SHAFT COMPONENTS DETAIL*

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 518 03 01		Driving Plate	4
2	191 518 04 01		Discharge Tube Plug T1000	24
3	191 518 05 01		Discharge Tube T1000	12
4	191 518 13 00		Center Wheel	1
5		20 46 089	M8 x 30 Grub Screw, Zinc	1
6		21 42 069	M6 x 20 SHCS, Zinc	4
7		25 09 105	M6 Square Nut, Zinc	4
8		26 02 109	M6 Flat Washer, Zinc	4

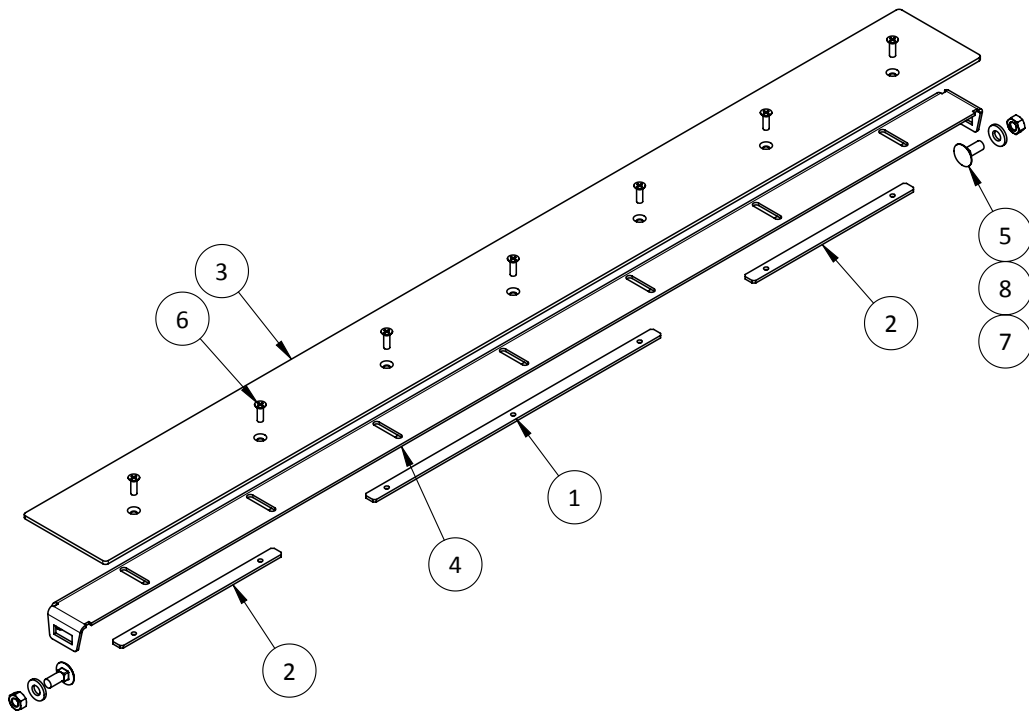


Discharge Wheel Complete			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 11 02	Discharge Wheel Complete T1000



## Section 2

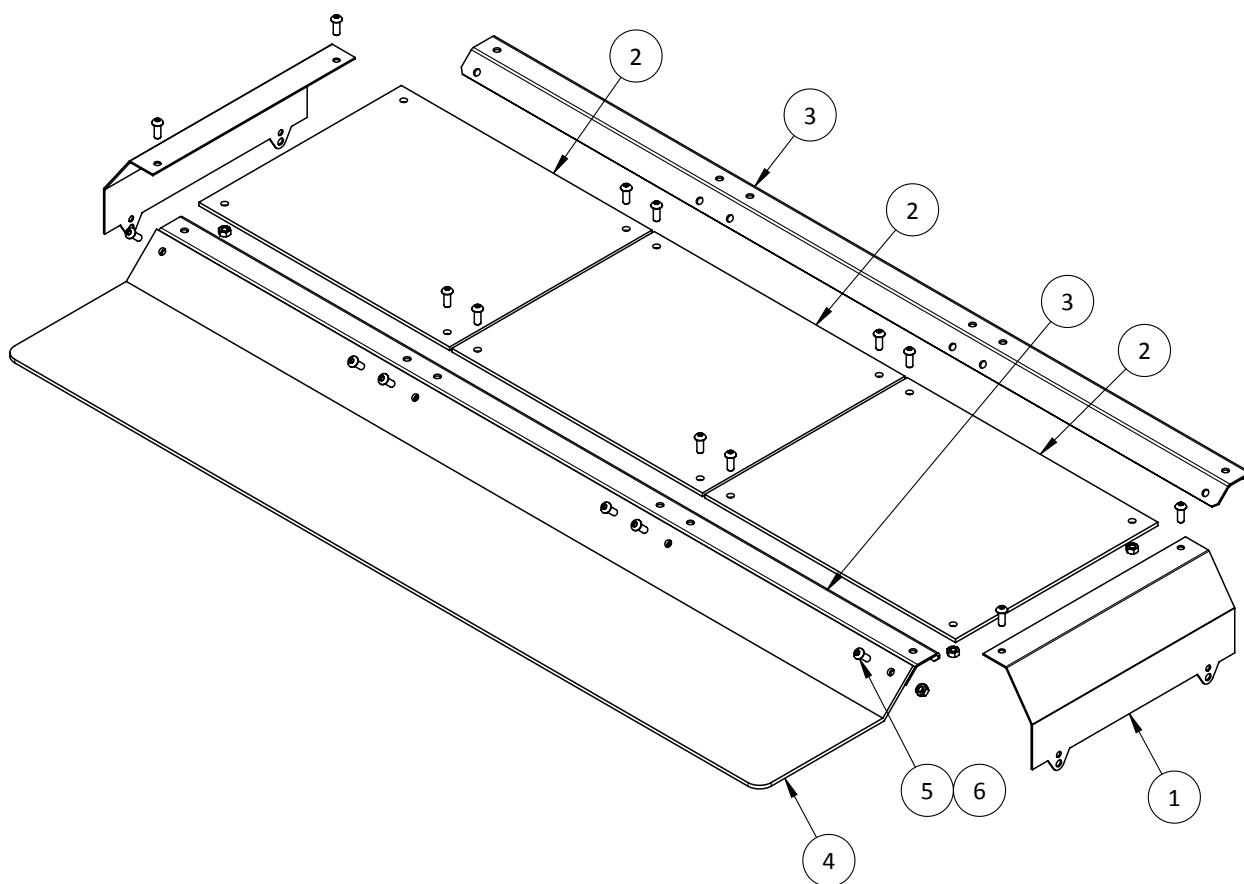
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	187 518 44 00		Thread Plate T350	1
2	189 518 44 00		Thread Plate T200	2
3	191 518 02 00		Transfer Plate T1000 x 95mm	1
4	191 518 43 00		Transfer Angle T1000	1
5		21 28 087	M8 x 20 Carriage Bolt, Zinc	2
6		21 63 049	M5 x 16 Countersunk Screw, Zinc	7
7		25 15 106	M8 Hex Nut, Zinc	2
8		26 02 111	M8 Flat Washer, Zinc	2



Transfer Complete 95mm			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 10 03	Transfer Complete T1000 x 95mm

## Section 2

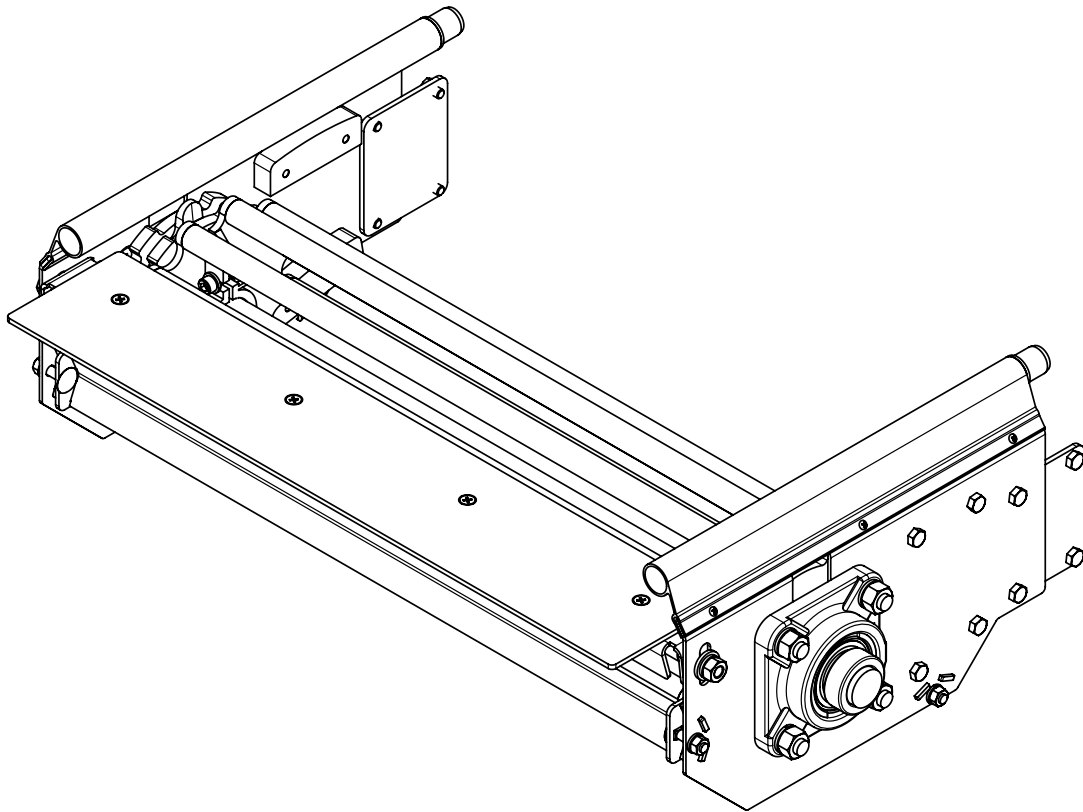
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	185 510 26 00		Cover Sidesheet	2
2	187 510 10 00		Top Cover T350	3
3	191 510 07 00		Cover U-Profile T1000	2
4	191 510 10 02		Transfer Cover T1000	1
5		21 90 068	M6 x 16 BHCS, Zinc	18
6		25 15 105	M6 Hex Nut, Zinc	18



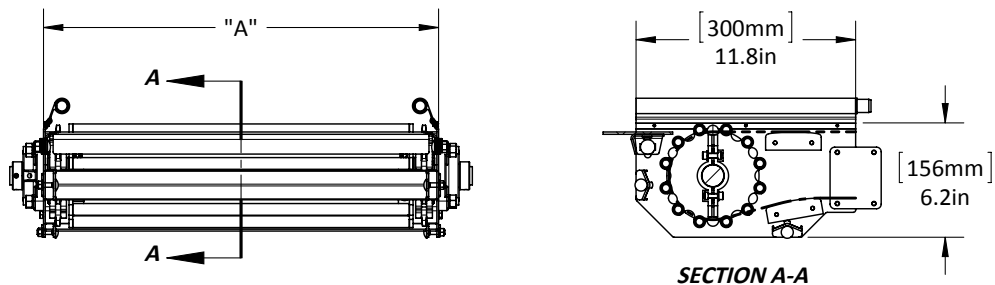
Cover Complete			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 56 10	Cover Complete T1000

## Section 2

### Idler Unit Stainless US T250 - T750



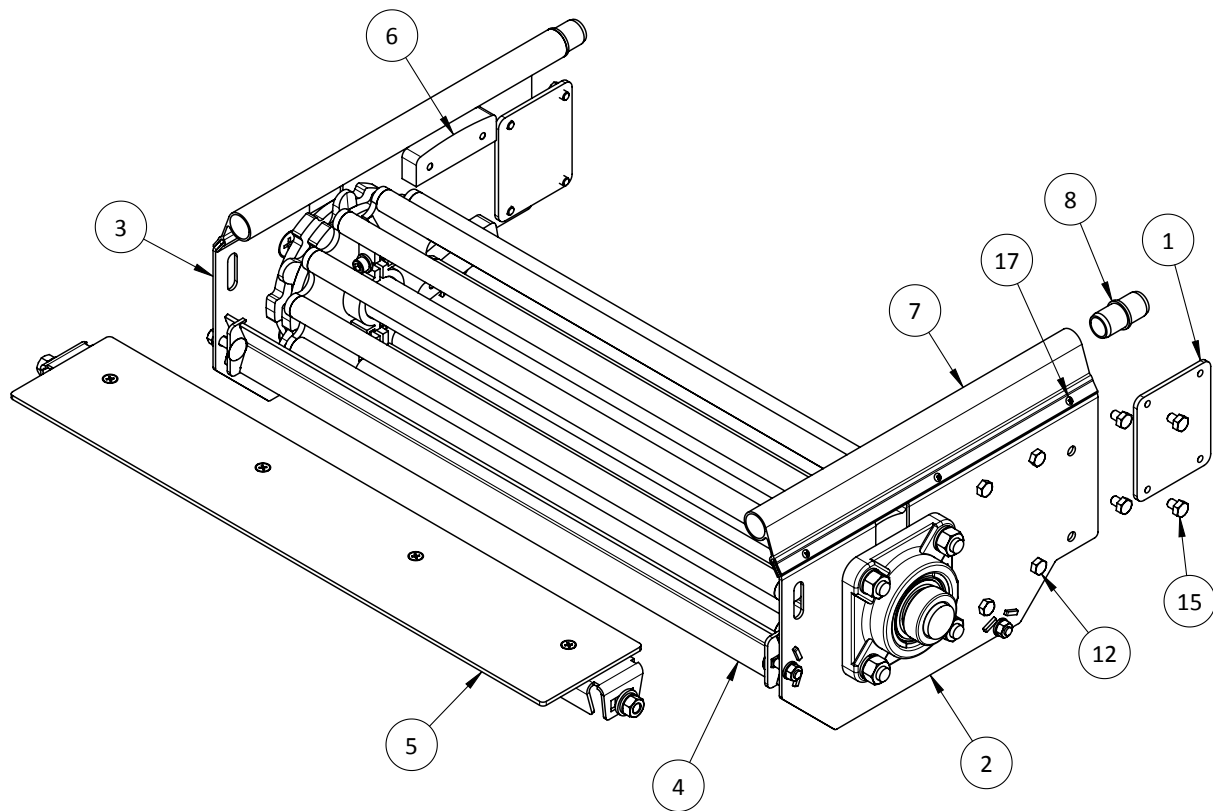
Idler Unit Stainless US			
Conveyor Type	Part Number	Drawing Number	Description
250	C201A	121 A 400 00A	Idler Unit T250 Stainless US
350	D201A	121 A 300 00A	Idler Unit T350 Stainless US
500	E201A	121 A 200 00A	Idler Unit T500 Stainless US
750	F201A	121 A 100 00A	Idler Unit T750 Stainless US



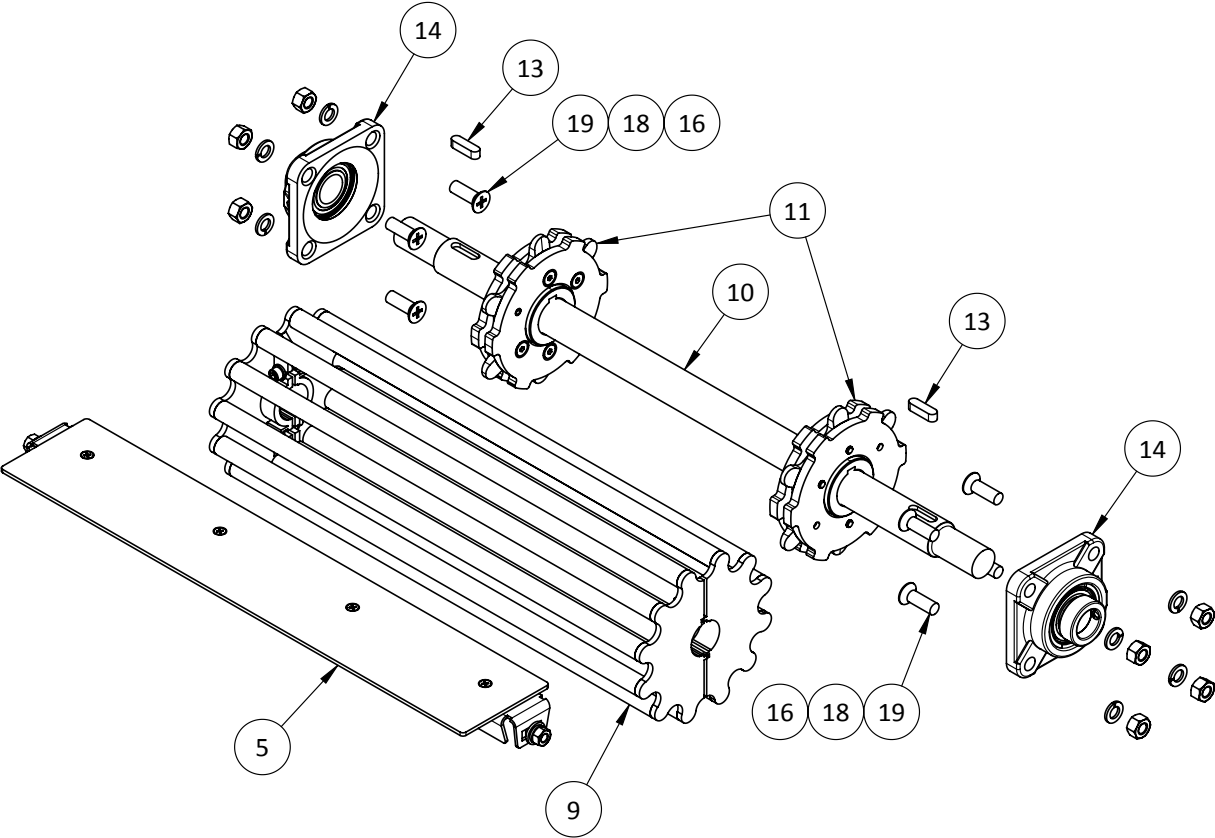
Idler Unit Stainless US							
Part Number	Conveyor Type	Description	A (mm/inches)	H1** min/max (mm/inches)	H2*** min/max (mm/inches)	H3**** min/max (mm/inches)	Chain Length (m/ft)
C201A	250	Idler Unit T250 Stainless US	290/11.4	190 - 320 7.5 12.6	310 - 610 12.2 - 24.0	600 - 1300 23.6 - 51.2	.6/2.0
D201A	350	Idler Unit T350 Stainless US	390/15.4				
E201A	500	Idler Unit T500 Stainless US	540/21.3				
F201A	750	Idler Unit T750 Stainless US	790/31.1				

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	12C A 010 04A		Thread Plate Stainless US	2	2	2	2
2	12I A 000 01A		Idler Sidesheet LH Stainless	1	1	1	1
3	12I A 000 02A		Idler Sidesheet RH Stainless	1	1	1	1
4	12I A 014 00A		Unit Traverse T250 Stainless	2	-	-	-
4	12I A 013 00A		Unit Traverse T350 Stainless	-	2	-	-
4	12I A 012 00A		Unit Traverse T500 Stainless	-	-	2	-
4	12I A 011 00A		Unit Traverse T750 Stainless	-	-	-	2
5	12I A 024 00A	C202A	Transfer Complete T250 Stainless	1	-	-	-
5	12I A 023 00A	D202A	Transfer Complete T350 Stainless	-	1	-	-
5	12I A 022 00A	E202A	Transfer Complete T500 Stainless	-	-	1	-
5	12I A 021 00A	F202A	Transfer Complete T750 Stainless	-	-	-	1
6	185 520 07 00		Curved Sliding Shoe	4	4	4	4
7	185 520 09 04		Mini Drive Capping	2	2	2	2
8	185 520 18 00		Intermediate Coupling	2	2	2	2
9	186 500 11 02		Discharge Wheel Complete T250	1	-	-	-
9	187 500 11 02		Discharge Wheel Complete T350	-	1	-	-
9	185 500 11 02		Discharge Wheel Complete T500	-	-	1	-
9	188 500 11 02		Discharge Wheel Complete T750	-	-	-	1
10	186 516 01 07		Return Shaft T250	1	-	-	-
10	187 516 01 07		Return Shaft T350	-	1	-	-
10	185 516 01 07		Return Shaft T500	-	-	1	-
10	188 516 01 07		Return Shaft T750	-	-	-	1
11	705 001 02 00		Main Drive Sprocket	2	2	2	2
12		23 56 068	M6 x 16 Hex Bolt, Stainless	8	8	8	8
13		27 43 070	8 x 7 x 28 Parallel Key	2	2	2	2
14		34 10 205	4-Bolt Flange Bearing 25mm	2	2	2	2
15		F8-7-46-2-144	M6 x 8 Hex Bolt, Stainless	8	8	8	8
16		F8-22-50-2-0	M10 Hex Nut, Stainless	8	8	8	8
17		F8-67-133-2-142	M2.9 x 6.5mm Self-Tapping Screw, Stainless	6	6	6	6
18		F8-96-50-0-0	M10 Lock Washer, Stainless	8	8	8	8
19		F8-58-50-2-171	M10 x 30 Countersunk Screw, Stainless	8	8	8	8



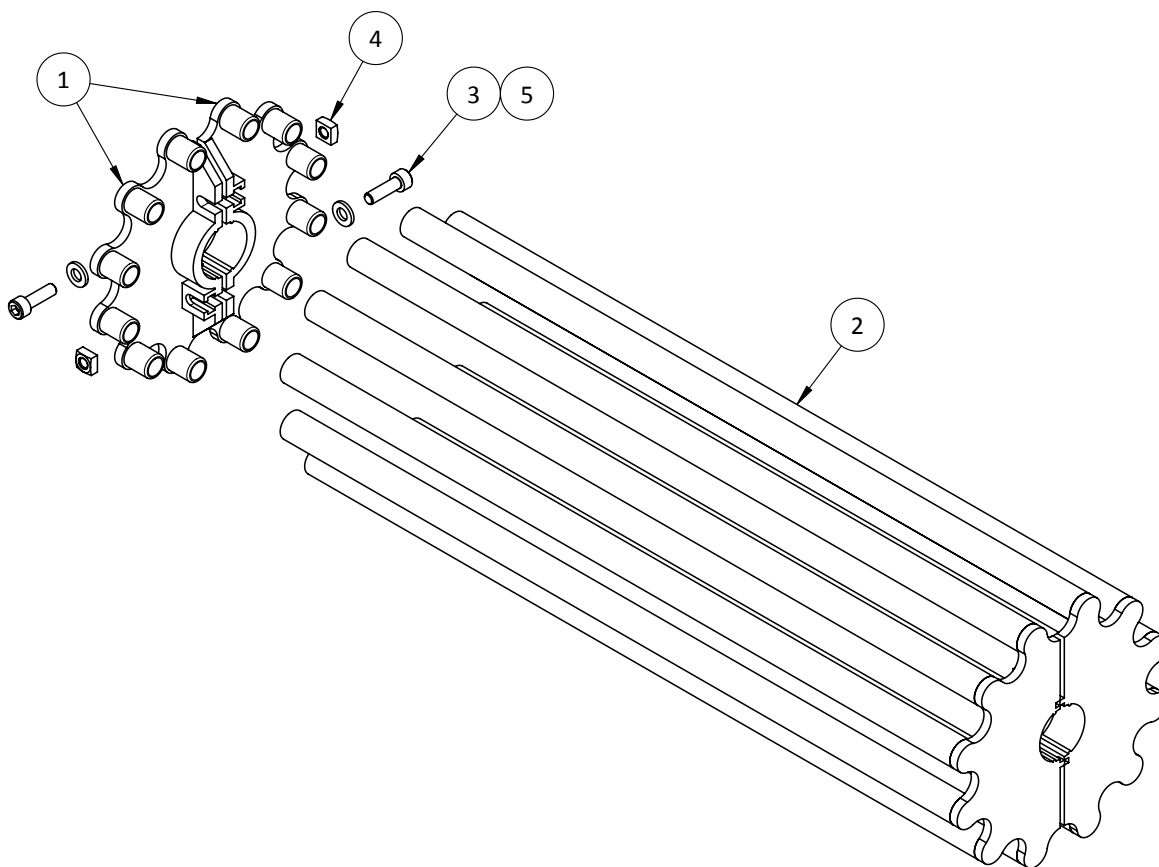
# Section 2



**RETURN SHAFT COMPONENTS DETAIL**

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 518 03 01		Driving Plate	4	4	4	4
2	186 518 05 01		Discharge Tube T250	12	-	-	-
2	187 518 05 01		Discharge Tube T350	-	12	-	-
2	185 518 05 01		Discharge Tube T500	-	-	12	-
2	188 518 05 01		Discharge Tube T750	-	-	-	12
3		21 42 069	M6 x 20 SHCS, Zinc	4	4	4	4
4		25 09 105	M6 Square Nut, Zinc	4	4	4	4
5		26 02 109	M6 Flat Washer, Zinc	4	4	4	4

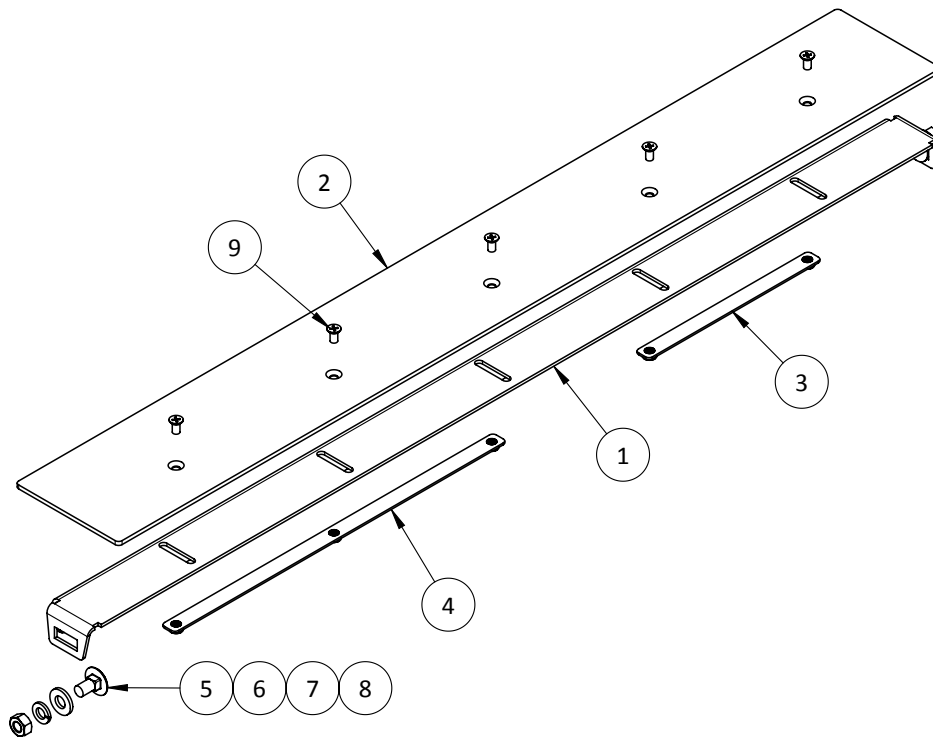


Discharge Wheel Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 11 02	Discharge Wheel Complete T250
350	--	187 500 11 02	Discharge Wheel Complete T350
500	--	185 500 11 02	Discharge Wheel Complete T500
750	--	188 500 11 02	Discharge Wheel Complete T750

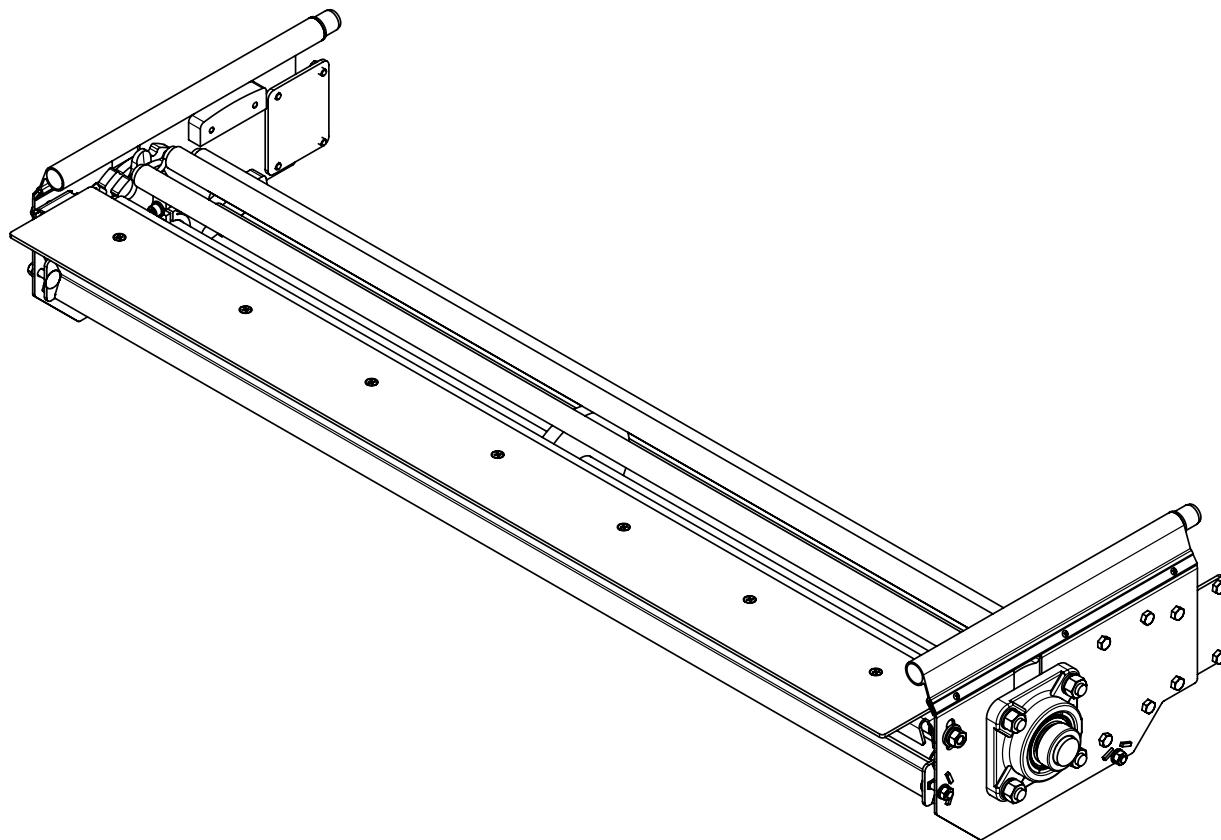


## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	12I A 024 01A		Transfer Support T250 Stainless	1	-	-	-
1	12I A 023 01A		Transfer Support T350 Stainless	-	1	-	-
1	12I A 022 01A		Transfer Support T500 Stainless	-	-	1	-
1	12I A 021 01A		Transfer Support T750 Stainless	-	-	-	1
2	186 518 02 00		Transfer Plate T250 x 95mm	1	-	-	-
2	187 518 02 00		Transfer Plate T350 x 95mm	-	1	-	-
2	185 518 02 00		Transfer Plate T500 x 95mm	-	-	1	-
2	188 518 02 00		Transfer Plate T750 x 95mm	-	-	-	1
3	12I A 025 00A		Nut Plate Assembly 145mm Stainless	1	-	2	1
4	12I A 026 00A		Nut Plate Assembly 290mm Stainless	-	1	-	1
5		F8-3-48-2-157	M8 x 16 Carriage Bolt, Stainless	2	2	2	2
6		F8-92-48-0-0	M8 Flat Washer, Stainless	2	2	2	2
7		F8-96-48-0-0	M8 Lock Washer, Stainless	2	2	2	2
8		F8-22-48-2-0	M8 Hex Nut, Stainless	2	2	2	2
9		F8-63-45-2-152	M5 x 10 Countersunk Screw, Stainless	2	3	4	5

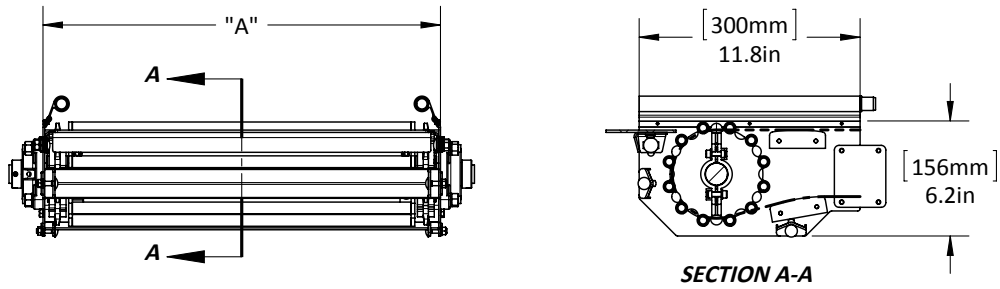


Transfer Complete Stainless			
Conveyor Type	Part Number	Drawing Number	Description
250	C202A	12I A 024 00A	Transfer Complete T250 Stainless
350	D202A	12I A 023 00A	Transfer Complete T350 Stainless
500	E202A	12I A 022 00A	Transfer Complete T500 Stainless
750	F202A	12I A 021 00A	Transfer Complete T750 Stainless

**Idler Unit Stainless US T1000**

Idler Unit Stainless US			
Conveyor Type	Part Number	Drawing Number	Description
1000	G201A	12I A 000 00A	Idler Unit T1000 Stainless US

## Section 2



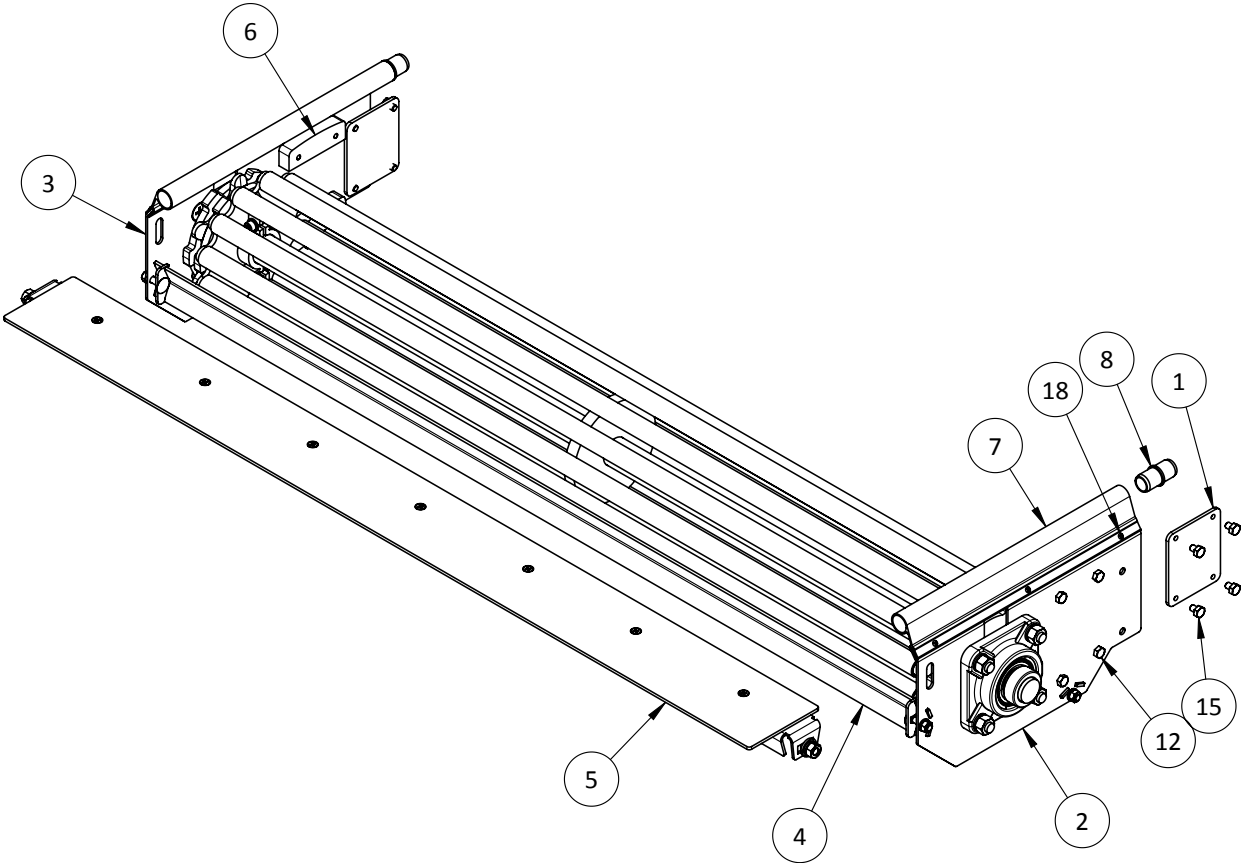
Idler Unit Stainless US							
Part Number	Conveyor Type	Description	A (mm/inches)	H1** min/max (mm/inches)	H2*** min/max (mm/inches)	H3**** min/max (mm/inches)	Chain Length (m/ft)
G201A	1000	Idler Unit T1000 Stainless US	1040/41.0	190 - 320 7.5 12.6	310 - 610 12.2 - 24.0	600 - 1300 23.6 - 51.2	.6/2.0

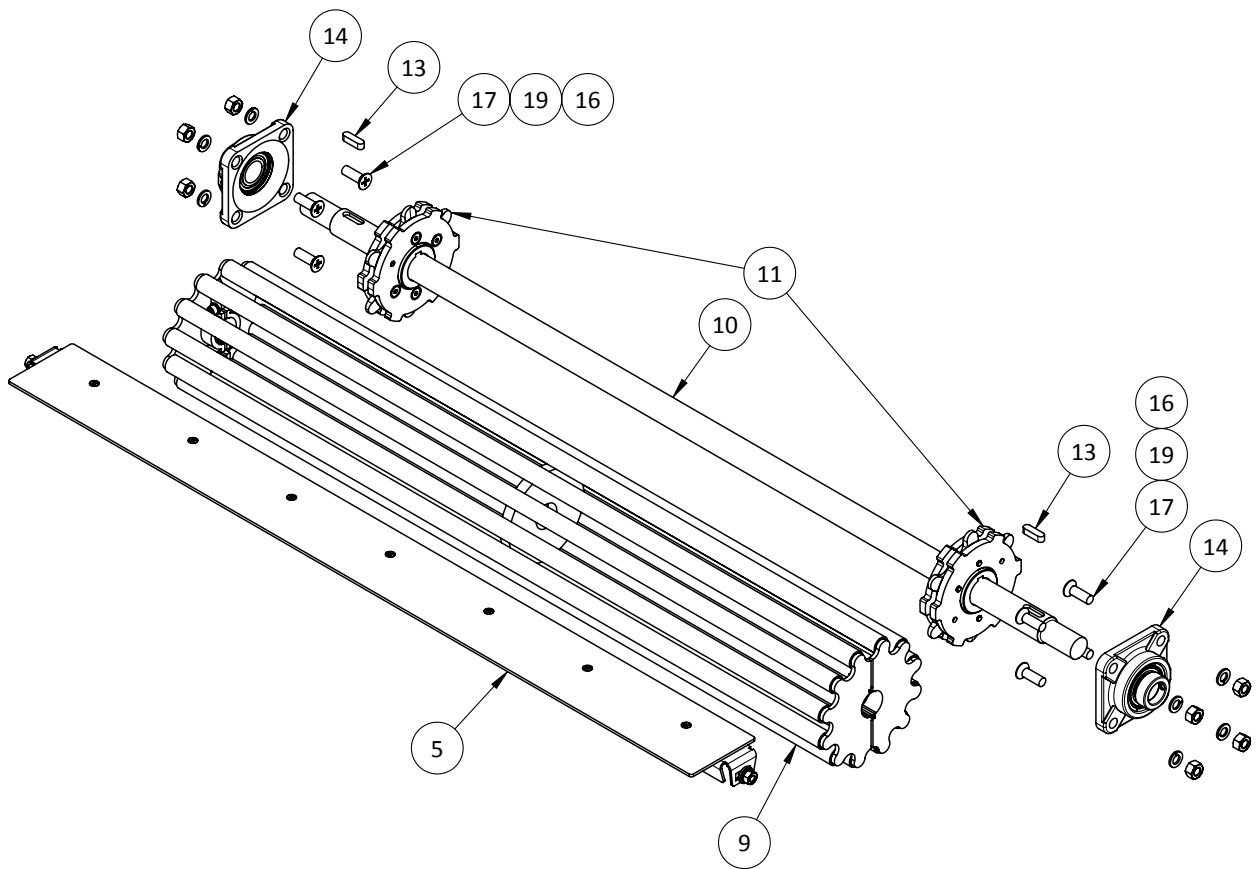
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	12C A 010 04A		Thread Plate Stainless US	2
2	12I A 000 01A		Idler Sidesheet LH Stainless	1
3	12I A 000 02A		Idler Sidesheet RH Stainless	1
4	12I A 010 00A		Unit Traverse T1000 Stainless	2
5	12I A 020 00A	G202A	Transfer Complete T1000 Stainless	1
6	185 520 07 00		Curved Sliding Shoe	4
7	185 520 09 04		Mini Drive Capping	2
8	185 520 18 00		Intermediate Coupling	2
9	191 500 11 02		Discharge Wheel Complete T1000	1
10	191 516 01 07		Return Shaft T1000	1
11	705 001 02 00		Main Drive Sprocket	2
12		23 56 068	M6 x 16 Hex Bolt, Stainless	8
13		27 43 070	8 x 7 x 28 Parallel Key	2
14		34 10 205	4-Bolt Flange Bearing 25mm	2
15		F8-7-46-2-144	M6 x 8 Hex Bolt, Stainless	8
16		F8-22-50-2-0	M10 Hex Nut, Stainless	8
17		F8-58-50-2-171	M10 x 30 Countersunk Screw, Stainless	8
18		F8-67-133-2-142	M2.9 x 6.5mm Self-Tapping Screw, Stainless	6
19		F8-96-50-0-0	M10 Lock Washer, Stainless	8

# Section 2

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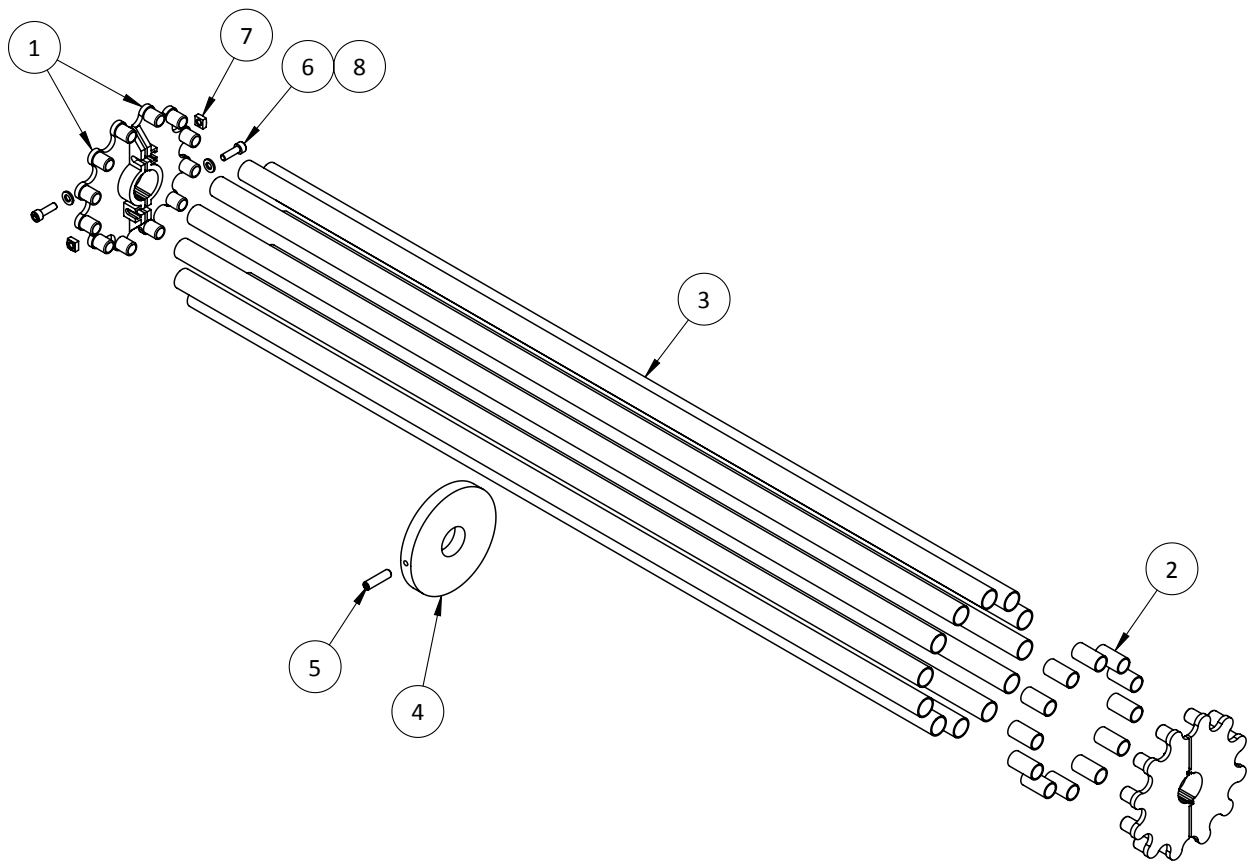




**RETURN SHAFT COMPONENTS DETAIL**

## Section 2

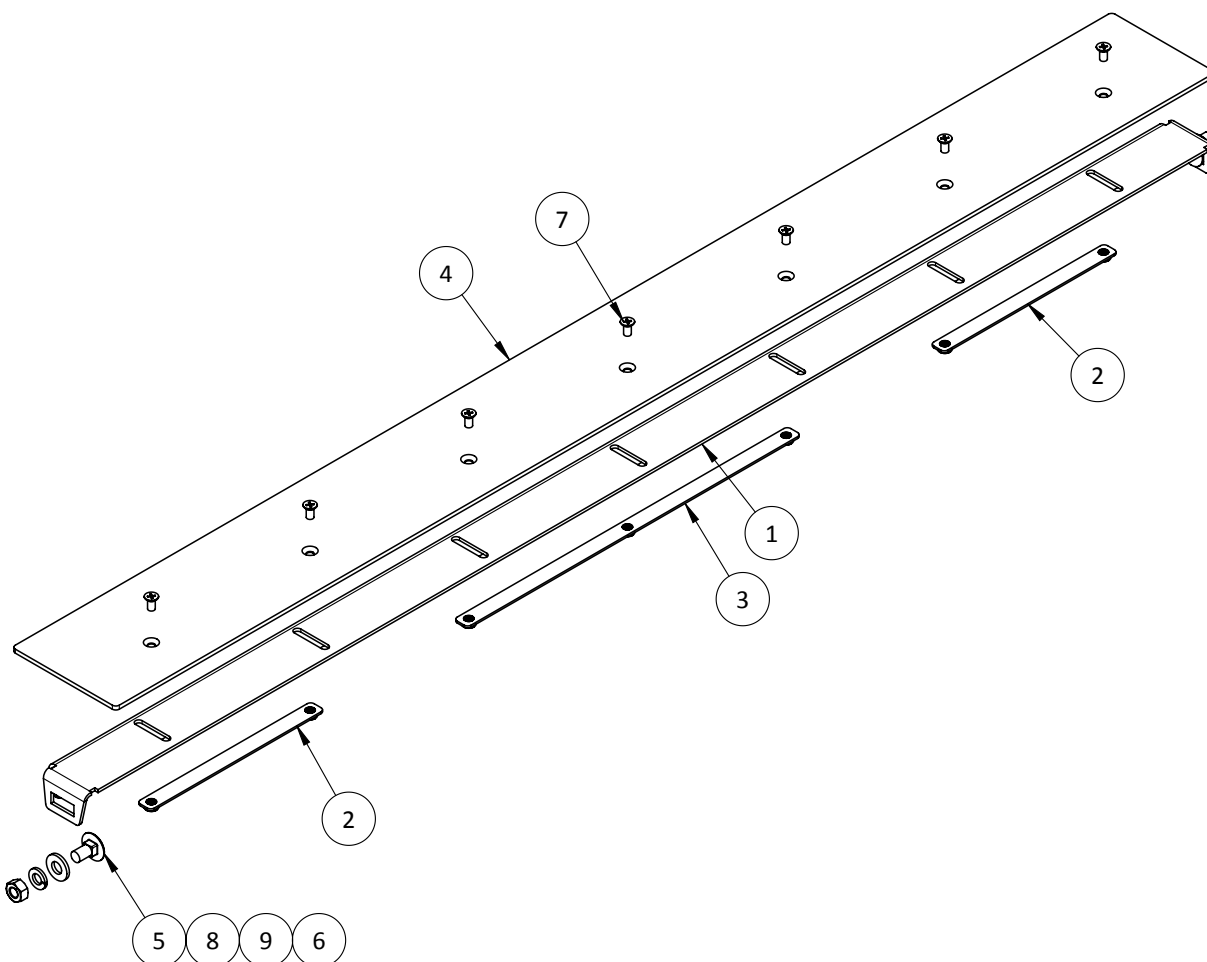
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 518 03 01		Driving Plate	4
2	191 518 04 01		Discharge Tube Plug T1000	24
3	191 518 05 01		Discharge Tube T1000	12
4	191 518 13 00		Center Wheel	1
5		20 46 089	M8 x 30 Grub Screw, Zinc	1
6		21 42 069	M6 x 20 SHCS, Zinc	4
7		25 09 105	M6 Square Nut, Zinc	4
8		26 02 109	M6 Flat Washer, Zinc	4



Discharge Wheel Complete			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 11 02	Discharge Wheel Complete T1000

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	12I A 020 01A		Transfer Support T1000 Stainless	1
2	12I A 025 00A		Nut Plate Assembly 145mm Stainless	2
3	12I A 026 00A		Nut Plate Assembly 290mm Stainless	1
4	191 518 02 00		Transfer Plate T1000 x 95mm	1
5		F8-3-48-2-157	M8 x 16 Carriage Bolt, Stainless	2
6		F8-22-48-2-0	M8 Hex Nut, Stainless	2
7		F8-63-45-2-152	M5 x 10 Countersunk Screw, Stainless	7
8		F8-92-48-0-0	M8 Flat Washer, Stainless	2
9		F8-96-48-0-0	M8 Lock Washer, Stainless	2

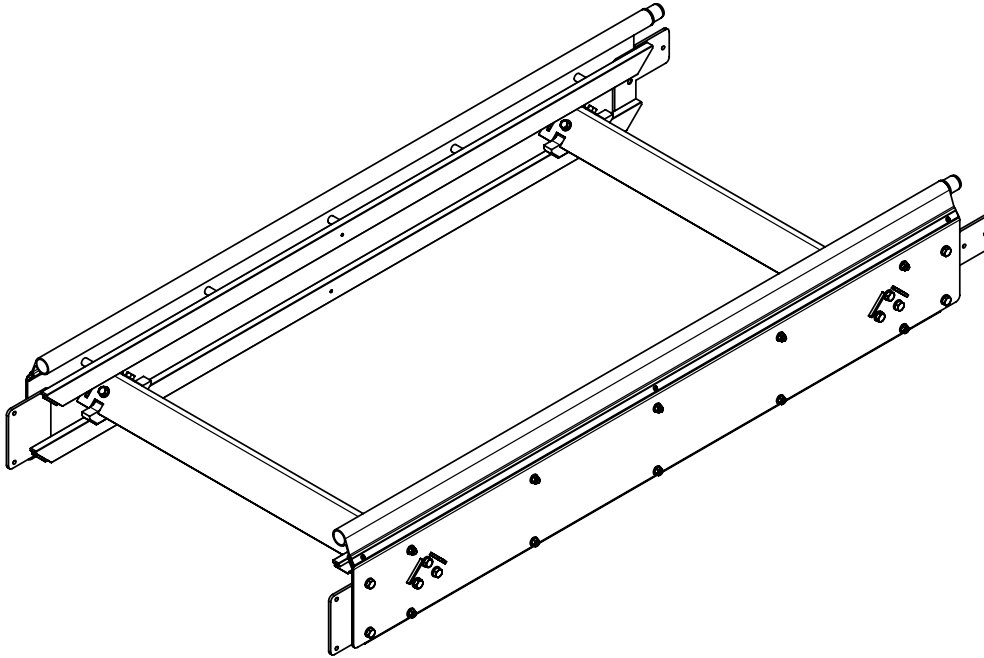


Transfer Complete Stainless			
Conveyor Type	Part Number	Drawing Number	Description
1000	G202A	12I A 020 00A	Transfer Complete T1000 Stainless

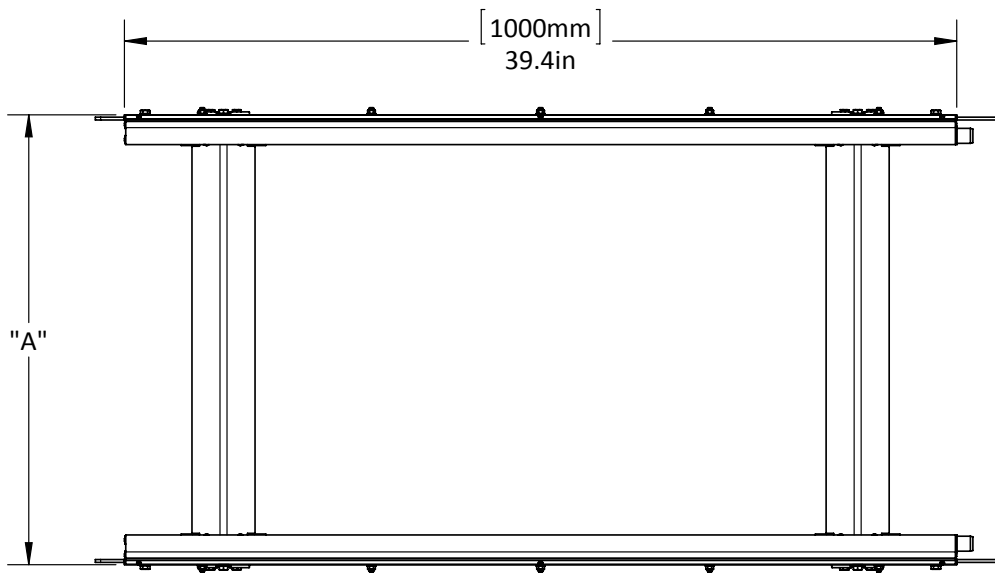


## Section 2

### Connecting Part 1m Closed Stainless US T250 - T750



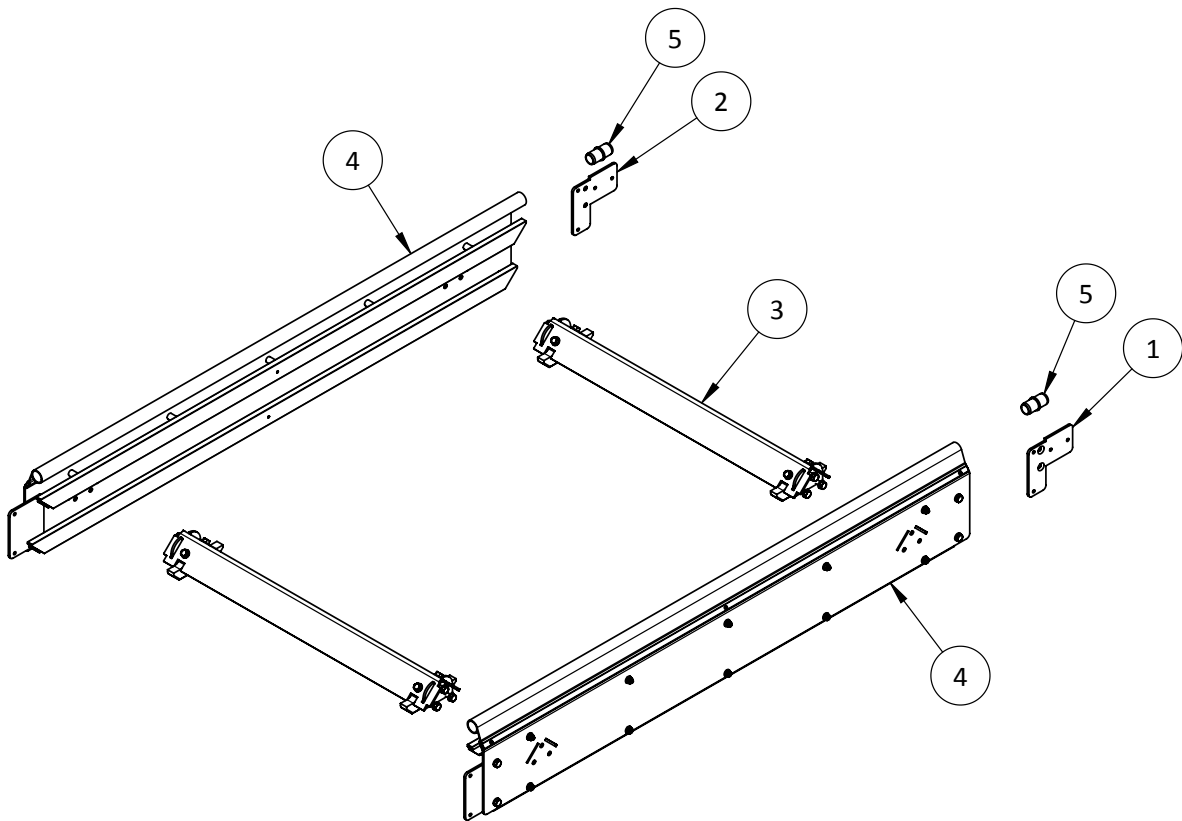
Connecting Part 1m Closed Stainless US			
Conveyor Type	Part Number	Drawing Number	Description
250	C203A	12P A 400 00A	Connecting Part T250 1m Closed Stainless US
350	D203A	12P A 300 00A	Connecting Part T350 1m Closed Stainless US
500	E203A	12P A 200 00A	Connecting Part T500 1m Closed Stainless US
750	F203A	12P A 100 00A	Connecting Part T750 1m Closed Stainless US



<b>Connecting Part 1m Closed Stainless US</b>				
<b>Part Number</b>	<b>Conveyor Type</b>	<b>Drawing Number</b>	<b>Description</b>	<b>A (mm/inches)</b>
C203A	250	12P A 400 00A	Connecting Part 1m T250 Closed Stainless US	290/11.4
D203A	350	12P A 300 00A	Connecting Part 1m T350 Closed Stainless US	390/15.4
E203A	500	12P A 200 00A	Connecting Part 1m T500 Closed Stainless US	540/21.3
F203A	750	12P A 100 00A	Connecting Part 1m T750 Closed Stainless US	790/31.1

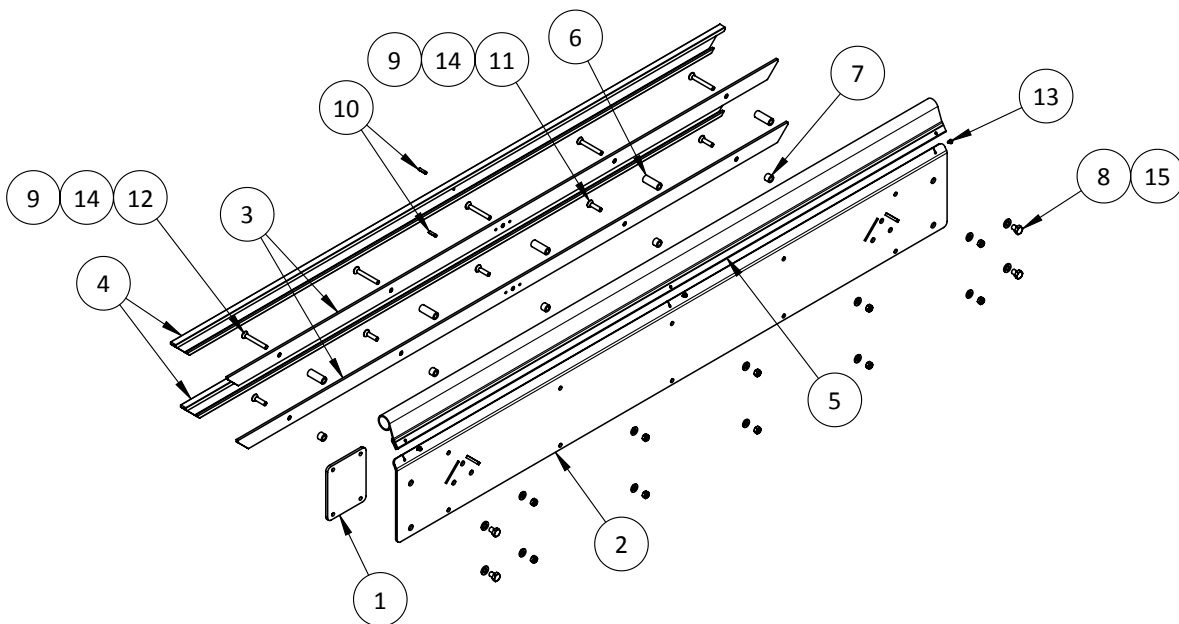
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	12C A 000 03A		Adapter Thread Plate, RH	1	1	1	1
2	12C A 000 04A		Adapter Thread Plate, LH	1	1	1	1
3	12C A 024 00A		Traverse Stainless T250	2	-	-	-
3	12C A 023 00A		Traverse Stainless T350	-	2	-	-
3	12C A 022 00A		Traverse Stainless T500	-	-	2	-
3	12C A 021 00A		Traverse Stainless T750	-	-	-	2
4	12P A 010 00A		Sidesheet Complete 1m Stainless US	2	2	2	2
5	185 520 18 00		Intermediate Coupling	2	2	2	2



## Section 2

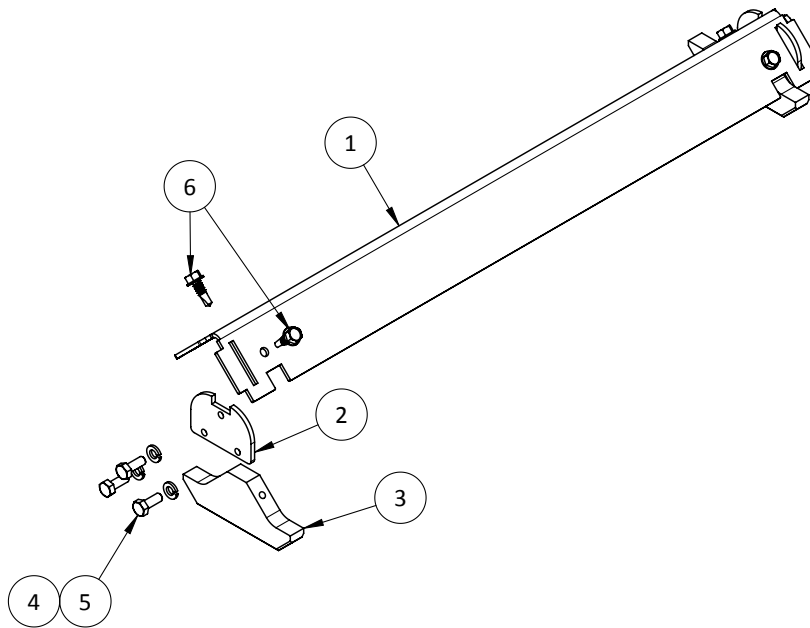
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	12C A 010 04A		Thread Plate Stainless US	1
2	12P A 010 01A		Sidesheet 1m Stainless US	1
3	12P A 010 02A		Bearing Bar 1m	2
4	12P A 010 03A		Bearing Strip 1m	2
5	12P A 010 05A		Capping Connecting Part 1m Stainless	1
6		92320A569	Spacer 1"	5
7		92320A814	Spacer 9/32"	5
8		F8-7-46-2-144	M6 x 8 Hex Bolt, Stainless	4
9		F8-29-45-2-0	M5 Nylock Nut, Stainless	10
10		F8-38-17-0-8	1/8" x 1/2" Roll Pin, Stainless	2
11		F8-58-45-2-161	M5 x 20mm FHCS, Stainless	5
12		F8-58-45-2-181	M5 x 40mm FHCS, Stainless	5
13		F8-67-133-2-142	M2.9 x 6.5mm Self-Tapping Screw, Stainless	3
14		F8-92-45-0-0	M5 Flat Washer, Stainless	10
15		F8-92-46-0-0	M6 Flat Washer, Stainless	4



Sidesheet Complete 1m Stainless US			
Conveyor Type	Part Number	Drawing Number	Description
250	--	12P A 010 00A	Sidesheet Complete 1m Stainless US
350			
500			
750			

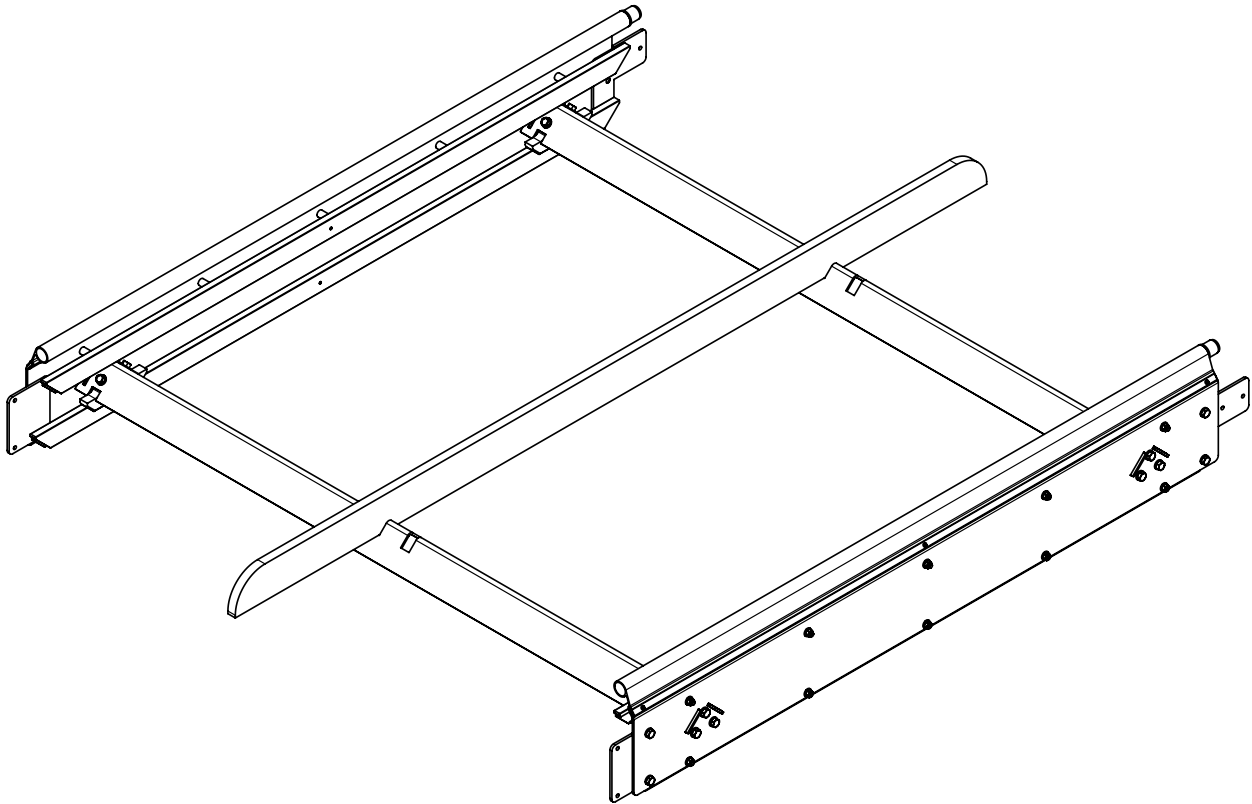
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	12C A 060 01A		Traverse Angle T250 Stainless	1	-	-	-
1	12C A 050 01A		Traverse Angle T350 Stainless	-	1	-	-
1	12C A 040 01A		Traverse Angle T500 Stainless	-	-	1	-
1	12C A 030 01A		Traverse Angle T750 Stainless	-	-	-	1
2	12C A 020 02A		Traverse Mount Plate Stainless	2	2	2	2
3	12C A 020 03A		Sliding Shoe	2	2	2	2
4		F8-96-46-0-0	M6 Lockwasher, Stainless	6	6	6	6
5		23 56 068	M6 x 16mm Hex Bolt, Stainless	6	6	6	6
6		F8-66-19-0-12	1/4" x 3/4" Hex Head Self-Tapping Screw, Stainless	4	4	4	4



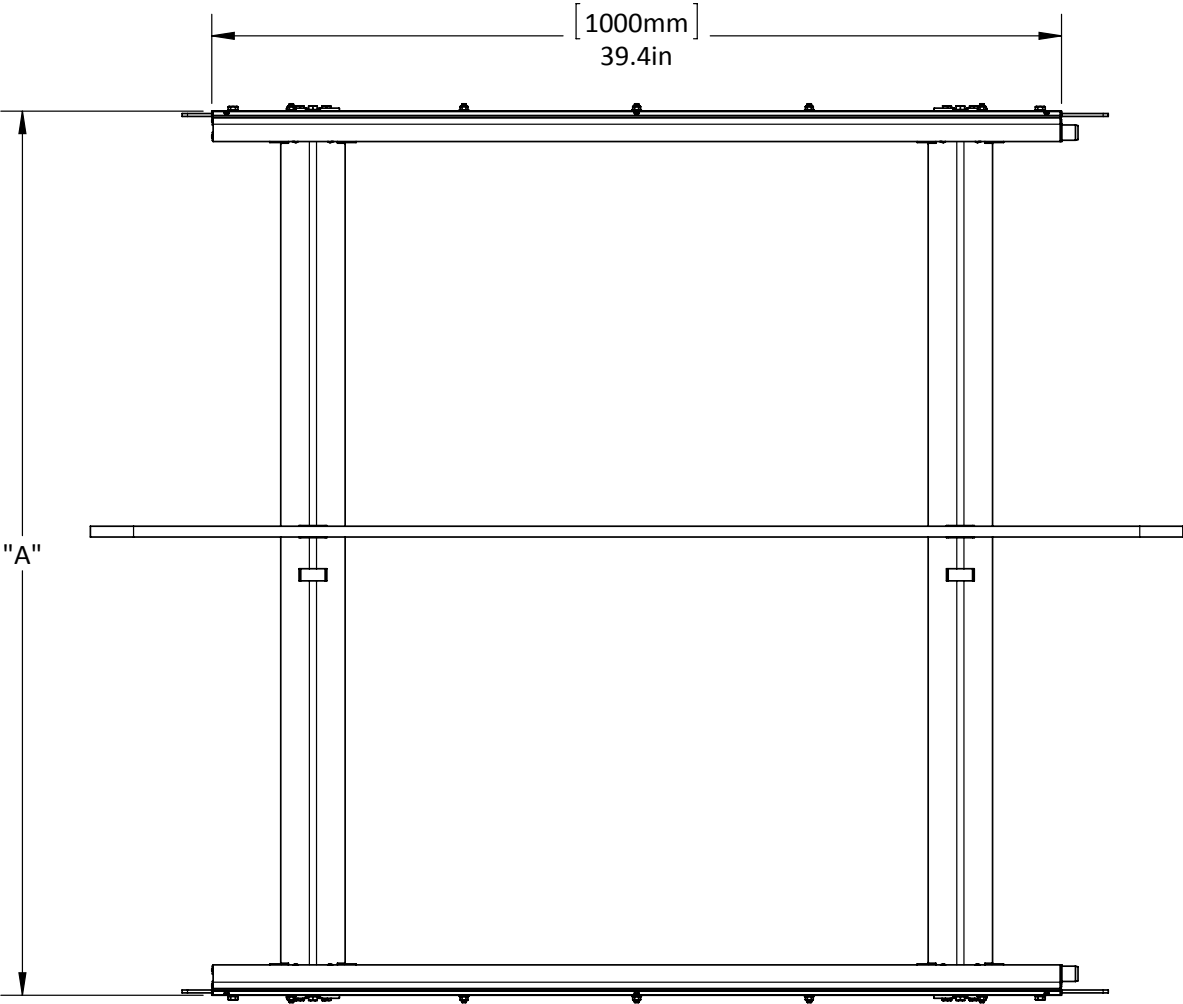
Traverse Stainless			
Conveyor Type	Part Number	Drawing Number	Description
250	--	12C A 024 00A	Traverse Stainless T250
350	--	12C A 023 00A	Traverse Stainless T350
500	--	12C A 022 00A	Traverse Stainless T500
750	--	12C A 021 00A	Traverse Stainless T750

---

**Connecting Part 1m Closed Stainless US T1000**

Connecting Part 1m Closed Stainless US			
Conveyor Type	Part Number	Drawing Number	Description
1000	G203A	12P A 000 00A	Connecting Part T1000 1m Closed Stainless US

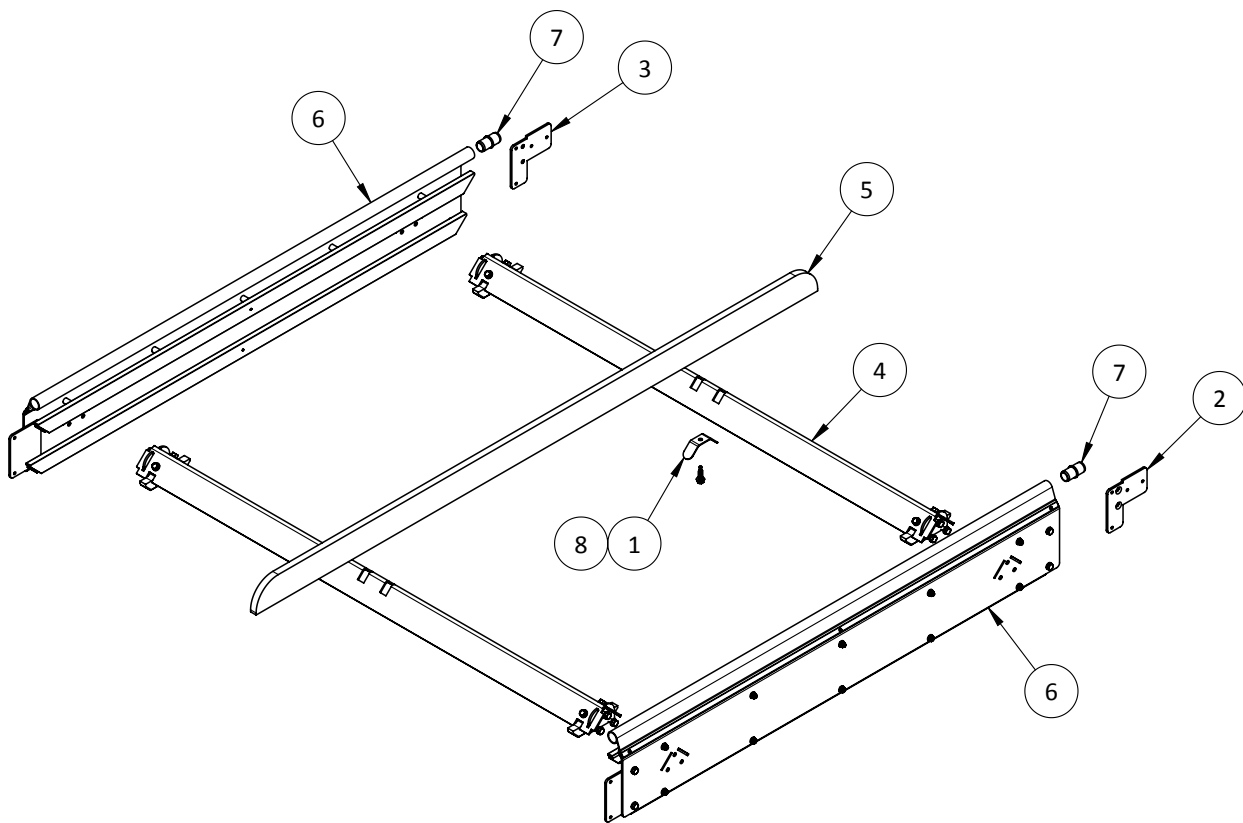
# Section 2



Connecting Part 1m Closed Stainless US				
Part Number	Conveyor Type	Drawing Number	Description	A (mm/inches)
G203A	1000	12P A 000 00A	Connecting Part 1m T1000 Closed Stainless US	1040/41.0

## Section 2

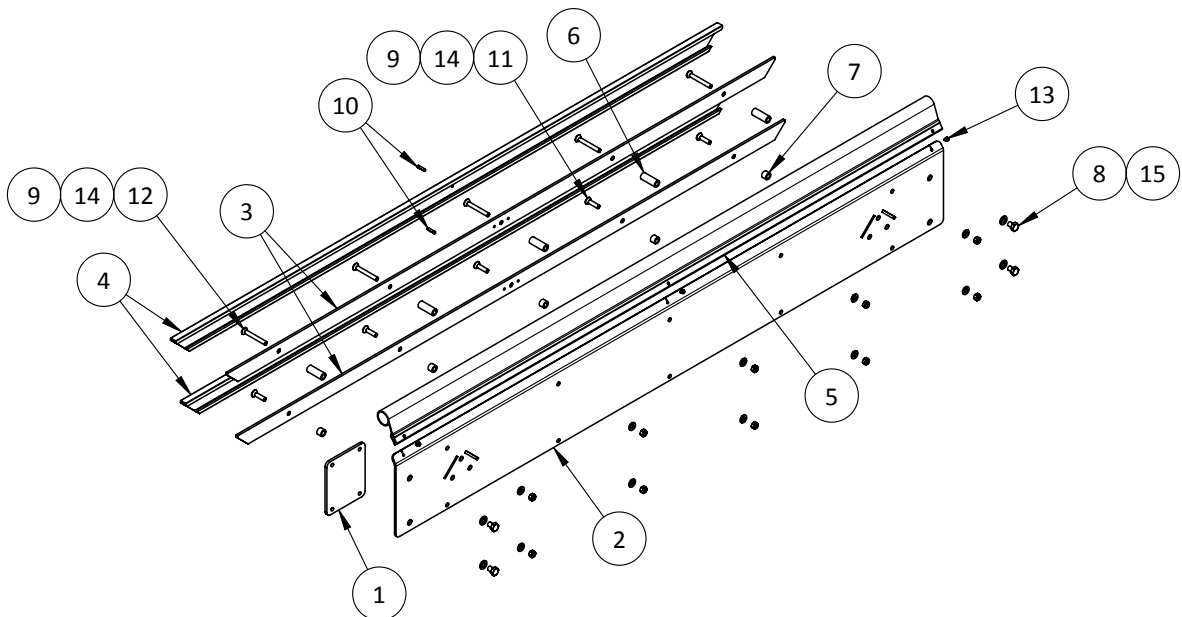
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	12C A 000 02A		Runner Mount	1
2	12C A 000 03A		Adapter Thread Plate, RH	1
3	12C A 000 04A		Adapter Thread Plate, LH	1
4	12C A 020 00A		Traverse Stainless T1000	2
5	12P A 000 01A		Center Bearing Runner, 1m	1
6	12P A 010 00A		Sidesheet Complete 1m Stainless US	2
7	185 520 18 00		Intermediate Coupling	2
8		F8-66-19-0-16	1/4" x 1" Hex Head Self-Tapping Screw, Stainless	1





