

Belt Conveyor System

Product Manual
60-in Width



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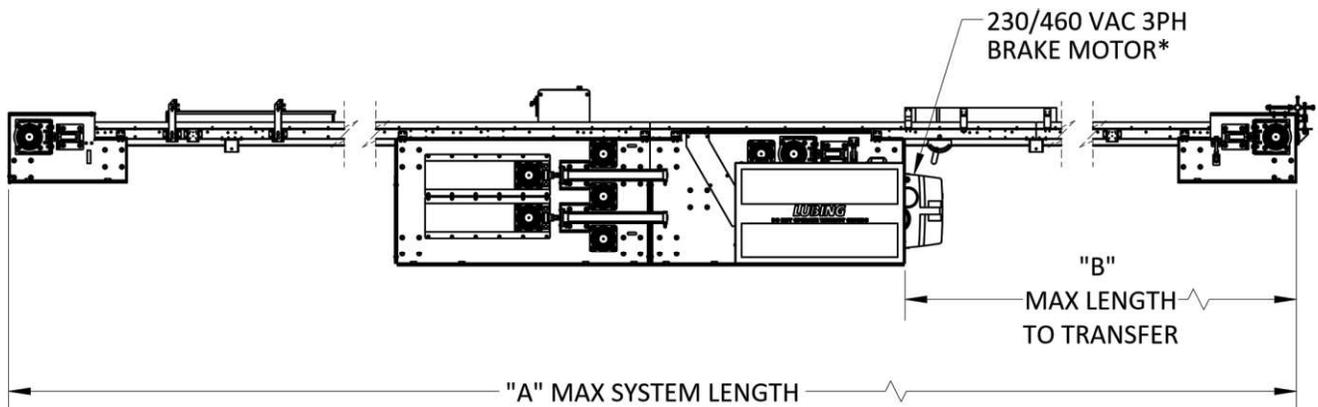
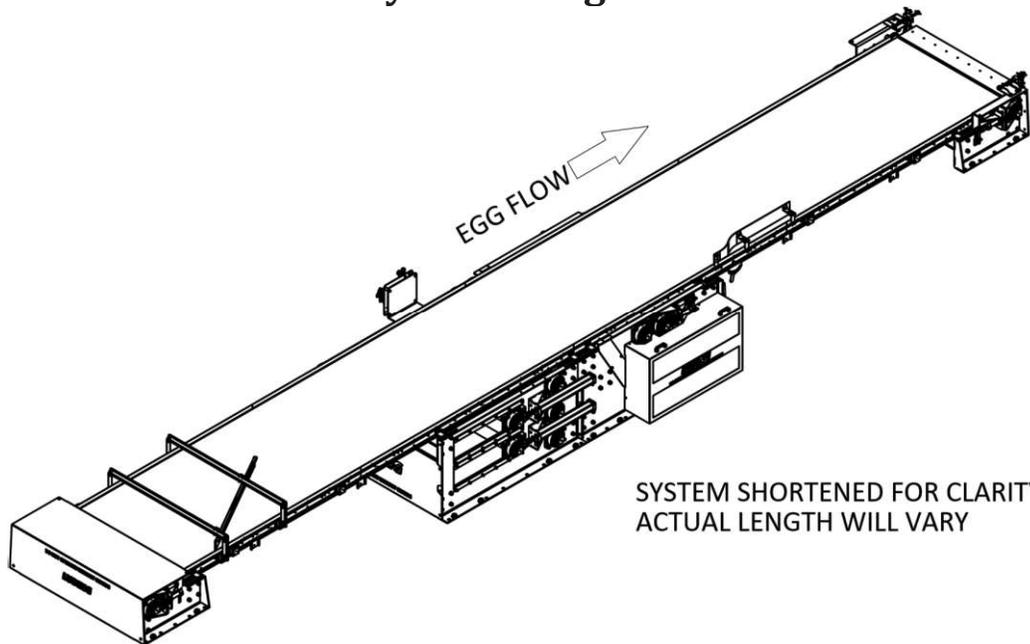
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Overview

SECTION 1 - OVERVIEW

System Length



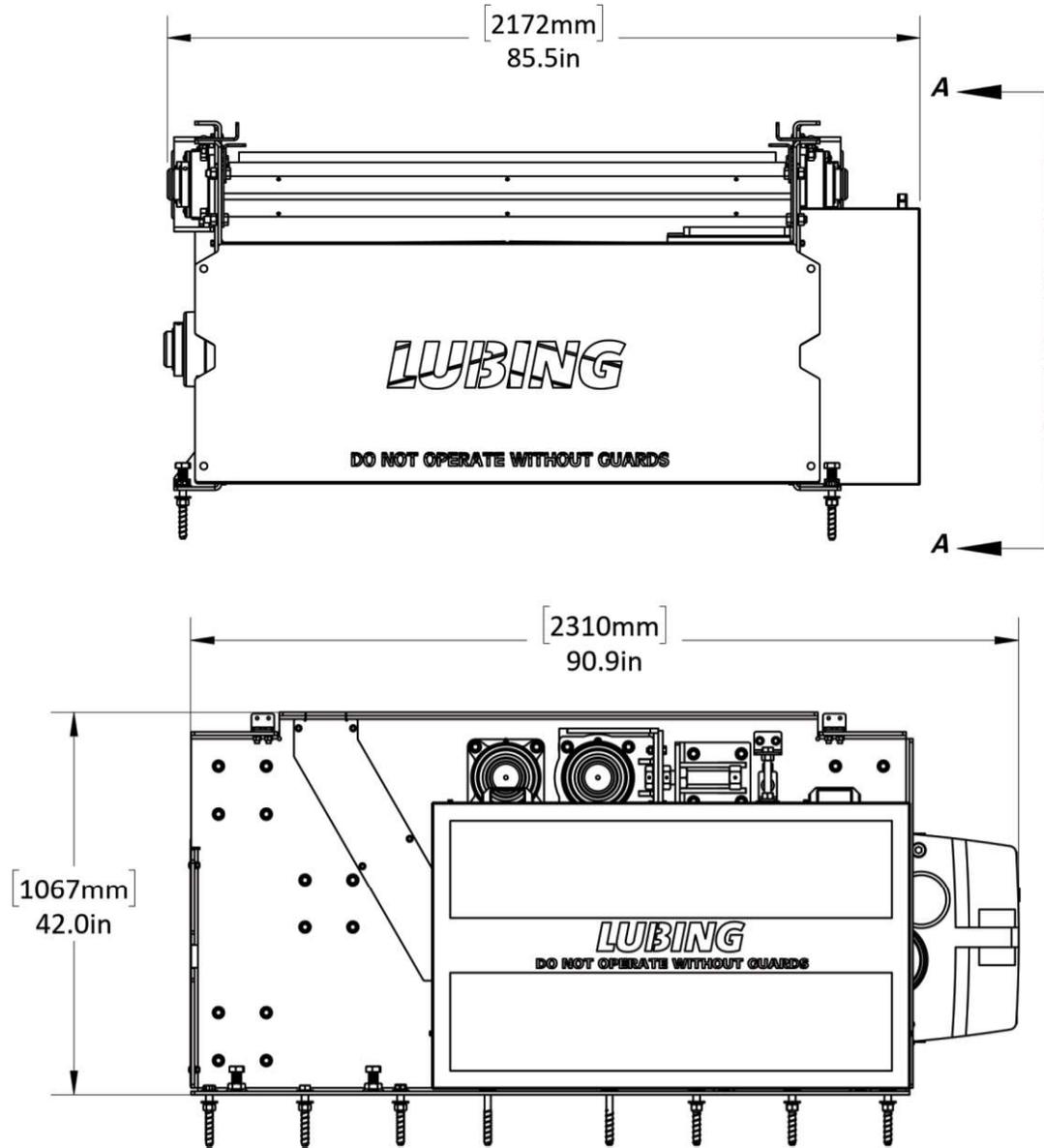
System Lengths and Capacities			
Belt Width	A (ft/meters)	B (ft/meters)	Capacity (cases/hr.)
60	2000/609	750/228	700

*REFER TO MANUFACTURER'S SPECIFICATIONS WHEN WIRING VARIABLE FREQUENCY DRIVE (VFD)

Overview

Component Dimensions

Drive Unit Dimensions

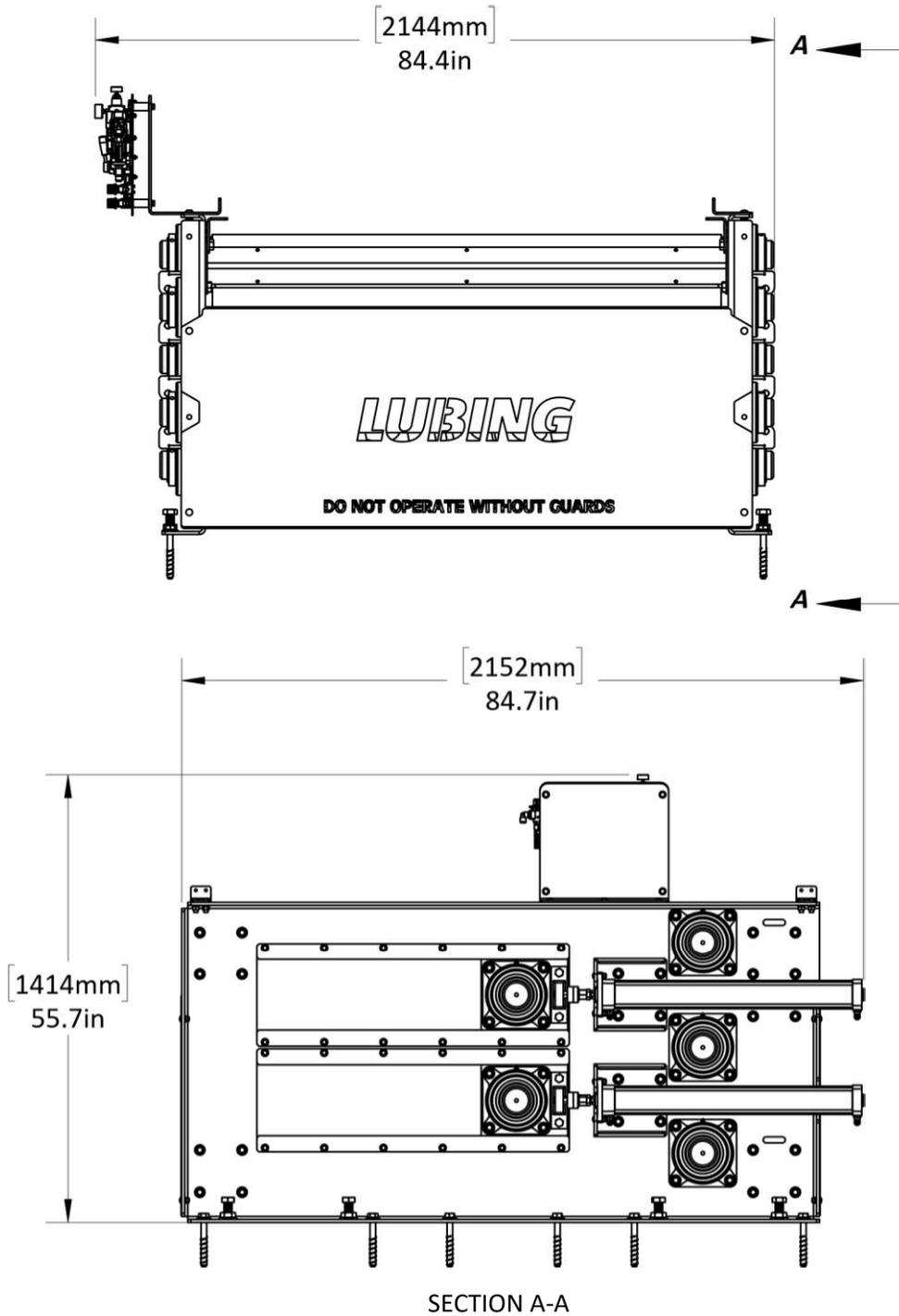


SECTION A-A

Drive Unit		
Belt Width	Part/Drawing Number	Description
60	19C F 000 00A	Drive Unit 60-in

Overview

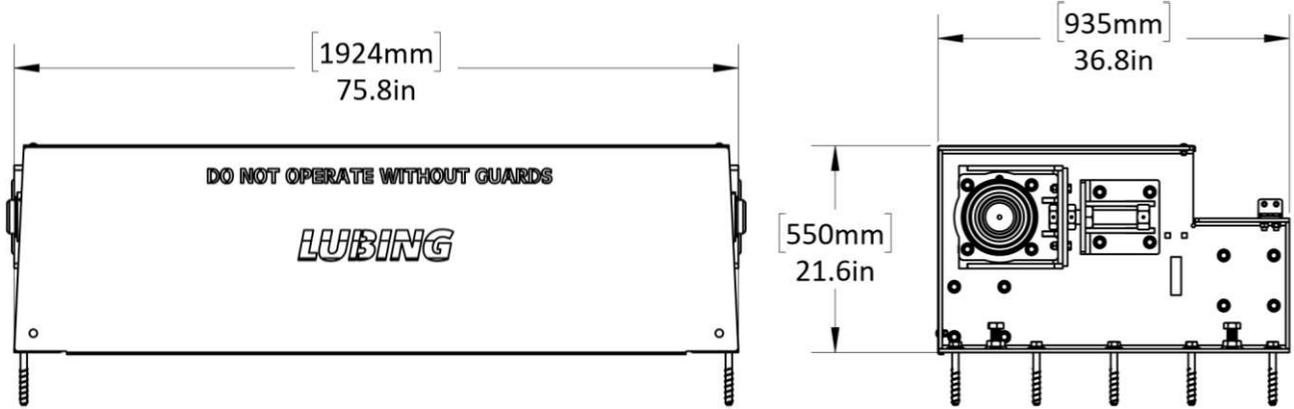
Take-up Unit Dimensions



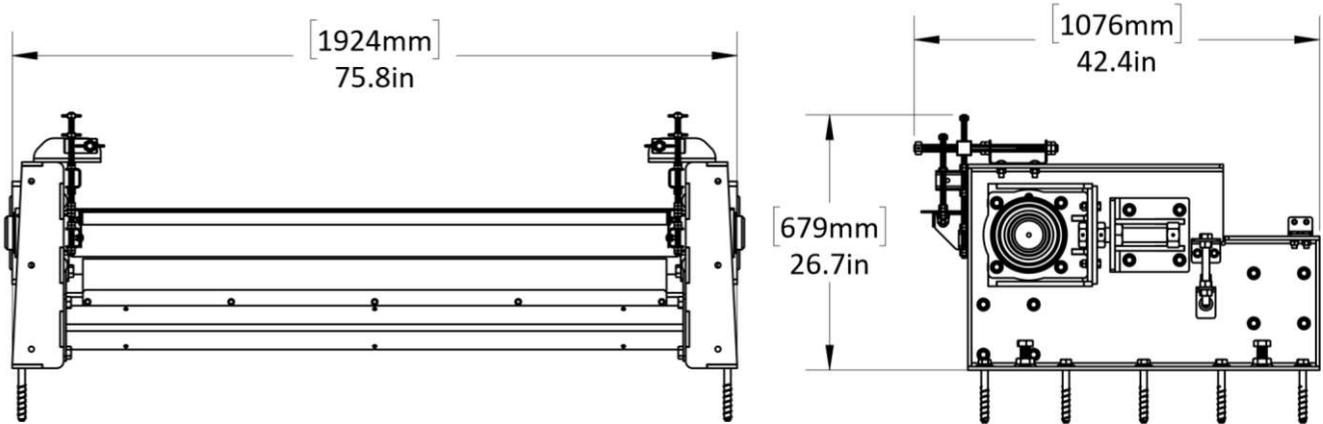
Take-up Unit		
Belt Width	Part/Drawing Number	Description
60	19C G 000 00A	Take-up Unit 60-in

Overview

End Unit Dimensions



End Unit Back 60-in

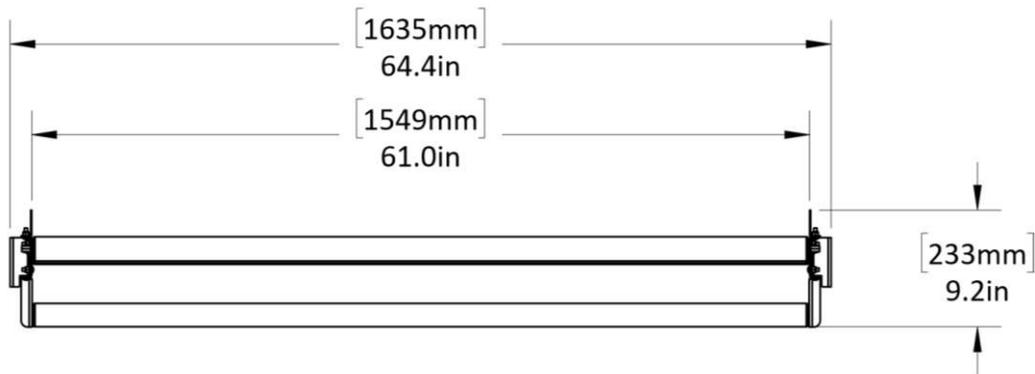
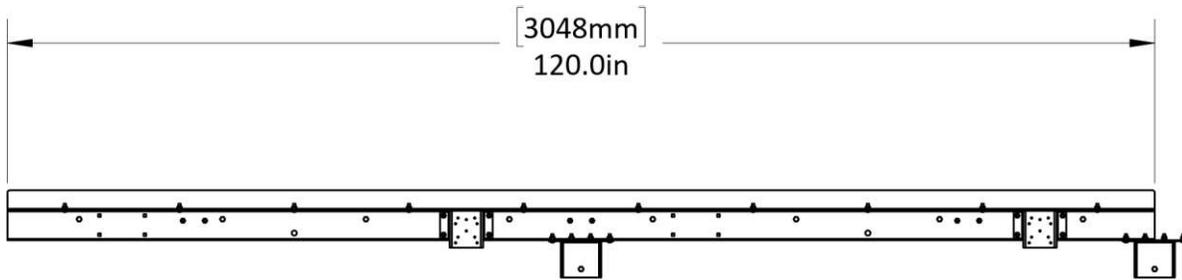


End Unit Front 60-in

End Unit		
Belt Width	Part/Drawing Number	Description
60	19C E 000 00B	End Unit Back 60-in
60	19C E 200 00B	End Unit Front 60- in

Overview

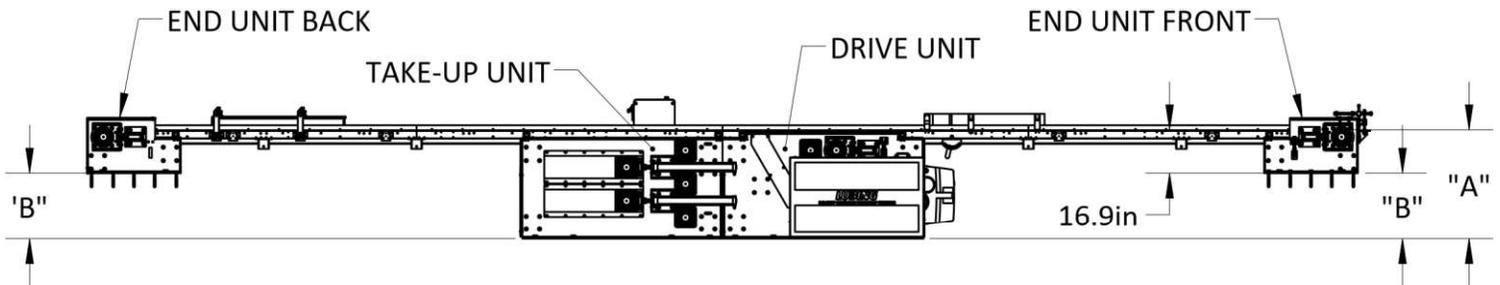
Connecting Part Dimensions



Connecting Part		
Belt Width	Part/Drawing Number	Description
60	19C C 000 00A	Connecting Part 60-in

Overview

Calculating Floor Support Heights



DETERMINE TRANSFER HEIGHT "A" AT END UNIT FRONT

$A - 16.9" = \text{END UNIT SUPPORT STAND HEIGHT "B"}$

IF "B" IS HIGHER THAN 25.9", DRIVE UNIT/TAKE-UP UNIT FLOOR SUPPORTS WILL BE REQUIRED

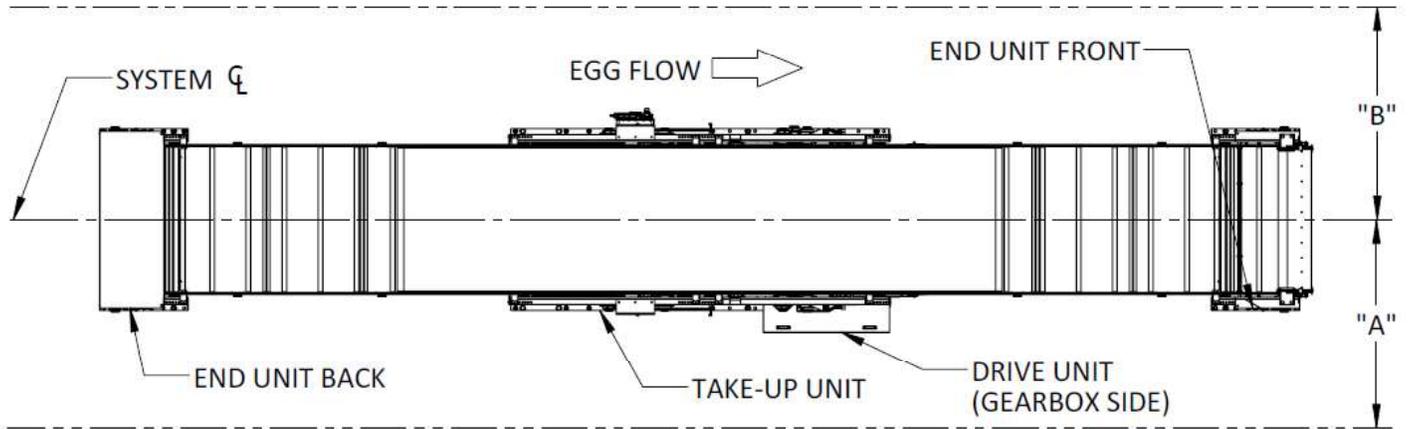
$B - 25.9" = \text{DRIVE UNIT/TAKE-UP UNIT SUPPORT STAND HEIGHT}$

CALCULATIONS ASSUME LEVEL FLOOR AND CONSISTENT ELEVATION, IF FLOOR ELEVATION CHANGES AT THE LOCATION OF THE COMPONENTS ABOVE, ADDITIONAL HEIGHT MAY BE REQUIRED

FLOOR SUPPORT/SUPPORT STAND CONSTRUCTION
MAY DIFFER BASED ON TOTAL HEIGHTS REQUIRED

Overview

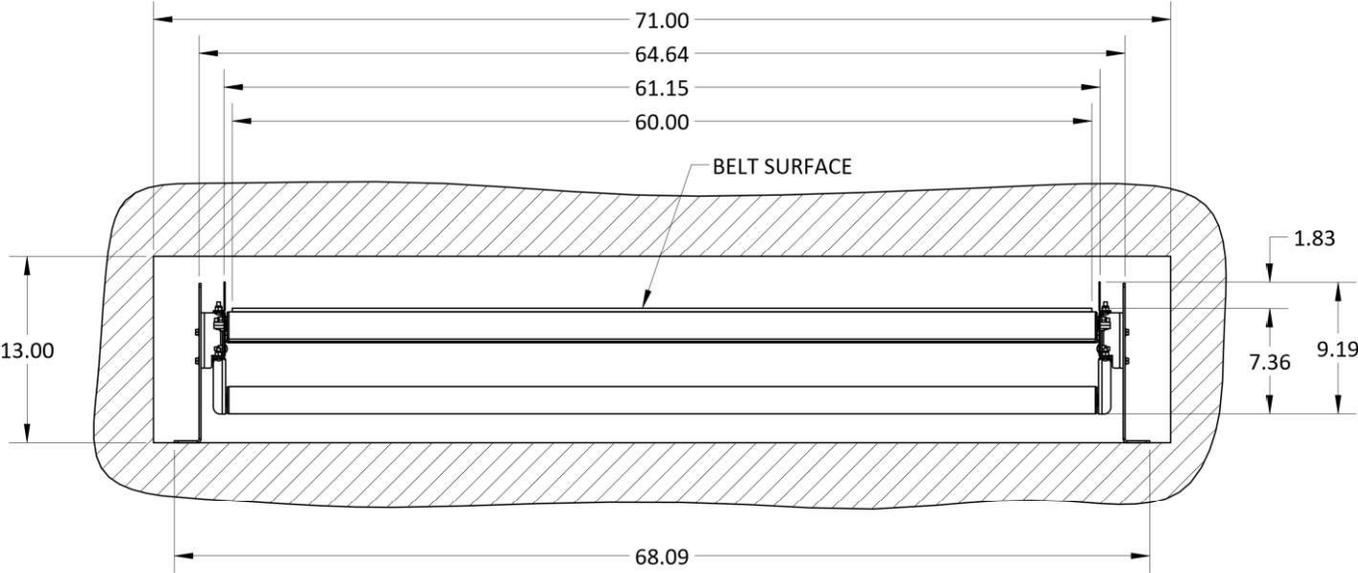
Recommended Clearance



Drive Unit			
Belt Width	Component	A Min (inches/mm)	B Min (inches/mm)
60	Drive Unit/Take-up Unit	114/2896	54/1372
60	End Units/Connecting Parts	96/2438	48/1219

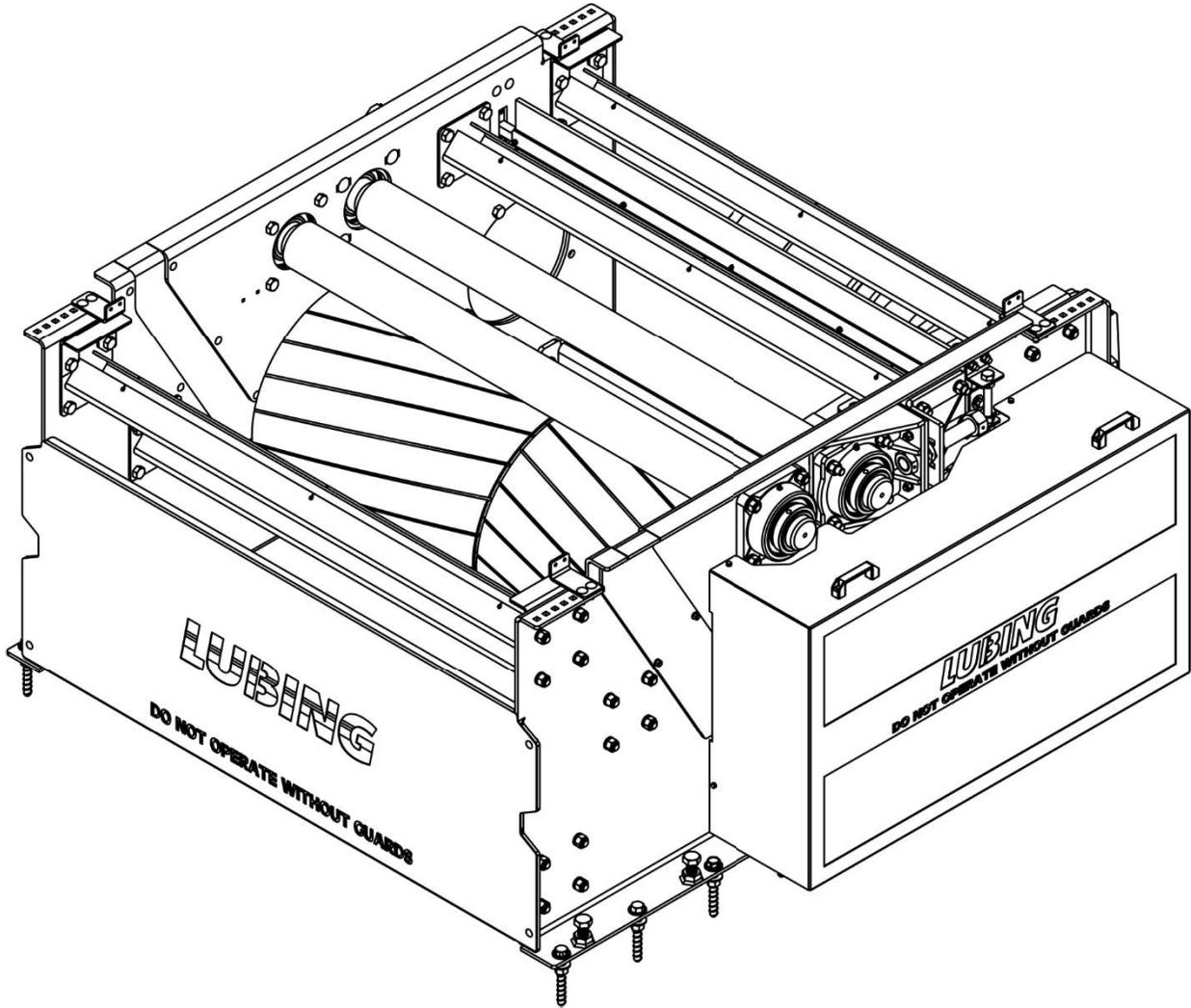
Overview

Recommended Wall Penetration



Component Details

SECTION 2 - COMPONENT DETAILS Drive Unit



Drive Unit			
Belt Width	Part Number	Drawing Number	Description
60	19C F 000 00A	19C F 000 00A	Drive Unit 60-in (SHOWN)
60	19C F 300 00A	19C F 000 00A	Drive Unit Opp. (DRIVE OPP. SIDE)

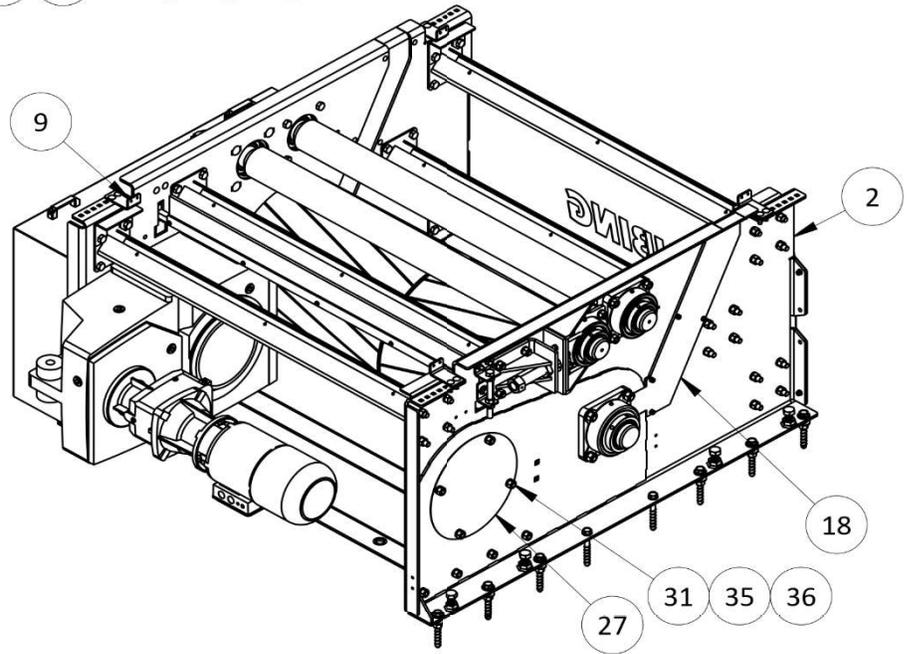
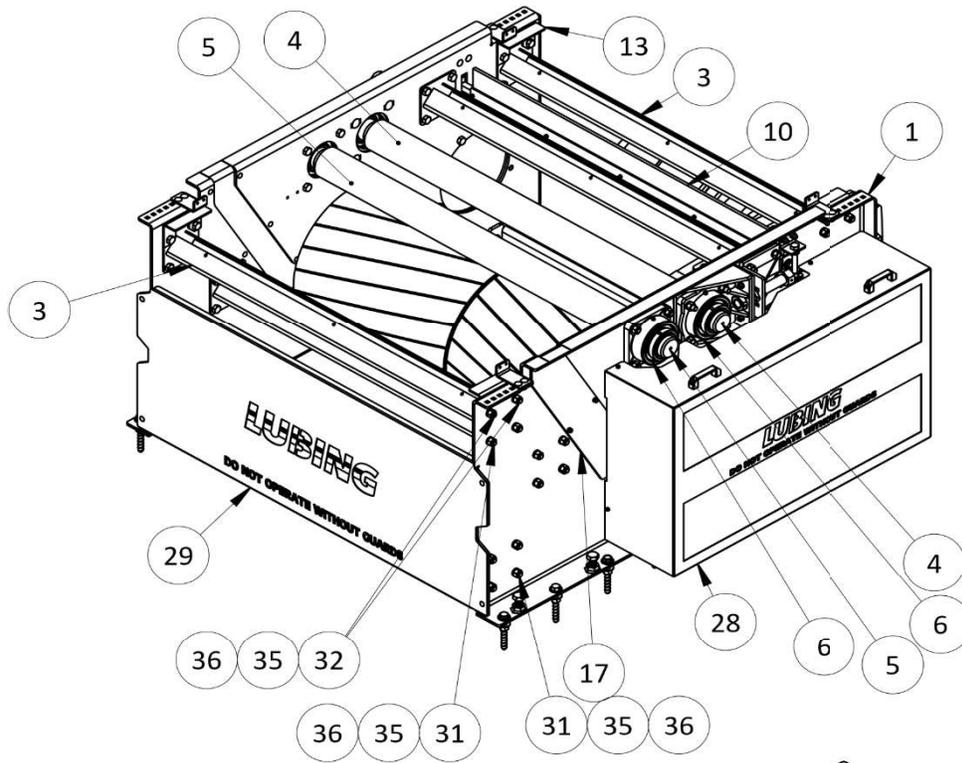
Component Details

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	Shown	Drive Opposite Side
1	19C F 000 01A	19C F 000 01A	Drive Unit Side Sheet Weldment	1	1
2	19C F 000 01A	19C F 000 02A	Drive Unit Side Sheet Weldment Opp.	1	1
3	19C G 000 14A	19C G 000 14A	Horizontal Brace	5	5
4	19C G 000 09B	19C G 000 10B	Straight Roller, Tracking 60-in	1	1
5	19C G 000 09B	19C G 000 09B	Straight Roller 60-in	1	1
6	19C F 000 12A	19C F 000 12A	4 Bolt Flange Bearing 3.5"	4	4
7	19C E 000 04A	19C E 000 04A	Tracking Bracket Assembly	2	2
8	19C E 000 07A	19C E 000 07A	Tracking Adjustment Rod	2	2
9	19C G 000 13A	19C G 000 13A	Connecting Part Mounting Bracket	4	4
10	19C F 100 00A	19C F 100 00A	Belt Scraper Assembly, 60-in	1	1
11	19C F 000 08A	19C F 000 08A	Belt Scraper Adjustment Bracket	2	2
12	19C F 000 07A	19C F 000 07A	Belt Scraper Adjustment Bracket Fixed	2	2
13	19C G 000 12A	19C G 000 12A	Connecting Part Support Angle	4	4
14	19C F 000 10A	19C F 000 10A	60-IN Drum Roller with Shaft	1	1
15	19C F 000 09A	19C F 000 09A	Single Brace, Drive	2	2
16	19C F 000 16A	19C F 000 16A	Parallel Shaft Gear Reducer w/ NEMA Brakemotor	1	1
17	19C F 000 05A	19C F 000 05A	Drive Removal Slot Cover	1	1
18	19C F 000 05A	19C F 000 06A	Drive Removal Slot Cover Opp.	1	1
19	19C F 000 12A	19C F 000 13A	4 Bolt Flange Bearing 4-in	2	2
20	19C E 000 03A	19C E 000 03A	Bearing Slide Plate Weldment, Tracking	2	2
21	19C F 000 14A	19C F 000 14A	Sprocket 240B21	1	1
22	19C F 000 14A	19C F 000 15A	Sprocket 240B21 w/ 4" Bore	1	1
23	19C F 000 18A	19C F 000 18A	RS240 Roller Chain for 60-in Belt	1	1
24	19C F 000 17A	19C F 000 17A	Snapidle SI-240 Chain Tensioner	1	1
25	19C E 000 05A	19C E 000 05A	Bearing Push Plate	2	2
26	19C E 000 06A	19C E 000 06A	Tracking Bracket Push Plate Reinforcement	2	2
27	19C F 000 04A	19C F 000 04A	Drive Hole Cover	1	1
28	19C F 200 00A	19C F 200 00A	Drive Guard Assembly	1	-
28	19C F 200 00A	19C F 400 00A	Drive Guard Assembly Opp.	-	1
29	19C G 000 18A	19C G 000 18A	End Guard	1	1
30		F8-7-29-2-48	7/8-9 x Hex Head Bolt Stainless	8	8
31		F8-7-27-2-28	3/4-10 x 1-3/4" Hex Bolt, Stainless	16	28
32		F8-7-27-2-32	3/4-10 x 2" Hex Bolt, Stainless	4	8
33		F8-7-27-2-40	3/4-10 x 2-1/2" Hex Bolt, Stainless	24	36

Component Details

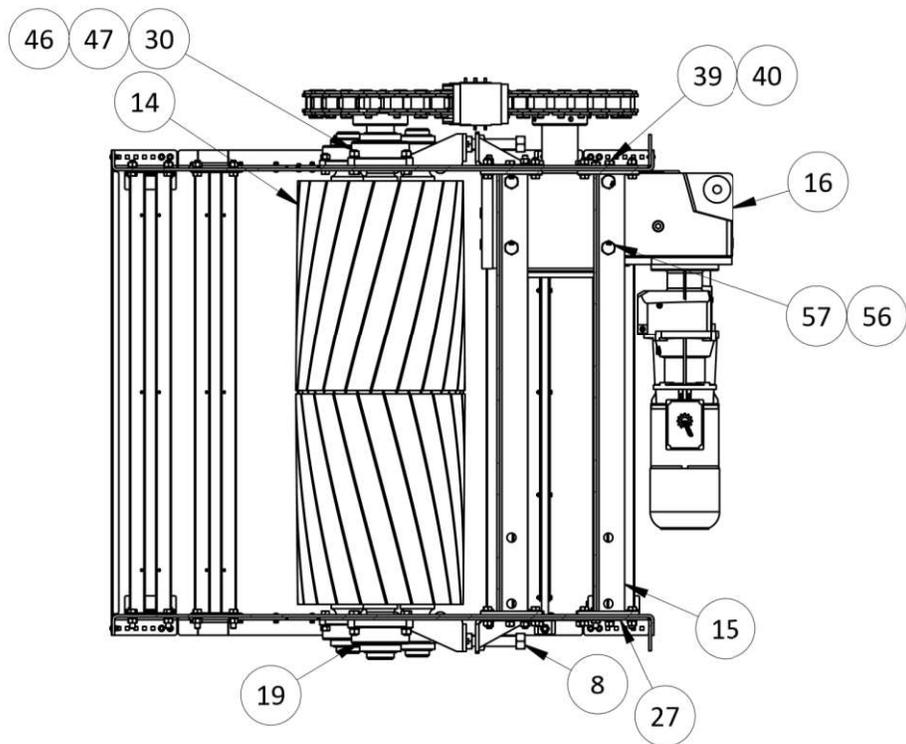
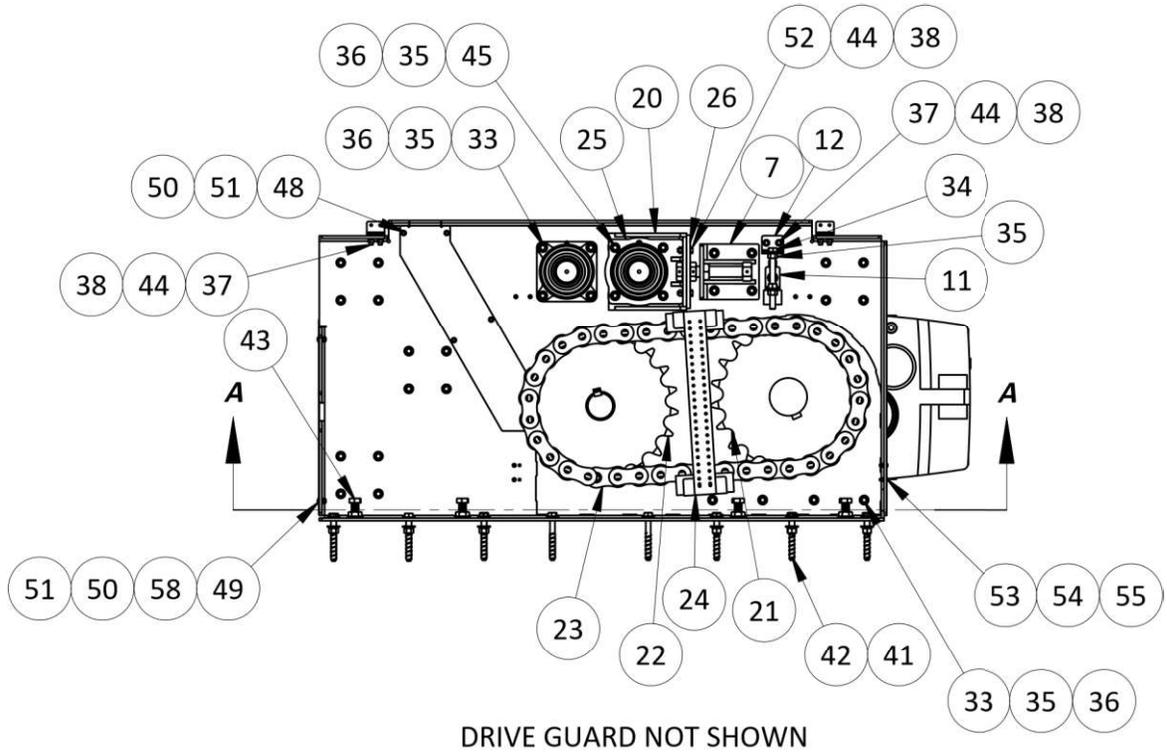
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	Shown	Drive Opposite Side
34		F8-7-27-2-96	3/4-10 x 6" Full Thread Hex Bolt, Stainless	2	2
35		F8-22-27-0-0	3/4-10 Hex Nut, Stainless	86	86
36		F8-96-27-0-0	3/4" Lock Washer, Stainless	81	80
37		F8-3-23-2-24	1/2-13 x 1-1/2" Carriage Bolt, Stainless	6	12
38		F8-96-23-0-0	1/2" Lock Washer, Stainless	8	16
39		F9-7-60-2-251	M20 x 40 Hex Bolt	8	8
40		F8-96-50-0-0	M10 Lock Washer, Stainless	8	8
41		F8-92-27-0-0	3/4" Flat Washer, Stainless	34	36
42		F9-77-27-0-96	3/4" x 6" Masonry Hex Head Screw, Zinc	16	16
43		F4-7-31-6-40	1"-5 x 2-1/2" Full Thread Acme Hex Bolt, Steel	8	8
44		F8-22-23-2-0	1/2-13 Hex Nut (Stainless)	16	16
45		F8-3-27-2-48	3/4-10 x 2-1/2" Carriage Bolt, Stainless	4	8
46		F8-96-27-0-0	3/4" Lock Washer, Stainless	8	8
47		F8-22-29-2-0	7/8-9 Hex Nut Stainless	8	8
48		F8-3-21-2-20	3/8-16 x 1-1/4" Carriage Bolt, Stainless	6	12
49		F8-3-21-2-16	3/8-16 x 1" Carriage Bolt, Stainless	4	4
50		F8-96-21-0-0	3/8" Lock Washer, Stainless	10	16
51		F8-22-21-0-0	3/8-16 Hex Nut, Stainless	10	16
52		F8-7-23-2-24	1/2-13 x 1-3/4" Hex Bolt, Stainless	2	4
53		F8-3-19-2-16	1/4-20 x 1" Carriage Bolt, Stainless	8	8
54		F8-96-19-0-0	1/4" Lock Washer, Stainless	8	10
55		F8-22-19-2-0	1/4-20 Hex Nut (Stainless)	8	8
56		F9-98-70-0-0	M30 Lock Washer	4	4
57		F9-7-70-2-191	M30 x 50 Hex Head Bolt	4	4
58		F8-92-21-0-0	3/8" Flat Washer, Stainless	4	4
59		F8-7-27-2-36	3/4-10 x 2-1/4" Hex Bolt, Stainless	28	-
60		F8-3-23-2-24	1/2-13 x 1-1/2" Carriage Bolt, Stainless	6	-
61		F9-96-23-0-0	1/2" Lock Washer, Zinc	8	-
62		F8-3-27-2-48	3/4-10 x 2-1/2" Carriage Bolt, Stainless	4	-
63		F8-3-21-2-12	3/8-16 x .75" Carriage Bolt, Stainless	6	-
64		F9-96-21-0-0	3/8" Lock Washer, Zinc	6	-
65		F9-22-21-0-0	3/8-16 Hex Nut, Zinc	6	-
66		91247A740	1/2-13 x 8" Hex Bolt, Zinc	2	-

Component Details



DRIVE MAY BE MOUNTED ON EITHER SIDE OF UNIT

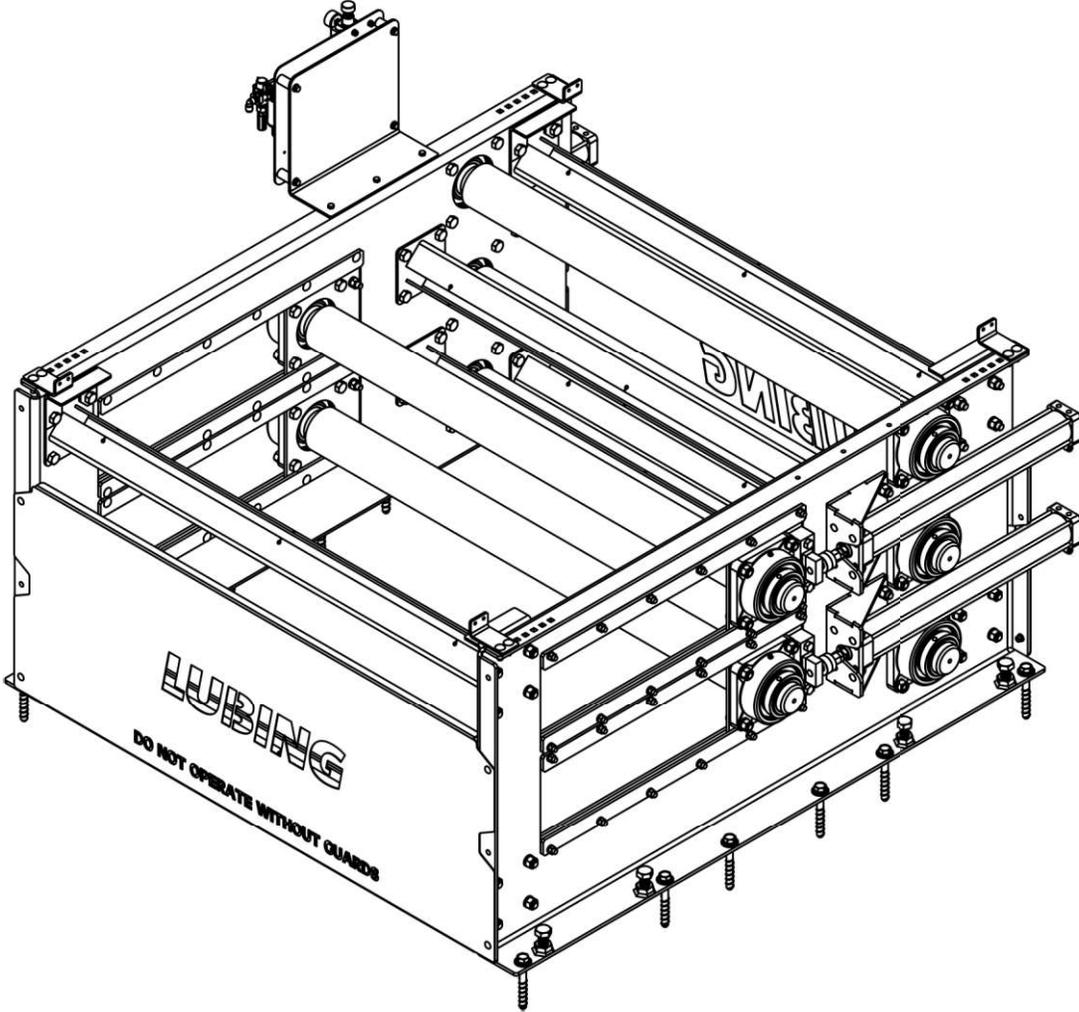
Component Details



SECTION A-A

Component Details

Take-up Unit

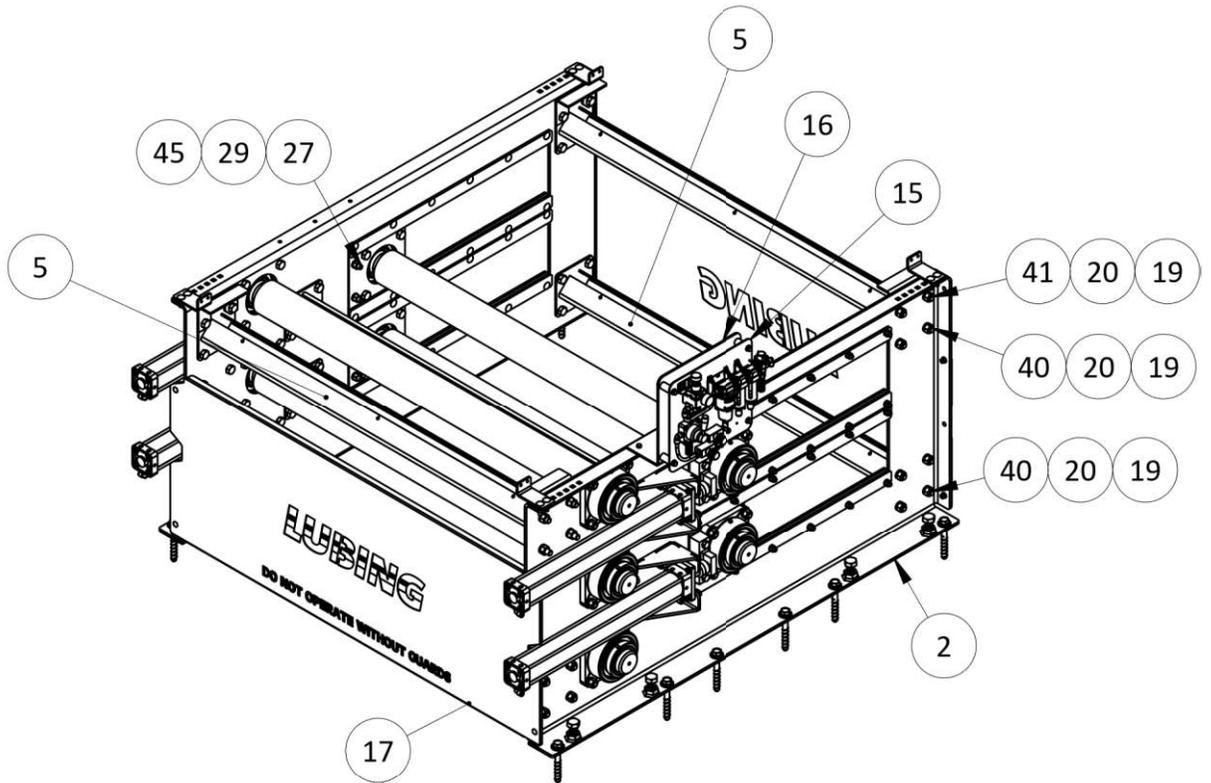
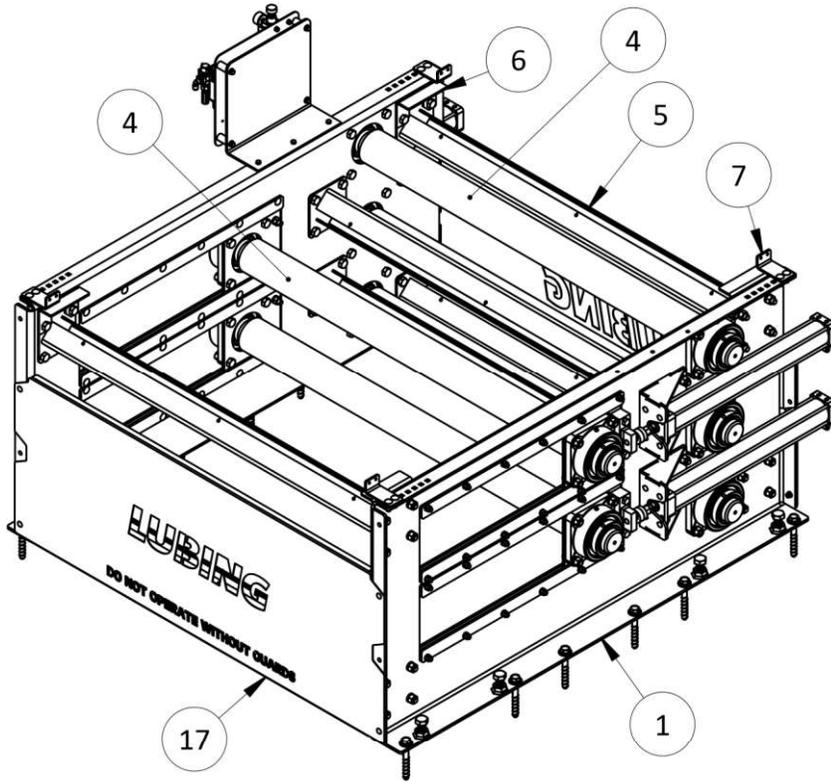


Take-up Unit			
Belt Width	Part Number	Drawing Number	Description
60		19C G 000 00A	Take-up Unit 60-in

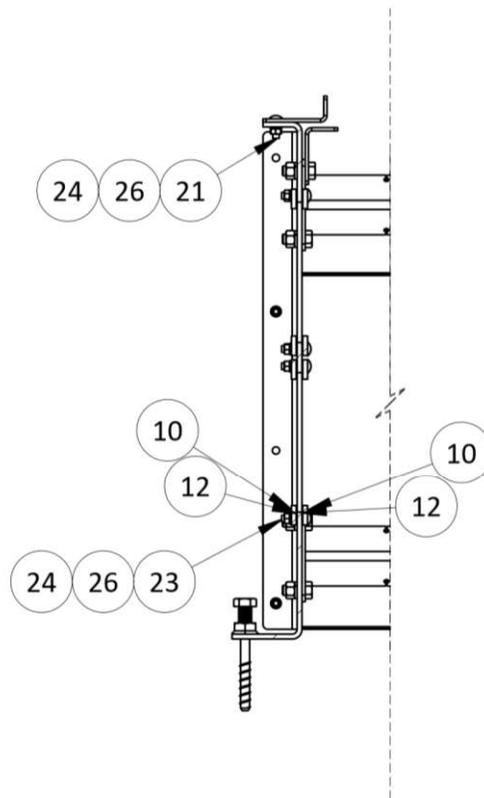
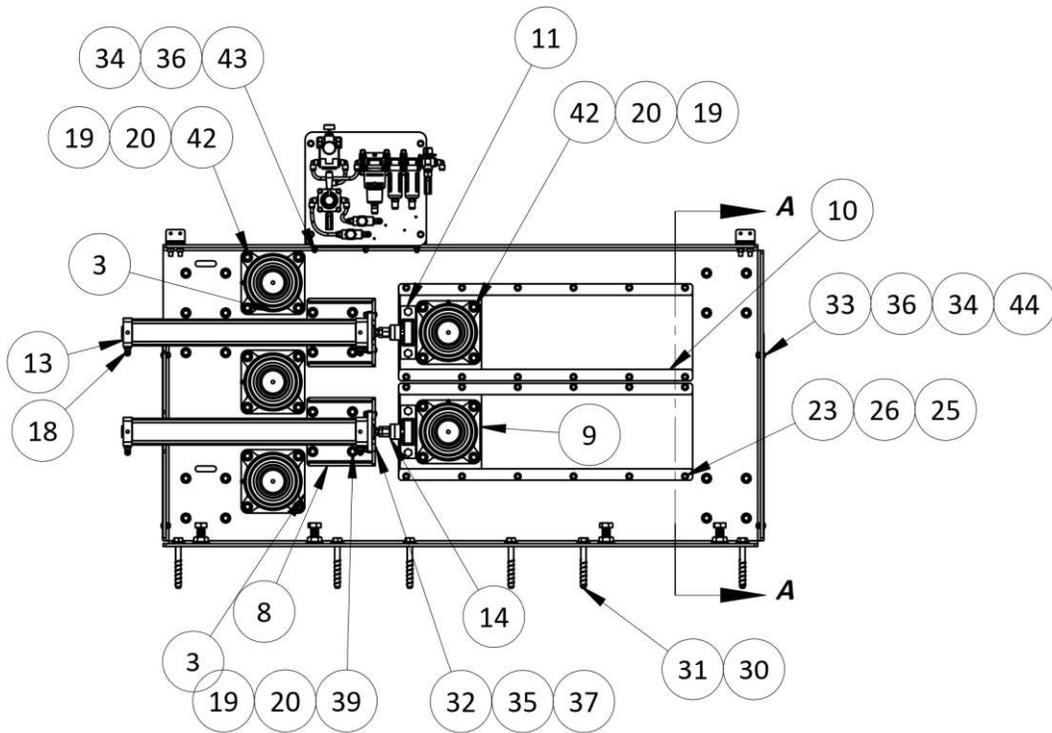
Component Details

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	19C G 000 01B	19C G 000 01B	Take up Unit Side Sheet	1
2	19C G 000 01A	19C G 000 02A	Take up Unit Side Sheet Opp.	1
3	19C F 000 12A	19C F 000 12A	4 Bolt Flange Bearing 3.5"	10
4	19C G 000 09B	19C G 000 09B	Straight Roller 60-in	5
5	19C G 000 14A	19C G 000 14A	Horizontal Brace	6
6	19C G 000 12A	19C G 000 12A	Connecting Part Support Angle	4
7	19C G 000 13A	19C G 000 13A	Connecting Part Mounting Bracket	4
8	19C G 000 03A	19C G 000 03A	Cylinder Mount Weldment	4
9	19C G 000 05A	19C G 000 05A	Bearing Slide Plate Take-up	4
10	19C G 000 04A	19C G 000 04A	Slider Plate Holding Plate Take-up	16
11	19C G 000 06A	19C G 000 06A	Floating Joint Support	4
12	19C G 000 07A	19C G 000 07A	Sliding Bearing Holding Plate Shim, Take-up	16
13	19C G 000 15A	19C G 000 15A	Take-up Assembly Air Cylinder	4
14	19C G 000 16A	19C G 000 16A	SMC Floating Joint NJ12	4
15	19C G 100 00A	19C G 100 00A	Pneumatic Panel	1
16	19C G 000 17A	19C G 000 17A	Pneumatic Panel Mount Bracket	1
17	19C G 000 18A	19C G 000 18A	End Guard	2
18		KQ2L11-37S	1/2" NPT Tube Elbow Fitting	8
19		F8-96-27-0-0	3/4" Lock Washer, Stainless	92
20		F8-22-27-0-0	3/4-10 Hex Nut, Stainless	92
21		F8-3-23-2-24	1/2-13 x 1-1/2" Carriage Bolt, Stainless	4
22		F8-3-23-2-24	1/2-13 x 1-1/2" Carriage Bolt, Stainless	4
23		F8-3-23-2-32	1/2-13 x 2" Carriage Bolt, Stainless	48
24		F8-96-23-0-0	1/2" Lock Washer, Stainless	5
25		F9-96-23-0-0	1/2" Lock Washer, Zinc	51
26		F8-22-23-2-0	1/2-13 Hex Nut (Stainless)	56
27		F8-7-25-2-56	5/8-11 x 3-1/2" Hex Bolt, Stainless	8
28		F9-96-25-0-0	5/8" Lock Washer, Zinc	4
29		F8-22-25-0-0	5/8-11 Hex Nut, Stainless	8
30		F8-92-27-0-0	3/4" Flat Washer, Stainless	12
31		F9-77-27-0-96	3/4" x 6" Masonry Hex Head Screw, Zinc	12
32		F8-3-21-2-24	3/8-16 x 1-1/2" Carriage Bolt, Stainless	16
33		F8-3-21-2-16	3/8-16 x 1" Carriage Bolt, Stainless	8
34		F8-96-21-0-0	3/8" Lock Washer, Stainless	19
35		F9-96-21-0-0	3/8" Lock Washer, Zinc	8
36		F8-22-21-0-0	3/8-16 Hex Nut, Stainless	19
37		F9-22-21-0-0	3/8-16 Hex Nut, Zinc	8
38		F4-7-31-6-40	1"-5 x 2-1/2" Full Thread Acme Hex Bolt, Steel	8
39		F8-7-27-2-36	3/4-10 x 2-1/4" Hex Bolt, Stainless	28
40		F8-7-27-2-28	3/4-10 x 1-3/4" Hex Bolt, Stainless	20
41		F8-7-27-2-32	3/4-10 x 2" Hex Bolt, Stainless	8
42		F8-7-27-2-40	3/4-10 x 2-1/2" Hex Bolt, Stainless	36
43		F8-7-21-2-20	3/8-16 x 1-1/4" Hex Bolt, Stainless	3
44		F8-92-21-0-0	3/8" Flat Washer, Stainless	8
45		F8-96-25-0-0	5/8" Lock Washer, Stainless	4