## Section 2

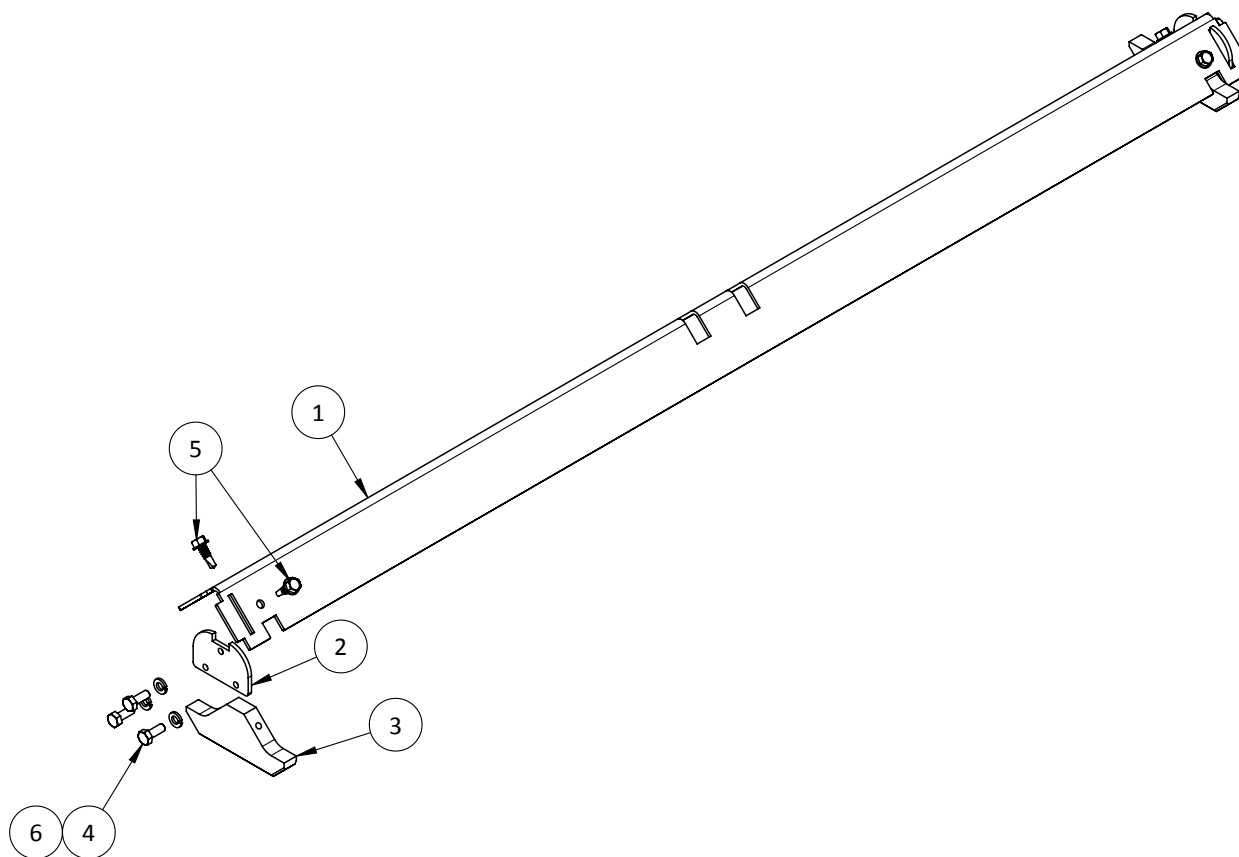
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	12C A 010 04A		Thread Plate Stainless US	1
2	12P A 010 01A		Sidesheet 1m Stainless US	1
3	12P A 010 02A		Bearing Bar 1m	2
4	12P A 010 03A		Bearing Strip 1m	2
5	12P A 010 05A		Capping Connecting Part 1m Stainless	1
6		92320A569	Spacer 1"	5
7		92320A814	Spacer 9/32"	5
8		F8-7-46-2-144	M6 x 8 Hex Bolt, Stainless	4
9		F8-29-45-2-0	M5 Nylock Nut, Stainless	10
10		F8-38-17-0-8	1/8" x 1/2" Roll Pin, Stainless	2
11		F8-58-45-2-161	M5 x 20mm FHCS, Stainless	5
12		F8-58-45-2-181	M5 x 40mm FHCS, Stainless	5
13		F8-67-133-2-142	M2.9 x 6.5mm Self-Tapping Screw, Stainless	3
14		F8-92-45-0-0	M5 Flat Washer, Stainless	10
15		F8-92-46-0-0	M6 Flat Washer, Stainless	4



Sidesheet Complete 1m Stainless US			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	12P A 010 00A	Sidesheet Complete 1m Stainless US

## Section 2

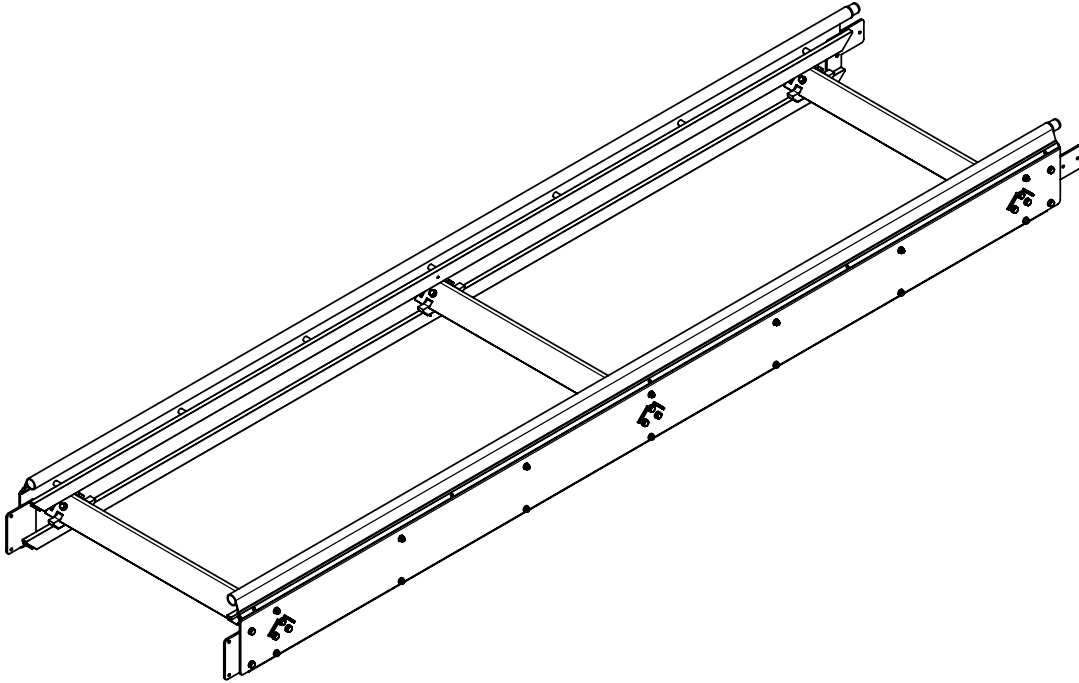
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	12C A 020 01A		Traverse Angle T1000 Stainless	1
2	12C A 020 02A		Traverse Mount Plate Stainless	2
3	12C A 020 03A		Sliding Shoe	2
4		23 56 068	M6 x 16mm Hex Bolt, Stainless	6
5		F8-66-19-0-12	1/4" x 3/4" Hex Head Self-Tapping Screw, Stainless	4
6		F8-96-46-0-0	M6 Lockwasher, Stainless	6



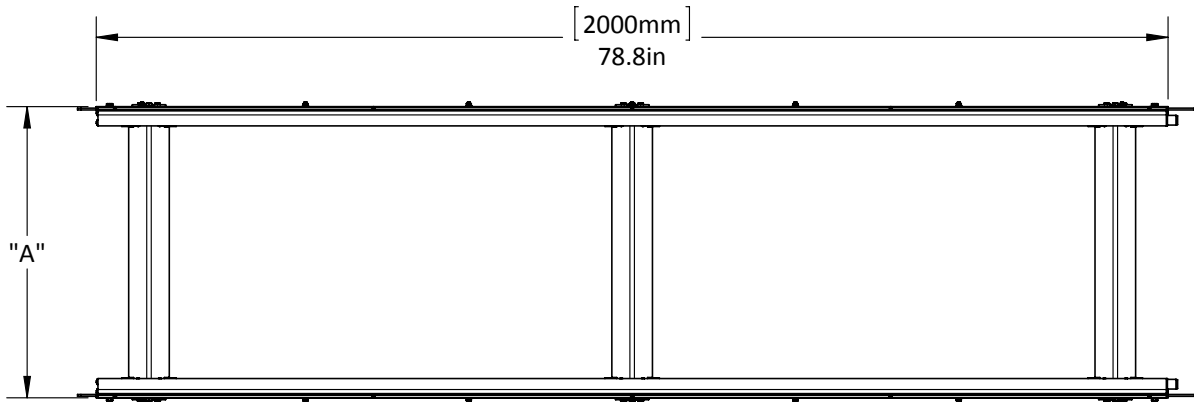
Traverse Stainless			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	12C A 020 00A	Traverse Stainless T1000

## Section 2

### Connecting Part 2m Closed Stainless US T250 - T750



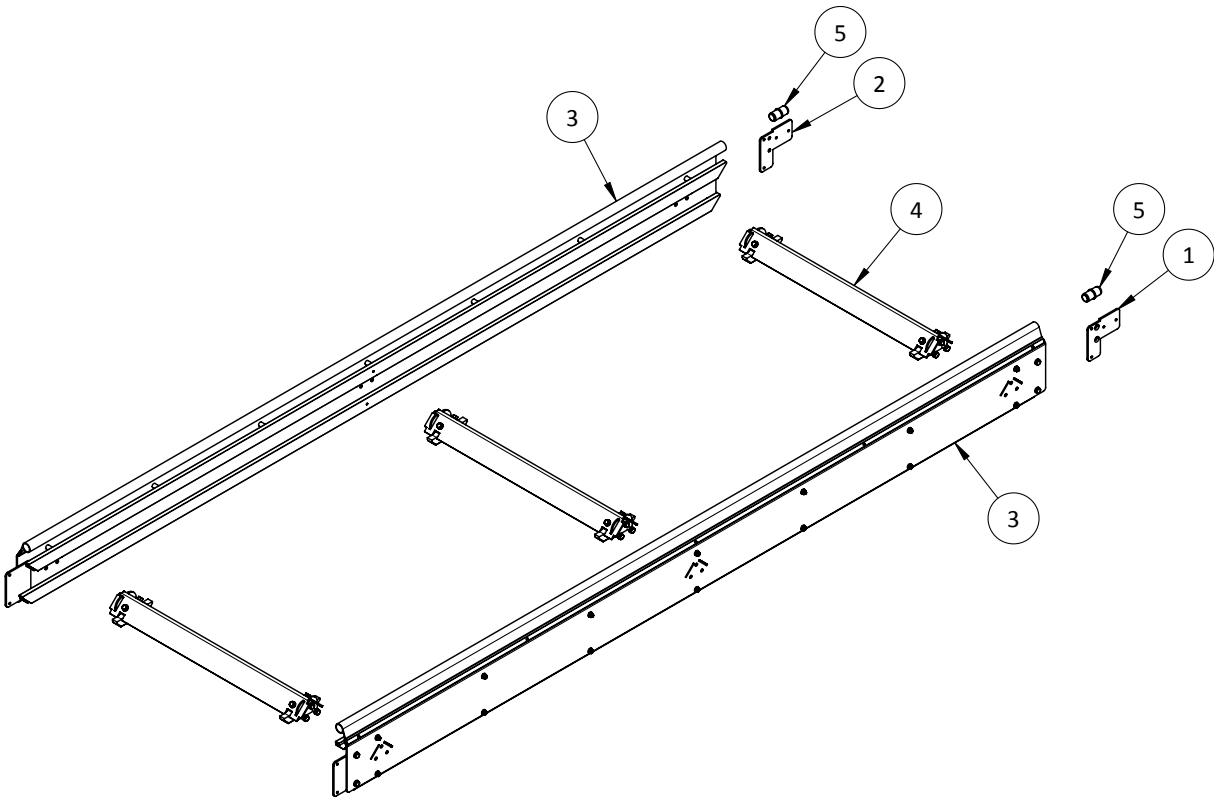
Connecting Part 2m Closed Stainless US			
Conveyor Type	Part Number	Drawing Number	Description
250	C200A	12C A 400 00A	Connecting Part T250 2m Closed Stainless US
350	D200A	12C A 300 00A	Connecting Part T350 2m Closed Stainless US
500	E200A	12C A 200 00A	Connecting Part T500 2m Closed Stainless US
750	F200A	12C A 100 00A	Connecting Part T750 2m Closed Stainless US



Connecting Part 2m Closed Stainless US				
Part Number	Conveyor Type	Drawing Number	Description	A (mm/inches)
C200A	250	12C A 400 00A	Connecting Part 2m T250 Closed Stainless US	290/11.4
D200A	350	12C A 300 00A	Connecting Part 2m T350 Closed Stainless US	390/15.4
E200A	500	12C A 200 00A	Connecting Part 2m T500 Closed Stainless US	540/21.3
F200A	750	12C A 100 00A	Connecting Part 2m T750 Closed Stainless US	790/31.1

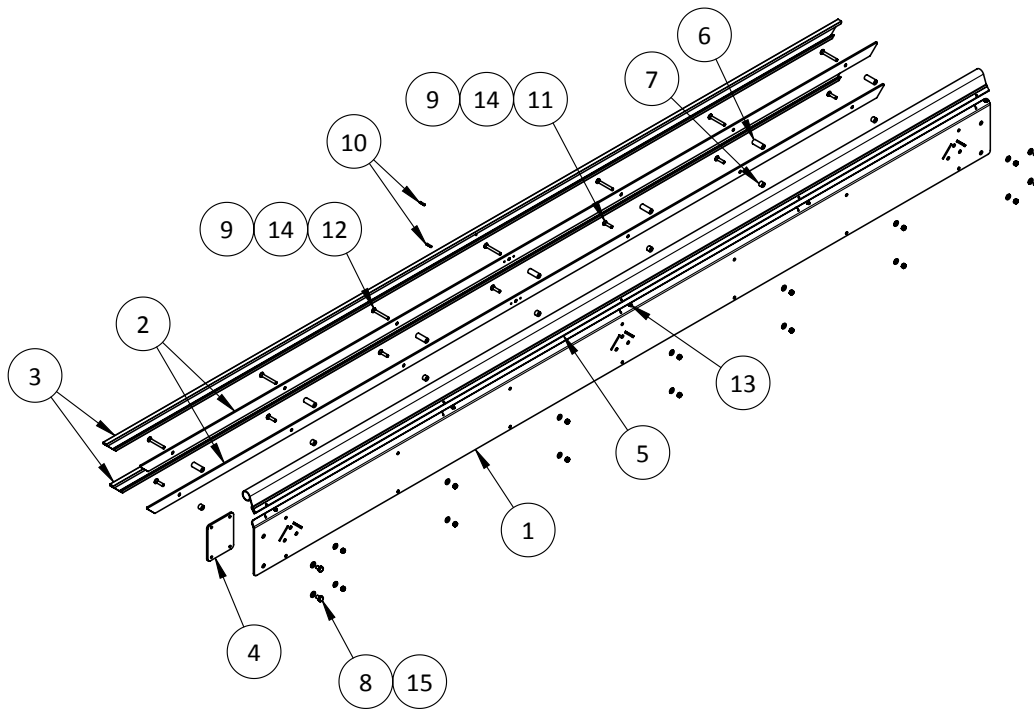
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	12C A 000 03A		Adapter Thread Plate, RH	1	1	1	1
2	12C A 000 04A		Adapter Thread Plate, LH	1	1	1	1
3	12C A 010 00A		Sidesheet Complete 2m Stainless US	2	2	2	2
4	12C A 024 00A		Traverse Stainless T250	3	-	-	-
4	12C A 023 00A		Traverse Stainless T350	-	3	-	-
4	12C A 022 00A		Traverse Stainless T500	-	-	3	-
4	12C A 021 00A		Traverse Stainless T750	-	-	-	3
5	185 520 18 00		Intermediate Coupling	2	2	2	2



## Section 2

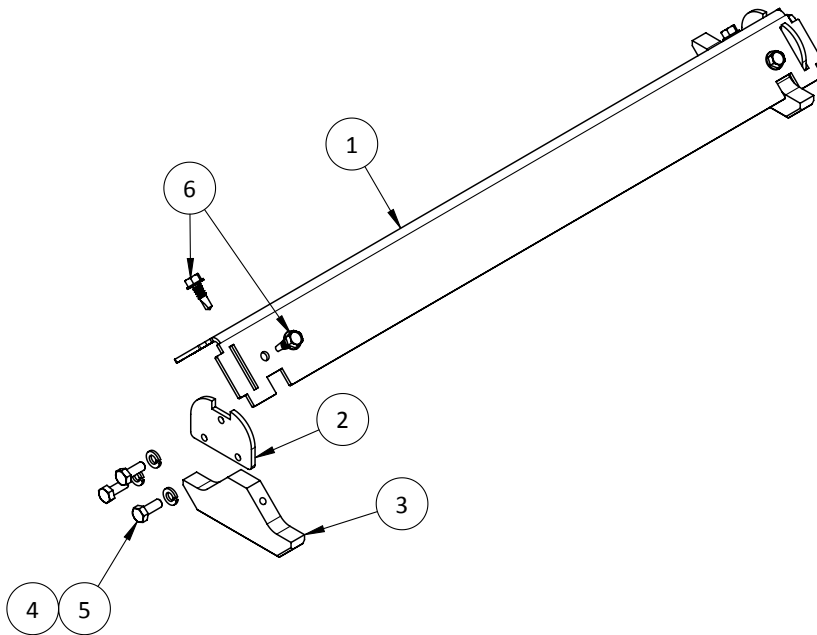
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	12C A 010 01A		Sidesheet 2m Stainless US	1
2	12C A 010 02A		Bearing Bar 2m	2
3	12C A 010 03A		Bearing Strip 2m	2
4	12C A 010 04A		Thread Plate Stainless US	1
5	12C A 010 05A		Capping Connecting Part 2m Stainless	1
6		92320A569	Spacer 1"	7
7		92320A814	Spacer 9/32"	7
8		F8-7-46-2-144	M6 x 8 Hex Bolt, Stainless	4
9		F8-29-45-2-0	M5 Nylock Nut, Stainless	14
10		F8-38-17-0-8	1/8" x 1/2" Roll Pin, Stainless	2
11		F8-58-45-2-161	M5 x 20mm FHCS, Stainless	7
12		F8-58-45-2-181	M5 x 40mm FHCS, Stainless	7
13		F8-67-133-2-142	M2.9 x 6.5mm Self-Tapping Screw, Stainless	5
14		F8-92-45-0-0	M5 Flat Washer, Stainless	14
15		F8-92-46-0-0	M6 Flat Washer, Stainless	4



Sidesheet Complete 2m Stainless US			
Conveyor Type	Part Number	Drawing Number	Description
250	--	12C A 010 00A	Sidesheet Complete 2m Stainless US
350			
500			
750			

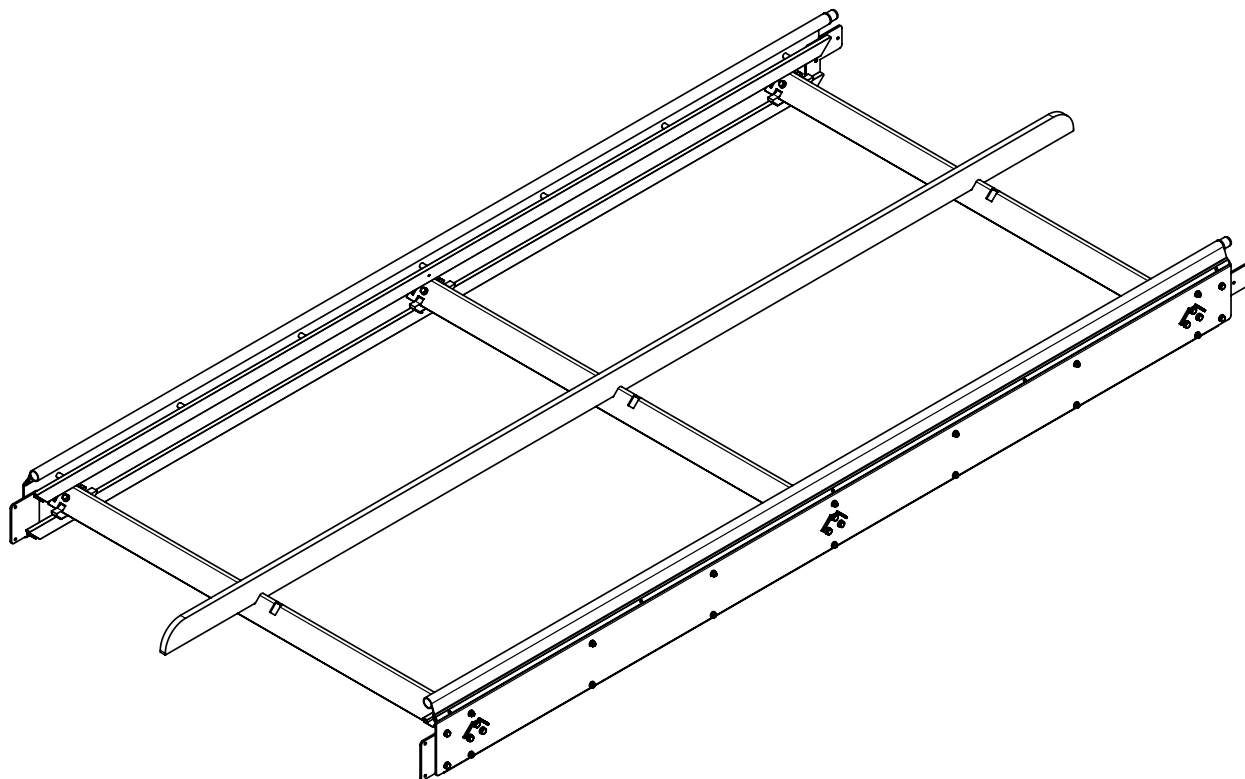
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	12C A 060 01A		Traverse Angle T250 Stainless	1	-	-	-
1	12C A 050 01A		Traverse Angle T350 Stainless	-	1	-	-
1	12C A 040 01A		Traverse Angle T500 Stainless	-	-	1	-
1	12C A 030 01A		Traverse Angle T750 Stainless	-	-	-	1
2	12C A 020 02A		Traverse Mount Plate Stainless	2	2	2	2
3	12C A 020 03A		Sliding Shoe	2	2	2	2
4		F8-96-46-0-0	M6 Lockwasher, Stainless	6	6	6	6
5		23 56 068	M6 x 16mm Hex Bolt, Stainless	6	6	6	6
6		F8-66-19-0-12	1/4" x 3/4" Hex Head Self-Tapping Screw, Stainless	4	4	4	4



Traverse Stainless			
Conveyor Type	Part Number	Drawing Number	Description
250	--	12C A 024 00A	Traverse Stainless T250
350	--	12C A 023 00A	Traverse Stainless T350
500	--	12C A 022 00A	Traverse Stainless T500
750	--	12C A 021 00A	Traverse Stainless T750

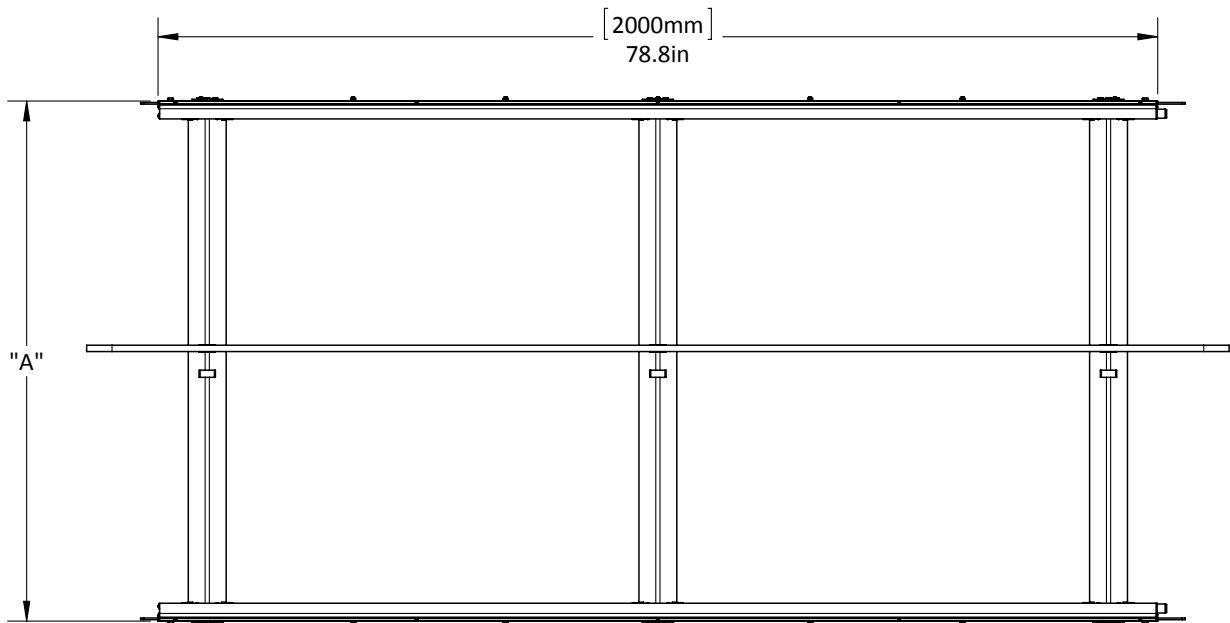
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**Connecting Part 2m Closed Stainless US T1000**

Connecting Part 2m Closed Stainless US			
Conveyor Type	Part Number	Drawing Number	Description
1000	G200A	12C A 000 00A	Connecting Part T1000 2m Closed Stainless US



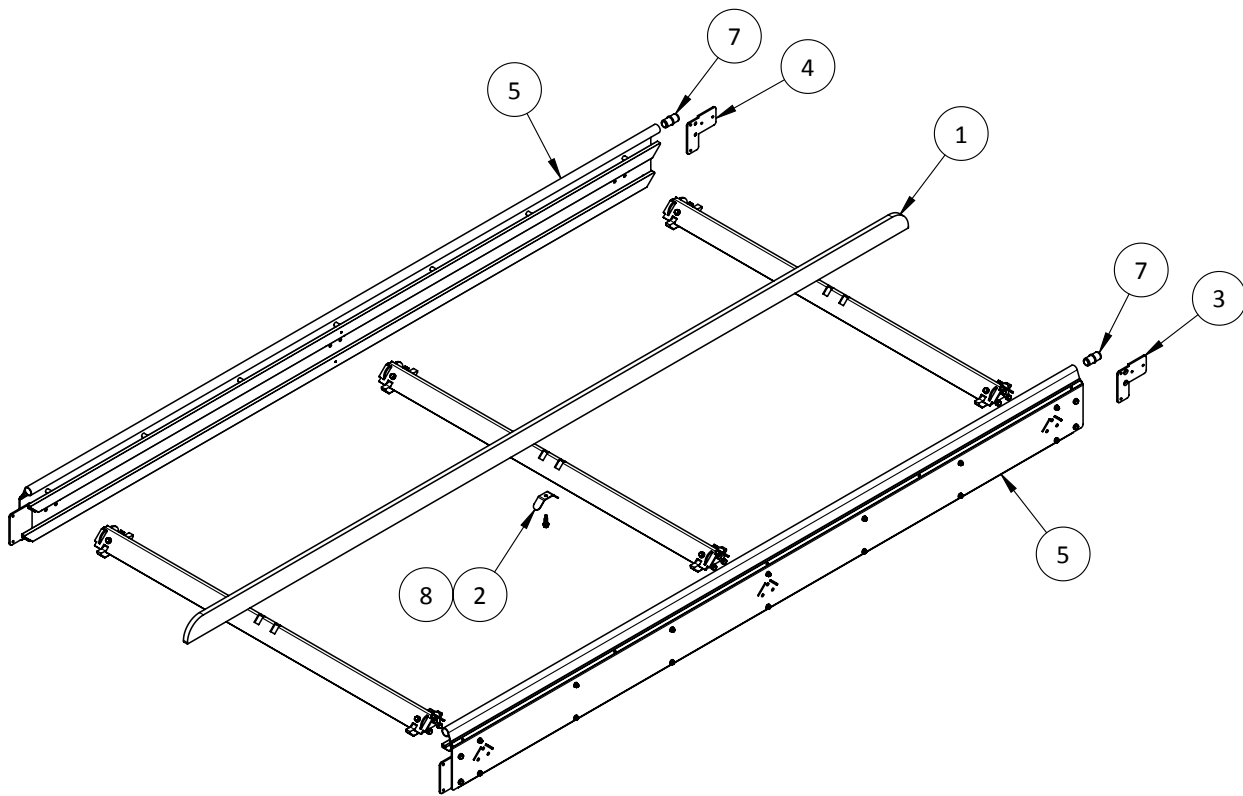
## Section 2



Connecting Part 2m Closed Stainless US				
Part Number	Conveyor Type	Drawing Number	Description	A (mm/inches)
G200A	1000	12C A 000 00A	Connecting Part 2m T1000 Closed Stainless US	1040/41.0

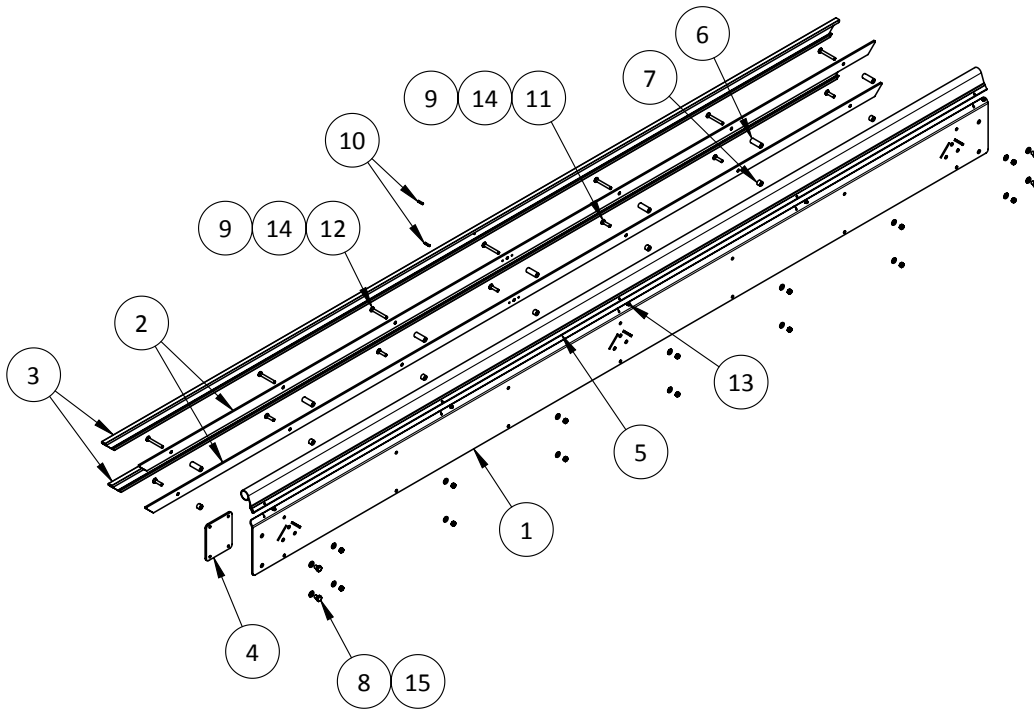
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	12C A 000 01A		Center Bearing Runner	1
2	12C A 000 02A		Runner Mount	1
3	12C A 000 03A		Adapter Thread Plate, RH	1
4	12C A 000 04A		Adapter Thread Plate, LH	1
5	12C A 010 00A		Sidesheet Complete 2m Stainless US	2
6	12C A 020 00A		Traverse Stainless T1000	3
7	185 520 18 00		Intermediate Coupling	2
8		F8-66-19-0-16	1/4" x 1" Hex Head Self-Tapping Screw, Stainless	1



## Section 2

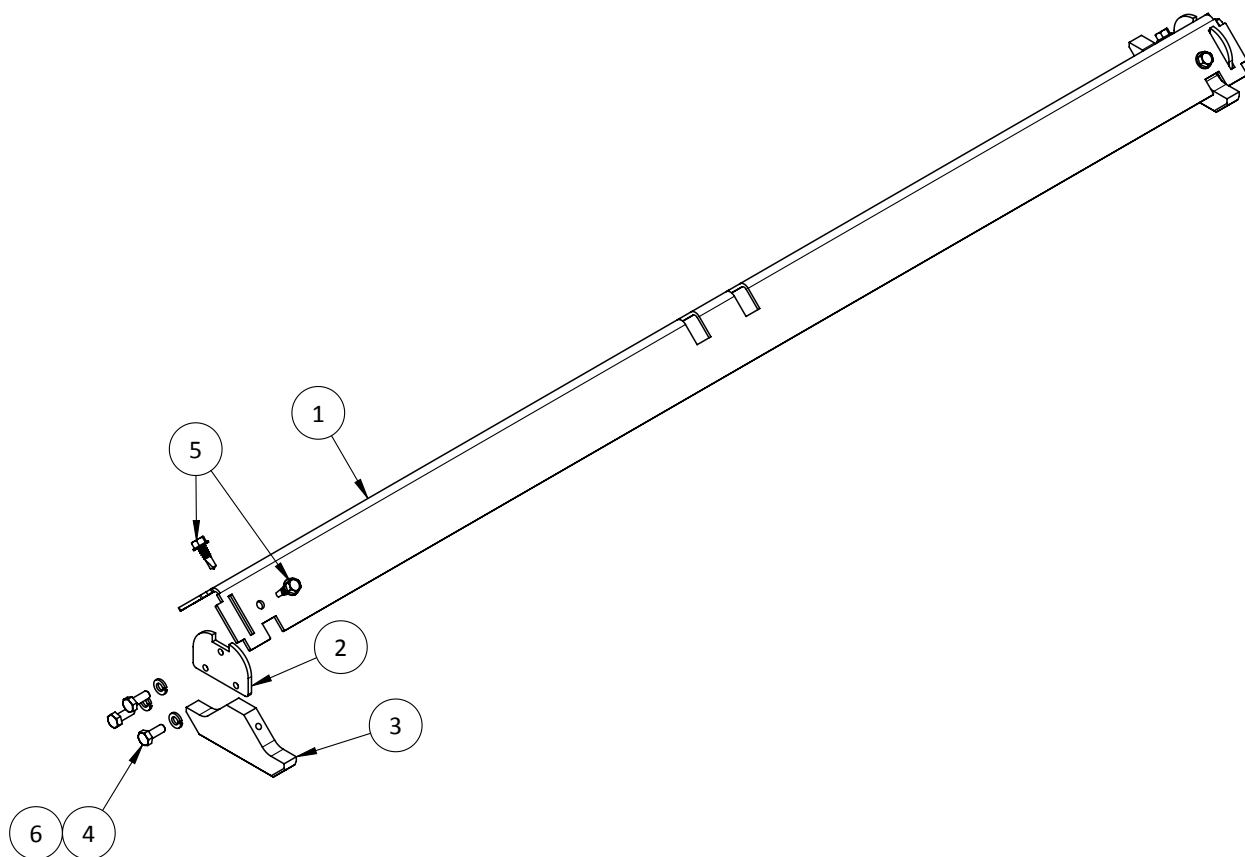
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	12C A 010 01A		Sidesheet 2m Stainless US	1
2	12C A 010 02A		Bearing Bar 2m	2
3	12C A 010 03A		Bearing Strip 2m	2
4	12C A 010 04A		Thread Plate Stainless US	1
5	12C A 010 05A		Capping Connecting Part 2m Stainless	1
6		92320A569	Spacer 1"	7
7		92320A814	Spacer 9/32"	7
8		F8-7-46-2-144	M6 x 8 Hex Bolt, Stainless	4
9		F8-29-45-2-0	M5 Nylock Nut, Stainless	14
10		F8-38-17-0-8	1/8" x 1/2" Roll Pin, Stainless	2
11		F8-58-45-2-161	M5 x 20mm FHCS, Stainless	7
12		F8-58-45-2-181	M5 x 40mm FHCS, Stainless	7
13		F8-67-133-2-142	M2.9 x 6.5mm Self-Tapping Screw, Stainless	5
14		F8-92-45-0-0	M5 Flat Washer, Stainless	14
15		F8-92-46-0-0	M6 Flat Washer, Stainless	4



Sidesheet Complete 2m Stainless US			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	12C A 010 00A	Sidesheet Complete 2m Stainless US

## Section 2

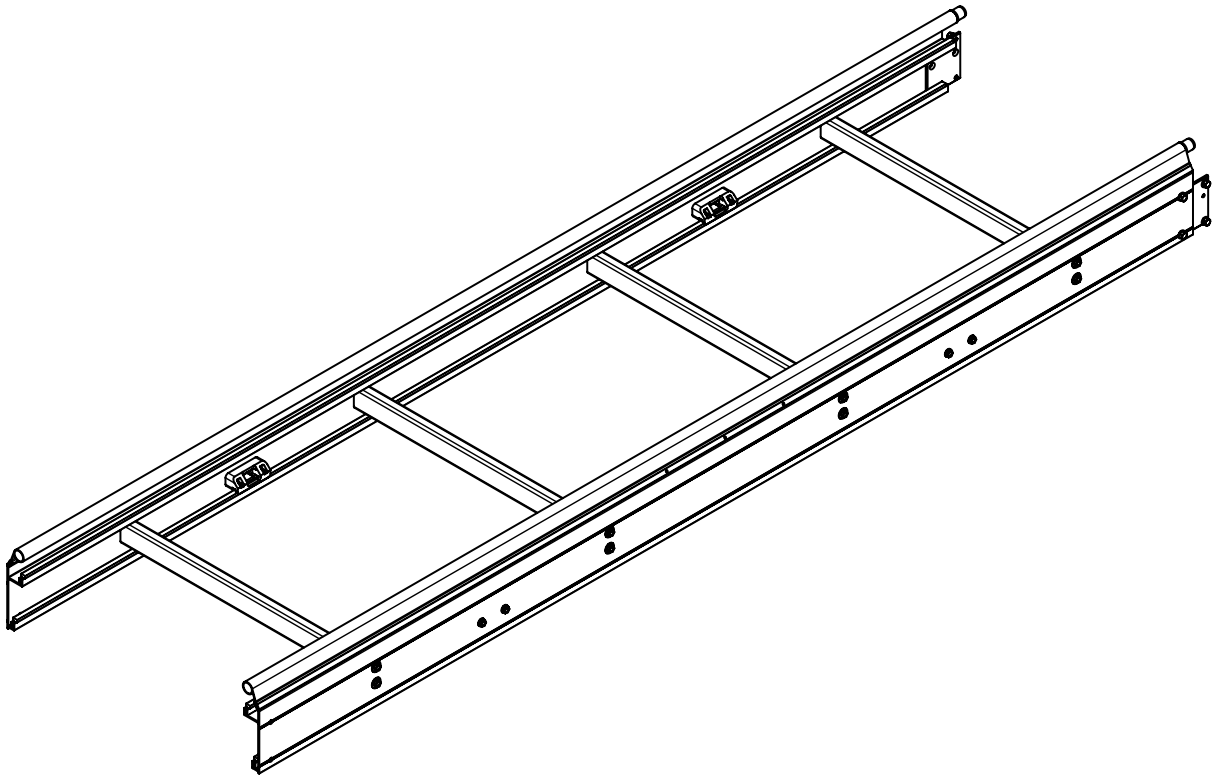
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	12C A 020 01A		Traverse Angle T1000 Stainless	1
2	12C A 020 02A		Traverse Mount Plate Stainless	2
3	12C A 020 03A		Sliding Shoe	2
4		23 56 068	M6 x 16mm Hex Bolt, Stainless	6
5		F8-66-19-0-12	1/4" x 3/4" Hex Head Self-Tapping Screw, Stainless	4
6		F8-96-46-0-0	M6 Lockwasher, Stainless	6



Traverse Stainless			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	12C A 020 00A	Traverse Stainless T1000

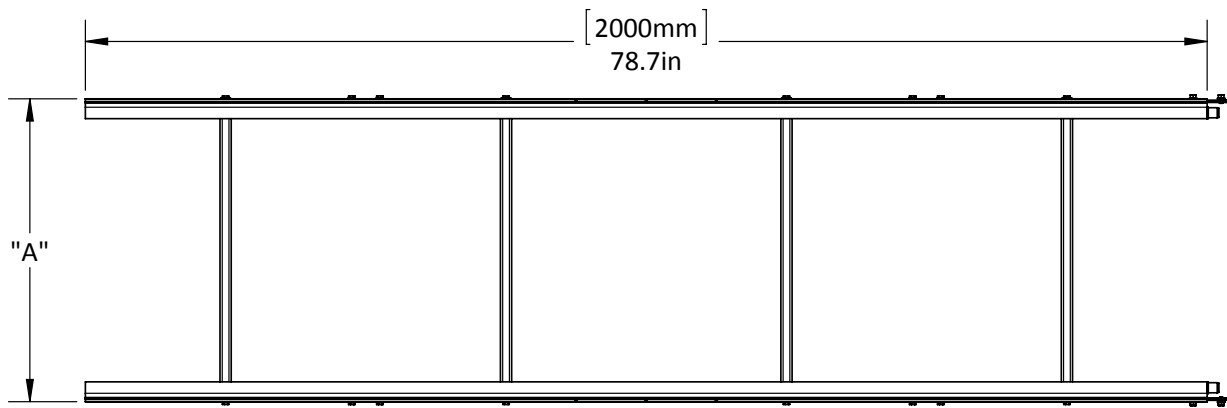
## Section 2

### Connecting Part 2m Closed T250 - T750



Connecting Part Closed 2m			
Conveyor Type	Part Number	Drawing Number	Description
250	4909	--	Connecting Part T250 2m Closed
350	4848	--	Connecting Part T350 2m Closed
500	4809	--	Connecting Part T500 2m Closed
750	4878	--	Connecting Part T750 2m Closed

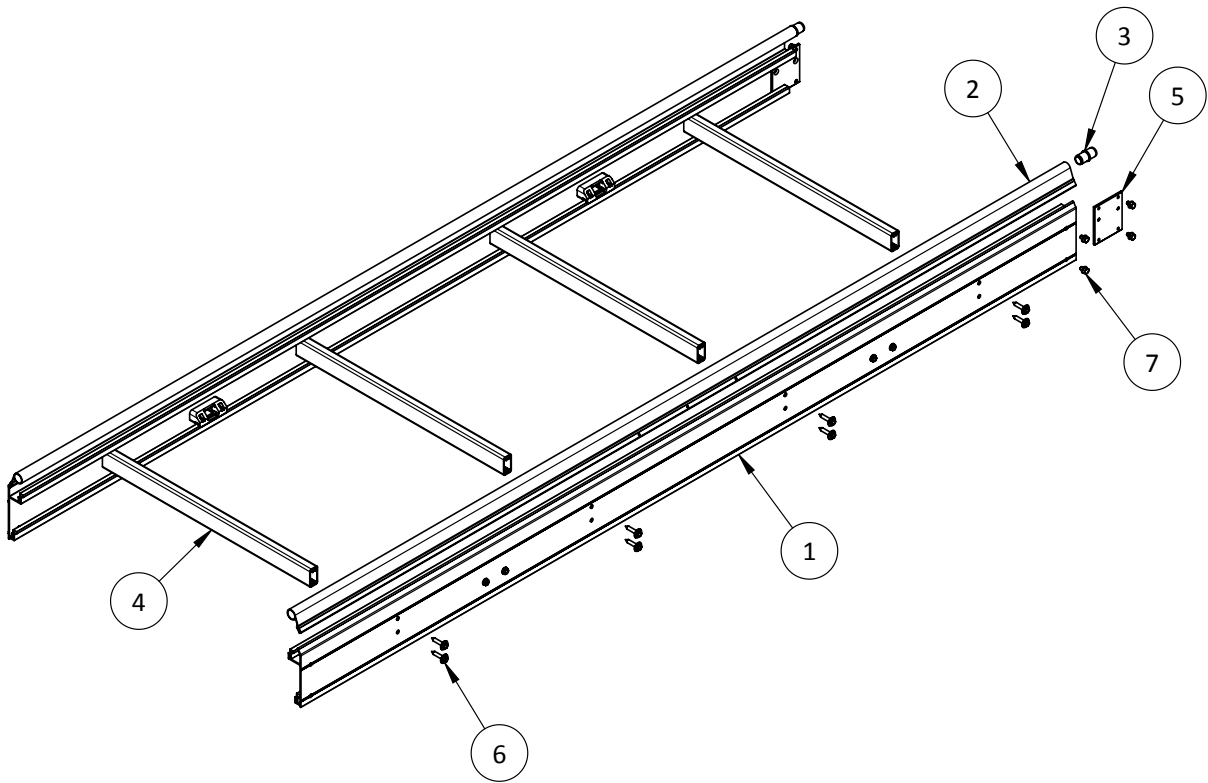
## Section 2



Connecting Part 2m Closed			
Part Number	Conveyor Type	Description	A (mm/inches)
4909	250	Connecting Part T250 2m Closed	290/11.4
4848	350	Connecting Part T350 2m Closed	390/15.4
4809	500	Connecting Part T500 2m Closed	540/21.3
4878	750	Connecting Part T750 2m Closed	790/31.1

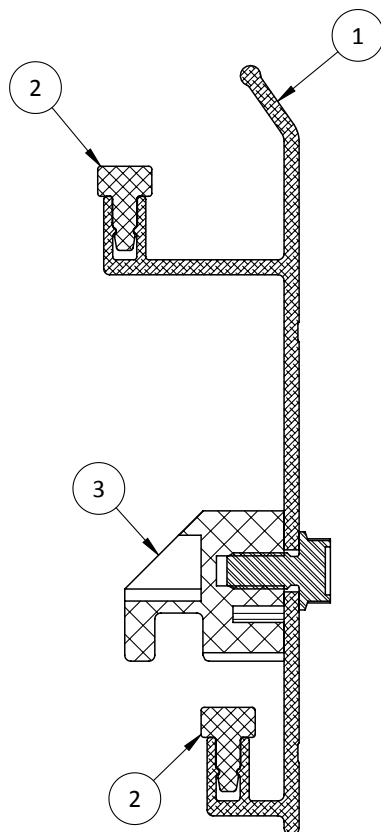
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 500 03 03		Sidesheet Complete 2m Closed T-Profile	2	2	2	2
2	185 520 09 02		Connecting Part Capping 2m	2	2	2	2
3	185 520 18 00		Intermediate Coupling	2	2	2	2
4	186 524 05 00		Traverse T250	4	-	-	-
4	187 524 05 00		Traverse T350	-	4	-	-
4	185 524 05 00		Traverse T500	-	-	4	-
4	188 524 05 00		Traverse T750	-	-	-	4
5	185 525 06 00		Thread Plate	2	2	2	2
6		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	16	16	16	16
7		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8	8



## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 520 08 12		Sidesheet T-Profile 2m	1
2	185 526 01 00		T-Profile 2m	2
3	707 120 02 00		Sliding Shoe Complete	2



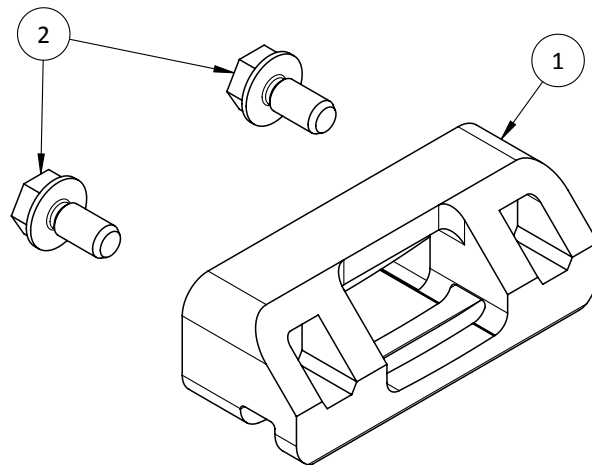
Sidesheet Complete 2m Closed T-Profile			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 500 03 03	Sidesheet Complete 2m Closed T-Profile
350			
500			
750			



## Section 2

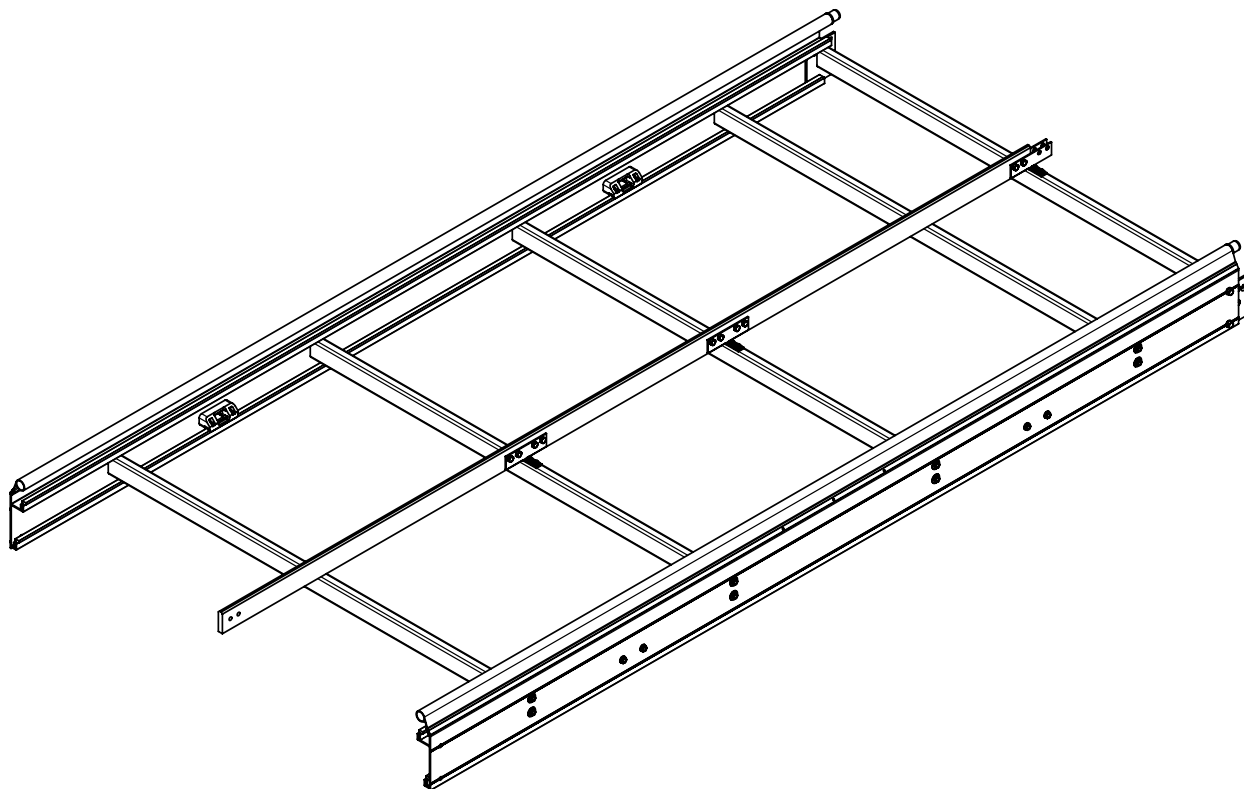
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 520 07 01*		Sliding Shoe	1
2		21 97 067	M6 x 12 Thread Forming Screw, Zinc	2

\*ITEM NOT AVAILABLE INDIVIDUALLY, IF NEEDED ORDER COMPLETE ASSEMBLY  
(SEE CHART BELOW)



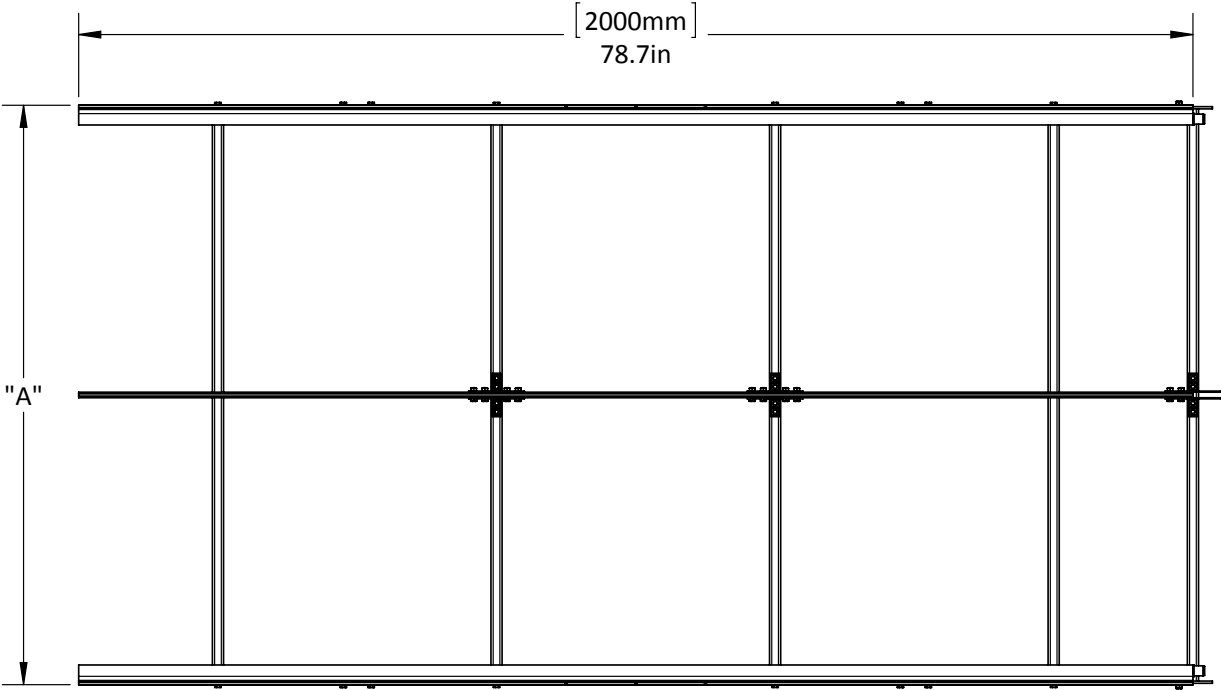
Sliding Shoe Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	707 120 02 00	Sliding Shoe Complete
350			
500			
750			

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**Connecting Part 2m Closed T1000**

Connecting Part Closed 2m			
Conveyor Type	Part Number	Drawing Number	Description
1000	5409	--	Connecting Part T1000 2m Closed

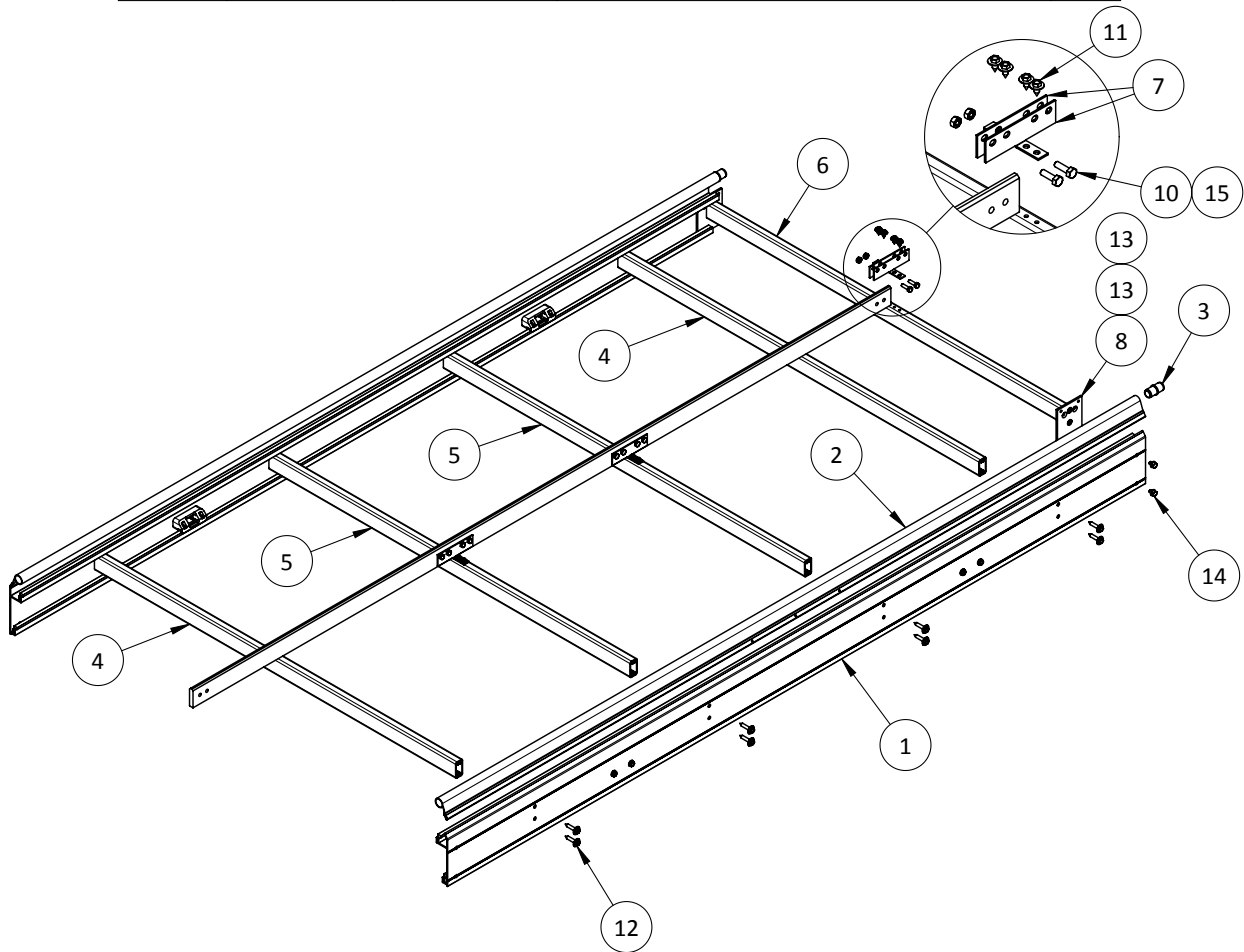
# Section 2



Connecting Part 2m Closed			
Part Number	Conveyor Type	Description	A (mm/inches)
5409	250	Connecting Part T1000 2m Closed	1040/41.0

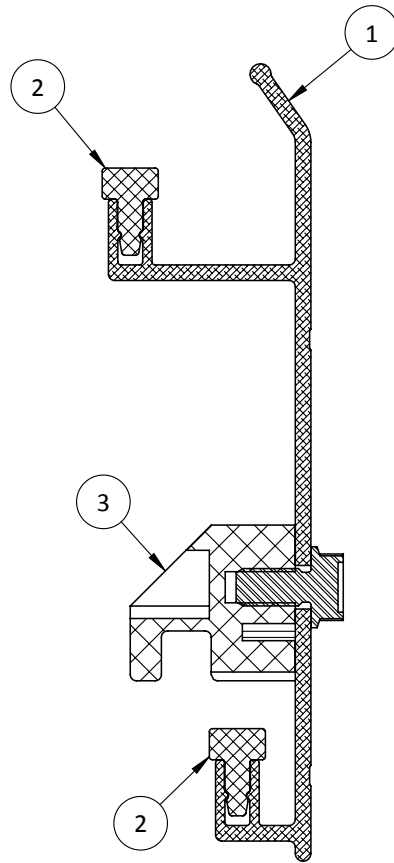
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	185 500 03 03		Sidesheet Complete 2m Closed T-Profile	2
2	185 520 09 02		Connecting Part Capping 2m	2
3	185 520 18 00		Intermediate Coupling	2
4	191 524 05 00		Traverse T1000 (No Holes)	2
5	191 524 05 07		Traverse T1000 (Thin Side Holes)	2
6	191 524 05 08		Traverse Narrow T1000	1
7	191 524 07 00		Connecting Angle	6
8	191 525 06 00		Thread Plate	2
9	191 525 21 00		Center Profile 2m T1000	1
10		21 56 069	M6 x 20 Hex Bolt, Zinc	10
11		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	12
12		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	16
13		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	4
14		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4
15		25 15 105	M6 Hex Nut, Zinc	10



## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 520 08 12		Sidesheet T-Profile 2m	1
2	185 526 01 00		T-Profile 2m	2
3	707 120 02 00		Sliding Shoe Complete	2

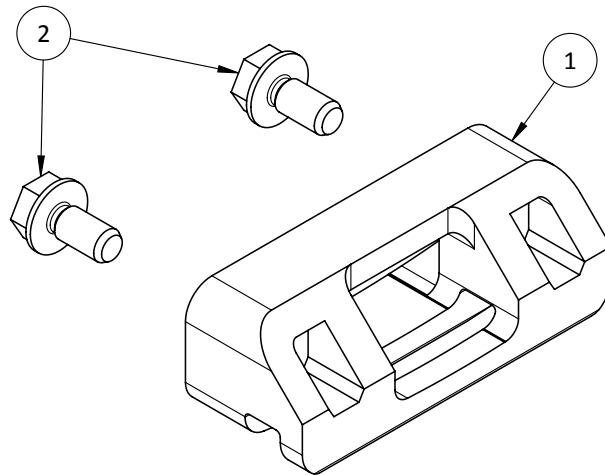


Sidesheet Complete 2m Closed T-Profile			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	185 500 03 03	Sidesheet Complete 2m Closed T-Profile

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 520 07 01*		Sliding Shoe	1
2		21 97 067	M6 x 12 Thread Forming Screw, Zinc	2

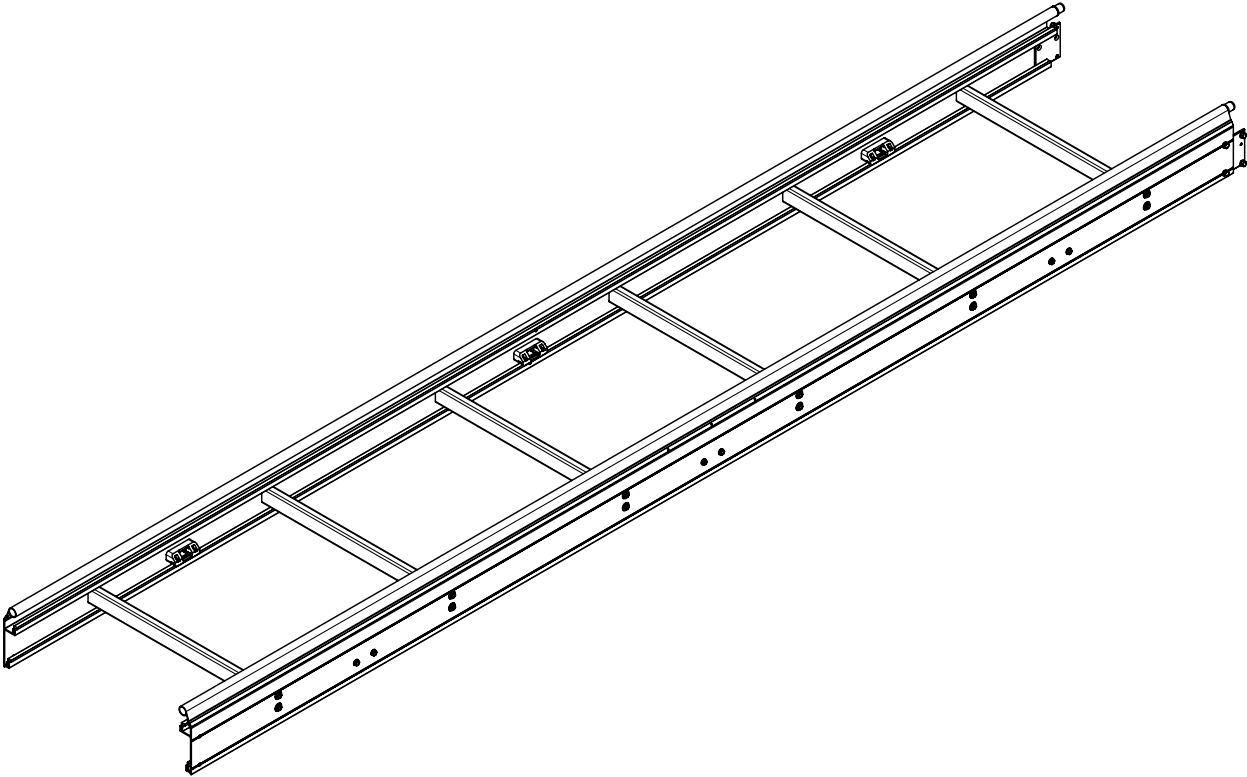
\*ITEM NOT AVAILABLE INDIVIDUALLY, IF NEEDED ORDER COMPLETE ASSEMBLY  
(SEE CHART BELOW)



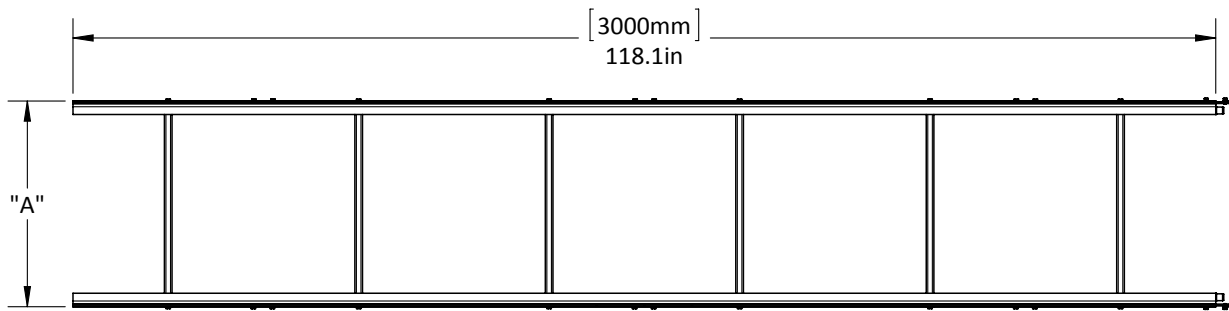
Sliding Shoe Complete			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	707 120 02 00	Sliding Shoe Complete

# Section 2

## Connecting Part 3m Closed T250 - T750



Connecting Part Closed 3m			
Conveyor Type	Part Number	Drawing Number	Description
250	4908	--	Connecting Part T250 3m Closed
350	4847	--	Connecting Part T350 3m Closed
500	4808	--	Connecting Part T500 3m Closed
750	4877	--	Connecting Part T750 3m Closed

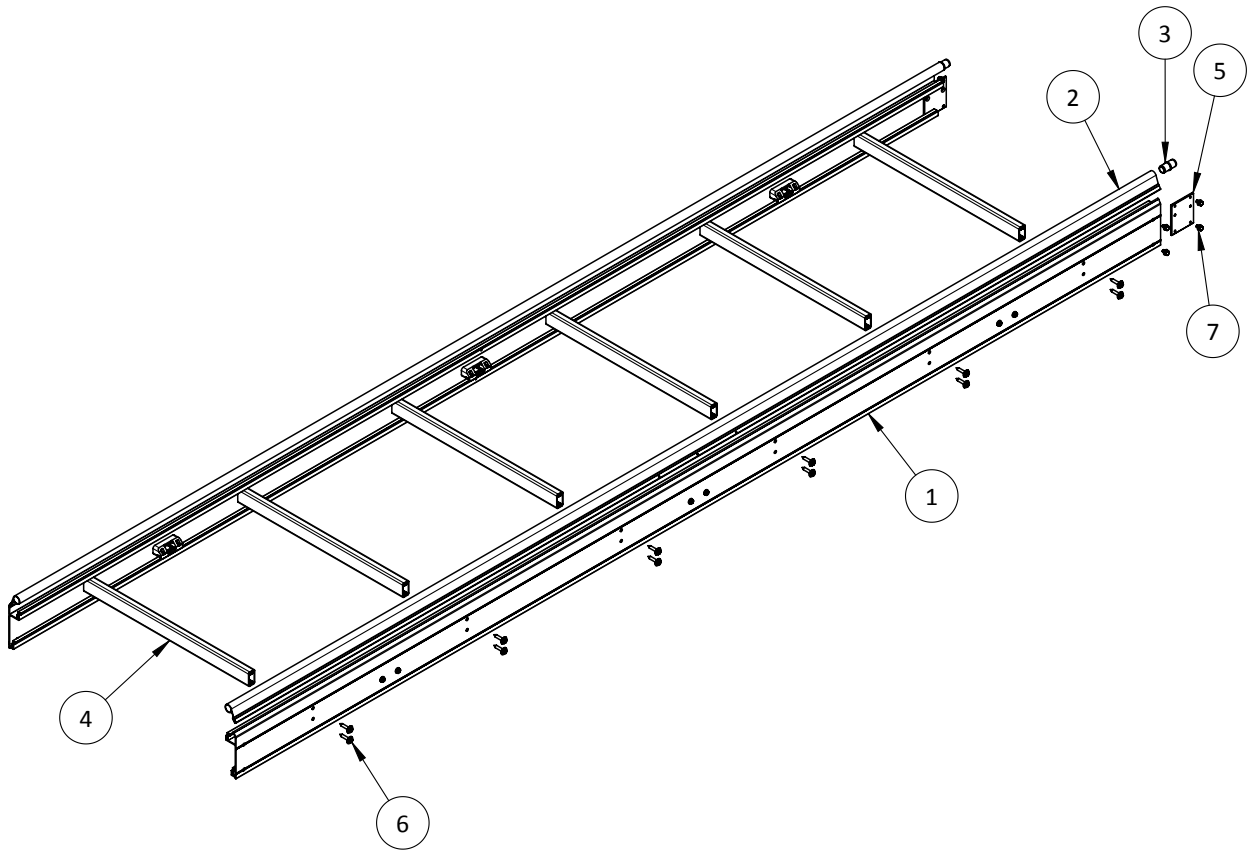


<b>Connecting Part 3m Closed</b>			
<b>Part Number</b>	<b>Conveyor Type</b>	<b>Description</b>	<b>A (mm/inches)</b>
4908	250	Connecting Part T250 3m Closed	290/11.4
4847	350	Connecting Part T350 3m Closed	390/15.4
4908	500	Connecting Part T500 3m Closed	540/21.3
4877	750	Connecting Part T750 3m Closed	790/31.1



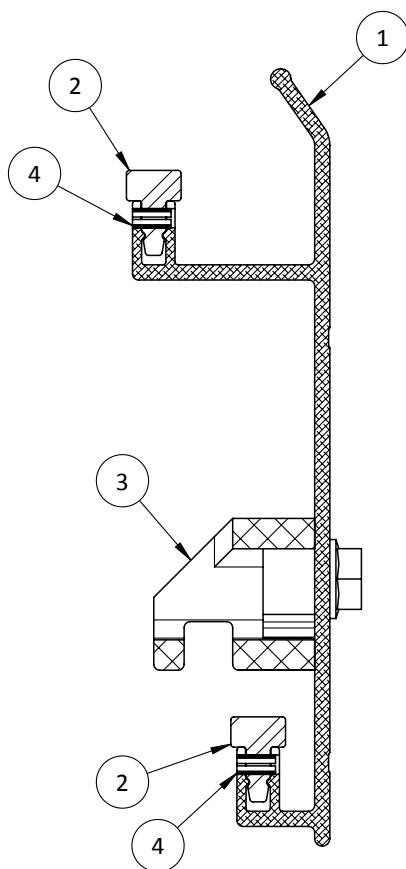
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 500 04 03		Sidesheet Complete 3m Closed T-Profile	2	2	2	2
2	185 520 09 01		Connecting Part Capping 3m	2	2	2	2
3	185 520 18 00		Intermediate Coupling	2	2	2	2
4	186 524 05 00		Traverse T250	6	-	-	-
4	187 524 05 00		Traverse T350	-	6	-	-
4	185 524 05 00		Traverse T500	-	-	6	-
4	188 524 05 00		Traverse T750	-	-	-	6
5	185 525 06 00		Thread Plate	2	2	2	2
6		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	24	24	24	24
7		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8	8



## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 520 08 13		Sidesheet T-Profile 3m	1
2	185 526 01 01		T-Profile 3m	2
3	707 120 02 00		Sliding Shoe Complete	3
4		F4-38-17-0-4	1/8" x 1/4" Spring Pin, Steel	2

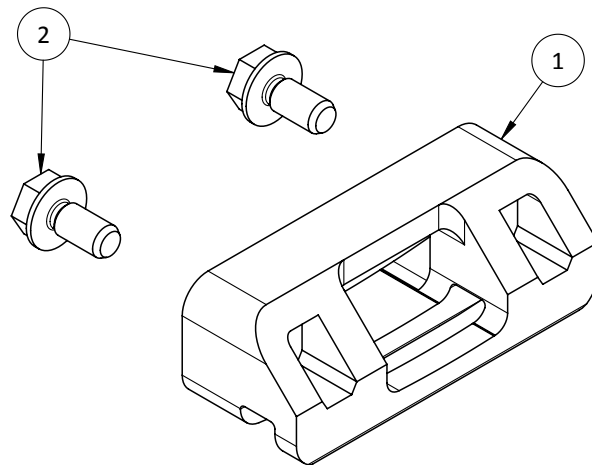


Sidesheet Complete 3m Closed T-Profile			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 500 04 03	Sidesheet Complete 3m Closed T-Profile
350			
500			
750			

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 520 07 01*		Sliding Shoe	1
2		21 97 067	M6 x 12 Thread Forming Screw, Zinc	2

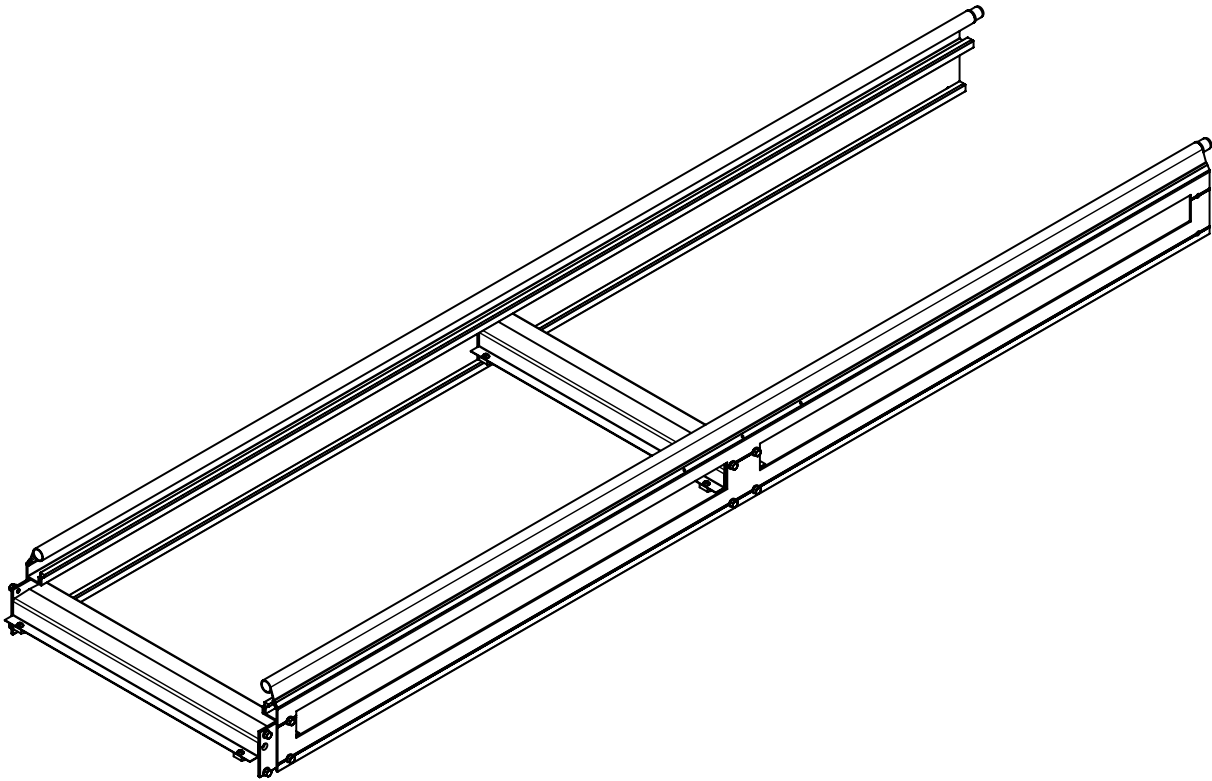
\*ITEM NOT AVAILABLE INDIVIDUALLY, IF NEEDED ORDER COMPLETE ASSEMBLY  
(SEE CHART BELOW)



Sliding Shoe Complete			
Conveyor Type	Part Number	Drawing Number	Description
250	--	707 120 02 00	Sliding Shoe Complete
350			
500			
750			

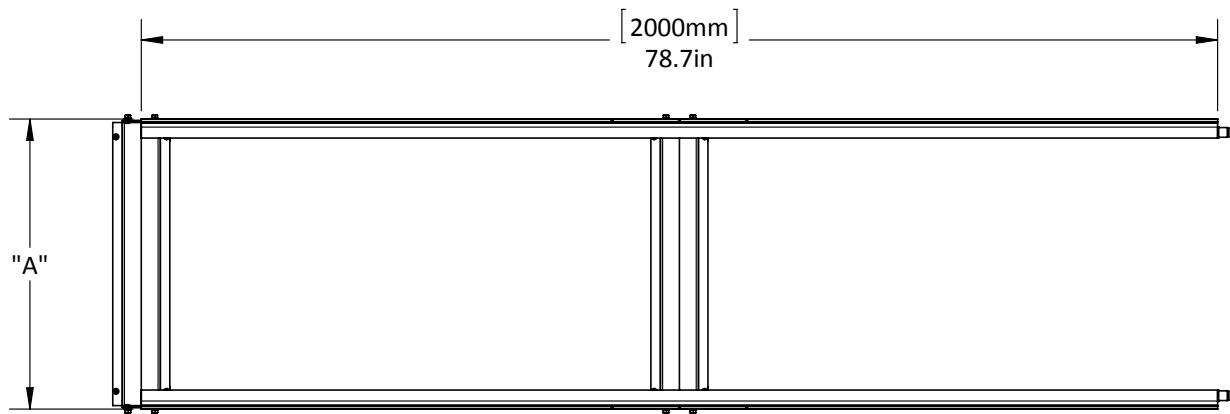
## Section 2

### Connecting Part 2m Open T250 - T750



Connecting Part Open 2m			
Conveyor Type	Part Number	Drawing Number	Description
250	4911	--	Connecting Part T250 2m Open
350	4850	--	Connecting Part T350 2m Open
500	4811	--	Connecting Part T500 2m Open
750	4880	--	Connecting Part T750 2m Open