Component Details



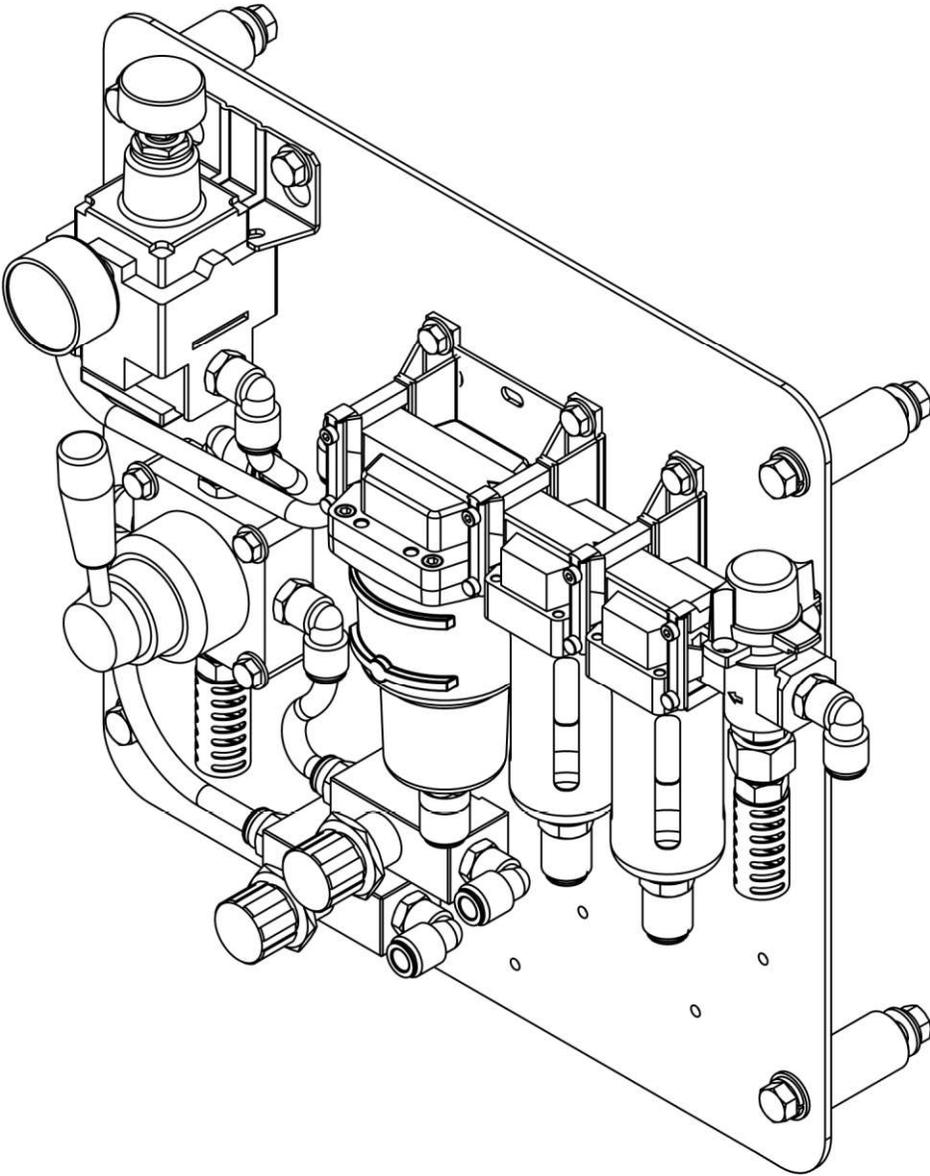
Component Details



SECTION A-A

Component Details

Pneumatic Panel

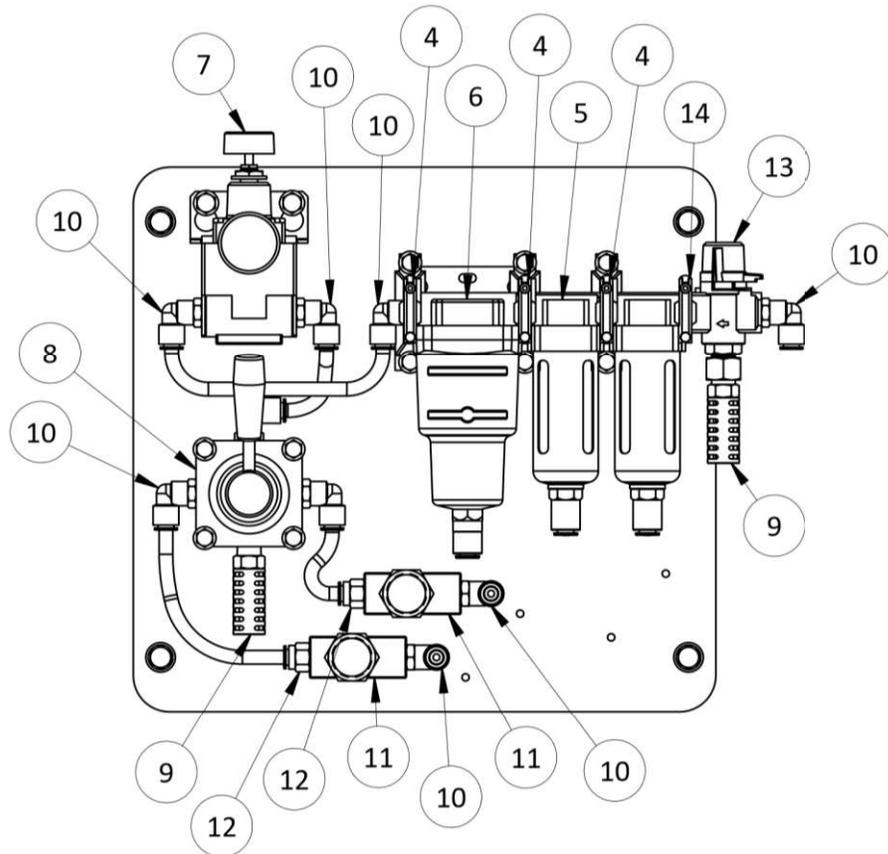
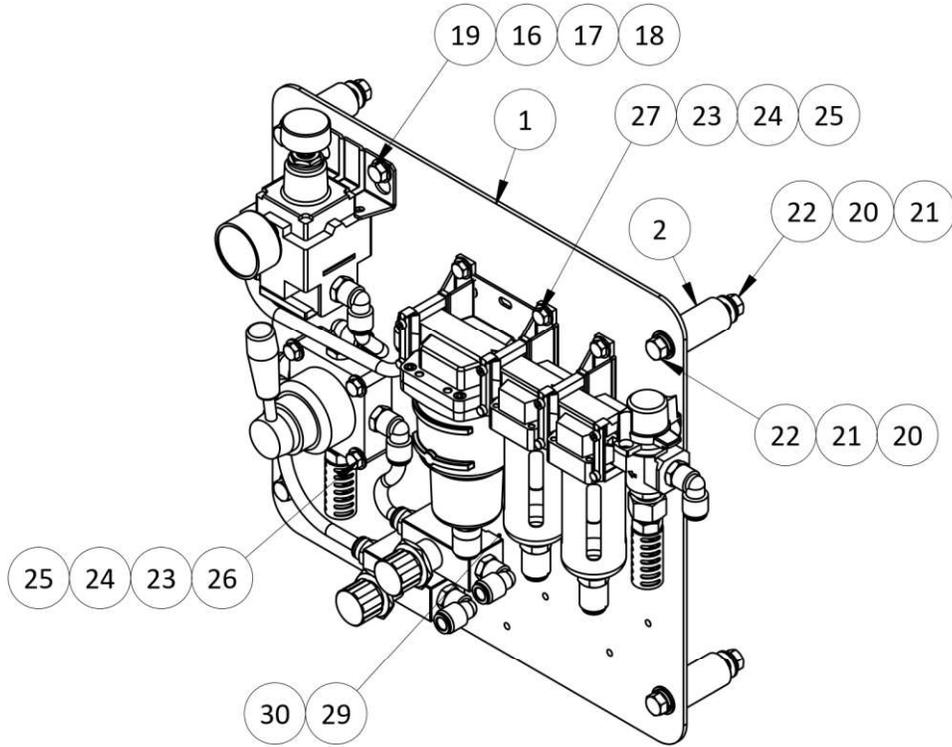


Pneumatic Panel			
Belt Width	Part Number	Drawing Number	Description
60	--	19C G 100 00A	Pneumatic Panel

Component Details

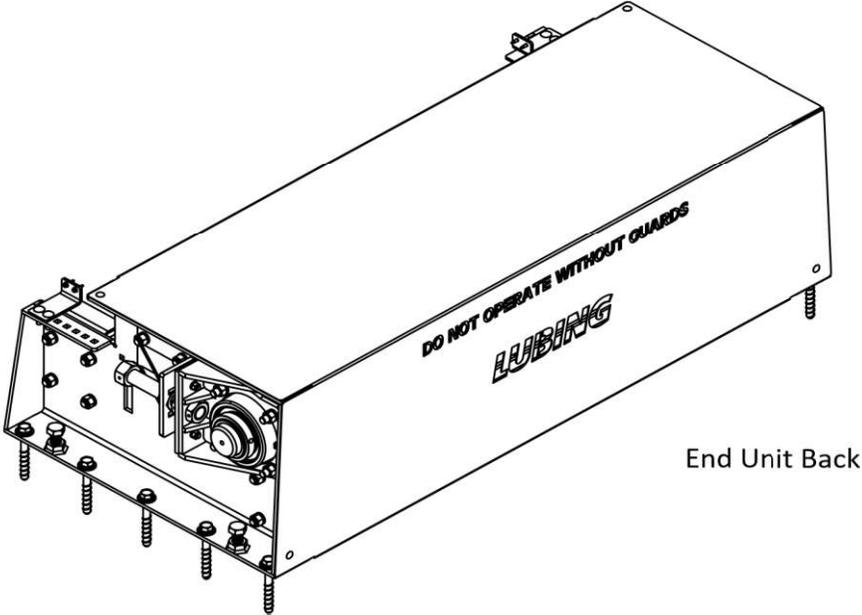
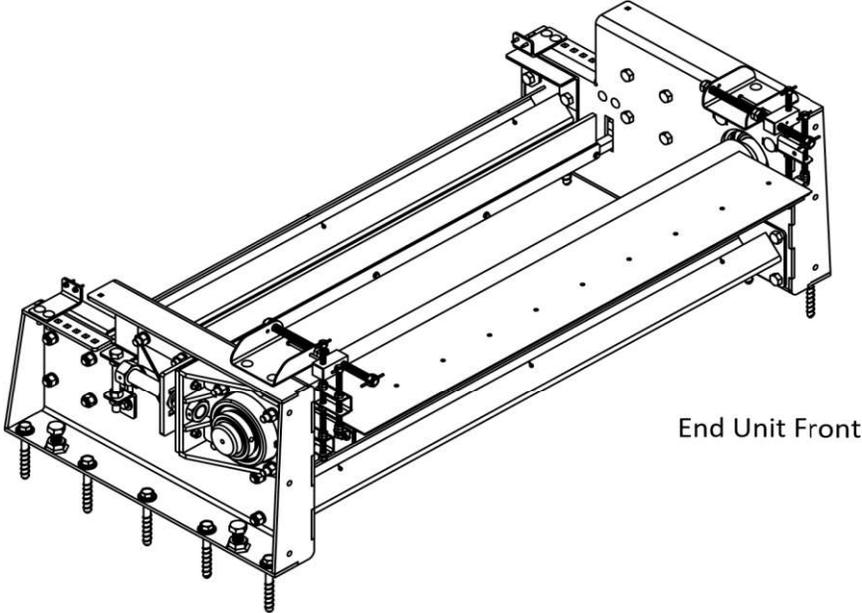
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	704 011 06 00A	704 011 06 00A	Pneumatic Panel	1
2	704 011 05 00	704 011 05 00	Pneumatic Plate Standoff	4
3		AF30-N03-Z	Air Filter	1
4		Y300T	Mounting Bracket	3
5		AFM30-N03C-Z	Mist Separator	1
6		AMG250C-N03BD	Water Separator	1
7		IR3020-N03BG	Precision Regulator	1
8		VH302-N03	Mechanical Hand Valve	1
9		AN303-03	Silencer	2
10		KQ2L11-36S	3/8" NPT Tube Elbow Fitting	9
11		AS4000-N03	Mounted Flow Control	2
12		KQ2H11-36	Male Connector	2
13		VHS30-N03-Z	Manual Shutoff Valve	1
14		Y300	Spacer	1
15		TIUB11B-20	Polyurethane Tubing, 3/8", 20m Roll	1
16		F8-92-20-0-0	5/16" Flat Washer, Stainless	2
17		F8-96-20-0-0	5/16" Lock Washer, Stainless	2
18		F8-22-20-0-0	5/16-18 Hex Nut, Stainless	2
19		F8-7-20-2-12	5/16-18 x 3/4" Hex Bolt, Stainless	2
20		F8-92-21-0-0	3/8" Flat Washer, Stainless	8
21		F8-96-21-0-0	3/8" Lock Washer, Stainless	8
22		F8-7-21-2-16	3/8-16 x 1" Hex Bolt, Stainless	8
23		F8-92-19-0-0	1/4" Flat Washer, Stainless	10
24		F8-96-19-0-0	1/4" Lock Washer, Stainless	10
25		F8-22-19-2-0	1/4-20 Hex Nut, Stainless	10
26		F8-7-19-2-28	1/4-20 x 1-3/4" Hex Bolt, Stainless	4
27		F8-7-19-2-12	1/4-20 x 3/4" Hex Bolt, Stainless	6
28		50785K290	Adapter, 1/2" to 3/8", Brass	1
29		F8-96-44-0-0	M4 Lock Washer, Stainless	4
30		F8-73-44-2-148	M4 x 10 SHCS, Stainless	4

Component Details



Component Details

End Units

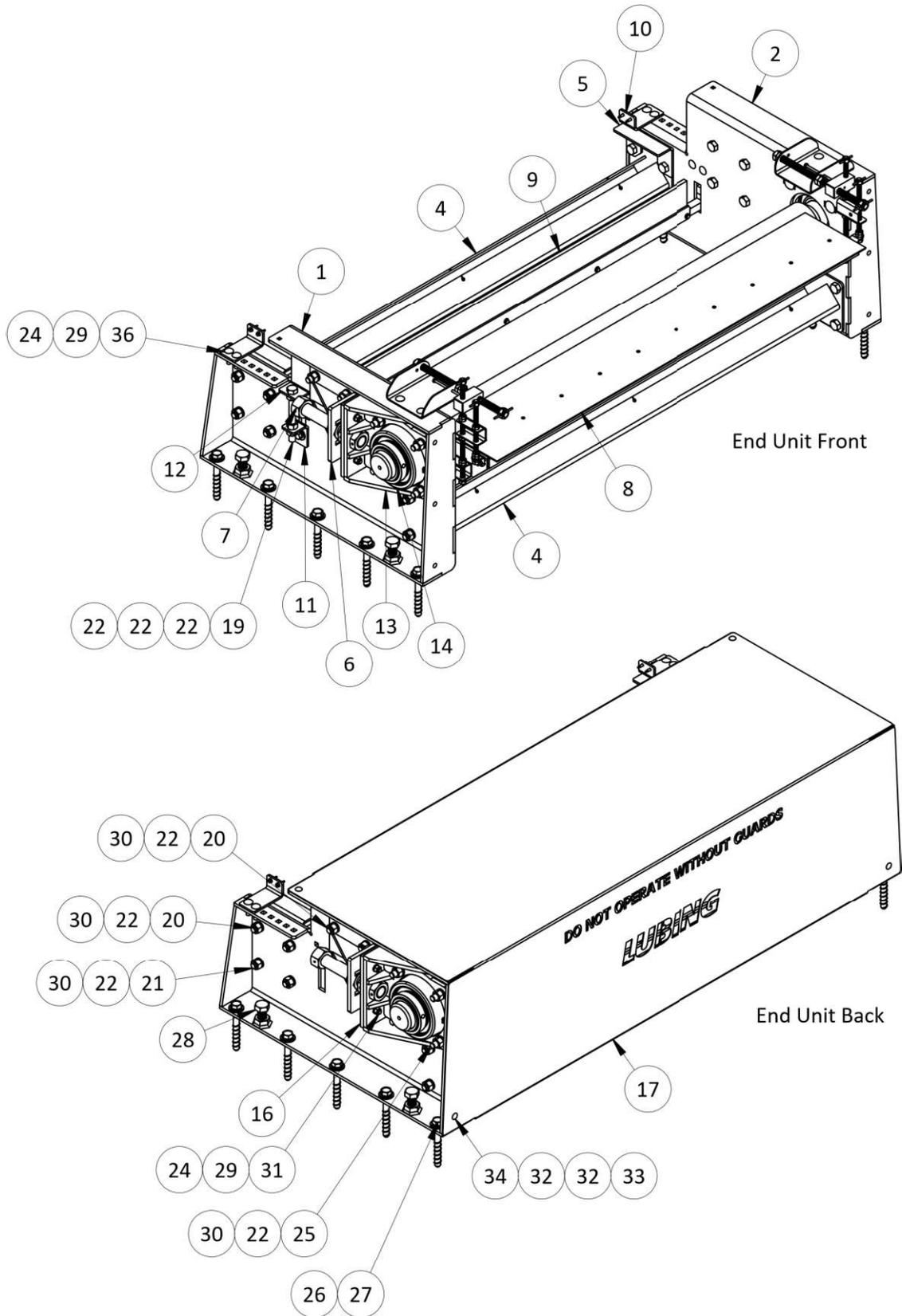


End Unit			
Belt Width	Part Number	Drawing Number	Description
60	--	19C E 200 00B	End Unit Front
60	--	19C E 000 00B	End Unit Back

Component Details

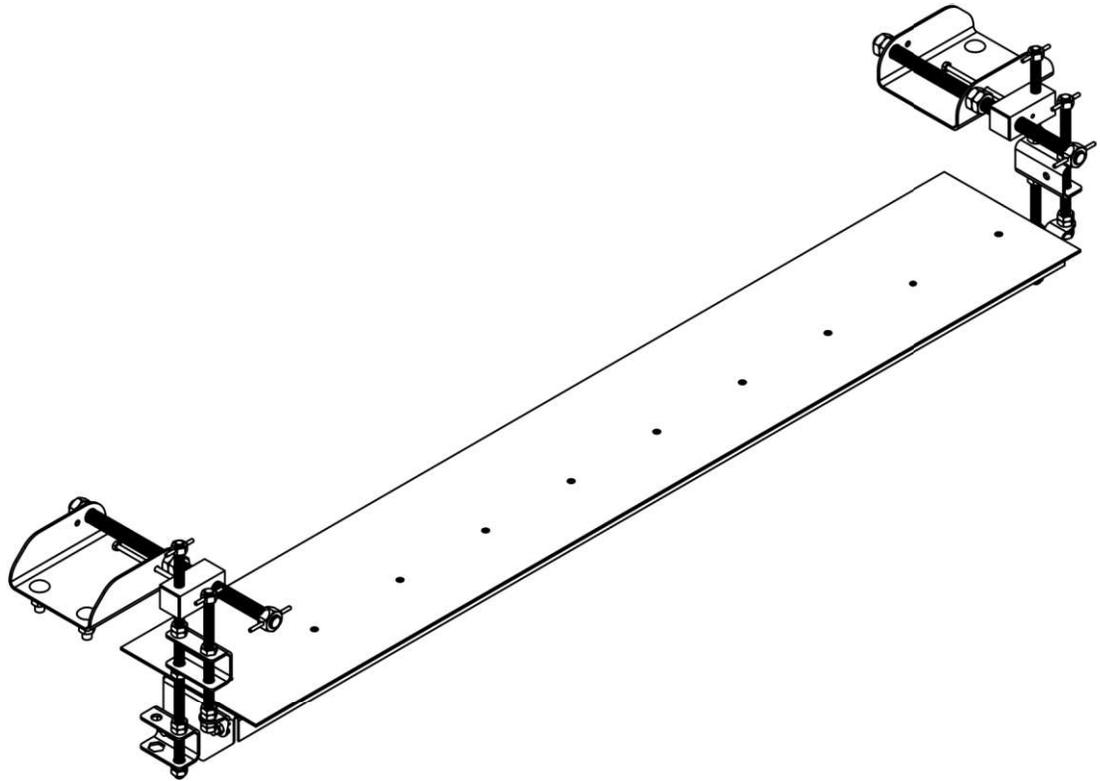
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	End Unit Front	End Unit Back
1	19C E 000 01A	19C E 000 01A	End Unit Side Sheet Weldment 60-in	1	1
2	19C E 000 01A	19C E 000 01A	End Unit Side Sheet Weldment Opp. 60-in	1	1
3	19C G 000 09B	19C G 000 10B	Straight Roller, Tracking 60-in	1	1
4	19C G 000 14A	19C G 000 14A	Horizontal Brace	2	2
5	19C G 000 12A	19C G 000 12A	Connecting Part Support Angle	2	2
6	19C E 000 04A	19C E 000 04A	Tracking Bracket Assembly	2	2
7	19C E 000 07A	19C E 000 07A	Tracking Adjustment Rod	2	2
8	19C E 100 00B	19C E 100 00B	Transfer Plate Adjustment Assembly	1	-
9	19C F 100 00A	19C F 100 00A	Belt Scraper Assembly, 60-in	1	-
10	19C G 000 13A	19C G 000 13A	Connecting Part Mounting Bracket	2	2
11	19C F 000 08A	19C F 000 08A	Belt Scraper Adjustment Bracket	2	-
12	19C F 000 07A	19C F 000 07A	Belt Scraper Adjustment Bracket Fixed	2	-
13	19C E 000 03A	19C E 000 03A	Bearing Slide Plate Weldment, Tracking	2	2
14	19C F 000 12A	19C F 000 19A	4 Bolt Flange Bearing 3.5" With 90 Grease Fitting	2	2
15	19C E 000 05B	19C E 000 05B	Bearing Push Plate	2	2
16	19C E 000 06A	19C E 000 06A	Tracking Bracket Push Plate Reinforcement	2	2
17	19C E 000 08A	19C E 000 08A	End Unit Cover	-	1
18		F8-3-23-2-24	1/2-13 x 1-1/2" Carriage Bolt, Stainless	4	2
19		F8-7-27-2-96	3/4-10 x 6" Full Thread Hex Bolt, Stainless	2	-
20		F8-7-27-2-32	3/4-10 x 2" Hex Bolt, Stainless	8	12
21		F8-7-27-2-28	3/4-10 x 1-3/4" Hex Bolt, Stainless	12	12
22		F8-22-27-0-0	3/4-10 Hex Nut, Stainless	38	32
23		F8-96-23-0-0	1/2" Lock Washer, Stainless	4	2
24		F9-96-23-0-0	1/2" Lock Washer, Zinc	6	6
25		F8-3-27-2-48	3/4-10 x 2-1/2" Carriage Bolt, Stainless	8	8
26		F8-92-27-0-0	3/4" Flat Washer, Stainless	10	10
27		F9-77-27-0-96	3/4" x 6" Masonry Hex Head Screw, Zinc	10	10
28		F4-7-31-6-40	1"-5 x 2-1/2" Full Thread Acme Hex Bolt, Steel	4	4
29		F8-22-23-2-0	1/2-13 Hex Nut (Stainless)	10	8
30		F8-96-27-0-0	3/4" Lock Washer, Stainless	32	32
31		F8-7-23-2-24	1/2-13 x 1-3/4" Hex Bolt, Stainless	4	4
32		F8-92-21-0-0	3/8" Flat Washer, Stainless	-	2
33		F8-22-21-0-0	3/8-16 Hex Nut, Stainless	-	4
34		F8-3-21-2-16	3/8-16 x 1" Carriage Bolt, Stainless	-	4
35		F8-96-21-0-0	3/8" Lock Washer, Stainless	-	4
36		F8-3-23-2-24	1/2-13 x 1-1/2" Carriage Bolt, Stainless	2	2
37		F8-7-27-2-36	3/4-10 x 2-1/4" Hex Bolt, Stainless	4	-
38		F9-66-19-0-12	1/4" x 3/4" Hex Head Self-Tapping Screw, Zinc	4	4

Component Details



Component Details

Adjustable Transfer Plate Assembly

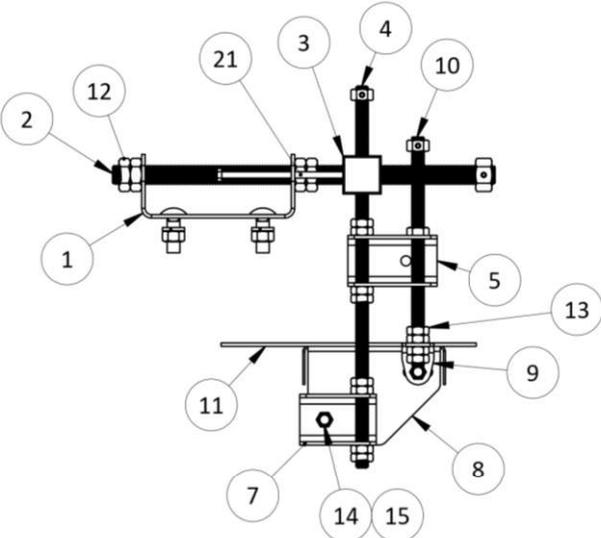
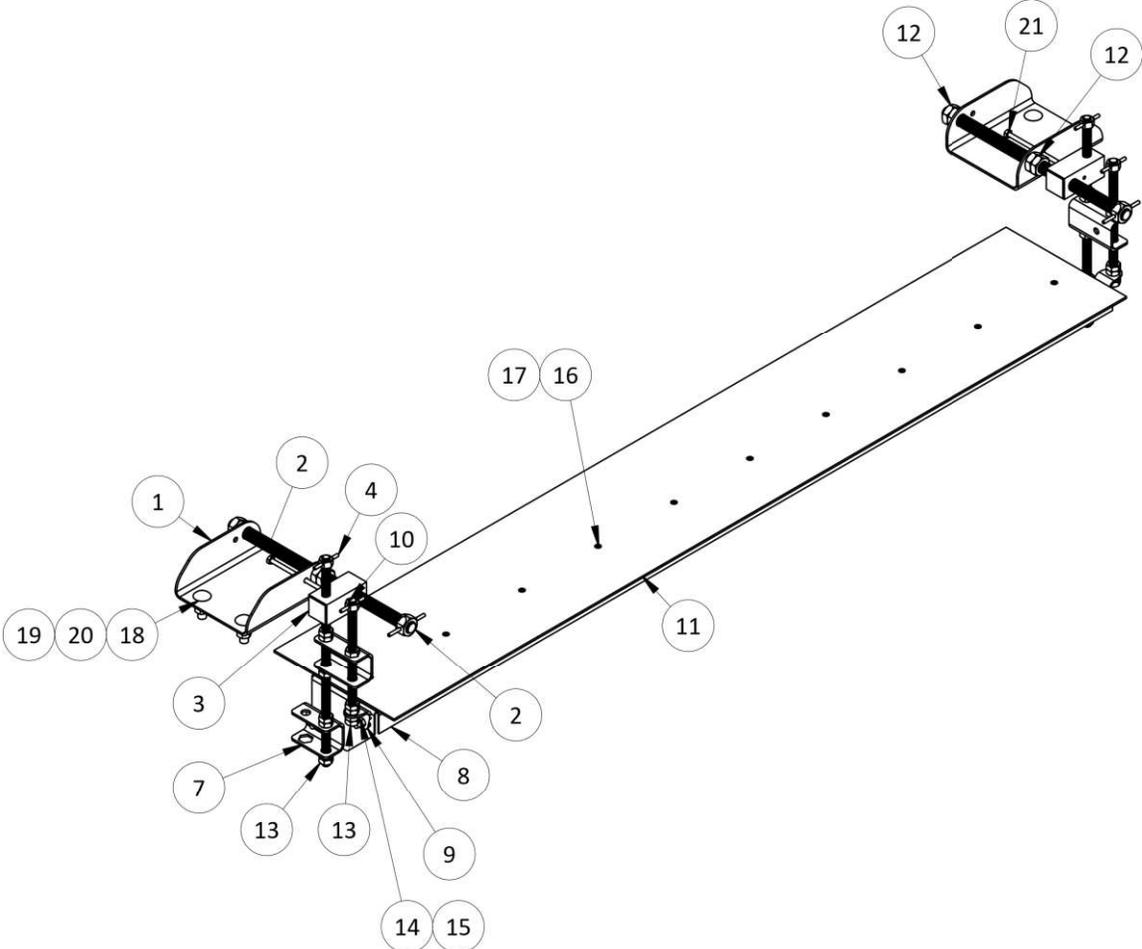


Adjustable Transfer Plate			
Belt Width	Part Number	Drawing Number	Description
60	--	19C E 100 00B	Adjustable Transfer Plate

Component Details

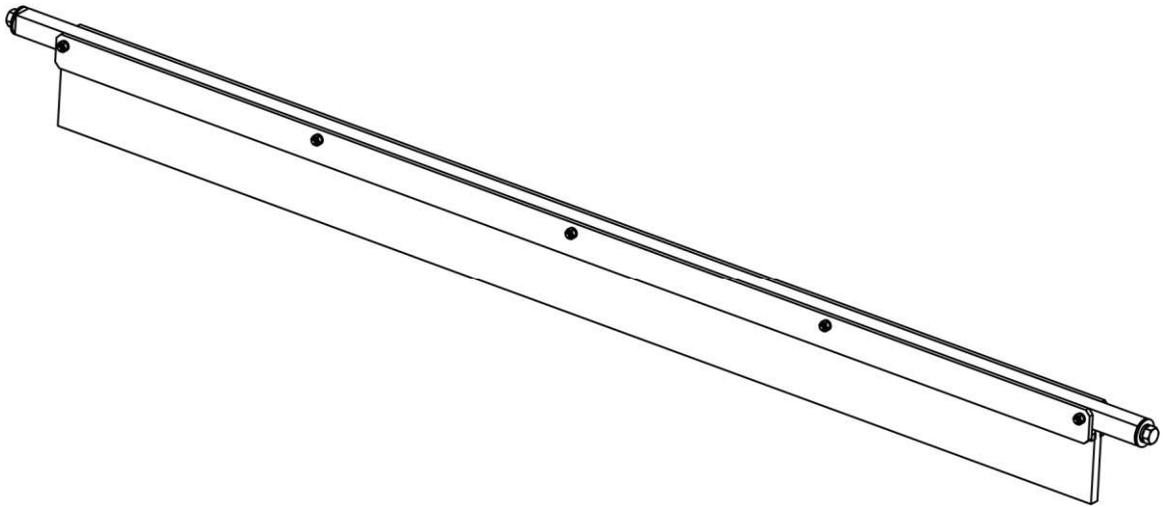
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	19C E 100 08C	19C E 100 08C	Transfer Assembly Support Crossmember	2
2	19C E 100 06B	19C E 100 06B	Transfer Plate Horizontal Lead Screw Assembly	2
3	19C E 100 05C	19C E 100 05C	Threaded Adjustment Block	2
4	19C E 100 11A	19C E 100 11A	Transfer Plate Vertical Lead Screw Assembly	2
5	19C E 100 01C	19C E 100 01C	Transfer Plate Pivot Bracket Weldment	1
6	19C E 100 01C	19C E 100 02C	Transfer Plate Pivot Bracket Right	1
7	19C E 100 01C	19C E 100 03C	Transfer Plate Pivot Bracket (Bracket Only)	2
8	19C E 100 10B	19C E 100 10B	Transfer Plate Base Bracket	1
9	19C E 100 04B	19C E 100 04B	Transfer Plate Angle Adjustment Bolt Bracket	2
10	19C E 100 07B	19C E 100 07B	Transfer Plate Angle Adjustment Assembly	2
11	19C E 100 09A	19C E 100 09A	Transfer Plate	1
12		F8-23-27-2-0	3/4-10 Jam Nut, Stainless	8
13		F8-23-23-2-0	1/2-13 Jam Nut, Stainless	24
14		F8-3-21-2-12	3/8-16 x .75" Carriage Bolt, Stainless	4
15		F8-28-21-2-0	3/8-16 THIN NYLOCK NUT	4
16		F8-61-8-3-8	#10-32 x 1/2" Flat Head Phillips Screw, Stainless	10
17		F8-29-8-3-0	#10-32 Nylock Nut, Stainless	10
18		F8-3-23-2-24	1/2-13 x 1-1/2" Carriage Bolt, Stainless	4
19		F8-96-23-0-0	1/2" Lock Washer, Stainless	4
20		F8-22-23-2-0	1/2-13 Hex Nut (Stainless)	4
21		F8-7-19-2-88	1/4-20 x 5.5" Hex Bolt Full Thread, Stainless	2

Component Details



Component Details

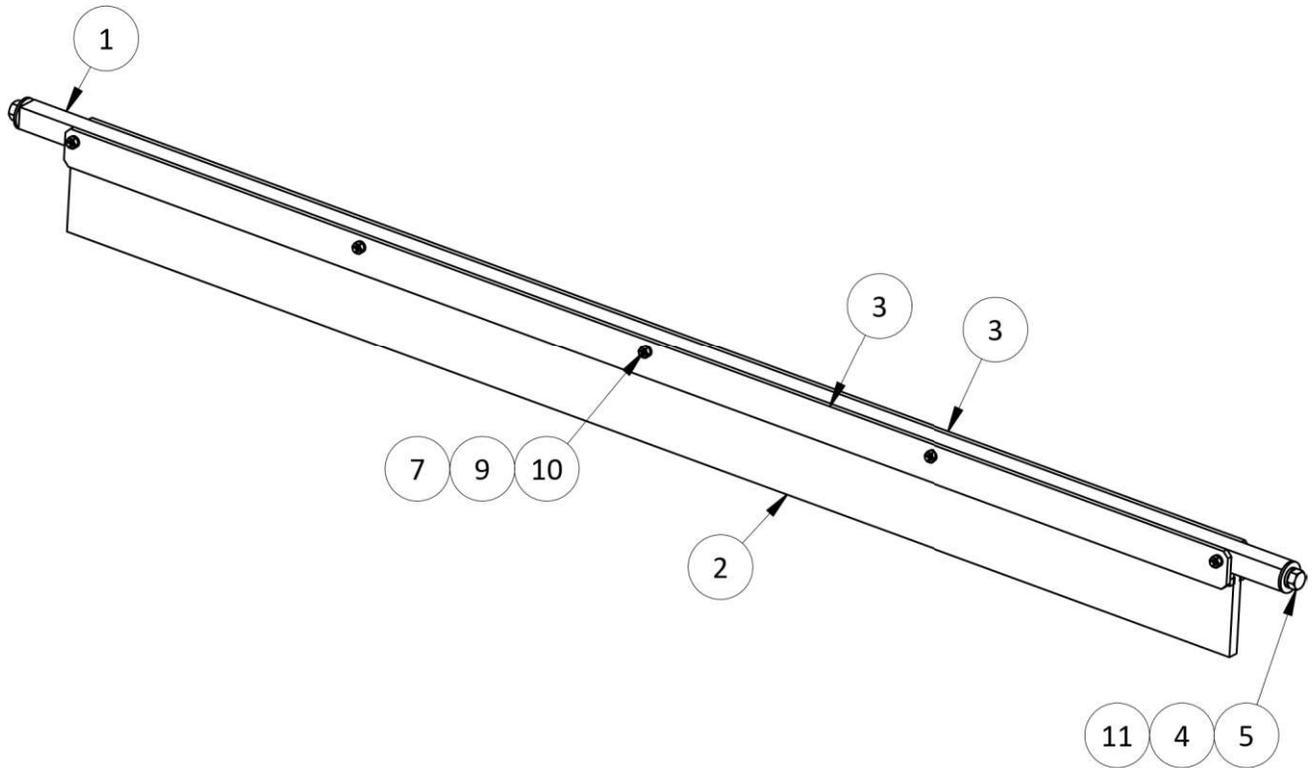
Belt Scraper Assembly (Drive/End Units)



Belt Scraper Assembly			
Belt Width	Part Number	Drawing Number	Description
60	--	19C F 100 00A	Belt Scraper Assembly

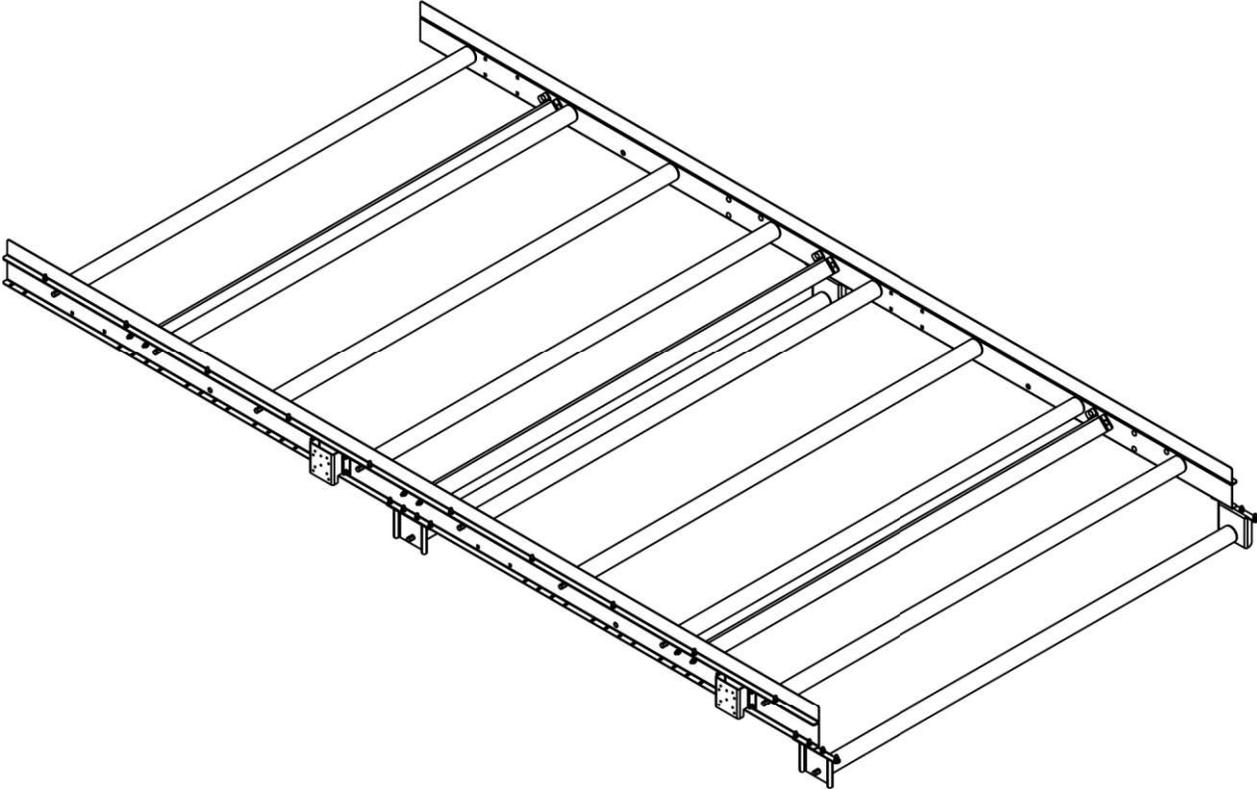
Component Details

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	19C F 100 02A	19C F 100 02A	Belt Scraper Support Bar, 60-in	1
2	19C F 100 03A	19C F 100 03A	Polyurethane Belt Scraper	1
3	19C F 100 01A	19C F 100 01A	Belt Scraper Holding Plate, 60-in	2
4		F8-96-23-0-0	1/2" Lock Washer, Stainless	2
5		F8-7-23-2-24	1/2-13 x 1-1/2" Hex Bolt, Stainless	2
6		F8-92-19-0-0	1/4" Flat Washer, Stainless	5
7		F8-96-19-0-0	1/4" Lock Washer, Stainless	5
8		F8-22-19-2-0	1/4-20 Hex Nut, Stainless	1
9		F9-22-19-2-0	1/4-20 Hex Nut, Zinc	4
10		F8-7-19-2-32	1/4-20 x 2" Hex Bolt, Stainless	5
11		F8-90-23-0-0	1/2" Fender Washer, Stainless	2



Component Details

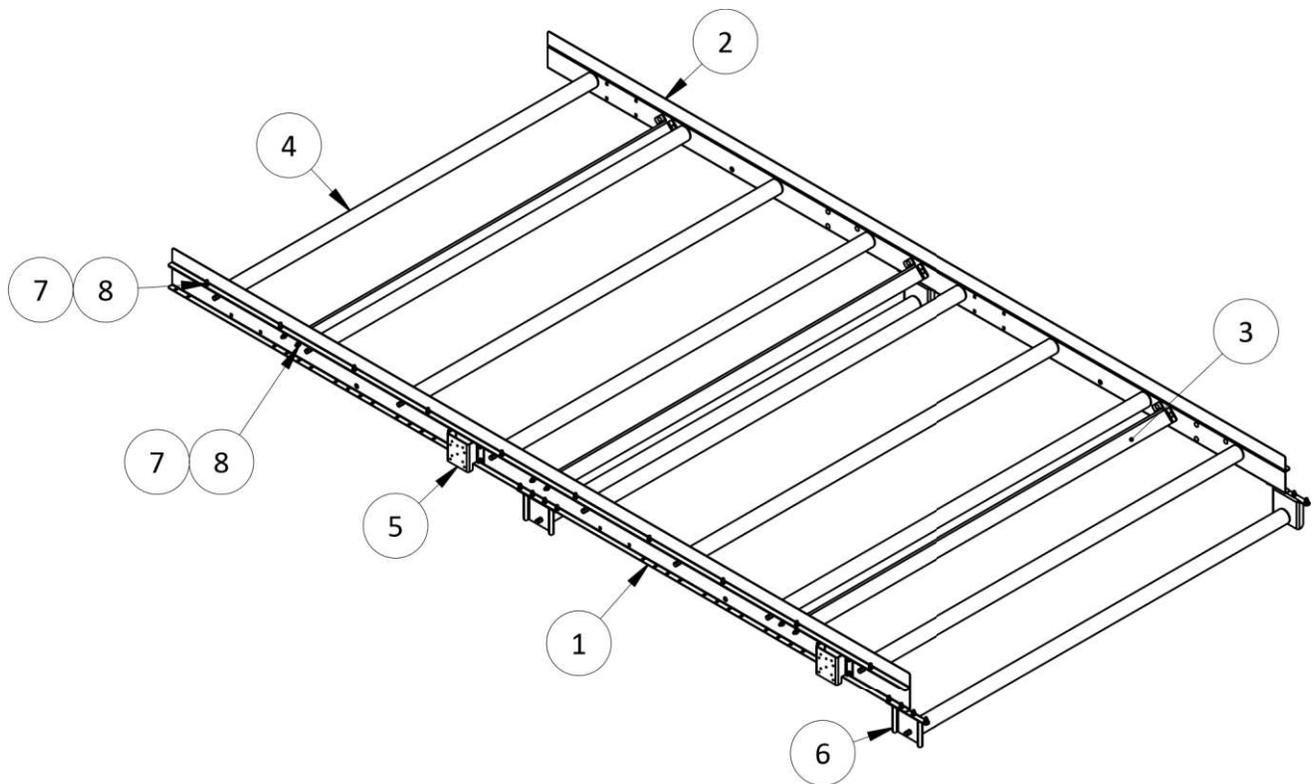
Connecting Part



Connecting Part			
Belt Width	Part Number	Drawing Number	Description
60	--	19C C 000 00A	Connecting Part 60-in

Component Details

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	Qty
1	19C C 000 04A	19C C 000 04A	Connecting Part Sidesheet, 10-ft Galv.	2
2	19C C 000 05A	19C C 000 05A	Connecting Part Egg Guide 10-ft Galv.	2
3	19C C 000 01A	19C C 000 01A	Traverse 60-in Formed Galvanized	3
4	19C C 000 03A	19C C 000 03A	60-in Galvanized Roller	10
5	19C C 500 00A	19C C 500 00A	Connecting Part Support Bracket Kit Galvanized	4
6	19C D 600 00A	19C D 700 00A	Connecting Plate Kit Galvanized	4
7		F9-3-19-2-12	1/4-20 x 3/4" Carriage Bolt, Zinc	32
8		F9-29-19-2-0	1/4-20 Nylock Nut, Zinc	32

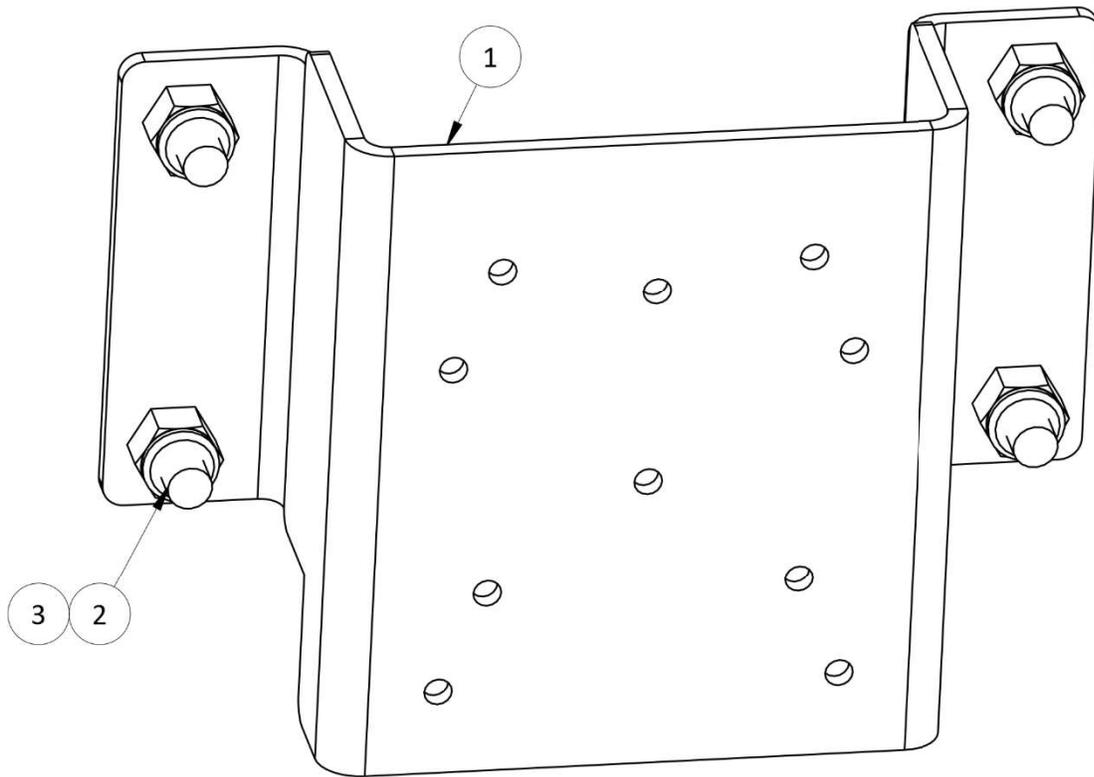


Support Bracket Kit must be installed a minimum of every 5' on both sides of Connecting Part

Component Details

Connecting Part Support Bracket Kit

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	Qty
1	19C C 500 01B	19C C 500 01B	Connecting Part Support Bracket Galv.	1
2		F9-3-19-2-12	1/4-20 x 3/4" Carriage Bolt, Zinc	4
3		F9-29-19-2-0	1/4-20 Nylock Nut, Zinc	4

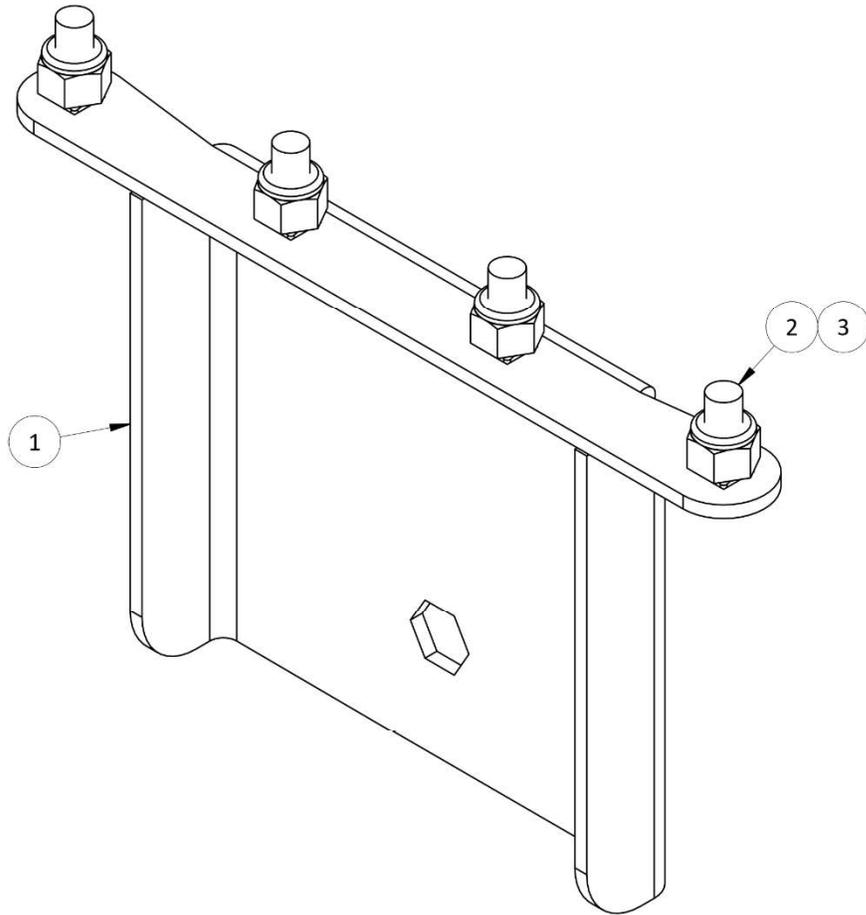


Connecting Part Support Bracket Kit Galv.			
Belt Width	Part Number	Drawing Number	Description
60	--	19C C 500 00A	Connecting Part Support Bracket

Component Details

Connecting Plate Kit Galvanized

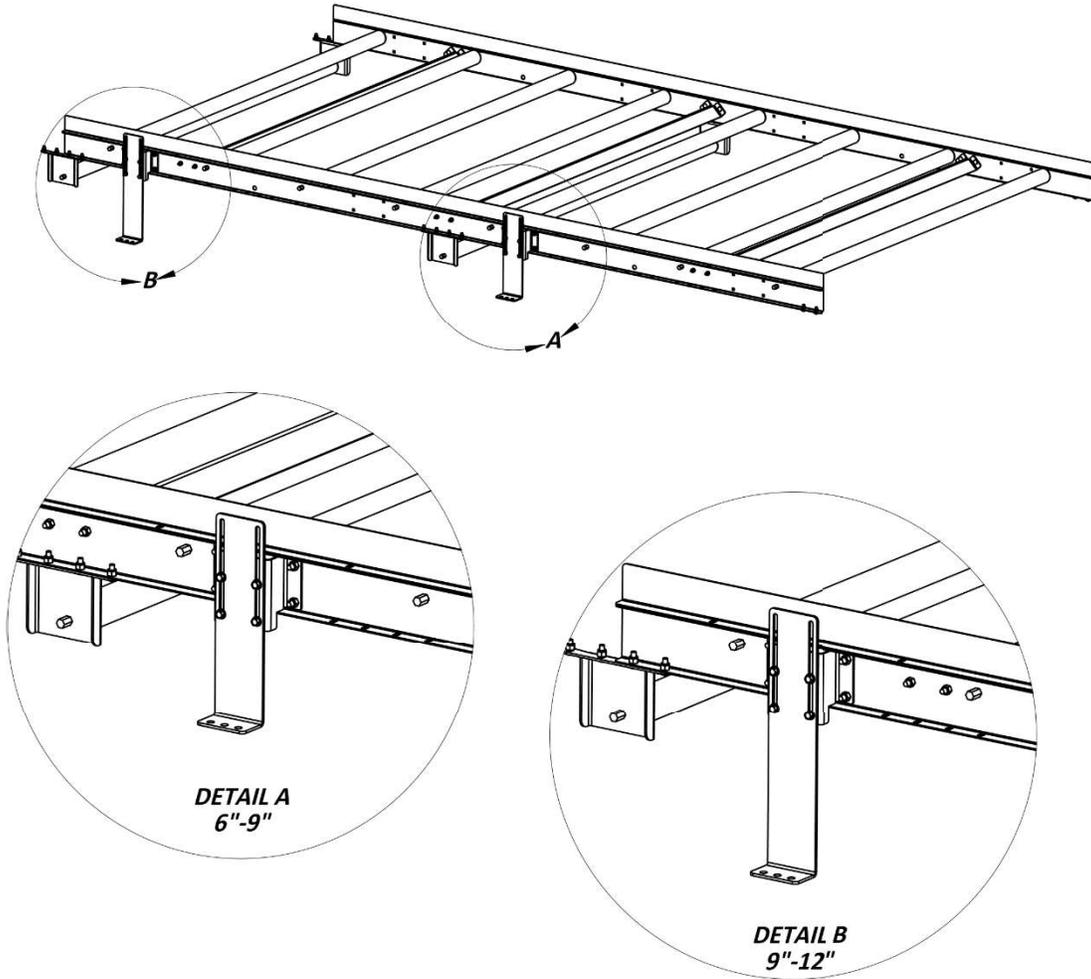
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	Qty
1	19C C 000 06A	19C C 000 06A	Connecting Plate	1
2		F9-3-19-2-12	1/4-20 x 3/4" Carriage Bolt, Zinc	4
3		F9-29-19-2-0	1/4-20 Nylock Nut, Zinc	4



Connecting Plate Kit Galv.			
Belt Width	Part Number	Drawing Number	Description
60	19C D 700 00A	19C D 600 00A	Connecting Plate Kit Galvanized

Component Details

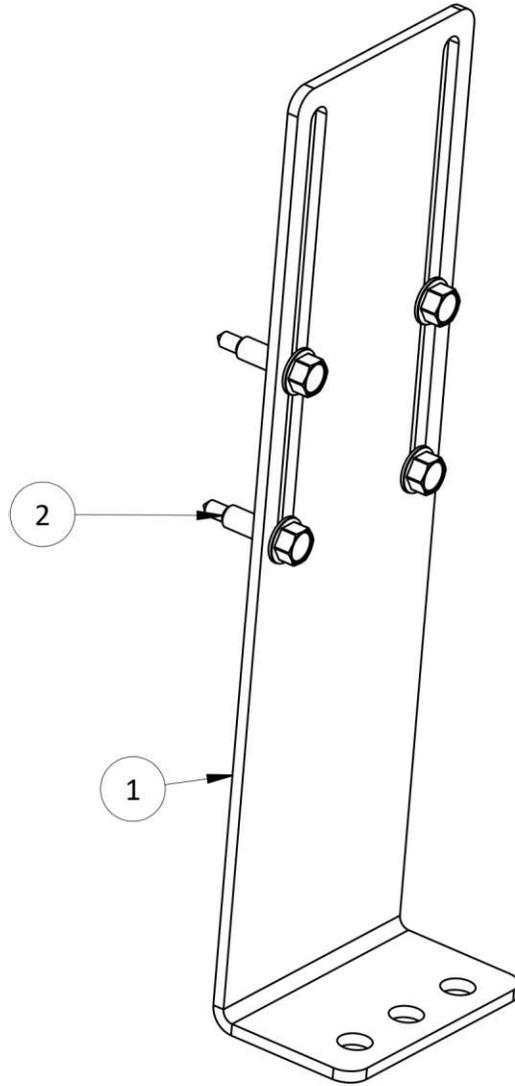
Connecting Part Support Foot Kits



Support Foot Kit			
Belt Width	Part Number	Drawing Number	Description
60	--	19C C 300 00A	Support Foot Kit 6"-9"
60	--	19C C 400 00A	Support Foot Kit 9"-12"

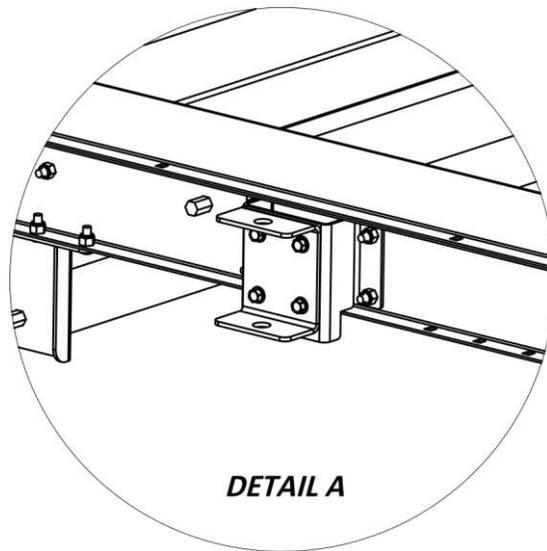
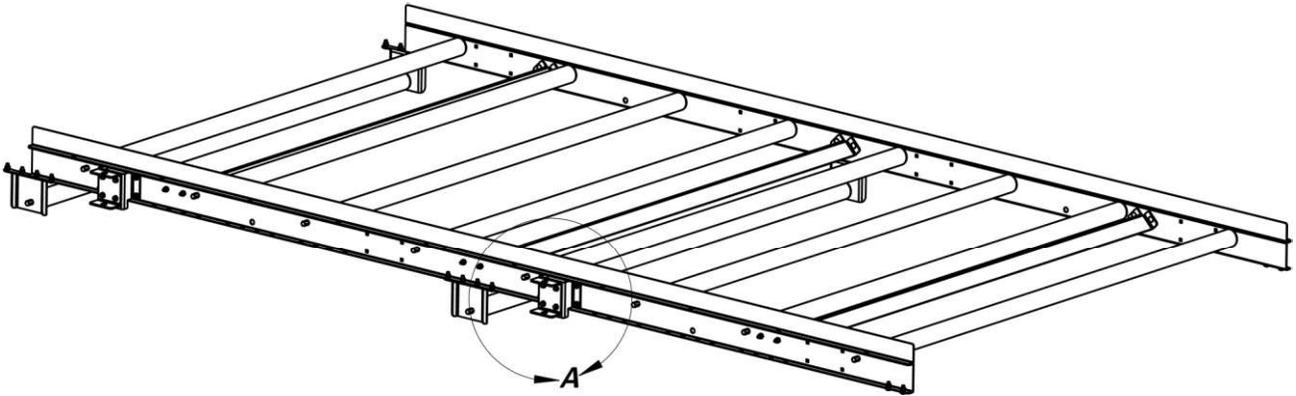
Component Details

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY. 6"-9"	QTY. 9"-12"
1	19C C 300 01A	19C C 300 01A	Connecting Part Support Foot 6"-9"	1	-
1	19C C 400 01A	19C C 400 01A	Connecting Part Support Foot 9"-12"	-	1
2		F9-66-19-0-12	1/4" x 3/4" Hex Head Self-Tapping Screw, Zinc	4	4



Component Details

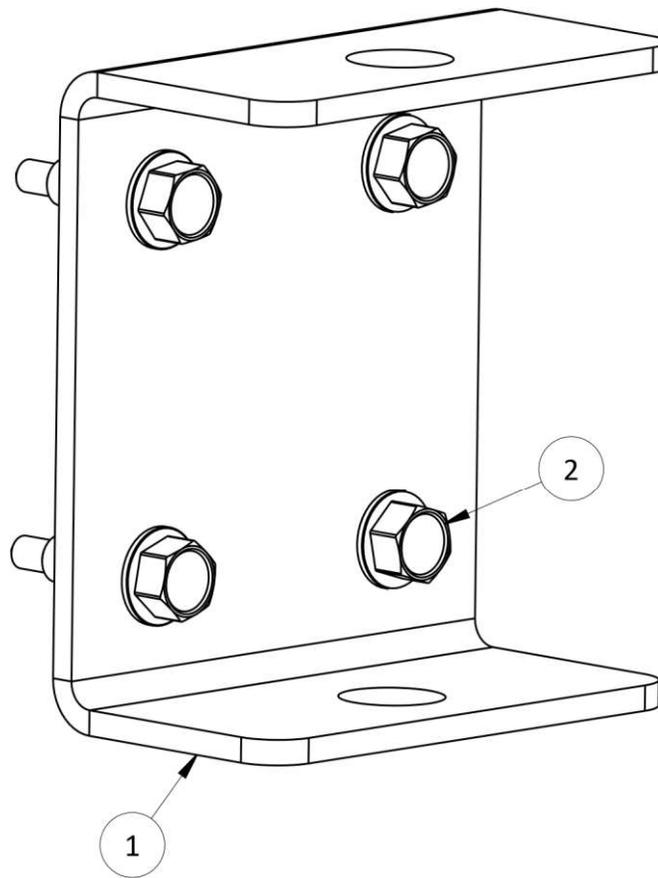
Connecting Part Hanger Bracket Kit



Hanger Bracket Kit			
Belt Width	Part Number	Drawing Number	Description
60	--	19C C 200 00A	Hanger Bracket Kit

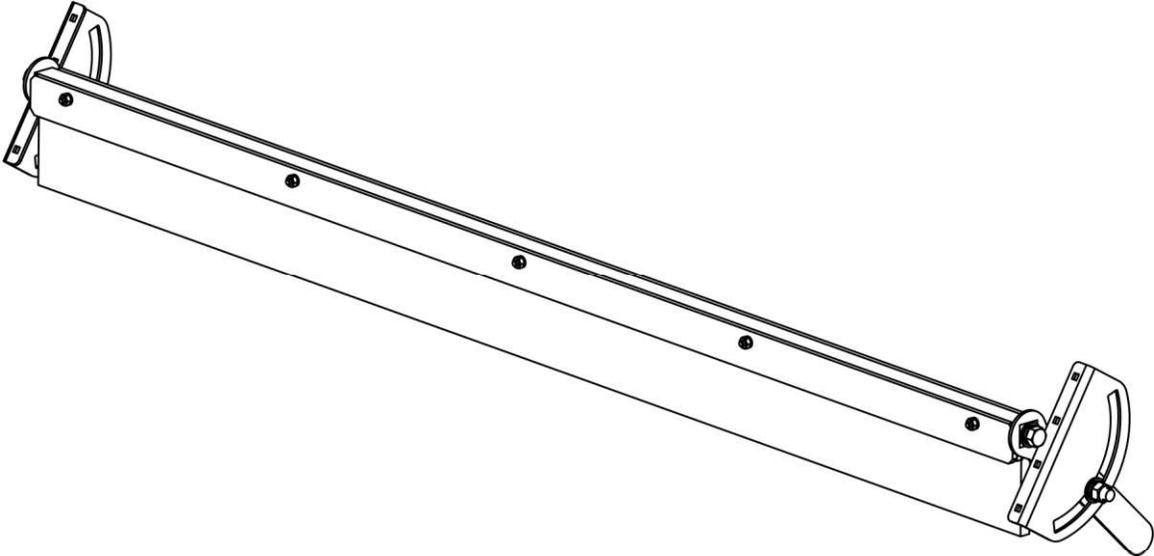
Component Details

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	19C C 200 01A	19C C 200 001A	Connecting Part Hanger Bracket	1
2		F9-66-19-0-12	1/4" x 3/4" Hex Head Self-Tapping Screw, Zinc	4



Component Details

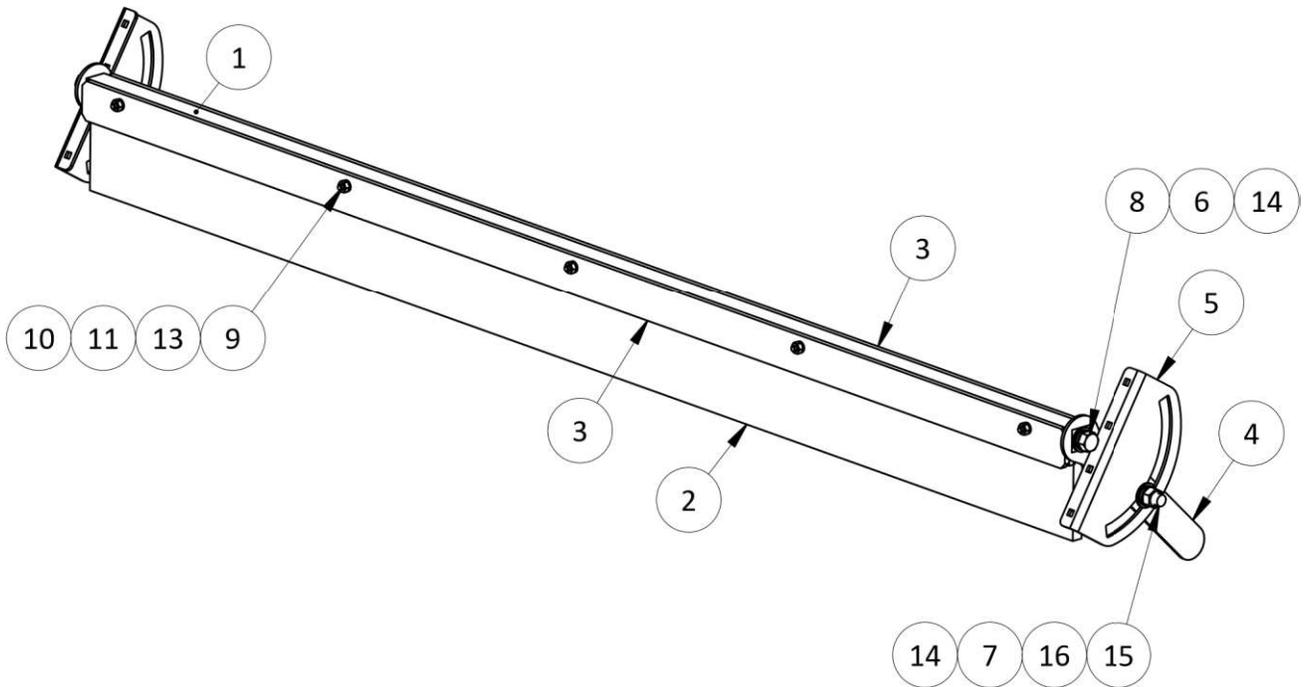
Belt Scraper Assembly (Connecting Part)



Belt Scraper Assembly Connecting Part			
Belt Width	Part Number	Drawing Number	Description
60	--	19C C 100 00A	Belt Scraper Assembly Connecting Part