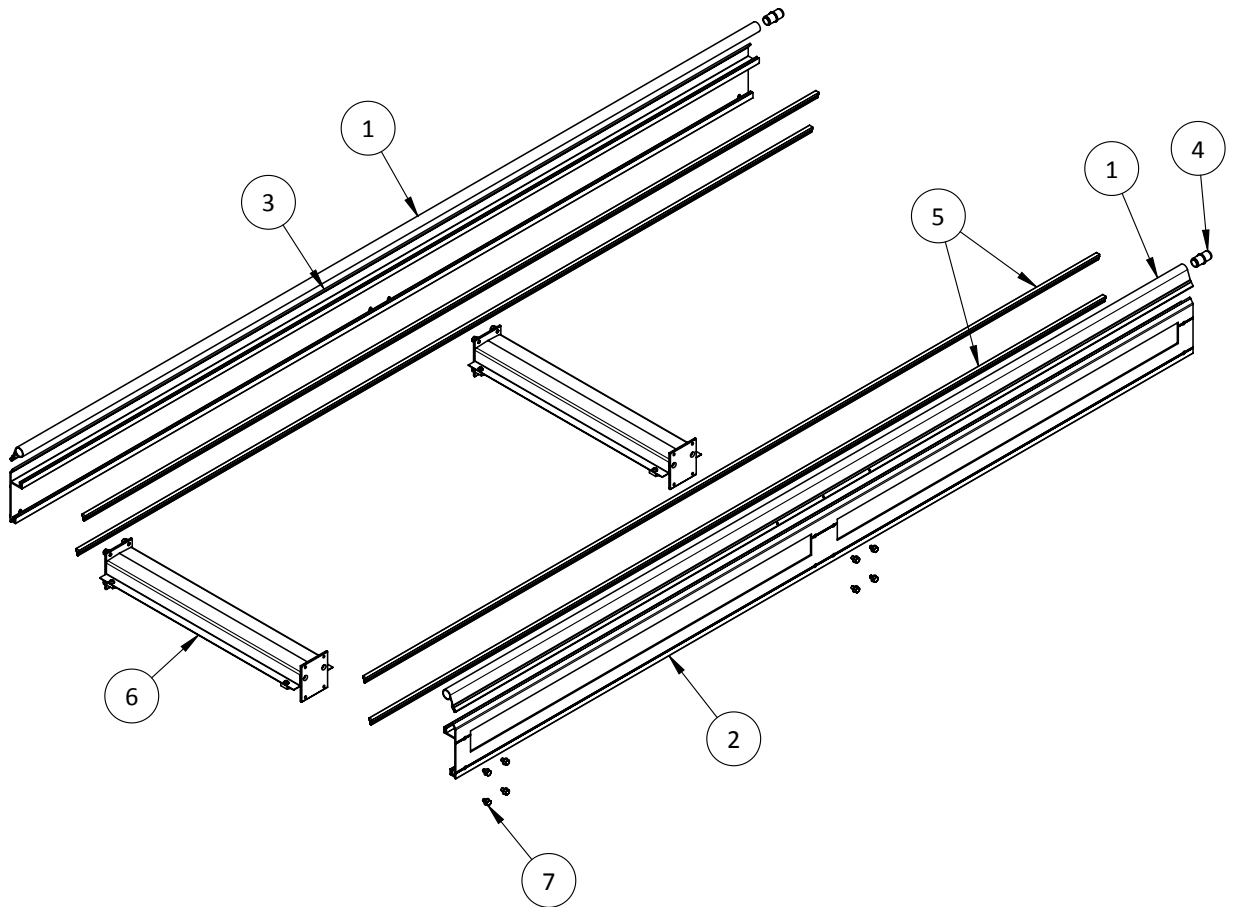
## Section 2



Connecting Part 2m Open			
Part Number	Conveyor Type	Description	A (mm/inches)
4911	250	Connecting Part T250 2m Open	290/11.4
4850	350	Connecting Part T350 2m Open	390/15.4
4811	500	Connecting Part T500 2m Open	540/21.3
4880	750	Connecting Part T750 2m Open	790/31.1

## Section 2

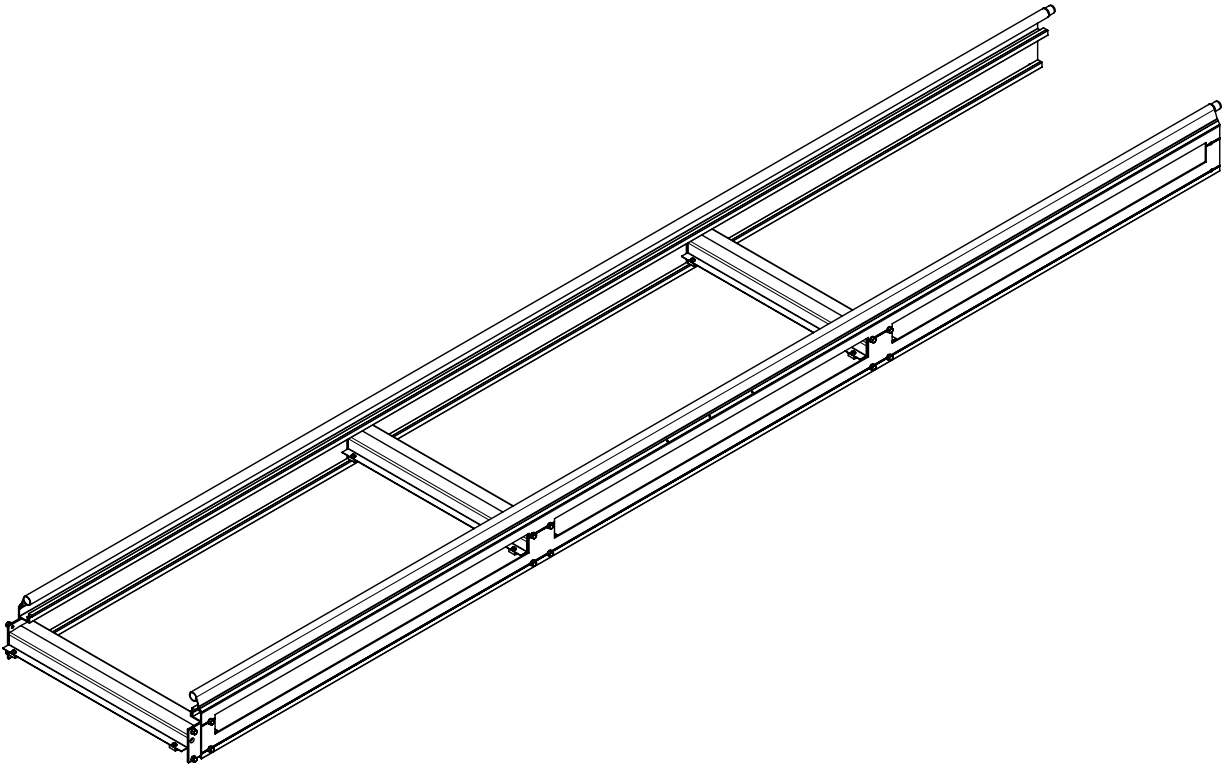
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 520 09 02		Connecting Part Capping 2m	2	2	2	2
2	185 520 10 05		Drip Pan Sidesheet Open 2m	1	1	1	1
3	185 520 15 02		Drip Pan Sidesheet Closed 2m	1	1	1	1
4	185 520 18 00		Intermediate Coupling	2	2	2	2
5	185 526 01 00		T-Profile 2m	4	4	4	4
6	186 500 25 00		Open Traverse Complete T250	2	-	-	-
6	187 500 25 00		Open Traverse Complete T350	-	2	-	-
6	185 500 25 00		Open Traverse Complete T500	-	-	2	-
6	188 500 25 00		Open Traverse Complete T750	-	-	-	2
7		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	16	16	16	16



## Section 2

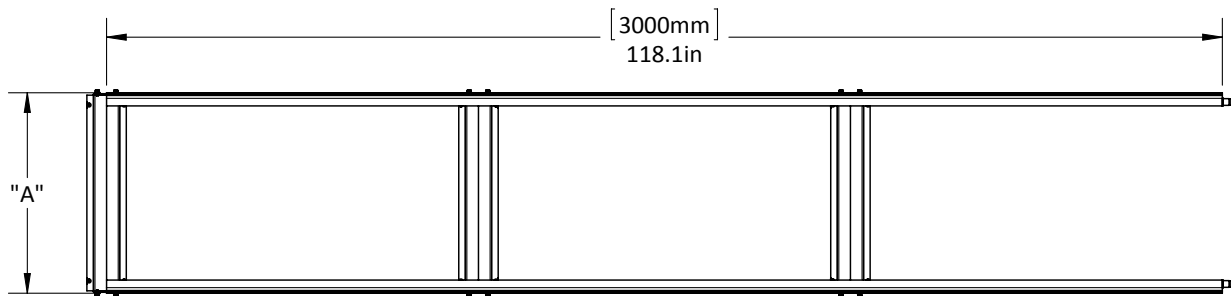
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### Connecting Part 3m Open T250 - T750



Connecting Part Open 3m			
Conveyor Type	Part Number	Drawing Number	Description
250	4910	--	Connecting Part T250 3m Open
350	4849	--	Connecting Part T350 3m Open
500	4810	--	Connecting Part T500 3m Open

## Section 2

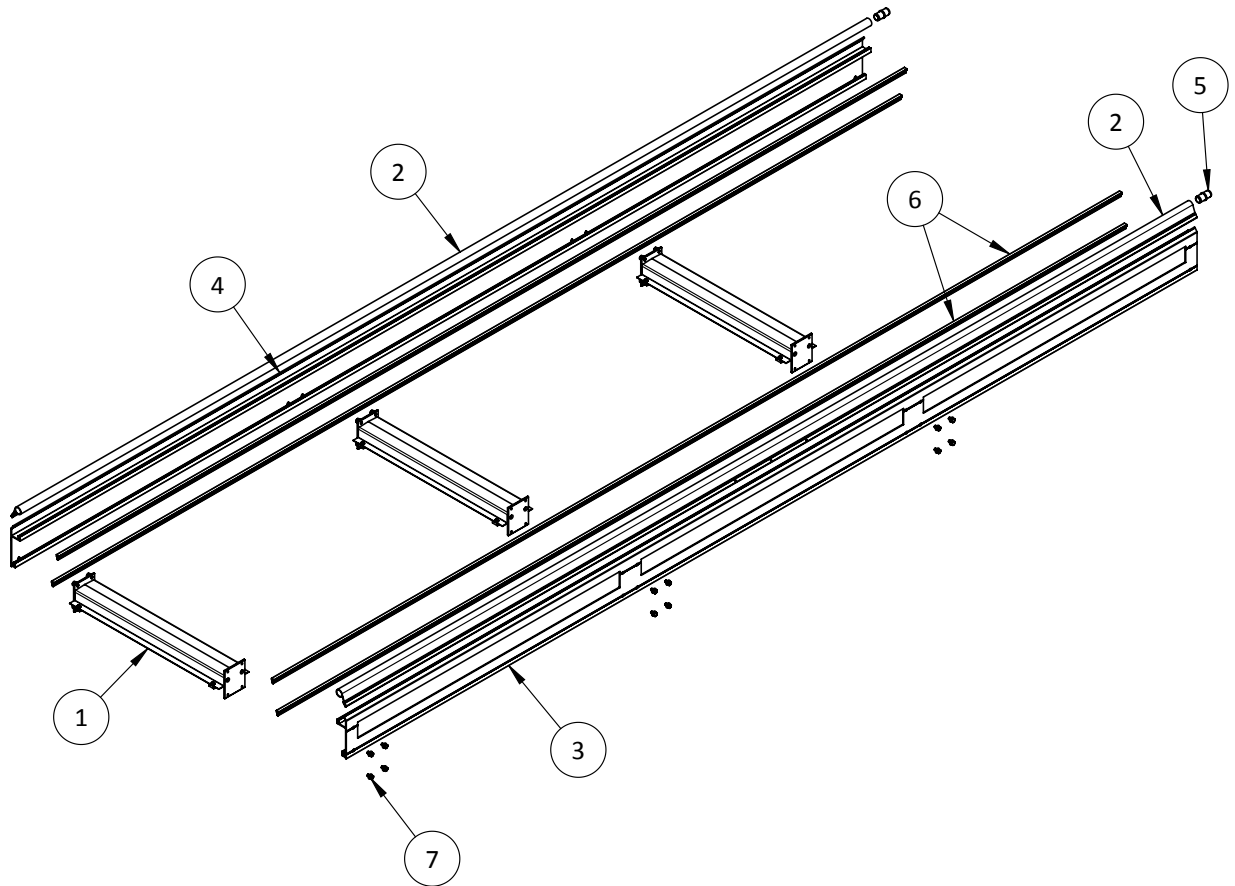


Connecting Part 3m Open			
Part Number	Conveyor Type	Description	A (mm/inches)
4910	250	Connecting Part T250 3m Open	290/11.4
4849	350	Connecting Part T350 3m Open	390/15.4
4810	500	Connecting Part T500 3m Open	540/21.3
--	750	--	--



## Section 2

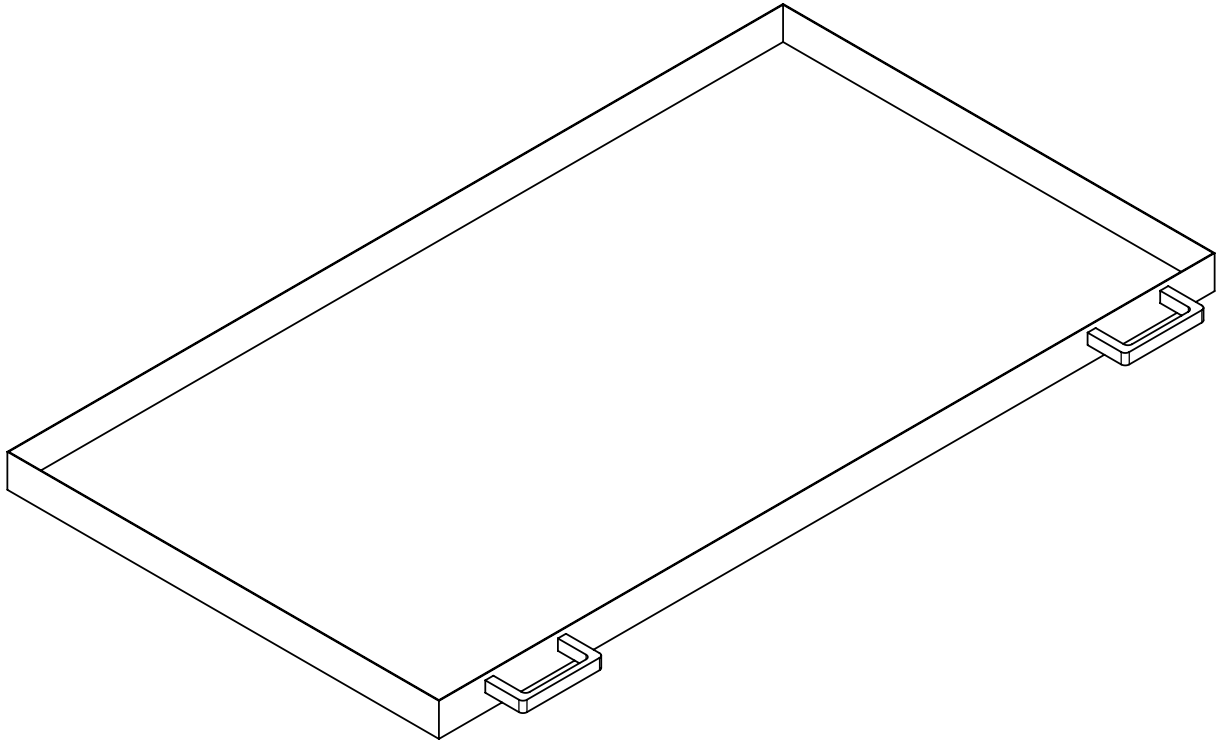
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500
1	186 500 25 00		Open Traverse Complete T250	3	-	-
1	187 500 25 00		Open Traverse Complete T350	-	3	-
1	185 500 25 00		Open Traverse Complete T500	-	-	3
2	185 520 09 01		Connecting Part Capping 3m	2	2	2
3	185 520 10 04		Drip Pan Sidesheet Open 3m	1	1	1
4	185 520 14 02		Drip Pan Sidesheet Closed 3m	1	1	1
5	185 520 18 00		Intermediate Coupling	2	2	2
6	185 526 01 01		T-Profile 3m	4	4	4
7		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	24	24	24



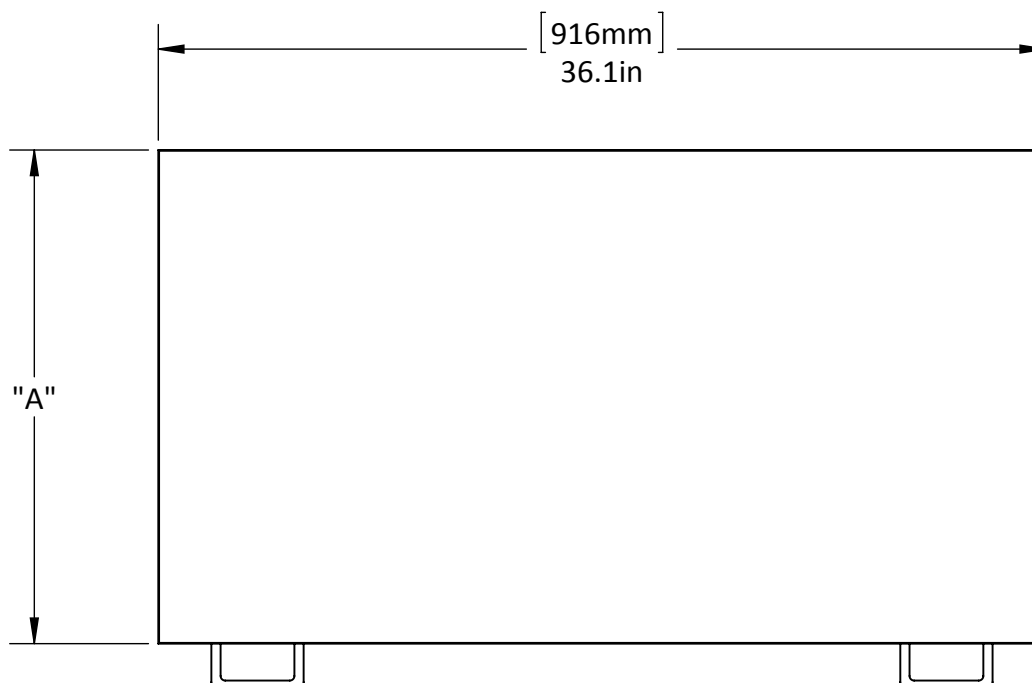
## Section 2

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### Drip Pan 1m T250 - T750



Drip Pan 1m			
Conveyor Type	Part Number	Drawing Number	Description
250	4915	--	Drip Pan T250 1m
350	4750	--	Drip Pan T350 1m
500	4714	--	Drip Pan T500 1m
750	4780	--	Drip Pan T750 1m

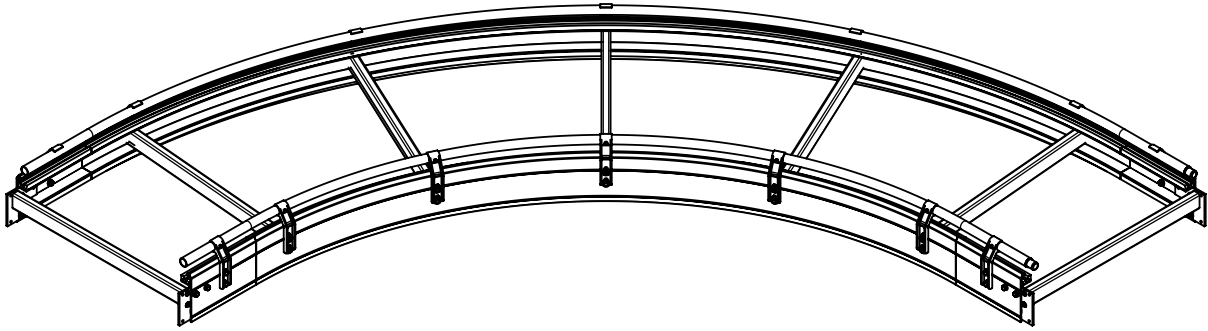


Drip Pan 1m			
Part Number	Conveyor Type	Description	A (mm/inches)
4915	250	Drip Pan T250 1m	290/11.4
4750	350	Drip Pan T350 1m	390/15.4
4714	500	Drip Pan T500 1m	540/21.3
4780	750	Drip Pan T750 1m	790/31.1

## Section 2

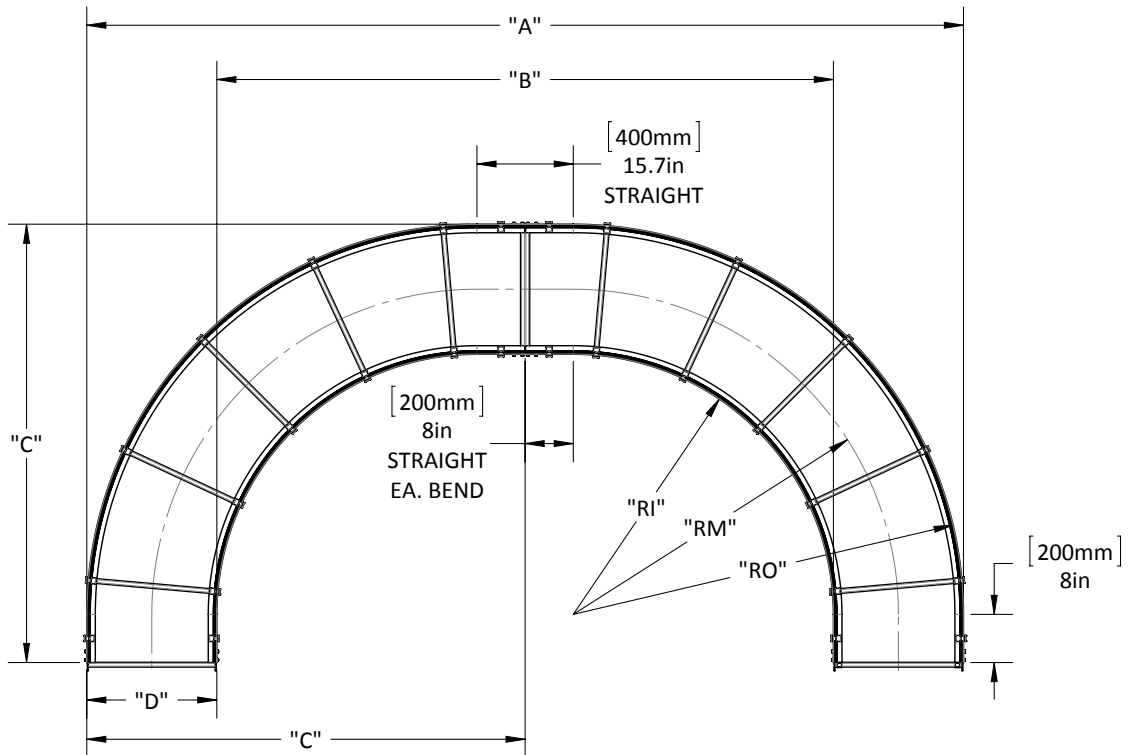
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### Bend Unit T250 - T750



<b>Bend Unit 90 Degree</b>			
<b>Conveyor Type</b>	<b>Part Number</b>	<b>Drawing Number</b>	<b>Description</b>
250	4912	--	Bend Unit T250 90 Deg
350	4851	--	Bend Unit T350 90 Deg
500	4812	--	Bend Unit T500 90 Deg
750	4881	--	Bend Unit T750 90 Deg

<b>Bend Unit 45 Degree</b>			
<b>Conveyor Type</b>	<b>Part Number</b>	<b>Drawing Number</b>	<b>Description</b>
250	4913	--	Bend Unit T250 45 Deg
350	4852	--	Bend Unit T350 45 Deg
500	4813	--	Bend Unit T500 45 Deg
750	4882	--	Bend Unit T750 45 Deg



Bend Unit									
Part No.*	Conveyor Type	Description	A** (mm/inches)	B** (mm/inches)	C** (mm/inches)	D (mm/inches)	RI*** (mm/inches)	RM*** (mm/inches)	RO*** (mm/inches)
4912	250	Bend T250 90 Deg	2040/80.3	1460/57.5	1020/40.2	290/11.4	530/20.8	675/26.6	820/32.3
4913		Bend T250 45 Deg	N/A	N/A	N/A				
4851	350	Bend T350 90 Deg	2680/105.5	1900/74.8	1340/52.8	390/15.4	750/29.5	945/37.2	1140/44.9
4852		Bend T350 45 Deg	N/A	N/A	N/A				
4812	500	Bend T500 90 Deg	3640/143.3	2560/100.8	1820/71.7	540/21.3	1080/42.5	1350/53.1	1620/63.8
4813		Bend T500 45 Deg	N/A	N/A	N/A				
4881	750	Bend T750 90 Deg	5240/206.3	3660/144.1	2620/103.2	790/31.1	1630/64.2	2025/79.7	2420/95.3
4882		Bend T750 45 Deg	N/A	N/A	N/A				

\*Part Numbers reflect single 90° Bend

\*\*Dimensions based on (2) 90° Bend Units assembled for 180° Bend

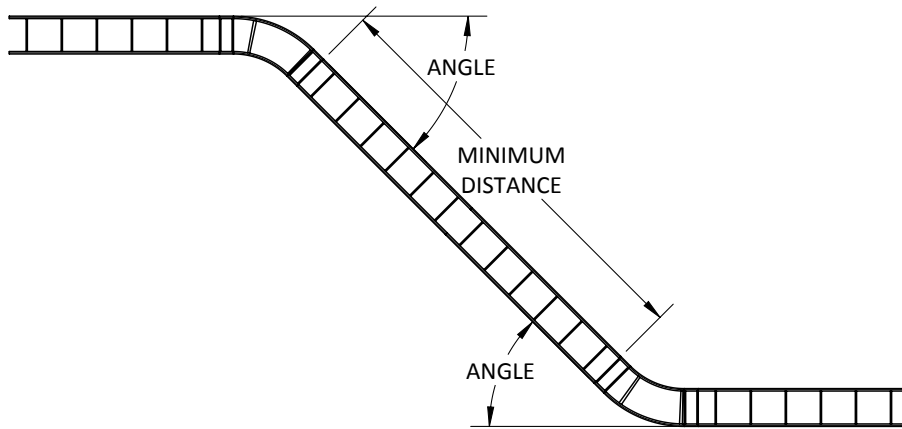
\*\*\*Radius dimensions are applicable to any degree Bend for a particular Conveyor Type

N/A = Not applicable to any Bend or pair of Bends other than 90°

Chain Length (approx.) through Bend Unit			
Conveyor Type	Chain Length (45°) (m/ft)	Chain Length (90°) (m/ft)	Chain Length (180°) (m/ft)****
250	1.0/3.4	1.7/5.5	3.3/10.9
350	1.3/4.2	2.2/7.1	4.3/14.2
500	1.7/5.5	2.9/9.6	5.8/19.1
750	2.3/7.5	4.2/13.7	8.4/27.4

\*\*\*\*180° Chain Length based on (2) 90° Bends

## Section 2



Minimum Distances Between Offset Bend Units (meters/feet)									
Conveyor Type	3°-5°	6°-10°	11°-15°	16°-20°	21°-25°	26°-30°	31°-35°	36°-40°	45°-90°
250	.75/2.5	1.0/3.3	1.25/4.1	1.5/4.9	1.75/5.7	2.0/6.6	2.25/7.4	2.38/7.8	2.5/8.2
350	.88/2.9	1.25/4.1	1.75/5.7	2.0/6.6	2.25/7.4	2.5/8.2	2.75/9.0	2.88/9.5	3.0/9.8
500	1.5/4.9	2.0/6.6	2.5/8.2	3.0/9.8	3.5/11.5	4.0/13.1	4.5/14.8	4.75/15.6	5/16.4
750	1.75/5.7	2.5/8.2	3.5/11.5	4.0/13.1	4.5/14.8	5/16.4	5.5/18.0	5.75/18.9	6.0/19.7

All dimensions are reference only. Other variables within the system may affect minimum lengths as noted.

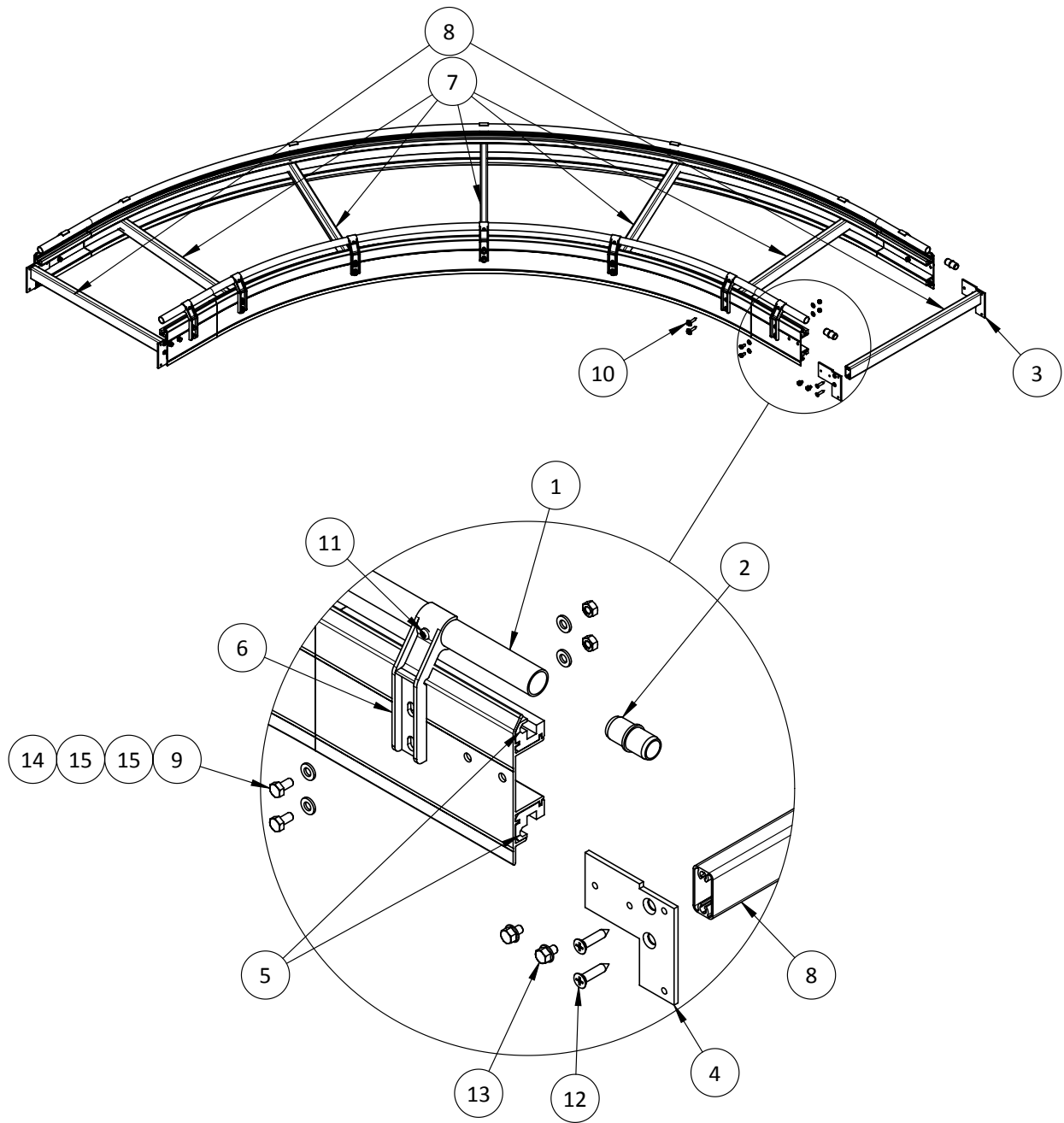
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	001 320 06 00*		Bend Unit Capping	2.9	-	-	-
1	001 320 06 00*		Bend Unit Capping	-	3.8	-	-
1	001 320 06 00*		Bend Unit Capping	-	-	5.1	-
1	001 320 06 00*		Bend Unit Capping	-	-	-	7.2
2	185 520 18 00		Intermediate Coupling	2	2	2	2
3	185 525 08 00		Thread Plate LH	2	2	2	2
4	185 525 08 01		Thread Plate RH	2	2	2	2
5	185 550 06 02*		Sliding Profile Bend Unit	5.9	-	-	-
5	185 550 06 02*		Sliding Profile Bend Unit	-	7.6	-	-
5	185 550 06 02*		Sliding Profile Bend Unit	-	-	10.1	-
5	185 550 06 02*		Sliding Profile Bend Unit	-	-	-	14.3
6	185 550 09 01		Pipe Holder	10	12	14	18
7	186 524 05 00		Traverse T250	3	-	-	-
7	187 524 05 00		Traverse T350	-	4	-	-
7	185 524 05 00		Traverse T500	-	-	5	-
7	188 524 05 00		Traverse T750	-	-	-	7
8	186 524 05 05		Traverse Narrow T250	2	-	-	-
8	187 524 05 05		Traverse Narrow T350	-	2	-	-
8	185 524 05 05		Traverse Narrow T500	-	-	2	-
8	188 524 05 05		Traverse Narrow T750	-	-	-	2
9		21 56 067	M6 x 12 Hex Bolt, Zinc	8	8	8	8
10		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	12	16	20	28
11		21 80 020	M4.2 x 22 Self-Tapping Screw, Zinc	10	12	14	18
12		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	8	8	8	8
13		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8	8
14		25 15 105	M6 Hex Nut, Zinc	8	8	8	8
15		26 02 109	M6 Flat Washer, Zinc	16	16	16	16

BOM Qty.s based on 90° Bend Unit

\*Qty. reflects total length (meters) to completely service (1) 90° Bend Unit

\*Components sold in (1) meter increments

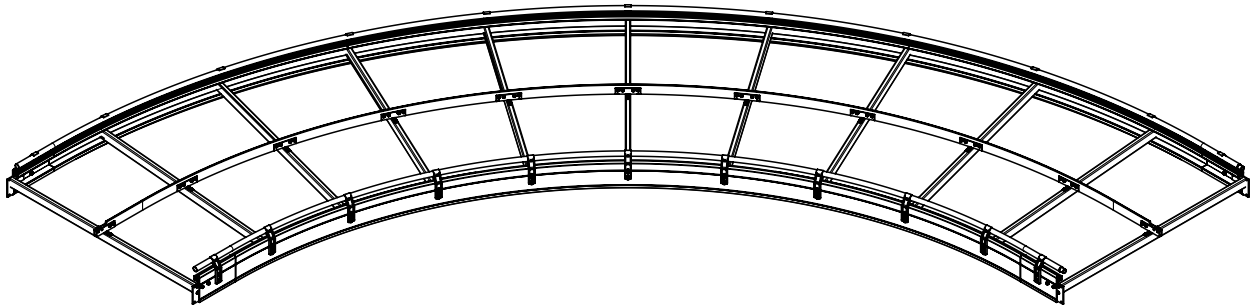




## Section 2

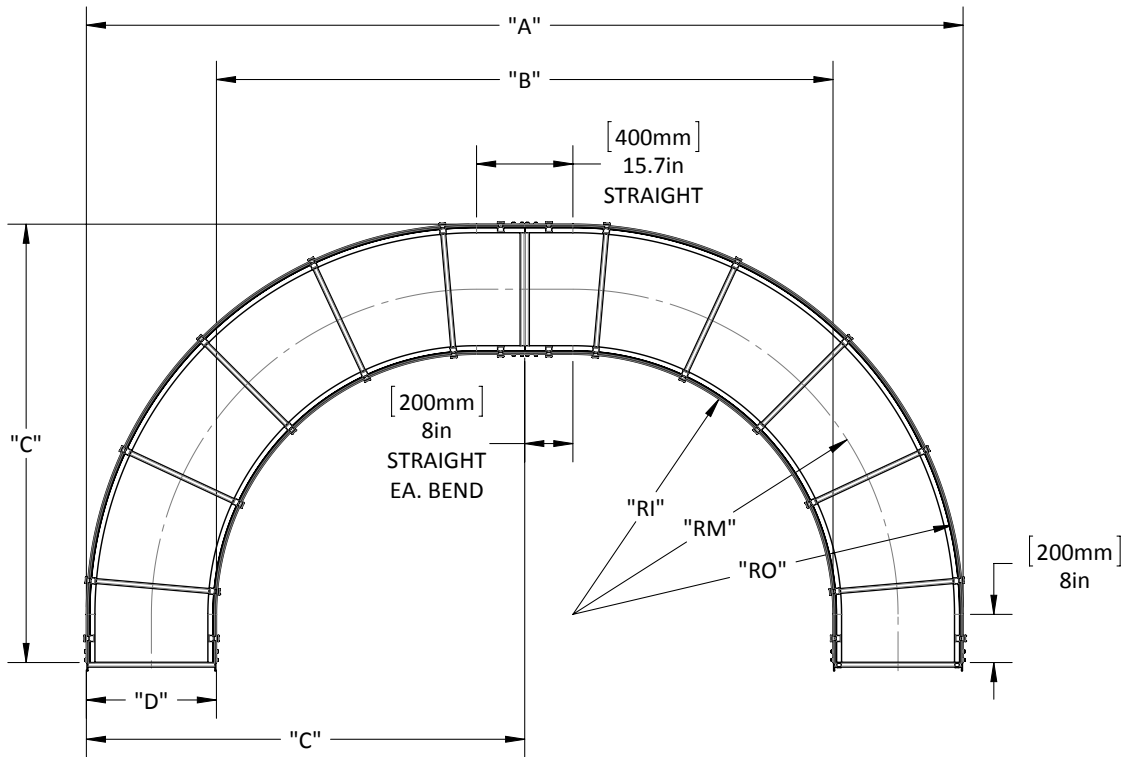
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### Bend Unit T1000



Bend Unit 90 Degree			
Conveyor Type	Part Number	Drawing Number	Description
1000	5412	--	Bend Unit T1000 90 Deg

Bend Unit 45 Degree			
Conveyor Type	Part Number	Drawing Number	Description
1000	5413	--	Bend Unit T1000 45 Deg



Bend Unit									
Part No.*	Conv. Type	Description	A** (mm/inches)	B** (mm/inches)	C** (mm/inches)	D (mm/inches)	RI*** (mm/inches)	RM*** (mm/inches)	RO*** (mm/inches)
5412	1000	Bend T1000 90 Deg	6840/269.3	4760/187.4	3420/134.6	1040/41.0	2180/85.8	2700/106.3	3220/126.8
5413		Bend T1000 45 Deg	N/A	N/A	N/A				

\*Part Numbers reflect single 90° Bend

\*\*Dimensions based on (2) 90° Bend Units assembled for 180° Bend

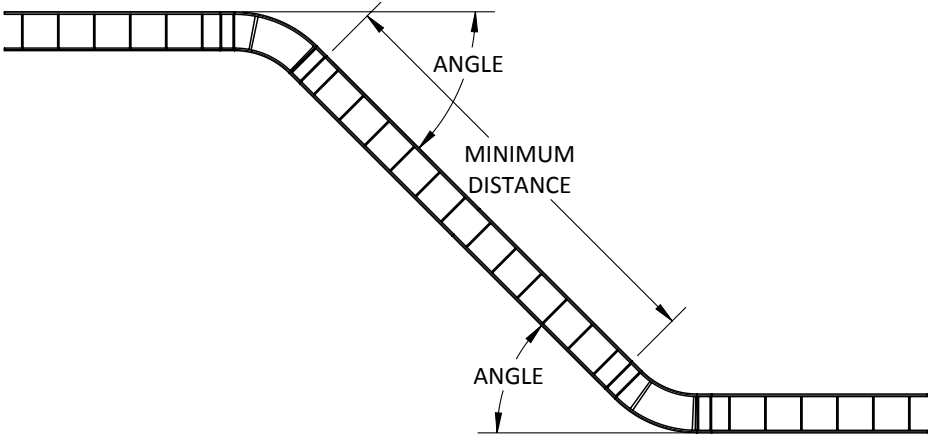
\*\*\*Radius dimensions are applicable to any degree Bend for a particular Conveyor Type

N/A = Not applicable to any Bend or pair of Bends other than 90°

Chain Length (approx.) through Bend Unit			
Conveyor Type	Chain Length (45°) (m/ft)	Chain Length (90°) (m/ft)	Chain Length (180°) (m/ft)****
1000	2.9/9.6	5.4/17.8	10.9/35.6

\*\*\*\*180° Chain Length based on (2) 90° Bends

# Section 2



Minimum Distances Between Offset Bend Units (meters/feet)									
Conveyor Type	3°-5°	6°-10°	11°-15°	16°-20°	21°-25°	26°-30°	31°-35°	36°-40°	45°-90°
1000	2/6.6	3.0/9.8	4.0/13.1	4.5/14.8	5/16.4	5.5/18.0	6.0/19.7	6.5/21.3	7.0/23.0

All dimensions are reference only. Other variables within the system may affect minimum lengths as noted.

## Section 2

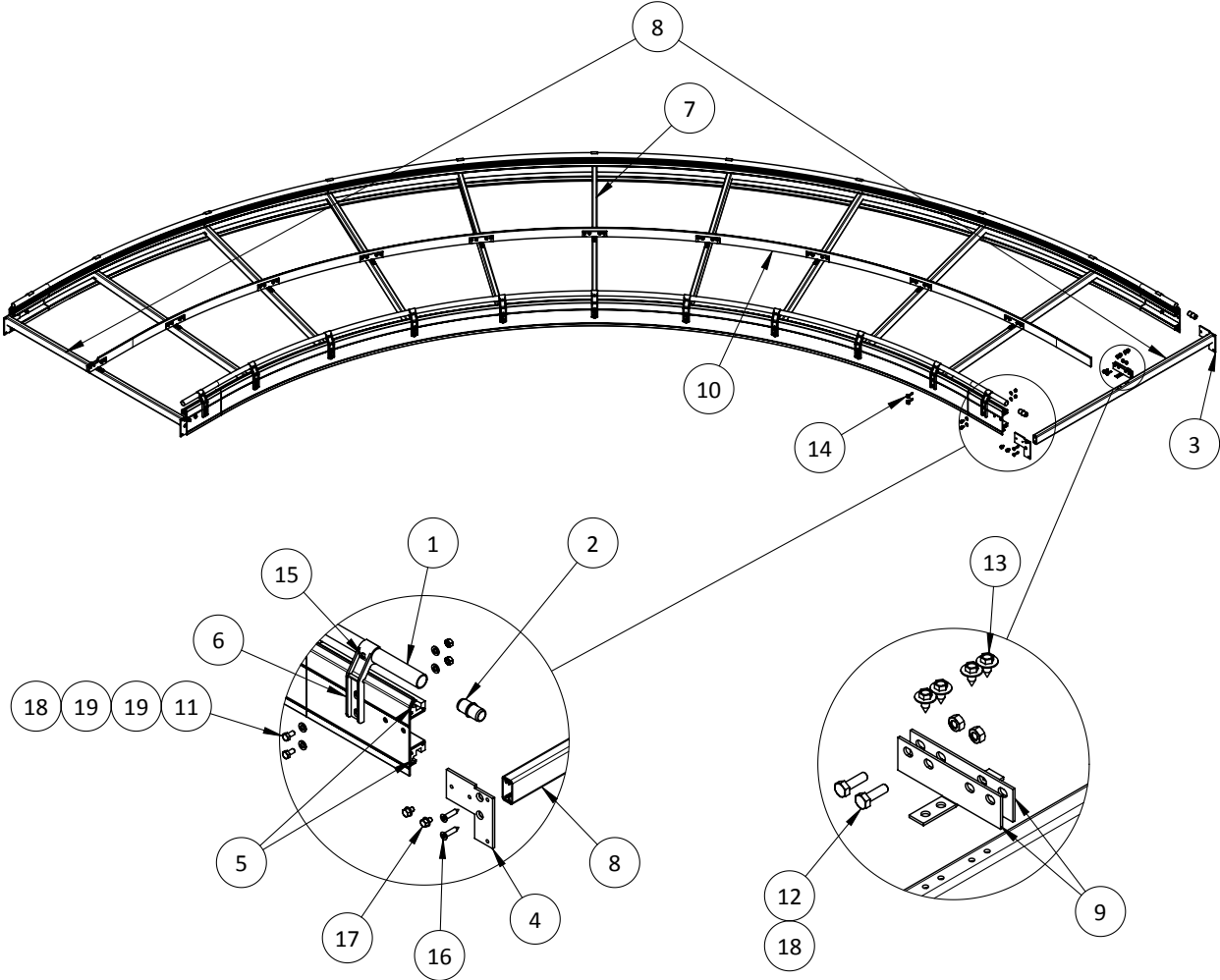
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	001 320 06 00*		Bend Unit Capping	9.2
2	185 520 18 00		Intermediate Coupling	2
3	185 525 08 00		Thread Plate LH	2
4	185 525 08 01		Thread Plate RH	2
5	185 550 06 02*		Sliding Profile Bend Unit	18.6
6	185 550 09 01		Pipe Holder	22
7	191 524 05 07		Traverse T1000 (Thin Side Holes)	9
8	191 524 05 08		Traverse Narrow T1000	2
9	191 524 07 00		Connecting Angle	22
10	191 525 26 00		Center Profile, Bend T1000	1
11		21 56 067	M6 x 12 Hex Bolt, Zinc	8
12		21 56 069	M6 x 20 Hex Bolt, Zinc	40
13		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	44
14		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	36
15		21 80 020	M4.2 x 22 Self-Tapping Screw, Zinc	22
16		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	8
17		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8
18		25 15 105	M6 Hex Nut, Zinc	48
19		26 02 109	M6 Flat Washer, Zinc	16

BOM Qty.s based on 90° Bend Unit

\*Qty. reflects total length (meters) to completely service (1) 90° Bend Unit

\*Components sold in (1) meter increments

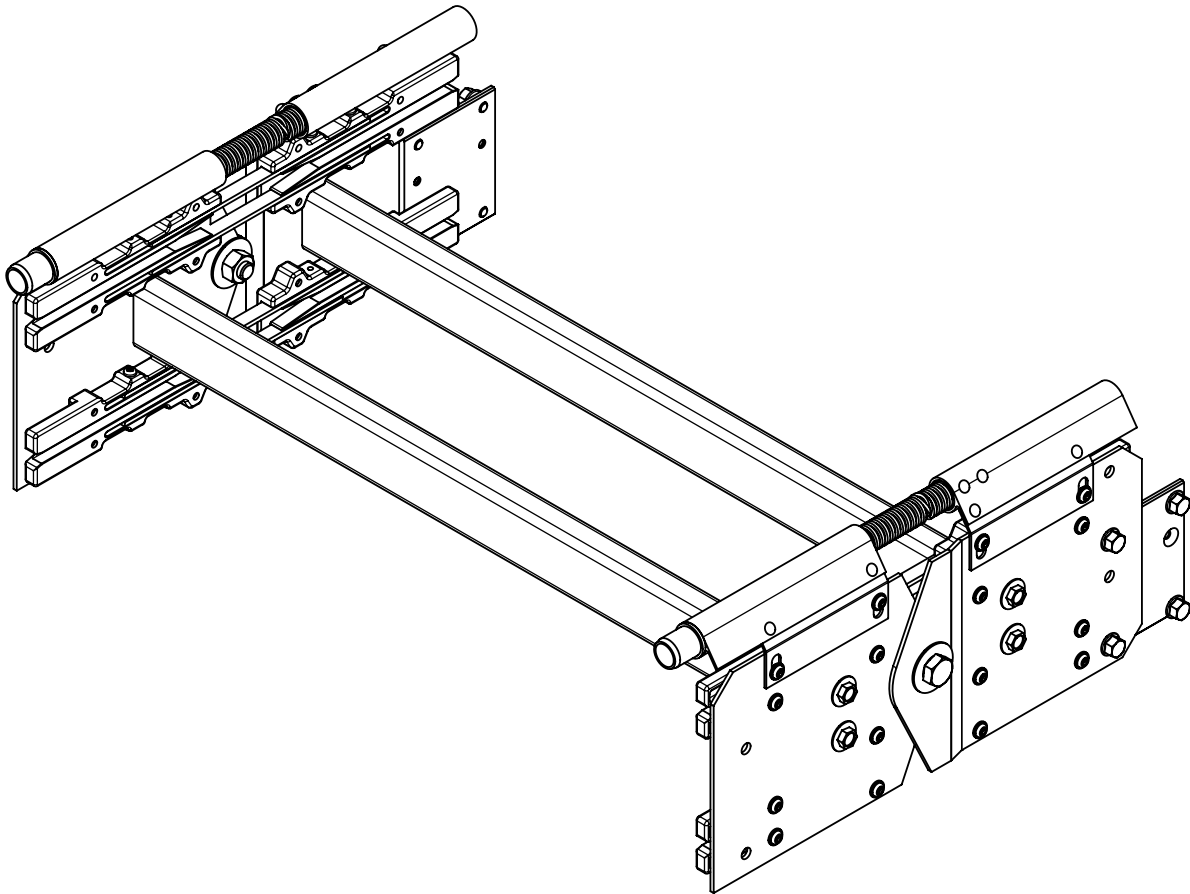
# Section 2



## Section 2

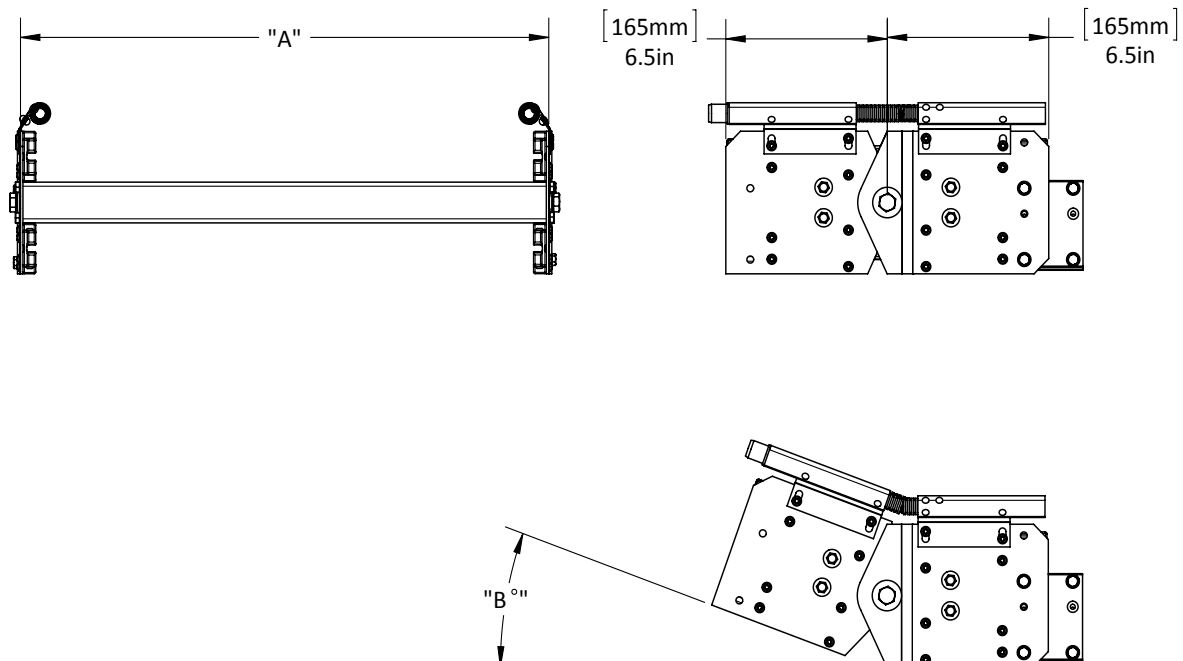
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### Pivot Unit T250 - T750



Pivot Unit			
Conveyor Type	Part Number	Drawing Number	Description
250	4905	--	Pivot Unit T250
350	4844	--	Pivot Unit T350
500	4805	--	Pivot Unit T500
750	4874	--	Pivot Unit T750

## Section 2

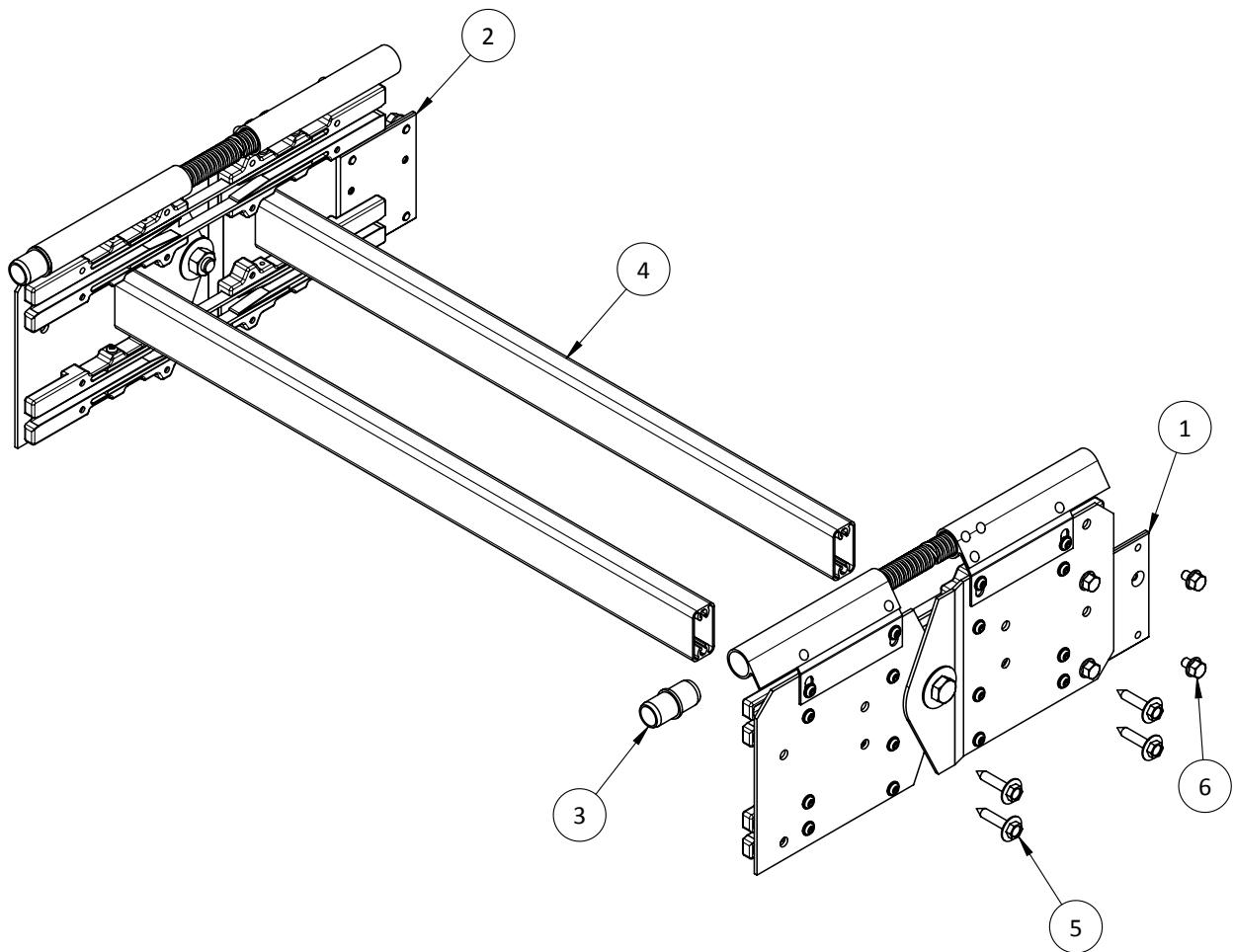


Pivot Unit					
Part Number	Conveyor Type	Description	A (mm/inches)	B ° max* (Standard Chain)	B ° max* (Coated Chain)
4905	250	Pivot Unit T250	290/11.4	20 °	18 °
4844	350	Pivot Unit T350	390/14.4		
4805	500	Pivot Unit T500	540/21.3		
4874	750	Pivot Unit T750	790/31.1		

\*Typical max incline or decline angle, other factors may limit max angle.  
Consult engineering for more information.

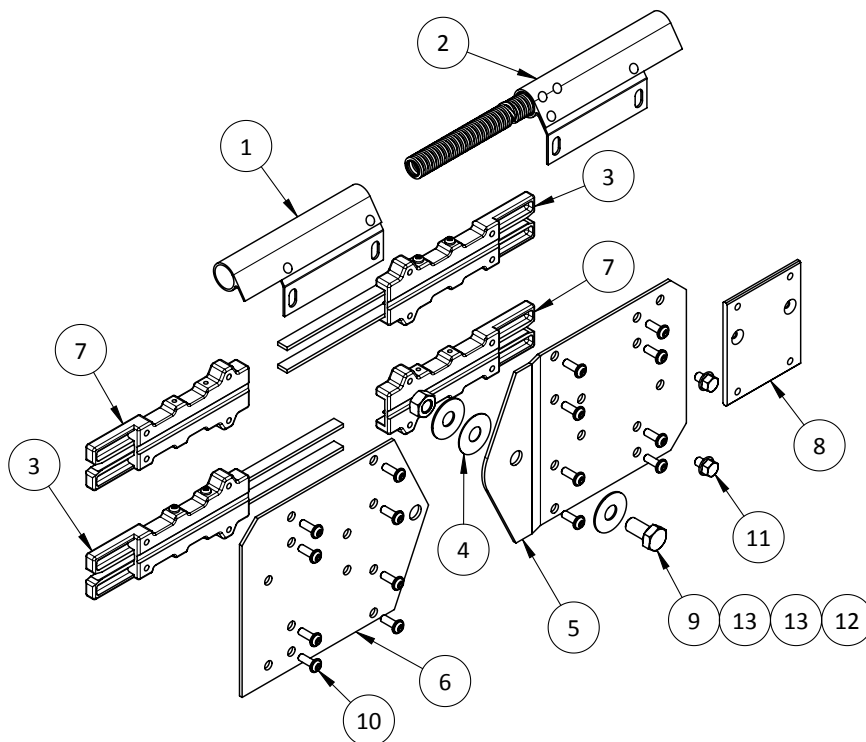
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 100 02 04		Pivot Sidesheet Complete LH	1	1	1	1
2	185 100 02 05		Pivot Sidesheet Complete RH	1	1	1	1
3	185 520 18 00		Intermediate Coupling	2	2	2	2
4	186 524 05 00		Traverse T250	2	-	-	-
4	187 524 05 00		Traverse T350	-	2	-	-
4	185 524 05 00		Traverse T500	-	-	2	-
4	188 524 05 00		Traverse T750	-	-	-	2
5		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	8	8	8	8
6		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4	4	4	4





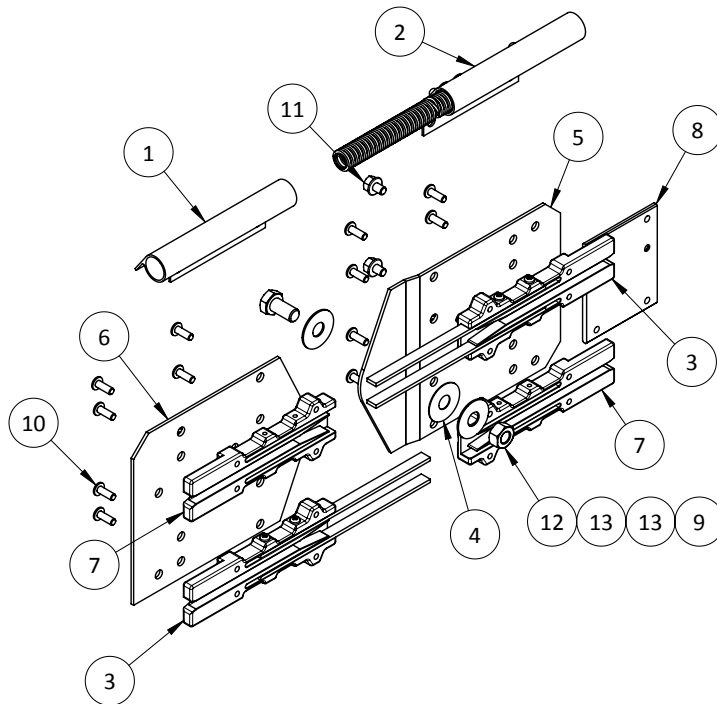
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 08 00		Pivot Capping Complete LH	1
2	185 100 09 00		Pivot Flex Capping Complete LH	1
3	185 100 11 00		Sliding Shoe Long Complete	2
4	185 515 13 02		Distance Washer	1
5	185 525 01 02		Pivot Outer Sidesheet	1
6	185 525 02 02		Pivot Inner Sidesheet	1
7	185 525 05 01		Sliding Shoe Long	2
8	185 525 06 00		Thread Plate	1
9		21 56 107	M10 x 20 Hex Bolt, Zinc	1
10		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	16
11		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	2
12		25 20 107	M10 Self-Locking Nut, Zinc	1
13		26 34 112	M10 Fender Washer, Zinc	2



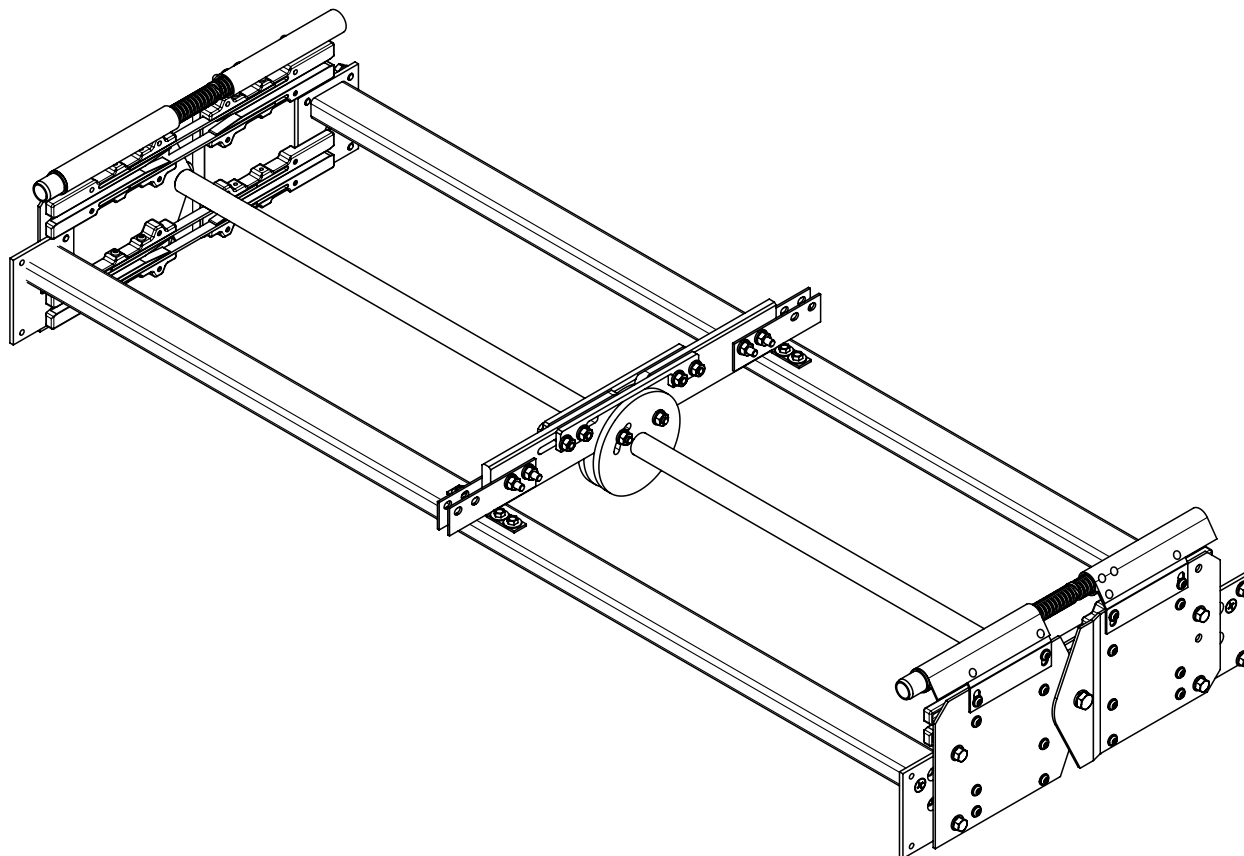
Pivot Complete Sidesheet LH			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 100 02 04	Pivot Sidesheet Complete LH
350			
500			
750			

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 08 01		Pivot Capping Complete RH	1
2	185 100 09 01		Pivot Flex Capping Complete RH	1
3	185 100 11 00		Sliding Shoe Long Complete	2
4	185 515 13 02		Distance Washer	1
5	185 525 01 02		Pivot Outer Sidesheet	1
6	185 525 02 02		Pivot Inner Sidesheet	1
7	185 525 05 01		Sliding Shoe Long	2
8	185 525 06 00		Thread Plate	1
9		21 56 107	M10 x 20 Hex Bolt, Zinc	1
10		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	16
11		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	2
12		25 20 107	M10 Self-Locking Nut, Zinc	1
13		26 34 112	M10 Fender Washer, Zinc	2

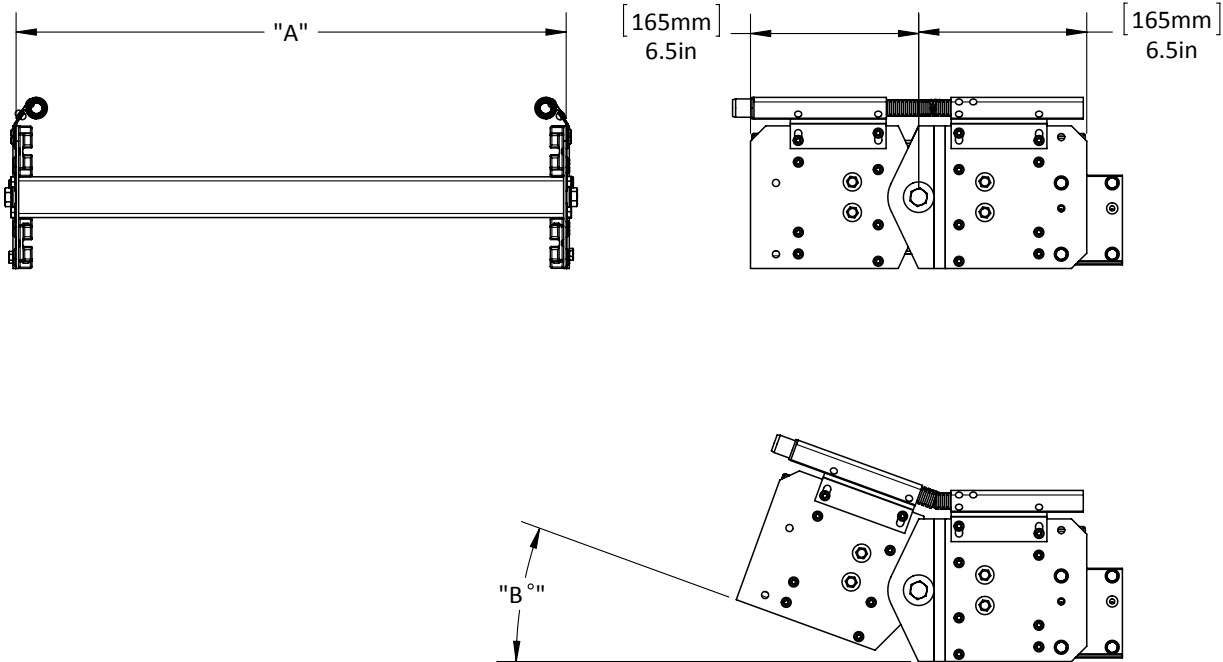


Pivot Sidesheet Complete RH			
Conveyor Type	Part Number	Drawing Number	Description
250	--	185 100 02 05	Pivot Sidesheet Complete RH
350			
500			
750			

**Pivot Unit T1000**

Pivot Unit			
Conveyor Type	Part Number	Drawing Number	Description
1000	5405	--	Pivot Unit T1000

# Section 2

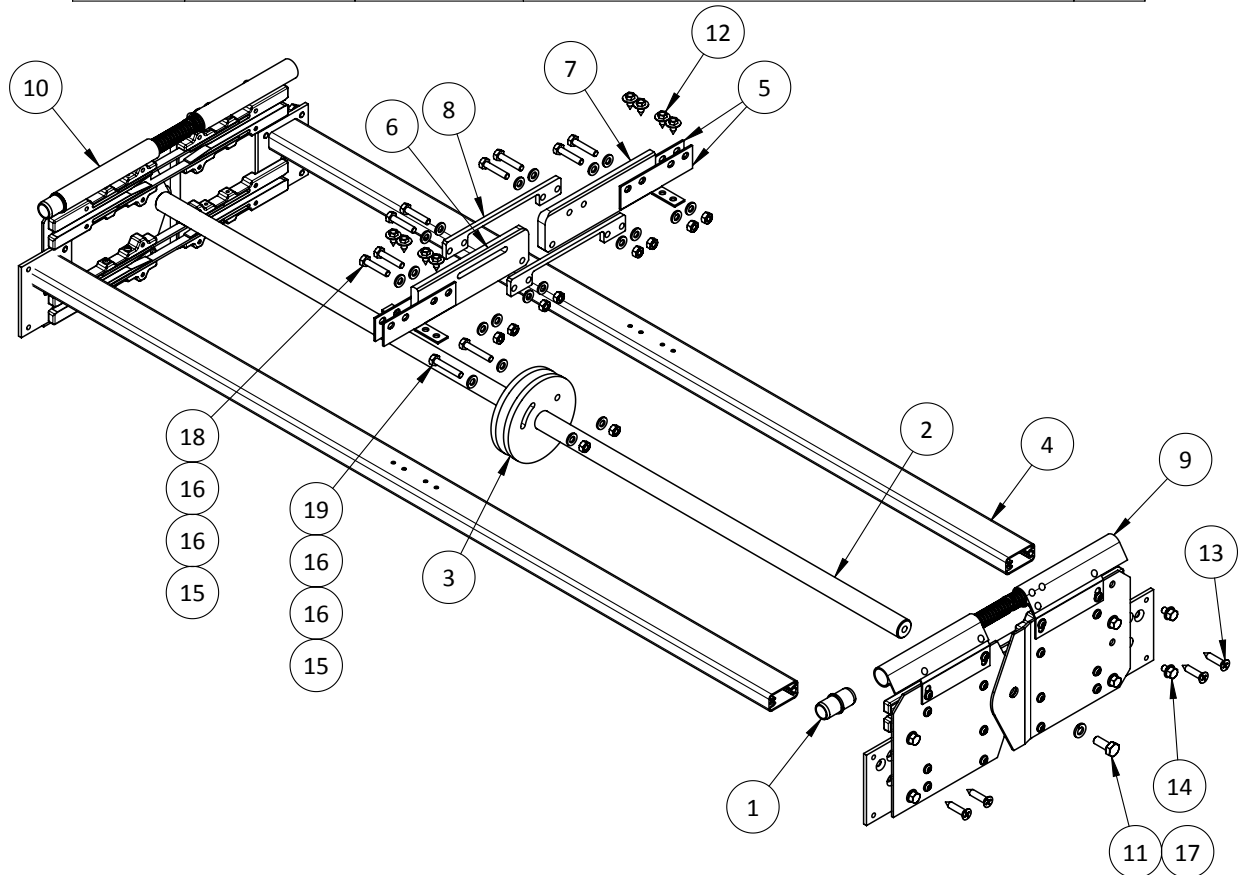


Pivot Unit				
Part Number	Conveyor Type	Description	A (mm/inches)	B ° max* (Standard Chain)
5405	1000	Pivot Unit T1000	1040/41.0	18 °

\*Typical max incline or decline angle, other factors may limit max angle. Consult engineering for more information.