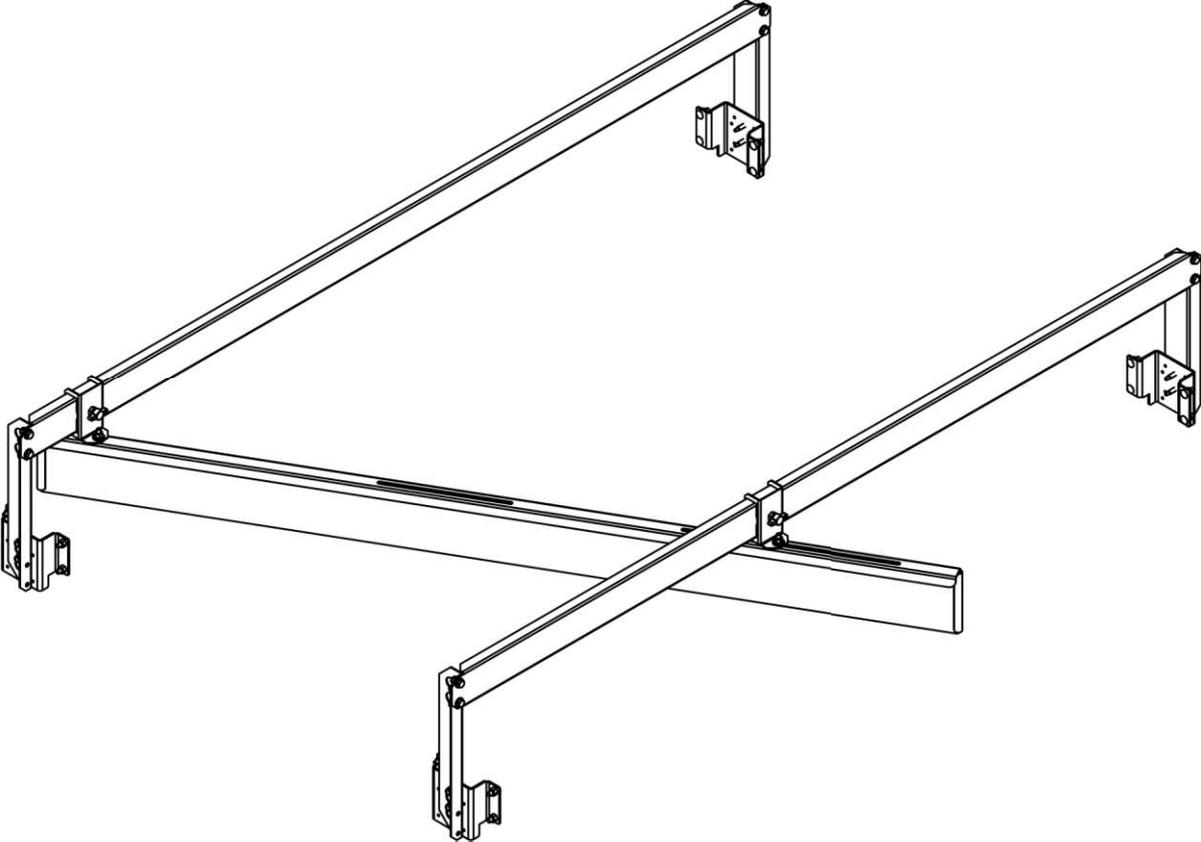
Component Details

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	Qty.
1	19C C 100 02A	19C C 100 02A	Belt Scraper Support Bar 60-in Connecting Part	1
2	19C C 100 03A	19C C 100 03A	Polyurethane Belt Scraper, Connecting Part	1
3	19C C 100 01A	19C C 100 01A	Belt Scraper Holding Plate Weldment 60-in Connecting Part	2
4	19C C 100 04A	19C C 100 04A	Belt Scraper Adjustment Handle	2
5	19C C 100 05A	19C C 100 05A	Connecting Part Scraper Bracket	2
6		F8-96-23-0-0	1/2" Lock Washer, Stainless	2
7		F9-96-23-0-0	1/2" Lock Washer, Zinc	2
8		F8-7-23-2-20	1/2-13 x 1-1/4" Hex Bolt, Stainless	2
9		F8-7-19-2-32	1/4-20 x 2" Hex Bolt, Stainless	5
10		F8-92-19-0-0	1/4" Flat Washer, Stainless	5
11		F8-96-19-0-0	1/4" Lock Washer, Stainless	5
12		F8-22-19-2-0	1/4-20 Hex Nut, Stainless	1
13		F9-22-19-2-0	1/4-20 Hex Nut, Zinc	4
14		F8-92-23-0-0	1/2" Flat Washer, Stainless	4
15		F8-3-23-2-20	1/2-13 x 1-1/4" Carriage Bolt, Stainless	2
16		F8-22-23-2-0	1/2-13 Hex Nut (Stainless)	2



Component Details

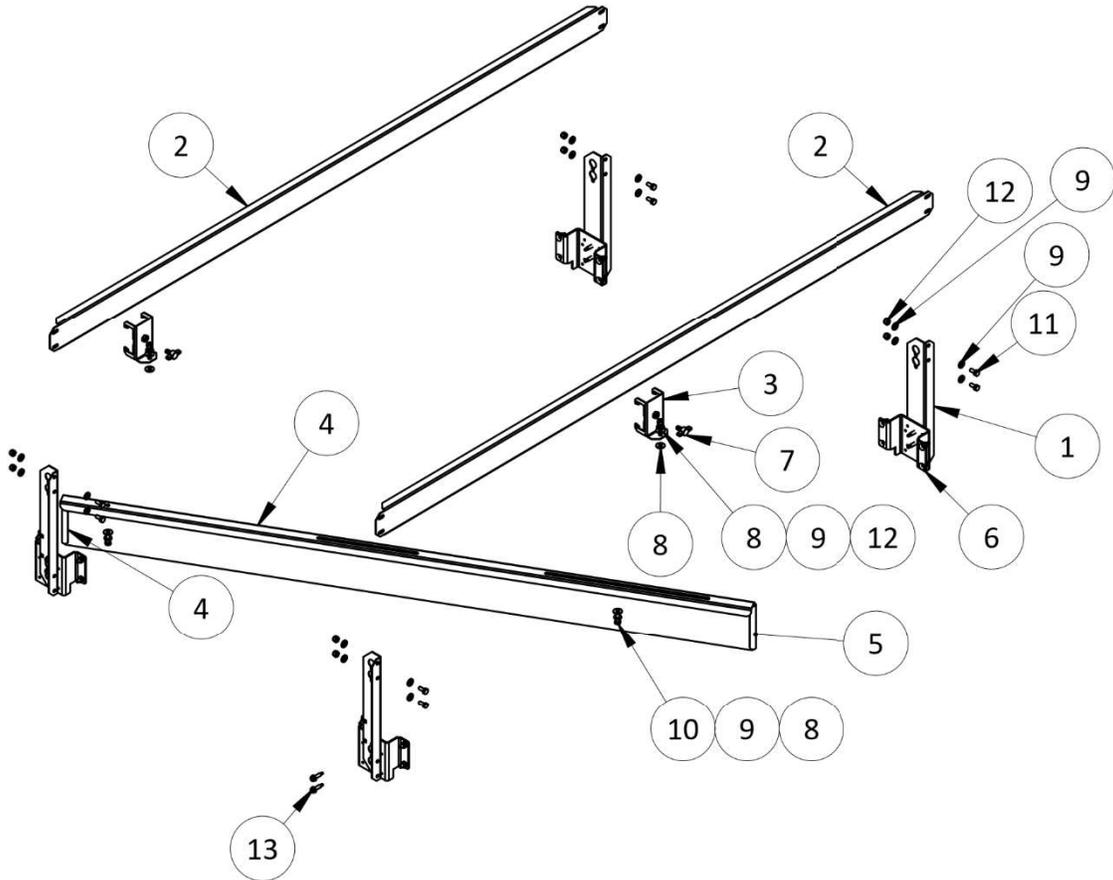
Diverter Unit



Diverter Assembly			
Belt Width	Part Number	Drawing Number	Description
60	--	19C J 100 00A	Diverter Assembly

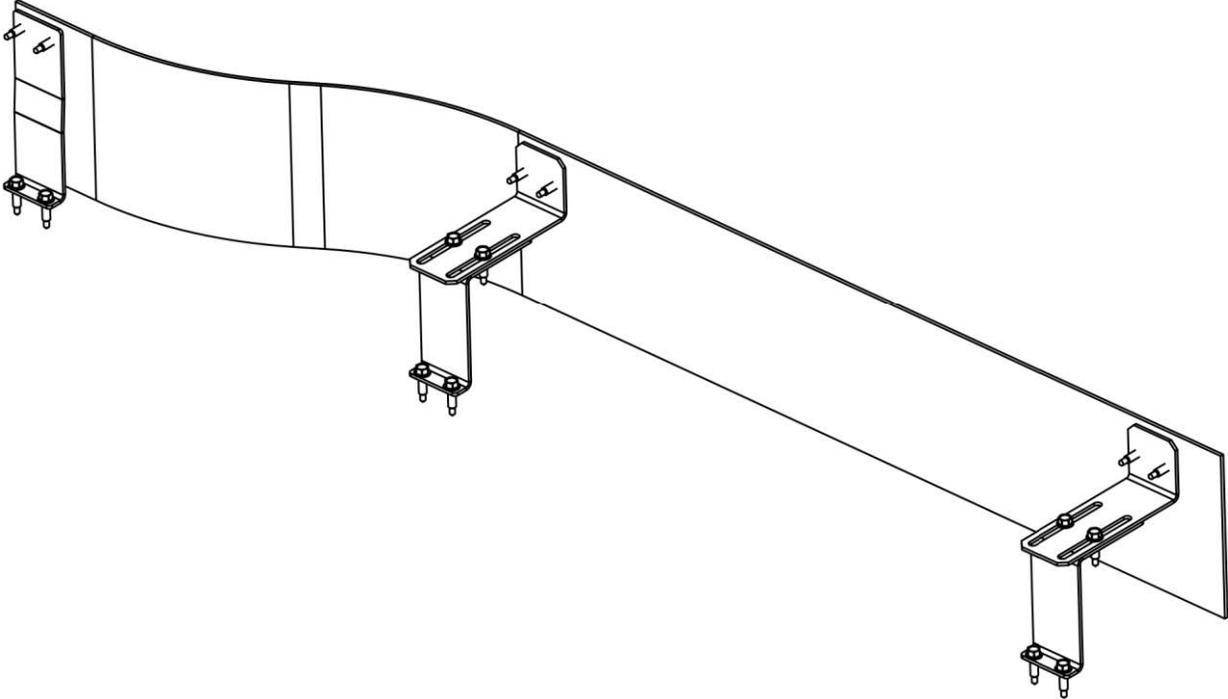
Component Details

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	19C J 100 02A	19C J 100 02A	Diverter Upright 60-in Belt	4
2	19C J 100 01A	19C J 100 01A	Diverter Bridge 60-in Belt	2
3	18D A 000 03A	18D A 000 03A	Diverter Hanger Weldment	2
4	18D A 000 04B	18D A 000 04B	Diverter 60-in	1
5	18D A 000 05A	18 A 000 05A	Diverter Bumper	2
6	19C C 500 00A	19C C 500 00A	Connecting Part Support Bracket Kit Galvanized	4
7		91185A957	Knob, Phenolic, 2-Lobe, 5/16-18 (Black)	2
8		90295A455	Washer, Nylon, 1/4" (White)	6
9		F9-92-19-0-0	1/4" Flat Washer, Zinc	20
10		F9-7-19-2-16	1/4-20 x 1" Hex Bolt, Zinc	2
11		F9-7-19-2-10	1/4-20 x 5/8" Hex Bolt, Zinc	8
12		F9-29-19-2-0	1/4-20 Nylock Nut, Zinc	10
13		F9-66-19-0-12	1/4" x 3/4" Hex Head Self-Tapping Screw, Zinc	8



Component Details

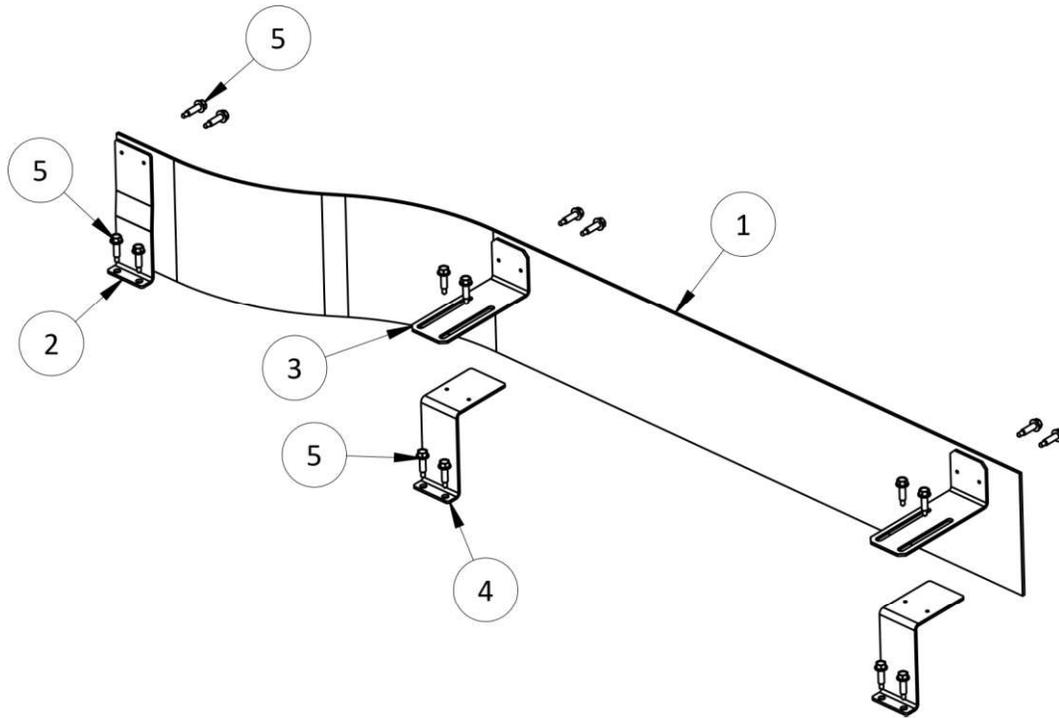
Guide Unit



Guide Unit			
Belt Width	Part Number	Drawing Number	Description
60	--	19C C 100 00A	Guide Unit

Component Details

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	15Q A 000 04A	15Q A 000 04A	Guide Unit Plate	1
2	19C J 200 01A	19C J 200 01A	Guide Unit End Support	1
3	15Q A 000 02A	15Q A 000 02A	Guide Unit Adjustment Angle	2
4	19C J 200 02A	19C J 200 02A	Guide Unit Standoff 60-in Belt	2
5		F9-66-19-0-12	1/4" x 3/4" Hex Head Self-Tapping Screw, Zinc	16



Installation

SECTION 3 - ASSEMBLY & INSTALLATION

Preparing for Installation

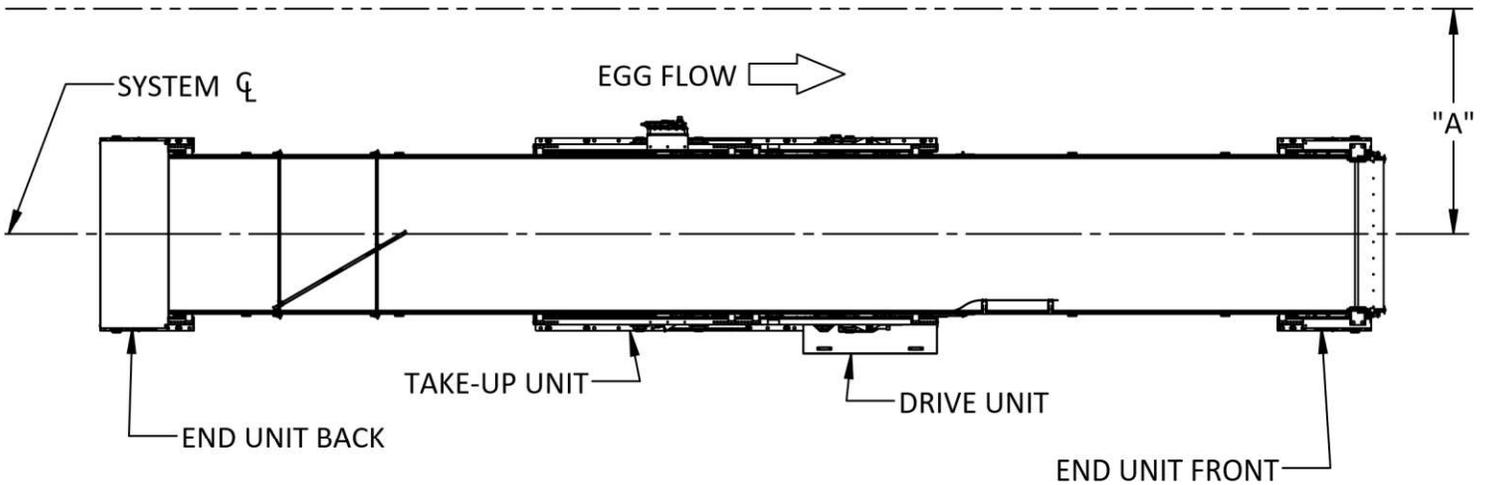
Recommended Tool / Equipment List	
Forklift	
Lifting Slings	Lifting lugs are designed for approximately 3/8" chain
6-ft Level	Locating center of belt
Framing Square	Marking center of belt
Speed Square	Marking Connecting Parts
Reciprocating Saw / Hacksaw	Modifying Connecting Part
Hammer Drill / Bit	Anchoring
Tape Measure	Various measurements required
1-in x 2,000-ft Rope	Pulling belt

Installation

1. Determine centerline of system.

Note: Centerline must be level to prevent slope in system.

Note: Centerline must be straight to ensure proper tracking of the Belt.



Drive Unit		
Belt Width	Component	A (inches/mm)
60	Drive Unit/Take-up Unit	96/2438
60	End Units/Connecting Parts	48/1219

Installation

- Determine location and height for End Unit, Front.

Note: Custom Support Stand may be required for desired transfer height.

- Determine location and height for Drive Unit.

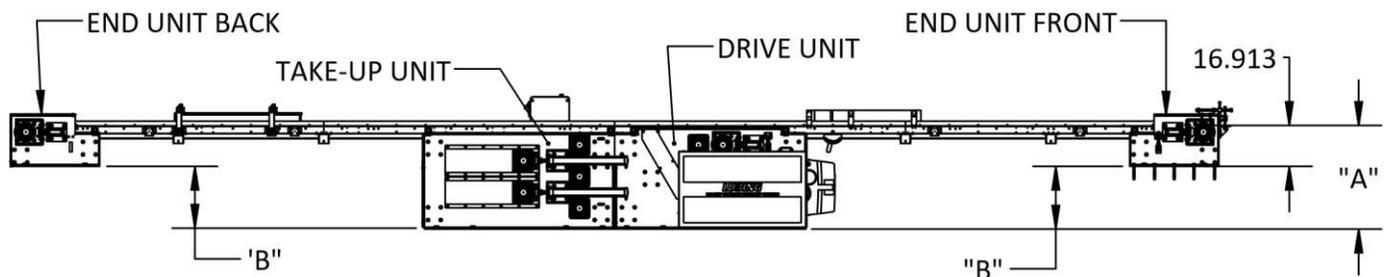
Note: Drive Unit must be level with End Unit, Front to prevent slope in the system.

Note: Custom Floor Supports may be required.

Note: Do not exceed max recommended distance between Drive Unit and End Unit, Front.

Note: Connecting Parts are intended to be suspended.

Note: If floor supports are required for Connecting Parts, contact your Lubing sales representative.



DETERMINE TRANSFER HEIGHT "A" AT THE END UNIT,

FRONT $A - 10" =$ END UNIT SUPPORT STAND HEIGHT "B"

IF "B" IS HIGHER THAN 24", DRIVE UNIT FLOOR SUPPORTS WILL BE

REQUIRED $B - 24" =$ DRIVE UNIT FLOOR SUPPORT HEIGHT

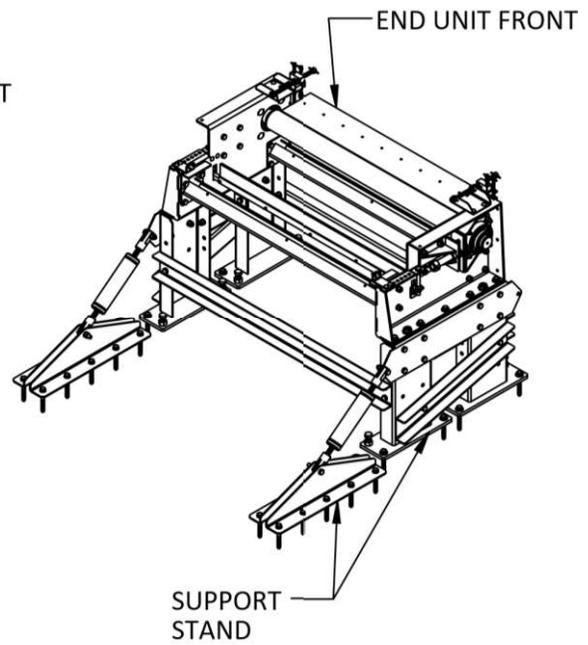
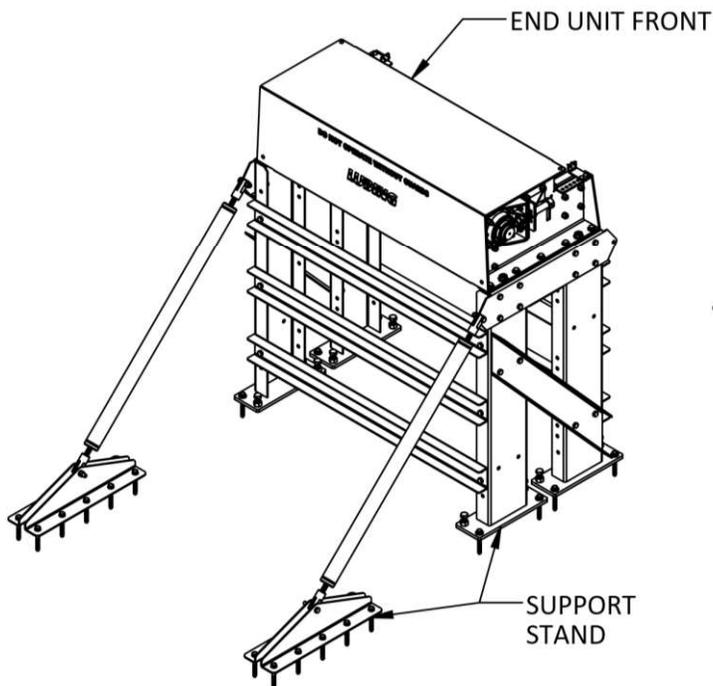
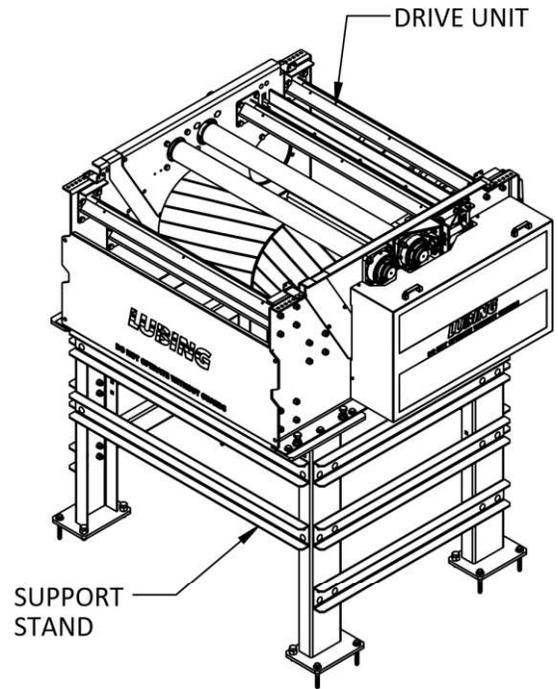
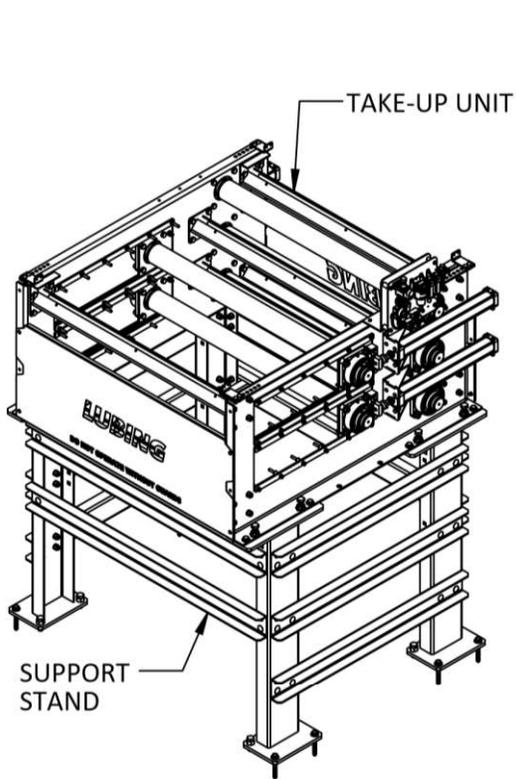
CALCULATIONS ASSUME LEVEL FLOOR AND CONSISTENT ELEVATION, IF FLOOR ELEVATION CHANGES AT THE LOCATION OF THE COMPONENTS ABOVE, ADDITIONAL HEIGHT MAY BE REQUIRED

FLOOR SUPPORT/SUPPORT STAND CONSTRUCTION
MAY DIFFER BASED ON TOTAL HEIGHTS REQUIRED

Installation



Support Stands and Floor Supports are special order and not included with system orders.



Installation

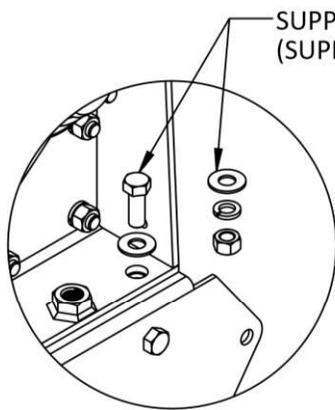
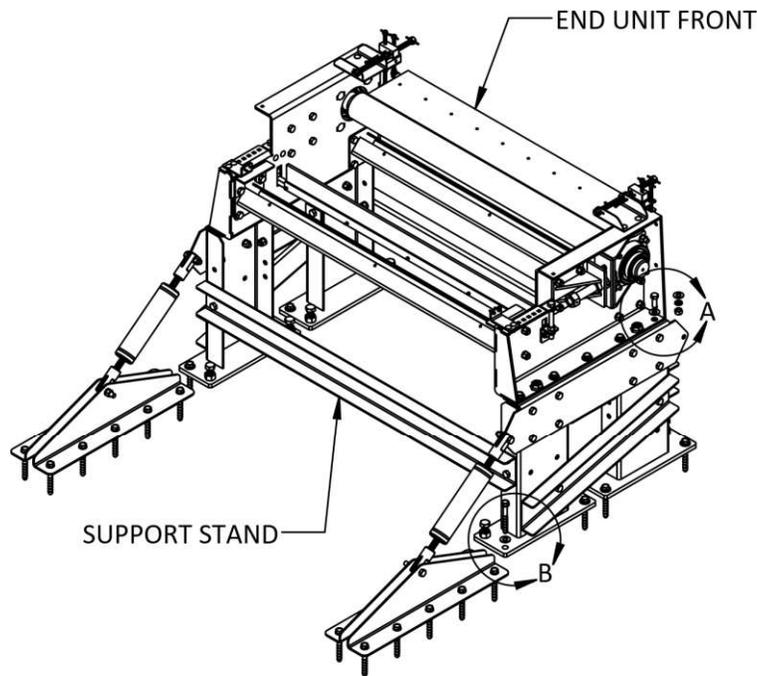
4. Position and anchor End Unit, Front.

Note: If a Support Stand is required, attach to End Unit, Front prior to anchoring.

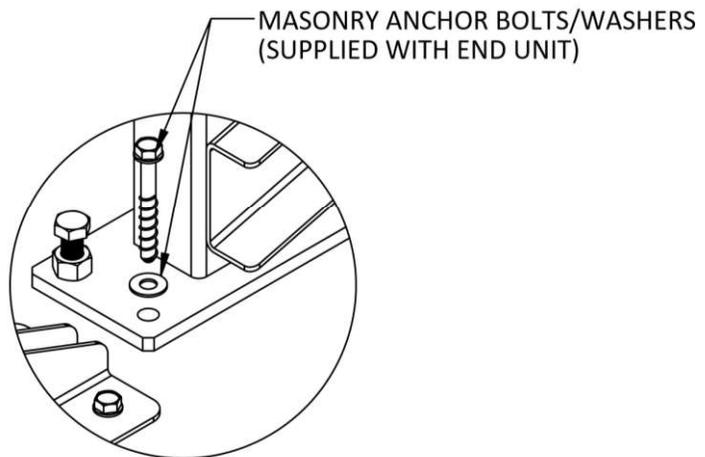
Note: If a Support Stand was purchased through Lubing Systems, use supplied hardware for attaching End Unit, Front.



End Unit, Front must be aligned to centerline and level to ensure proper operation.



DETAIL A



DETAIL B

Installation

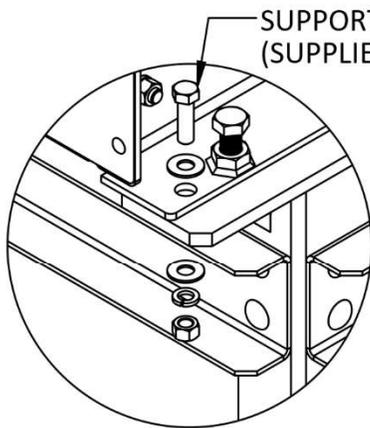
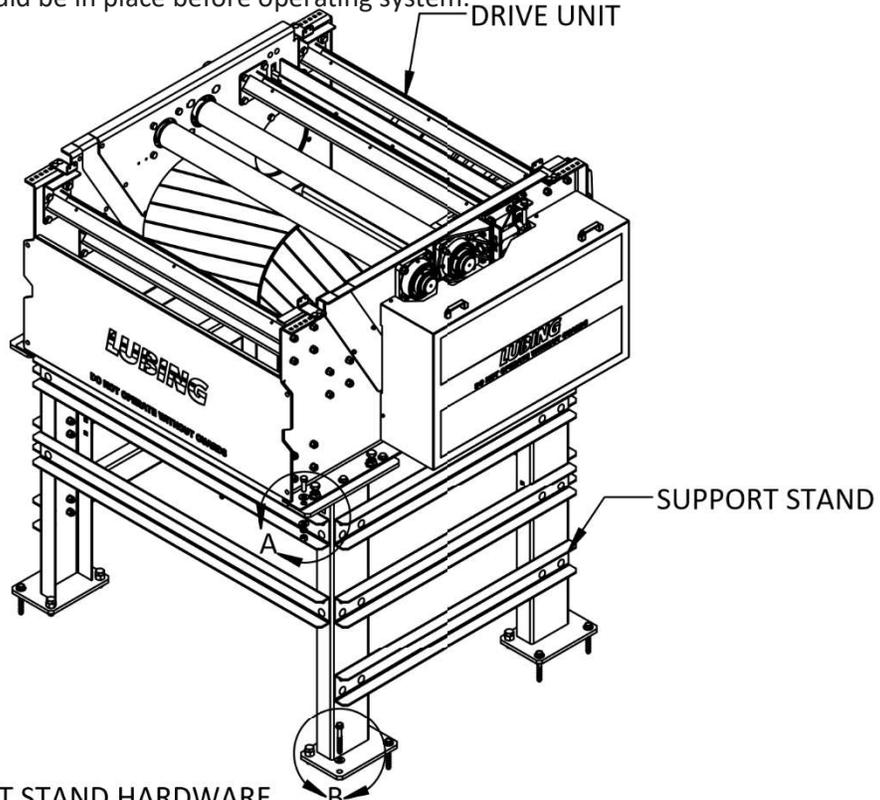
4. Position and anchor Drive Unit

Note: If Floor Supports were purchased through Lubing Systems, use supplied hardware for attaching Drive Unit.