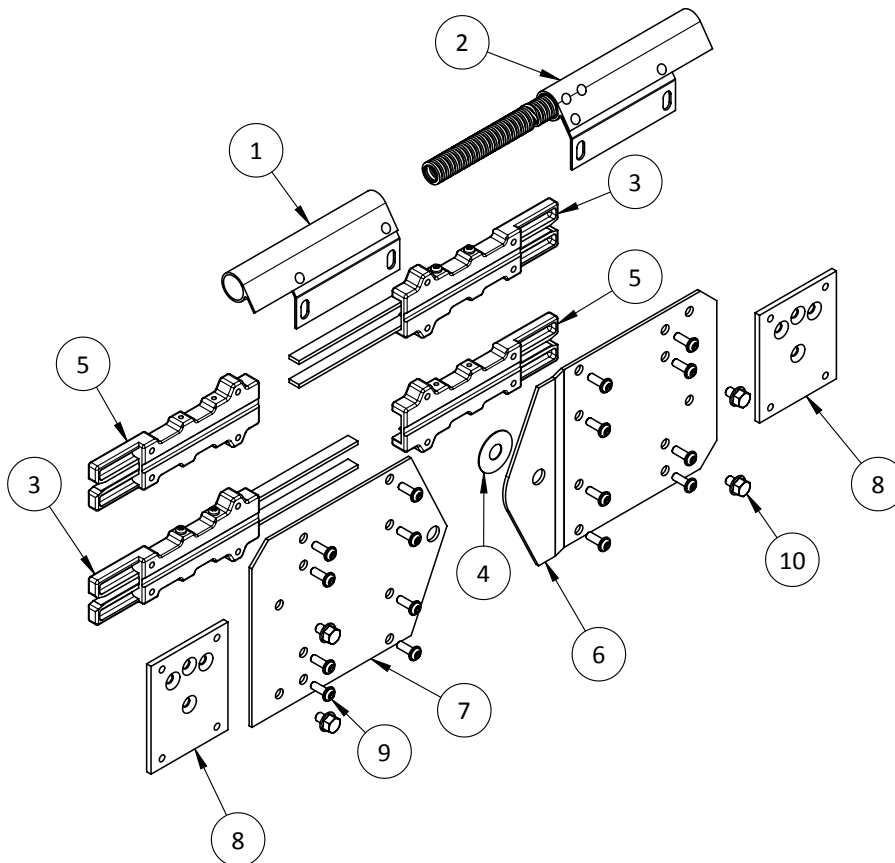
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	185 520 18 00		Intermediate Coupling	2
2	191 515 04 02		20mm Axle T1000	1
3	191 518 14 00		Fastening Disk	1
4	191 524 05 06		Traverse NarrowT1000 (Wide Side Holes)	2
5	191 524 07 00		Connecting Angle	4
6	191 525 22 00		Sliding Profile	1
7	191 525 22 01		Sliding Profile	1
8	191 525 25 00		Slide Strip </td <td>2</td>	2
9	191 530 01 00		Pivot Sidesheet Complete LH T1000	1
10	191 530 01 01		Pivot Sidesheet Complete RH T1000	1
11		21 56 087	M8 x 20 Hex Bolt, Zinc	2
12		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	8
13		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	8
14		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4
15		25 15 105	M6 Hex Nut, Zinc	10
16		26 02 109	M6 Flat Washer, Zinc	20
17		26 04 111	M8 Lock Washer, Zinc	2
18		F8-7-46-2-171	M6 x 30 Hex Bolt, Zinc	8
19		F8-7-46-2-176	M6 x 35 Hex Bolt, Zinc	2



## Section 2

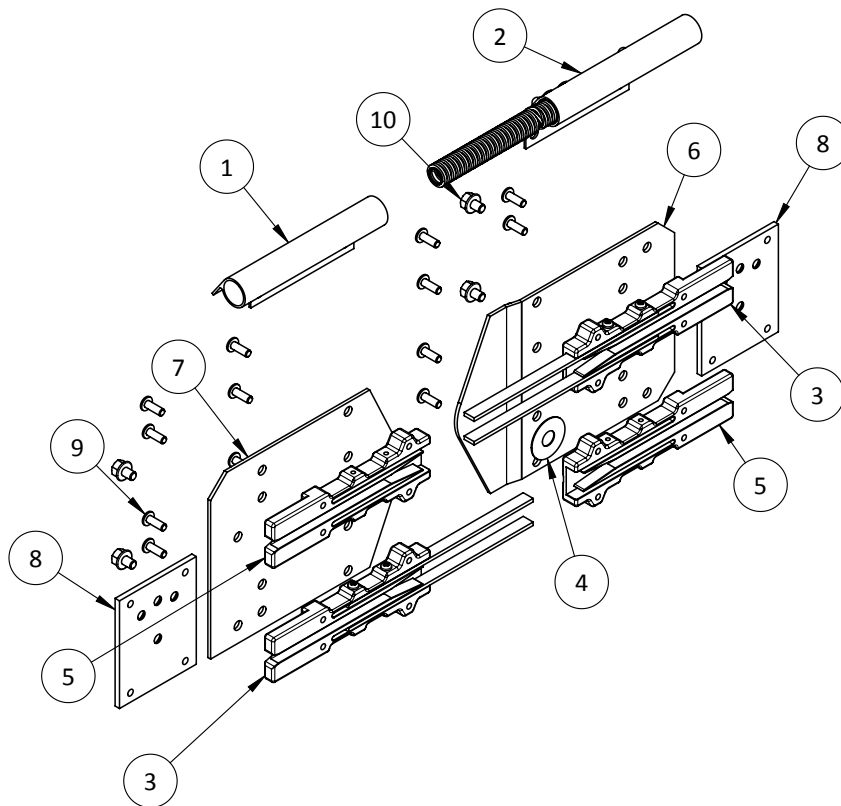
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 08 00		Pivot Capping Complete LH	1
2	185 100 09 00		Pivot Flex Capping Complete LH	1
3	185 100 11 00		Sliding Shoe Long Complete	2
4	185 515 13 02		Distance Washer	1
5	185 525 05 01		Sliding Shoe Long	2
6	191 525 01 02		Pivot Outer Sidesheet T1000	1
7	191 525 02 02		Pivot Inner Sidesheet T1000	1
8	191 525 06 00		Thread Plate	2
9		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	16
10		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4



Pivot Complete Sidesheet LH			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 530 01 00	Pivot Sidesheet Complete LH

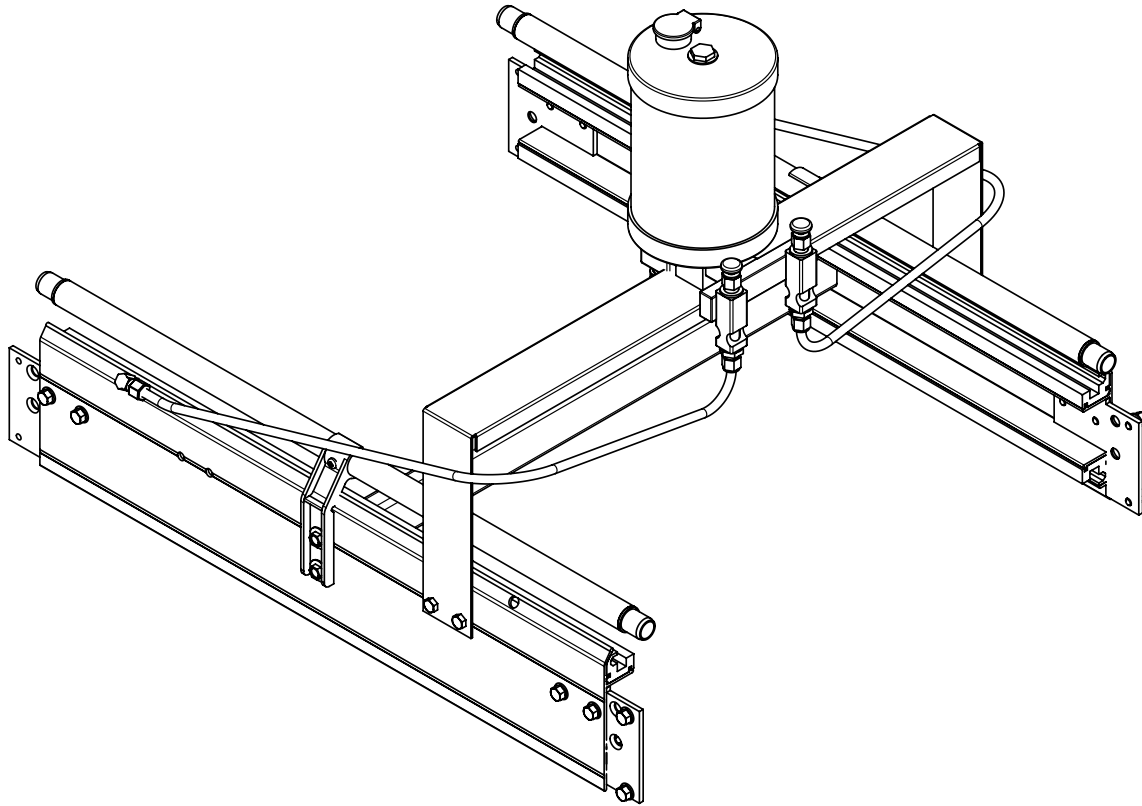
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 100 08 01		Pivot Capping Complete RH	1
2	185 100 09 01		Pivot Flex Capping Complete RH	1
3	185 100 11 00		Sliding Shoe Long Complete	2
4	185 515 13 02		Distance Washer	1
5	185 525 05 01		Sliding Shoe Long	2
6	191 525 01 02		Pivot Outer Sidesheet T1000	1
7	191 525 02 02		Pivot Inner Sidesheet T1000	1
8	191 525 06 00		Thread Plate	2
9		21 96 203	M5 x 14 Torx Head Tapping Screw, Zinc	16
10		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4



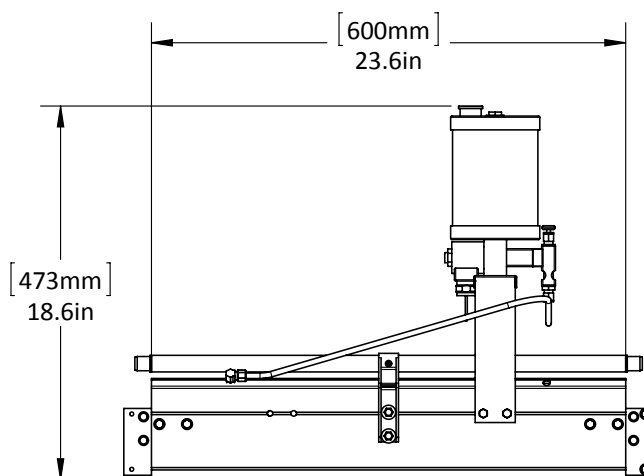
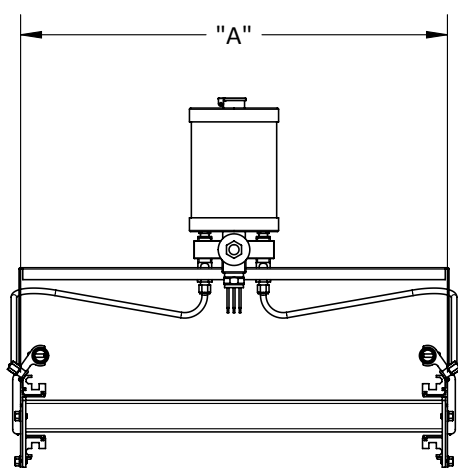
Pivot Sidesheet Complete RH			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 530 01 01	Pivot Sidesheet Complete RH

**Drip Oiler T250 - T750**



<b>Drip Oiler (120v and 240v)</b>			
<b>Conveyor Type</b>	<b>Part Number</b>	<b>Drawing Number</b>	<b>Description</b>
250	4929-120	--	Drip Oiler T250 120v
	4929-240	--	Drip Oiler T250 240v
350	4859-120	--	Drip Oiler T350 120v
	4859-240	--	Drip Oiler T350 240v
500	4829-120	--	Drip Oiler T500 120v
	4829-240	--	Drip Oiler T500 240v
750	4889-120	--	Drip Oiler T750 120v
	4889-240	--	Drip Oiler T750 240v





Drip Oiler			
Part Number	Conveyor Type	Description	A* (mm/inches)
4929-120 / 4929-240	250	Drip Oiler T250 (120v or 240v)	290/11.4
4859-120 / 4859-240	350	Drip Oiler T350 (120v or 240v)	390/15.4
4829-120 / 4829-240	500	Drip Oiler T500 (120v or 240v)	540/21.3
4889-120 / 4889-240	750	Drip Oiler T750 (120v or 240v)	790/31.1

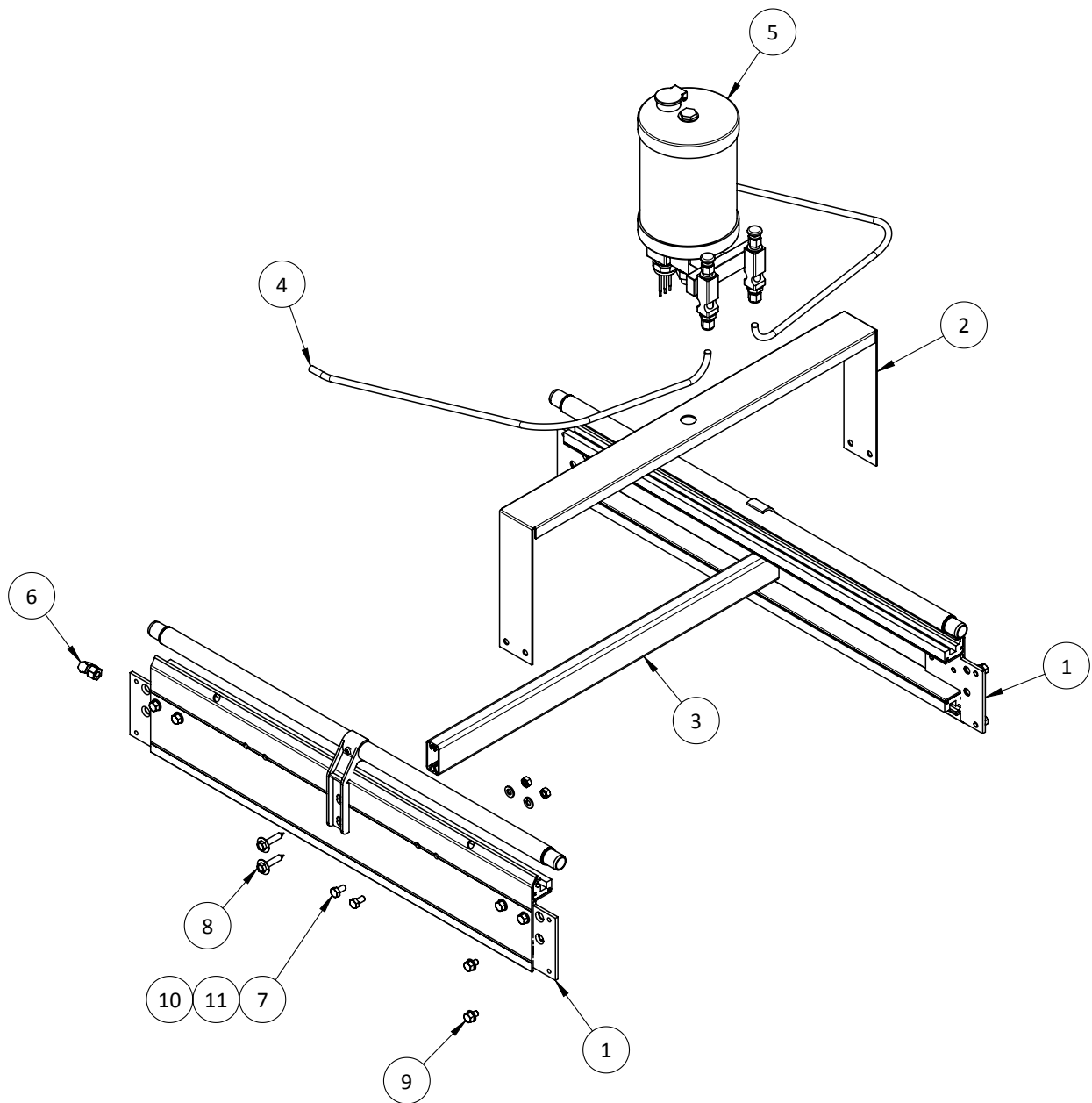
\*Dimensions not affected by Drip Oiler voltage

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 100 16 00		Drip Oiler Sidesheet Complete	2	2	2	2
2	186 511 35 00		Oiler Bridge T250	1	-	-	-
2	187 511 35 00		Oiler Bridge T350	-	1	-	-
2	185 511 35 00		Oiler Bridge T500	-	-	1	-
2	188 511 35 00		Oiler Bridge T750	-	-	-	1
3	186 524 05 00		Traverse T250	1	-	-	-
3	187 524 05 00		Traverse T350	-	1	-	-
3	185 524 05 00		Traverse T500	-	-	1	-
3	188 524 05 00		Traverse T750	-	-	-	1
4		1P640**	Tubing 1/4" (Clear)	4	-	-	-
4		1P640**	Tubing 1/4" (Clear)	-	5	-	-
4		1P640**	Tubing 1/4" (Clear)	-	-	5	-
4		1P640**	Tubing 1/4" (Clear)	-	-	-	6
5		1U725-XXX*	Drip Oiler	1	1	1	1
6		2P249	1/8" to 1/4" Male Compression Elbow	2	2	2	2
7		21 56 067	M6 x 12 Hex Bolt, Zinc	4	4	4	4
8		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	4	4	4	4
9		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4	4	4	4
10		25 15 105	M6 Hex Nut, Zinc	4	4	4	4
11		26 02 109	M6 Flat Washer, Zinc	4	4	4	4

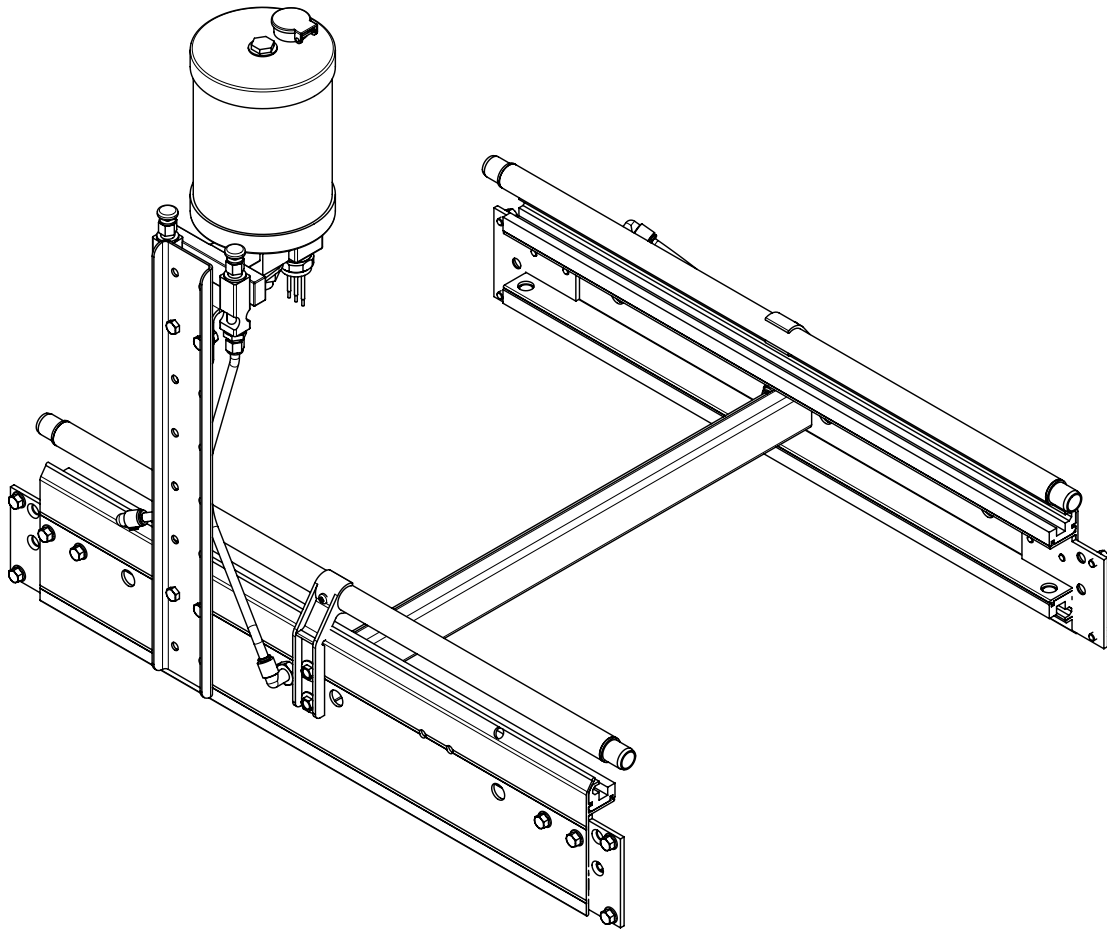
\*Specify voltage when ordering, "-120" for 120 volt, "-240" for 240 volt

\*\*Qty. listed reflects total feet of tubing required for (1) Drip Oiler

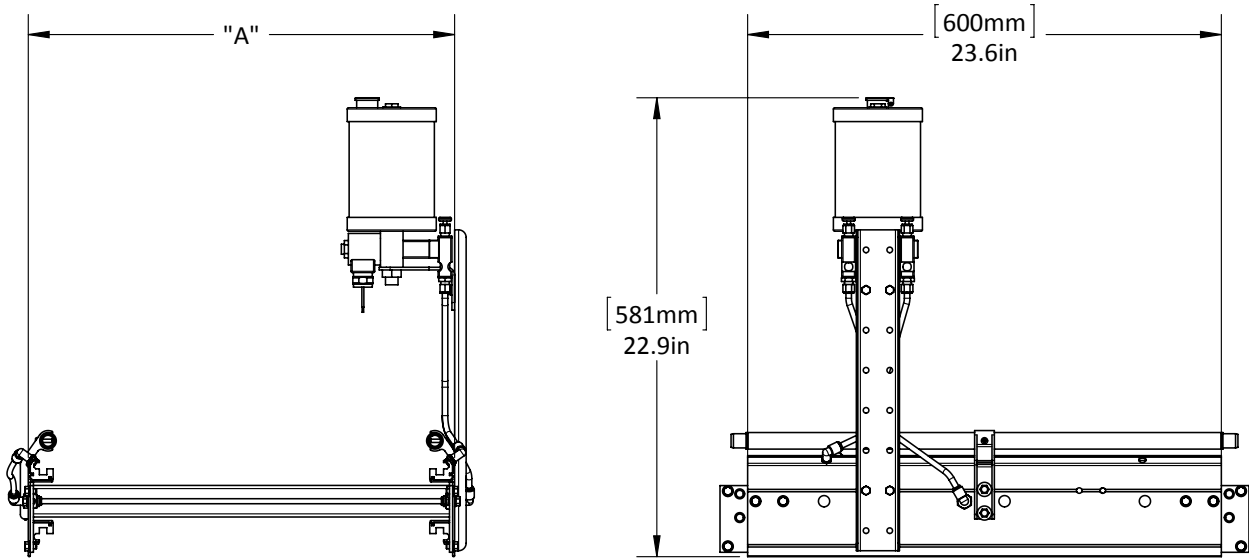


## Section 2

### Top Oiler T250 - T750



Top Drip Oiler (120v and 240v)			
Conveyor Type	Part Number	Drawing Number	Description
250	C100A	--	Top Drip Oiler T250 120v
	C101A	--	Top Drip Oiler T250 240v
350	D100A	--	Top Drip Oiler T350 120v
	D101A	--	Top Drip Oiler T350 240v
500	E100A	--	Top Drip Oiler T500 120v
	E101A	--	Top Drip Oiler T500 240v
750	F100A	--	Top Drip Oiler T750 120v
	F101A	--	Top Drip Oiler T750 240v



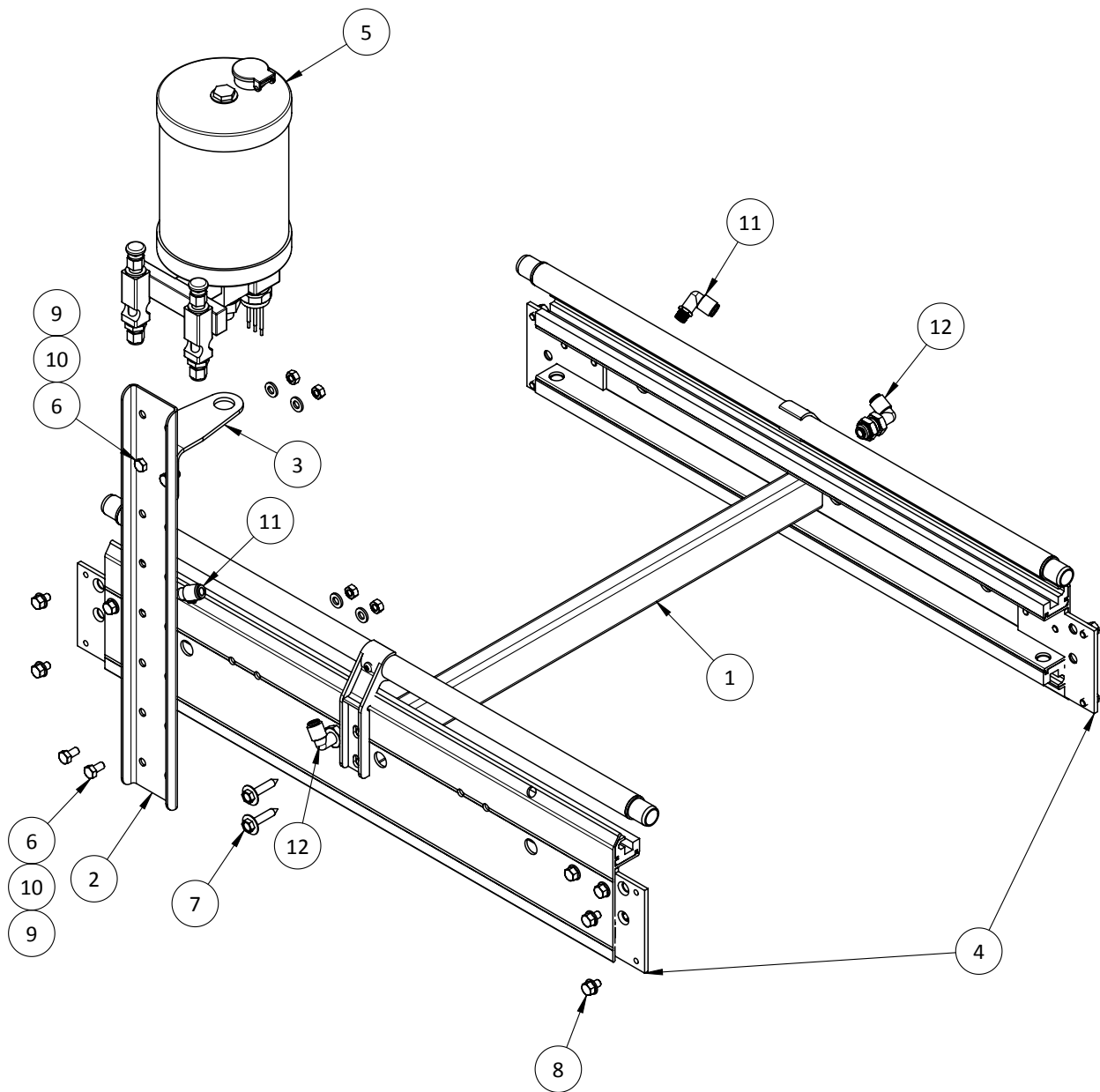
Top Oiler			
Part Number	Conveyor Type	Description	A* (mm/inches)
C100A / C101A	250	Top Oiler T250 (120v or 240v)	290/11.4
D100A / D101A	350	Top Oiler T350 (120v or 240v)	390/15.4
E100A / E101A	500	Top Oiler T500 (120v or 240v)	540/21.3
F100A / F101A	750	Top Oiler T750 (120v or 240v)	790/31.1

\*Dimensions not effected by Drip Oiler voltage

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250 120v	T250 240v	T350 120v	T350 240v	T500 120v	T500 240v	T750 120v	T750 240v
1	186 524 05 00		Traverse T250	1	1	-	-	-	-	-	-
1	187 524 05 00		Traverse T350	-	-	1	1	-	-	-	-
1	185 524 05 00		Traverse T500	-	-	-	-	1	1	-	-
1	188 524 05 00		Traverse T750	-	-	-	-	-	-	1	1
2	707 027 01 00		Drip Oiler Vertical Support	1	1	1	1	1	1	1	1
3	707 027 02 00		Drip Oiler Angle Support	1	1	1	1	1	1	1	1
4	707 127 01 00		Drip Oiler Sidesheet Complete US	2	2	2	2	2	2	2	2
5		1U725-120	Electric Drip Oiler, 120 volt	1	-	1	-	1	-	1	-
5		1U725-240	Electric Drip Oiler, 240 volt	-	1	-	1	-	1	-	1
6		21 56 067	M6 x 12 Hex Bolt, Zinc	4	4	4	4	4	4	4	4
7		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	4	4	4	4	4	4	4	4
8		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8	8	8	8	8	8
9		25 15 105	M6 Hex Nut, Zinc	4	4	4	4	4	4	4	4
10		26 02 109	M6 Flat Washer, Zinc	4	4	4	4	4	4	4	4
11		KQ2L07-34	Male Elbow Fitting 1/4"	2	2	2	2	2	2	2	2
12		KQ2LE07-00	Male Elbow Bulkhead Fitting 1/4"	2	2	2	2	2	2	2	2
13		TIA07R-305*	Tubing 1/4" (Red)	10	10	-	-	-	-	-	-
13		TIA07R-305*	Tubing 1/4" (Red)	-	-	10	10	-	-	-	-
13		TIA07R-305*	Tubing 1/4" (Red)	-	-	-	-	10	10	-	-
13		TIA07R-305*	Tubing 1/4" (Red)	-	-	-	-	-	-	10	10

\*Qty. reflects length (feet) required to complete (1) unit

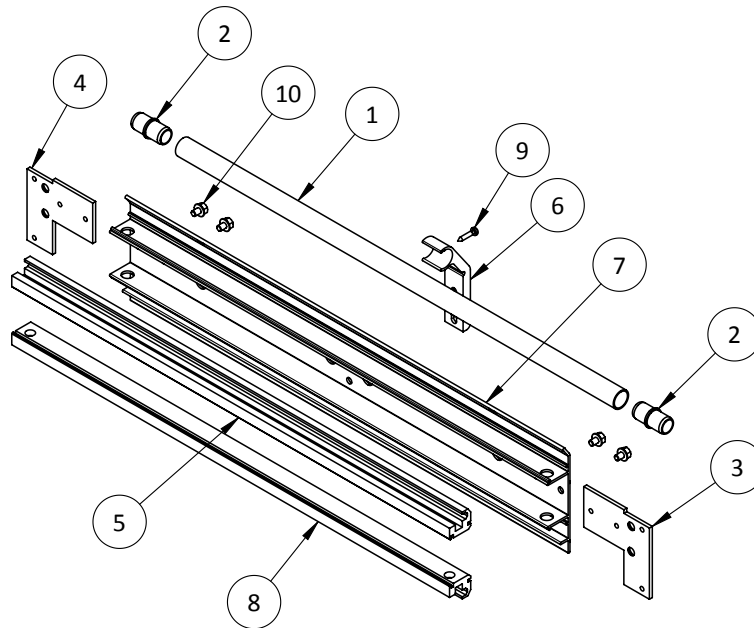


Item #13 not shown for clarity

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	001 320 06 00*		Bend Unit Capping	0.6
2	185 520 18 00		Intermediate Coupling	2
3	185 525 08 00		Thread Plate LH	1
4	185 525 08 01		Thread Plate RH	1
5	185 550 06 02*		Sliding Profile Bend Unit	1.2
6	185 550 09 01		Pipe Holder	1
7	707 027 03 00		Sidesheet Drip Oiler US	1
8	707 027 04 00		Drip Oiler Sliding Profile USA	1
9		21 80 020	M4.2 x 22 Self-Tapping Screw, Zinc	1
10		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4

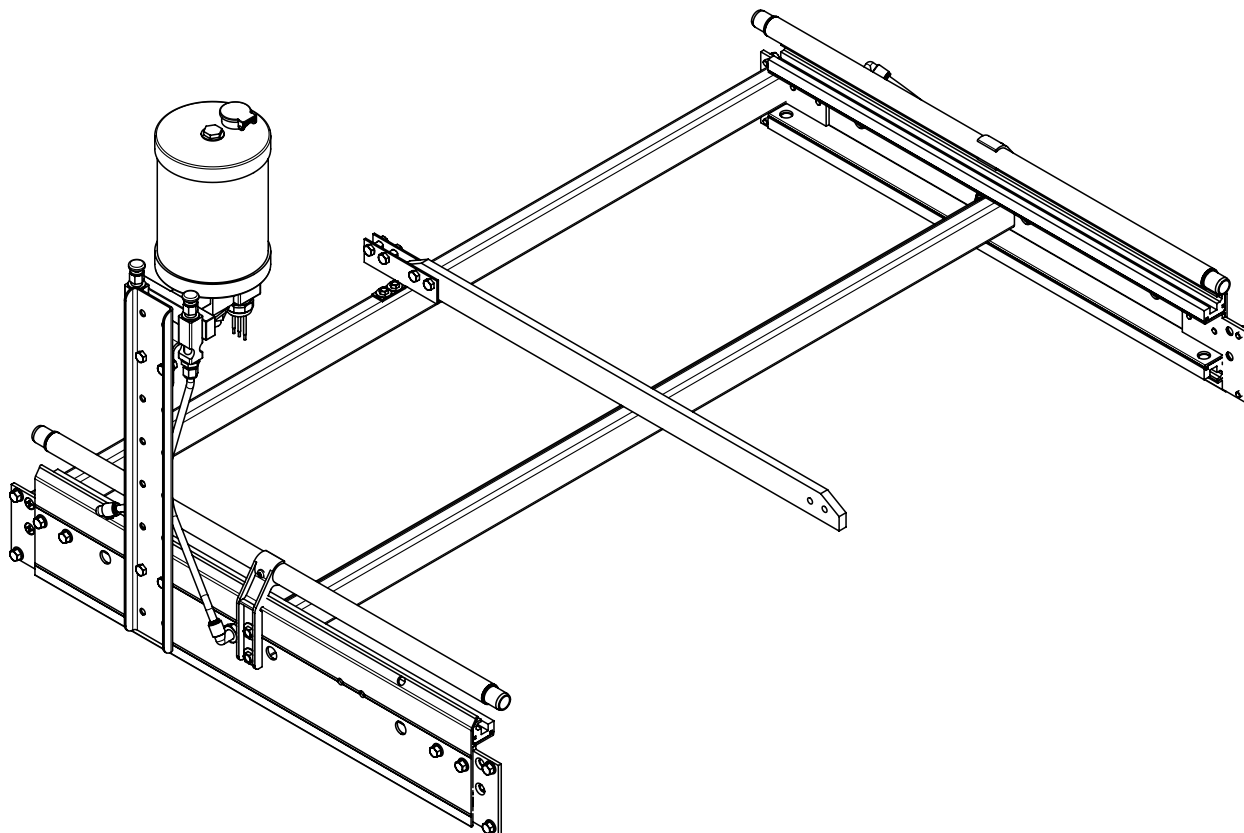
\*Qty. reflects total length (meters) to complete (1) Drip Oiler Sidesheet



Drip Oiler Sidesheet Complete US			
Conveyor Type	Part Number	Drawing Number	Description
250	--	707 127 01 00	Drip Oiler Sidesheet Complete US
350			
500			
750			

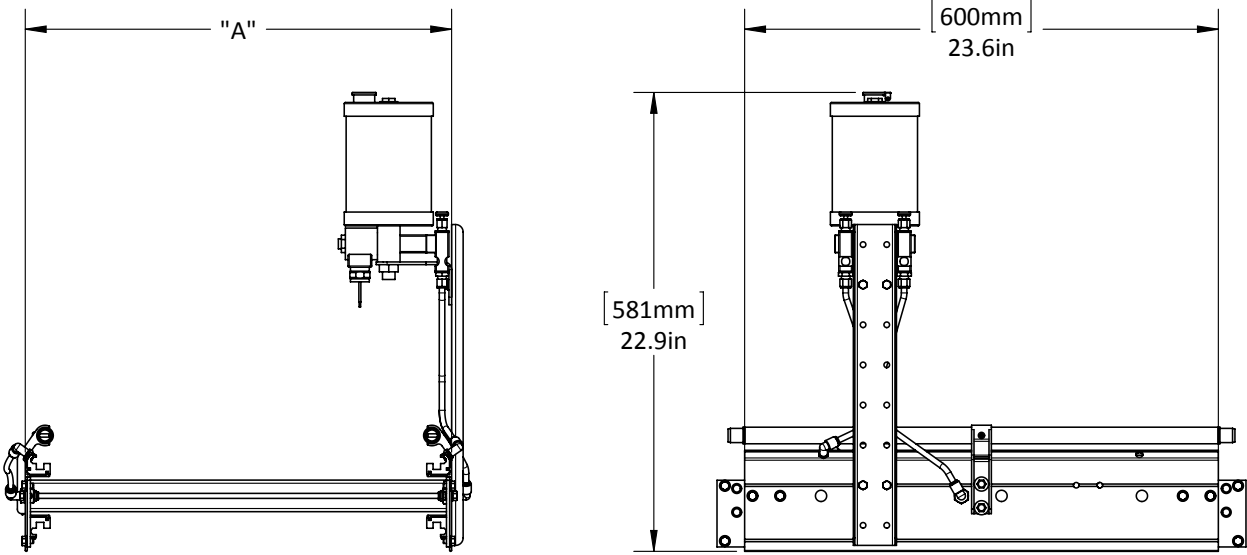


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**Top Oiler T1000**

Top Drip Oiler (120v and 240v)			
Conveyor Type	Part Number	Drawing Number	Description
1000	G100A	--	Top Drip Oiler T1000 120v
	G101A	--	Top Drip Oiler T1000 240v

# Section 2



Top Oiler			
Part Number	Conveyor Type	Description	A* (mm/inches)
G100A / G101A	1000	Top Oiler T1000 (120v or 240v)	1040/41.0

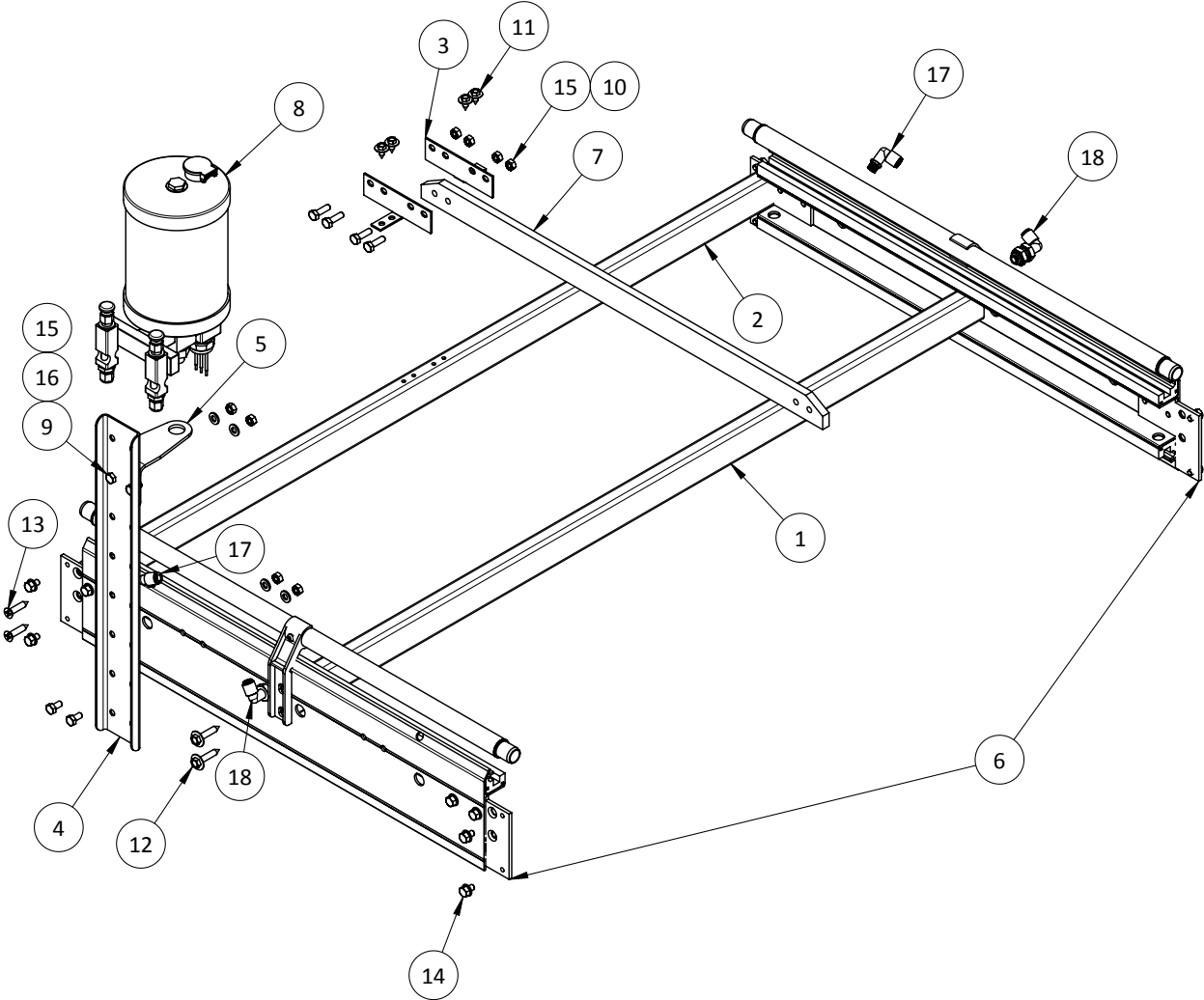
\*Dimensions not effected by Drip Oiler voltage

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000 120v	T1000 240v
1	191 524 05 00		Traverse T1000 (No Holes)	1	1
2	191 524 05 08		Traverse Narrow T1000 (Thin Side Holes)	1	1
3	191 524 07 00		Connecting Angle	2	2
4	707 027 01 00		Drip Oiler Vertical Support	1	1
5	707 027 02 00		Drip Oiler Angle Support	1	1
6	707 127 01 00		Drip Oiler Sidesheet Complete US	2	2
7	709 127 01 00		Center Support, Drip Oiler	1	1
8		1U725-120	Electric Drip Oiler, 120 volt	1	-
8		1U725-240	Electric Drip Oiler, 240 volt	-	1
9		21 56 067	M6 x 12 Hex Bolt, Zinc	4	4
10		21 56 069	M6 x 20 Hex Bolt, Zinc	4	4
11		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	4	4
12		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	4	4
13		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	4	4
14		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8
15		25 15 105	M6 Hex Nut, Zinc	8	8
16		26 02 109	M6 Flat Washer, Zinc	4	4
17		KQ2L07-34	Male Elbow Fitting 1/4"	2	2
18		KQ2LE07-00	Male Elbow Bulkhead Fitting 1/4"	2	2
19		TIA07R-305*	Tubing 1/4" (Red)	15	15

\*Qty. reflects length (feet) required to complete (1) unit

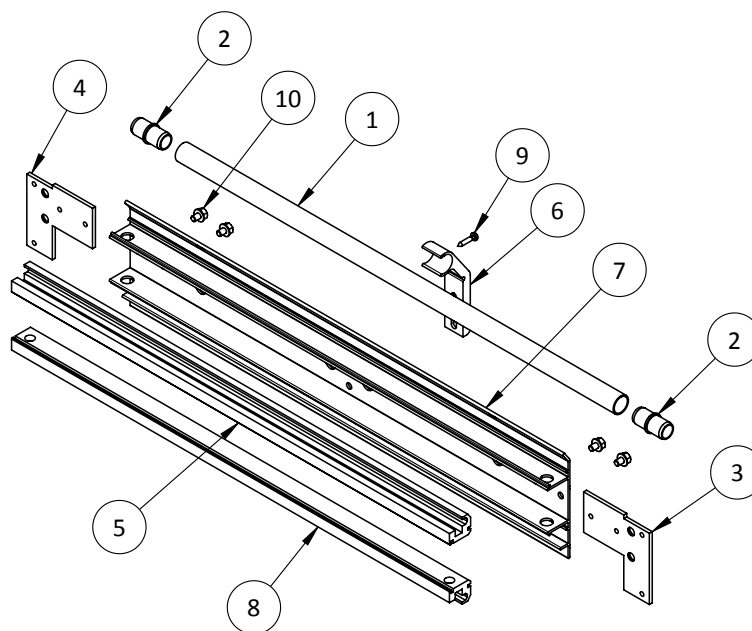
# Section 2



Item #19 not shown for clarity

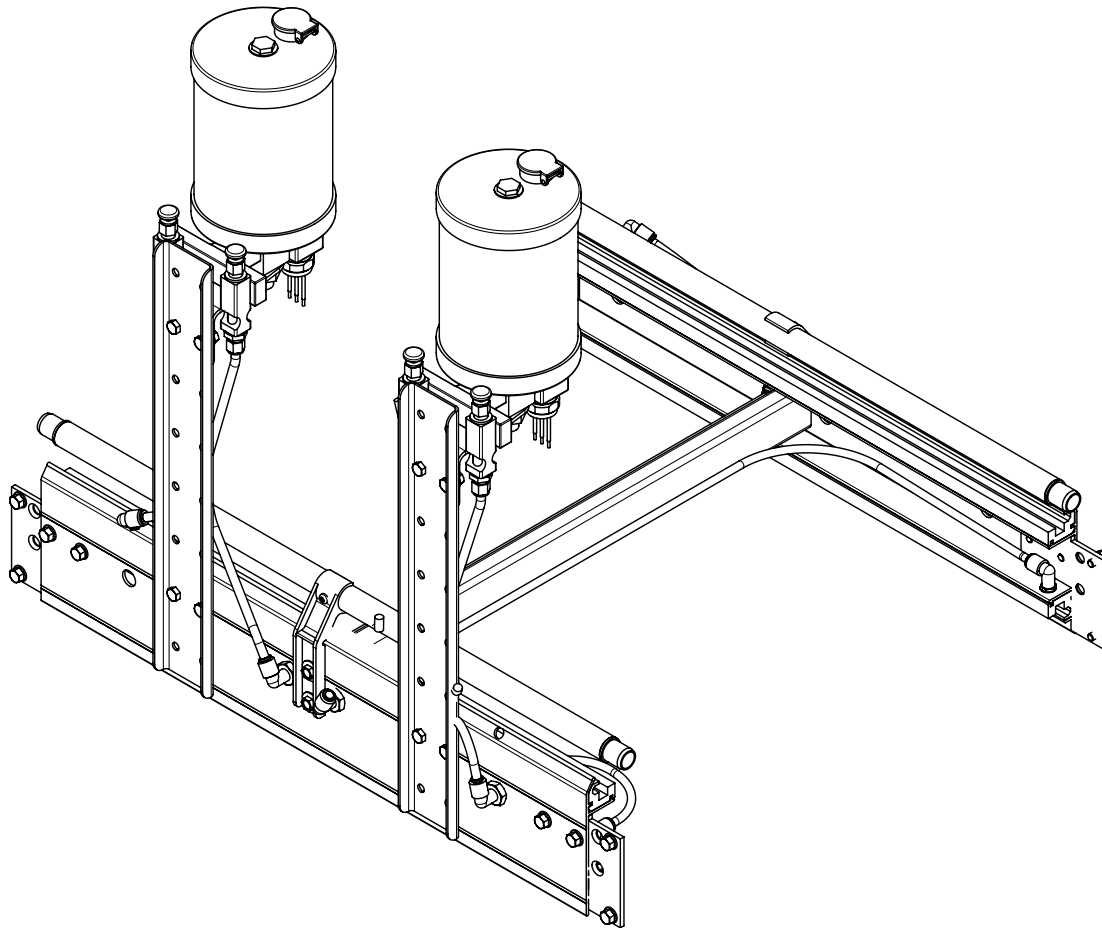
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	001 320 06 00*		Bend Unit Capping	0.6
2	185 520 18 00		Intermediate Coupling	2
3	185 525 08 00		Thread Plate LH	1
4	185 525 08 01		Thread Plate RH	1
5	185 550 06 02*		Sliding Profile Bend Unit	1.2
6	185 550 09 01		Pipe Holder	1
7	707 027 03 00		Sidesheet Drip Oiler US	1
8	707 027 04 00		Drip Oiler Sliding Profile USA	1
9		21 80 020	M4.2 x 22 Self-Tapping Screw, Zinc	1
10		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4

\*Qty. reflects total length (meters) to complete (1) Drip Oiler Sidesheet

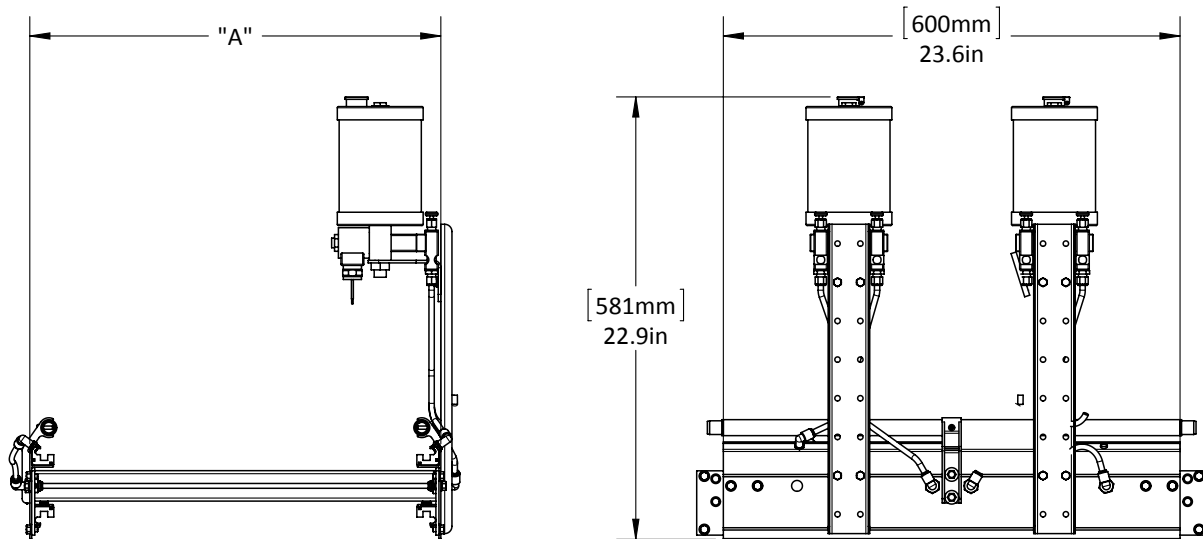


Drip Oiler Sidesheet Complete US			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	707 127 01 00	Drip Oiler Sidesheet Complete US

## Tandem Oiler T250 - T750



Tandem Drip Oiler (120v and 240v)			
Conveyor Type	Part Number	Drawing Number	Description
250	C102A	--	Tandem Drip Oiler T250 120v
	C103A	--	Tandem Drip Oiler T250 240v
350	D102A	--	Tandem Drip Oiler T350 120v
	D103A	--	Tandem Drip Oiler T350 240v
500	E102A	--	Tandem Drip Oiler T500 120v
	E103A	--	Tandem Drip Oiler T500 240v
750	F102A	--	Tandem Drip Oiler T750 120v
	F103A	--	Tandem Drip Oiler T750 240v



Tandem Oiler			
Part Number	Conveyor Type	Description	A* (mm/inches)
C102A / C103A	250	Tandem Oiler T250 (120v or 240v)	290/11.4
D102A / D103A	350	Tandem Oiler T350 (120v or 240v)	390/15.4
E102A / E103A	500	Tandem Oiler T500 (120v or 240v)	540/21.3
F102A / F103A	750	Tandem Oiler T750 (120v or 240v)	790/31.1

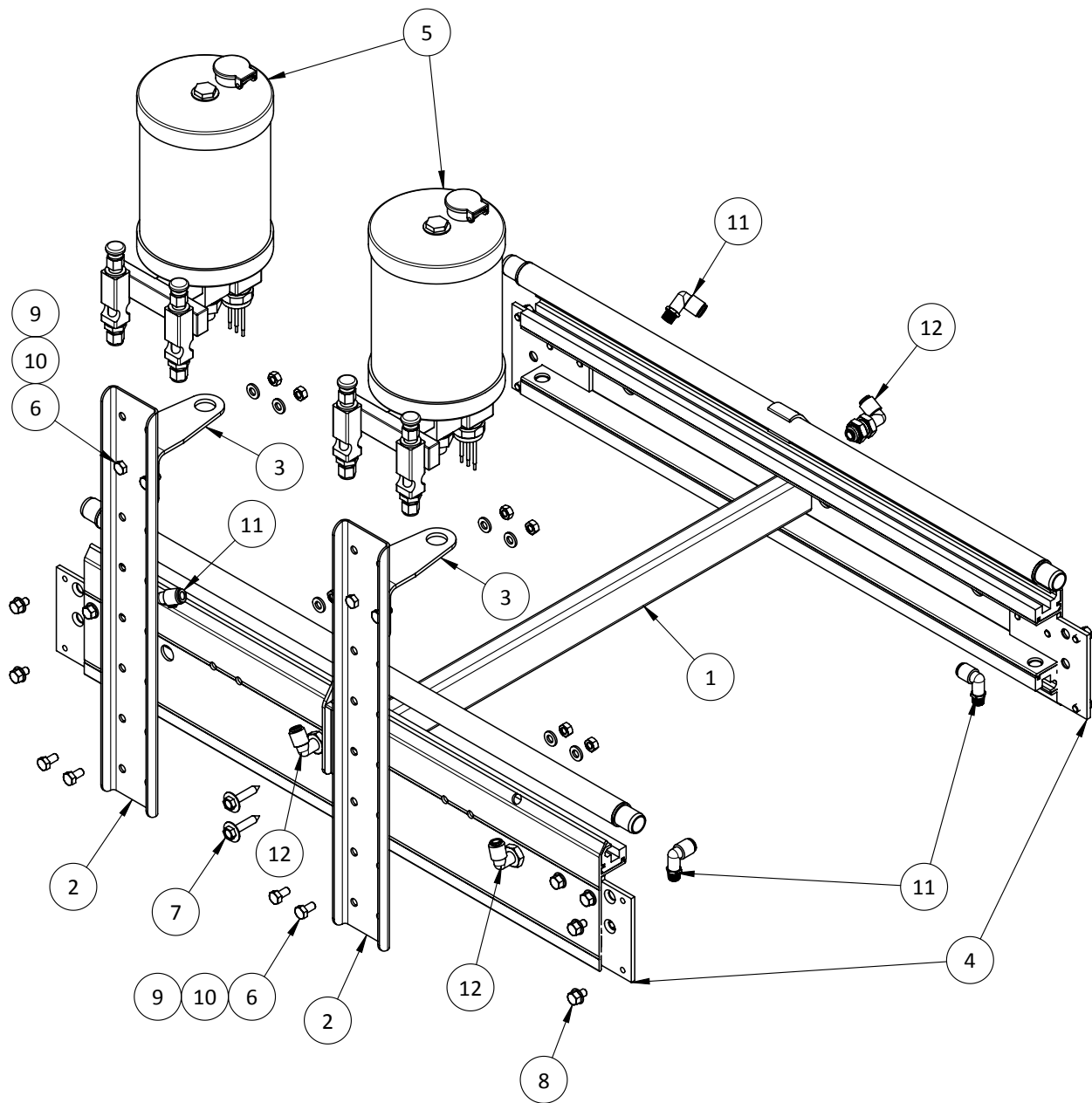
\*Dimensions not effected by Drip Oiler voltage

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250 120v	T250 240v	T350 120v	T350 240v	T500 120v	T500 240v	T750 120v	T750 240v
1	186 524 05 00		Traverse T250	1	1	-	-	-	-	-	-
1	187 524 05 00		Traverse T350	-	-	1	1	-	-	-	-
1	185 524 05 00		Traverse T500	-	-	-	-	1	1	-	-
1	188 524 05 00		Traverse T750	-	-	-	-	-	-	1	1
2	707 027 01 00		Drip Oiler Vertical Support	2	2	2	2	2	2	2	2
3	707 027 02 00		Drip Oiler Angle Support	2	2	2	2	2	2	2	2
4	707 127 01 00		Drip Oiler Sidesheet Complete US	2	2	2	2	2	2	2	2
5		1U725-120	Electric Drip Oiler, 120 volt	2	-	2	-	2	-	2	-
5		1U725-240	Electric Drip Oiler, 240 volt	-	2	-	2	-	2	-	2
6		21 56 067	M6 x 12 Hex Bolt, Zinc	8	8	8	8	8	8	8	8
7		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	4	4	4	4	4	4	4	4
8		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8	8	8	8	8	8
9		25 15 105	M6 Hex Nut, Zinc	8	8	8	8	8	8	8	8
10		26 02 109	M6 Flat Washer, Zinc	8	8	8	8	8	8	8	8
11		KQ2L07-34	Male Elbow Fitting 1/4"	4	4	4	4	4	4	4	4
12		KQ2LE07-00	Male Elbow Bulkhead Fitting 1/4"	4	4	4	4	4	4	4	4
13		TIA07R-305*	Tubing 1/4" (Red)	15	15	-	-	-	-	-	-
13		TIA07R-305*	Tubing 1/4" (Red)	-	-	15	15	-	-	-	-
13		TIA07R-305*	Tubing 1/4" (Red)	-	-	-	-	15	15	-	-
13		TIA07R-305*	Tubing 1/4" (Red)	-	-	-	-	-	-	15	15

\*Qty. reflects length (feet) required to complete (1) unit



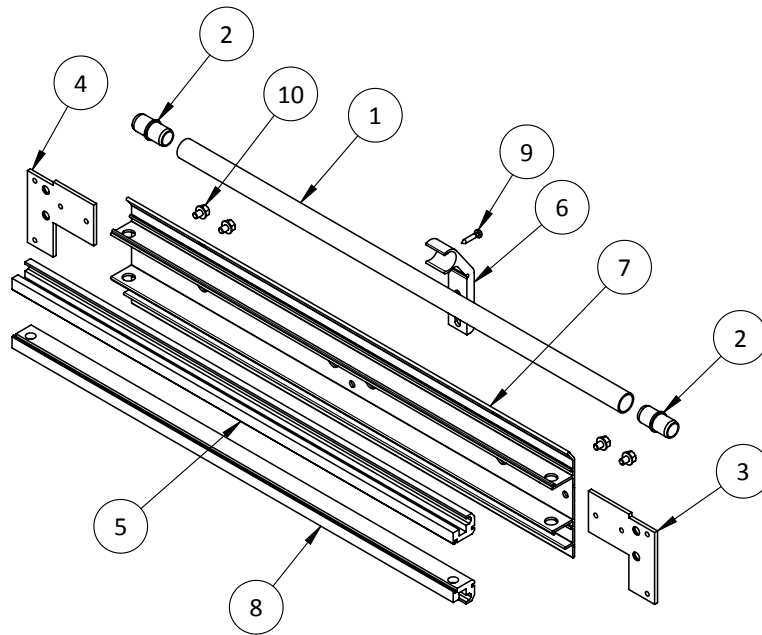


Item #13 not shown for clarity

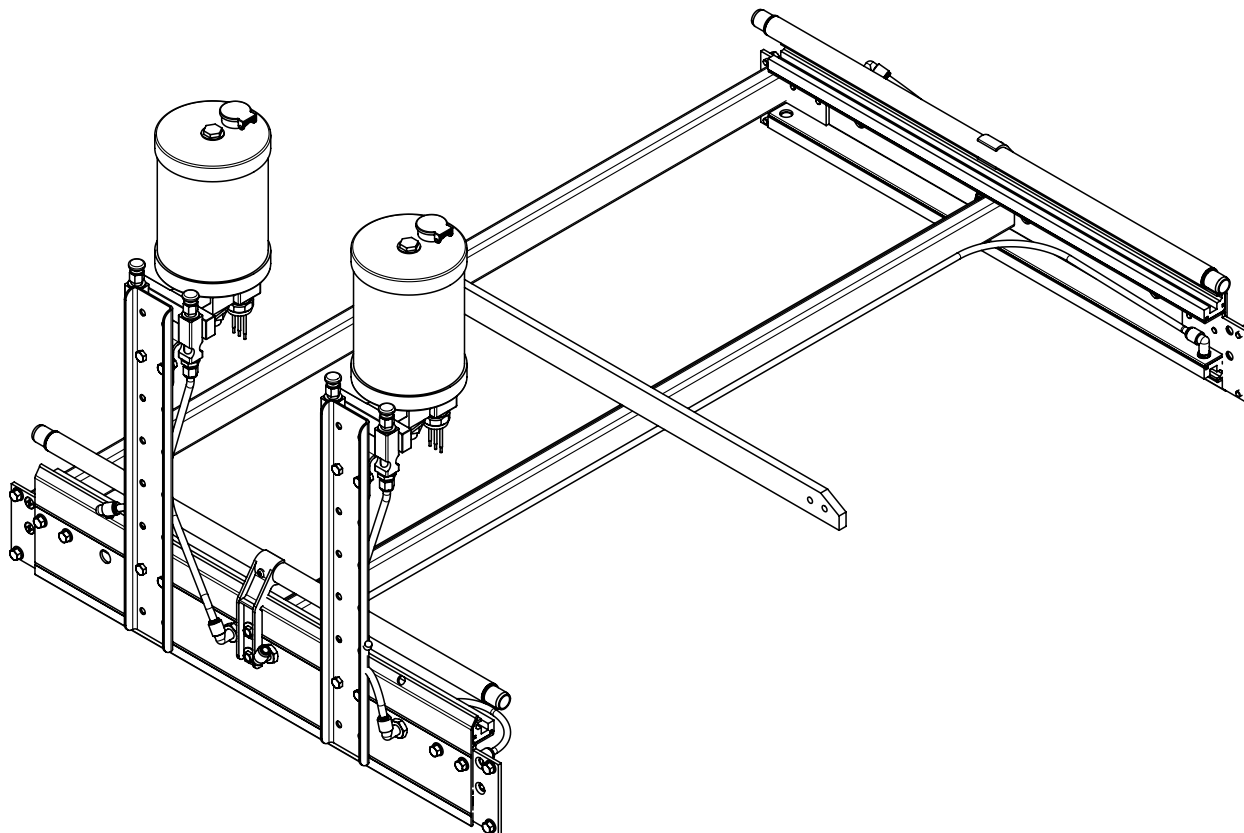
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	001 320 06 00*		Bend Unit Capping	0.6
2	185 520 18 00		Intermediate Coupling	2
3	185 525 08 00		Thread Plate LH	1
4	185 525 08 01		Thread Plate RH	1
5	185 550 06 02*		Sliding Profile Bend Unit	1.2
6	185 550 09 01		Pipe Holder	1
7	707 027 03 00		Sidesheet Drip Oiler US	1
8	707 027 04 00		Drip Oiler Sliding Profile USA	1
9		21 80 020	M4.2 x 22 Self-Tapping Screw, Zinc	1
10		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4

\*Qty. reflects total length (meters) to complete (1) Drip Oiler Sidesheet

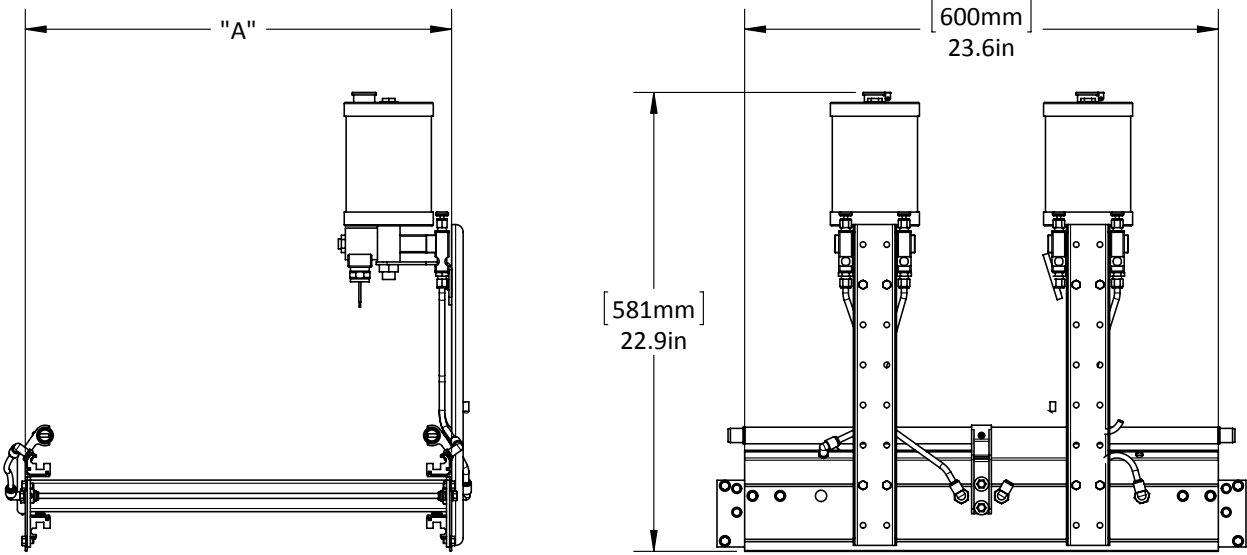


Drip Oiler Sidesheet Complete US			
Conveyor Type	Part Number	Drawing Number	Description
250	--	707 127 01 00	Drip Oiler Sidesheet Complete US
350			
500			
750			

**Tandem Oiler T1000**

<b>Tandem Drip Oiler (120v and 240v)</b>			
<b>Conveyor Type</b>	<b>Part Number</b>	<b>Drawing Number</b>	<b>Description</b>
1000	G102A	--	Tandem Drip Oiler T1000 120v
	G103A	--	Tandem Drip Oiler T1000 240v

# Section 2



Top Oiler			
Part Number	Conveyor Type	Description	A* (mm/inches)
G102A / G103A	1000	Tandem Oiler T1000 (120v or 240v)	1040/41.0

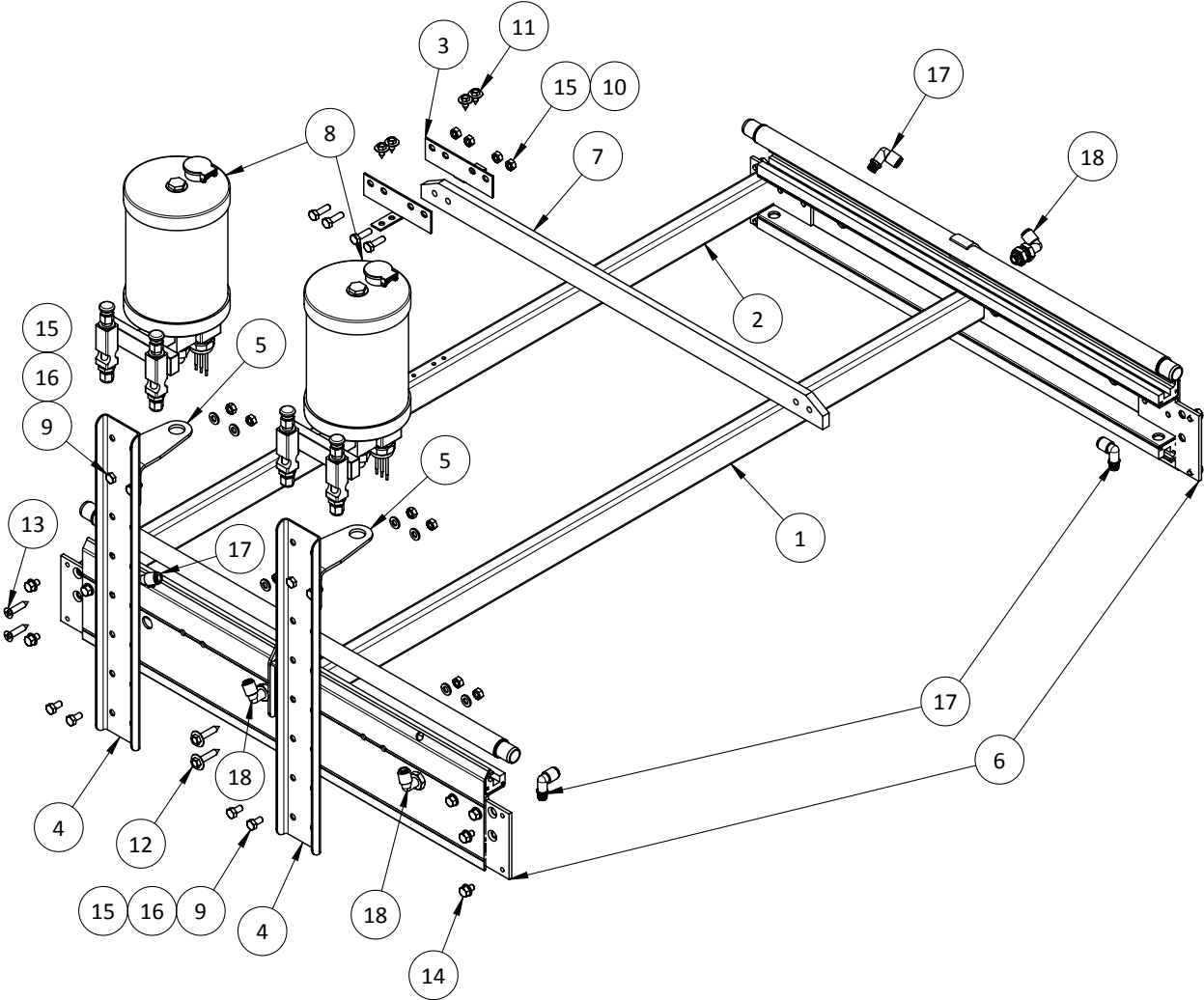
\*Dimensions not effected by Drip Oiler voltage

## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000 120v	T1000 240v
1	191 524 05 00		Traverse T1000 (No Holes)	1	1
2	191 524 05 08		Traverse Narrow T1000 (Thin Side Holes)	1	1
3	191 524 07 00		Connecting Angle	2	2
4	707 027 01 00		Drip Oiler Vertical Support	2	2
5	707 027 02 00		Drip Oiler Angle Support	2	2
6	707 127 01 00		Drip Oiler Sidesheet Complete US	2	2
7	709 127 01 00		Center Support, Drip Oiler	1	1
8		1U725-120	Electric Drip Oiler, 120 volt	2	-
8		1U725-240	Electric Drip Oiler, 240 volt	-	2
9		21 56 067	M6 x 12 Hex Bolt, Zinc	8	8
10		21 56 069	M6 x 20 Hex Bolt, Zinc	4	4
11		21 69 024	M5.5 x 13 Self-Tapping Screw, Zinc	4	4
12		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	4	4
13		21 81 038	M6.3 x 32 Countersunk Self-Tapping Screw, Zinc	4	4
14		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8
15		25 15 105	M6 Hex Nut, Zinc	12	12
16		26 02 109	M6 Flat Washer, Zinc	8	8
17		KQ2L07-34	Male Elbow Fitting 1/4"	4	4
18		KQ2LE07-00	Male Elbow Bulkhead Fitting 1/4"	4	4
19		TIA07R-305*	Tubing 1/4" (Red)	20	20

\*Qty. reflects length (feet) required to complete (1) unit

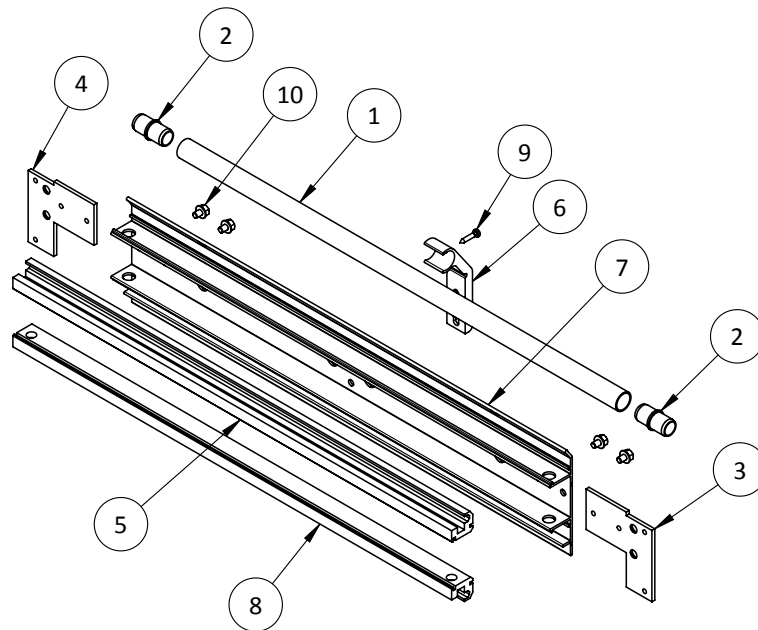
# Section 2



Item #19 not shown for clarity

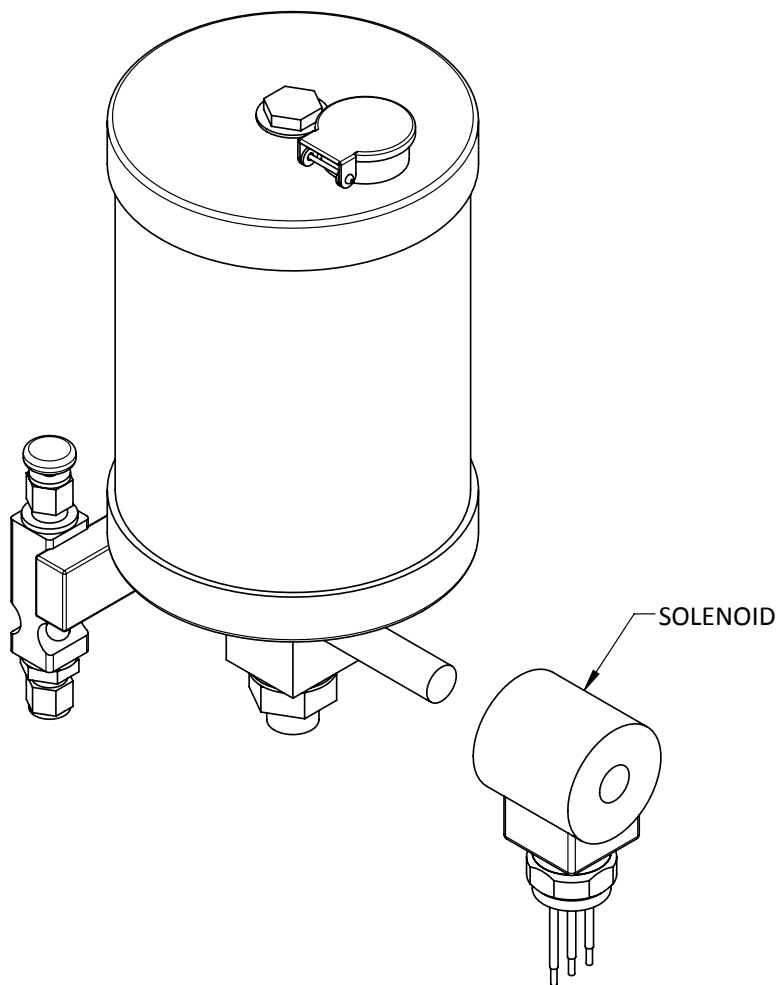
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	001 320 06 00*		Bend Unit Capping	0.6
2	185 520 18 00		Intermediate Coupling	2
3	185 525 08 00		Thread Plate LH	1
4	185 525 08 01		Thread Plate RH	1
5	185 550 06 02*		Sliding Profile Bend Unit	1.2
6	185 550 09 01		Pipe Holder	1
7	707 027 03 00		Sidesheet Drip Oiler US	1
8	707 027 04 00		Drip Oiler Sliding Profile USA	1
9		21 80 020	M4.2 x 22 Self-Tapping Screw, Zinc	1
10		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	4

\*Qty. reflects total length (meters) to complete (1) Drip Oiler Sidesheet



Drip Oiler Sidesheet Complete US			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	707 127 01 00	Drip Oiler Sidesheet Complete US

**Drip Oiler Replacement Solenoid T250 - T1000**



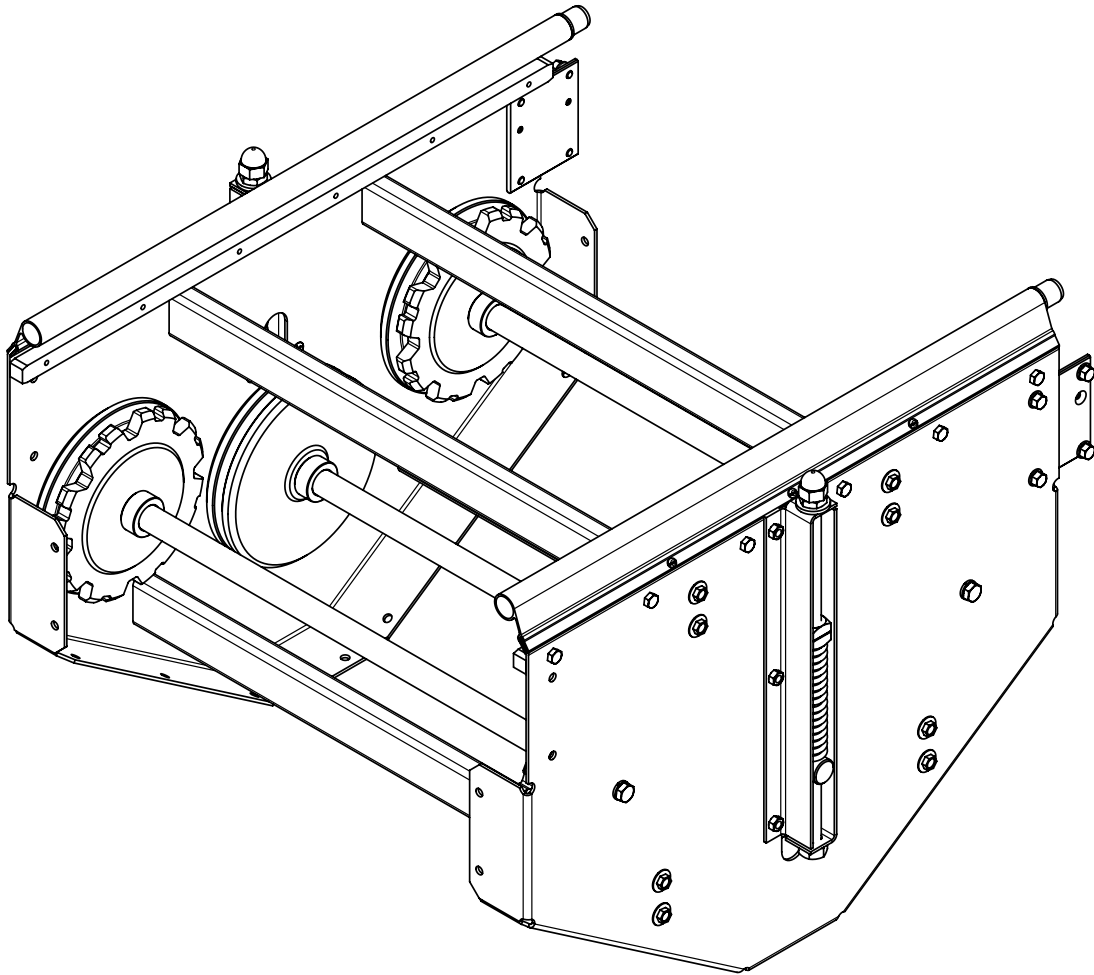
See chart below when ordering replacement Solenoids  
 See respective Oiler Units (Drip, Top, and Tandem) for  
 ordering entire Drip Oiler Reservoir with Solenoid

Drip Oiler Solenoid			
Conveyor Type	Part Number	Voltage	Description
250 - 1000	835380	120	Solenoid 120v
250 - 1000	835381	240	Solenoid 240v

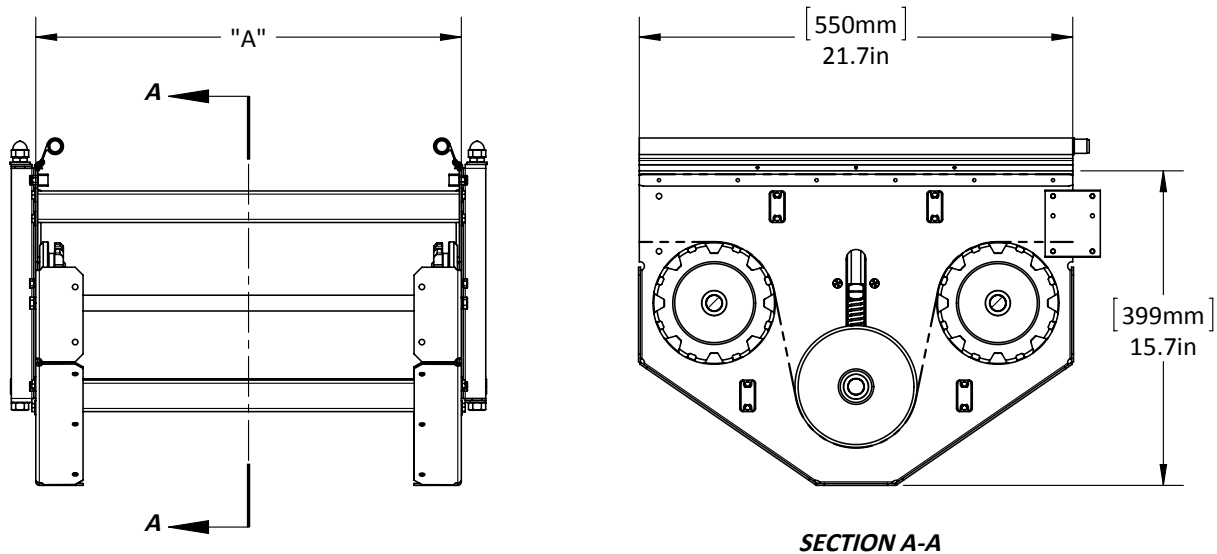


## Section 2

### Bolt-In Tensioner T250 - T1000



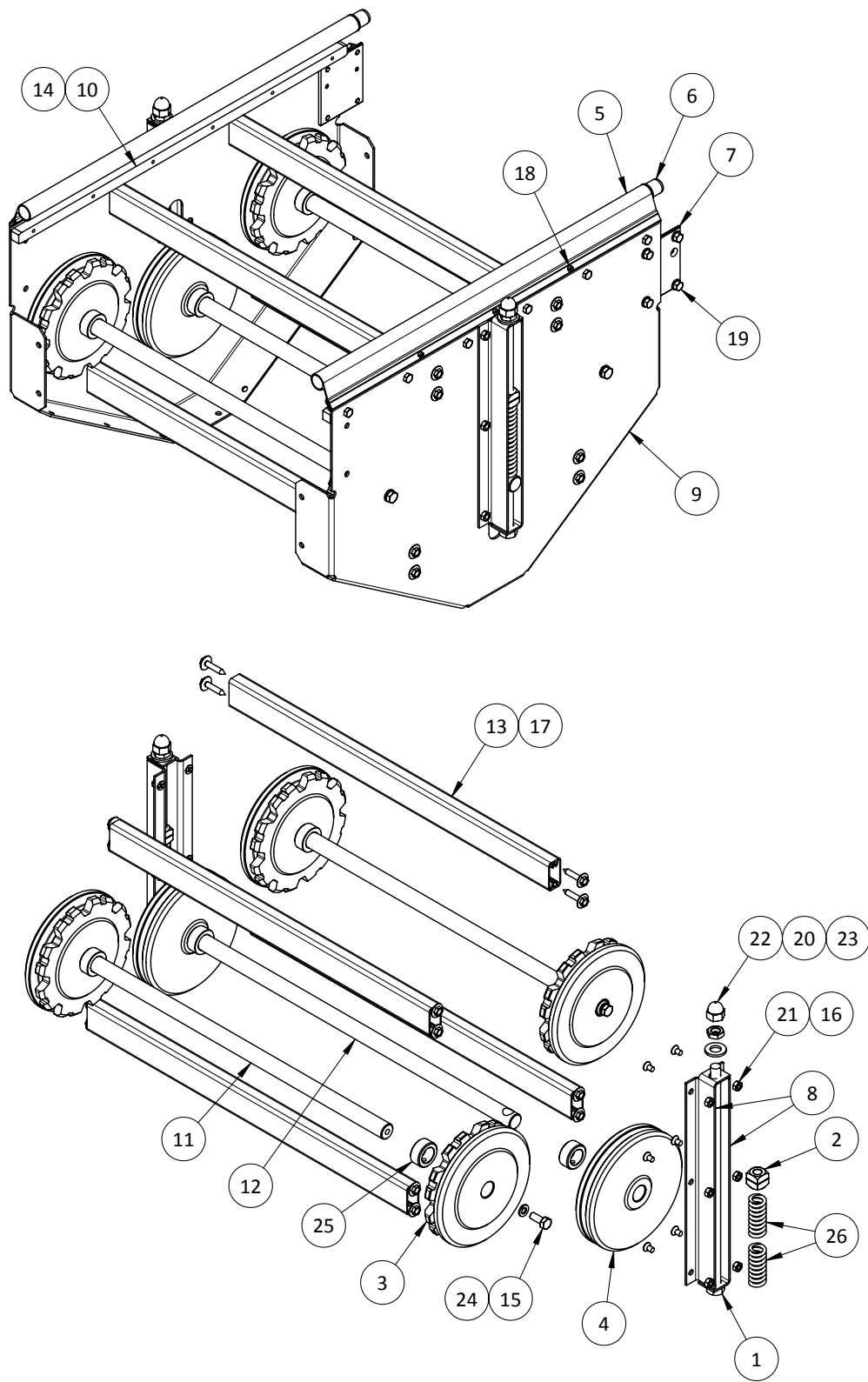
Bolt-In Tensioner			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 005 50 01	Bolt-In Tensioner T250
350	--	187 005 50 01	Bolt-In Tensioner T350
500	--	185 005 50 01	Bolt-In Tensioner T500
750	--	188 005 50 01	Bolt-In Tensioner T750
1000	--	191 005 50 01	Bolt-In Tensioner T1000



<b>Bolt-In Tensioner</b>				
<b>Drawing Number</b>	<b>Conveyor Type</b>	<b>Description</b>	<b>A (mm/inches)</b>	<b>Chain Length (m/ft)</b>
186 005 50 01	250	Bolt-In Tensioner T250	290/11.4	1.4/4.7
187 005 50 01	350	Bolt-In Tensioner T350	390/15.4	
185 005 50 01	500	Bolt-In Tensioner T500	540/21.3	
188 005 50 01	750	Bolt-In Tensioner T750	790/31.1	
191 005 50 01	1000	Bolt-In Tensioner T1000	1040/41.0	

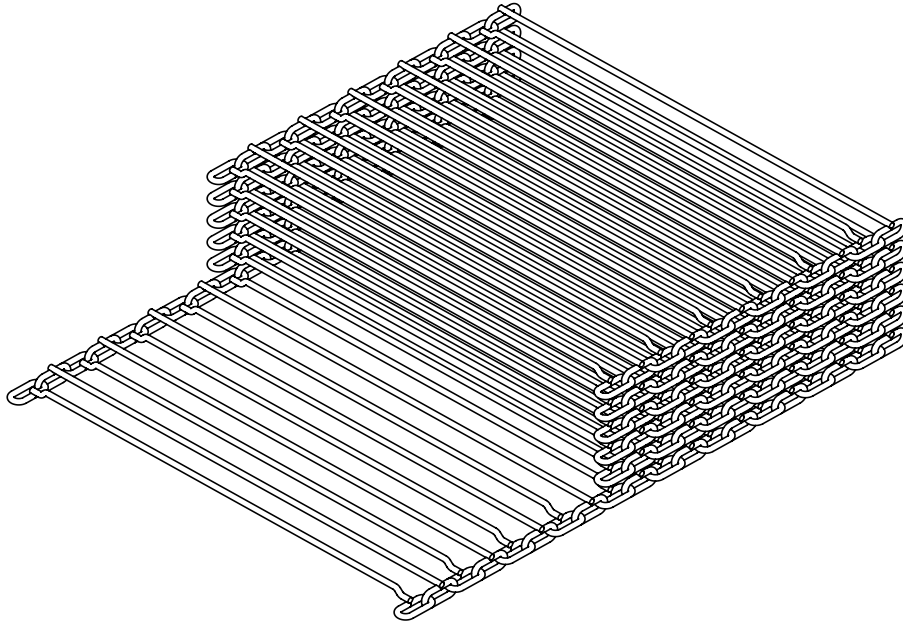
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750	T1000
1	185 500 77 01		Screw Spindle Bolt-In Tensioner	2	2	2	2	2
2	185 515 07 00		Pressure Piece	2	2	2	2	2
3	185 515 21 01		Deflection Wheel Grooved 155mm	4	4	4	4	4
4	185 515 22 01		Deflection Wheel Smooth 155mm	2	2	2	2	2
5	185 520 09 22		Bolt-In Tensioner Capping	2	2	2	2	2
6	185 520 18 00		Intermediate Coupling	2	2	2	2	2
7	185 525 06 00		Thread Plate	2	2	2	2	2
8	185 530 11 02		Tensioner Take-Up Frame	4	4	4	4	4
9	185 536 09 02		Bolt-In Tensioner Sidesheet	2	2	2	2	2
10	185 536 10 00		Guide Rail Bolt-In Tensioner	2	2	2	2	2
11	186 515 04 02		20mm Axle T250	2	-	-	-	-
11	187 515 04 02		20mm Axle T350	-	2	-	-	-
11	185 515 04 02		20mm Axle T500	-	-	2	-	-
11	188 515 04 02		20mm Axle T750	-	-	-	2	-
11	191 515 04 02		20mm Axle T1000	-	-	-	-	2
12	186 515 11 02		Tension Axle T250	1	-	-	-	-
12	187 515 11 02		Tension Axle T350	-	1	-	-	-
12	185 515 11 02		Tension Axle T500	-	-	1	-	-
12	188 515 11 02		Tension Axle T750	-	-	-	1	-
12	191 515 11 02		Tension Axle T1000	-	-	-	-	1
13	186 524 05 00		Traverse T250	4	-	-	-	-
13	187 524 05 00		Traverse T350	-	4	-	-	-
13	185 524 05 00		Traverse T500	-	-	4	-	-
13	188 524 05 00		Traverse T750	-	-	-	4	-
13	191 524 05 00		Traverse T1000 (No Holes)	-	-	-	-	4
14		21 56 067	M6 x 12 Hex Bolt, Zinc	12	12	12	12	12
15		21 56 087	M8 x 20 Hex Bolt, Zinc	4	4	4	4	4
16		21 63 066	M6 x 10 Countersunk Screw, Zinc	12	12	12	12	12
17		21 69 041	M6.3 x 32 Self Tapping Screw, Zinc	16	16	16	16	16
18		21 76 901	M3.5 x 6.5 Self-Tapping Screw, Zinc	6	6	6	6	6
19		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8	8	8	8	8
20		25 03 108	M12 Jam Nut, Zinc	2	2	2	2	2
21		25 15 105	M6 Hex Nut, Zinc	12	12	12	12	12
22		25 24 108	M12 Cap Nut, Zinc	2	2	2	2	2
23		26 02 113	M12 Flat Washer, Zinc	2	2	2	2	2
24		26 04 111	M8 Lock Washer, Zinc	4	4	4	4	4
25		26 43 064	Adjusting Ring A20-705	6	6	6	6	6
26		32 02 639	Pressure Spring	4	4	4	4	4



## Section 2

### Conveyor Chain T250 - T1000

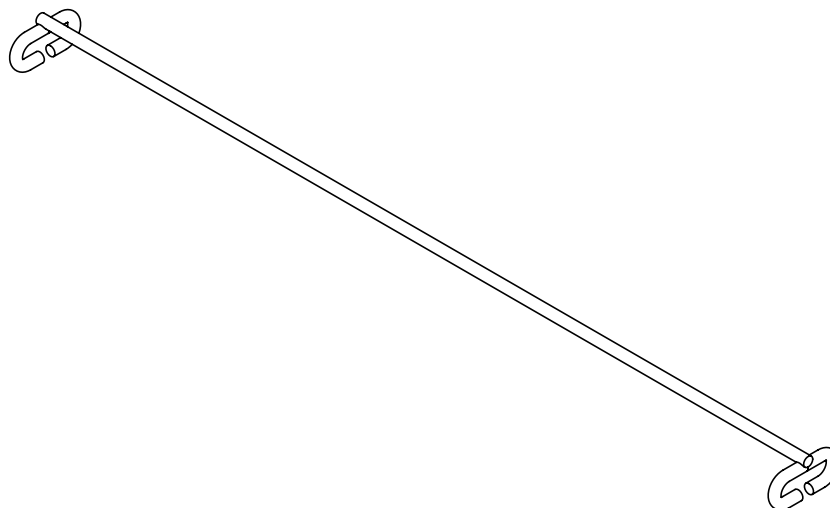


Conveyor Chain Standard				
Conveyor Type	Part Number	Drawing Number	Description	Roll Length
250	4921	--	Conveyor Chain T250 Standard	10m (32.8-ft)
350	4861	--	Conveyor Chain T350 Standard	
500	4821	--	Conveyor Chain T500 Standard	
750	4891	--	Conveyor Chain T750 Standard	
1000	5421	--	Conveyor Chain T1000 Standard	5m (16.4-ft)

Conveyor Chain Plastic Coated				
Conveyor Type	Part Number	Drawing Number	Description	Roll Length
250	--	--	--	10m (32.8-ft)
350	--	--	--	
500	4832	--	Conveyor Chain T500 Plastic Coated	
750	4892	--	Conveyor Chain T750 Plastic Coated	
1000	--	--	--	--

Conveyor Chain Hybrid				
Conveyor Type	Part Number	Drawing Number	Description	Roll Length
250	5921	--	Conveyor Chain T250 Hybrid	10m (32.8-ft)
350	--	--	--	
500	5821	--	Conveyor Chain T500 Hybrid	
750	5892	--	Conveyor Chain T750 Hybrid	
1000	5461	--	Conveyor Chain T1000 Hybrid	5m (16.4-ft)

## Closing Rod T250 - T1000



REQUIRES SECURITY ELEMENTS TO JOIN CHAIN SECTIONS (SOLD SEPARATELY)

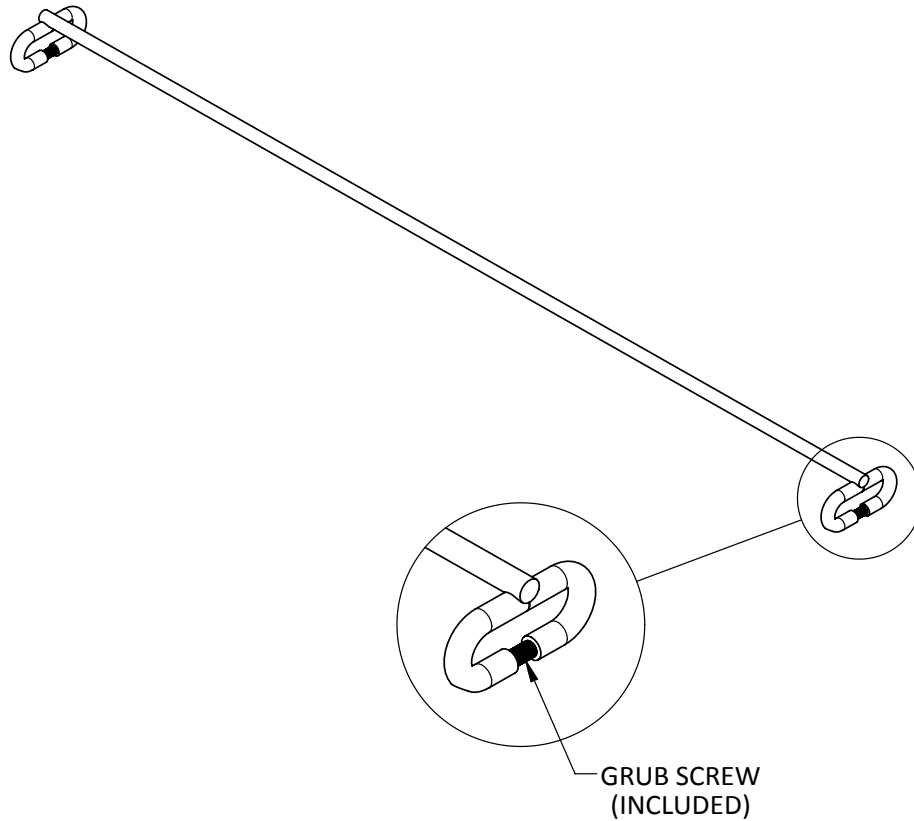
Closing Rod Standard			
Conveyor Type	Part Number	Drawing Number	Description
250	4924	--	Closing Rod T250 Standard
350	4864	--	Closing Rod T350 Standard
500	4824	--	Closing Rod T500 Standard
750	4894	--	Closing Rod T750 Standard
1000	5423	--	Closing Rod T1000 Standard

Closing Rod Plastic Coated			
Conveyor Type	Part Number	Drawing Number	Description
250	--	--	--
350	--	--	--
500	4833	--	Closing Rod T500 Plastic Coated
750	4893	--	Closing Rod T750 Plastic Coated
1000	--	--	--

Closing Rod Hybrid			
Conveyor Type	Part Number	Drawing Number	Description
250	5924	--	Closing Rod T250 Hybrid
350	--	--	--
500	5824	--	Closing Rod T500 Hybrid
750	5894	--	Closing Rod T750 Hybrid
1000	5464	--	Closing Rod T1000 Hybrid

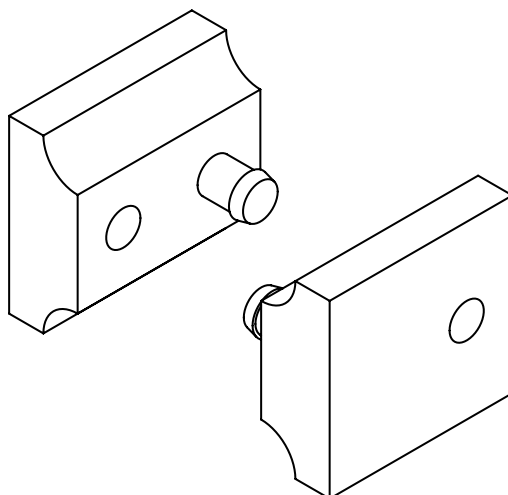
## Section 2

### Closing Rod Grub Screw T500 - T1000



Closing Rod Grub Screw			
Conveyor Type	Part Number	Drawing Number	Description
250	--	--	--
350	--	--	--
500	4824-1	--	Closing Rod T500 Grub Screw
750	4894-1	--	Closing Rod T750 Grub Screw
1000	5423-1	--	Closing Rod T1000 Grub Screw

**Security Elements T250 - T1000**

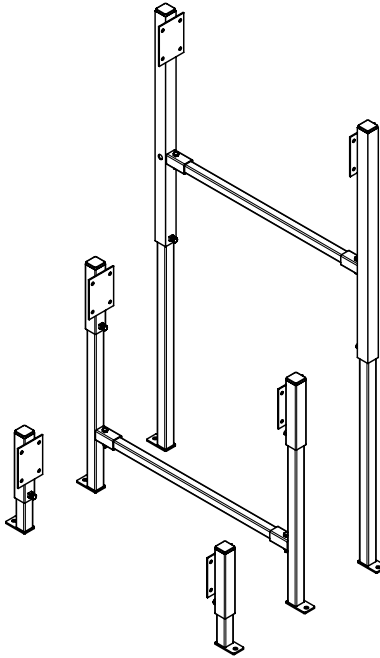


Security Elements				
Conveyor Type	Part Number	Drawing Number	Description	UOM
250	--	185 540 04 02	Security Elements	Pair
350				
500				
750				
1000				



## Section 2

### Floor Supports T250 - T1000

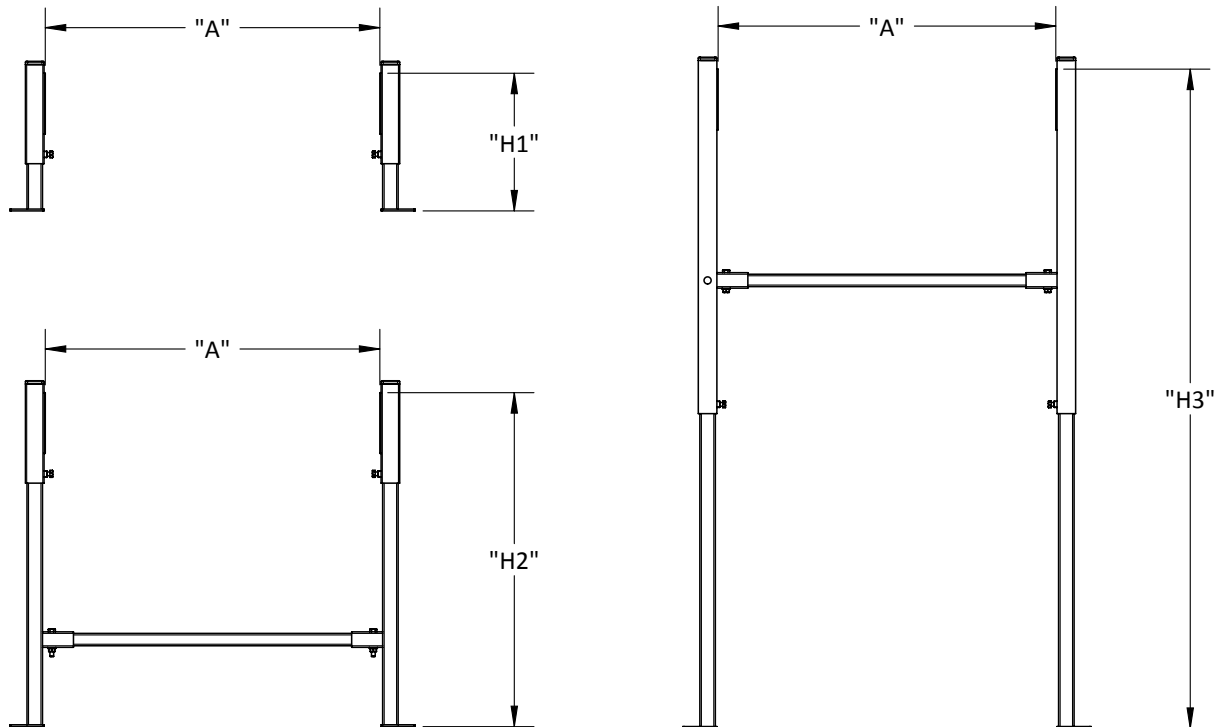


Floor Support Short			
Conveyor Type	Part Number	Drawing Number	Description
250	4815	--	Floor Support Short
350			
500			
750			
1000			

Floor Support Middle			
Conveyor Type	Part Number	Drawing Number	Description
250	4916	--	Floor Support Middle T250
350	4855	--	Floor Support Middle T350
500	4816	--	Floor Support Middle T500
750	4885	--	Floor Support Middle T750
1000	5416	--	Floor Support Middle T1000

Floor Support Long			
Conveyor Type	Part Number	Drawing Number	Description
250	4917	--	Floor Support Long T250
350	4856	--	Floor Support Long T350
500	4817	--	Floor Support Long T500
750	4886	--	Floor Support Long T750
1000	5417	--	Floor Support Long T1000

## Section 2



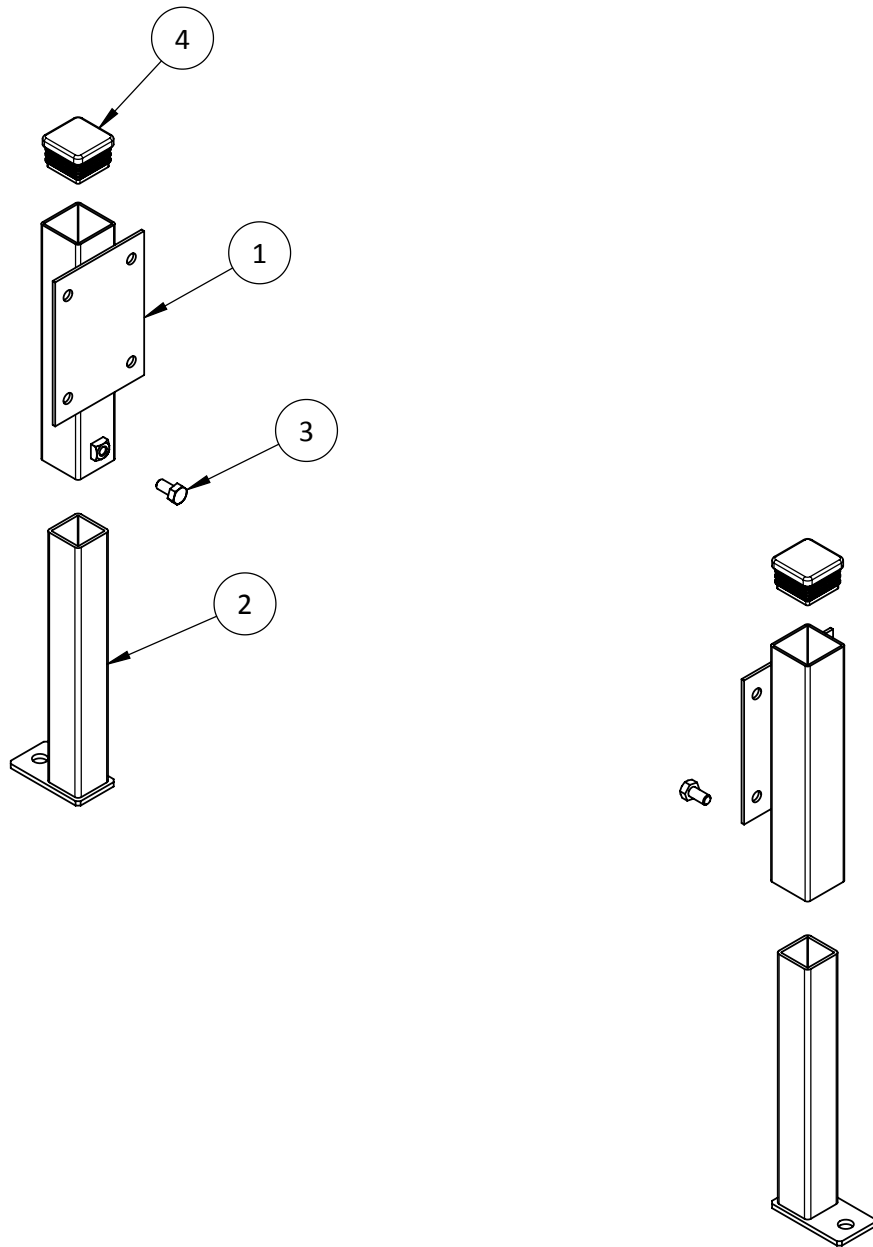
Floor Support Short				
Conveyor Type	Part Number	Description	A (mm/inches)	H1 min/max (mm/inches)
250	4815	Floor Support Short	290/11.4	190 - 320 7.5 - 12.6
350			390/15.4	
500			540/21.3	
750			790/31.1	
1000			1040/41.0	

Floor Support Middle				
Conveyor Type	Part Number	Description	A (mm/inches)	H2 min/max (mm/inches)
250	4916	Floor Support Middle T250	290/11.4	310 - 610 12.2 - 24.0
350	4855	Floor Support Middle T350	390/15.4	
500	4816	Floor Support Middle T500	540/21.3	
750	4885	Floor Support Middle T750	790/31.1	
1000	5416	Floor Support Middle T1000	1040/41.0	

Floor Support Long				
Conveyor Type	Part Number	Description	A (mm/inches)	H3 min/max (mm/inches)
250	4917	Floor Support T250 Long	290/11.4	600 - 1300 23.6 - 51.2
350	4856	Floor Support T350 Long	390/15.4	
500	4817	Floor Support T500 Long	540/21.3	
750	4886	Floor Support T750 Long	790/31.1	
1000	5417	Floor Support T1000 Long	1040/41.0	

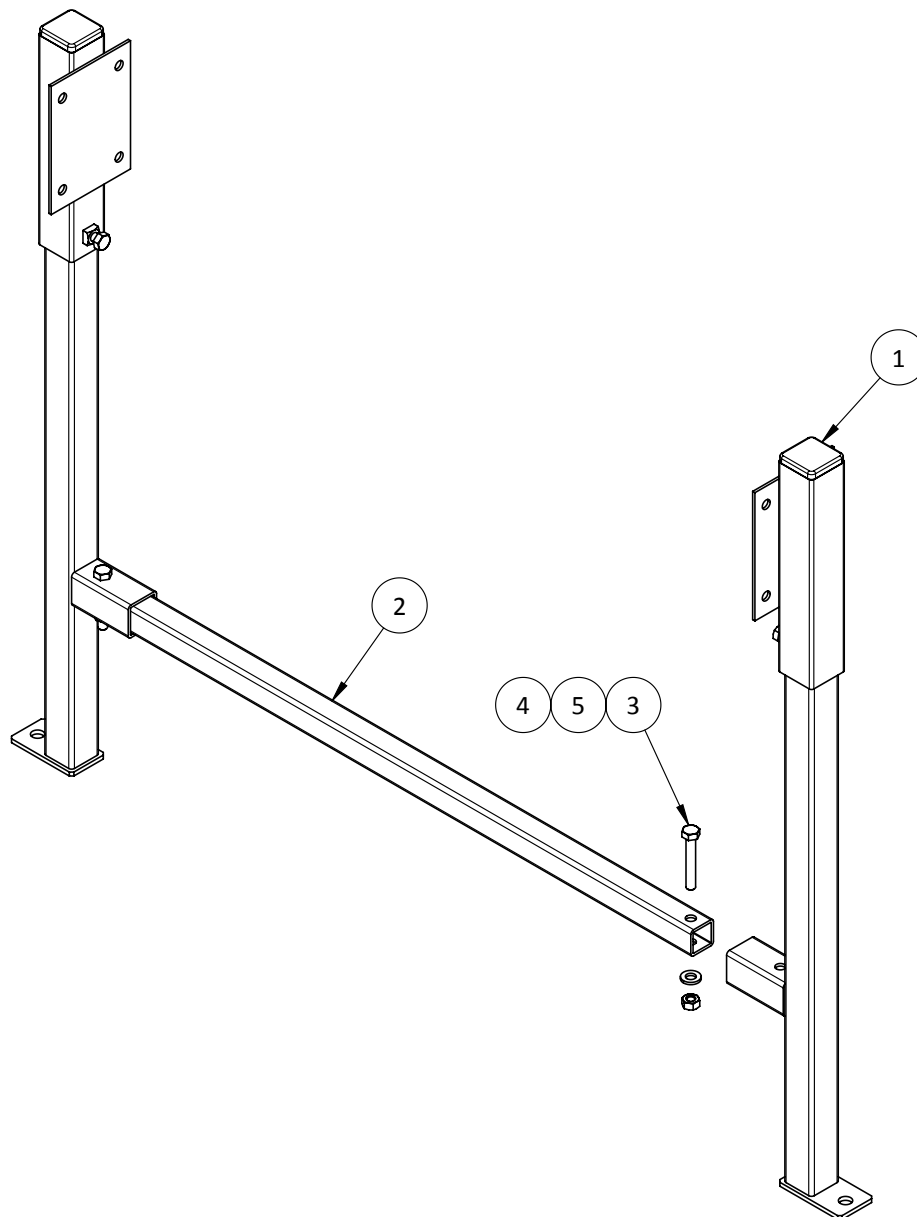
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 500 20 04		Leg Mount	2
2	185 500 20 11		Leg Weldment Short	2
3		21 56 067	M6 x 12 Hex Bolt, Zinc	2
4		70 50 005	Leg Mount Cap	2



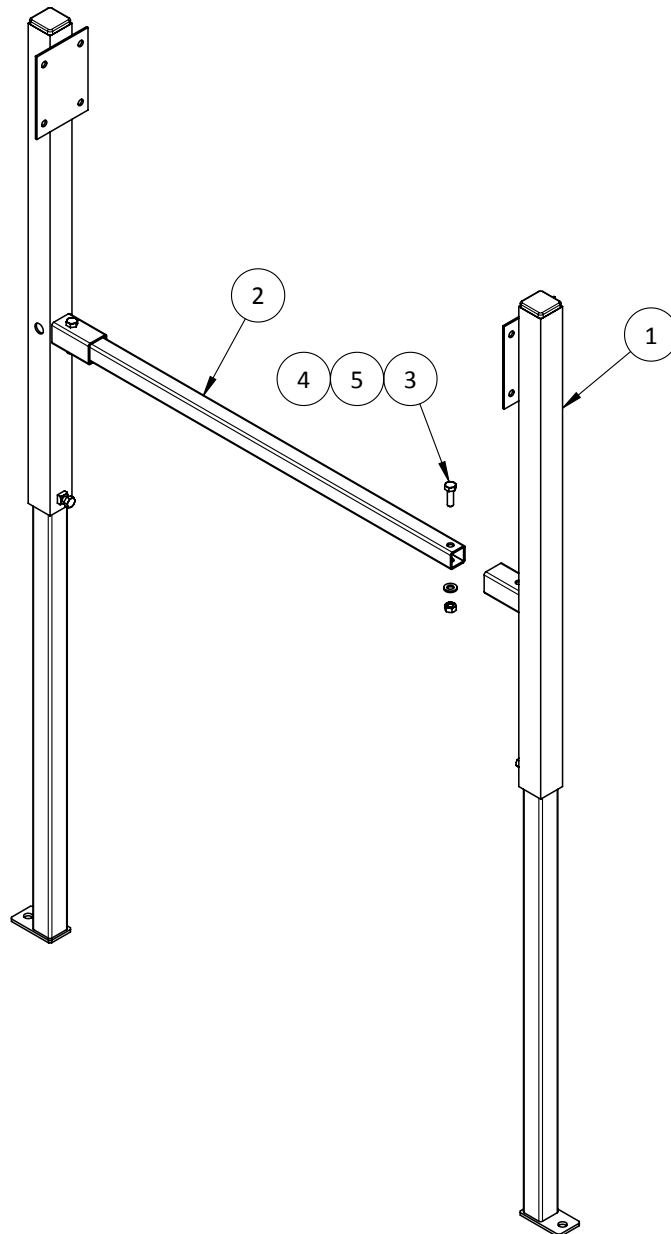
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750	T1000
1	185 500 20 24		Middle Leg Complete	2	2	2	2	2
2	186 520 02 06		Distance Tube T250	1	-	-	-	-
2	187 520 02 06		Distance Tube T350	-	1	-	-	-
2	185 520 02 06		Distance Tube T500	-	-	1	-	-
2	188 520 02 06		Distance Tube T750	-	-	-	1	-
2	191 520 02 04		Distance Tube T1000	-	-	-	-	1
3		21 56 073	M6 x 40 Hex Bolt, Zinc	2	2	2	2	2
4		25 15 105	M6 Hex Nut, Zinc	2	2	2	2	2
5		26 02 109	M6 Flat Washer, Zinc	2	2	2	2	2



## Section 2

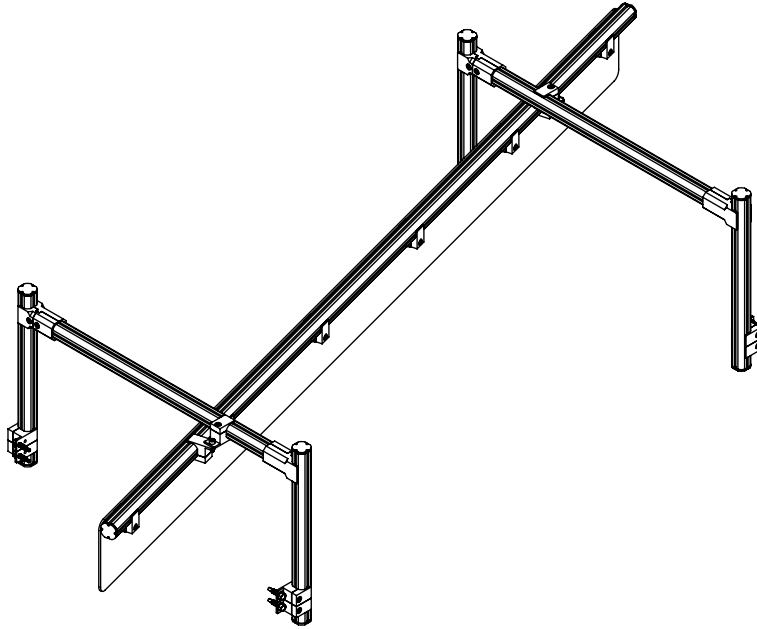
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750	T1000
1	185 500 20 23		Long Leg Complete	2	2	2	2	2
2	186 520 02 04		Distance Tube T250	1	-	-	-	-
2	187 520 02 04		Distance Tube T350	-	1	-	-	-
2	185 520 02 04		Distance Tube T500	-	-	1	-	-
2	188 520 02 04		Distance Tube T750	-	-	-	1	-
2	191 520 02 04		Distance Tube T1000	-	-	-	-	1
3		21 56 069	M6 x 20 Hex Bolt, Zinc	-	-	2	-	-
3		21 56 073	M6 x 40 Hex Bolt, Zinc	2	2	-	2	2
4		25 15 105	M6 Hex Nut, Zinc	2	2	2	2	2
5		26 02 109	M6 Flat Washer, Zinc	2	2	2	2	2



## Section 2

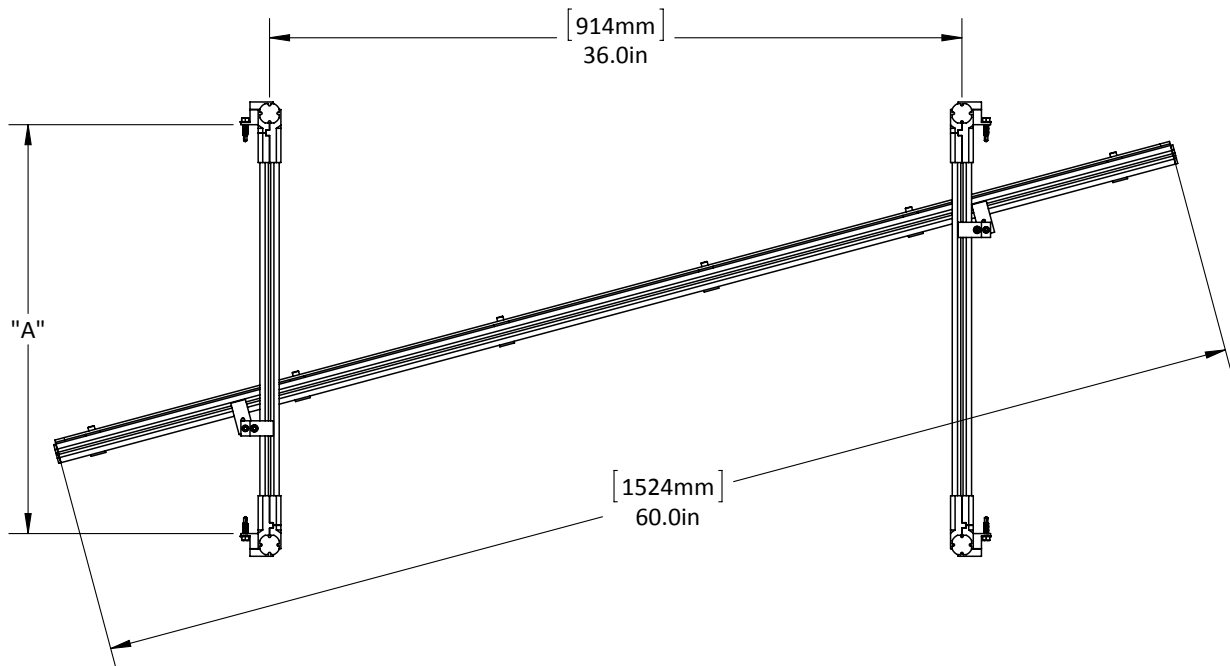
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### Extruded Diverter 60-in T350 - T1000



Extruded Diverter 60-in			
Conveyor Type	Part Number	Drawing Number	Description
350	--	706 170 01 00	Extruded Diverter Assembly with 60-in Diverter T350
500	--	707 170 01 00	Extruded Diverter Assembly with 60-in Diverter T500
750	--	708 170 02 00	Extruded Diverter Assembly with 60-in Diverter T750
1000	--	709 170 01 00	Extruded Diverter Assembly with 60-in Diverter T1000

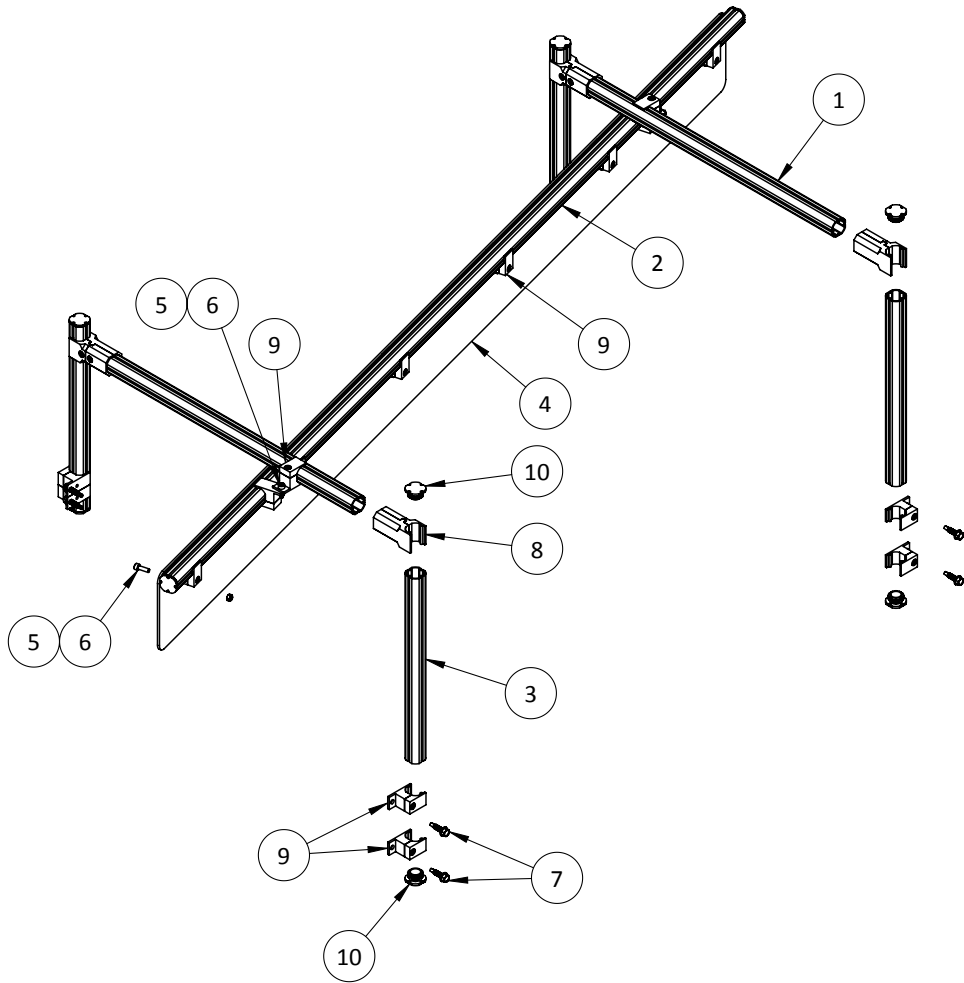
## Section 2



Extruded Diverter 60-in			
Drawing Number	Conveyor Type	Description	A (mm/inches)
706 170 01 00	350	Extruded Diverter Assembly with 60-in Diverter T350	390/15.4
707 170 01 00	500	Extruded Diverter Assembly with 60-in Diverter T500	540/21.3
708 170 02 00	750	Extruded Diverter Assembly with 60-in Diverter T750	790/31.1
709 170 01 00	1000	Extruded Diverter Assembly with 60-in Diverter T1000	1040/41.0

# Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T350	T500	T750	T1000
1	706 070 02 00		Bridge Extrusion T350	2	-	-	-
1	707 070 04 00		Bridge Extrusion T500	-	2	-	-
1	708 070 01 00		Bridge Extrusion T750	-	-	2	-
1	709 070 01 00		Bridge Extrusion T1000	-	-	-	2
2	707 070 01 00		Diverter Extrusion 60-in	1	1	1	1
3	707 070 02 00		Diverter Upright 12-in	4	4	4	4
4	707 070 03 00		Diverter Plate 60-in	1	1	1	1
5		F8-29-45-2-0	M5 Nylock Nut, Stainless	8	8	8	8
6		F8-73-45-2-157	M5 x 16 SHCS, Stainless	8	8	8	8
7		F9-66-19-0-12	1/4" x 3/4" Hex Head Self-Tapping Screw, Zinc	8	8	8	8
8		FFB1	Connector	4	4	4	4
9		FFB6	Connector	18	18	18	18
10		FFS103	End Cap	10	10	10	10

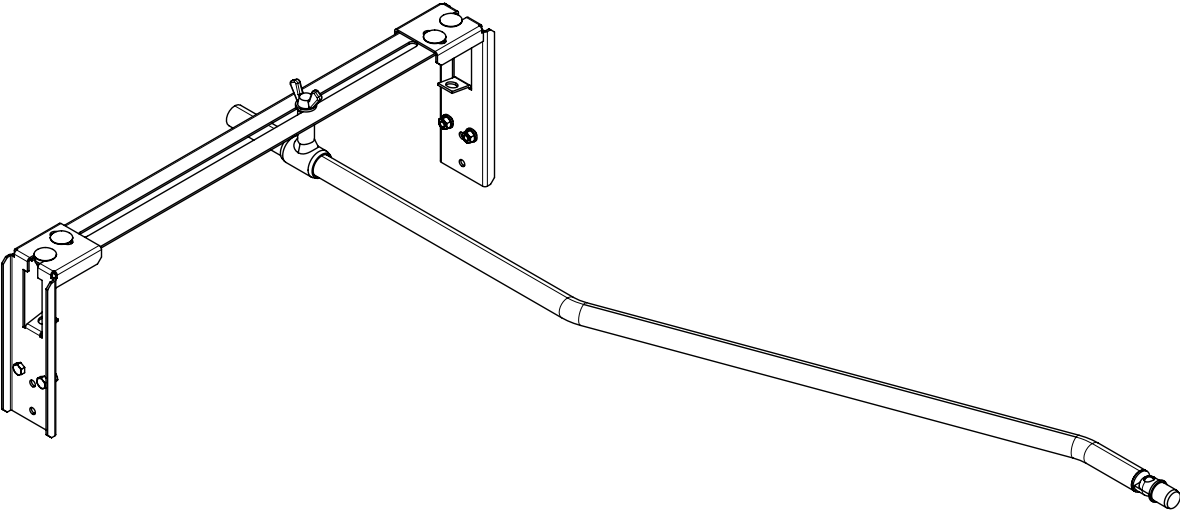




# Section 2

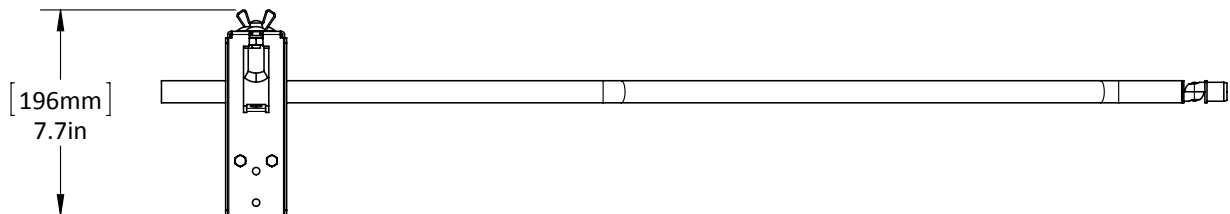
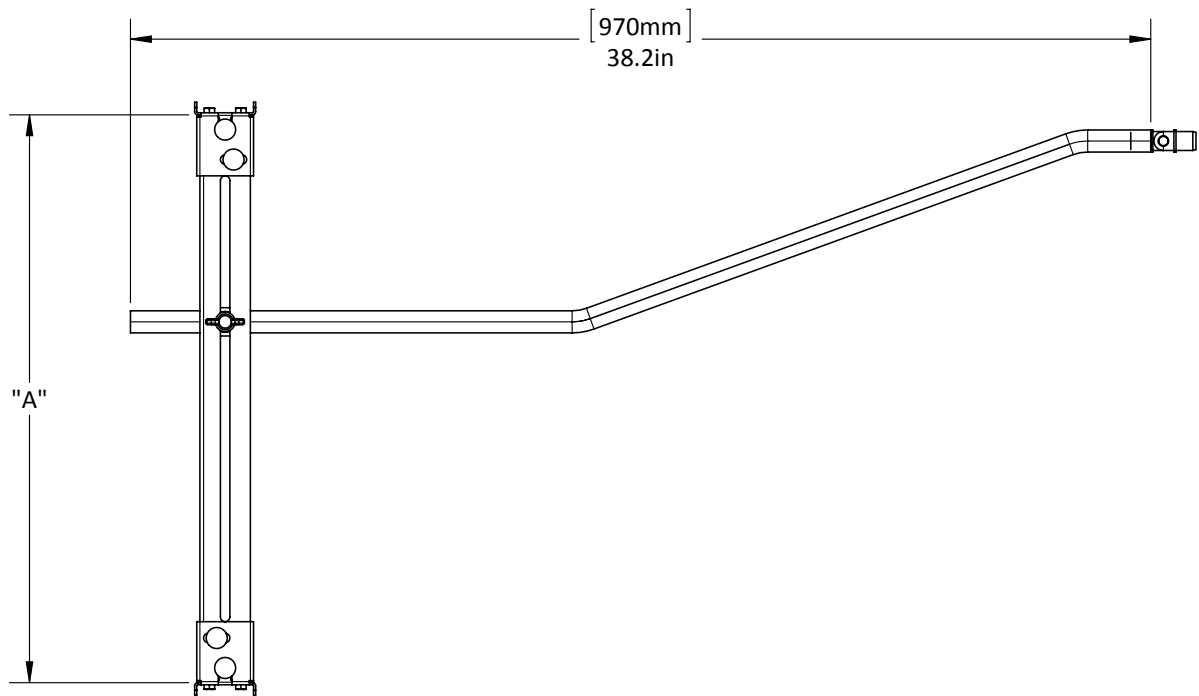
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## Guide Unit T250 - T750



Guide Unit			
Conveyor Type	Part Number	Drawing Number	Description
250	4928	--	Guide Unit T250
350	4858	--	Guide Unit T350
500	4828	--	Guide Unit T500
750	4888	--	Guide Unit T750

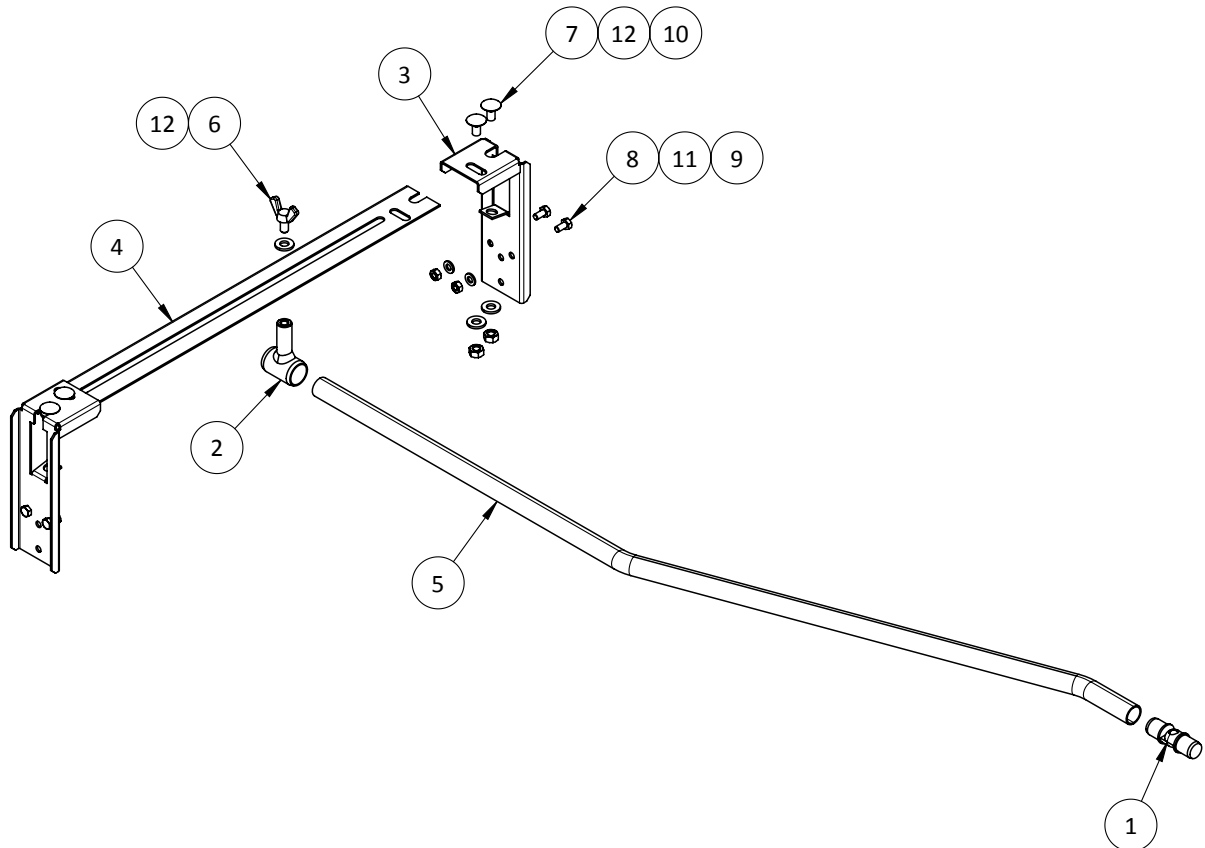
## Section 2



Guide Unit				
Part Number	Conveyor Type	Description	A (mm/inches)	B (mm/inches)
4928	250	Guide Unit T250	290/11.4	484/19.1
4858	350	Guide Unit T350	390/15.4	853/33.6
4828	500	Guide Unit T500	540/21.3	970/38.2
4888	750	Guide Unit T750	790/31.1	1158/45.6

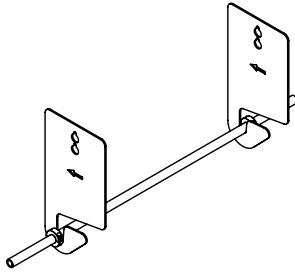
## Section 2

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	185 500 60 00		Joint Coupling Guide Unit	1	1	1	1
2	185 500 91 00		Pipe Holder	1	1	1	1
3	185 511 35 02		Bridge Bracket	2	2	2	2
4	186 511 35 03		Bridge Profile T250	1	-	-	-
4	187 511 35 03		Bridge Profile T350	-	1	-	-
4	185 511 35 03		Bridge Profile T500	-	-	1	-
4	188 511 35 03		Bridge Profile T750	-	-	-	1
5	186 511 36 00		Guide Tube T250	1	-	-	-
5	187 511 36 00		Guide Tube T350	-	1	-	-
5	185 511 36 00		Guide Tube T500	-	-	1	-
5	188 511 36 00		Guide Tube T750	-	-	-	1
6		21 09 086	M8 x 16 Wing Screw, Zinc	1	1	1	1
7		21 28 086	M8 x 16 Carriage Bolt, Zinc	4	4	4	4
8		21 56 067	M6 x 12 Hex Bolt, Zinc	4	4	4	4
9		25 15 105	M6 Hex Nut, Zinc	4	4	4	4
10		25 15 106	M8 Hex Nut, Zinc	4	4	4	4
11		26 02 109	M6 Flat Washer, Zinc	4	4	4	4
12		26 02 111	M8 Flat Washer, Zinc	5	5	5	5



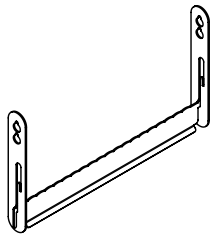
## Section 2

### Drip Canopy T250 - T1000

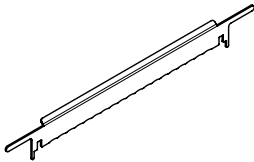


Refer to Drip Canopy Product Installation Manual for more information

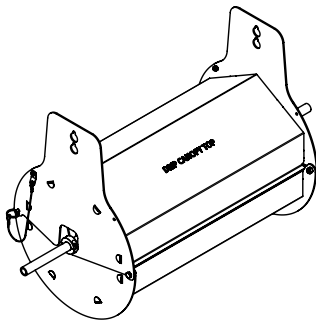
Roll Hanger without Enclosure			
Conveyor Type	Part Number	Drawing Number	Description
250	--	12S A 140 00A	Roll Hanger without Enclosure T250
350	--	12S A 130 00A	Roll Hanger without Enclosure T350
500	--	12S A 120 00A	Roll Hanger without Enclosure T500
750	--	12S A 110 00A	Roll Hanger without Enclosure T750
1000	--	12S A 100 00A	Roll Hanger without Enclosure T1000



Support Hanger			
Conveyor Type	Part Number	Drawing Number	Description
250	--	12S A 240 00A	Support Hanger T250
350	--	12S A 230 00A	Support Hanger T350
500	--	12S A 220 00A	Support Hanger T500
750	--	12S A 210 00A	Support Hanger T750
1000	--	12S A 200 00A	Support Hanger T1000



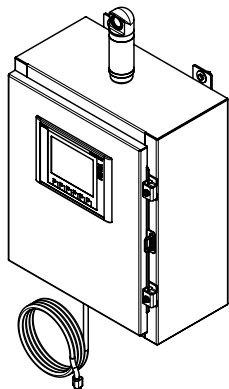
Lock Bar			
Conveyor Type	Part Number	Drawing Number	Description
250	--	12S A 240 03A	Lock Bar T250
350	--	12S A 230 03A	Lock Bar T350
500	--	12S A 220 03A	Lock Bar T500
750	--	12S A 210 03A	Lock Bar T750
1000	--	12S A 200 03A	Lock Bar T1000



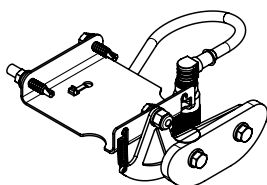
Roll Hanger with Enclosure			
Conveyor Type	Part Number	Drawing Number	Description
250	--	12S A 340 00A	Roll Hanger with Enclosure T250
350	--	12S A 330 00A	Roll Hanger with Enclosure T350
500	--	12S A 320 00A	Roll Hanger with Enclosure T500
750	--	12S A 310 00A	Roll Hanger with Enclosure T750
1000	--	12S A 300 00A	Roll Hanger with Enclosure T1000

## ChainKeeper T250 - T1000

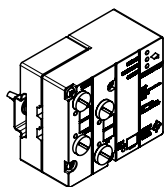
Refer to ChainKeeper Product Installation Manual more information



Control Panel Kit			
Conveyor Type	Part Number	Drawing Number	Description
250 - 1000	A100A	--	Control Panel Kit 120V
	A100B	--	Control Panel Kit 240V



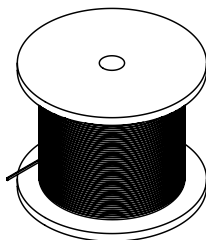
Sensor Kit			
Conveyor Type	Part Number	Drawing Number	Description
250 - 1000	A101B	--	Sensor Kit



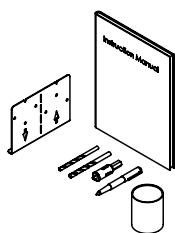
Tuner Kit			
Conveyor Type	Part Number	Drawing Number	Description
250 - 1000	A102A	--	Tuner Kit



Cable Mounting Kit			
Conveyor Type	Part Number	Drawing Number	Description
250 - 1000	A103B	--	Cable Mounting Kit



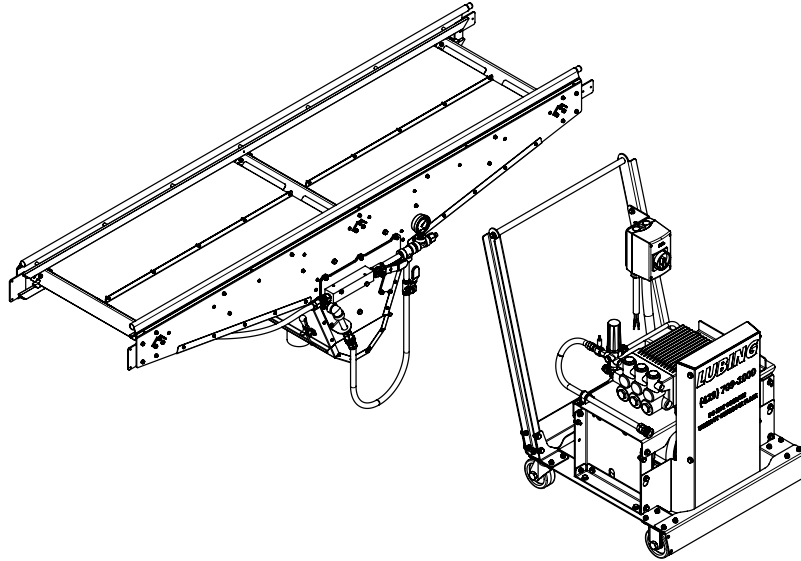
AS-i Cable, ft			
Conveyor Type	Part Number	Drawing Number	Description
250 - 1000	A104A	--	AS-i Cable (per ft.)



Installation Kit			
Conveyor Type	Part Number	Drawing Number	Description
250 - 1000	A105A	--	Installation Kit

## Section 2

### Spray Cabinet and Pump Cart T250 - T1000



Refer to Spray Cabinet Product Installation Manual for more information

Spray Cabinet US			
Conveyor Type	Part Number	Drawing Number	Description
250	C204A	12N A 400 00A	Spray Cabinet T250 US
350	D204A	12N A 300 00A	Spray Cabinet T350 US
500	E204A	12N A 200 00A	Spray Cabinet T500 US
750	F204A	12N A 100 00A	Spray Cabinet T750 US
1000	G204A	12N A 000 00A	Spray Cabinet T1000 US

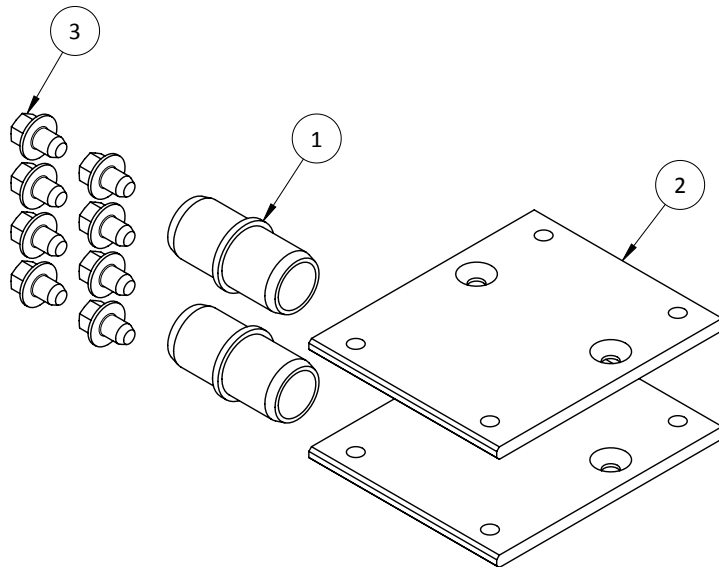
Pump Cart			
Conveyor Type	Part Number	Drawing Number	Description
250 - 1000	A200A	12N A 050 00A	Spray Cabinet Pump Cart 208-230v Stainless US
	A200B	12N A 050 00B	Spray Cabinet Pump Cart 460v Stainless US

## Section 2

### Accessories

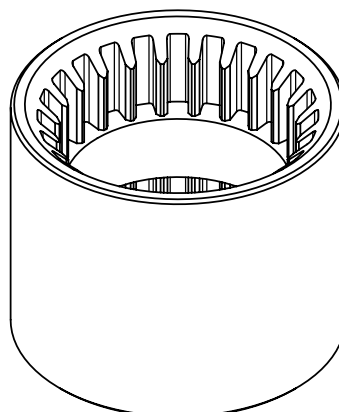
#### Accessory Pack T250 - T1000

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	185 520 18 00		Intermediate Coupling	2
2	185 525 06 00		Thread Plate	2
3		21 99 065	M6 x 8 Flanged Head Hex Bolt, Zinc	8

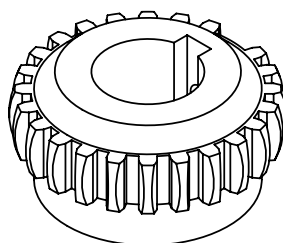


Curve Conveyor Accessory Pack			
Conveyor Type	Part Number	Drawing Number	Description
250	AP100	--	Curve Conveyor Accessory Pack
350			
500			
750			
1000			

**Stober Gearbox Coupling Components T250 - T1000**



COUPLING SLEEVE



MOTOR HUB

Components sold separately

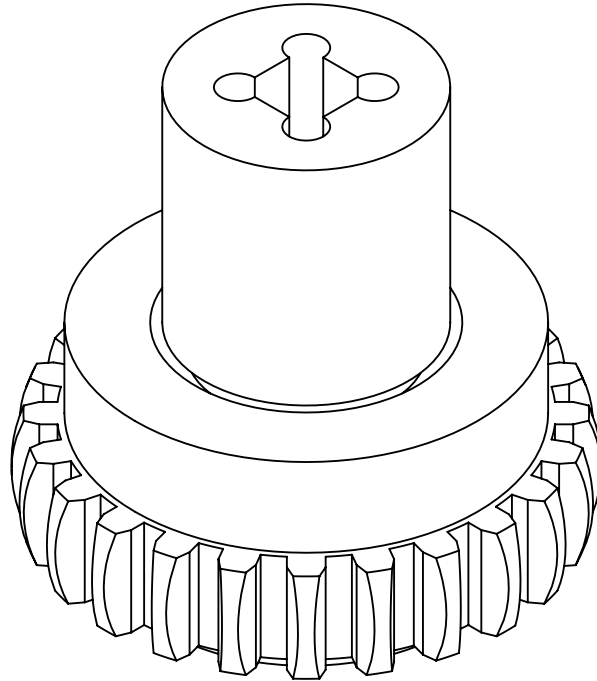
Stober Gearbox Coupling Components			
Conveyor Type	Part Number	Drawing Number	Description
250 - 1000	26336	--	Stober Coupling Sleeve (F, K, S Box)
	27920	--	Stober Motor Hub M19X0625



## Section 2

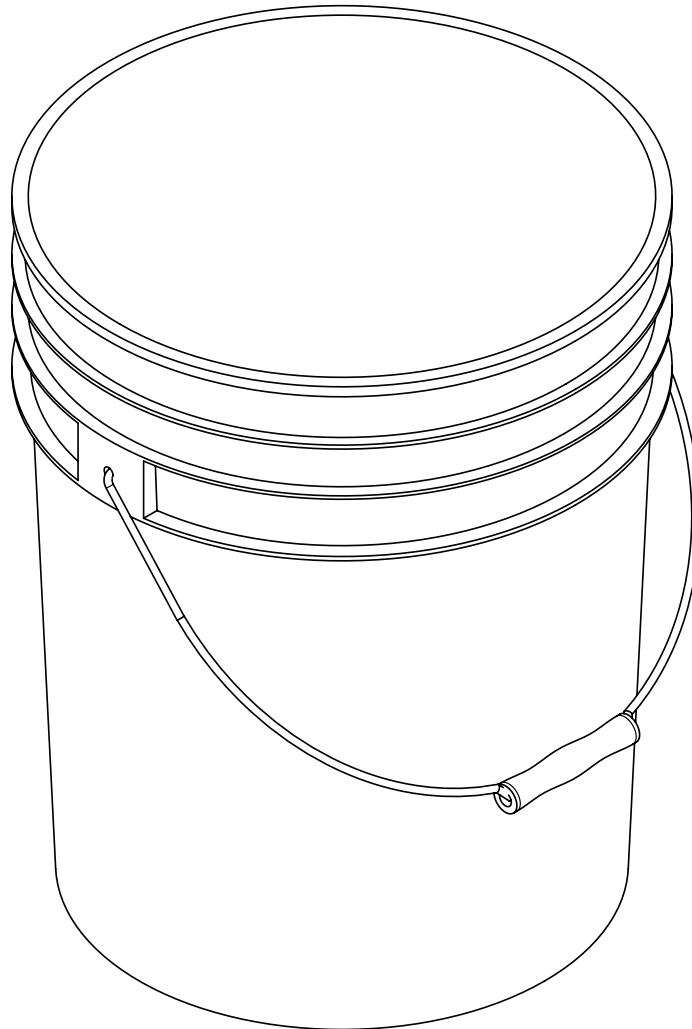
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### Stober Gearbox Tensioning Tool T250 - T1000



Stober Gearbox Tensioning Tool			
Conveyor Type	Part Number	Drawing Number	Description
250	--	707 211 01 00	Stober Gearbox Tensioning Tool
350			
500			
750			
1000			

**Chain Lubricant T250 - T1000**

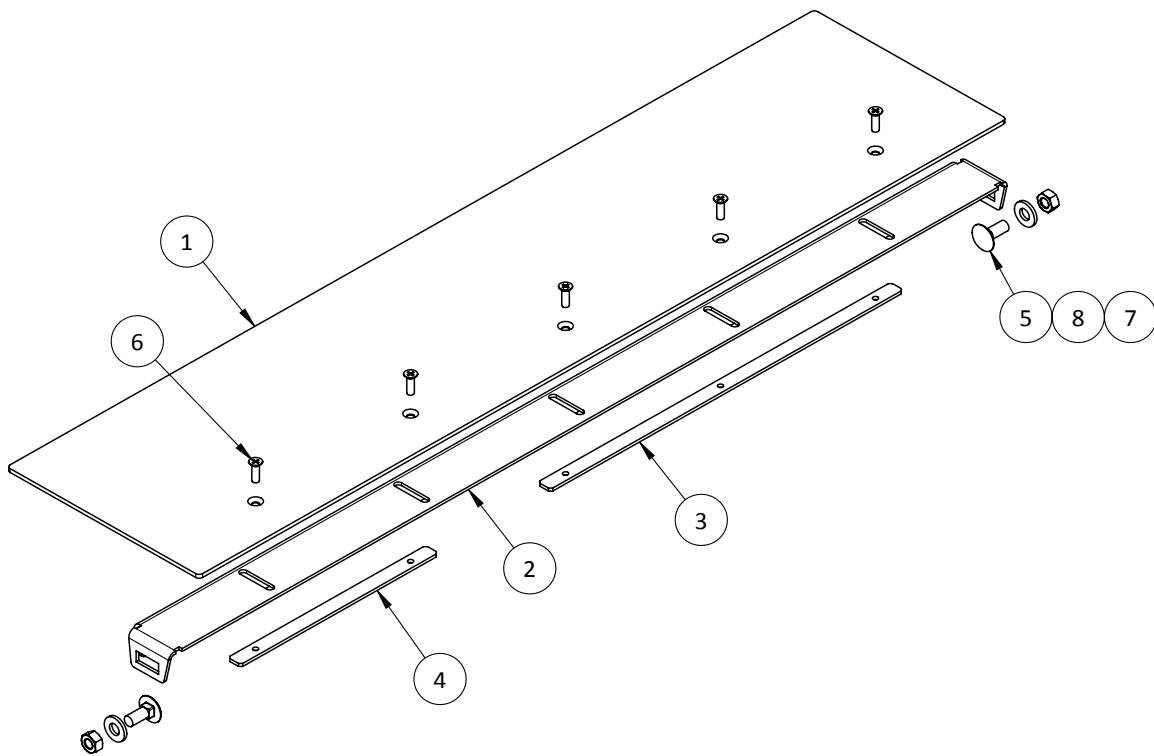


Chain Lubricant			
Conveyor Type	Part Number	Drawing Number	Description
250	LBG78-035	--	Lubricant Food Grade 5 Gallon
350			
500			
750			
1000			

## Section 2

### Transfer Complete 180mm (7-in) T250 - T750

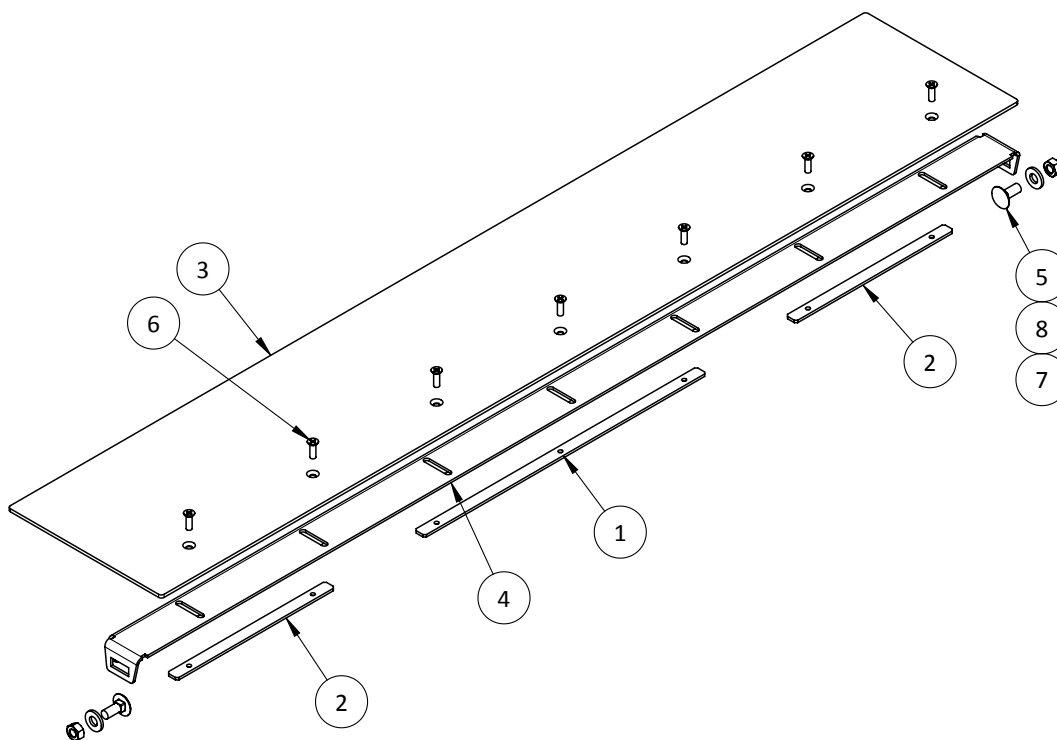
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T250	T350	T500	T750
1	186 518 02 06		Transfer Plate T250 x 180mm	1	-	-	-
1	187 518 02 06		Transfer Plate T350 x 180mm	-	1	-	-
1	185 518 02 06		Transfer Plate T500 x 180mm	-	-	1	-
1	188 518 02 06		Transfer Plate T750 x 180mm	-	-	-	1
2	186 518 43 00		Transfer Angle T250	1	-	-	-
2	187 518 43 00		Transfer Angle T350	-	1	-	-
2	185 518 43 00		Transfer Angle T500	-	-	1	-
2	188 518 43 00		Transfer Angle T750	-	-	-	1
3	187 518 44 00		Thread Plate T350	-	1	-	1
4	189 518 44 00		Thread Plate T200	1	-	2	1
5		21 28 087	M8 x 20 Carriage Bolt, Zinc	2	2	2	2
6		21 63 049	M5 x 16 Countersunk Screw, Zinc	2	3	4	5
7		25 15 106	M8 Hex Nut, Zinc	2	2	2	2
8		26 02 111	M8 Flat Washer, Zinc	2	2	2	2



Transfer Complete 180mm			
Conveyor Type	Part Number	Drawing Number	Description
250	--	186 500 10 06	Transfer Complete T250 x 180mm
350	--	187 500 10 06	Transfer Complete T350 x 180mm
500	--	185 500 10 06	Transfer Complete T500 x 180mm
750	--	188 500 10 06	Transfer Complete T750 x 180mm

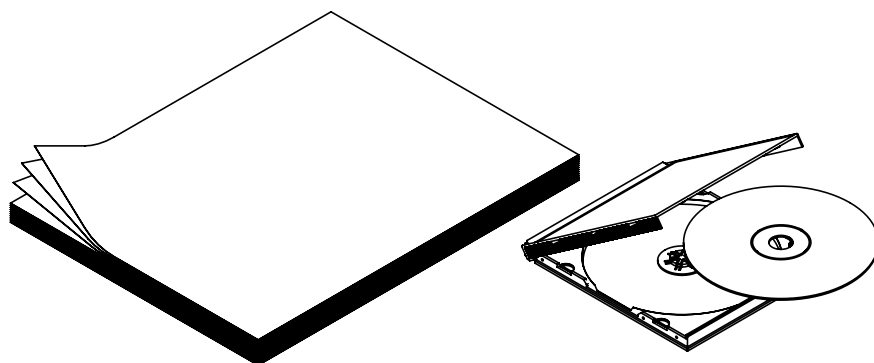
**Transfer Complete 180mm (7-in) T1000**

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	T1000
1	187 518 44 00		Thread Plate T350	1
2	189 518 44 00		Thread Plate T200	2
3	191 518 02 06		Transfer Plate T1000 x 180mm	1
4	191 518 43 00		Transfer Angle T1000	1
5		21 28 087	M8 x 20 Carriage Bolt, Zinc	2
6		21 63 049	M5 x 16 Countersunk Screw, Zinc	7
7		25 15 106	M8 Hex Nut, Zinc	2
8		26 02 111	M8 Flat Washer, Zinc	2



Transfer Complete 180mm			
Conveyor Type	Part Number	Drawing Number	Description
1000	--	191 500 10 06	Transfer Complete T1000 x 180mm

**Curve Conveyor User Manuals T250 - T1000**



Manual (Paper)			
Conveyor Type	Part Number	Drawing Number	Description
250	IM-707-00	--	User Manual Curve Conveyor T250 - T1000 (Paper)
350			
500			
750			
1000			

Manual (CD)			
Conveyor Type	Part Number	Drawing Number	Description
250	CD-707-00	--	User Manual CD Curve Conveyor Manual T250 - T1000
350			
500			
750			
1000			

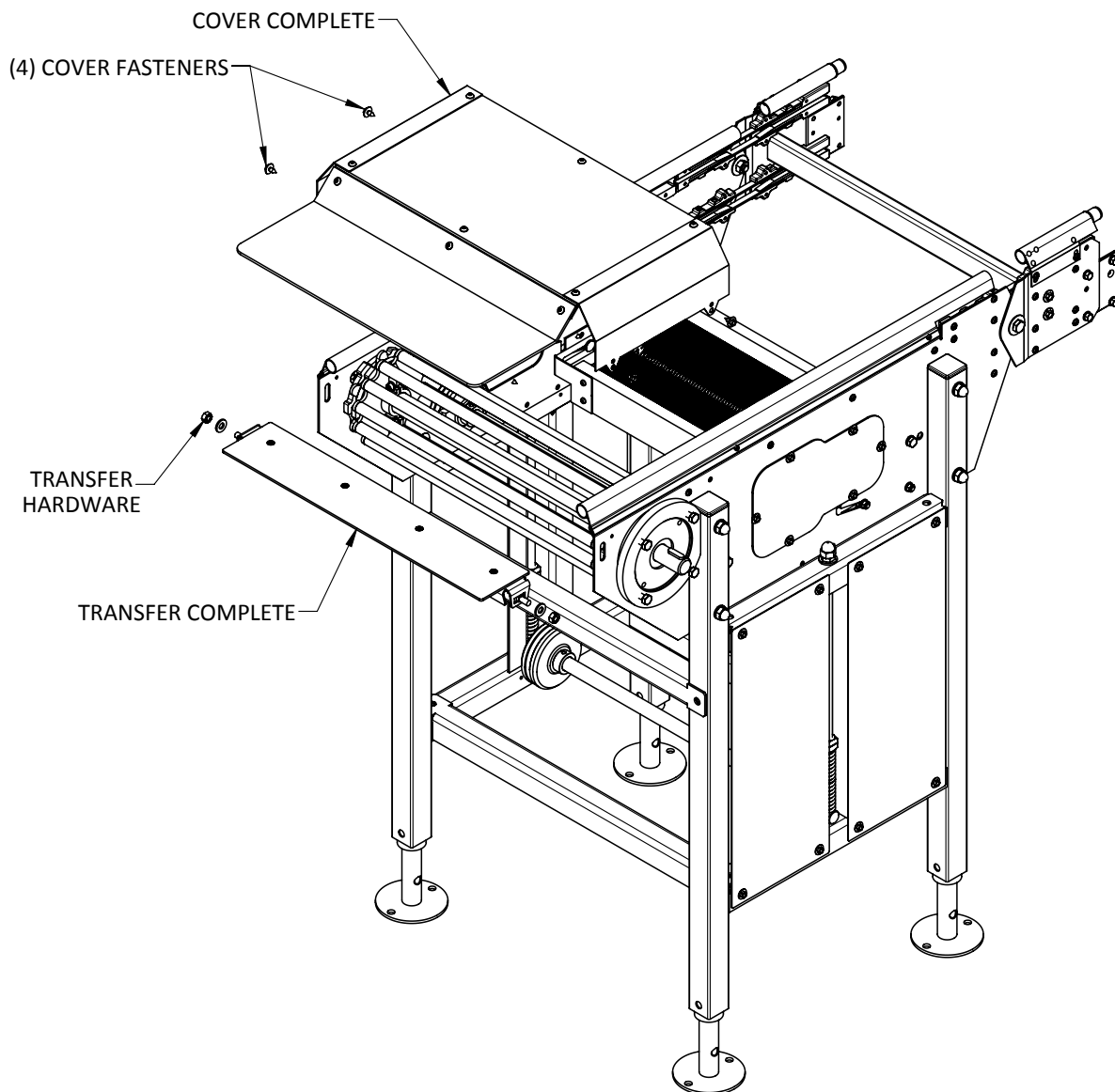
## Section 3

### SECTION 3 ASSEMBLY AND INSTALLATION

#### Preparing Equipment for Installation

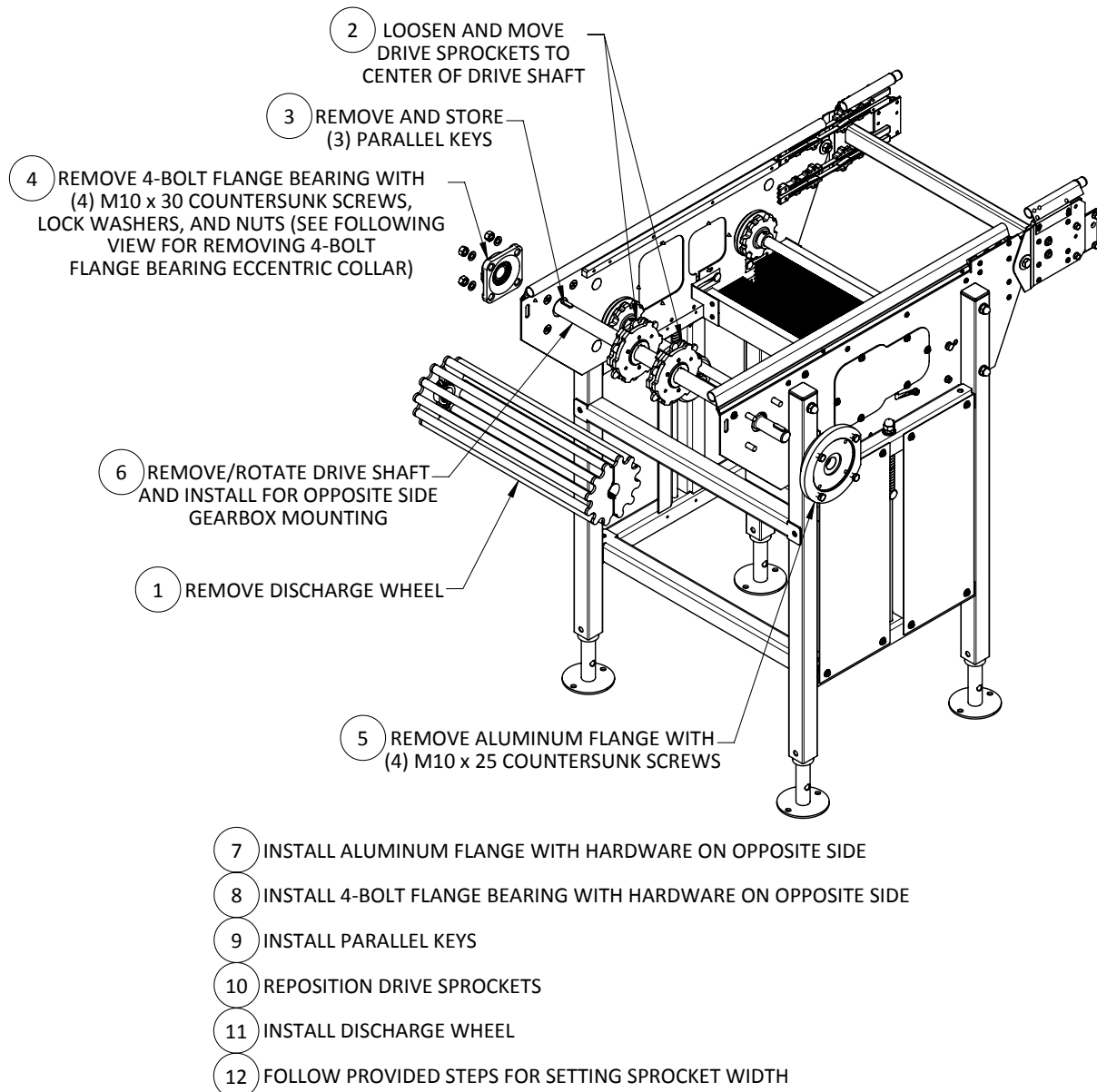
1. Before installation begins, remove all covers and transfers from new components to access Drive Sprockets for proper alignment and ease of installing chain.