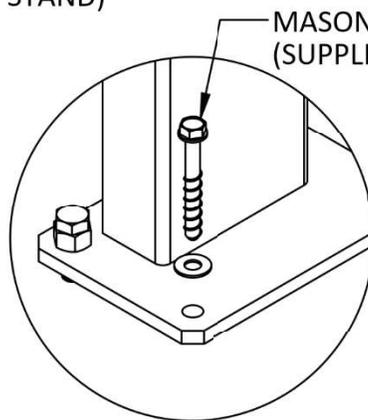
Note: Do not exceed the maximum recommended distance from End Unit, Front.



Drive Unit must be aligned to centerline and level to ensure proper operation.
All guards should be in place before operating system.



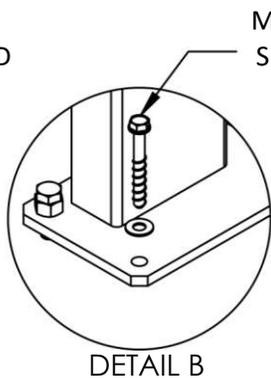
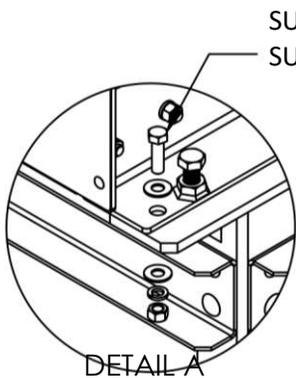
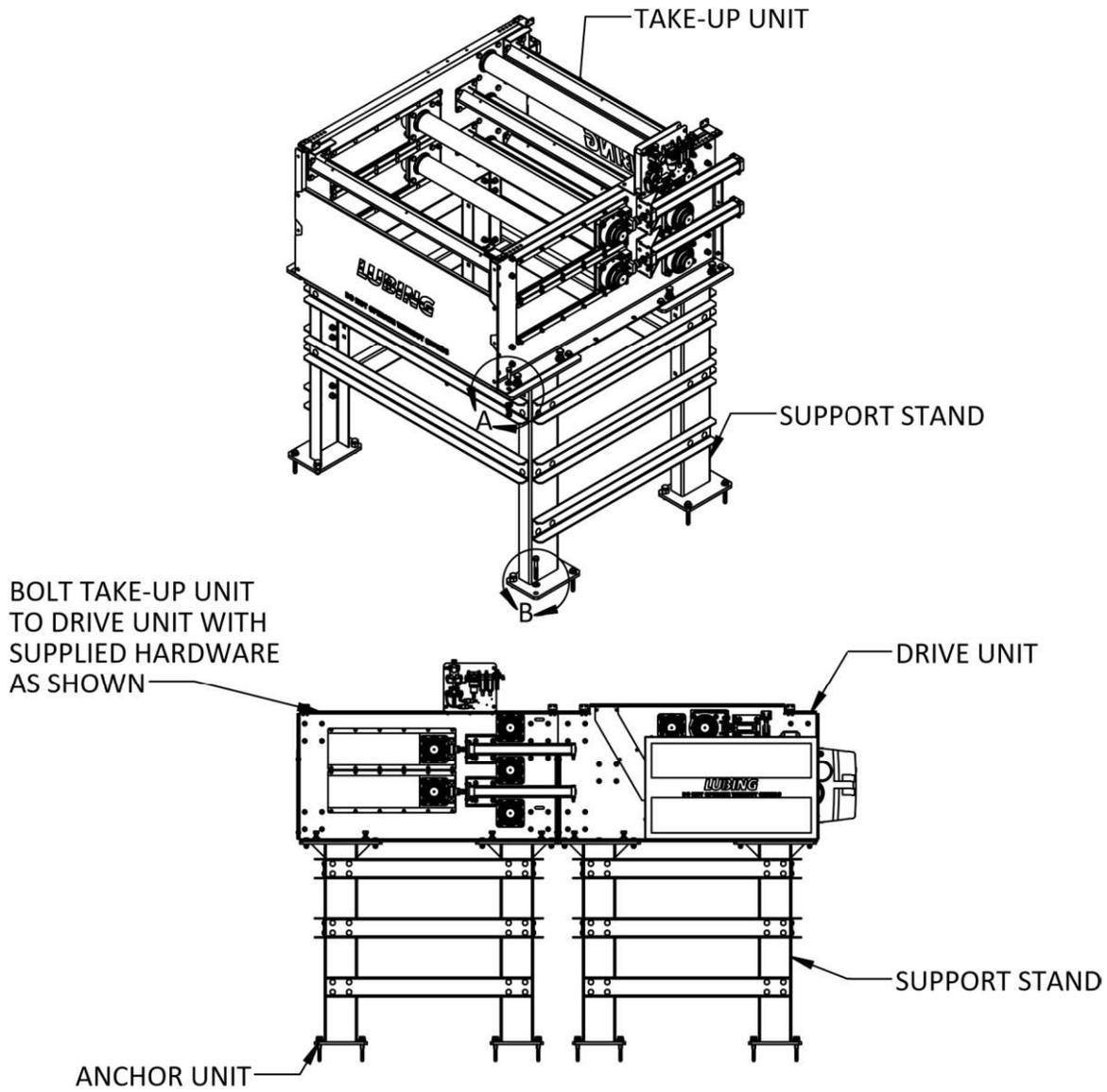
DETAIL B



DETAIL A

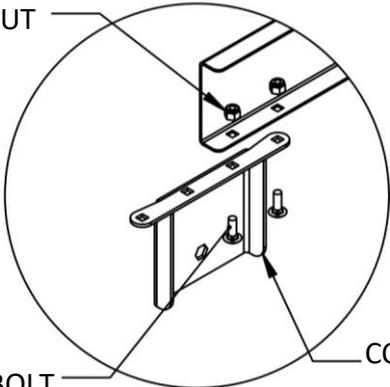
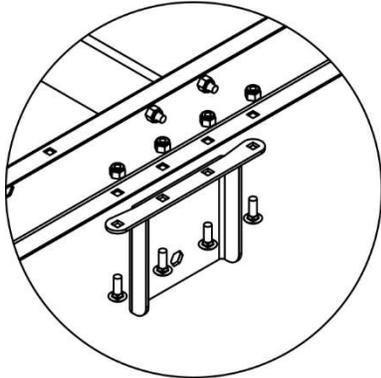
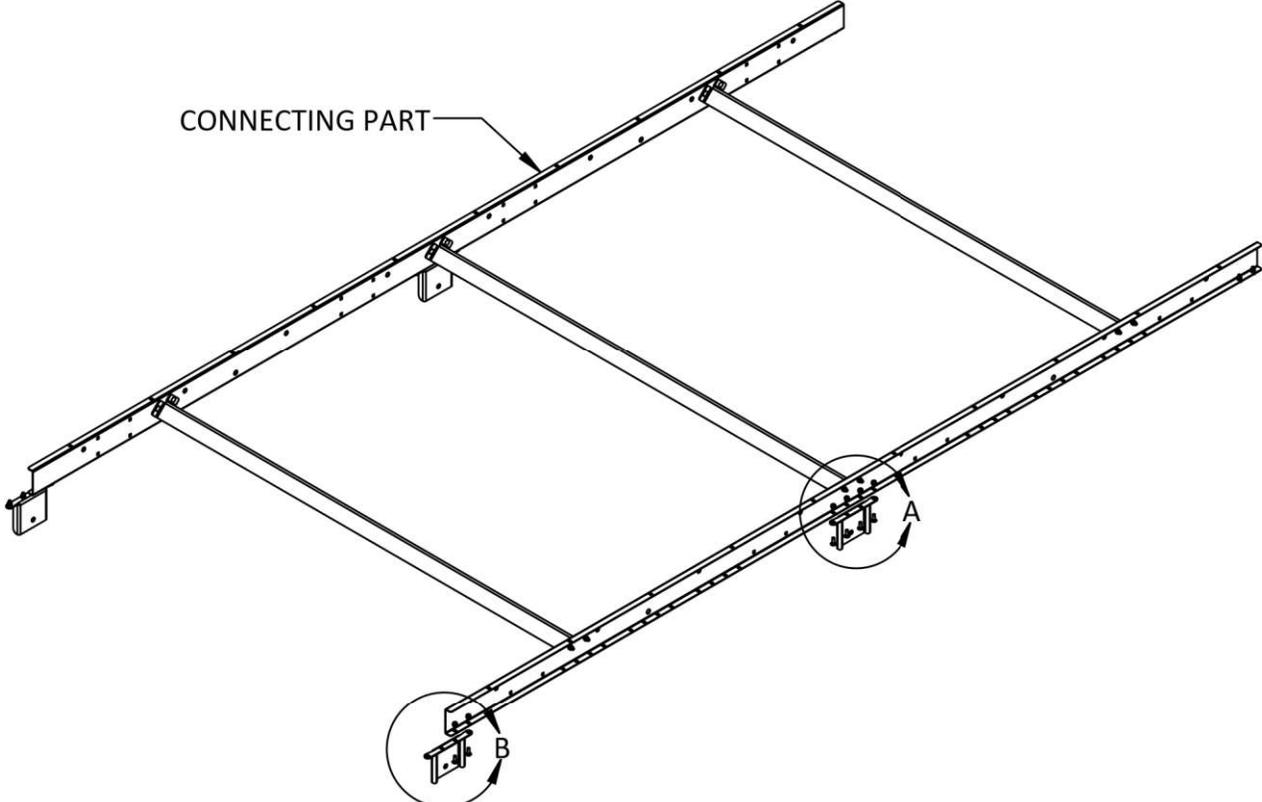
Installation

6. Position and anchor Take-up Unit



Installation

7. Attach Connecting Plates to all Connecting Part



1/4-20 X 3/4" CARRIAGE BOLT

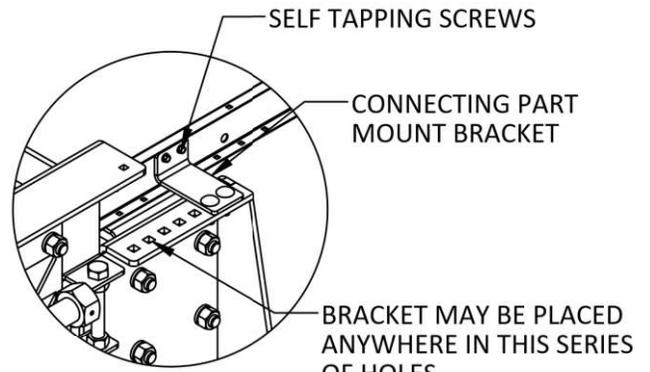
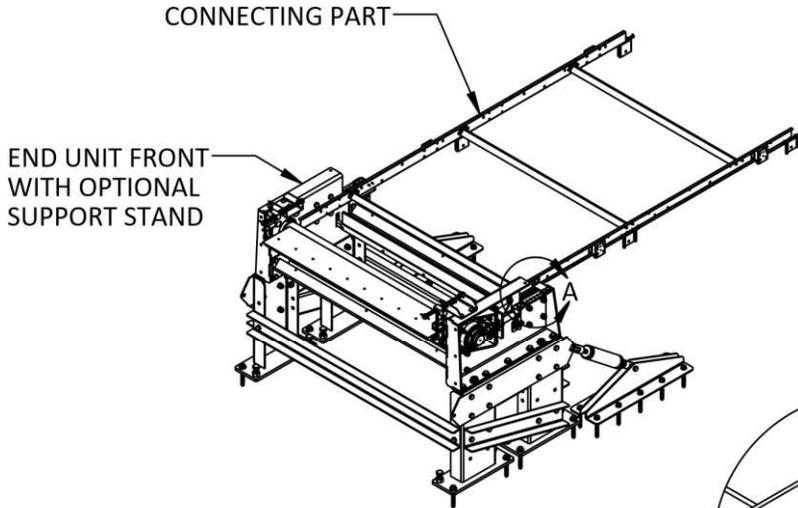
CONNECTING PLATE

Installation

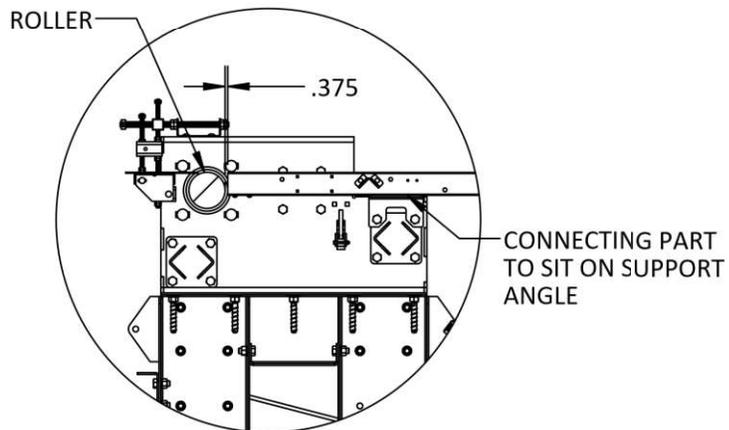
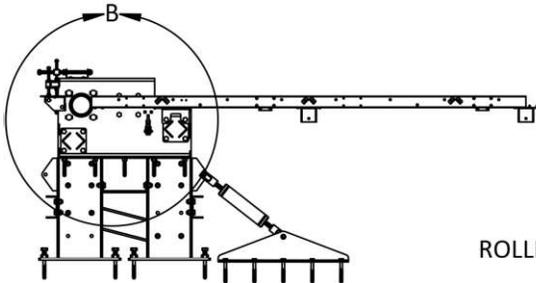
8. Attach Connecting Part to End Unit, Front using supplied hardware.



End of Connecting Part should be $3/8''$ away from face of roller



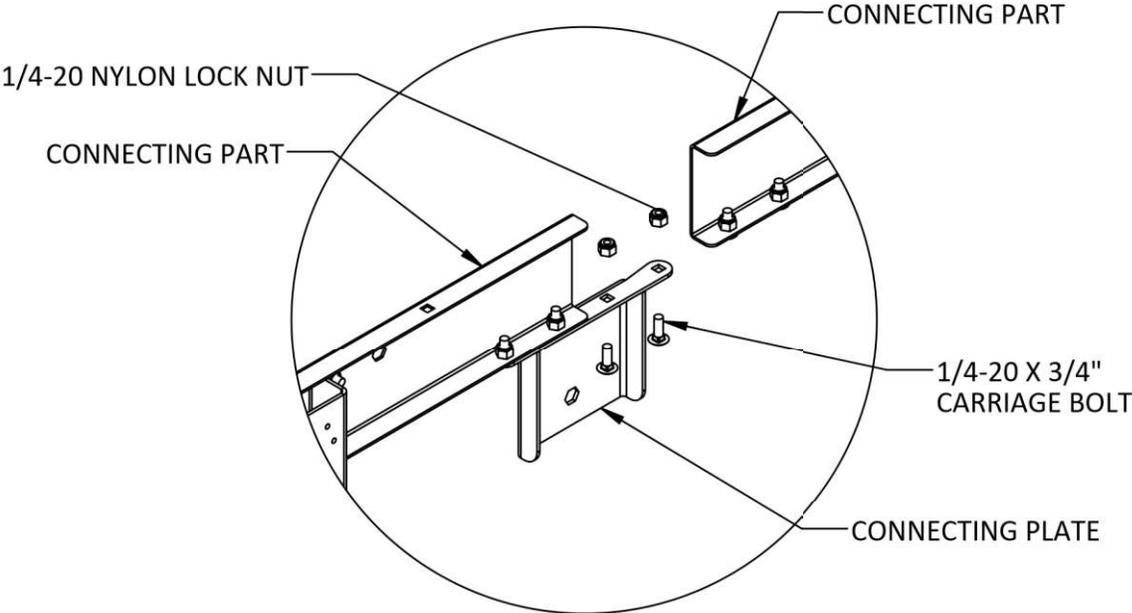
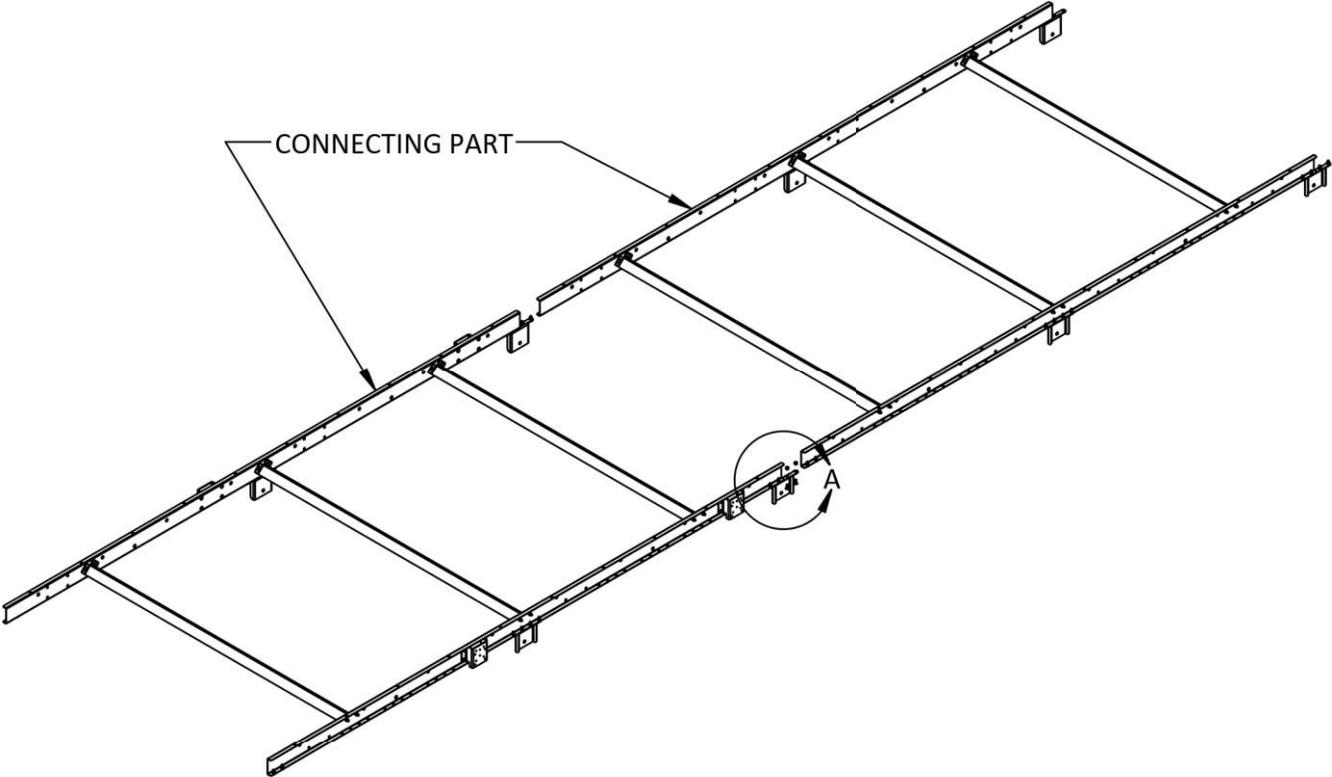
DETAIL A



DETAIL B

Installation

9. Continue to attach Connecting Parts up to Drive Unit using supplied hardware.



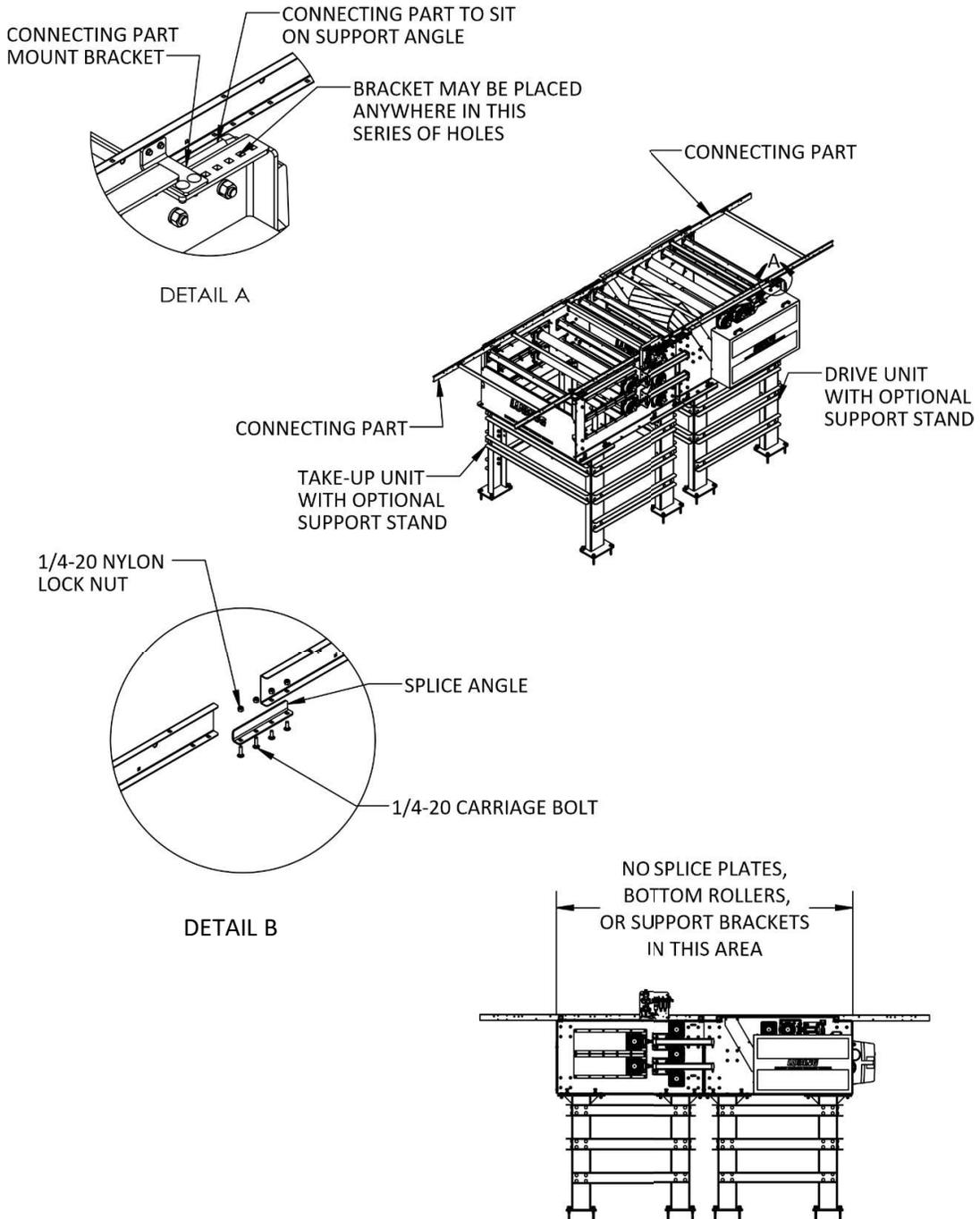
DETAIL A

Installation

10. Attach Connecting Part to Drive Unit using supplied hardware and Connecting Brackets.
11. Determine the location of the Connecting Part within the Drive Unit. Verify the Connecting Part is aligned and centered through the Drive Unit.
12. Attach the Connecting Part using supplied hardware and brackets.



All guards must be in place before operating system.



Installation

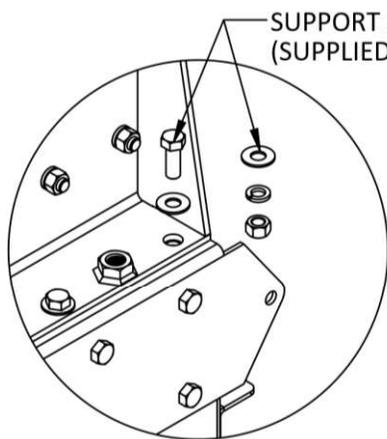
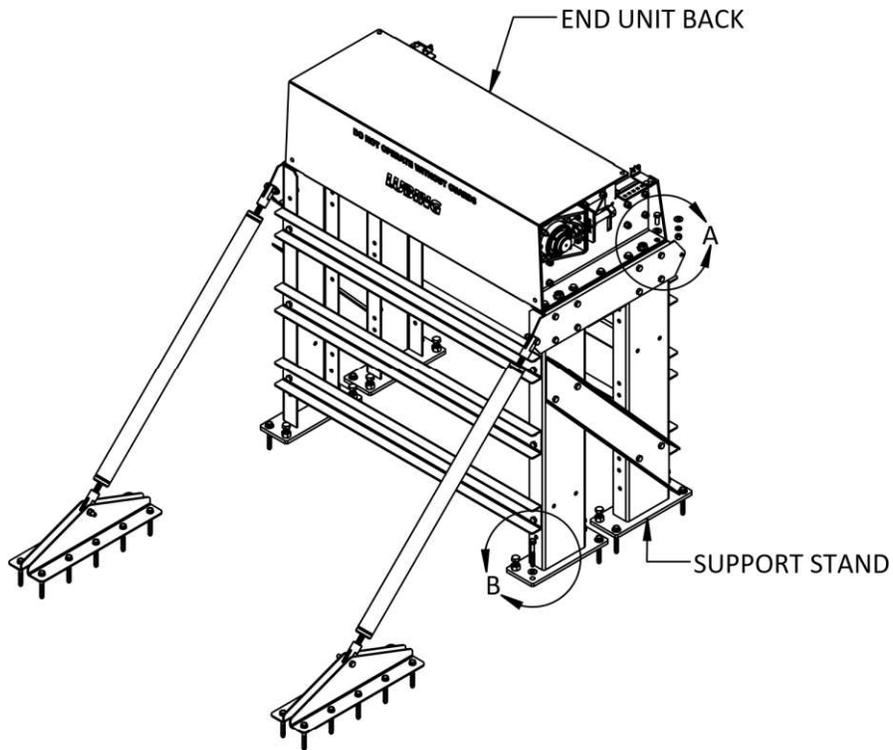
13. Position and anchor End Unit Back.

Note: If Support Stand is required, attach to End Unit Back prior to anchoring.

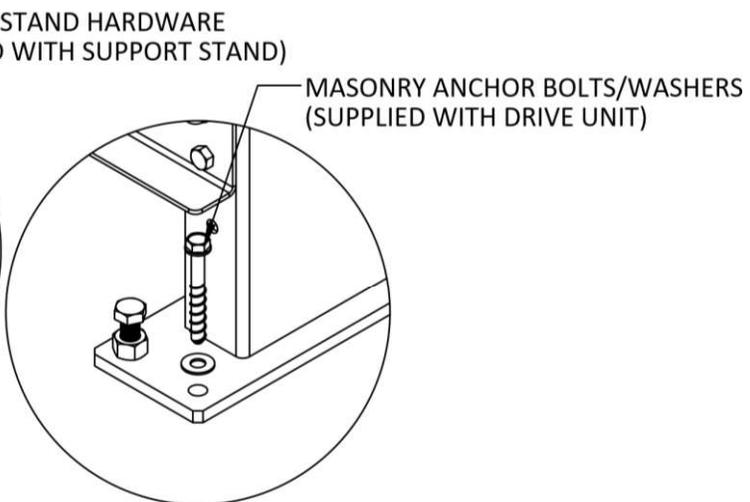
Note: If Support Stand was purchased through Lubing Systems, use supplied hardware for attaching End Unit Back.



End Unit Back must be aligned to centerline and level to ensure proper operation.
If anchoring End Unit Back to surface other than concrete, use appropriate fasteners.



DETAIL A



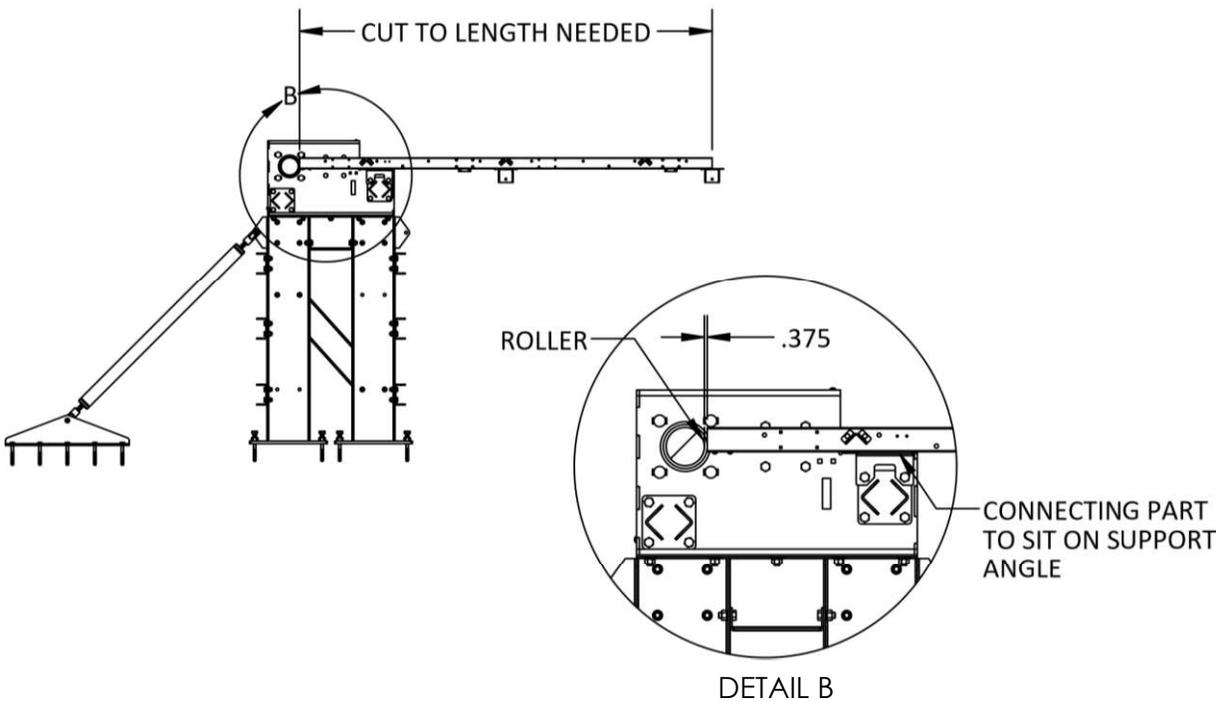
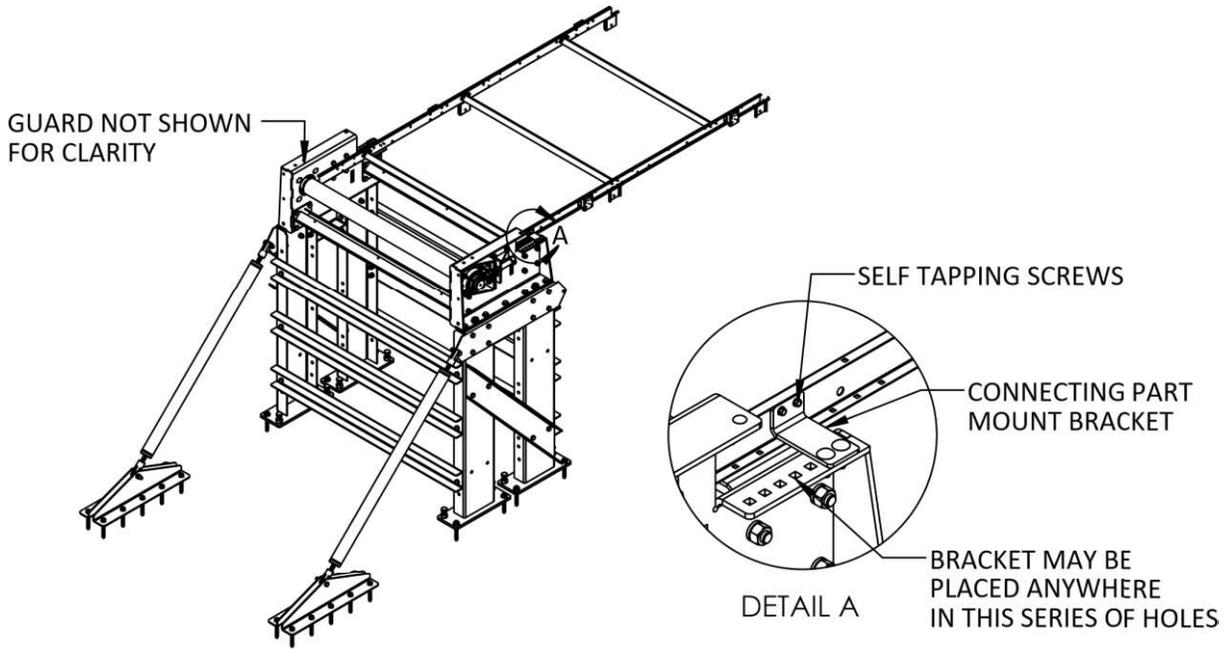
DETAIL B

Installation

- 14. Continue to attach Connecting Parts up to End Unit Back.
- 15. If needed, modify length of Connecting Part.