Views below reflect the Front Drive, but are applicable to any components containing covers, transfers, etc.

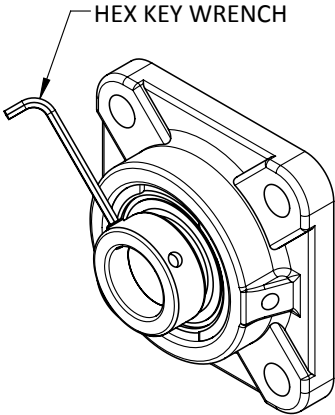


## Converting Drives from Left Hand to Right Hand Configurations

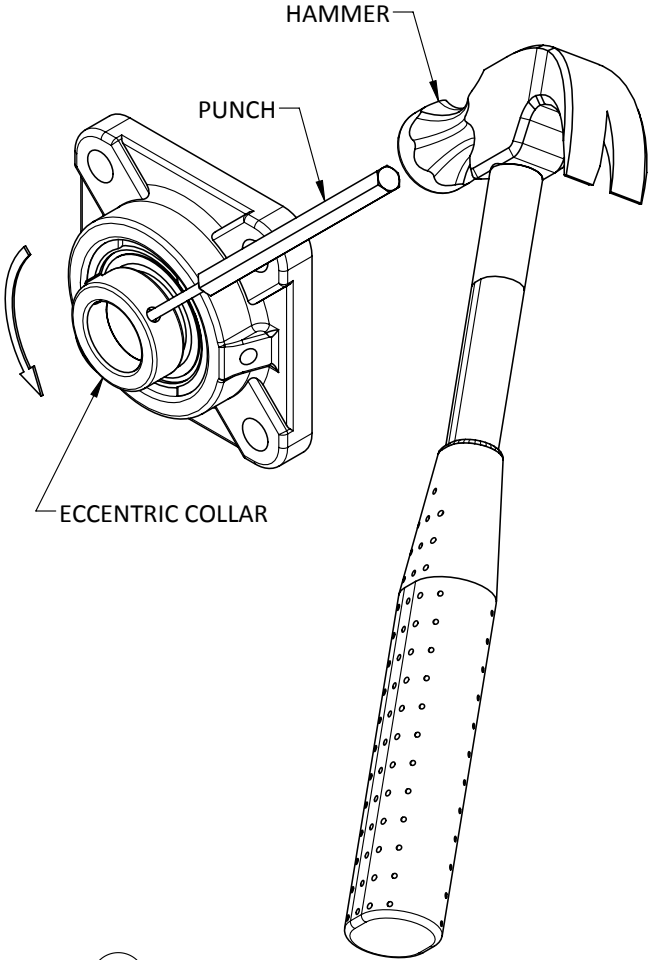
2. Verify all components requiring a motor and gearbox are setup with the Gearbox Flange on the appropriate side. The following view illustrates the steps involved in swapping the drive location from a left hand to right hand drive. See following page regarding the 4-bolt Flange Bearing.



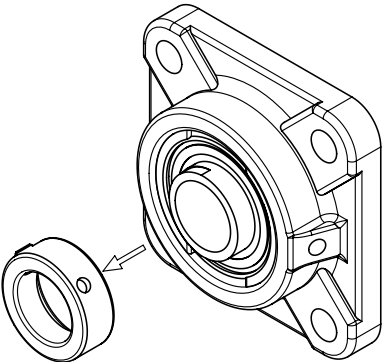
# Section 3



1 LOOSEN SET SCREW



2 USING HAMMER AND PUNCH,  
TAP ECCENTRIC COLLAR TO LOOSEN

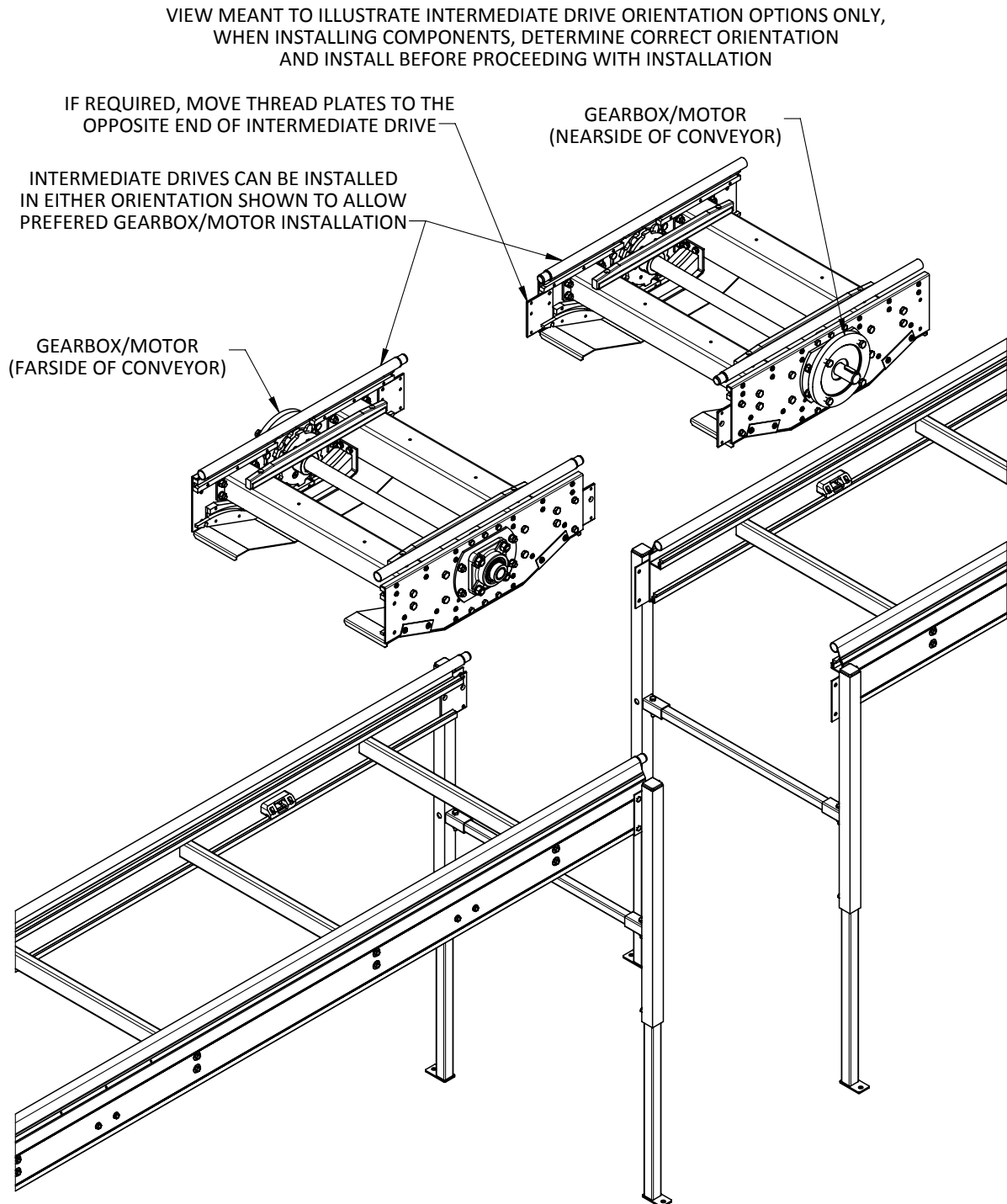


3 REMOVE COLLAR

- 4 BEARING IS NOW FREED FROM THE SHAFT FOR SERVICING, REPLACEMENT, ETC.
- 5 REVERSE STEPS FOR ASSEMBLY, TIGHTEN SET SCREW TO SECURE



3. In the case of Intermediate Drives, left and right configurations can be determined when installing the component. Thread Plate locations are the only mechanical changes that may need to be addressed.

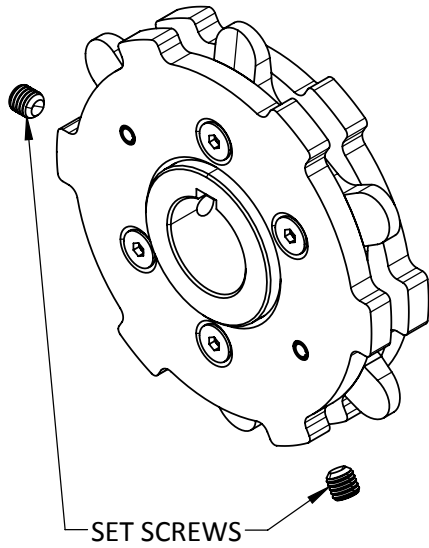


## Section 3

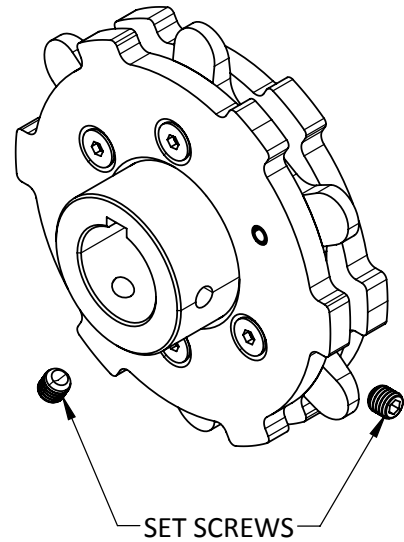
### Setting Sprocket Width

- The view below shows the set screw locations for the Drive Sprockets, loosen the set screws to begin adjusting the sprockets to best fit the Conveyor Chain in the system.

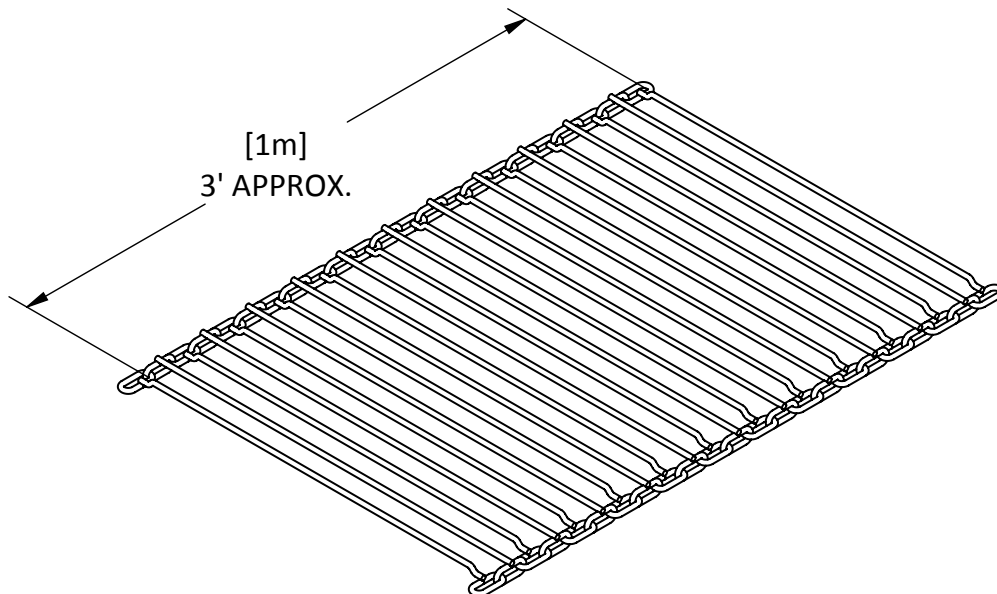
MAIN DRIVE SPROCKET  
(SET SCREWS LOCATED IN CENTER GROOVE)



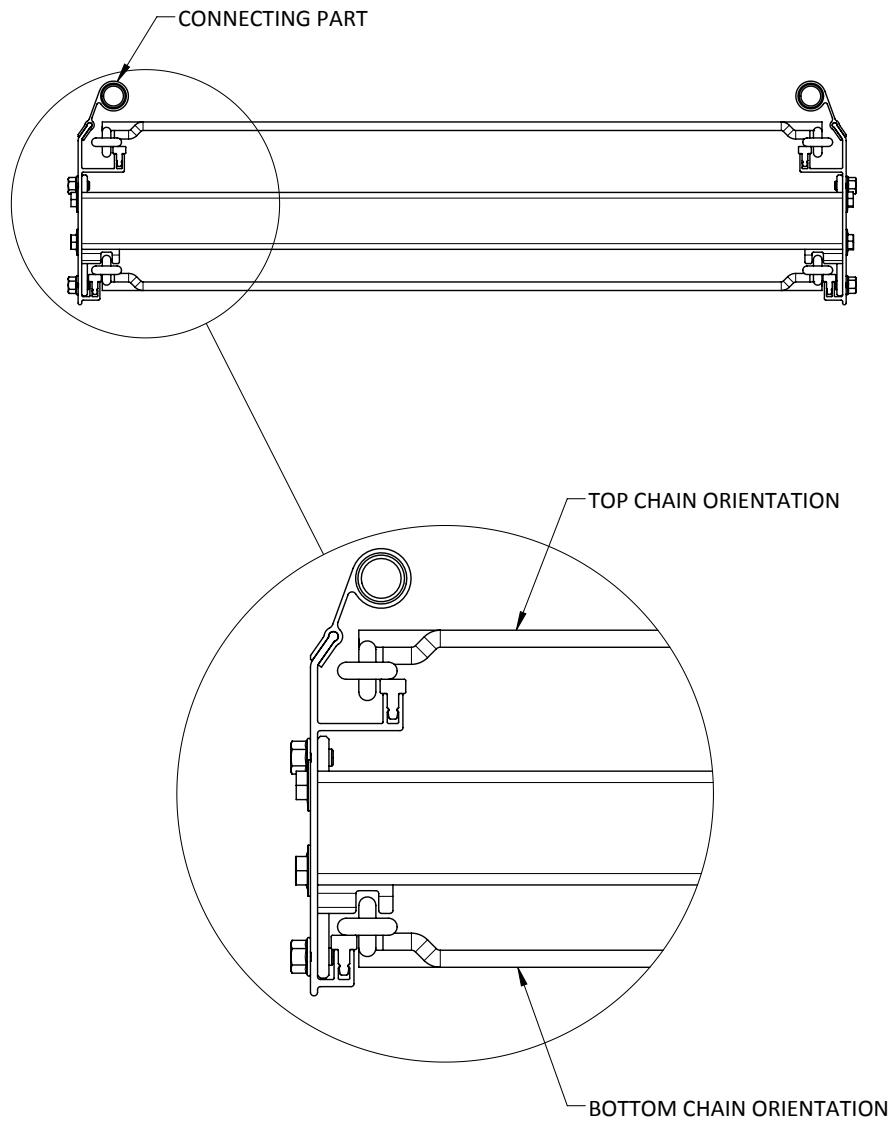
INTERMEDIATE DRIVE SPROCKET  
(SET SCREWS LOCATED IN HUB)



- Using a roll of chain intended for the current installation, cut a short section as pictured below to use as a gauge while setting all sprocket widths for the system (any main drive, intermediates, and components containing drive sprockets).



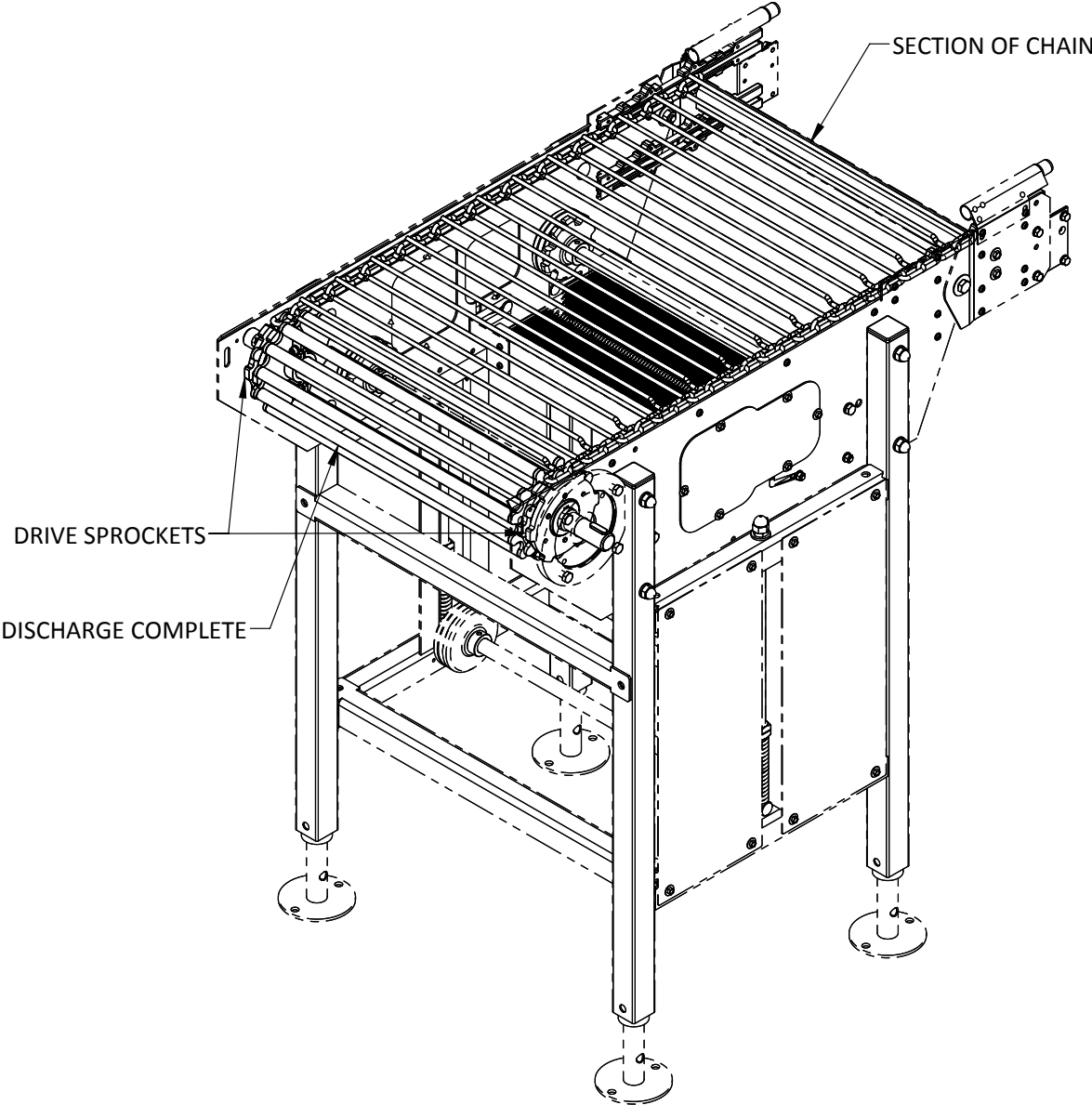
6. The following view illustrates typical chain orientation for all components.



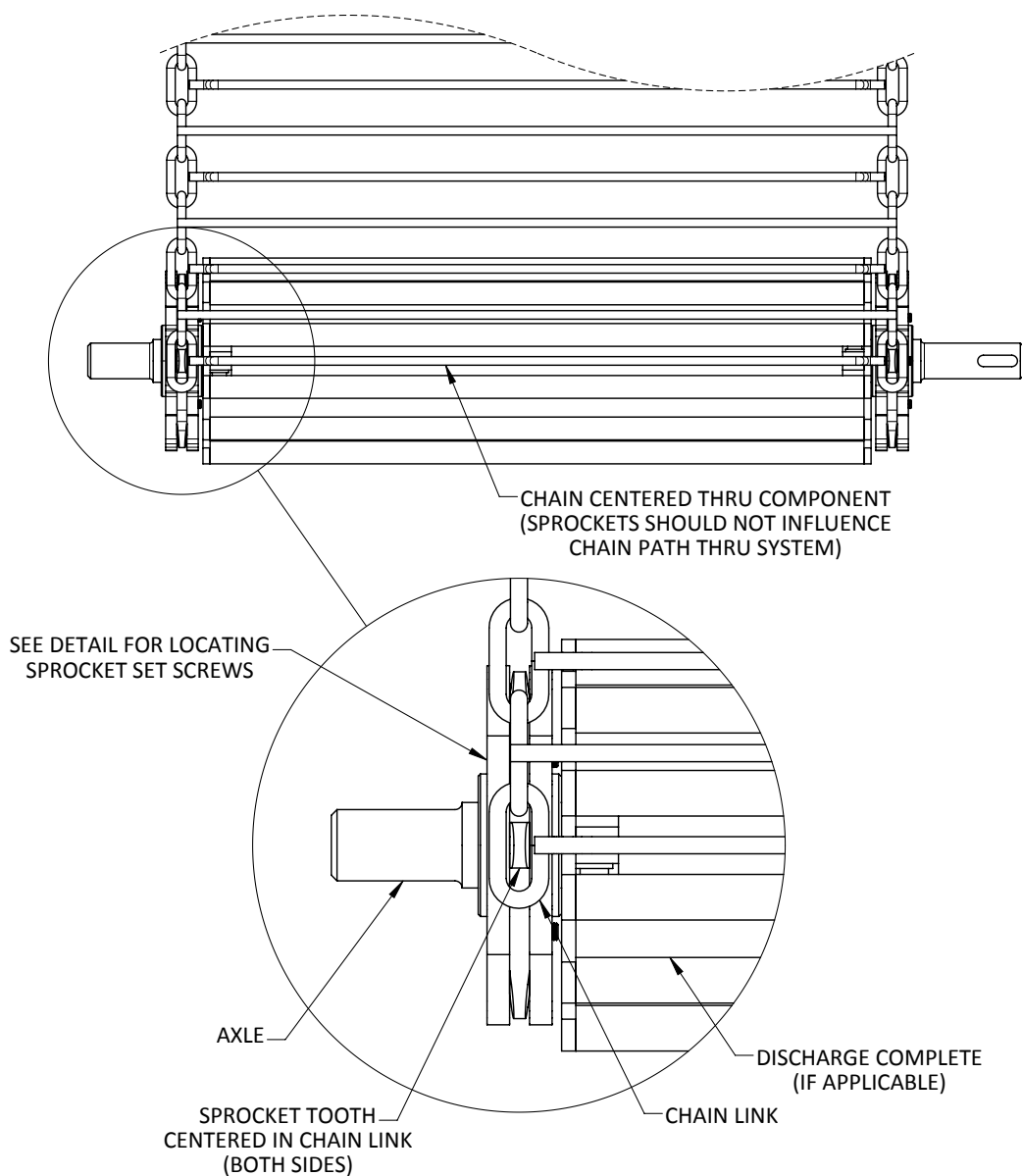
# Section 3

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- 7. Feed the chain section through the top side of the components until engaged with the Drive Sprockets.



- Adjust the Sprocket Tooth to be centered in the Chain Link on both sides of the component. Ensure the chain is centered through the component and tighten the set screws.



NOTE: USE SECTION OF CHAIN INTENDED FOR INSTALLATION IN SYSTEM  
(DO NOT USE CHAIN FROM ANOTHER INSTALLATION OR CONVEYOR)

## Section 3

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### Converting Intermediate Top Drives to Bottom Drives

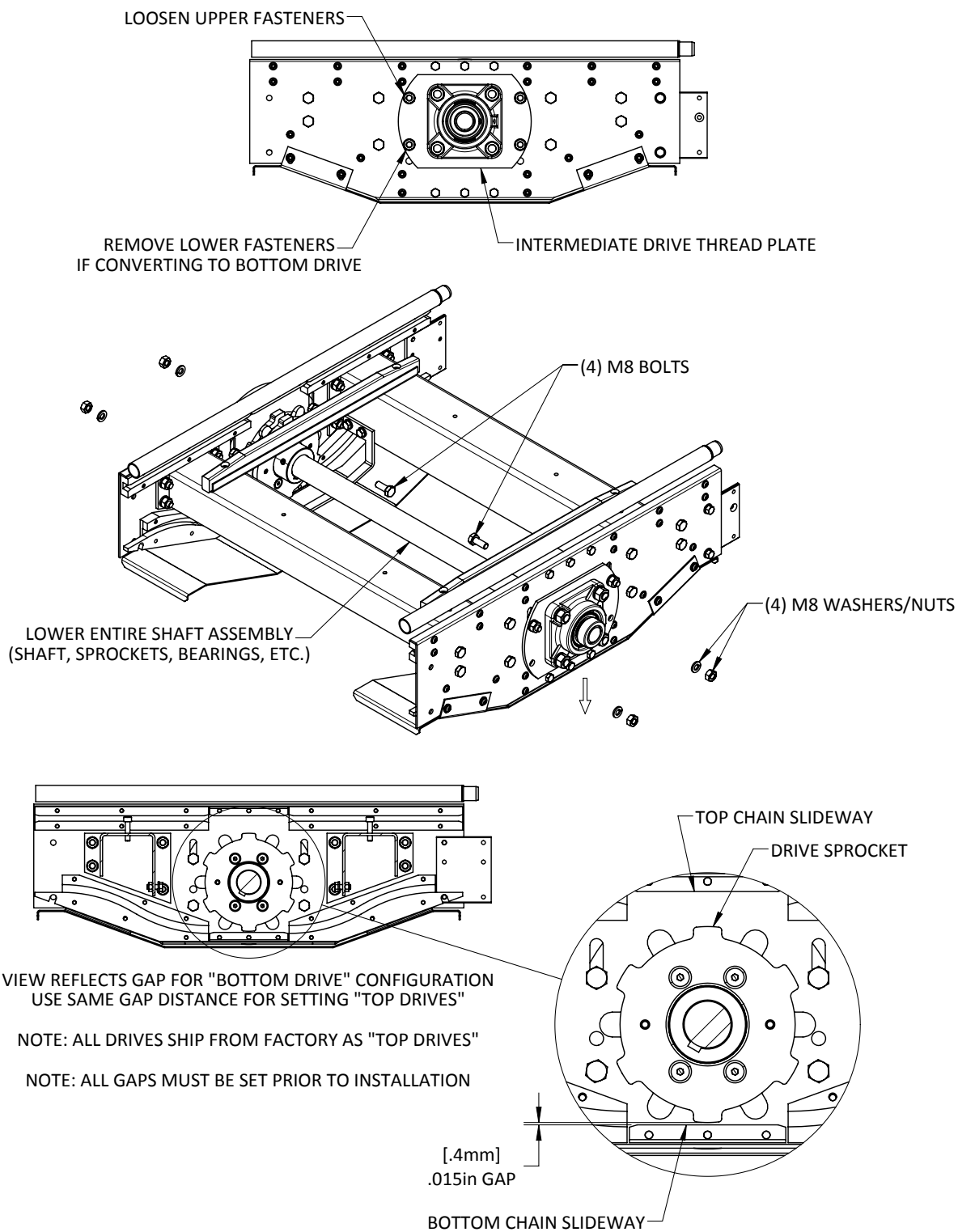
9. All Intermediate Drives ship from the factory as “Top Drives” or driving the top side of the chain. A layout is provided for each installation containing a Bill of Materials specifying the quantity of “Top” and “Bottom” Intermediate Drives. The following view details the conversion of a “Top Drive” to a “Bottom Drive” and setting the Sprocket Gap for best performance.

If no Top to Bottom change is required, follow the steps provided in setting the proper Sprocket Gap.

Set the Sprocket Gap for a “Top Drive” between the Drive Sprocket and top Chain Slideway, set the Sprocket Gap for a “Bottom Drive” between the Drive Sprocket and bottom Chain Slideway.

Note: A standard business card can be used to approximate the proper gap.

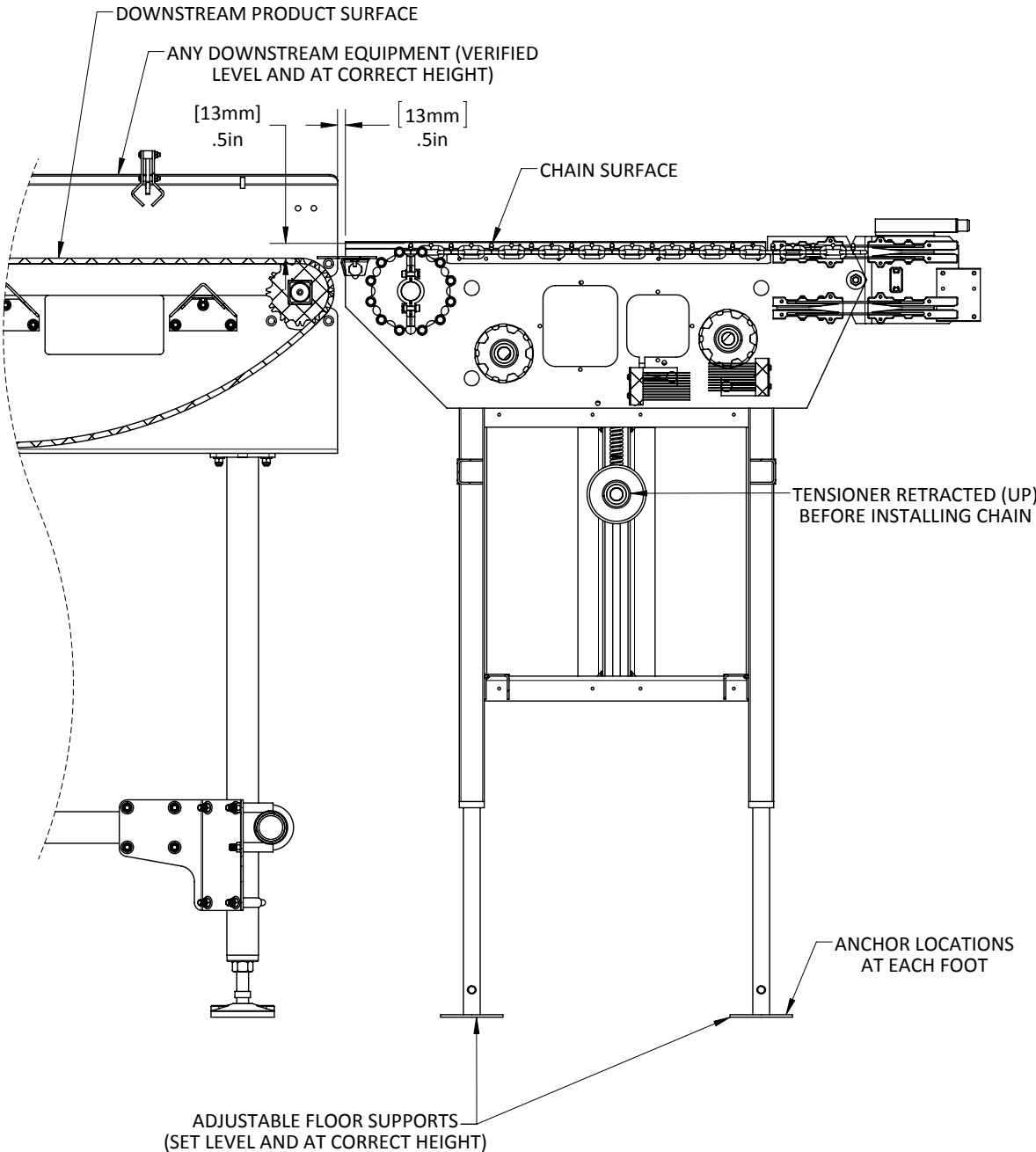
Set Sprocket Width as previously discussed.



# Section 3

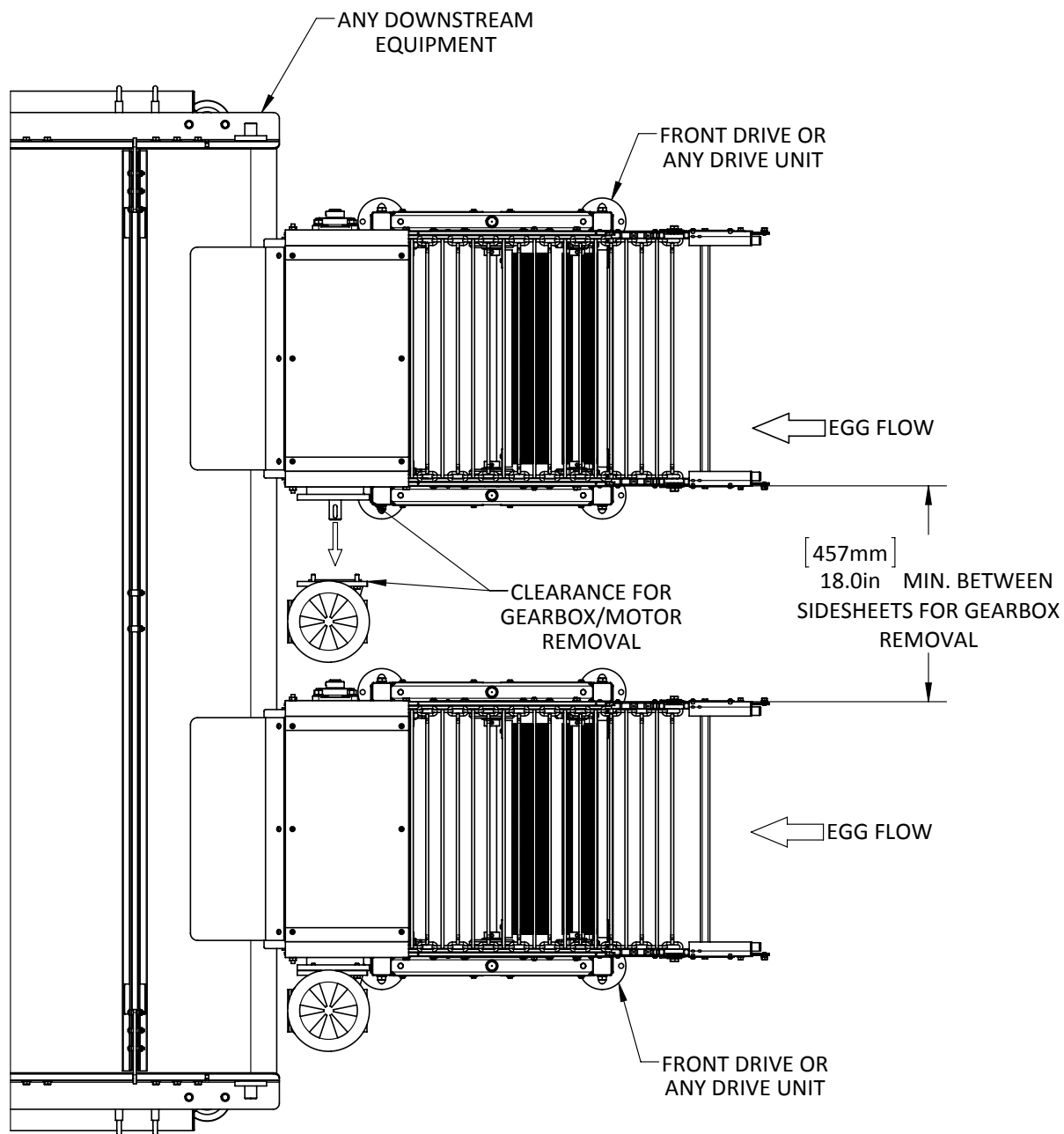
## Setting Components to Downstream Equipment

- 10. Verify any downstream equipment as level and at the correct height before proceeding.
- 11. Secure the first component as shown below. Adjust heights and level before proceeding.





12. If installing multiple conveyors, verify the clearances required for servicing the gearbox and motor.



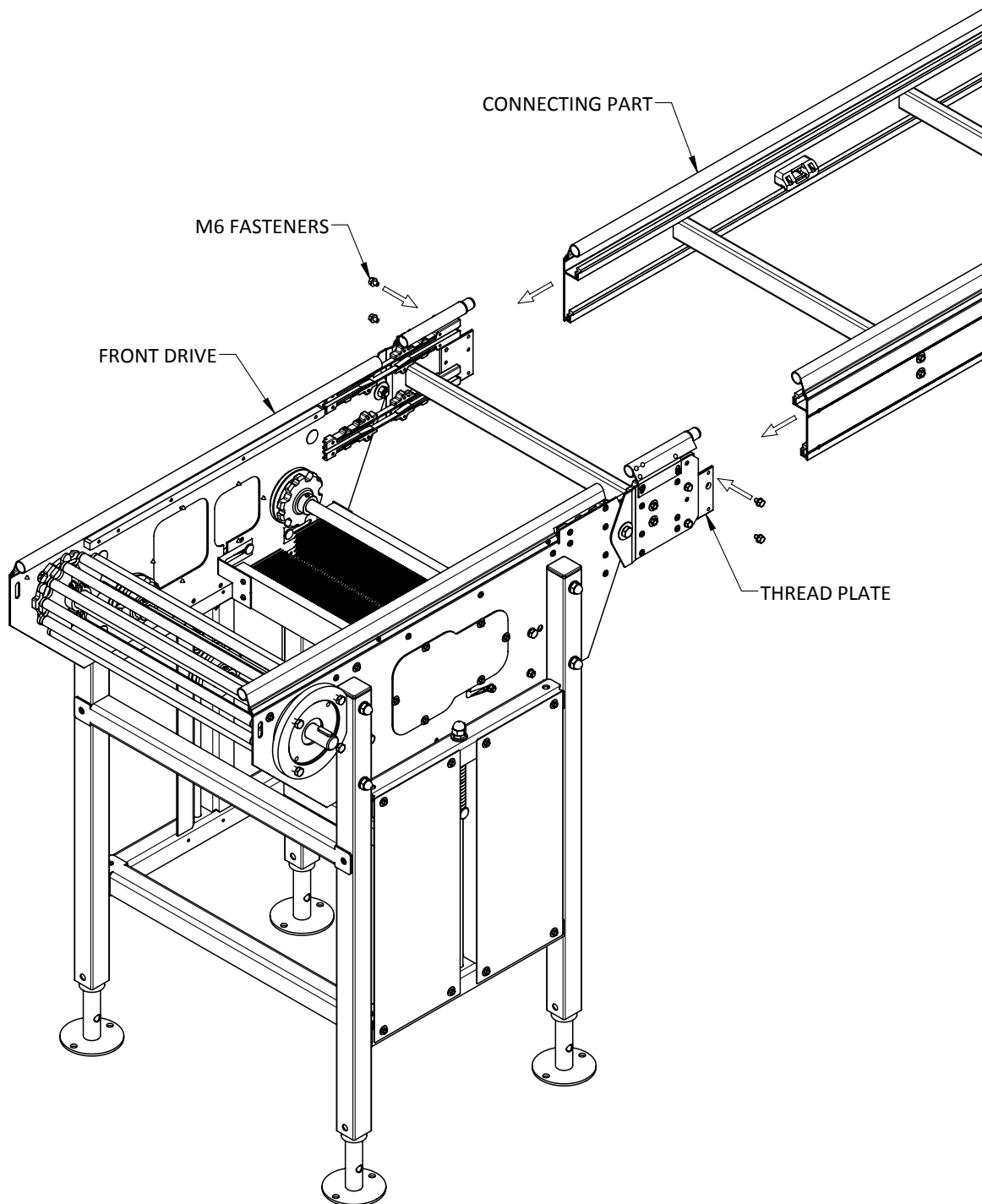
NOTE: IF NO GEARBOX/MOTOR IS PRESENT BETWEEN DRIVE UNITS, MINIMUM CLEARANCE CAN BE REDUCED TO [152mm] OR 6in

## Section 3

### Joining Components

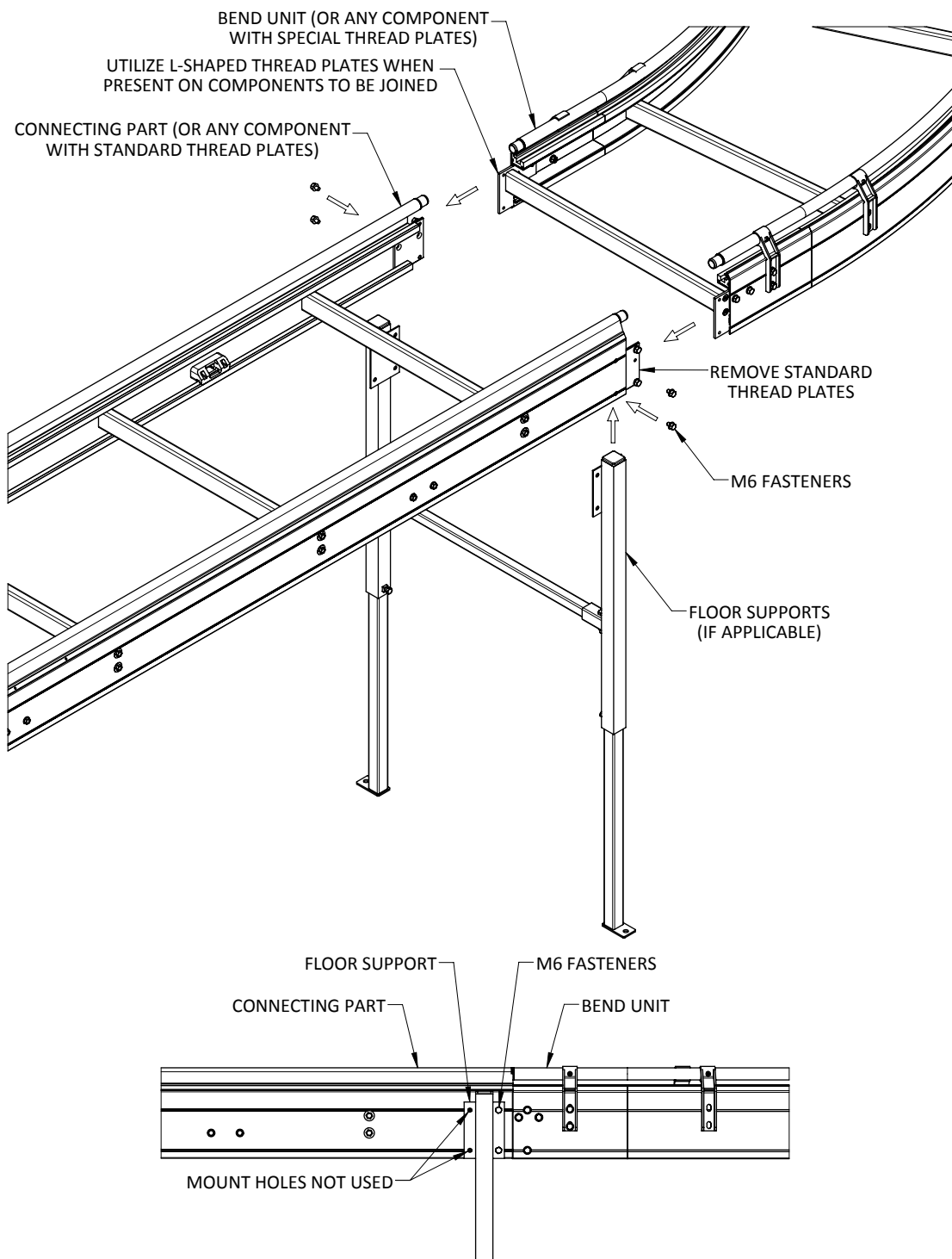
#### Standard Thread Plates

13. Install components per the provided layout drawing. Use the provided M6 fasteners to join components with the standard (square) Thread Plates as shown below.



### Special Thread Plates

14. When joining components requiring special (L-shaped) Thread Plates, remove the standard (square) Thread Plates from one component and join as shown below.



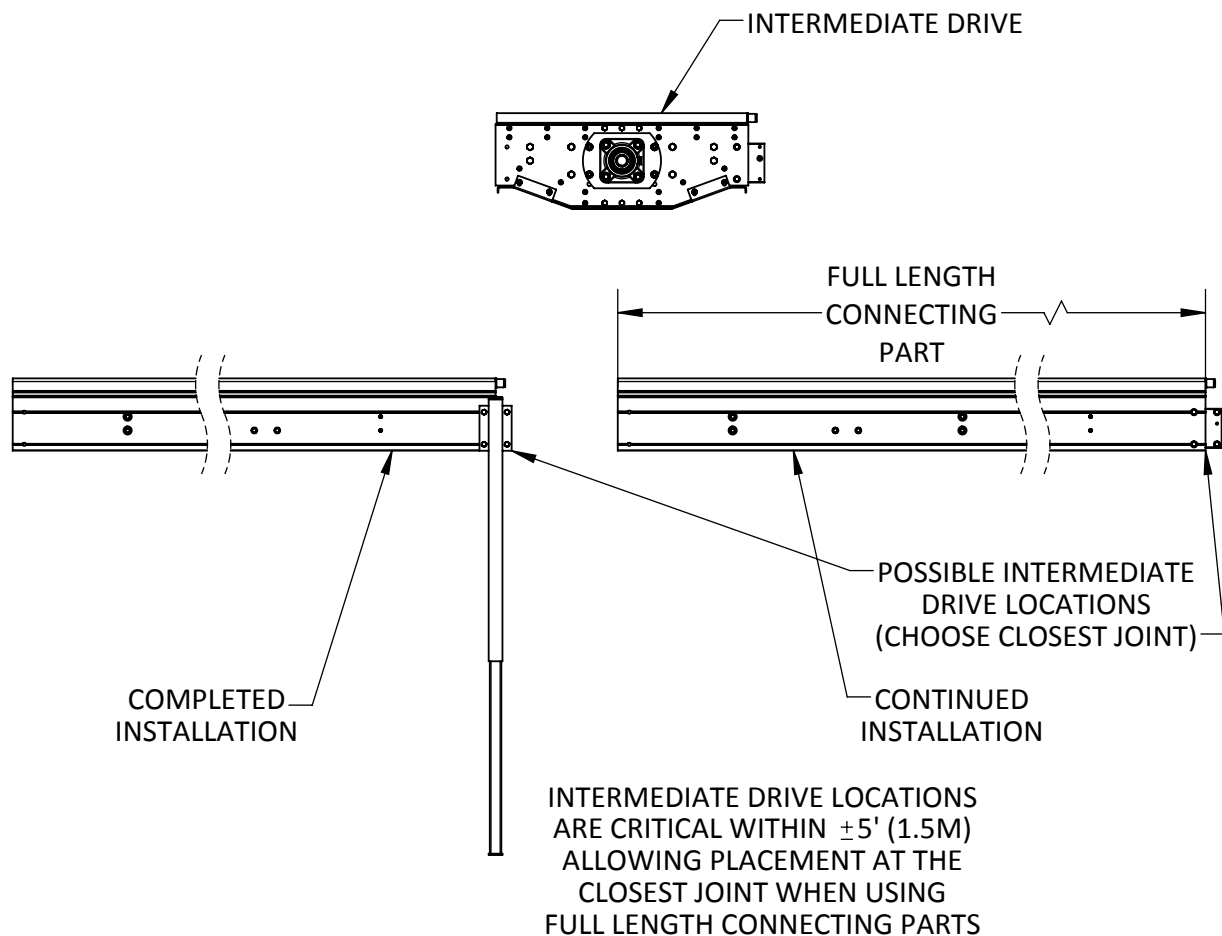
## Section 3

### Locating Components

15. Components should always be located per the supplied Conveyor Layout drawing. If issues are encountered during installation, contact your Lubing representative. Seemingly small compromises during installation may result in poor performance, delays, and/or damage to the system later.

Note: All drives should be located plus or minus (5) five feet (1.5 meters) of the provided dimensions. This allows for installation at the closest end of a Connecting Part without effecting the drive layout or balance of the conveyor. Any compromises exceeding this tolerance should be communicated with your Lubing representative before proceeding.

Note: The quantity and style of Drip Oilers are calculated based on the Conveyor Layout drawing. Although not as critical as drive placement, an attempt to match the layout as closely as possible should be made. Excessive deviations may result in oil starvation to certain areas within the system.



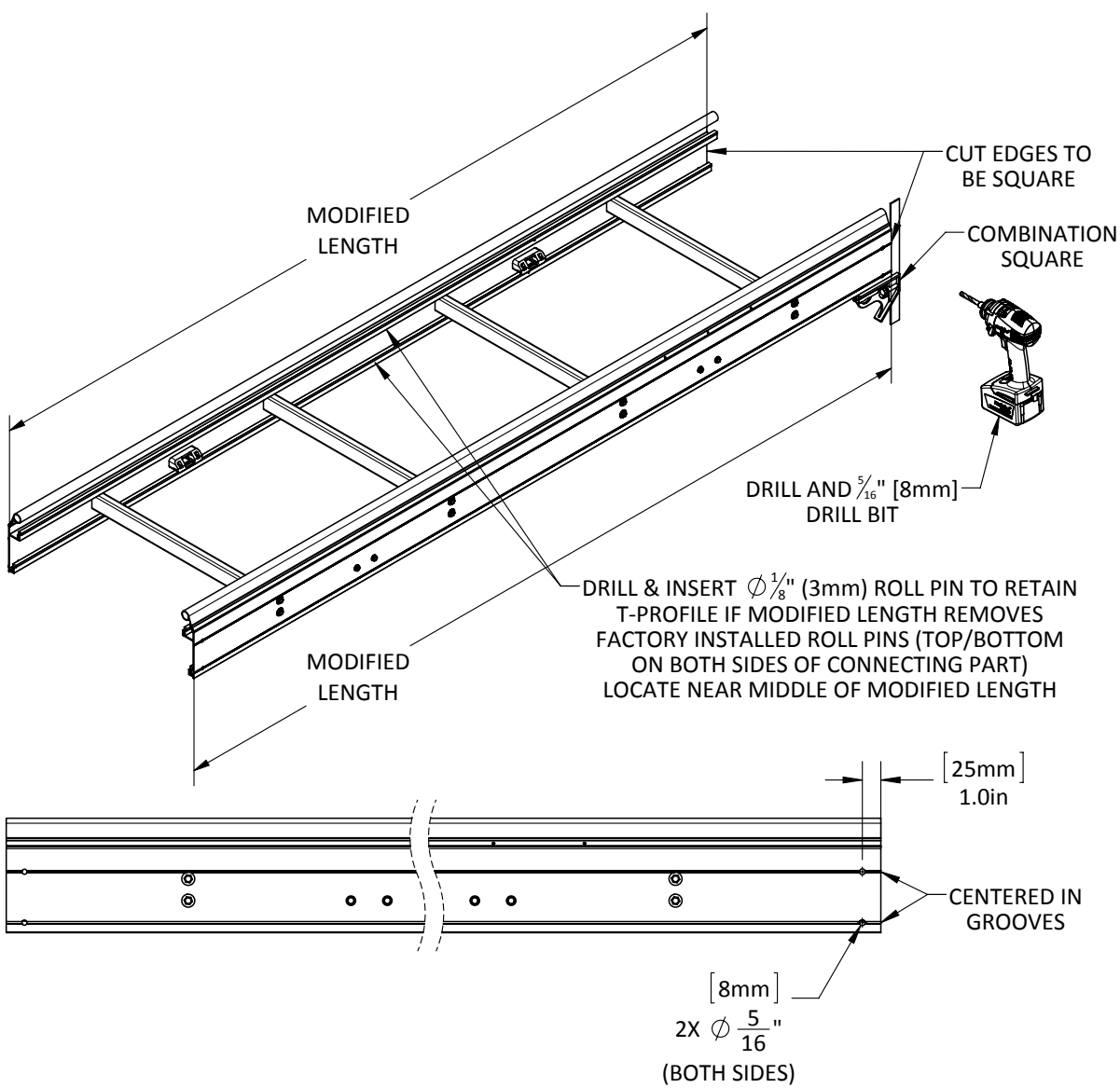
## Modifying Connecting Part Length

16. The following view illustrates the cutting of Connecting Parts and adding the required holes.

Cut edges must be square and both side lengths must be equal to ensure correct mounting once modified.

Note: The following view illustrates the addition of Roll Pins to secure the T-Profile if the modified length removes the factory-installed roll pins. All T-Profile in the system should be secured to prevent the components from walking over time.

Note: It is not recommended to modify the length of stainless Connecting Parts.



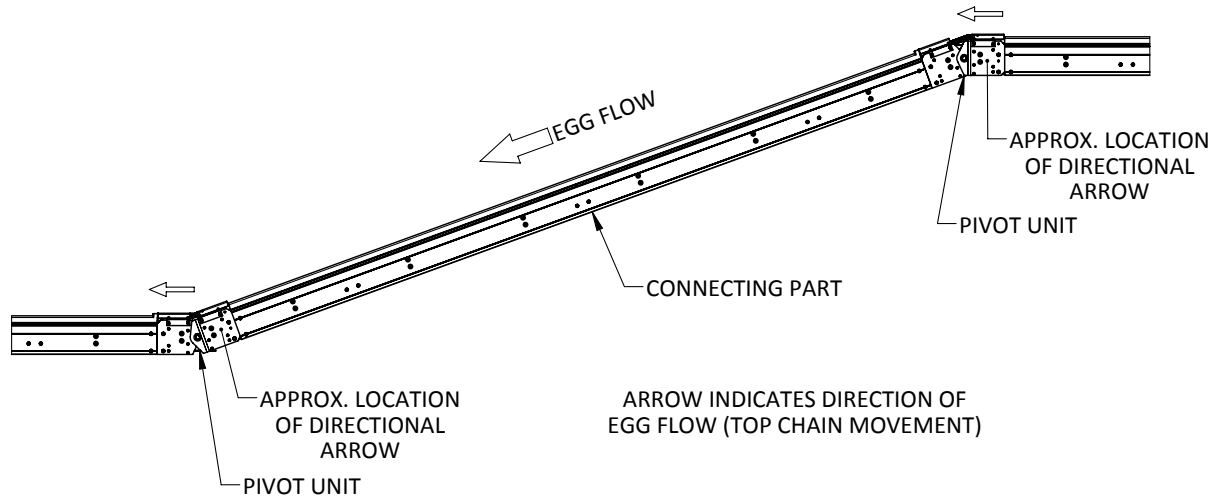
## Section 3

### Directional Components

#### Pivot Units

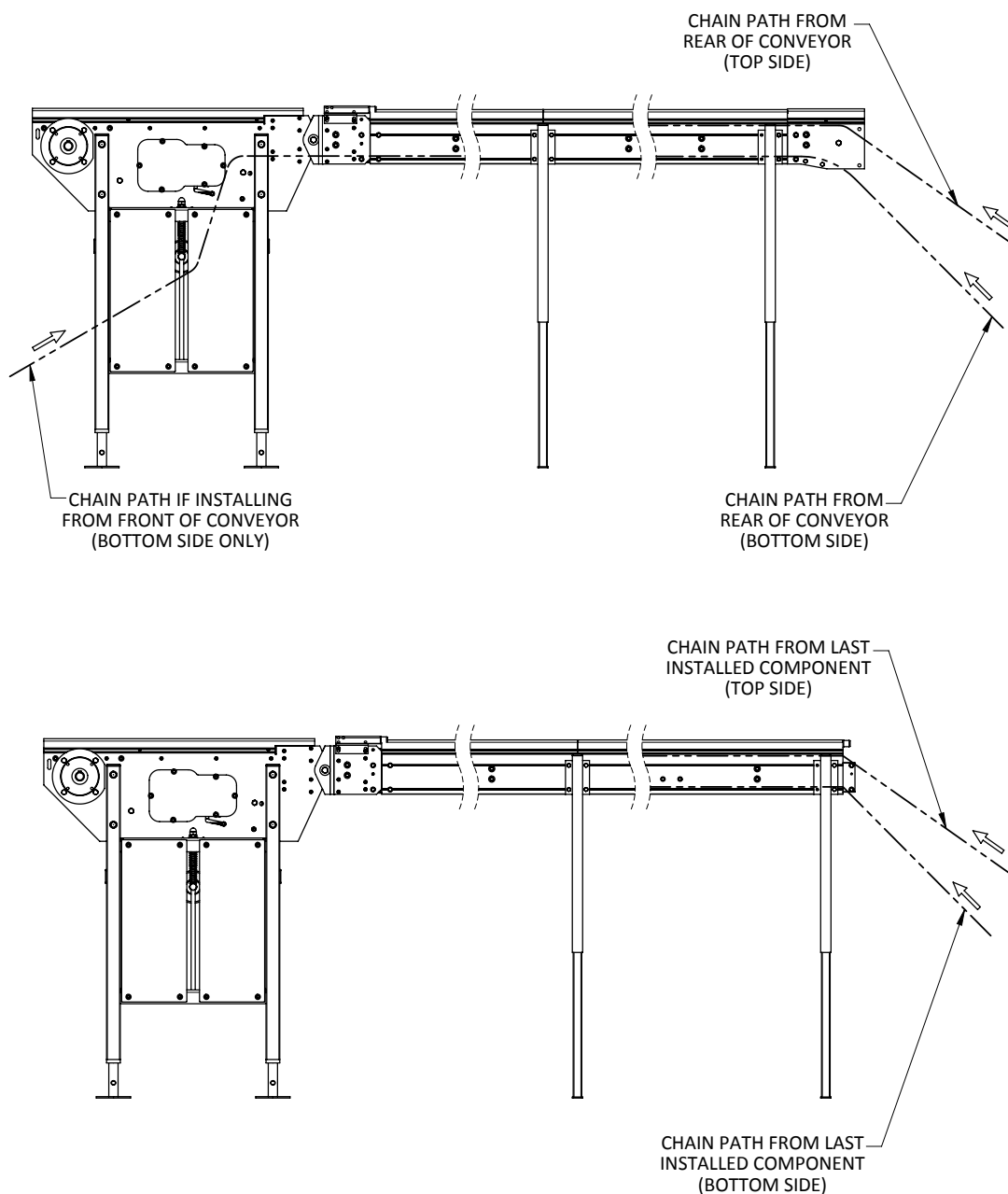
17. The following view illustrates proper orientation when installing Pivot Units.

Note: Locate the directional arrow on the Pivot Units when installing. Failure to install in the correct orientation can result in damage to Pivot Units and/or Conveyor Chain.



## Installing Chain

18. Retract any tensioners before installing chain.
19. The following view illustrates the appropriate areas to feed chain into the system. Never force chain into an enclosed section of conveyor, damage to chain or other components may occur.

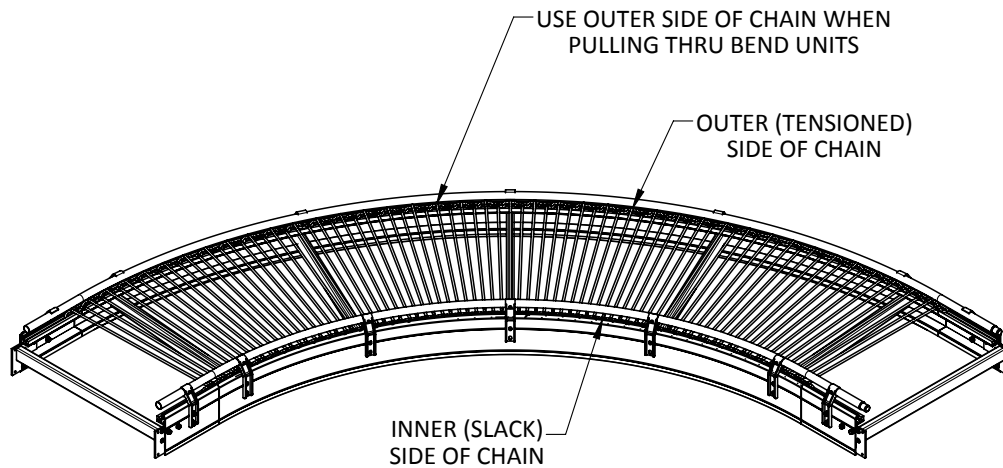


## Section 3

### Pulling Chain

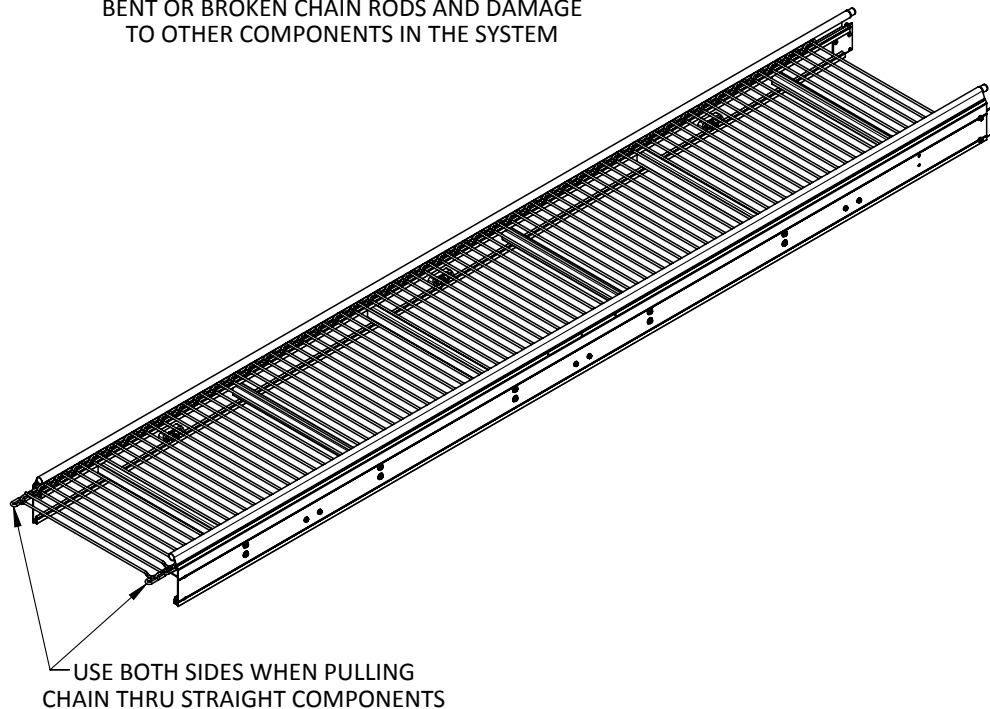
20. Stock lengths of chain rolls are 10 meters or 32'. When possible, there should be enough linear length of conveyor to accept a minimum of (1) one complete roll before installing chain.

21. The following view illustrates the proper techniques for pulling chain.



NOTE: NEVER USE THE CENTER OF THE CHAIN ROD TO PULL CHAIN!

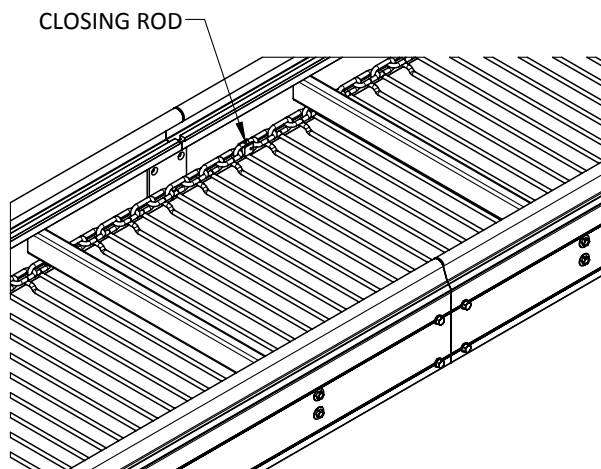
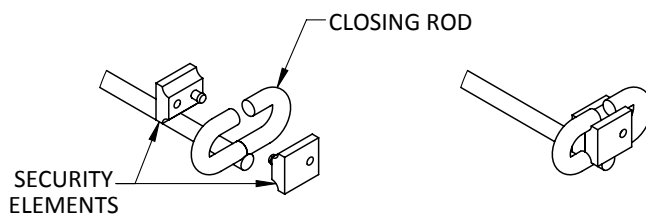
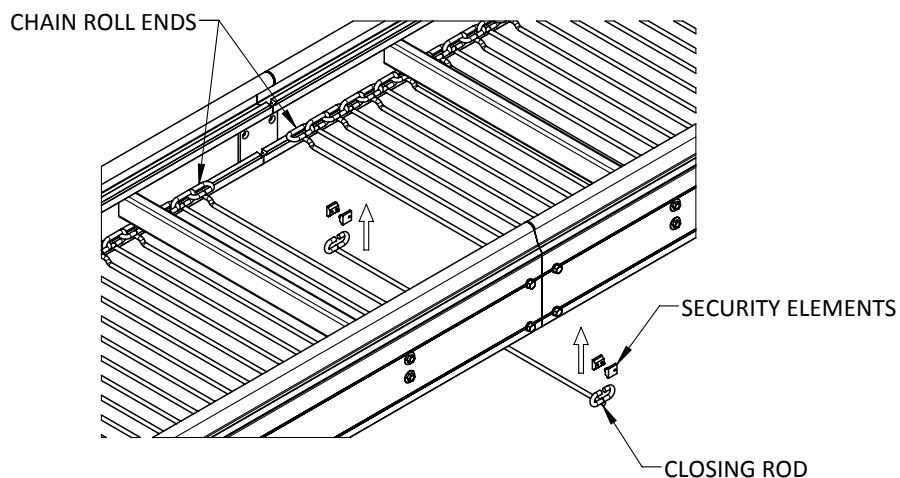
IMPROPER PULLING TECHNIQUES MAY RESULT IN BENT OR BROKEN CHAIN RODS AND DAMAGE TO OTHER COMPONENTS IN THE SYSTEM





## Joining Chain Sections

22. The following view illustrates joining chain sections with a Closing Rod and Security Elements.
23. Install complete sections of chain when possible to minimize the number of Closing Rods in the system.



VIEW REFLECTS CLOSING ROD INSTALLATION ON BOTTOM SIDE OF CONVEYOR. SAME PROCESS EMPLOYED ON TOP SIDE.  
NOTE: VERIFY CLOSING ROD ORIENTATION IS CORRECT

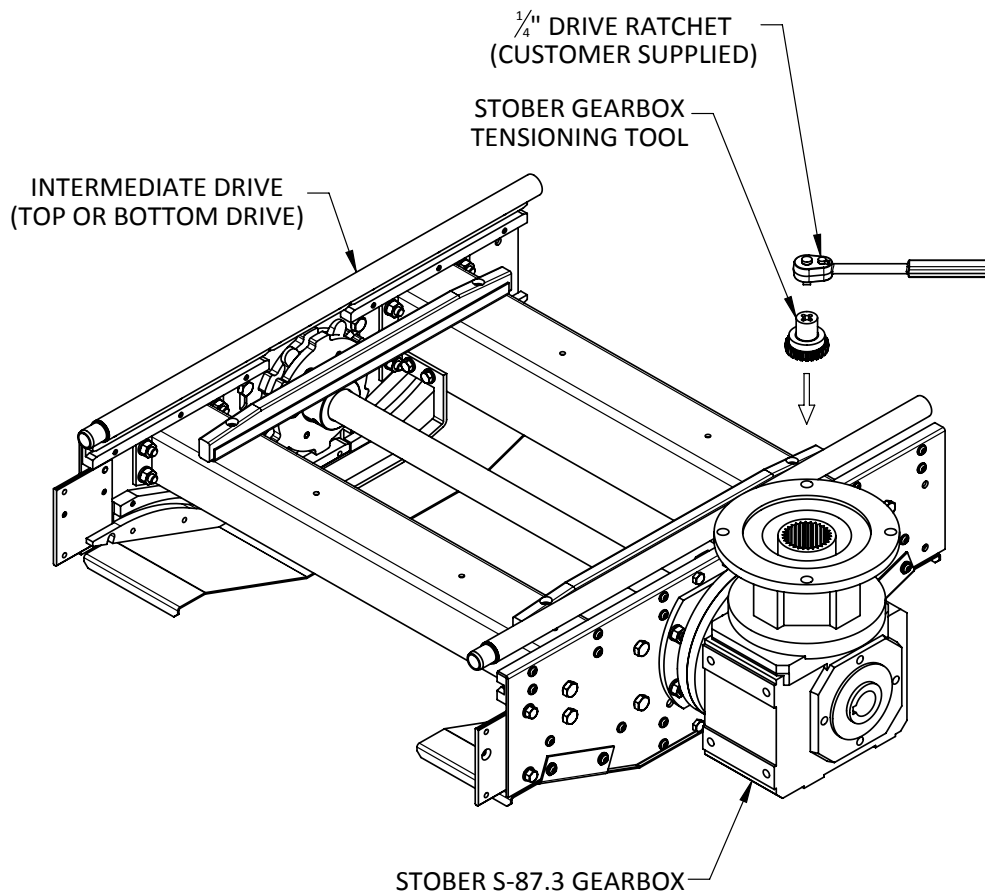
## Section 3

### Moving Chain Slack

24. The following view illustrates the use of the Stober Gearbox Tensioning Tool (purchased separately) inserted into the Stober Gearbox to move chain through the system. This is the safest method to move chain slack.

Start at the second “Bottom Drive” after the main driving unit and begin moving slack toward the next “Bottom Drive” or end of the conveyor. After the end is reached, move to the “Top Drive” closest to the end unit and continue moving slack forward to the main driving unit.

Remove excess chain at the tensioning unit and join with Closing Rod and Security Elements.



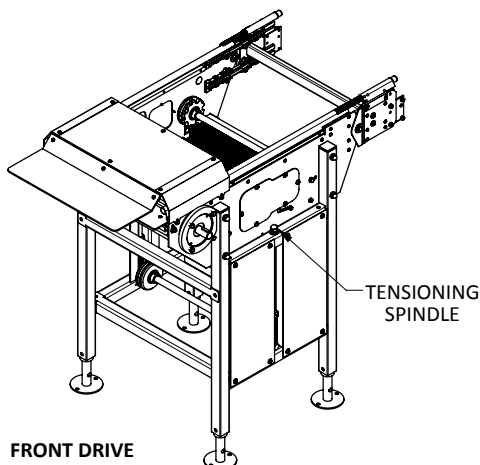
**NOTE: USE CAUTION WHEN APPLYING TENSION TO THE CHAIN, OVER TENSIONING MAY DAMAGE CHAIN AND/OR CLOSING RODS. NEVER RELEASE RATCHET UNDER TENSION, HOLD AND ALLOW ROTATION UNTIL TENSION IS RELEASED.**

## Locating Tensioner Components

25. Proper chain tension is crucial to system performance and longevity. The following view details the components with integrated tensioning.

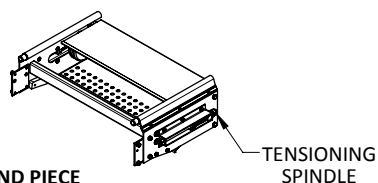
Refer to the layout drawing provided for the correct tensioning unit and its placement within your system. Before installing chain, retract all tensioners.

### COMPONENTS INCLUDING TENSIONING



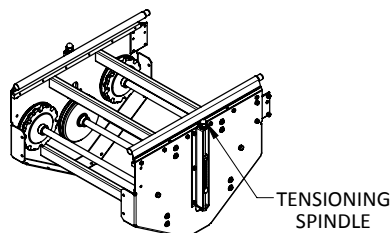
**FRONT DRIVE**

- USED AS MAIN DRIVE FOR CONVEYOR
- INTEGRATED TENSIONER
- ANY LENGTH SYSTEM



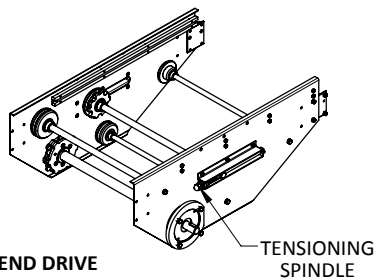
**END PIECE**

- USED IN CONJUNCTION WITH MAIN DRIVE UNITS OTHER THAN FRONT DRIVE
- LOCATED AT THE END OF CONVEYOR
- SHORT LENGTH SYSTEM



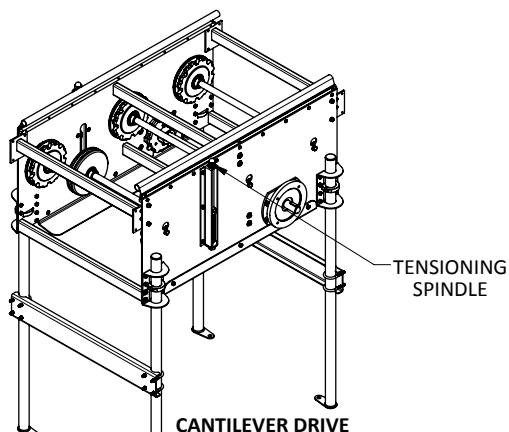
**BOLT-IN TENSIONER**

- USED IN CONJUNCTION WITH MAIN DRIVE UNITS OTHER THAN FRONT DRIVE
- LOCATED NEAR MAIN DRIVE UNIT
- ANY LENGTH SYSTEM



**END DRIVE**

- LOCATED AT THE END OF CONVEYOR
- INTEGRATED TENSIONER
- ANY LENGTH SYSTEM



**CANTILEVER DRIVE**

- USED AS MAIN DRIVE FOR CONVEYOR
- INTEGRATED TENSIONER
- ANY LENGTH SYSTEM

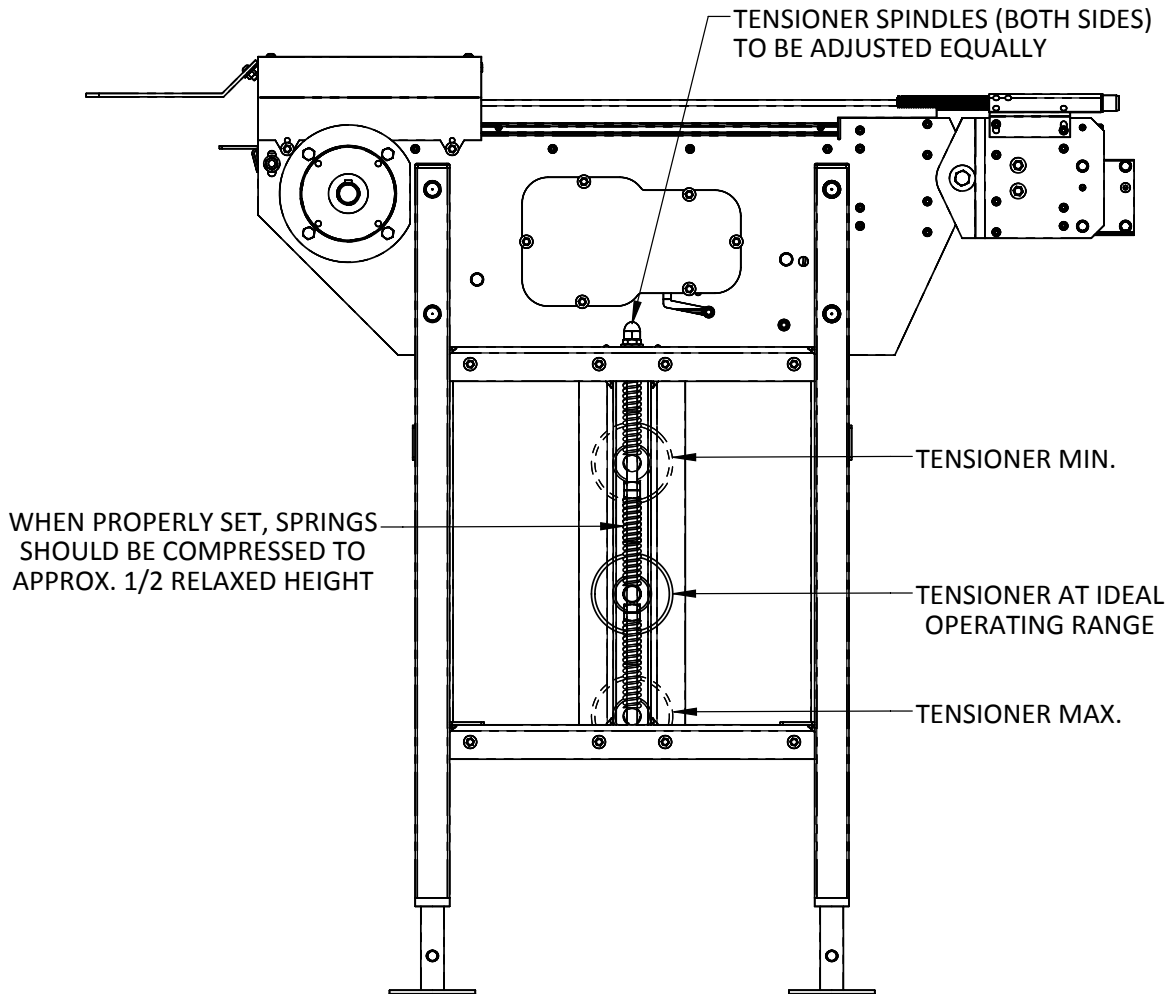
## Section 3

### Setting Chain Tension

26. After completing chain installation, apply tension to remove any slack from the system. The following view illustrates the proper adjustment and working location of tensioners within the system.

The correct amount of chain will allow the tensioner to work somewhere near the midpoint of its travel. Adjust the length of chain accordingly.

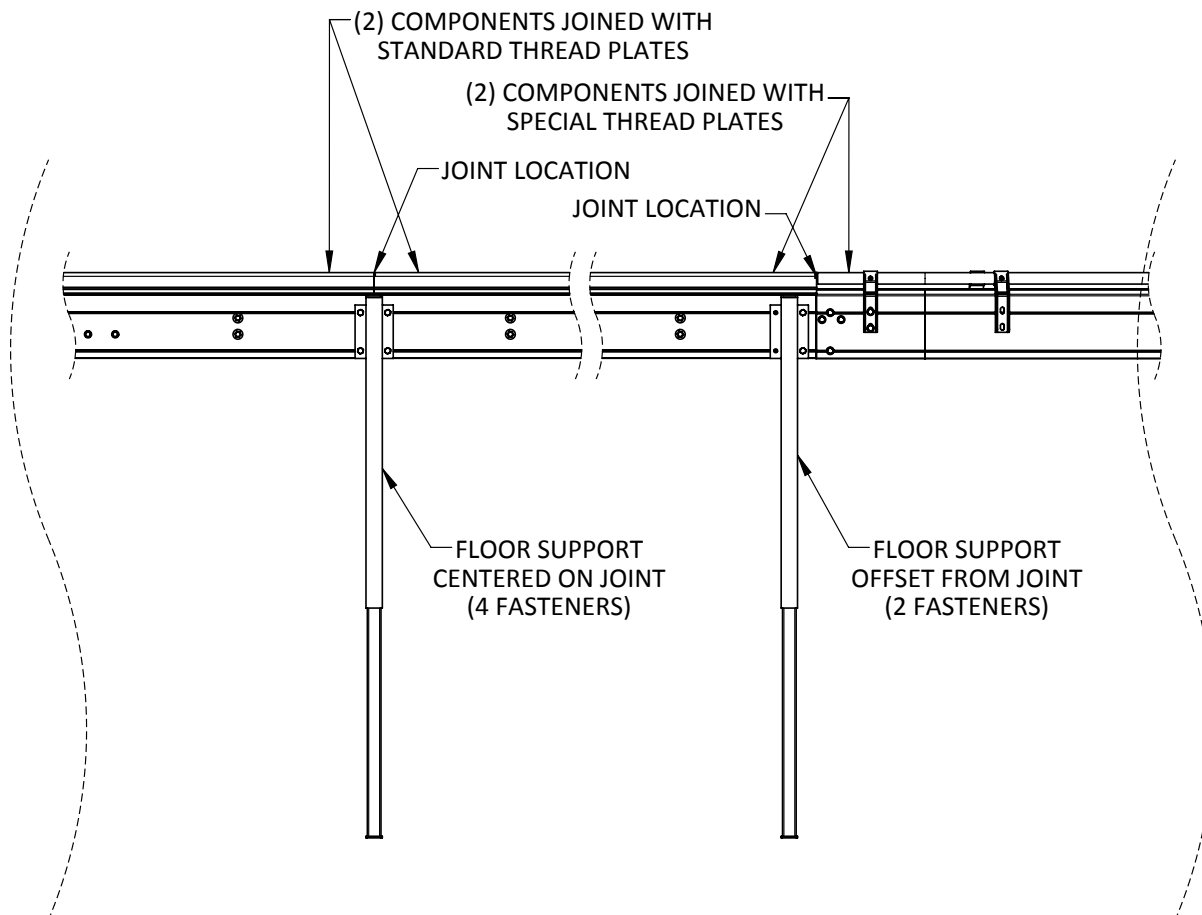
At initial startup, inspect chain tension at regular intervals as slack may move through the system and gather at this location. Remove excess chain as needed to maintain the correct operating location.