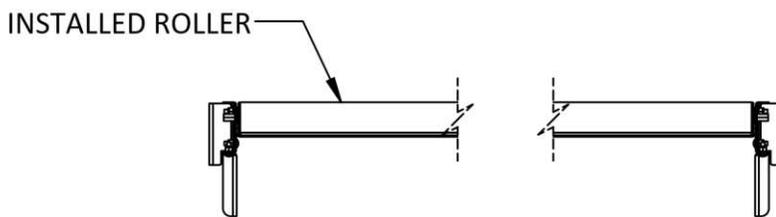
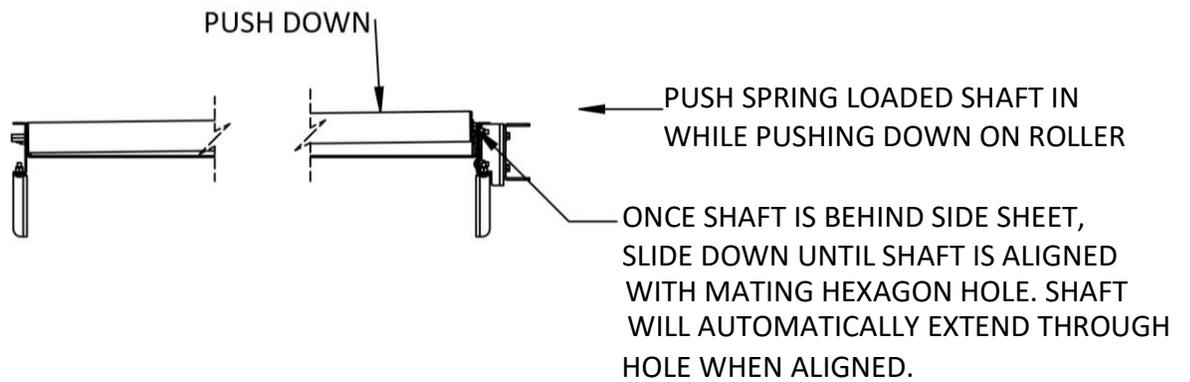
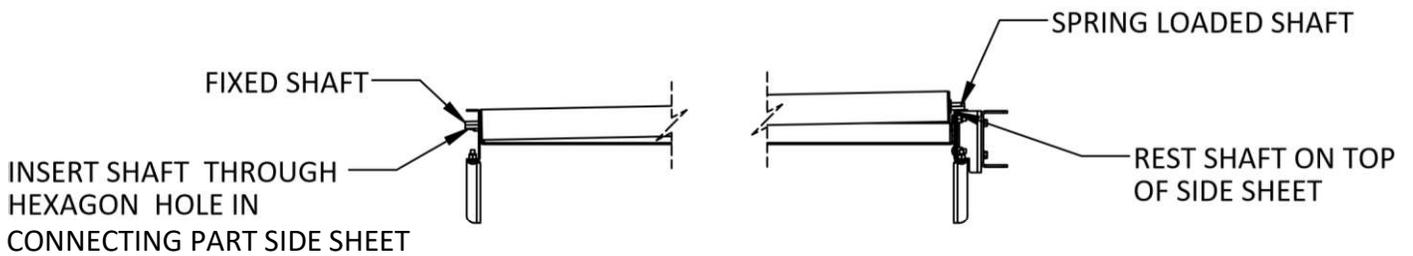
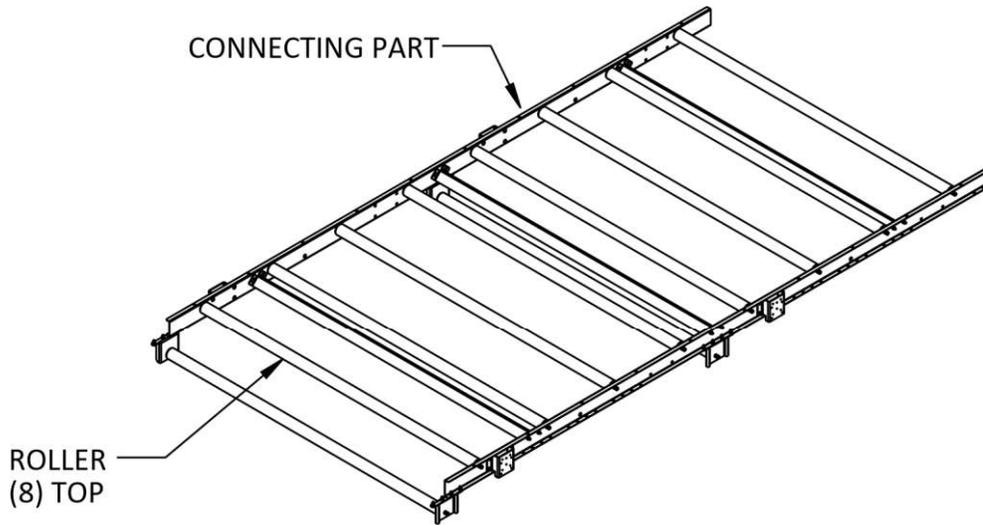


Both Side sheets and egg guide must be cut to the same length to ensure proper operation.
End of Connecting Part should be 3/8" away from face of roller



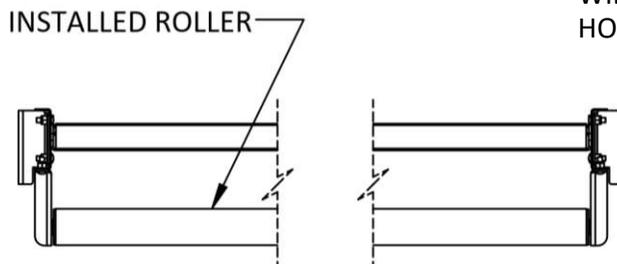
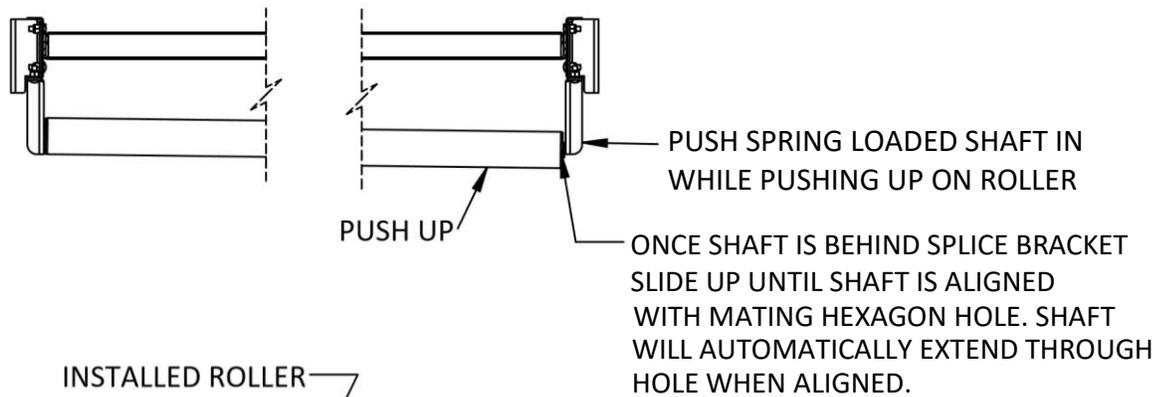
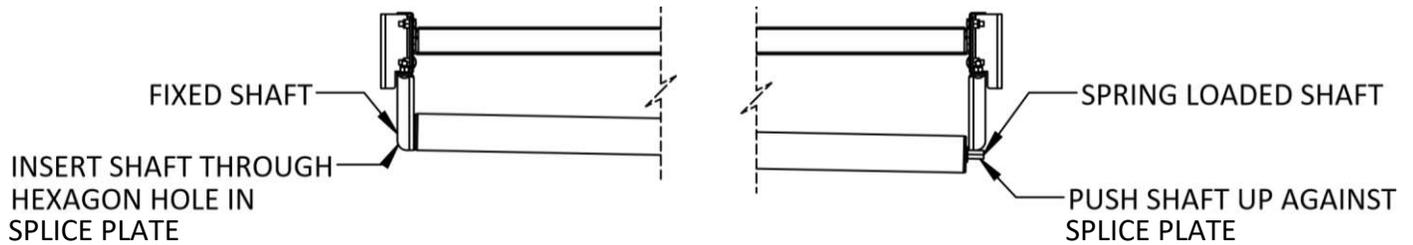
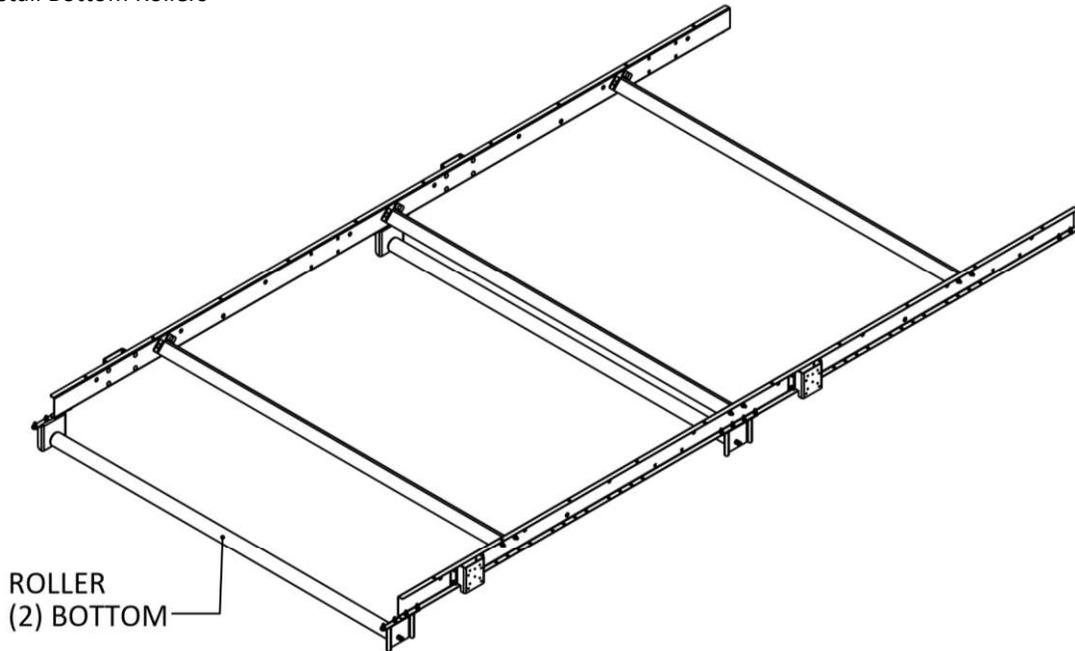
Installation

Install Top Rollers.



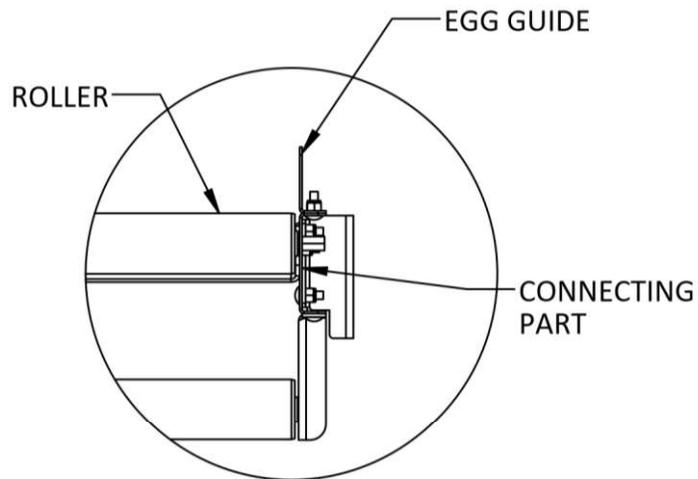
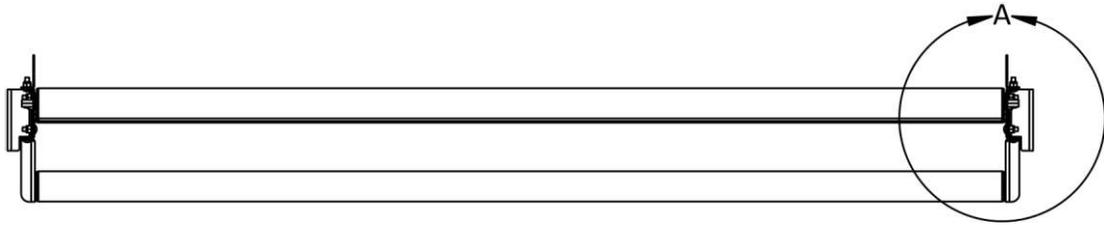
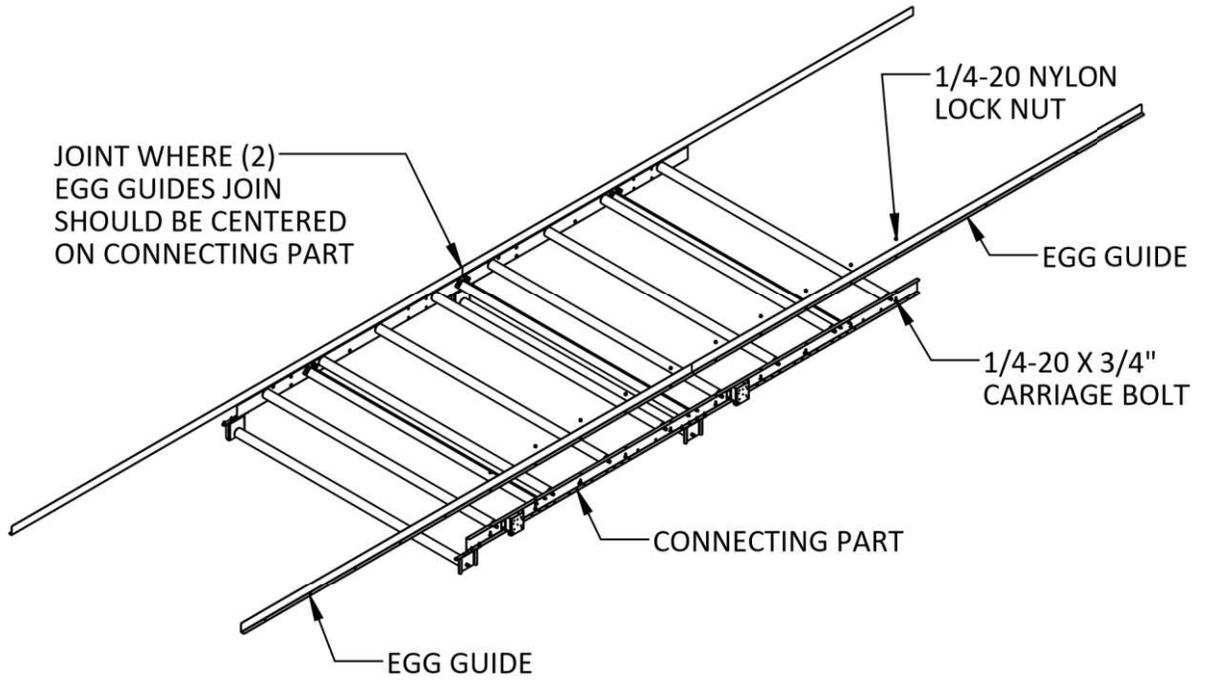
Installation

16. Install Bottom Rollers



Installation

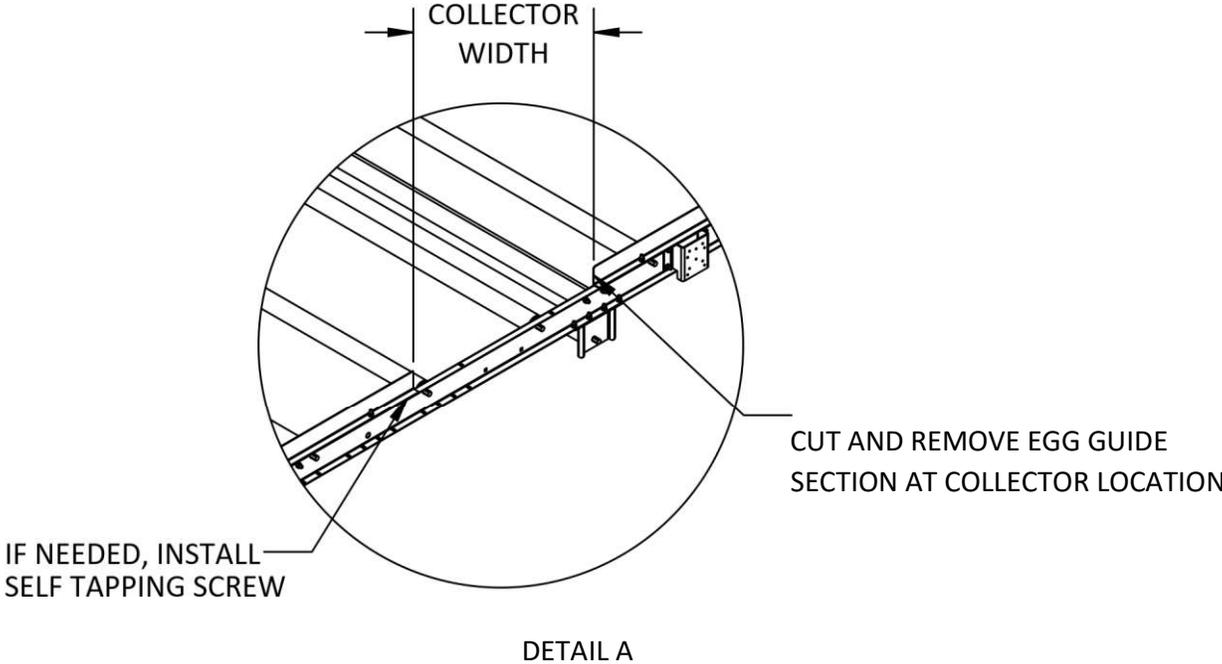
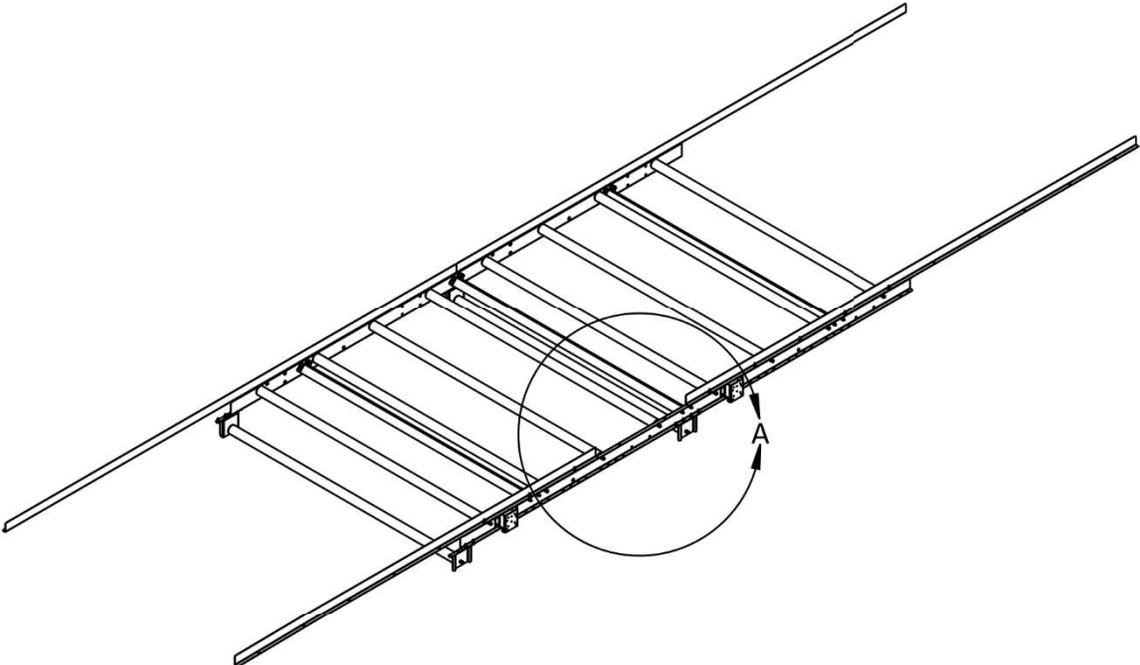
17. Install Egg Guide



DETAIL A

Installation

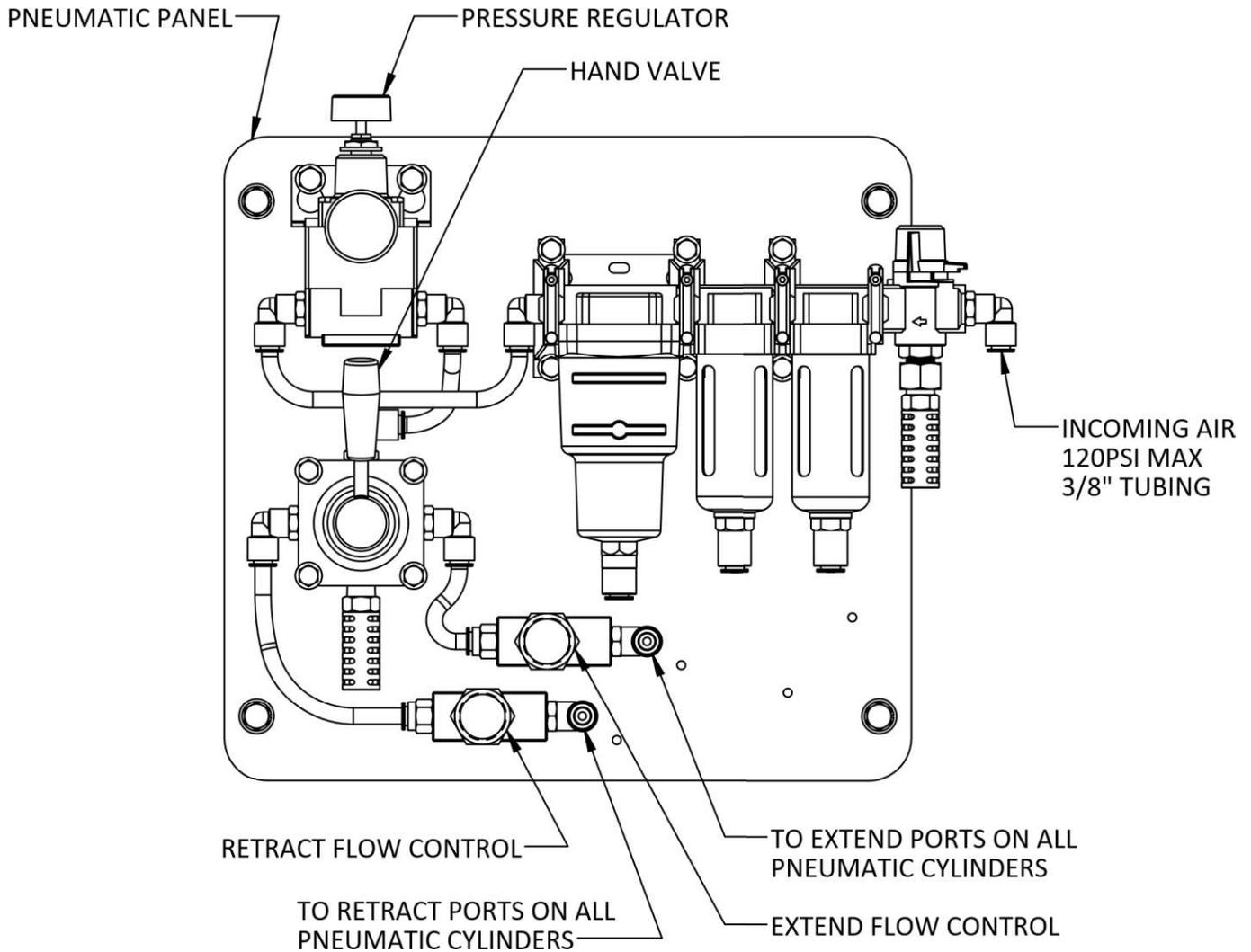
18. After installation, cut Egg Guide at desired location for egg collectors.



Installation

19. Plumb Take-up Unit Air cylinders using supplied 3/8" pneumatic tubing.

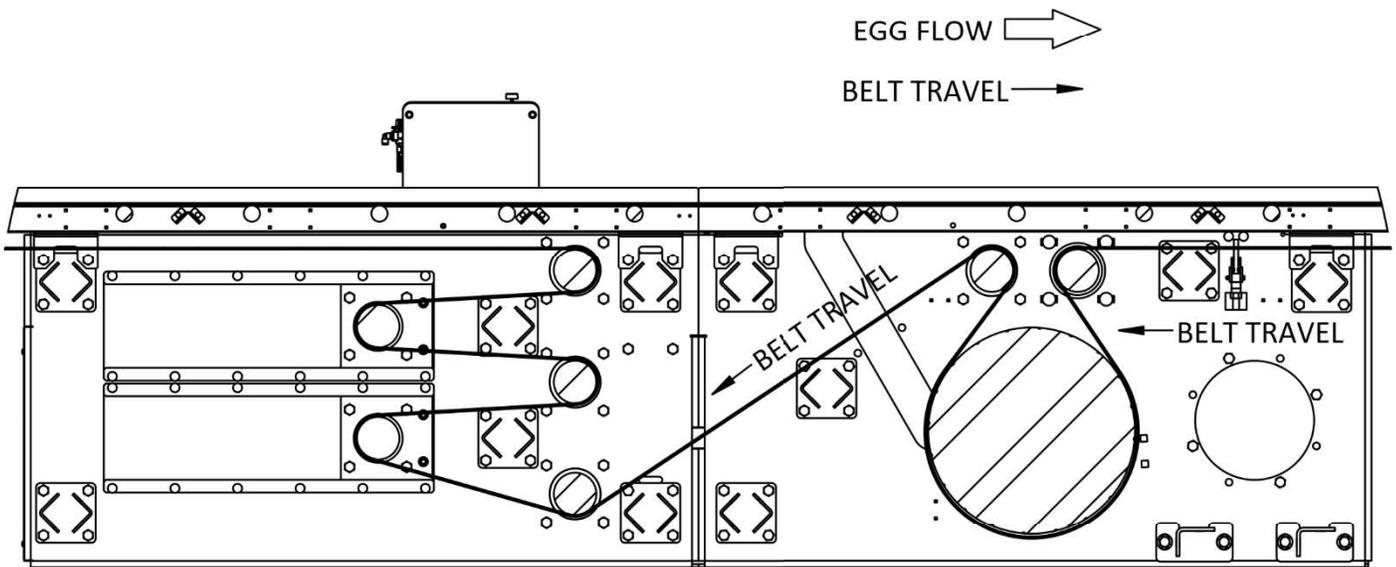
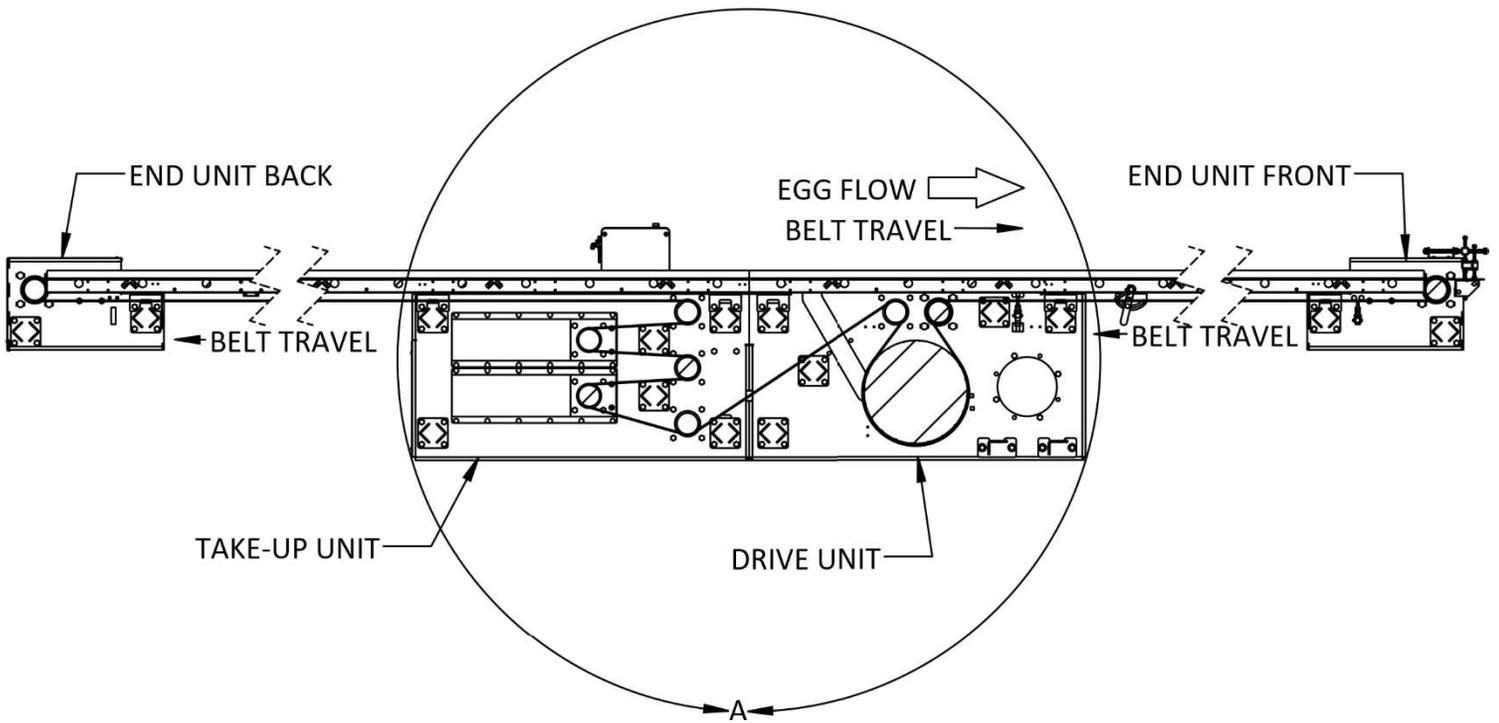
Note: Pneumatic Panel may be mounted on either side of Take-Up Unit



* ALL TUBING LENGTHS FROM PNEUMATIC PANEL TO AIR CYLINDERS MUST BE THE SAME LENGTH TO ENSURE REACTION SPEEDS ON BOTH SIDES ARE SYNCHRONOUS

Installation

Belt Threading



DETAIL A

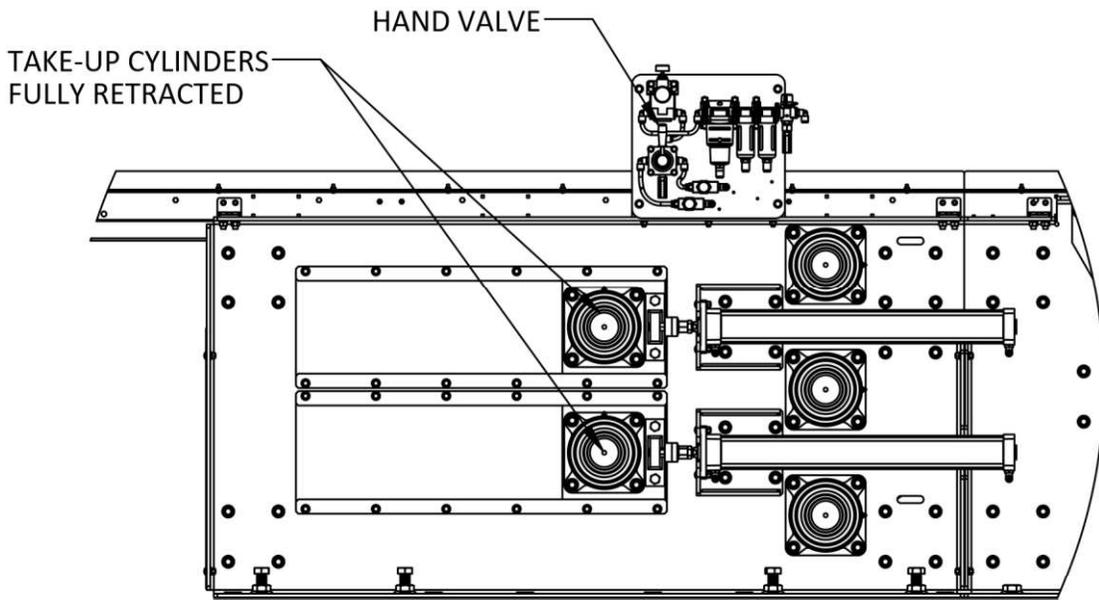
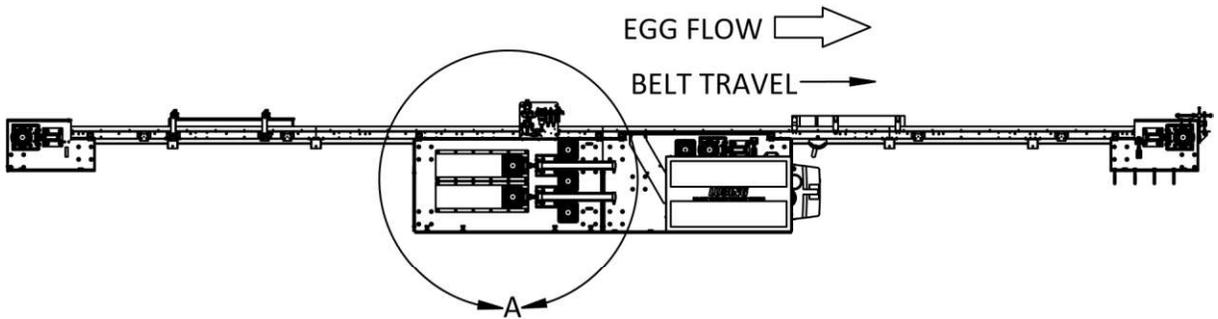
Installation

Belt Installation

20. Take-up Cylinders must be fully retracted before threading Belt. This will allow maximum take-up after the Belt installation is complete. If air pressure is applied, use the Hand Valve to move the Take-up Cylinders to the appropriate position.