## Floor Support Installation

### Floor Supports at Standard Locations

27. Some type of support is intended at each joint location. The following view illustrates the installation of Floor Supports at standard locations where mounting holes exist.

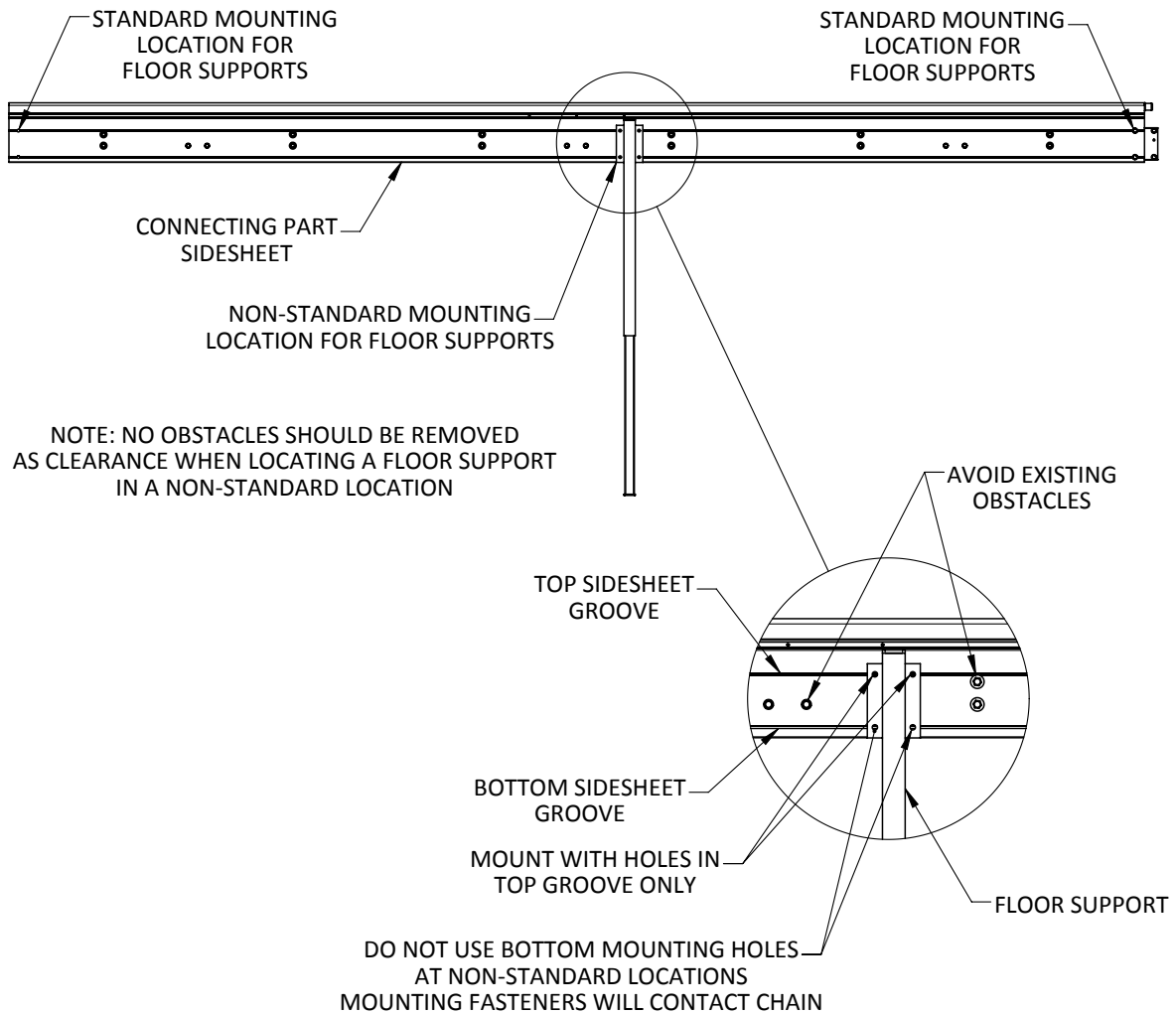


## Section 3

### Floor Supports at Non-standard Locations

28. The following view illustrates the procedure for installing Floor Supports at a non-standard location.

Note: See below regarding the placement of drilled holes when locating Floor Supports.



## Suspending Components

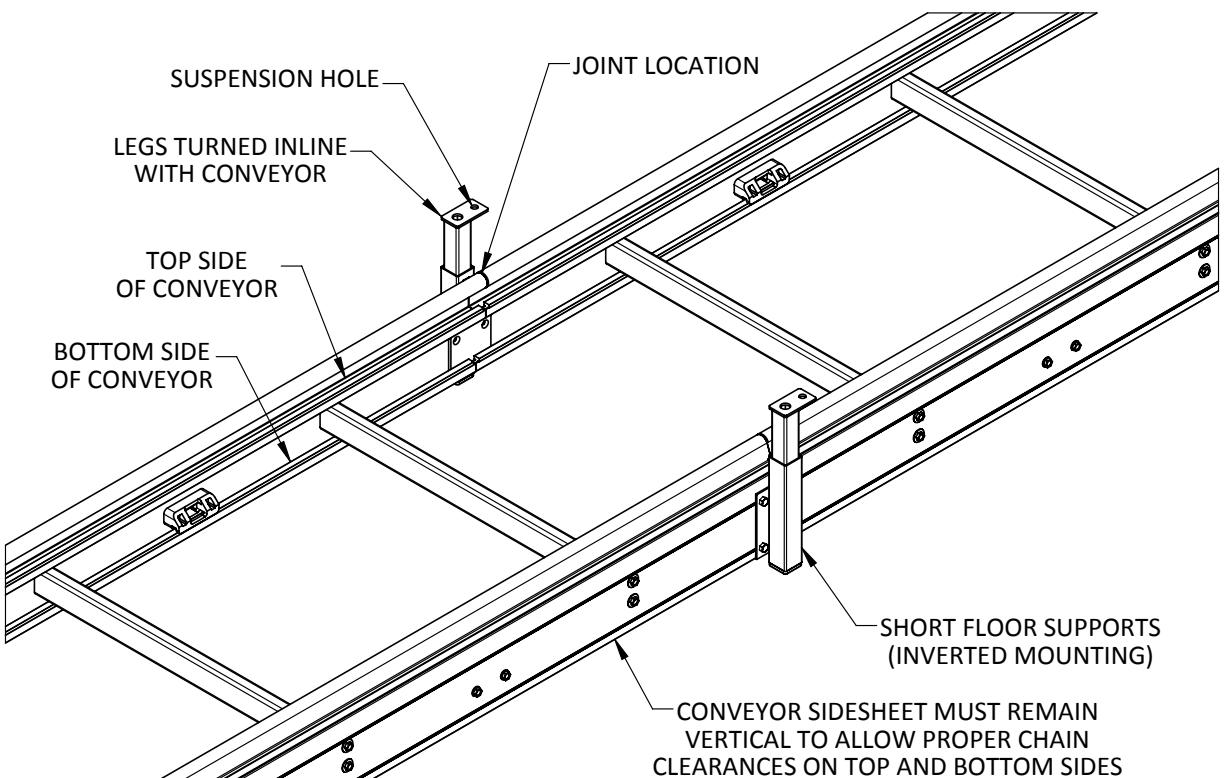
29. The following view illustrates suspending components using inverted Short Floor Supports.

It is the customer's responsibility to suspend components in a manner that satisfies all building and safety codes. Vertical suspension drops must be made for each joint location where components connect.

Turn legs in-line with Conveyor travel to prevent side loading the sidesheets of the conveyor. Side loading these components could result in binding the chain on the top side of the conveyor or the ability of the chain to fall out of the bottom side of the conveyor.

When properly suspended, conveyor will not sway when system is in operation or under load. If excessive movement is observed, action should be taken to improve suspension practices.

Suspend with threaded rod, washers, and nuts from overhead structure. Do not use chain and hooks for suspension components.

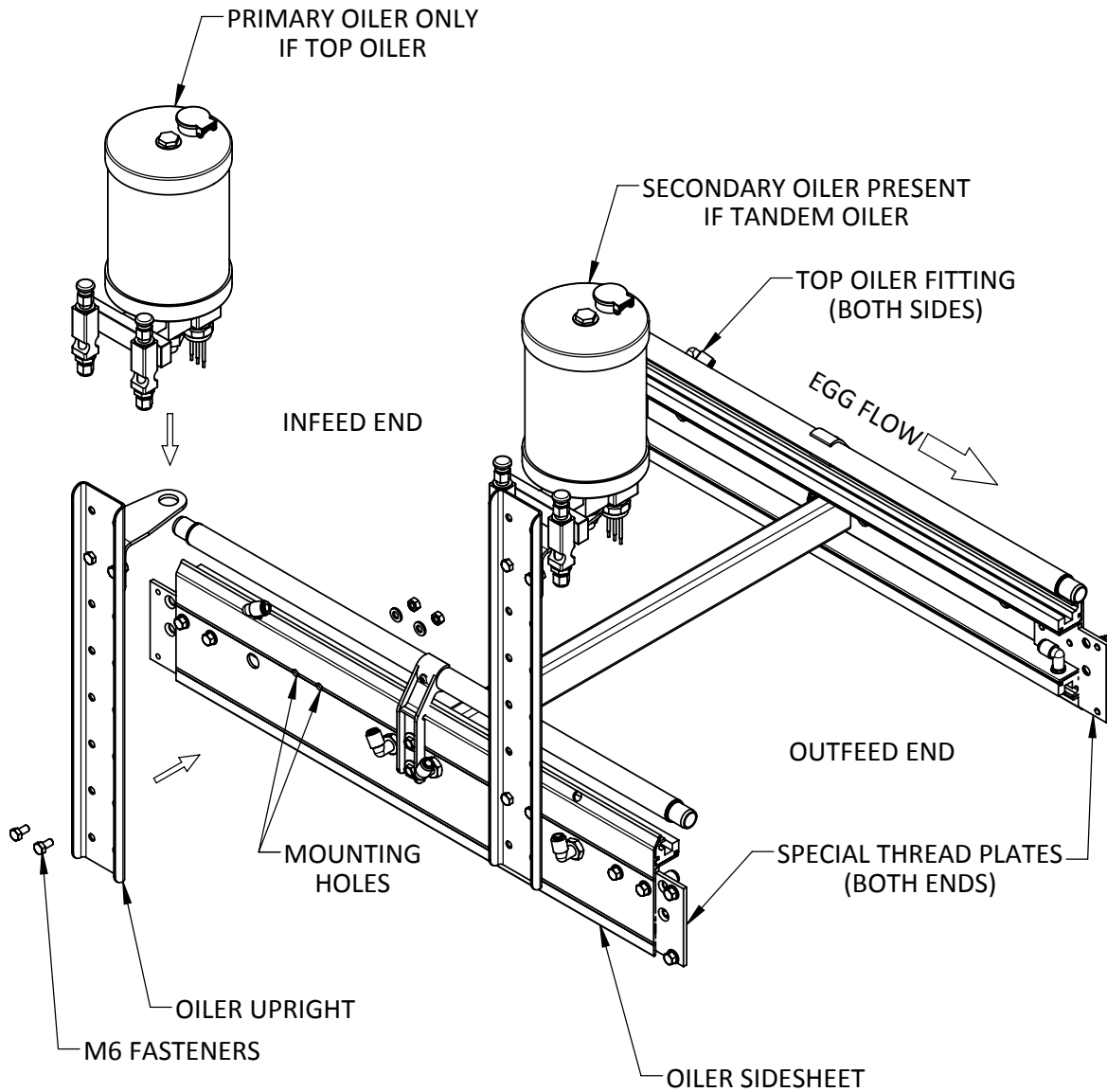


## Section 3

# Drip Oiler Installation

## Drip Oiler Assembly

30. Top and Tandem Drip Oiler are shipped from the factory partially assembled. The following view illustrates the assembly process for either Top or Tandem assemblies.

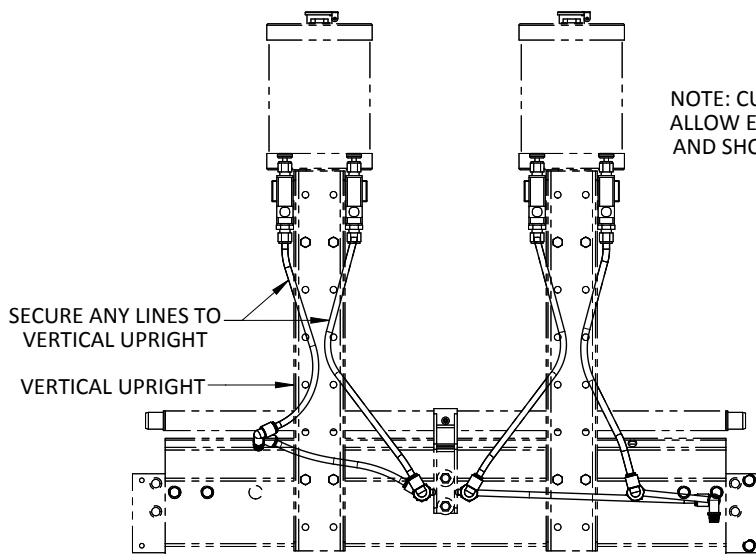
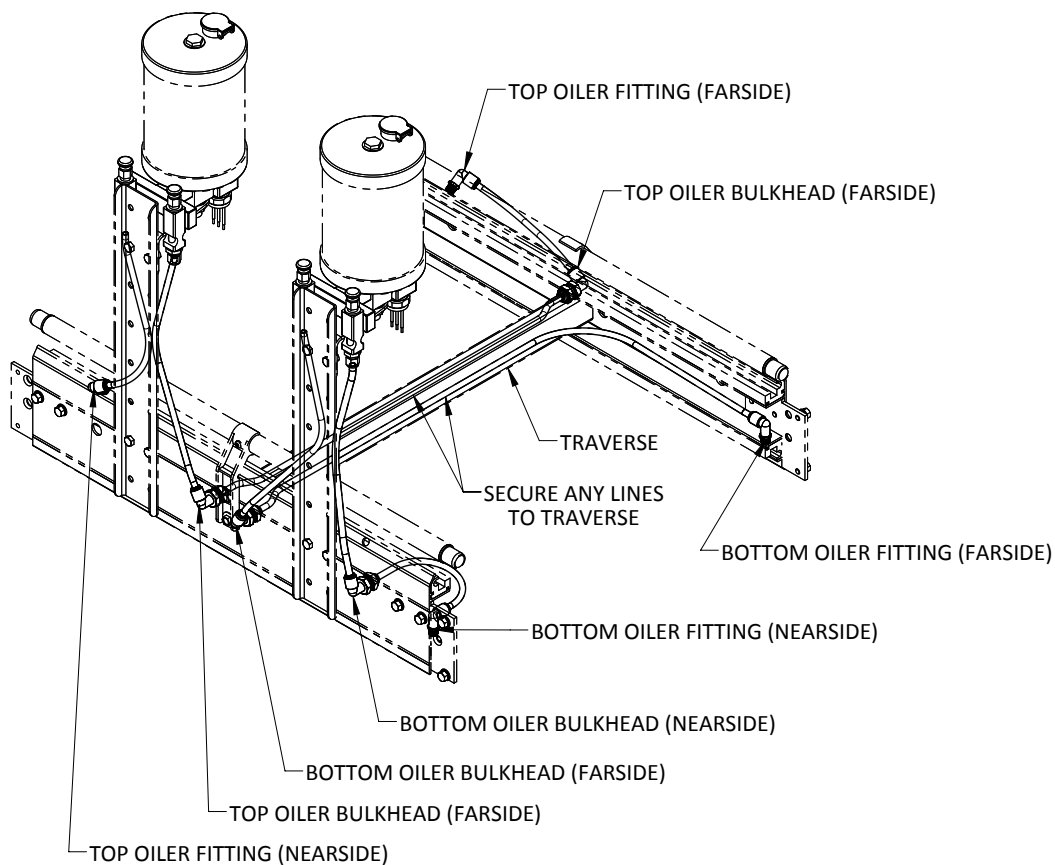




## Routing Supply Lines

31. Once assembled, cut and route the required supply lines for either Top or Tandem oiling.

Cuts should be as clean and straight as possible to prevent leaks. Secure tubing as needed.



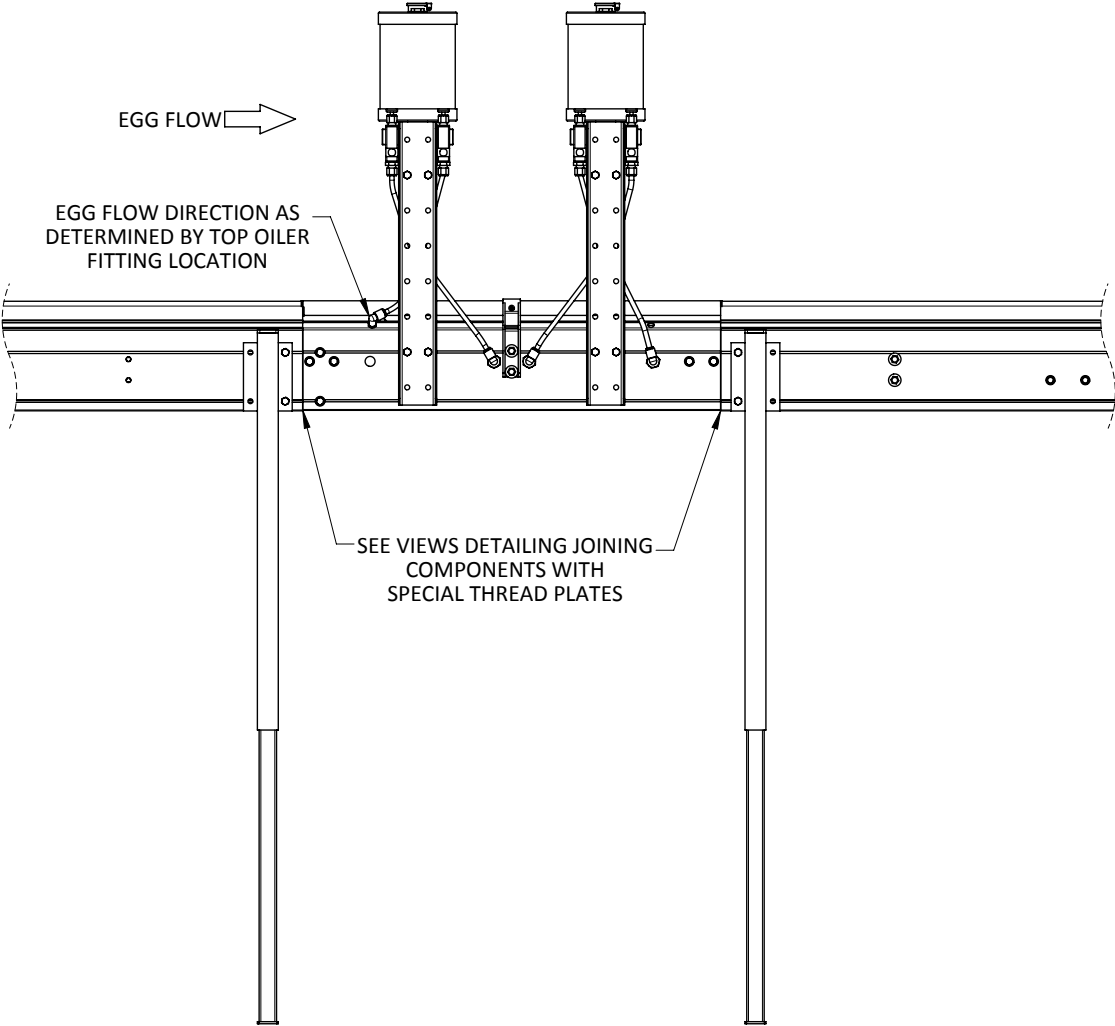
NOTE: CUT LENGTHS OF TUBING SHOULD ALLOW ENOUGH SLACK TO SECURE LINES AND SHOULD PREVENT KINKS OR STRESS ON THE FITTINGS

# Section 3

## Correct Orientation for Installation

32. Top and Tandem Drip Oilers are directional component and must be installed accordingly.

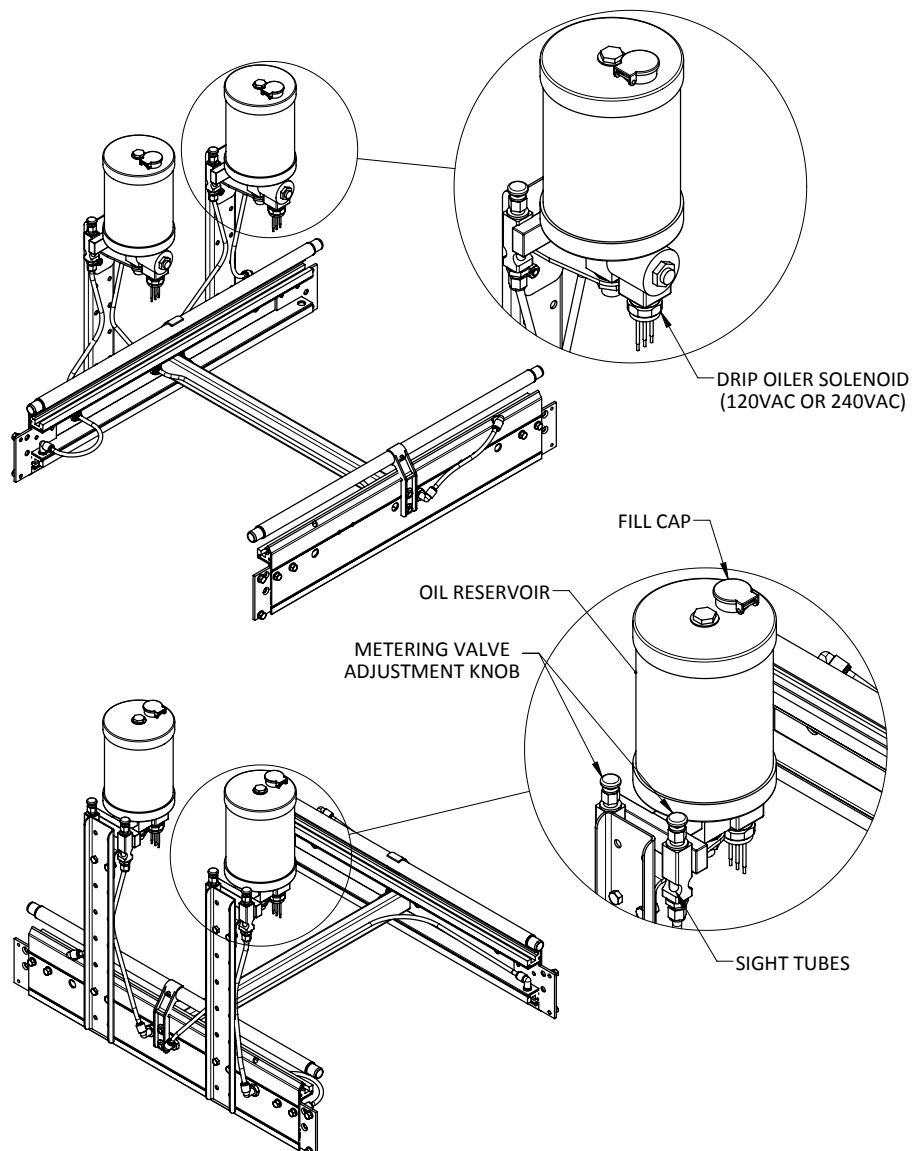
The following view illustrates the installation of Top or Tandem Oilers in the correct direction.



## Drip Oiler Wiring and Adjustment

33. To perform correctly, any Drip Oiler Solenoid must be wired into the start/stop circuit of the conveyor. This will prevent the continued gravity feed of lubricant onto the conveyor when motion stops and allow flow to the conveyor when motion begins again.
34. Using the Metering Valve Adjustment Knobs, set the flow for adequate chain lubrication (see Break-in section for initial flow rates). Oil flow should be set to apply adequate lubrication to allow the chain to move smoothly without surging, but not overflow the conveyor and run to the floor or other equipment under the oiling area.

Improper electrical installation or flow adjustment may result in excessive usage or starvation of lubricant to the system leading to chain surging, increased current load on motors, or damage to chain and components in the system.



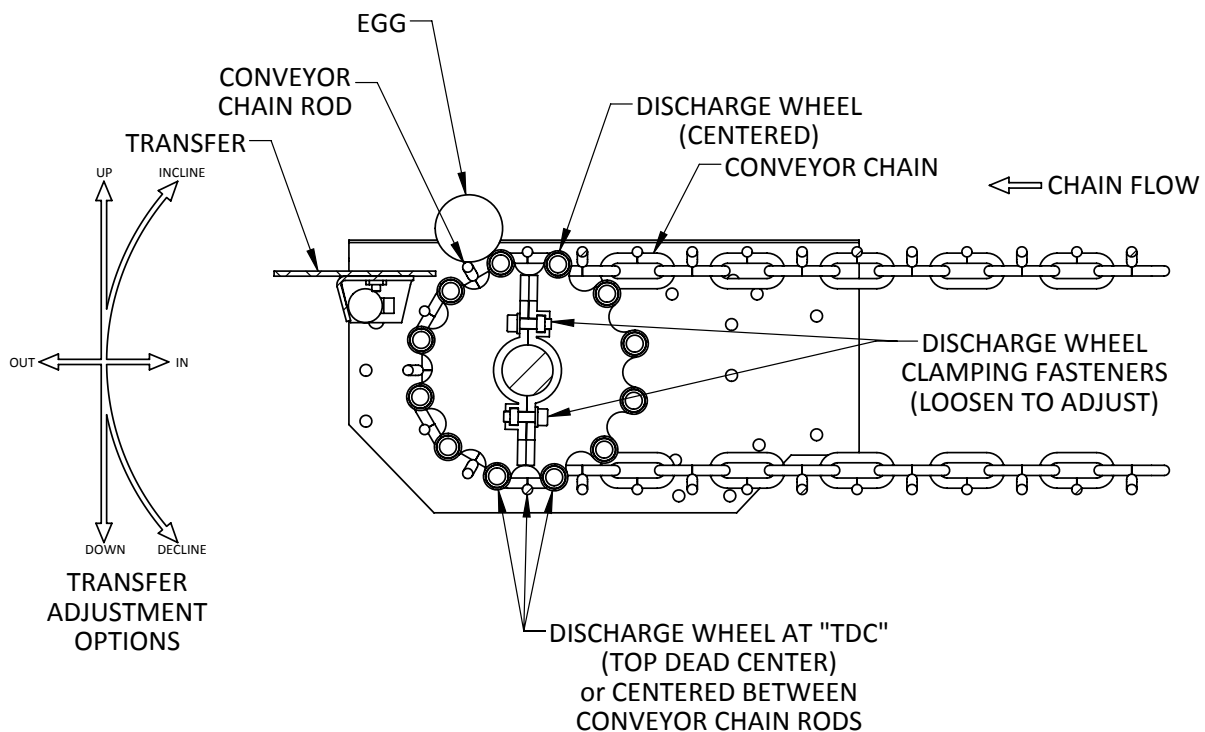
## Section 3

### Initial Setting of Discharge Wheels and Transfers

35. Once chain installation is complete and all chain sections have been joined, Discharge Wheels should be set at Top Dead Center (TDC) relative to the Drive Sprockets.

The following view illustrates the positioning of the Discharge Wheel at TDC. Product (egg) is shown as reference only, the purpose of the view is to detail a safe starting location for the Discharge Wheel prior to startup.

36. Loosen the Clamping Fasteners on both ends of the Discharge Wheel and rotate around the Drive Shaft until approx. centered as shown. Tighten fasteners and repeat process as needed for all Discharge Wheels.
37. Install any Transfer previously removed. As with the Discharge Wheel, final adjustments will be made after installation is complete. Temporarily set the Transfer leaving the widest possible gap for chain clearance.

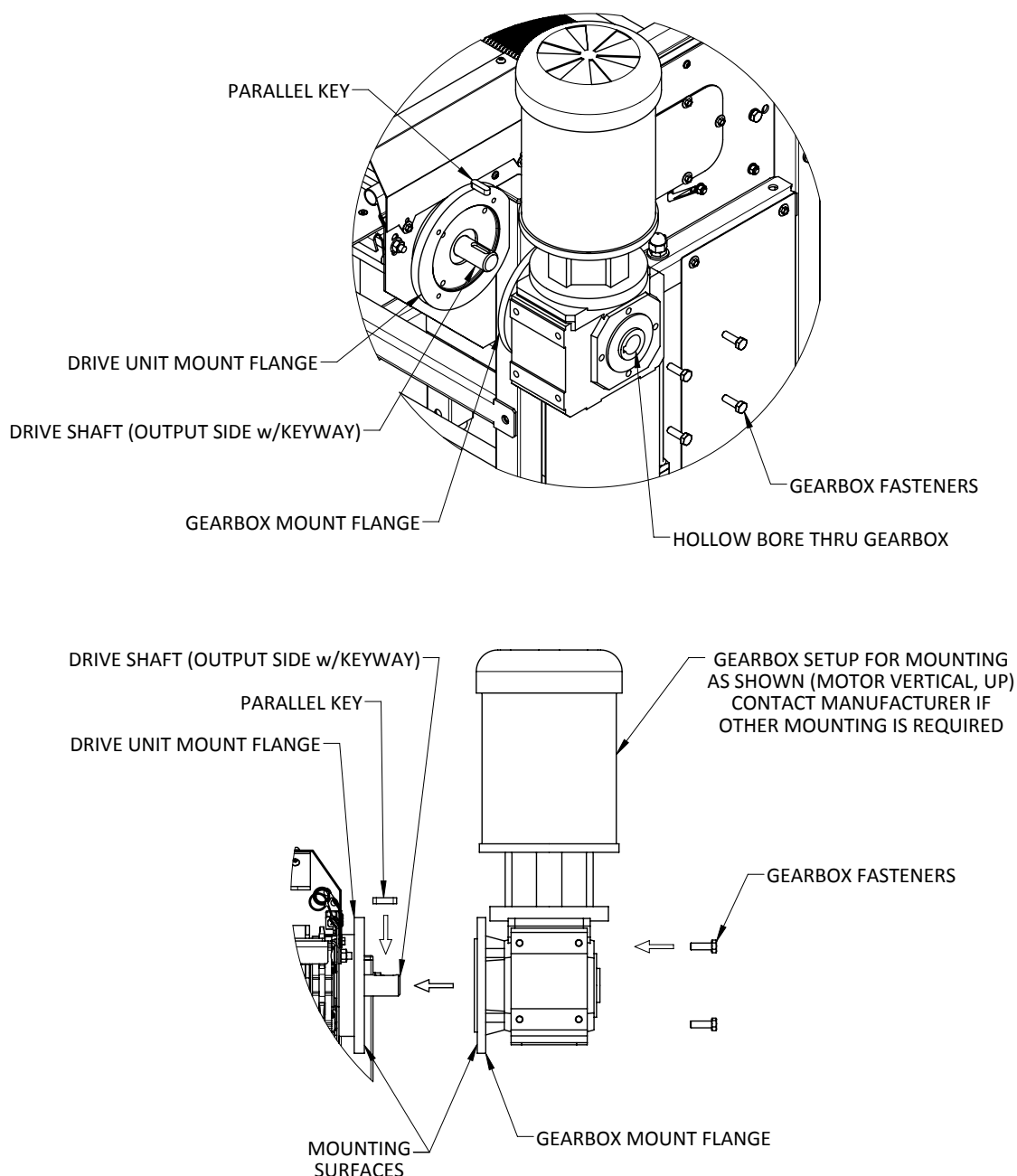


## Attaching Gearboxes and Motors

38. Once chain installation is complete, attach Gearboxes and Motors to the respective components. The following view illustrates typical gearbox and motor assembly onto drive components.

Ensure the correct motor horsepower is paired with the appropriate drive units and all Parallel Keys are installed on Drive Shaft Outputs.

Note: Verify rotation of motors before installing onto conveyor. Failure to do so will result in damage to chain and conveyor system.



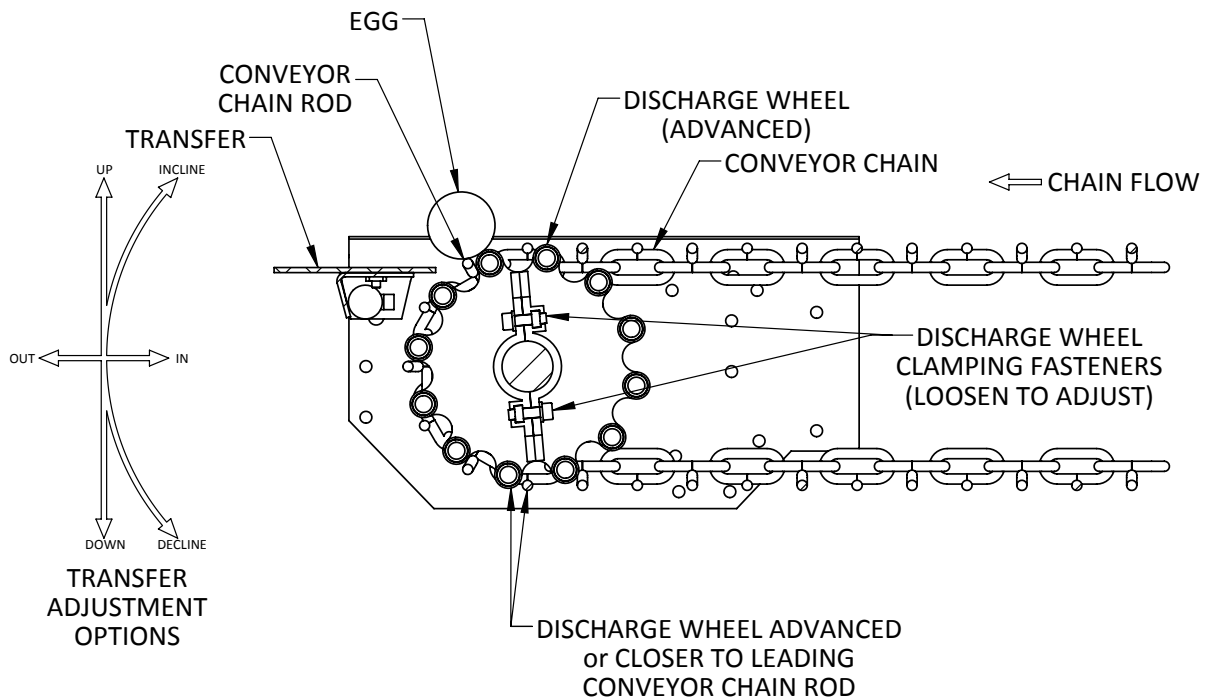
## Section 3

### Final Setting of Discharge Wheels and Transfers

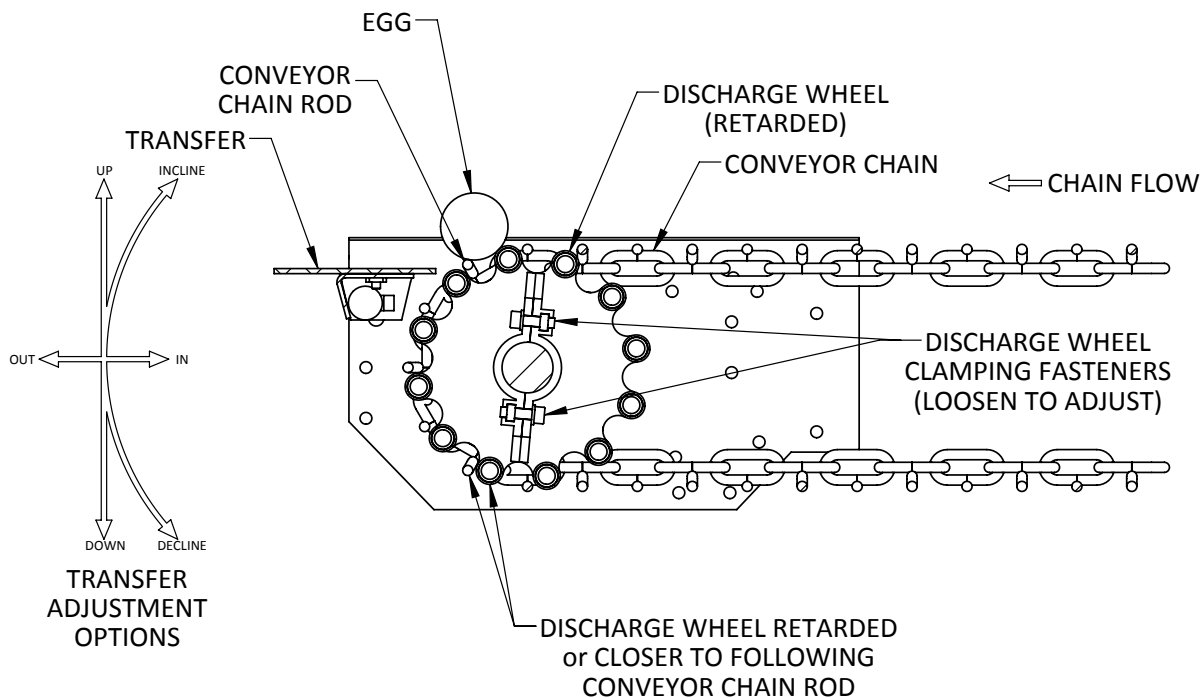
39. After the conveyor has been powered and run at least one full revolution of chain, set the final gap for Transfers and the desired Discharge.

Transfers are set to customer preference. These views demonstrate the functionality of the components not a recommendation by Lubing Systems.

40. Advancing the Discharge Wheel as shown causes the egg to ride higher in the cradle formed between the Discharge Wheel Tube and Conveyor Chain Rod.



41. Retarding the Discharge Wheel as shown causes the egg to ride lower in the cradle formed between the Discharge Wheel Tube and Conveyor Chain Rod.



## Section 3

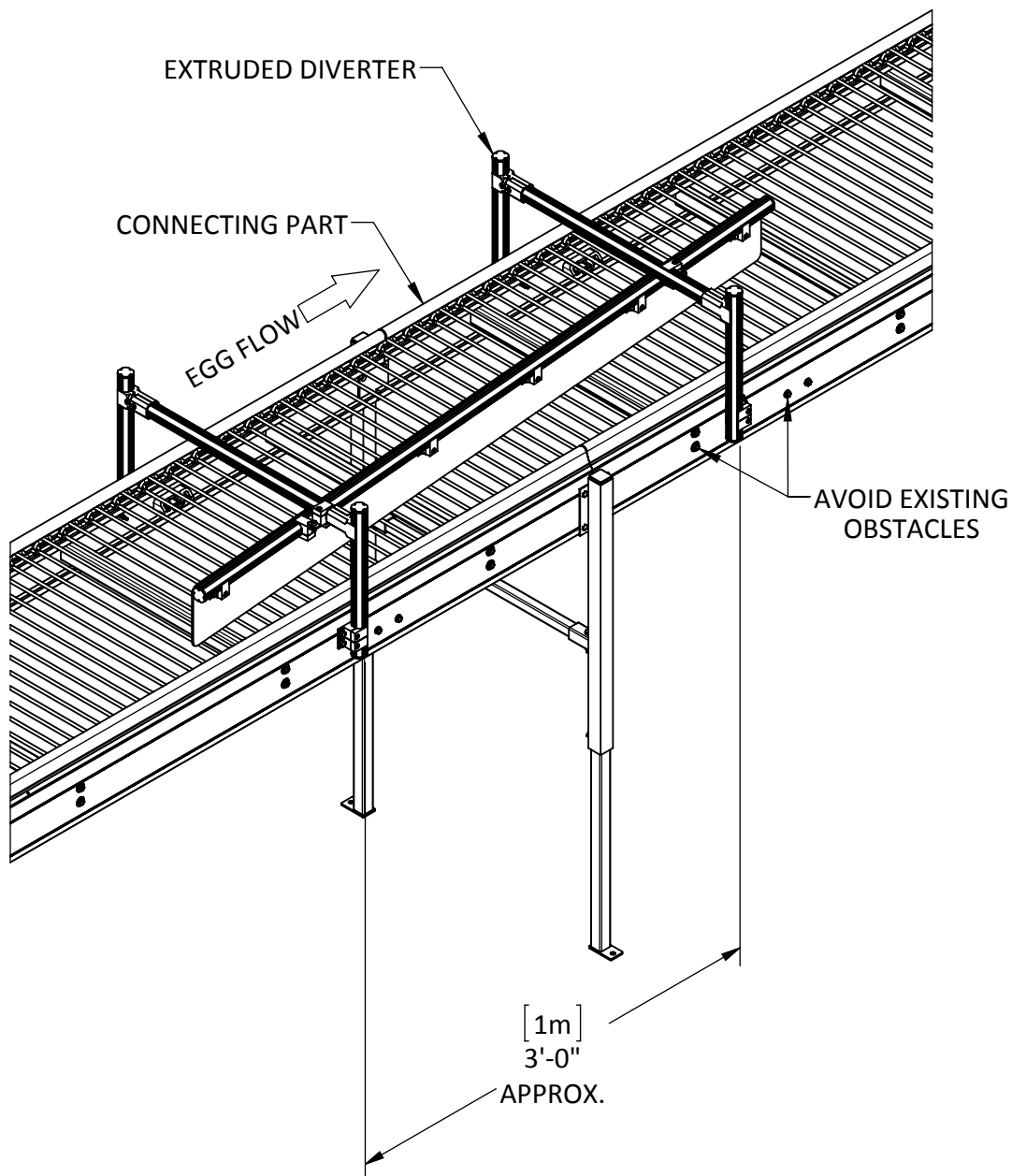
### Diverting Eggs

#### Extruded Diverter Installation

42. The following views illustrate the installation of the Extruded Diverter if needed for the system. Use the view below to determine the proper location for this component.

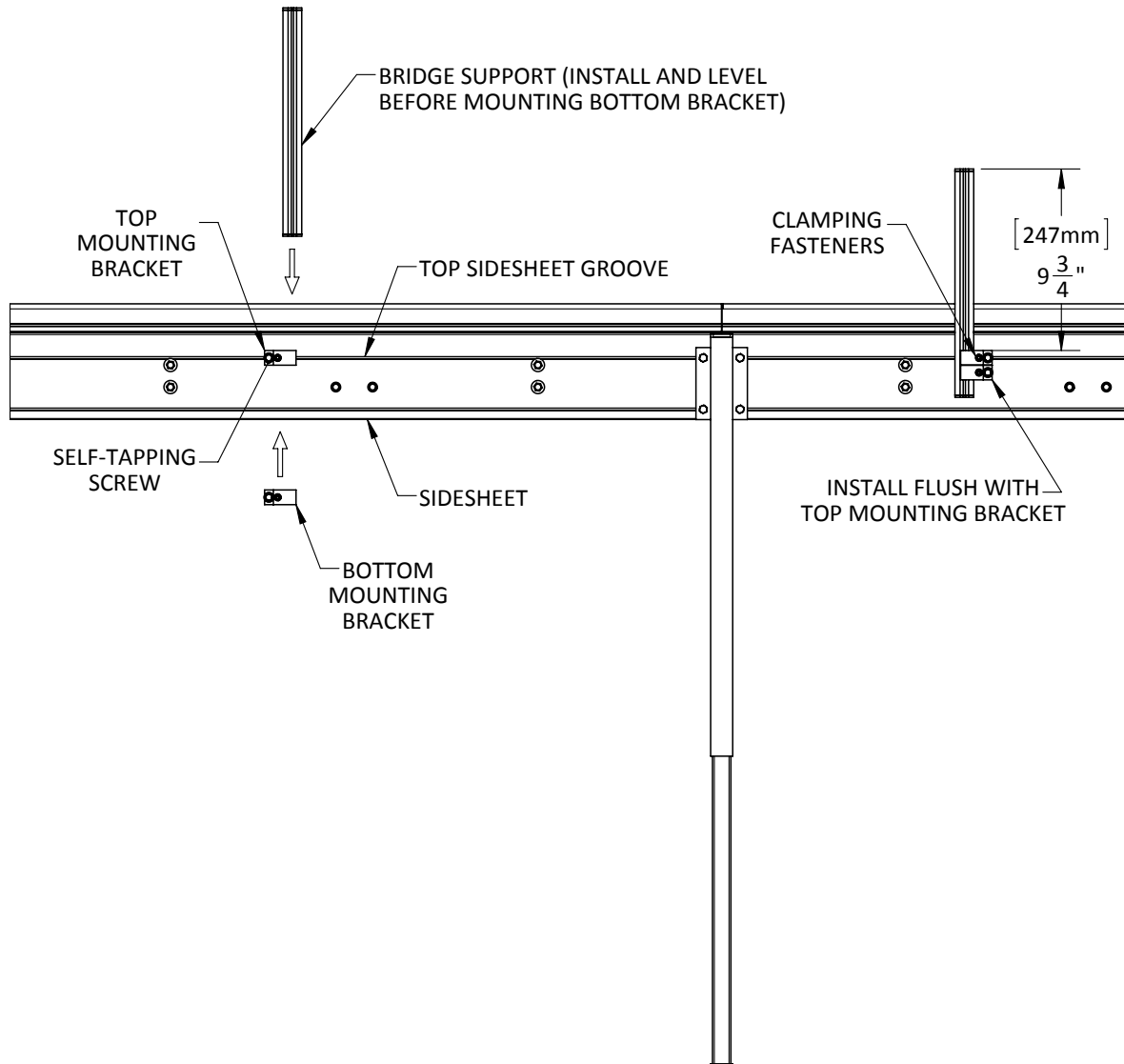
Diverter angles should be set at the most gradual angle possible to move eggs the given distance across the conveyor. If additional movement is required, install multiple Diverters.

Note: Never exceed 30 degrees of diverter angle.





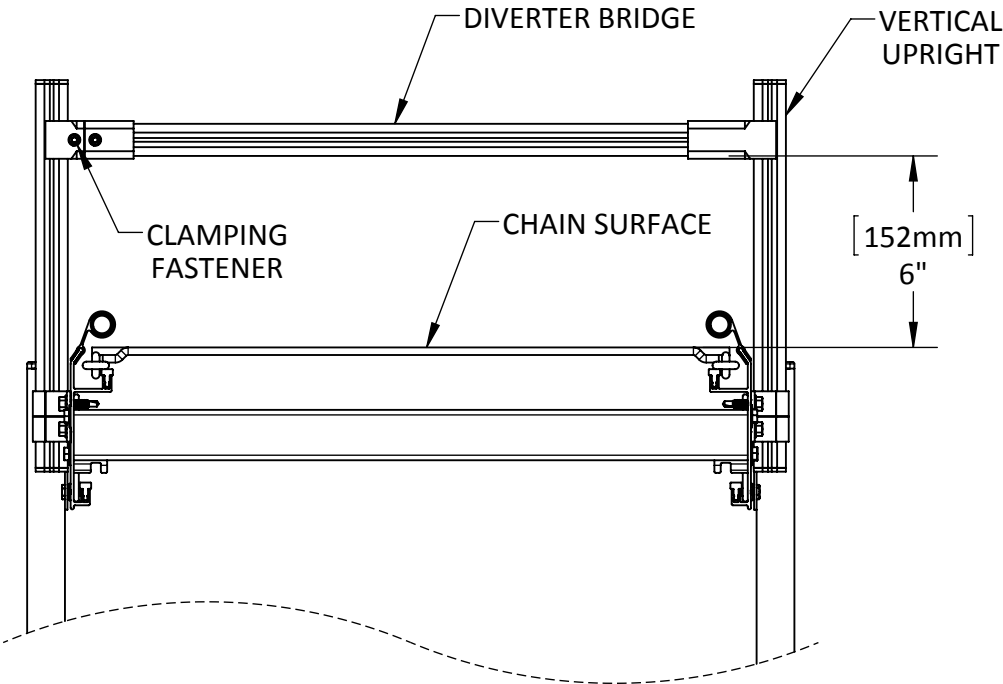
43. Mount the Top Mounting Brackets with the provided self-tapping screws on both sides of the conveyor at the specified distance apart (shown previously).
44. Install the Bridge Support to the height shown and secure with the Clamping Fasteners.
45. Level the Bridge Support and install the Bottom Mounting Brackets as shown.



# Section 3

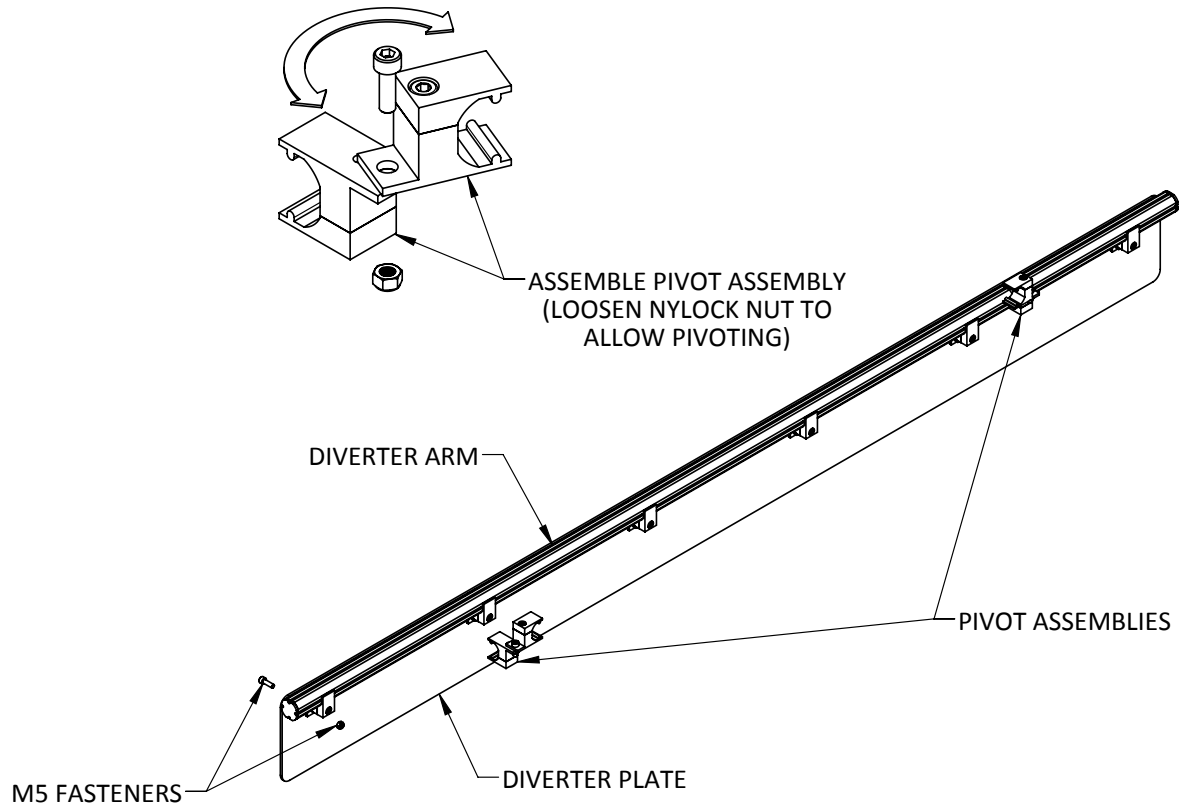
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46. Install the Diverter Bridge to the specified height and secure with the Clamping Fasteners.



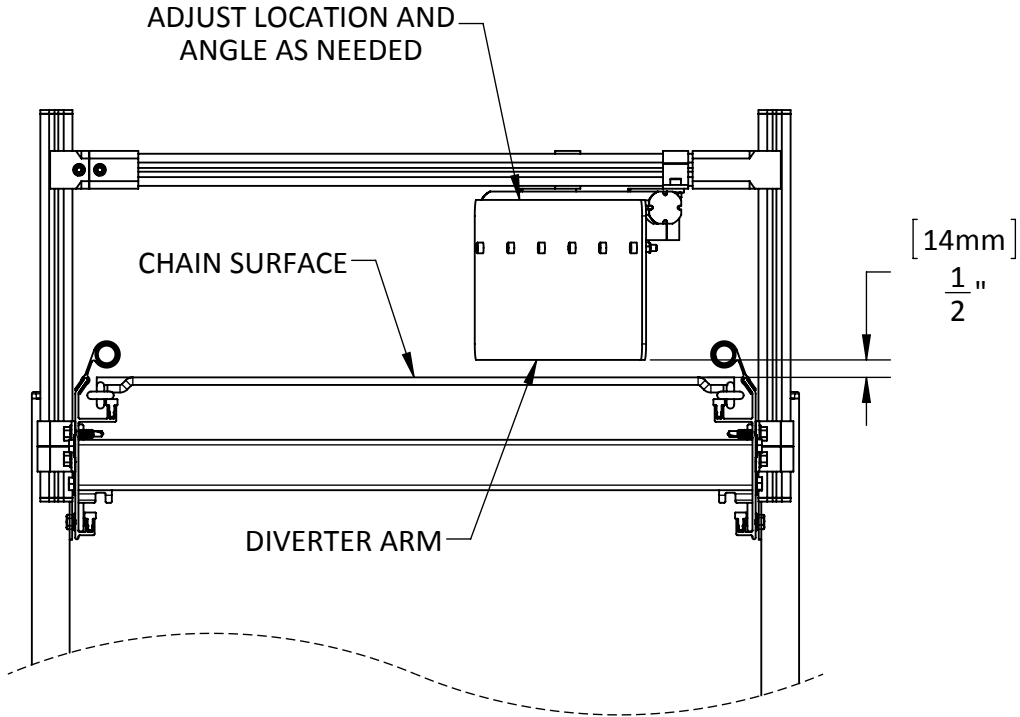
47. Assemble the Pivot Assemblies and Diverter Arm as shown.

The Pivot Assemblies must support the Diverter Arm and allow for pivoting movement.



# Section 3

48. Attach the Diverter Arm to the Diverter Bridge and verify clearance as shown.

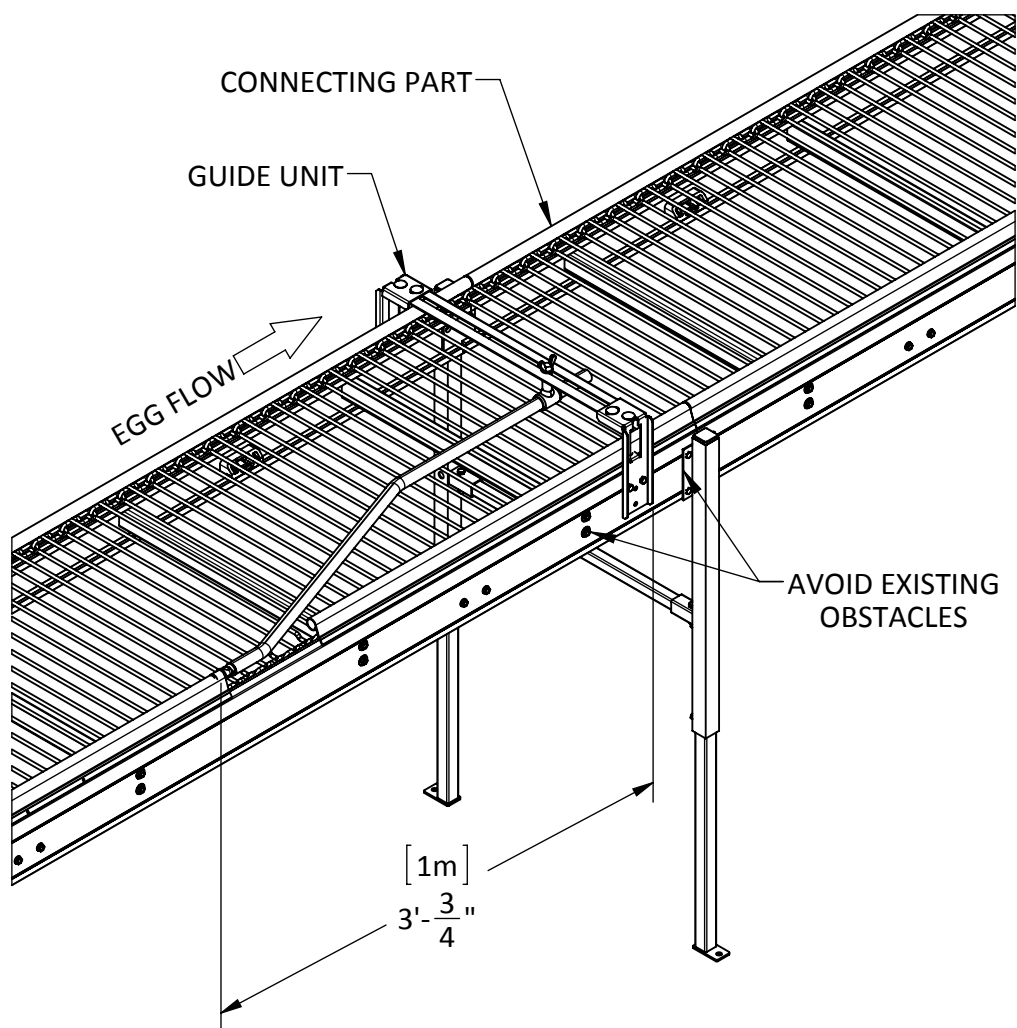


## Guide Unit Installation

The following views illustrate the installation of the Guide Unit if needed for the system. Use the view below to determine the proper location for this component.

Guide Units are intended to divert the egg path at Collector locations.

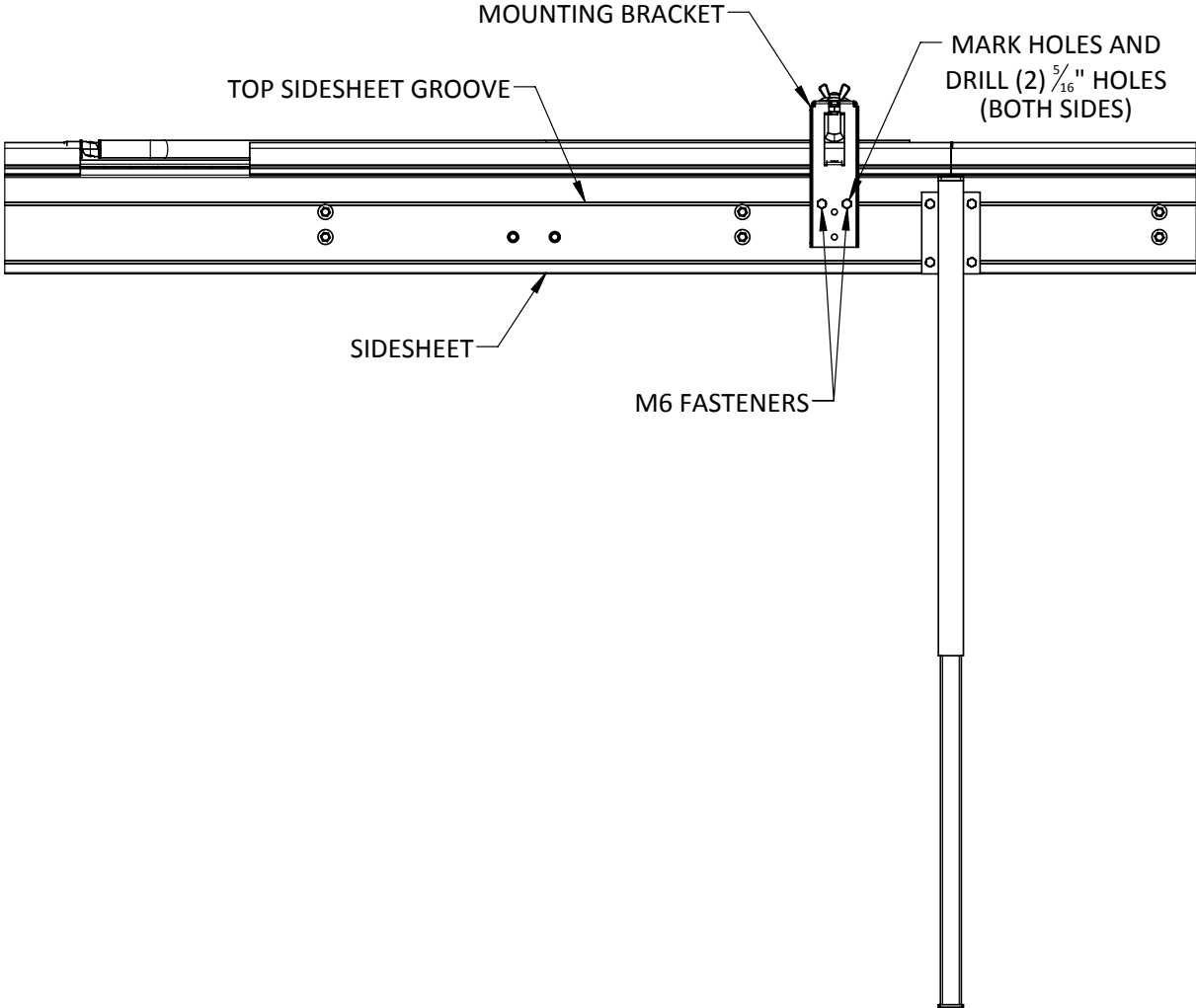
Note: Never exceed 30 degrees of diverter angle.



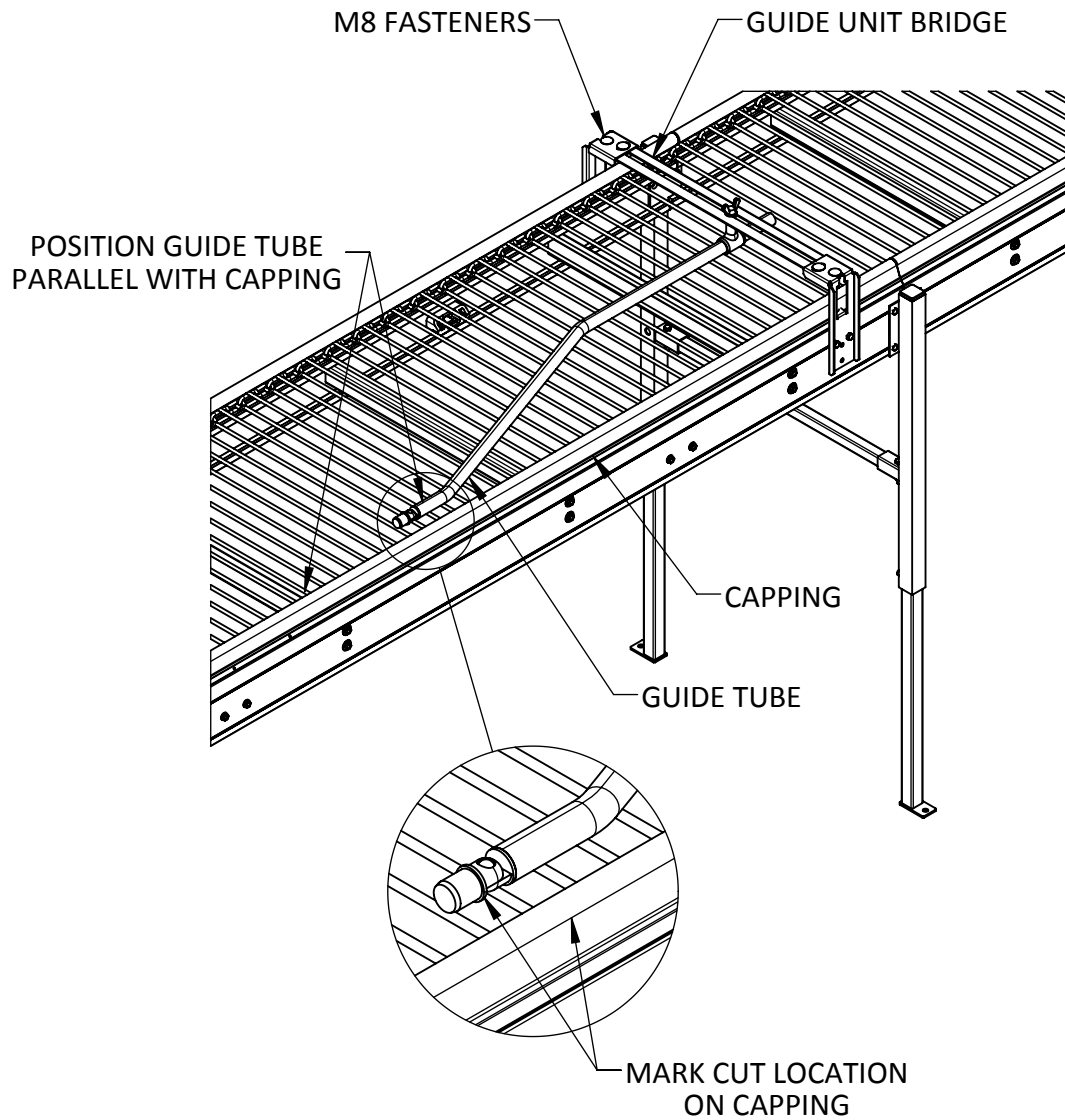
# Section 3

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49. Once a location is chosen, use the Top Sidesheet Groove as reference when marking and drilling the holes required for the Mounting Brackets. Install the provided fasteners and level.



50. Attached the Guide Unit Bridge with the provided fasteners.
51. Loosely attach the Guide Tube and position parallel with the Capping along the edge of the conveyor.
52. Mark the approx. cut location on the Capping.

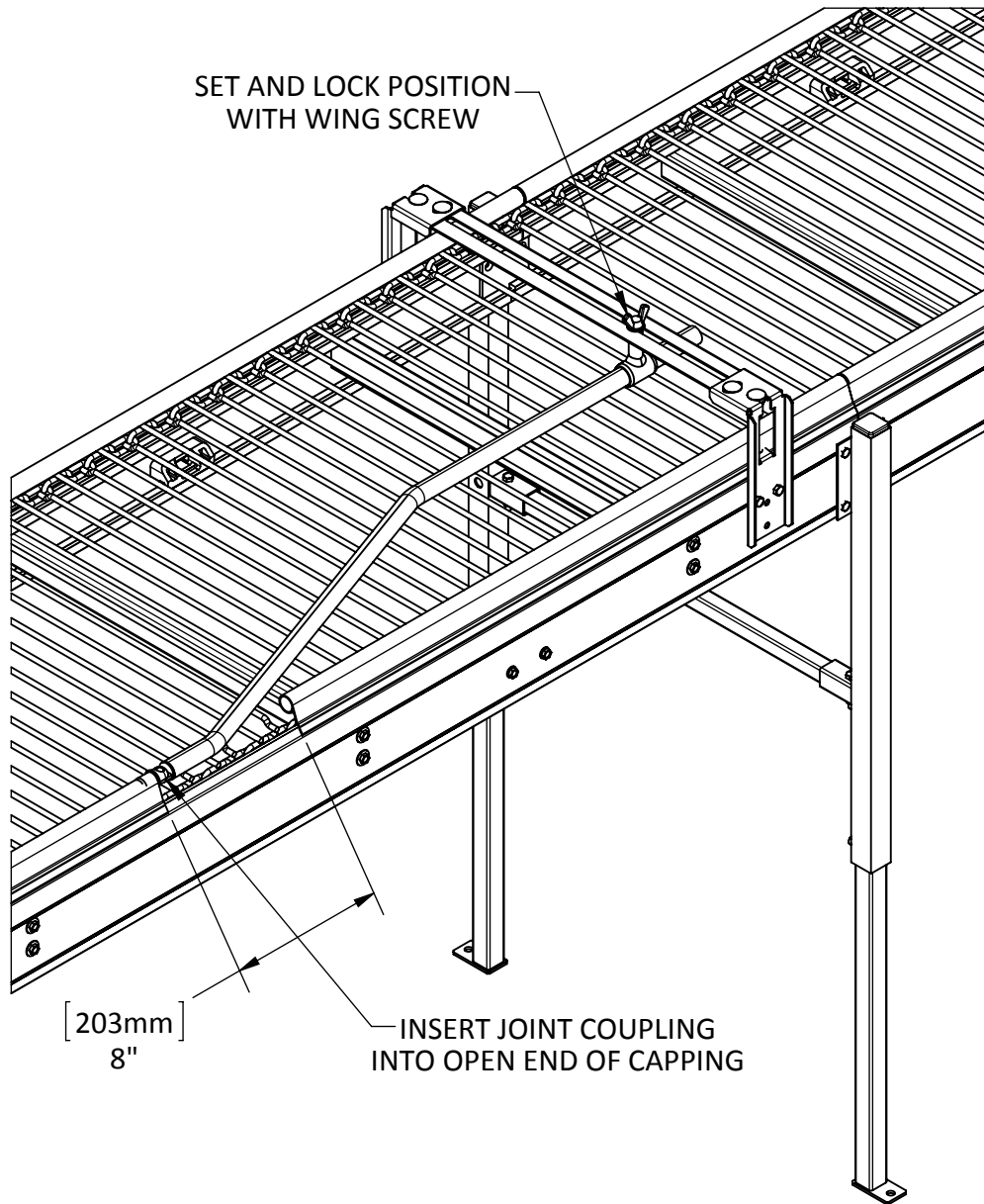


## Section 3

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53. As shown below, cut and remove a section of the Capping. Insert the Joint Coupling into the open end to create a smooth transition for the eggs onto the Guide Tube.

54. Set the desired angle (less than 30 degrees) and secure.





### Final Assembly Considerations

55. Any system option(s) provided by Lubing Systems that require fastening or securing to the conveyor will be covered in the respective manuals. These manuals detail areas of attachment that will not interfere with the chain path, other moving components, or cause stresses on components that may result in damage to the system.

Note: Auxiliary components or systems not provided by Lubing Systems and intended for fastening or securing to the conveyor will be installed at the customer's own risk.

56. Electrical systems must be installed according to all state and local codes applicable to the installation site.

Note: Lubing Systems makes no claims for safety systems and their employment within each installation. It is the customer's responsibility to ensure safety systems are in place and operational.

Note: All drives within the system must start/stop together to avoid damage to the system. Verify these operations before attempting to start-up the system.

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# SECTION 4 START-UP AND TROUBLESHOOTING

## System Start-up

### Personal and Equipment Safety

1. Be sure to wear all necessary *Personal Protective Equipment* (PPE) prior to beginning any work.
2. Always observe all *Lockout-Tagout* procedures prior to performing any work on the system.
3. All safety systems should be tested and verified for correct operation before starting the system.
4. All electrical systems should be tested and verified for correct operation before starting the system.

### Verifying Installation

1. Verify the installation to the provided layout. Communicate any discrepancies with your Lubing representative before system start-up. Total lengths, component locations, elevations and/or offsets, should be confirmed before proceeding.
2. Ensure that gearbox rotation has been verified for each drive unit. Incorrect rotation will cause damage to the chain and possibly drive units or other components.
3. All components should be securely anchored into the appropriate position according to the layout drawing provided.
4. Pre-lubricating the chain is critical for start-up to prevent damage to the chain, drive units, and other components. Verify all Oilers are present, wired for correct operation, and adjusted to apply (1) one drop of oil onto the chain links every (10) ten seconds during the initial break-in of the conveyor.

Note: During *Start-up* and *Break-In*, oil may be present under the conveyor until the entire system has been lubricated. After *Break-In* is complete, adjust any Drip Oiler(s) according to the procedures outlined in *Section 3 Assembly and Installation*.

Note: Mineral Oil and other lubricants often found on egg complexes are not acceptable substitutions for proper chain path lubrication. The lubrication provided, as well as the manufacturer cross references provided, are specifically engineered for this application and contain the required additives for the conveyor system.

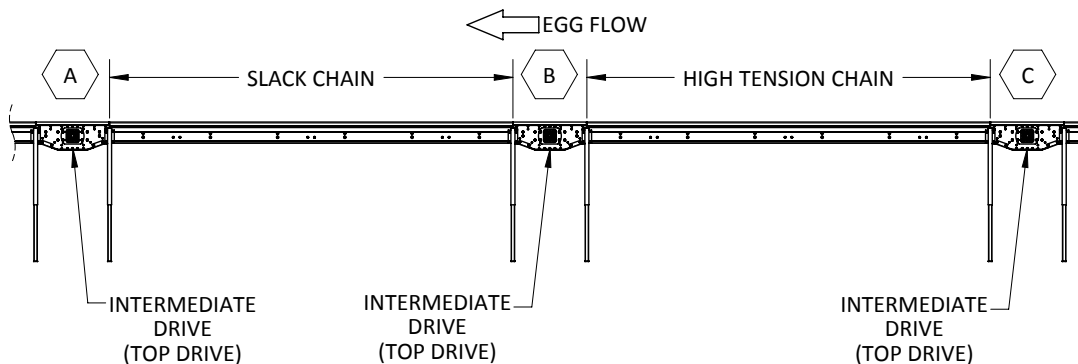
### Start-up Checklist

1. Review the *Final Assembly Considerations* in *Section 3* of this manual.
2. Inspect the entire length of conveyor for loose or foreign objects. Remove if present.
3. Stage personnel at intervals along the length of the system, especially at drive locations.
4. Ensure all slack has been removed from the system at the tensioners.
5. Verify the chain is oriented correctly and in its appropriate track on the top and bottom sides of the conveyor along the entire length.

## Section 4

### Jogging the Conveyor

1. With all personnel and objects clear of the conveyor, jog the system for (2) two seconds or approx. 12" of linear travel. Stop and inspect the entire system especially at drive locations for slack or high tension areas in the chain.
2. Slack chain at a particular drive location is usually indicative of an issue at the next drive. Verify the drive is operational and turning the correct direction (see view below).
3. High tensioned chain at a particular drive location is usually indicative of an issue at the previous drive. Verify the drive is operational and turning the correct direction (see view below).



NOTE: CHAIN ISSUES DEVELOPING AT OR NEAR A DRIVE LOCATION MAY INDICATE PROBLEMS AT ANOTHER DRIVE LOCATION EITHER UPSTREAM OR DOWNSTREAM

INSPECT THE NEAREST UPSTREAM OR DOWNSTREAM DRIVE OF THE SAME CONFIGURATION (TOP OR BOTTOM DRIVE)

THE VIEW ABOVE REFLECTS TOP DRIVES BUT REMAINS TRUE FOR BOTTOM DRIVE ISSUES

IN THE CASE OF SLACK CHAIN OBSERVED AT LOCATION "B", VERIFY DRIVE OPERATION AT LOCATION "A" (DOWNSTREAM RELATIVE TO EGG FLOW)

IN THE CASE OF HIGH TENSIONED CHAIN OBSERVED AT LOCATION "B", VERIFY DRIVE OPERATION AT LOCATION "C" (UPSTREAM RELATIVE TO EGG FLOW)

4. In the case of high tensioned chain, inspect the Closing Rods for damage. In most cases, a stretched Closing Rod will be missing Security Elements.
5. Verify the chain has remained in the appropriate track on the top and bottom sides of the conveyor.
6. Ensure any slack appearing in the conveyor is removed before starting again.
7. Repeat the above process until the conveyor has been advanced a total of (6) six seconds or approx. 36" of linear travel without slack or high tensioned chain being observed. A complete inspection should be made after each (2) two second or 12" linear travel segment.

### Initial Start-up

1. Select and mark a Closing Rod with tape or some high-visibility indicator to track through the system for (1) one complete revolution.
2. Position personnel at each drive location to observe chain behavior as the system runs. Personnel should be able to communicate any issues immediately so the system may be stopped if any need should arise.
3. Start the system and observe until the marked Closing Rod has made at least (1) one full circuit through the system.

Note: A revolution is complete when the marked Closing Rod is in the same location and on the same side (top or bottom of conveyor) as when start-up began.

### Commissioning the System

1. Once the single revolution of chain is successful, start the system and allow to run under observation.
2. Personnel should still be positioned at drive locations.
3. Inspect areas near tensioners and adjust accordingly. If the tensioner approaches maximum travel to eliminate slack, stop the conveyor and address the tensioner issue.

Retract the tensioner, remove a length of chain, and join with Closing Rods and Security Elements.

Pretension the chain according to the steps previously provided in *Section 3 Setting Chain Tension* and restart the system.

4. Refer to the *Troubleshooting* tables in this section for any start-up issues. Correct before proceeding.
5. Once the system is running consistently without slack or high tension issues and the chain is traveling through the entire system smoothly and without issue, begin to load product.
6. Adjust all transfers for smooth transitions on and off these locations.
7. As product advances through the system, follow the product looking for any issues occurring under load.
8. Start-up is now complete. It is critical that the *Break-in Procedures* now be employed before continued use of the system begins.

## Section 4

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### Break-in Inspection Table

Interval	Component	Key Observations
Hourly	Drive Units (Front, Mini, Transfer, Intermediate, Cantilever, and End Drives)	<ul style="list-style-type: none"><li>• Verify position of Discharge Wheel and Transfers</li><li>• Monitor for unusual sounds and/or vibrations</li></ul>
	Tensioner Units (Front Drive, Transfer Drive, End Drive, Cantilever Drive, Bolt-In Tensioner, and End Piece)	<ul style="list-style-type: none"><li>• Verify proper tensioning, correct as needed</li></ul>

1. Special attention is required during the first few weeks of operation to make adjustments as needed to ensure the proper break-in of the system.
2. If a new component is added to the system, use the above table during the initial break-in period for that particular component.
3. *Break-in* periods vary based on load, run time, start/stop cycles, and other factors. As a general rule, *Break-in* is completed when tensioners do not require more than (1) one adjustment per day.

## Troubleshooting Table

Component	Observation(s)	Action(s)
Chain	Surging/jumping when starting, operating at low speed, or under load	<ul style="list-style-type: none"> <li>• Verify correct/adequate lubrication and correct operation of Drip Oiler(s)</li> <li>• Check for worn/damaged chain sliding profile</li> <li>• Check for bent/broken Chain Rods</li> <li>• Check for worn/damaged chain slideways on Drive Units</li> <li>• Check for worn/damaged Drive Sprockets on Drive Units</li> <li>• Verify operation of all Drive Units</li> </ul>
	Oily Chain Rods	<ul style="list-style-type: none"> <li>• Check Cleaning Brushes at Front Drive</li> <li>• Check for excessive chain oiling at Drip Oiler(s)</li> </ul>
	Bent/Broken Chain Rods	<ul style="list-style-type: none"> <li>• Check chain path through Drive Units and Bends</li> <li>• Check for chain chatter or popping at Drive Units</li> <li>• Check for damaged/missing Sliding Shoes on Connecting Parts</li> </ul>
	Chain Breakage (Tension)	<ul style="list-style-type: none"> <li>• Verify previous Drive Unit is operational if breakage occurred at a known location</li> <li>• Check for obstructions in chain path</li> <li>• Check for bent/broken Chain Rods</li> <li>• Check chain path through Drive Units</li> <li>• Check for worn/damaged Drive Sprockets on Drive Units</li> <li>• Verify Drive Unit quantity and locations to Layout Drawing</li> </ul>

## Section 4

Component	Observation(s)	Action(s)
	Chain Breakage (Slack)	<ul style="list-style-type: none"> <li>• Verify next Drive Unit is operational if breakage occurred at a known location</li> <li>• Check for worn/damaged Drive Sprockets on Drive Units</li> </ul>
	Security Elements loose or missing	<ul style="list-style-type: none"> <li>• Inspect Closing Rod for stretch</li> <li>• Troubleshoot as Chain Breakage (Tension)</li> <li>• Check for high tension locations within the system</li> </ul>
General	Product Damage	<ul style="list-style-type: none"> <li>• Check transfers onto and off the system</li> <li>• Check for obstructions along the entire system length</li> <li>• Check for bowing Chain Rods at Drive Units</li> <li>• Check for chain chatter or popping at Drive Units</li> </ul>
Chain Tensioners (Front Drive, Transfer Drive, Cantilever Drive, Bolt-In Tensioner, or End Piece)	Excessive Slack	<ul style="list-style-type: none"> <li>• Check nearest downstream bottom drive for proper gearbox/motor operation</li> <li>• New chain break-in period, remove excess chain</li> <li>• Verify number and placement of drives within the system</li> <li>• On extremely long conveyors, temperature variation may cause expansion/contraction of chain length</li> </ul>

Component	Observation(s)	Action(s)
Chain Tensioners (Front Drive, Transfer Drive, Cantilever Drive, Bolt-In Tensioner, or End Piece)	Excessive Tension	<ul style="list-style-type: none"> <li>• Check nearest upstream drive for proper gearbox/ motor operation</li> <li>• Verify number and placement of drives within the system</li> <li>• On extremely long conveyors, temperature variation may cause expansion/contraction of chain length</li> </ul>
Discharge Wheels (Front Drive, Mini Drive, Idler Units, or Transfer Drives)	Misalignment, twisting, breakage, or movement	<ul style="list-style-type: none"> <li>• Check for worn/damaged Drive Sprockets</li> <li>• Check for debris on the Conveyor Chain</li> <li>• Check for damaged/broken Closing Rods and/or Chain Rods</li> <li>• Inspect Transfers for proper setting/gap</li> </ul>
Gearbox/Motor (any Drive Unit)	Excessive movement/rocking	<ul style="list-style-type: none"> <li>• Check Bearings for wear</li> <li>• Check for loose fasteners</li> <li>• Check for worn/damaged Parallel Keys and/or Drive Shaft keyways</li> </ul>
Transfers (Front Drive, Mini Drive, Transfer Drive, or Idler Unit)	Transfer Plate damage/breakage	<ul style="list-style-type: none"> <li>• Verify proper gap between Conveyor Chain and Transfer Plate</li> <li>• Check for bent/broken Closing Rods and/or Chain Rods</li> <li>• Check for foreign objects/ debris on Conveyor Chain</li> <li>• Check downstream equipment for obstructions</li> <li>• Check for worn/damaged Drive Sprockets</li> <li>• Check for excessive slack in Conveyor Chain</li> </ul>



## Section 4

Component	Observation(s)	Action(s)
Chain Lubrication	Oil starvation	<ul style="list-style-type: none"> <li>• Verify oilers are filled with proper Chain Lubricant</li> <li>• Verify flow rate</li> <li>• Check for blockage within Supply Lines</li> <li>• Ensure oiler is not air-locked</li> </ul>
	Excessive oiling	<ul style="list-style-type: none"> <li>• Verify oilers are filled with proper Chain Lubricant</li> <li>• Verify flow rate</li> <li>• Check Supply Lines for damage</li> <li>• Check Oiler Solenoid for correct operation</li> <li>• Check for correct Drip Oiler orientation</li> <li>• Check for correct Drip Oiler location within the system</li> </ul>
Motors (any Drive Unit)	Overloading/various electrical issues (Note: when using VFDs, use True RMS meter for accurate readings)	<ul style="list-style-type: none"> <li>• If Bottom Drive, check nearest upstream Bottom Drive for correct gearbox/motor operation</li> <li>• If Top Drive, check nearest upstream Top Drive for correct gearbox/motor operation</li> <li>• Check upstream conveyor for adequate lubrication</li> <li>• Check upstream conveyor for debris/foreign objects</li> <li>• Check upstream conveyor for damage</li> <li>• Verify correct electrical installation (wiring, phases, VFDs, etc.)</li> <li>• Verify correct motor specifications (rpm, FLA, phase, etc.)</li> <li>• Check for correct number and placement of drives within the system</li> </ul>

## Section 5

### SECTION 5 MAINTENANCE AND SPARE PARTS

#### Inspection Schedule

Interval	Component(s)	Key Observations
Daily	General	<ul style="list-style-type: none"> <li>Verify Guards/Covers in place and secured</li> <li>Inspect for egg debris along entire length of conveyor</li> </ul>
	Drive Units (Front, Mini, Transfer, Intermediate, and End Drives)	<ul style="list-style-type: none"> <li>Inspect any Discharge Wheels and Transfers for correct adjustment</li> <li>Monitor for any unusual sounds and/or vibrations</li> </ul>
	Tensioning Units (Front Drive, Transfer Drive, End Drive, Cantilever Drive, Bolt-In Tensioner, and End Piece)	<ul style="list-style-type: none"> <li>Verify tensioner is operational and adjusted correctly</li> </ul>
	Oiler Units (Top and Tandem)	<ul style="list-style-type: none"> <li>Check oil level</li> <li>Check flow to both sides of conveyor chain</li> </ul>
1 to 3 months	General	<ul style="list-style-type: none"> <li>Inspect chain for damaged or bent cross rods</li> <li>Inspect Closing Rods for missing Security Elements</li> </ul>
	Gearboxes	<ul style="list-style-type: none"> <li>Inspect for oil leaks</li> </ul>
3 to 6 months	Drive Units (Front, Mini, Transfer, Intermediate, Cantilever, and End Drives)	<ul style="list-style-type: none"> <li>Inspect Drive Sprockets for wear</li> <li>Inspect Brushes for build-up</li> </ul>
	Intermediate Drives	<ul style="list-style-type: none"> <li>Inspect Metal Chain Slideways for wear</li> </ul>
12 to 18 months	General	<ul style="list-style-type: none"> <li>Inspect and clean all chain sliding surfaces</li> </ul>

#### Preventive Maintenance

- The following table suggests a time interval, component, and action for Preventive Maintenance.
- Once Preventive Maintenance (PM) rotation is complete through Month 48, repeat procedures starting at Month 6 and continuing through Month 48 (7.5 years total PM)

Interval	Component(s)	Action(s)
Month 6	Intermediate Drives	<ul style="list-style-type: none"> <li>• Rotate Drive Sprockets</li> <li>• Rotate Metal Chain Slideways (left/right)</li> </ul>
	Front or Transfer Drive	<ul style="list-style-type: none"> <li>• Clean Brushes</li> </ul>
Month 12	Intermediate Drives	<ul style="list-style-type: none"> <li>• Replace Drive Sprockets</li> <li>• Rotate Metal Chain Slideways (top/ bottom)</li> </ul>
	Drive Units (Front, Transfer, Mini, Cantilever, or End Drives)	<ul style="list-style-type: none"> <li>• Clean Brushes</li> <li>• Replace drive shaft bearings</li> </ul>
Month 18	Intermediate Drives	<ul style="list-style-type: none"> <li>• Rotate Drive Sprockets</li> <li>• Rotate Metal Chain Slideways (left/right)</li> </ul>
	Front or Transfer Drive	<ul style="list-style-type: none"> <li>• Clean Brushes</li> </ul>
Month 24	Intermediate Drives	<ul style="list-style-type: none"> <li>• Replace Drive Sprockets</li> <li>• Replace Metal Chain Slideways (top/ bottom)</li> <li>• Replace UHMW Chain Slideways (left/ right)</li> </ul>
	Drive Units (Front, Transfer, Mini, Cantilever, or End Drives)	<ul style="list-style-type: none"> <li>• Clean Brushes</li> <li>• Replace drive shaft bearings</li> </ul>
Month 30	Intermediate Drives	<ul style="list-style-type: none"> <li>• Rotate Drive Sprockets</li> <li>• Rotate Metal Chain Slideways (left/right)</li> </ul>
	Front or Transfer Drive	<ul style="list-style-type: none"> <li>• Clean Brushes</li> </ul>
Month 36	Intermediate Drives	<ul style="list-style-type: none"> <li>• Replace Drive Sprockets</li> <li>• Rotate Metal Chain Slideways (top/ bottom)</li> </ul>
	Drive Units (Front, Transfer, Mini, Cantilever, or End Drives)	<ul style="list-style-type: none"> <li>• Clean Brushes</li> <li>• Replace drive shaft bearings</li> </ul>
Month 48	Intermediate Drives	<ul style="list-style-type: none"> <li>• Replace Drive Sprockets</li> <li>• Replace Metal Chain Slideways (top/ bottom)</li> <li>• Replace UHMW Chain Slideways (left/ right)</li> </ul>
	Drive Units (Front, Transfer, Mini, Cantilever, or End Drives)	<ul style="list-style-type: none"> <li>• Replace Brushes</li> <li>• Replace drive shaft bearings</li> <li>• Replace Deflection Wheels</li> <li>• Replace Sliding Shoes</li> <li>• Rotate Drive Sprockets</li> <li>• Replace Deflection Wheel Bearings (End Drive metal deflection wheels only)</li> </ul>
	End Unit, End Piece, and Bolt-In Tensioner	<ul style="list-style-type: none"> <li>• Replace Deflection Wheels</li> </ul>

## Section 5

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### Critical Spares Overview

1. *Critical Spares* are defined as components and/or subassemblies maintained on-site to prevent extended periods of downtime in the case of failure.
2. The following charts detail the recommended components to inventory and a minimum quantity to repair most breakdowns.

Note: Minimum quantities should be adjusted based on components within each specific installation. The following charts detail all places where certain components are utilized, but do not always require a certain number of spares be maintained for each location. For example, if a component is used on a Front Drive and Intermediate Drive, the site is not required to maintain a recommended quantity for both as Critical Spares. Typically, having enough on hand to repair one or the other is sufficient as multiple components rarely fail simultaneously.

Note: *Critical Spares* are not *Preventive Maintenance* (PM) spares. PM Spares should be maintained as needed for upcoming scheduled repairs.

3. The following charts are separated into *All Types* and *Type Specific* components. *All Types* components are shared between multiple conveyor widths whereas, *Type Specific* are utilized only in specific width conveyors (e.g. Type 500, etc.).
4. The following charts are provided as a suggested guideline only. Each site should develop and maintain a spares program to suit each system.
5. Always rotate stock to ensure the components are in good working order when needed.

## Critical Spares All Widths

Part Number	Description	Recommended Min. Qty.	Front Drive	Intermediate Drive	Mini Drive	Transfer Drive	End Drive	End Unit	Cantilever Drive	End Piece	Idler Unit	Connecting Part	Pivot Unit	Top/Tandem Oilers	Bolt-In Tensioner
S-87.3	Stober Gearbox	1	•	•	•	•	•		•						
G580	Motor 1/3hp 3ph 208-230/460 60Hz	1		•		•			•						
G513	Motor 1/3hp 1ph 115-208/230 60Hz	1		•			•		•						
6K950	Motor 1/3hp 1ph 110/220 50Hz	1		•			•		•						
G581	Motor 1/2hp 3ph 208-230/460 60Hz	1	•		•	•			•						
N411	Motor 1/2hp 3ph 208-230/460 60Hz SS	1	•		•	•			•						
G515	Motor 1/2hp 1ph 115-208/230 60Hz	1	•		•	•			•						
34 10 205	4-Bolt Flange Bearing 25mm	2	•	•	•	•	•		•		•				
6205.2RSR	Bearing 25mm	2	•	•	•	•	•		•						
6002.2RSR	Bearing 15mm	4					•								
185 500 55 01	Flange Complete Main Drive	1	•		•	•	•								
185 500 55 02	Flange Complete Intermediate Drive	1		•					•						
27 43 070	8 x 7 x 28 Parallel Key	6	•	•	•	•	•		•		•				
705 001 02 00	Main Drive Sprocket	2	•	•	•	•	•				•				
705 001 03 00	Intermediate Drive Sprocket	2		•					•						
185 515 03 00	Driving Sprocket	2									•				
185 515 21 00	Deflection Wheel Grooved 94.7mm	4	•			•	•								
185 515 21 01	Deflection Wheel Grooved 155mm	2													•
185 515 22 00	Deflection Wheel Smooth 94.7mm	2	•			•	•	•		•					
185 515 22 01	Deflection Wheel Smooth 155mm	2							•						•
185 100 23 00	Deflection Wheel Steel Complete	2					•								
26 43 064	Adjusting Ring A20-705	8	•			•		•	•	•					•
707 120 02 00	Sliding Shoe Complete	6										•			
185 100 11 00	Sliding Shoe Long Complete	4	•			•							•		
185 100 13 00	Sliding Shoe Short Complete	4	•			•									
185 525 05 01	Sliding Shoe Long	4	•			•							•		
185 525 05 02	Sliding Shoe Short	4	•			•									
LBG78-035	Lubricant Food Grade 5 Gallon	1													•
185 516 07 08	Chain Slideway, LH	2		•											
185 516 07 09	Chain Slideway, RH	2		•											
185 516 05 01	Chain Slideway, Metal	4		•											
185 540 04 02	Security Elements	20													
835380	Solenoid 120v	1													•
835381	Solenoid 240v	1													•

## Section 5

### Critical Spares T250

Part Number	Description	Recommended Min. Qty.	Front Drive	Intermediate Drive	Mini Drive	Transfer Drive	End Drive	Cantilever Drive	End Unit	End Piece	Idler Unit	Connecting Part	Pivot Unit	Top/Tandem Oilers	Bolt-in Tensioner	Standard Chain	Coated Chain	Hybrid Chain
186 516 01 01	Drive Shaft T250	1	•	•	•	•		•										
186 516 01 07	Return Shaft T250	1									•							
186 500 11 02	Discharge Wheel Complete T250	1	•		•	•					•							
186 500 10 03	Transfer Complete T250 x 95mm	1	•		•	•					•							
4921	Conveyor Chain T250 Standard (roll)	1														•		
4924	Closing Rod T250 Standard	1														•		
5921	Conveyor Chain T250 Hybrid (roll)	1																•
5924	Closing Rod T250 Hybrid	5																•
4935 <sup>1</sup>	Intermediate Drive T250	1		•														

<sup>1</sup>It is recommended that a complete spare unit be kept in inventory to reduce downtime. Replacement of the entire unit is often quicker than servicing/repairing a unit installed in the system. The removed unit can be repaired and placed in inventory for future use.

## Critical Spares T350

Part Number	Description	Recommended Min. Qty.	Front Drive	Intermediate Drive	Mini Drive	Transfer Drive	End Drive	End Unit	Cantilever Drive	End Piece	Idler Unit	Connecting Part	Pivot Unit	Top/Tandem Oilers	Bolt-in Tensioner	Standard Chain	Coated Chain	Hybrid Chain
187 516 01 01	Drive Shaft T350	1	•	•	•	•	•		•									
187 516 01 07	Return Shaft T350	1									•							
187 500 11 02	Discharge Wheel Complete T350	1	•		•	•					•							
186 500 10 03	Transfer Complete T350 x 95mm	1	•		•	•					•							
4861	Conveyor Chain T350 Standard (roll)	1														•		
4864	Closing Rod T350 Standard	5														•		
4868 <sup>1</sup>	Intermediate Drive T350	1		•														

<sup>1</sup>It is recommended that a complete spare unit be kept in inventory to reduce downtime. Replacement of the entire unit is often quicker than servicing/repairing a unit installed in the system. The removed unit can be repaired and placed in inventory for future use.

## Section 5

### Critical Spares T500

Part Number	Description	Recommended Min. Qty.	Front Drive	Intermediate Drive	Mini Drive	Transfer Drive	End Drive	Cantilever Drive	End Unit	End Piece	Idler Unit	Connecting Part	Pivot Unit	Top/Tandem Oilers	Bolt-in Tensioner	Standard Chain	Coated Chain	Hybrid Chain
185 516 01 01	Drive Shaft T500	1	•	•	•	•	•	•										
185 516 01 07	Return Shaft T500	1									•							
185 500 11 02	Discharge Wheel Complete T500	1	•		•	•					•							
185 500 10 03	Transfer Complete T500 x 95mm	1	•		•	•					•							
4821	Conveyor Chain T500 Standard (roll)	1														•		
4824	Closing Rod T500 Standard	1														•		
4832	Conveyor Chain T500 Plastic Coated (roll)	1															•	
4833	Closing Rod T500 Plastic Coated	1															•	
5821	Conveyor Chain T500 Hybrid (roll)	1																•
5824	Closing Rod T500 Hybrid	5																•
4824-1	Closing Rod T500 Grub Screw	5														•		
4835 <sup>1</sup>	Intermediate Drive T500	1		•														

<sup>1</sup>It is recommended that a complete spare unit be kept in inventory to reduce downtime. Replacement of the entire unit is often quicker than servicing/repairing a unit installed in the system. The removed unit can be repaired and placed in inventory for future use.



## Critical Spares T750

Part Number	Description	Recommended Min. Qty.	Front Drive	Intermediate Drive	Mini Drive	Transfer Drive	End Drive	Cantilever Drive	End Unit	End Piece	Idler Unit	Connecting Part	Pivot Unit	Top/Tandem Oilers	Bolt-in Tensioner	Standard Chain	Coated Chain	Hybrid Chain
188 516 01 01	Drive Shaft T750	1	•	•	•	•	•	•										
188 516 01 07	Return Shaft T750	1									•							
188 500 11 02	Discharge Wheel Complete T750	1	•		•	•					•							
188 500 10 03	Transfer Complete T750 x 95mm	1	•		•	•					•							
4891	Conveyor Chain T750 Standard (roll)	1														•		
4894	Closing Rod T750 Standard	1														•		
4892	Conveyor Chain T750 Plastic Coated (roll)	1															•	
4893	Closing Rod T750 Plastic Coated	5															•	
5892	Conveyor Chain T750 Hybrid (roll)	1																•
5894	Closing Rod T750 Hybrid	5																•
4894-1	Closing Rod T750 Grub Screw	5														•		
4898 <sup>1</sup>	Intermediate Drive T750	1		•														

<sup>1</sup>It is recommended that a complete spare unit be kept in inventory to reduce downtime. Replacement of the entire unit is often quicker than servicing/repairing a unit installed in the system. The removed unit can be repaired and placed in inventory for future use.

## Section 5

### Critical Spares T1000

Part Number	Description	Recommended Min. Qty.	Front Drive	Intermediate Drive	Mini Drive	Transfer Drive	End Drive	Cantilever Drive	End Unit	End Piece	Idler Unit	Connecting Part	Pivot Unit	Top/Tandem Oilers	Bolt-in Tensioner	Standard Chain	Coated Chain	Hybrid Chain
191 516 01 01	Drive Shaft T1000	1	•	•	•	•		•										
191 516 01 07	Return Shaft T1000	1									•							
191 500 11 02	Discharge Wheel Complete T1000	1	•		•	•					•							
191 500 10 03	Transfer Complete T1000 x 95mm	1	•		•	•					•							
5421	Conveyor Chain T1000 Standard (roll)	1														•		
5423	Closing Rod T1000 Standard	1														•		
5461	Conveyor Chain T1000 Hybrid (roll)	1																•
5464	Closing Rod T1000 Hybrid	5																•
5423-1	Closing Rod T1000 Grub Screw	5														•		
5435 <sup>1</sup>	Intermediate Drive T1000	1		•														

<sup>1</sup>It is recommended that a complete spare unit be kept in inventory to reduce downtime. Replacement of the entire unit is often quicker than servicing/repairing a unit installed in the system. The removed unit can be repaired and placed in inventory for future use.

## Section 5

### Electrical Specifications

#### Drip Oiler Solenoids

Part Number	Voltage	Frequency (Hz)	Power (Watts)
835380	120	60	11
835381	240	60	11

#### Motors (nameplate data)

Mfg.	Model	Frame	Encl.	HP	Phase	Voltage	Freq. (HZ)	Full Load Amps	RPM	Service Factor
Marathon	G515	56C	TEFC	1/2	1	115/230	60	8.6/4.3	1725	1.15
	G581	56C			3	208-230/460		2.3-2.4/1.2	1725	1.15
	N411	56C	TENV	3	208-230/460	1.5-1.6/.8		1750	1.15	
	G513	56C	TEFC	1/3	1	115/208-230		6/3-3	1725	1.15
	G580	56C			3	208-230/460		1.4-1.6/.8	1725	1.15

Note: Motors not purchased from Lubing Systems must match the above criteria for proper operation. Failure to match these specifications may result in damage to the chain and/or other components within the system.

Note: Always verify “advertised” specifications to the “actual” data on the nameplate.

### Mechanical Specifications

#### Conveyor Speed (ft/min.)

Motor rpm	Freq. (HZ)	Gearbox	Speed (approx.)
1800	60	S-87.3 Stober	25 ft/min. <sup>1</sup>
1500	50		21 ft/min. <sup>1</sup>

<sup>1</sup>Linear speed dependent on all variables. Deviation from any parameter above will yield differing speeds. System designed for approx. 25 ft/min for best performance and longevity. Any increases in speed should be accompanied with increases in acceleration/deceleration time for the drives. Speeds exceeding 30 ft/min will result in increased product damage and decreases in system longevity.

## Conveyor Capacity (cases/hr)

Conveyor Type	Width (mm/inches)	Capacity (cases/hr)
250	250/10	90
350	350/14	125
500	500/20	190
750	750/30	300
1000	1000/40	400

## Inclines/Declines (max. angles)

Conveyor Chain Type	Incline or Decline Max. (degrees)
Standard	20 <sup>1</sup> (18 for Type 1000)
Hybrid	
Plastic Coated	18 <sup>1</sup>

<sup>1</sup>Maximum angles are given as reference only, other variables may dictate lesser angles. Consult your Lubing representative or the provided engineered layout drawing for recommended angles.

## Bend Units (standard/custom angles)

Standard bend angles are available as 45 and 90 degrees.

Custom bend angles are available, consult your Lubing representative or the provided engineered layout drawing for recommended angles.

## Lubricants (approved alternates)

Drip Oiler Capacity	Recommended Lubricants	Mfg.
1 quart	LBG78-035	Lubing
	FG100	Amoco
	FM-E ISO 100	Chevron
	Magna-Plate 78	JAX

Refer to the *OEM Contact Section* to find a distributor for your area.

## Gearboxes (oil levels)

Contact Manufacturer for recommended gearbox oil and levels. Refer to the *General Information Section* for OEM contact information.

## Section 5

### Recommended Tool List

Conveyor Manual	Assembly, Installation, Start-up, and Troubleshooting guide
Conveyor Layout	Drawing specifically engineered for your system
Tape Measure	Measuring distances, modifying Connecting Part lengths, etc.
Level	Setting components level during installation
Combination or Speed Square	Marking cut lines when modifying Connecting Part lengths
Metric Hex Keys (Allen Wrenches)	1.5mm - 10mm range
Metric Sockets/Ratchet	8mm - 19mm range (1/4" or 3/8" drive ratchet)
3" Extension	For ratchet/sockets above
#2 & #3 Phillips Screwdriver	Misc. fasteners
Flat blade Screwdriver	Misc. fasteners
T20 Torx Bit	Misc. self-tapping fasteners
5/16" or 8mm Drill Bit	Adding holes when modifying Connecting Part lengths
Cordless Drill (3/8" chuck)	Adding holes when modifying Connecting Part lengths
Hammer/Punch	Loosening Eccentric Collar on 4-bolt Flange Bearing
Hacksaw/Blade	Cutting Sidesheets when modifying Connecting Part lengths
6" Tongue and Groove Pliers	Small-head pliers for installing Security Elements
Cutting Wheel/Bolt Cutters	Cutting Chain Rolls
True RMS Meter	Voltage readings when using VFDs
True RMS Amp Meter	Current readings when using VFDs

### Materials of Construction

Components	Material (contact surface)	Finish
Chain Path	UHMW-PE	None
Red Capping	ABS	None
Transfers	PVC, Rigid	None
Discharge Wheel Tubes	PVC, Rigid	None
Cleaning Brush Bristles	Nylon	None
Conveyor Chain, Standard	Steel	Electro-galvanized
Conveyor Chain, Hybrid	Stainless	None
Conveyor Chain, Plastic Coated	ABS	None
Sidesheets (Aluminum)	Aluminum 6063-T5	Clear Anodize
Sidesheets (Stainless)	Stainless	None
Drip Oiler Reservoir	Glass	None

# Component Replacement

## General

1. Always observe all Lockout-Tagout and safety procedures for your facility prior to performing any work on the system.
2. Always wear all *Personal Protective Equipment* (PPE) when servicing equipment.
3. When servicing the conveyor requires the replacement of a particular component, please refer to the *Assembly and Installation Section*, *Start-up Checklist*, and the *Break-In Tables* provided in this manual.
4. It is recommended that the item removed is replaced with the exact component. Please discuss any changes with your Lubing representative.

## Conveyor Chain

5. When replacing Conveyor Chain, use the same style existing in the system (i.e. Standard, Plastic Coated, or Hybrid). Mixing chain styles is not recommended and can lead to damaged product, collectors, transfers, or other components within the system.
6. Replacing full chain roll lengths will decrease the number of Closing Rods within the system.

## Drive Components

7. When replacing any component containing motors and gearboxes, ensure the component is installed in the same orientation as the unit being replaced. Always verify motor rotation before re-installing motors and gearboxes.
8. In the case of Intermediate Drives, ensure the drive is set to the proper configuration (i.e. Top or Bottom Drive). Refer to the *Assembly and Installation Section* for proper Intermediate Drive setup.

Note: Downtime can be reduced by maintaining a spare Intermediate Drive with the proper Sprocket widths and gaps as detailed in the *Assembly and Installation Section*.

## Section 5

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### Motors and Gearboxes

9. When replacing motors, ensure the nameplate data on the new motor matches that on the one being replaced. Refer to the *Electrical Specifications Table* in this manual for motor information.

Note: Motors not purchased from Lubing Systems must meet the same criteria. Failure to match all parameters may result in damage to the chain and/or other components within the system.

Note: Always verify motor rotation before installing onto Drive Components. Incorrect rotation will result in damage to the chain and/or other components within the system.

10. When replacing gearboxes, match the exact gearbox present within the system.

Note: Failure to match gearboxes may result in damage to the chain and/or other components within the system.

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## Tips and Tricks

### Installation

1. Correct installation begins with the first component. Taking time to properly elevate and level downstream equipment and then the first component of the new installation will better guarantee good results when starting and operating the system.
2. Provide accurate measurements for best layout engineering.
3. Do not compromise the layout when installing. Should issues arise, it is best to communicate these to your Lubing representative to avoid possible delays later.

### Maintenance

1. *Maintenance and Inspection Tables* and time-lines are provided as guidelines only. Develop your own schedules and areas of observation based on equipment on site.
2. Maintenance suggestions are made to reduce downtime and costs by, when possible, rotating and reusing components to extend their service life.
3. Review the *Component Details Section* to see how parts are offered. It is often possible to stock items as subassemblies in order to make repairs quicker and reduce downtime. Once the entire subassembly has been replaced, order the required components, repair, and stock the subassembly for future use.
4. In systems requiring multiple identical components, it may be more cost and time effective to stock an entire component as a spare. As with subassemblies, replace the entire component, order the appropriate replacement parts, repair, and stock the assembly for future use.

### Motors and Gearboxes

1. Motors not purchased from Lubing Systems must match the exact horsepower and output speed (rpm). Failure to match will cause issues possibly leading to damage to the chain and/or drive units.
2. Gearboxes are intended for a specific mounting (motor vertical facing up). Contact the manufacturer if attempting to run in another mounting orientation.
3. Variable Frequency Drives (VFDs) or other “soft start” devices should be implemented to increase component life and reduce downtime due to breakages. All drives should start/stop together.

### Spares

1. All spares should be properly stored. Prolonged exposure to weather, excessive temperatures, sunlight, or other environmental elements may damage components.
2. Rotate inventory on spares to prevent excessive age before use. This is especially critical for bearings or other items containing lubricants or grease.
3. When servicing an older system, verify any fasteners involved with replacing a component(s) to the current fasteners employed on the system. If variations are found, order the appropriate fasteners with the component(s) to be replaced. See *Section 2 Component Details* for current BOMs.



## Section 5

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### Conveyor Chain

1. Conveyor Chain is manufactured within a specific tolerance, however, there are variations between manufactured batches of chain. For best results, order enough chain for the system and spare at the same time for best results.
2. If serious damage occurs to the chain, inspect all Closing Rods. If the Closing Rod has been overstressed, the Security Elements will often be loose or missing.
3. If the eggs begin to show excessive oiling picked up from the conveyor, check the Cleaning Brushes. The Cleaning Brush can sometimes begin to wick oil from the chain links and allow the oil to migrate toward the center of the conveyor. If this is observed, clean the Brushes and trim back the first inch or so of bristles on both sides away from the chain links.
4. If an intermittent issue is occurring at a drive location, mark the section of chain passing through the drive during the issue. If the drive smooths out or the issue goes away once the marked section has exited the drive, replace that section of chain.

### Chain Lubricant (Oil)

1. Attempts to reduce costs with lesser expensive oils will lead to increased maintenance and repair costs. The specified oil and the acceptable alternate oils provided in the *Mechanical Specifications Section* of this manual are engineered for the conveyor system and must be used.
2. The specified oil is designed to travel with the chain and transfer onto the sliding surfaces throughout the conveyor system. Mineral Oils and other lubricants not specified do not contain the proper additives for adequate transfer onto the sliding surfaces and will lead to issues such as chain surging, increased product damage, premature wear of components, and possibly, chain breakage.
3. Less expensive oils often cost more due to the increased amount required in an attempt to prevent chain surging and other side effects associated with their use. Slip hazards may also increase with these non-approved substitute lubricants.

## Section 6

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### SECTION 6 GENERAL INFORMATION

#### Conveyor Layout Sketches

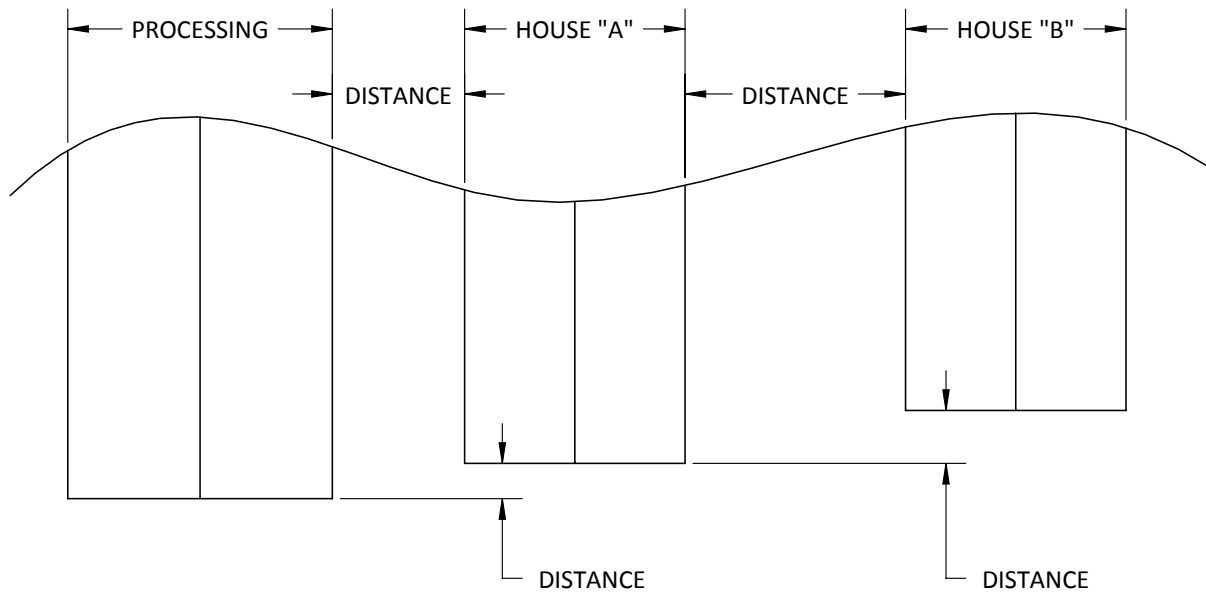
##### Sketching Houses and other Buildings

1. A House layout is often beneficial when submitting a conveyor sketch. See the following view for locating houses.

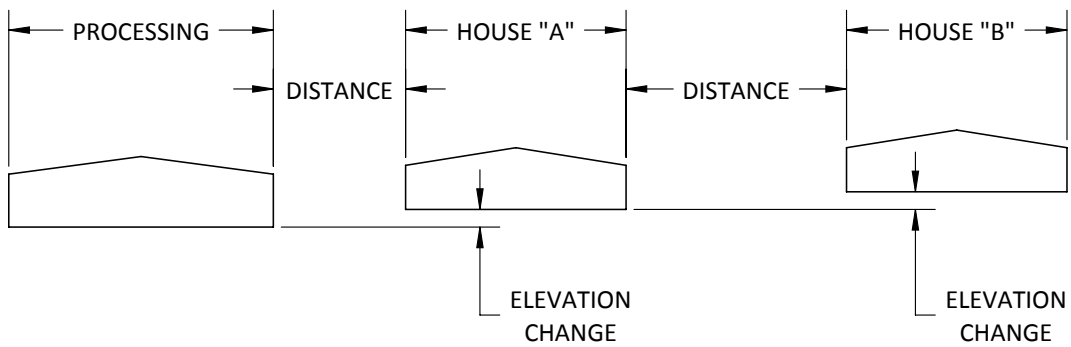
Note: Please communicate house widths, distances between, elevation changes, and/or any offset distances if the houses are not in line with one another.

House/Building designations (e.g. Processing, House #1, etc.) can be specified and will be referenced on the provided Lubing Systems Conveyor Layout.

2. Not all House layouts require a Plan (Top) View and an Elevation (Side) View. Provide only the view(s) needed to communicate the locations of the houses relative to one another.
3. When submitting a House layout, consider any future expansion or construction projects. When this information is provided, Lubing Systems can better engineer the layout to accommodate these changes and will specify the appropriate actions at each phase of the installation to decrease the amount of changes required as the expansion is completed.



**PLAN VIEW**



**ELEVATION VIEW**

HOUSE DIMENSIONS AND LOCATIONS SHOULD BE AS ACCURATE AS POSSIBLE. ERRORS IN ESTIMATION OVER THE ENTIRE LAYOUT CAN ACCUMULATE AND EFFECT THE DESIGN.

## Section 6

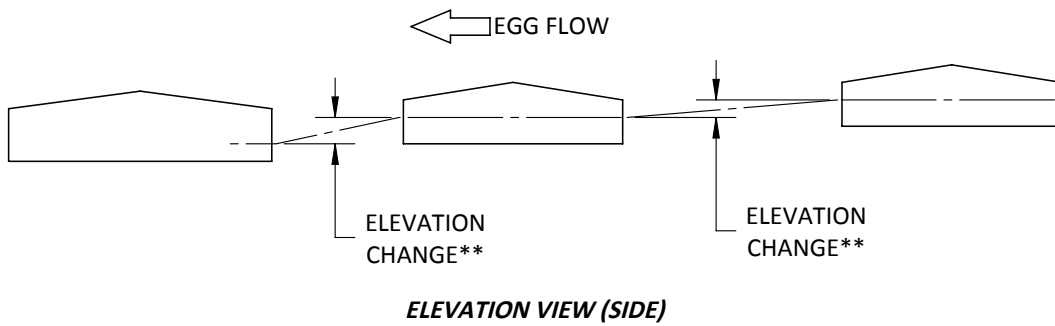
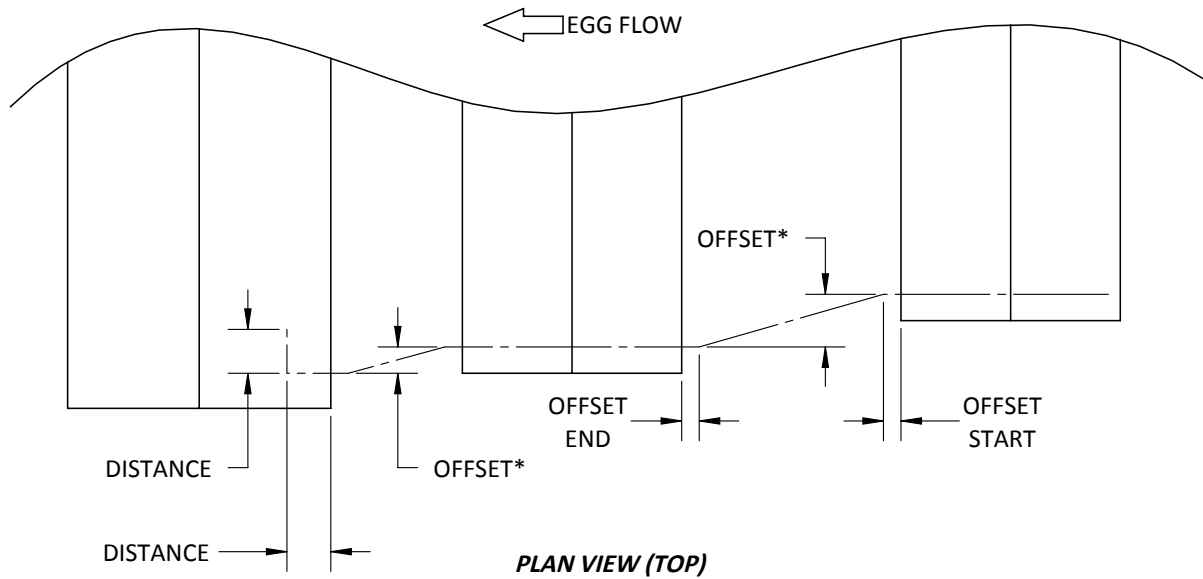
---

### Sketching the Conveyor Path

4. The following view illustrates an example of sketching the conveyor path. Communicate any obstacles, offsets, or elevation changes required.

Note: A Lubing Sales Representative can assist in sizing the conveyor for your application.

Note: Lubing Systems will engineer a layout based on this recommendation and communicate any deviations based on design parameters and components requested.



HOUSE DIMENSIONS AND LOCATIONS SHOULD BE AS ACCURATE AS POSSIBLE. ERRORS IN ESTIMATION OVER THE ENTIRE LAYOUT CAN ACCUMULATE AND EFFECT THE DESIGN.

\* **OFFSETS** ARE DEFINED AS ANY SIDE-TO-SIDE CHANGES IN DIRECTION ACCOMPLISHED WITH A PAIR OF BEND UNITS

\*\* **ELEVATION CHANGES** ARE DEFINED AS ANY UP OR DOWN CHANGES IN HEIGHT ACCOMPLISHED WITH PIVOT UNITS

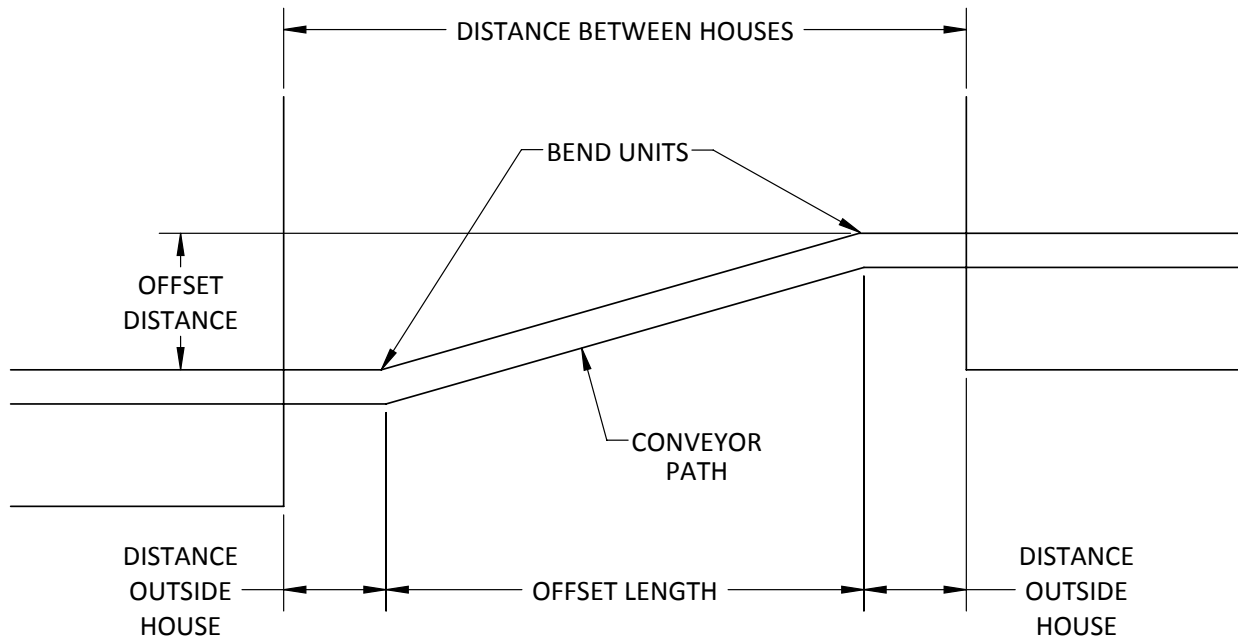
## Section 6

### Sketching Offsets

5. The following view illustrates proper techniques for sketching offsets in the conveyor path.

Note: The following view illustrates an offset between houses as example only. Note the obstacles or any limiting factors to the offset. If no limitations are given, Lubing Engineering will apply the slightest angles possible to achieve the desired offset amount for best possible performance.

Note: Lubing Engineering will review sketches received and communicate any issues found in the requested conveyor paths prior to providing a layout.



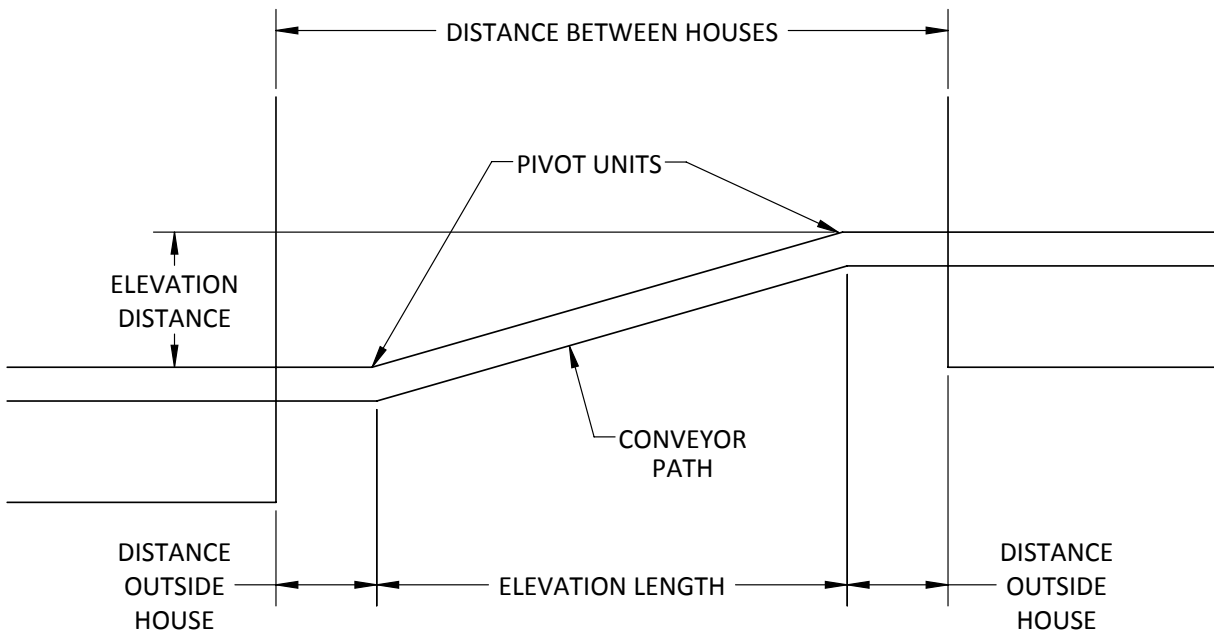
IF NO "DISTANCE OUTSIDE HOUSE"  
IS PROVIDED, IT IS ASSUMED THAT  
OFFSETS CAN BEGIN IMMEDIATELY  
OUTSIDE HOUSE

**Sketching Elevations**

6. The following view illustrates proper techniques for sketching Elevations in the conveyor path.

Note: The following view illustrates an elevation change between houses as example only. Note the obstacles or any limiting factors to the elevation. If no limitations are given, Lubing Engineering will apply the slightest angles possible to achieve the desired elevation change for best possible performance.

Note: Lubing Engineering will review sketches received and communicate any issues found in the requested conveyor paths prior to providing a layout.



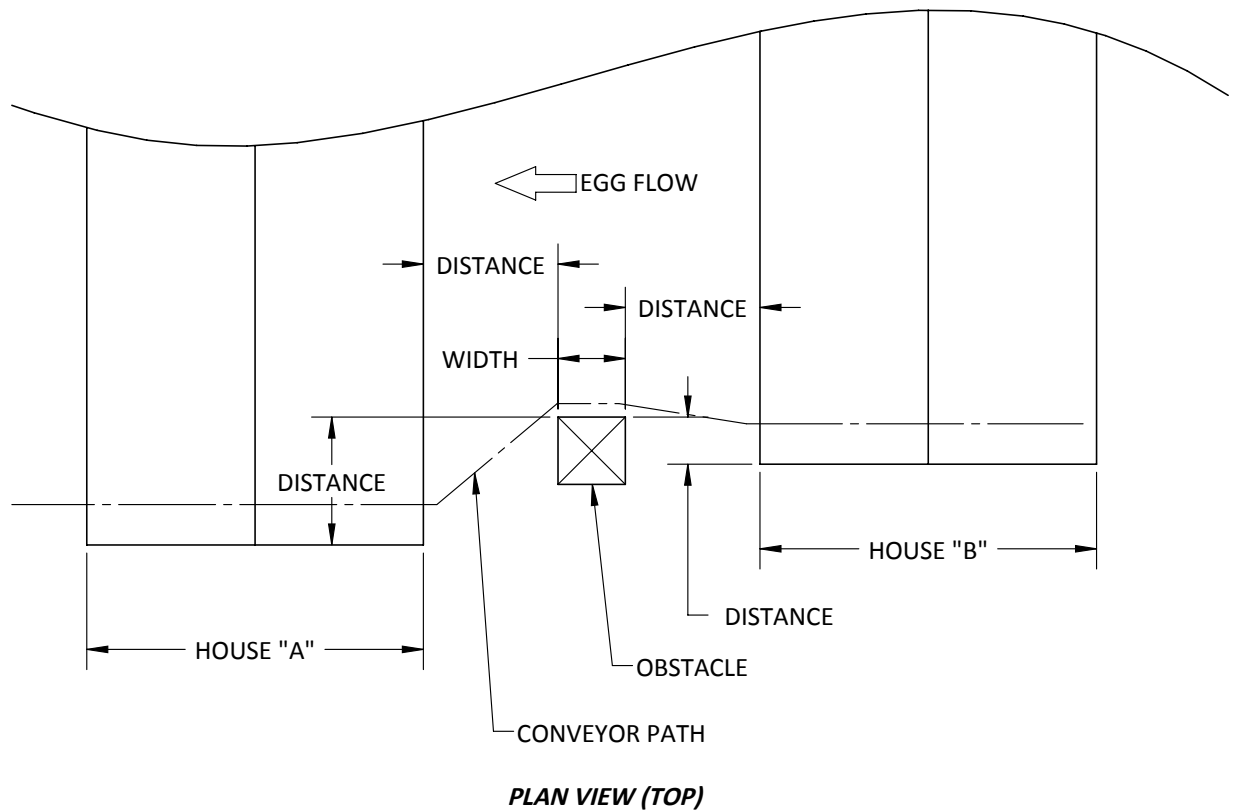
IF NO "DISTANCE OUTSIDE HOUSE"  
IS PROVIDED, IT IS ASSUMED THAT  
ELEVATIONS CAN BEGIN IMMEDIATELY  
OUTSIDE HOUSE

## Section 6

### Avoiding Obstacles

7. The following view illustrates proper sketching techniques when encountering obstacles in the conveyor path. Providing the location and size of the obstacle allows the best engineering of the layout possible around or over said obstacles.

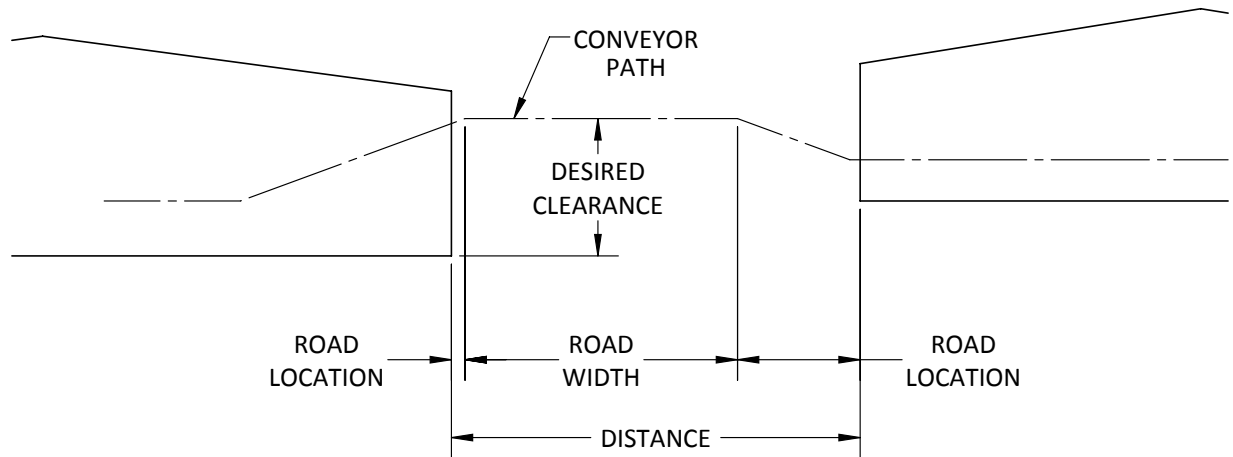
Note: The above practice is often more accurate and easily obtained on site than attempting to provide the appropriate angles of offset or elevation changes. Include heights when the conveyor must travel over or under the obstacle.





## Road Clearance

8. The following view illustrates the information required when encountering roads where overhead clearance is critical for traffic flow.



## Section 6

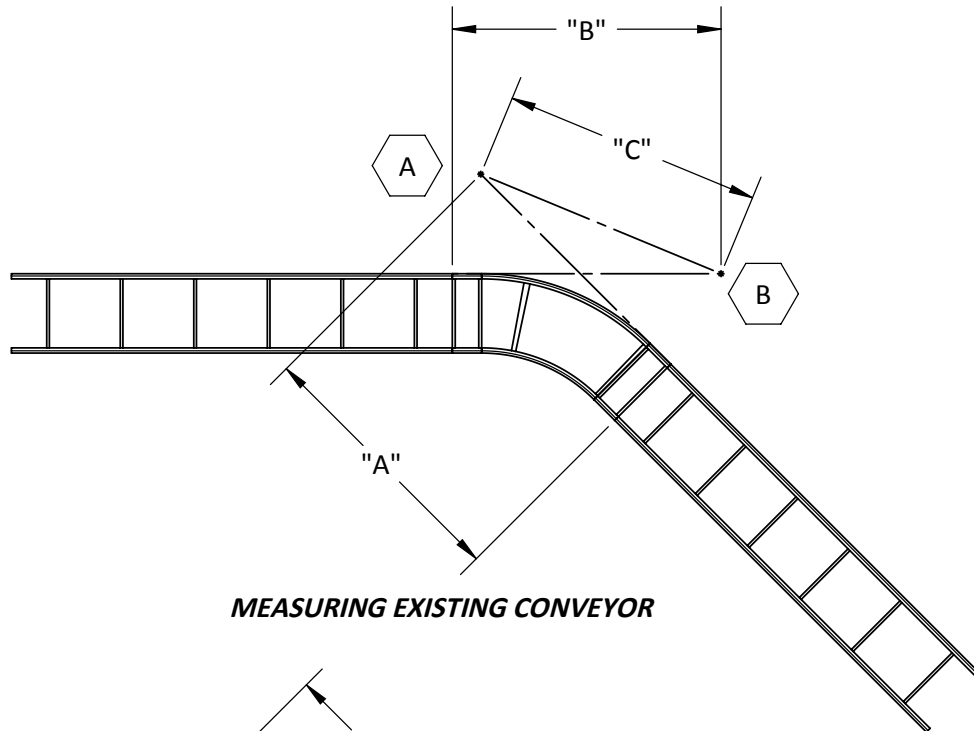
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### Determining Bend Angles

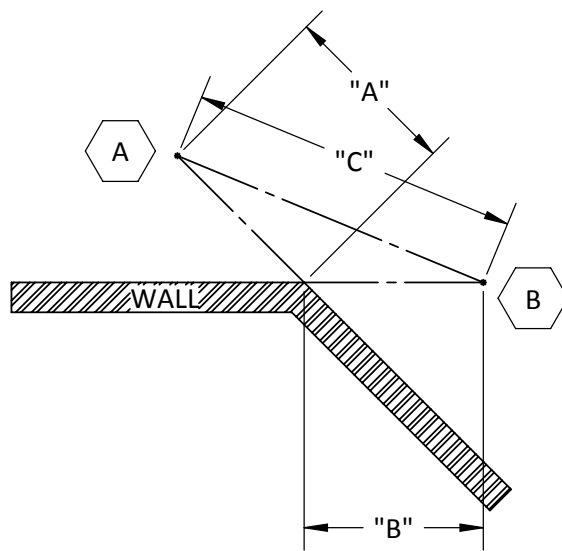
9. The following view illustrates the proper technique for determining a bend angle when encountering an existing Bend Unit or a wall where the angle is unknown.

Note: The measurement in degrees does not have to be specified. The angle can be calculated if A, B, and C are provided.

Note: If possible, A and B should be a minimum of 5' or 1.5m. Any distance longer increases the accuracy of the measurement.



**MEASURING EXISTING CONVEYOR**



**MEASURING FOR FUTURE CONVEYOR**

- A** = SOME MEASURED DISTANCE ALONG CONVEYOR EDGE OR WALL
- B** = SOME MEASURED DISTANCE ALONG CONVEYOR EDGE OR WALL
- C** = MEASURED DISTANCE BETWEEN MARKS "A" AND "B"

NOTE: ACTUAL ANGLE CALCULATION IS NOT REQUIRED,  
 SUBMIT INFORMATION ABOVE TO ENGINEERING  
 FOR APPROPRIATE BEND UNIT SPECIFICATION

## Section 6

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### Understanding Layouts

#### Layout Acceptance Form (LAF)

10. After an order for the conveyor system has been placed and sketch information received, a layout will be engineered and returned to the customer for review. The following view illustrates the first sheet of the layout known as the *Layout Acceptance Form* or *LAF*.
11. A Signed *LAF* must be returned per the instructions on the sheet for approval to ship the order.

Note: If the layout is approved with no changes, return only the signed *LAF*.

Note: If the layout is approved with noted changes, return the signed *LAF* along with any sheets containing notes and/or changes. Lubing Systems engineering will revise the layout and submit for customer review.

**\*IMPORTANT\***

**FORM MUST BE SIGNED AND RETURNED BEFORE ORDER SHIPS**

- This layout is based upon information provided to Lubing Systems, LP.
- It is the responsibility of the customer and/or installer to verify all dimensions before proceeding with installation.
- It is the responsibility of the customer and/or installer to verify that the correct equipment is on the jobsite before proceeding with installation. Refer to packing list for required parts and accessories.
- Any questions and/or concerns should be addressed with your Sales Representative before installation begins.
- Any deviation from this layout could result in additional expenses to the customer and/or installer, e.g., electrical modifications, conveyor damage/breakage, downtime, premature wear, delayed startups, overall performance, etcetera.
- Before startup, conveyor must be fully installed per provided layout.
- If installing in phases is required, contact your Sales Representative.
- Termination points must be approved by Lubing Systems Engineering to ensure proper operation prior to installation.
- Refer to sections "Assembly and Installation" and "Start-up and Troubleshooting" in the *Curve Conveyor Systems Product Manual* #IM-707-00 before and during installation.

Please remit any changes via fax to:

**LUBING SYSTEMS, LP**  
 Attention: Engineering  
 135 Corporate Drive SW  
 Cleveland, TN 37311  
 (423) 709-1000 phone  
 (423) 709-1001 fax  
 (866) 289-3237 toll free fax

If approved as shown, remit this page only

If changes are required, note on respective sheets and remit

Please remit any changes via email to:

engineering@lubingusa.com

Subject line of email must include complete drawing number

Email must clearly state approval or changes required and customer contact information

Company/Farm Representative: \_\_\_\_\_

Company/Farm Name: \_\_\_\_\_

Date: \_\_\_\_\_

DATE: FILING: TREATMENT:	SCALE: 1:2	DRAWN BY: CHECKED BY: APPROVED BY:	DATE: 8/30/2013	PROPRITARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF LUBING SYSTEMS, LP. NO REPRODUCTION OR TRANSMISSION IN ANY FORM OR BY ANY MEANS, WITHOUT THE WRITTEN PERMISSION OF LUBING SYSTEMS, LP IS PROHIBITED.	UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. UNRESPECIFIED HOLE DIA ARE .001" ±1" FINISH TOLERANCES: METRIC TOLERANCES: FRACTIONAL: ±.005" ±1.0 ANGULAR: ±1.0° HOLE DIA: ±.001 HOLE DIA: ±.005	DWG. NO.:	DESCRIPTION:
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Lubing Systems, LP  
 135 Corporate Drive SW  
 Cleveland, TN 37311 USA

## Section 6

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### Component Spacing Chart

12. If applicable, the second sheet of the layout drawing will contain a *Component Spacing Chart* detailing the locations of certain milestone components such as pivots, bends, and drive units to aid in the initial layout of the conveyor and electrical systems.

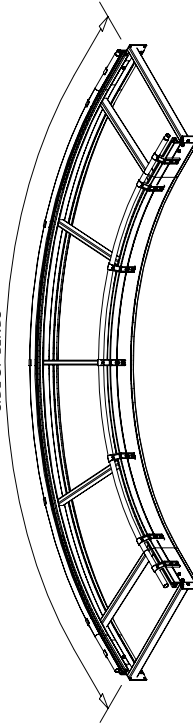
Note: *Component Spacing Charts* will match the units of the layout drawing. If the initial sketch received from the customer is in feet, the drawing and any associated charts will be communicated in feet. If the initial sketch is in meters, the drawing and charts will be in meters.

Note: The following view illustrates the *Component Spacing Chart* and the proper practice for measuring Bend Units if encountered in the layout.

Feet or Meters

Component Spacing Chart	
Component	Distance from Front Transferring Plate
Front Drive Unit	0.00 ft
3M Custom Connecting Part	3.23 ft
Pivot Unit	11.52 ft
3M Custom Connecting Part	32.29 ft
Pivot Unit	33.87 ft
Top Intermediate Drive Unit	94.01 ft
Top Intermediate Drive Unit	174.56 ft
Bottom Intermediate Drive Unit	186.20 ft
Tandem Drip Oiler Unit	197.85 ft
3M Custom Connecting Part	198.82 ft
Pivot Unit	200.88 ft
3M Custom Connecting Part	251.18 ft
Pivot Unit	251.81 ft
Top Intermediate Drive Unit	302.11 ft
Bottom Intermediate Drive Unit	353.12 ft
3M Custom Connecting Part	413.98 ft
Pivot Unit	417.81 ft
Top Intermediate Drive Unit	418.89 ft
3M Custom Connecting Part	489.59 ft
Pivot Unit	492.44 ft
Top Intermediate Drive Unit	532.89 ft
Bottom Intermediate Drive Unit	544.54 ft
Tandem Drip Oiler Unit	615.24 ft
Top Intermediate Drive Unit	676.26 ft
Bottom Intermediate Drive Unit	707.59 ft
3M Custom Connecting Part	758.61 ft
Pivot Unit	759.44 ft
3M Custom Connecting Part	819.58 ft
Pivot Unit	823.23 ft
Top Intermediate Drive Unit	824.31 ft
Bottom Intermediate Drive Unit	875.33 ft
Top Intermediate Drive Unit	955.87 ft
3M Custom Connecting Part	1016.73 ft
Pivot Unit	1017.23 ft
3M Custom Connecting Part	1038.00 ft
Pivot Unit	1040.40 ft
Bottom Intermediate Drive Unit	1041.49 ft
Tandem Drip Oiler Unit	1053.13 ft
Top Intermediate Drive Unit	1114.16 ft
Bottom Intermediate Drive Unit	1204.55 ft
3M Custom Connecting Part	1236.88 ft
End Unit	1242.88 ft

MEASURE LONGEST SIDE OF BENDS



SYSTEM NOTES:

- DRIVE LOCATIONS ± 5'-0" (1.5m)
- DIMENSIONS ARE CRITICAL. (DIMENSIONS ARE REFERENCE ONLY)
- CUSTOMER RESPONSIBILITY TO VERIFY ALL PRINTS
- QUESTIONS? REFER TO CURVE CONVEYOR MANUAL or SALES REPRESENTATIVE

SCALE:	1:3072
WEIGHT:	6667.07
DATE:	10/10/2013
APPROVED BY:	
DESIGNED BY:	
DRAWN BY:	

PROPRIETARY AND CONFIDENTIAL  
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UNLESS OTHERWISE SPECIFIED, UNINSPECTED DIMENSIONS ARE TO ± 1"	METRIC TOLERANCES:
INCH TOLERANCES:	ANGULAR: ± 1.0
XX ± .001	XX ± .015
XXX ± .002	XXX ± .030
XXXX ± .005	XXXX ± .050

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 Lubing Systems, LP  
 135 Corporate Drive SW  
 Cleveland, TN 37311 USA

DWG. NO.	20131010-155807
DESCRIPTION:	

## Section 6

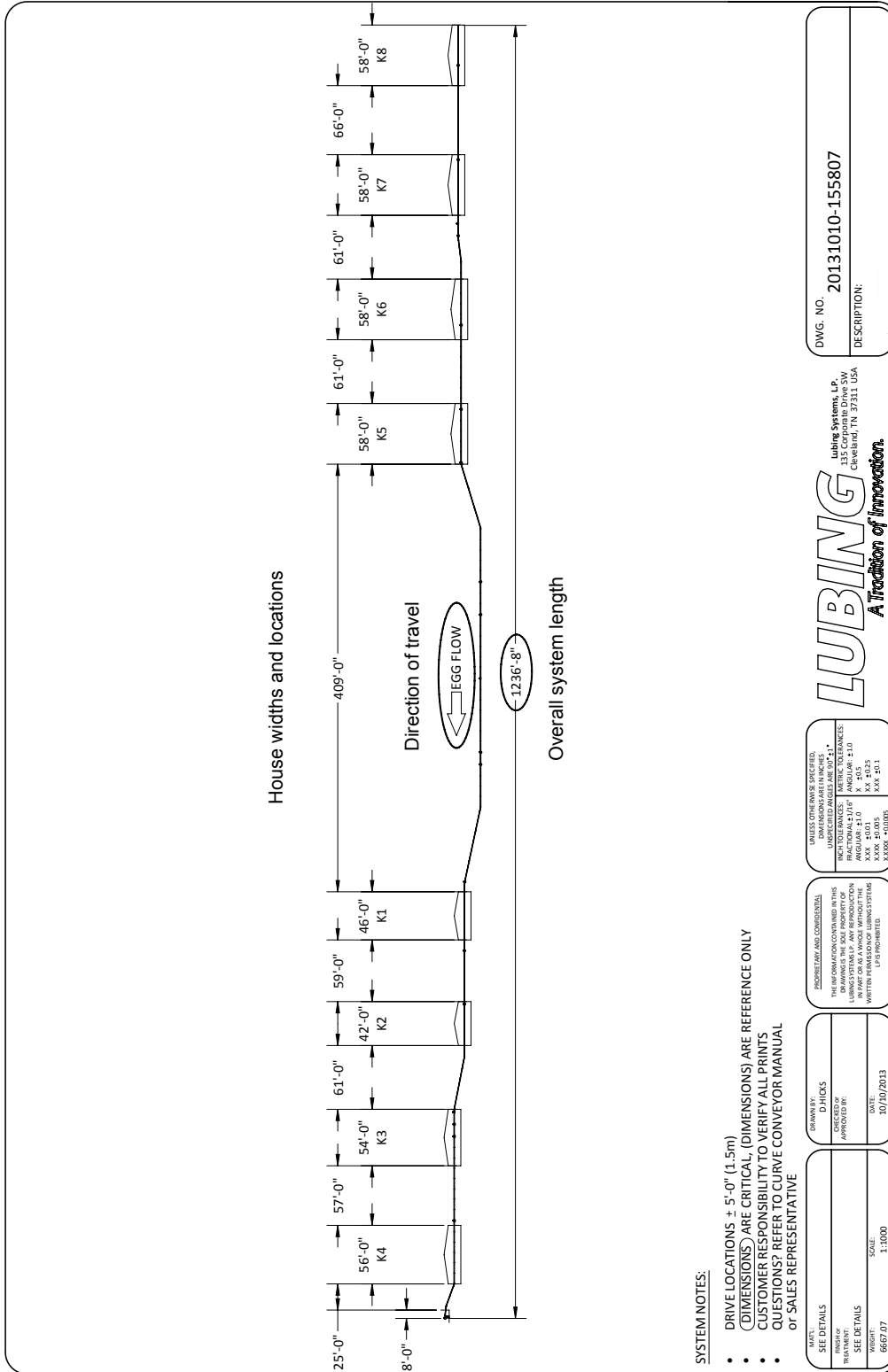
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### System Overview

13. If possible, a single sheet overview will be included in the layout drawing provided. This sheet details the overall length of the system with houses and their designations as provided by the customer.

Note: The following view illustrates an example of the overall conveyor layout. Not all details are provided on this sheet, but will be reflected on other sheets within the layout drawing provided.





## Section 6

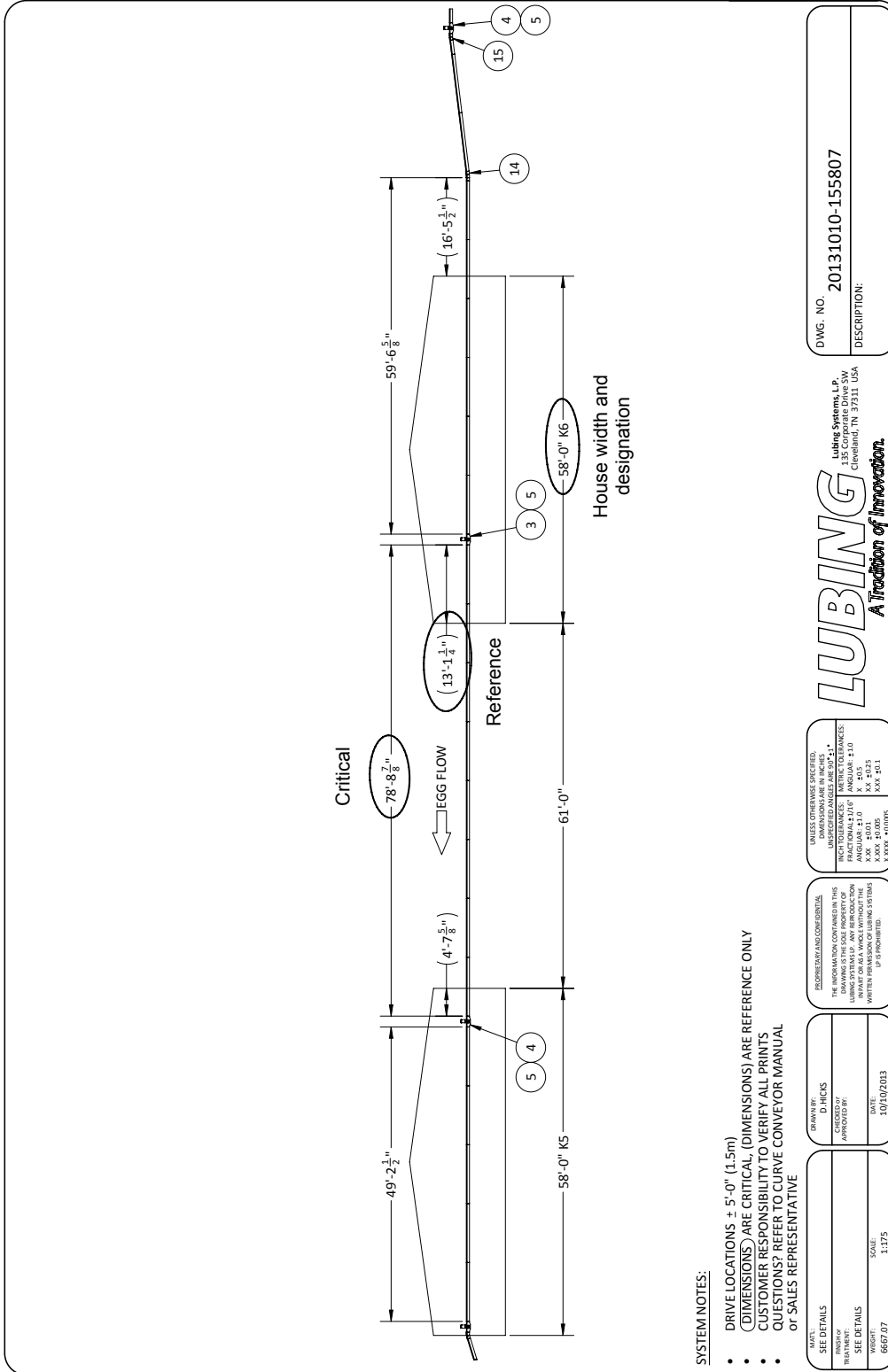
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### Locating Components

14. Lubing Systems will reference critical landmarks such as houses or other buildings on the provided layout drawing when possible. Reference dimensions, noted in parenthesis, are often provided from these landmarks to locate components within the conveyor system. However, these dimensions are superseded by critical dimensions such as lengths between two drive units or other milestone components.

Note: To ensure best performance, measure and locate components in relation to one another. Dimensions to other external landmarks should be utilized as reference only.

Note: The following view illustrates critical versus reference dimensions.



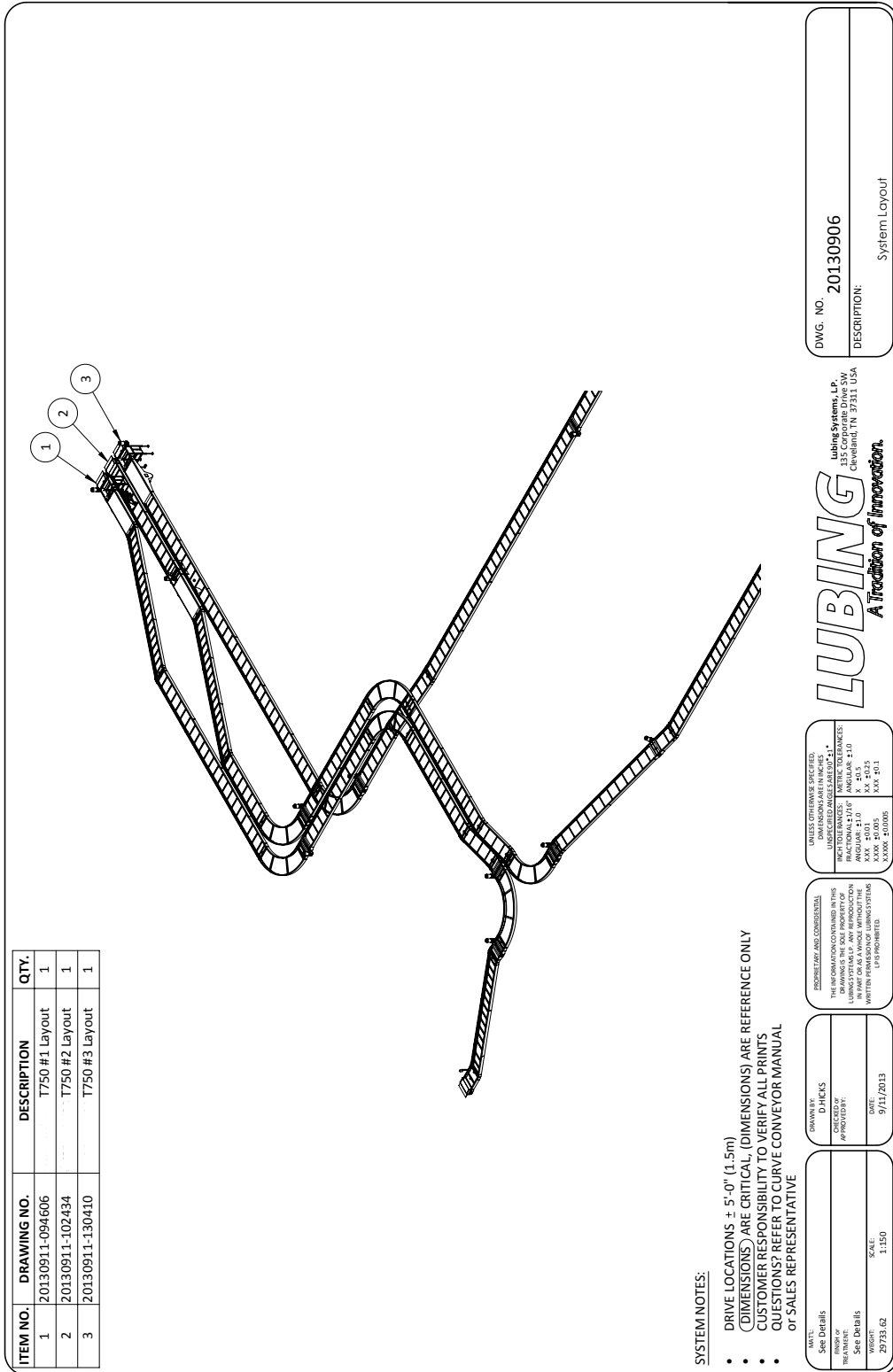
## Section 6

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### Multiple Conveyor Systems

15. When designing multiple conveyors, a total system overview may be provided as reference for the customer to review and approve areas where these systems converge. The following view illustrates a system overview of multiple conveyors to better communicate their locations relative to one another.

Note: Often this layout drawing is used when developing process equipment layouts or Accumulator Table widths and lengths.



ITEM NO.	DRAWING NO.	DESCRIPTION	QTY.
1	20130911-094606	T750 #1 Layout	1
2	20130911-102434	T750 #2 Layout	1
3	20130911-130410	T750 #3 Layout	1

**SYSTEM NOTES:**

- DRIVE LOCATIONS ± 5'-0" (1.5m)
- (DIMENSIONS) ARE CRITICAL; (DIMENSIONS) ARE REFERENCE ONLY
- CUSTOMER RESPONSIBILITY TO VERIFY ALL PRINTS
- QUESTIONS? REFER TO CURVE CONVEYOR MANUAL
- OR SALES REPRESENTATIVE

MATERIAL: See Details	DRAWN BY: D.HICKS	DATE: 9/11/2013
PROJECT: See Details	CHECKED BY: M.PROBERT	SCALE: 1:150
TITLE: 20733.02		

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------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

<p>UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES - FRACTIONAL DIMENSIONS ARE TO DECIMALS OF AN INCH - ANGULAR DIMENSIONS ARE TO NEAREST 1/4°</p> <p>XXX ± 0.01 XXX ± 0.05 XXX ± 0.10 XXX ± 0.15</p>
------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

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Lubing Systems, L.P.  
135 Corporate Drive  
Chesapeake, VA 23031, USA

DWG. NO. 20130906
DESCRIPTION: System Layout

## Section 6

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### Layout Correspondence

16. Typically, layout drawings are provided via email in PDF format for easy viewing by the customer.
17. Drawings can be provided to Lubing Systems as sketches (faxed or scanned/emailed), AutoCAD dxf/dwg formats (R2000 or older), or PDF.
18. Final Layouts can be exported and supplied to the customer in AutoCAD dxf/dwg formats as well if requested by the customer.

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## Lubing System Contact Information

# LUBING

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Contact your local Lubing Distributor or Representative for additional information regarding Lubing products.

**Northeast/Canada** MA,VT, NH, ME, RI, CT, NY, NJ, PA, DE,  
**GEORGE BAILEY** MD, VA, WV, NC, MI, OH  
Cell: (540) 908-8899 East Canada: MB, ON, QC, NB, NL, PEI  
Fax: (540) 433-7400  
E-mail: gbailey@lubingusa.com

**Southeast** AL, FL, GA, KY, IN, MS, LA, SC, TN  
**BARRY DUTTON**  
Cell: (205) 612-5625  
Fax: (240) 368-8784  
E-mail: bdutton@lubingusa.com

**Midwest/Canada** AK, AR, CO, KS, MO, ND, NE, NM,  
**STEVE KUYKENDALL** OK, SD, TX, WY  
Cell: (469) 908-8899 West Canada: AB, SK, BC, YT, NT  
Fax: (540) 433-7400  
E-mail: skuykendall@lubingusa.com

**West Coast** AZ, CA, ID, NV, OR, UT, WA, MT, HI  
**International Sales**  
**KURT HUTT**  
Cell: (432) 464-0500  
Fax: (423) 709-1001  
E-mail: khutt@lubingusa.com

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Cleveland, TN 37312 - USA  
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Fax: (423) 709-1001  
E-mail: info@lubingusa.com  
E-mail: support@lubingusa.com

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## Section 6

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### OEM Contact Information

**Stober USA (Gearboxes)**

1781 Downing Drive  
Maysville, KY 41056 USA  
(606) 759-5090 Phone  
(800) 711-3588 Toll Free  
888-4-STOBER (786237) Fax

[www.stober.com](http://www.stober.com)      Company Website  
[sales@stober.com](mailto:sales@stober.com)      Technical Support Email

**Marathon Electric - Motor Division**

100 E. Randolph Street  
P.O. Box 8003  
Wausau, WI 54401-8003  
(715) 675-3311 Phone

[www.marathonelectric.com](http://www.marathonelectric.com)      Company Website  
[motor.help@marathonelectric.com](mailto:motor.help@marathonelectric.com)      Tech Support Email

**JAX (Lubricants)**

W134 N5373 Campbell Drive  
Menomonee Falls, WI 53051  
(262) 781-8850 Phone  
(800) 782-8850 Toll Free

[www.jax.com](http://www.jax.com)      Company Website



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E: [support@lubingusa.com](mailto:support@lubingusa.com)

[www.lubingusa.com](http://www.lubingusa.com)

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