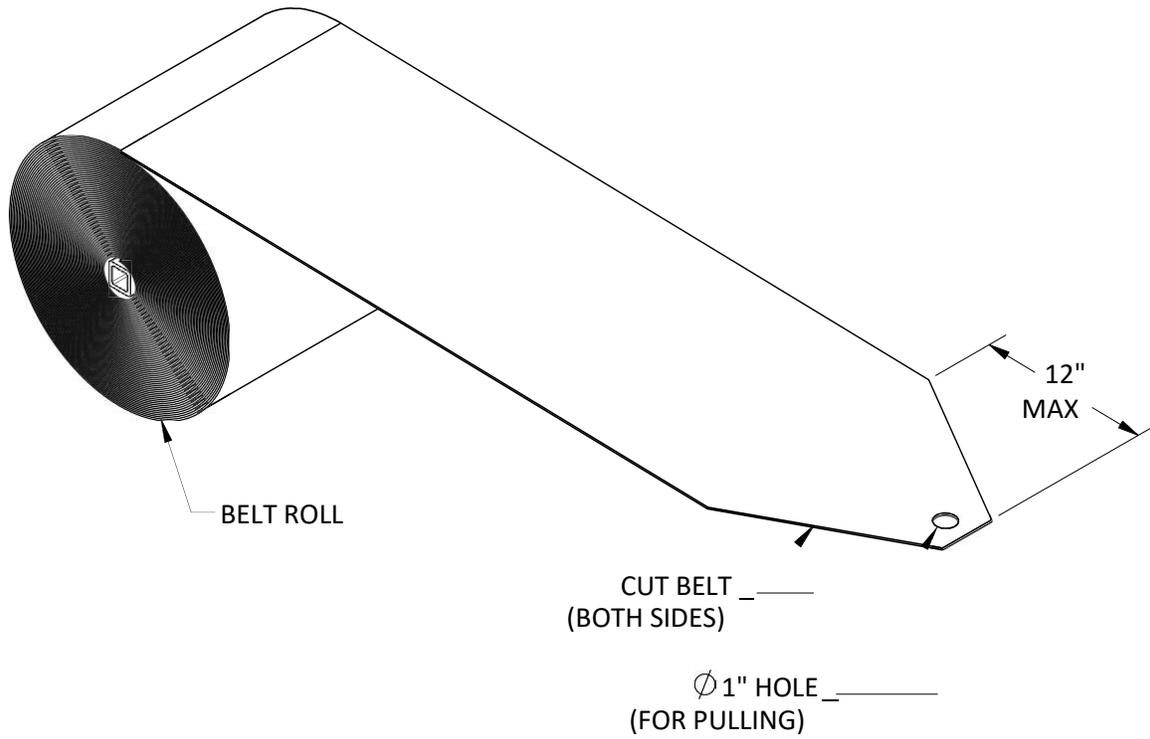
Failure to observe will result in slippage between Belt and Drive Roller or loss of Take-up travel.



DETAIL A

Installation

21. Trim Belt corners to ease threading through system.
22. Add a hole in the center of the Belt to attach rope.



Installation

23. Thread rope through system as shown below starting on the bottom side of the system.

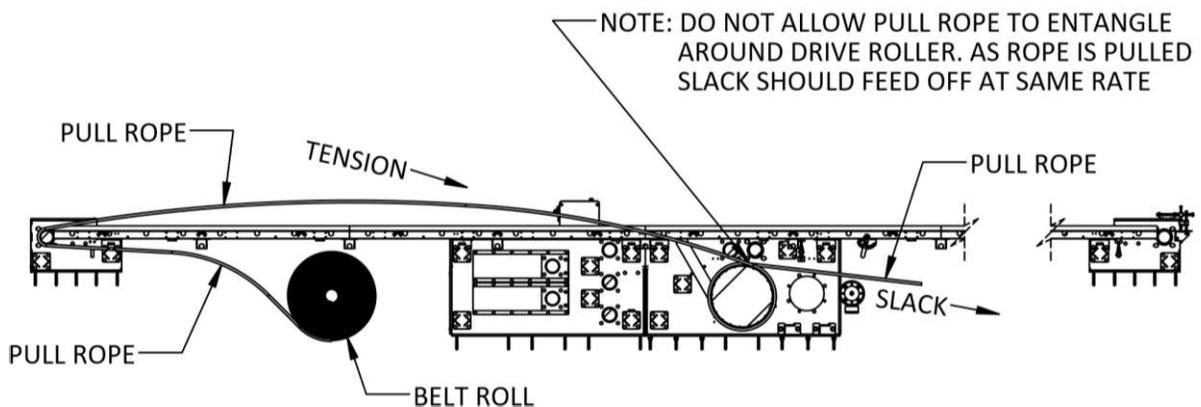
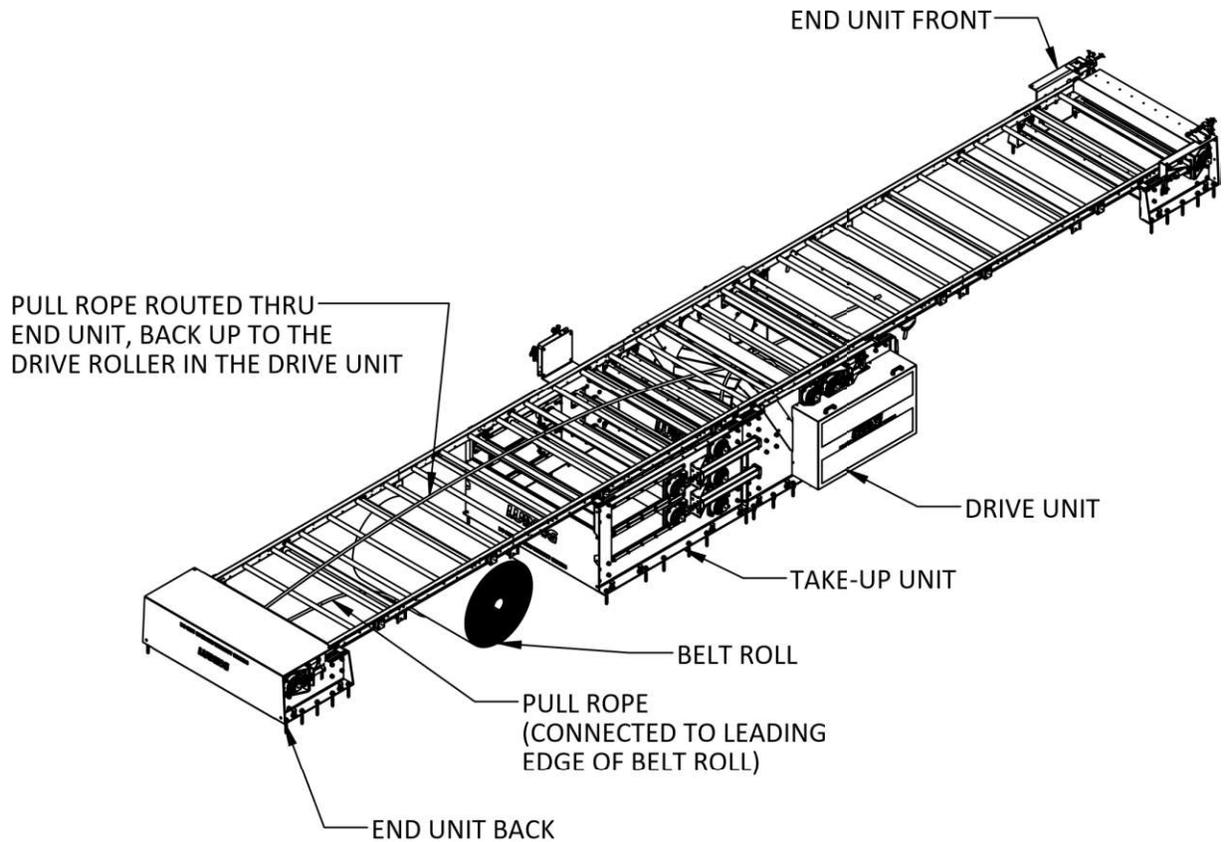


Failure to observe will result in slippage between Belt and Drive Roller or loss of Take-up travel.

24. Use Drive Roller to thread Belt.



Rope should be wrapped only once around Drive Roller.
Speed of Drive Roller should be set to minimum via the Variable Frequency Drive.
Drive Roller direction must be reversed.



Installation

25. Hold tension on free end of rope to start threading.

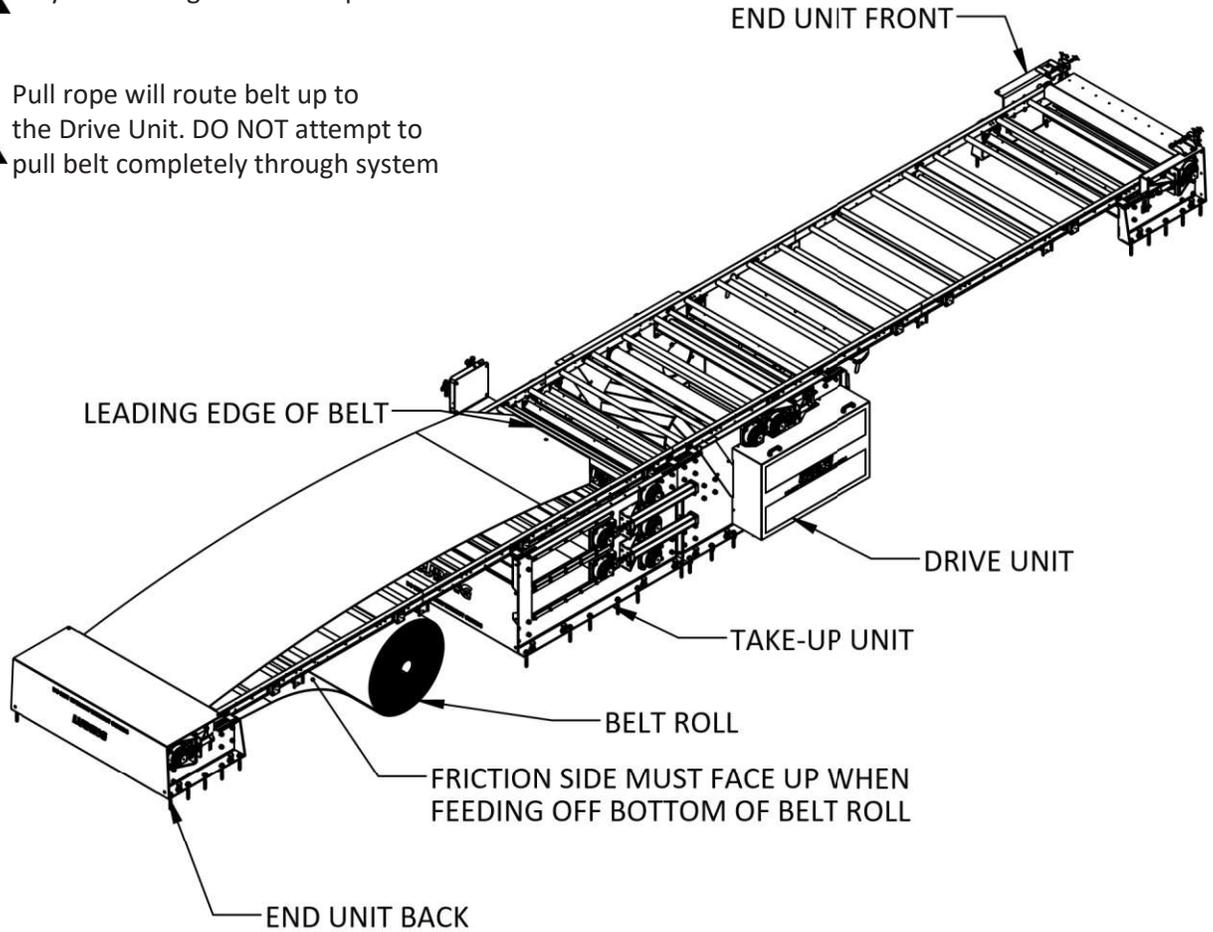
26. Stop pulling when Belt reaches Drive Roller.



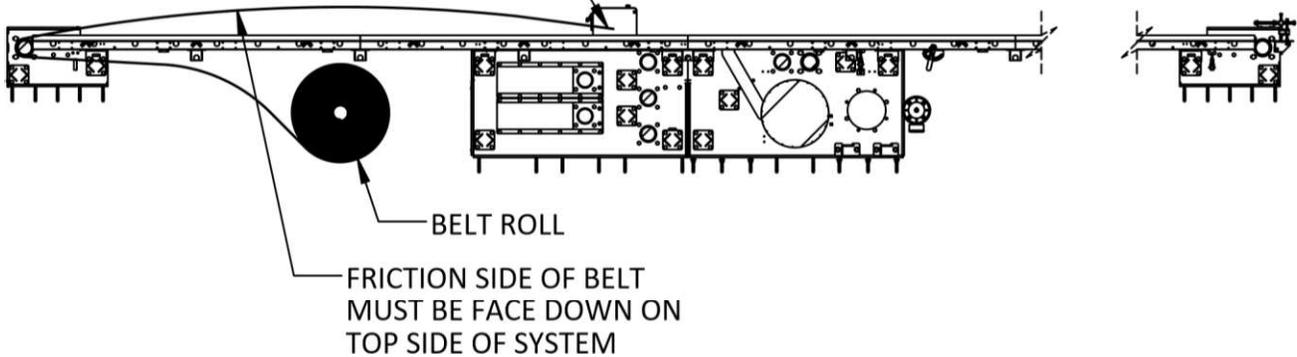
Stay clear of nip points and rope entanglement.
Stay clear of high-tension rope.



Pull rope will route belt up to the Drive Unit. DO NOT attempt to pull belt completely through system



NOTE: STOP PULLING BELT WITH PULL ROPE WHEN APPROACHING DRIVE UNIT



Installation

27. Thread opposite end of Belt through Drive Unit and End Unit, Front meeting opposite end of Belt on top side of system. Ends should meet outside Drive Unit for ease of Belt cutting/splicing.
28. Overlap Belt approximately 16 inches. Amount of overlap should ensure complete removal of any cuts, holes, or damage previously made on Belt.
29. Mark the overlap location on the top Belt layer, measure 3-inches and mark (this will become the cut location).

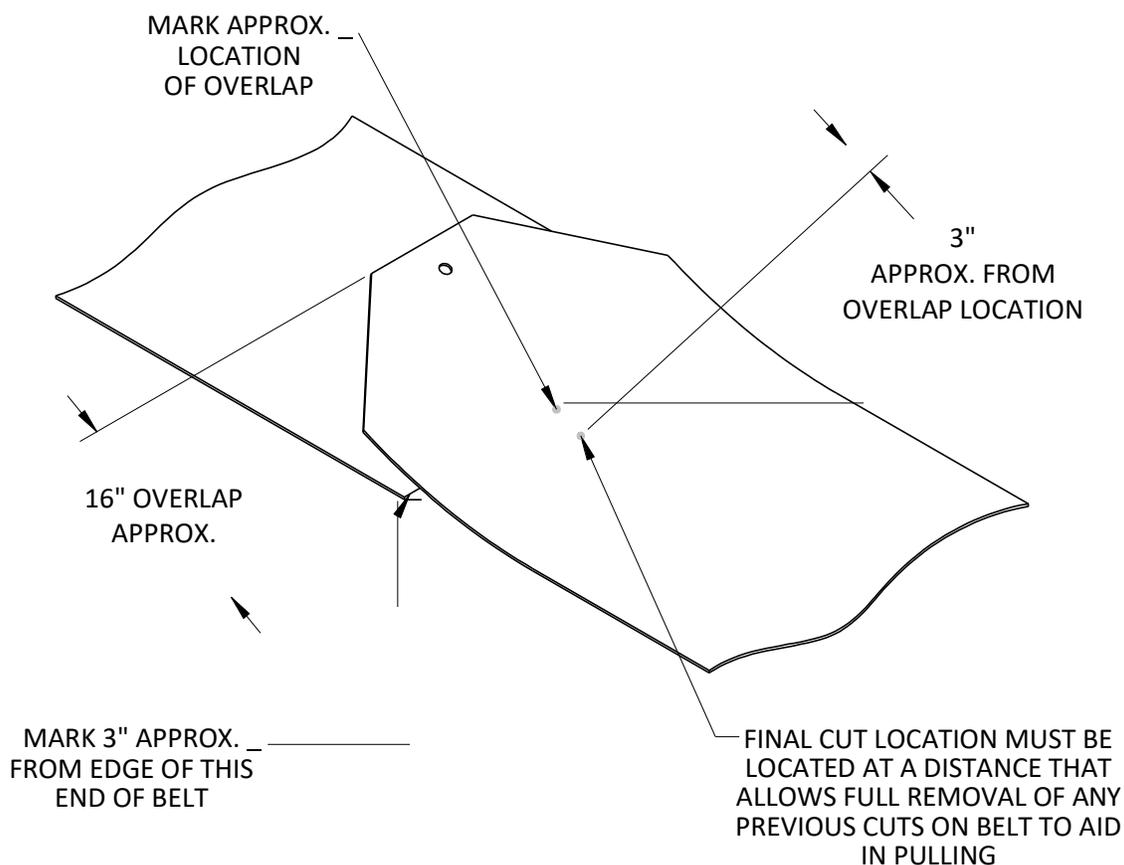


Do not cut Belt at this time!

30. On the bottom Belt Layer, measure 3-inches from the end and mark (this will become the cut location for this end of Belt).



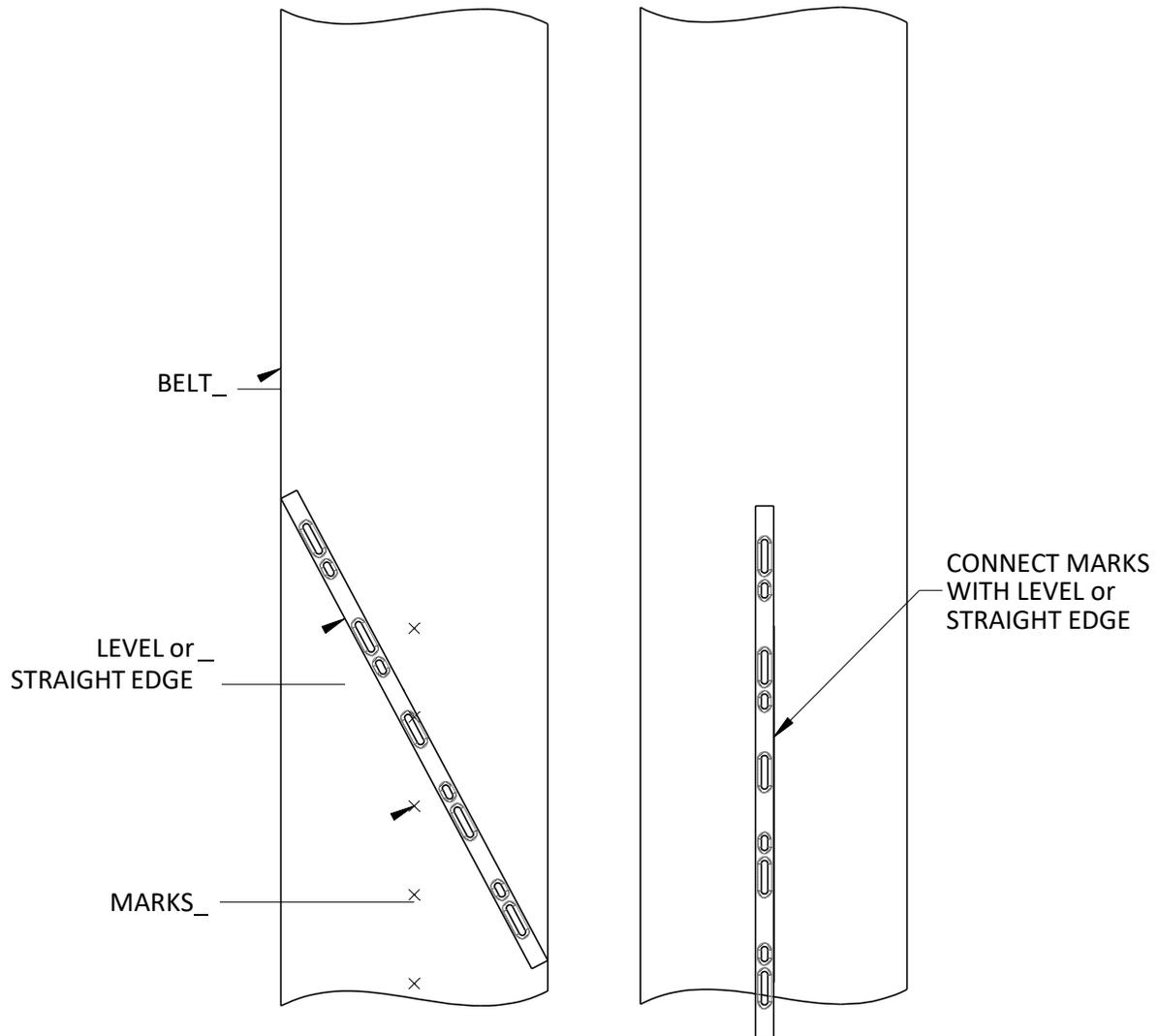
Do not cut Belt at this time!



Installation

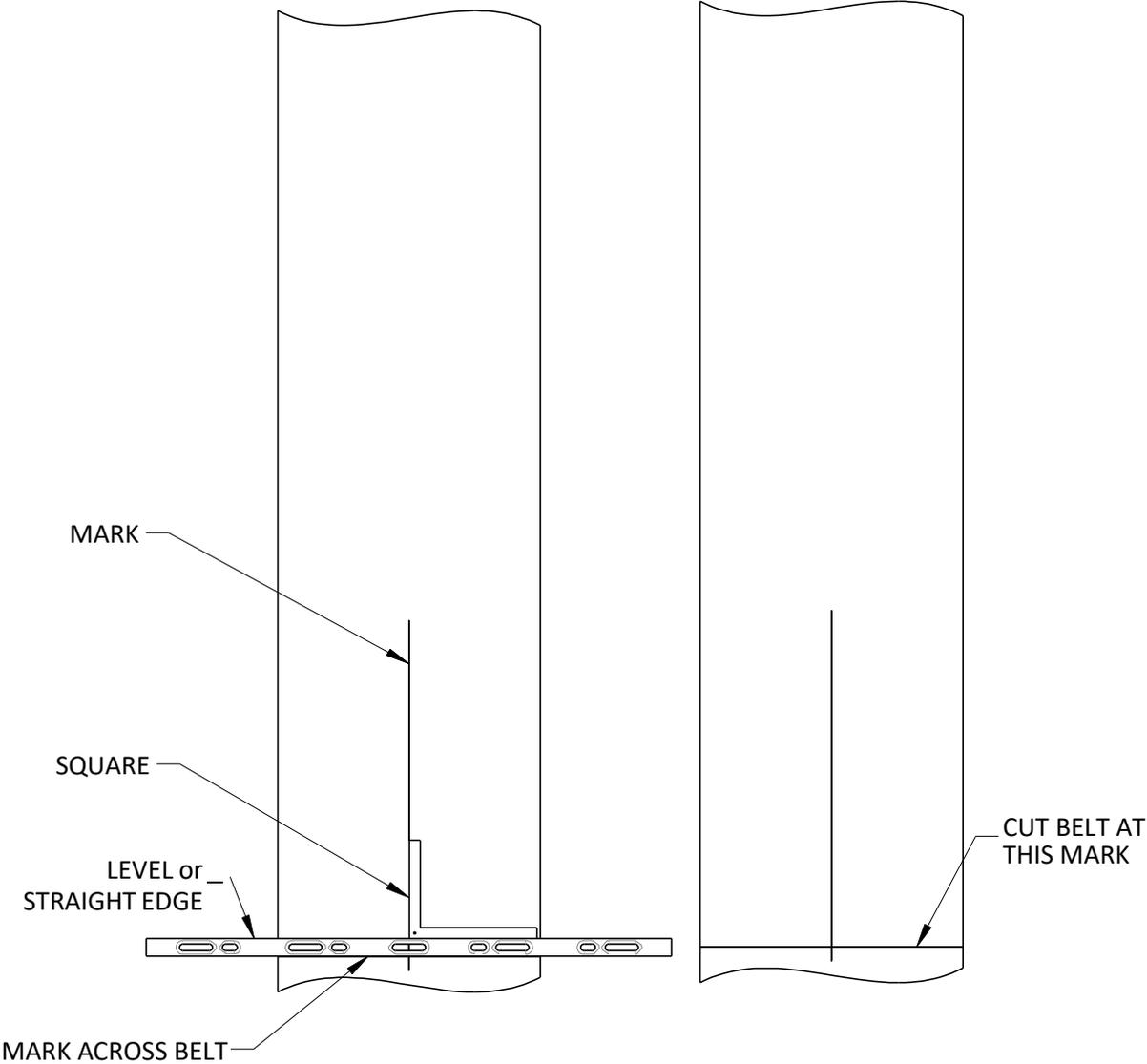
Belt Cutting

31. Mark the 6-ft level in the approximate center as a reference point.
32. Align the corners of the level with the sides of Belt.
33. Move the level down Belt, transferring marks on Belt that corresponds to the center mark on the level. Ensure the corners of level are aligned with the sides of Belt before each mark is made. A minimum of five marks should be transferred onto Belt.
34. Align level with marks and draw a line. Line is parallel with Belt Travel.



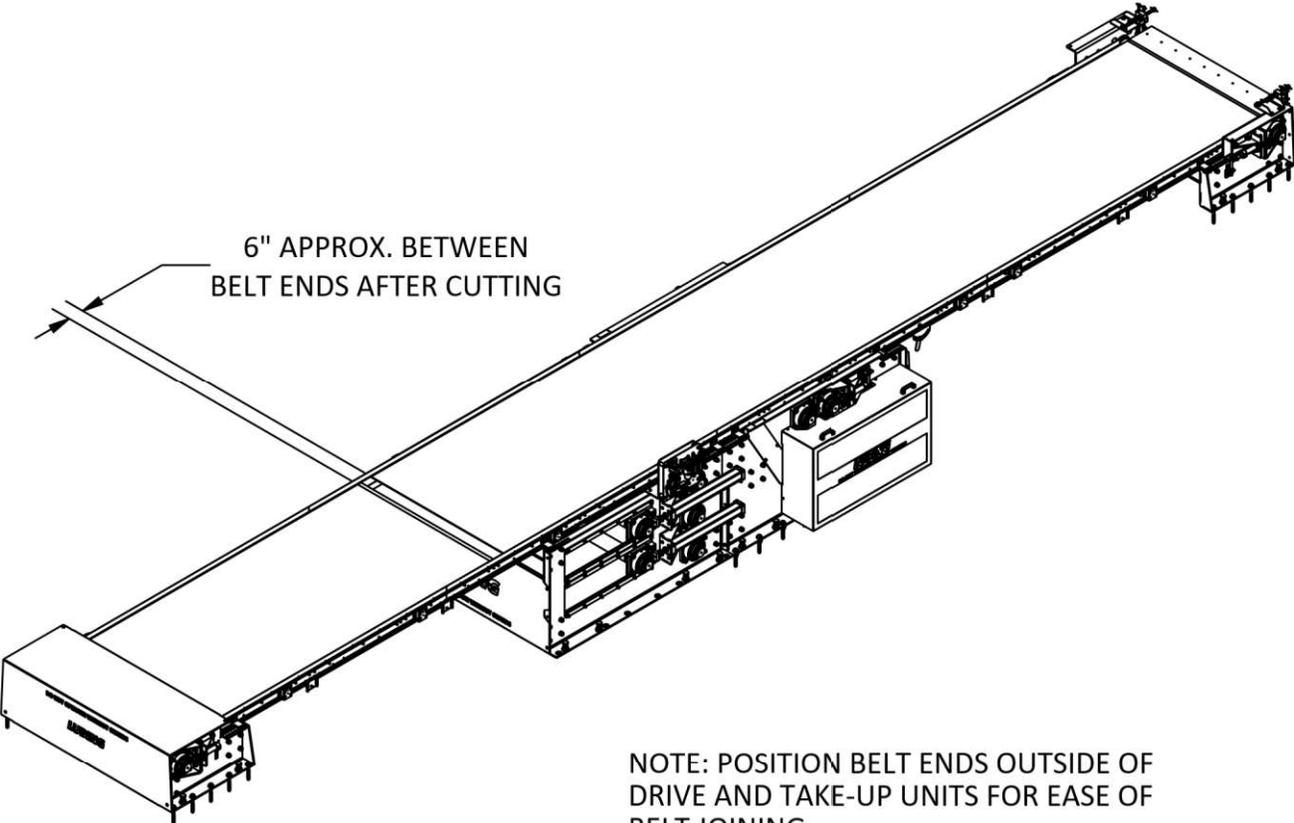
Installation

- 35. Align framing square with parallel line.
- 36. Align level with framing square and draw perpendicular line at cut location.
- 37. Use level to ensure straight cut.



Installation

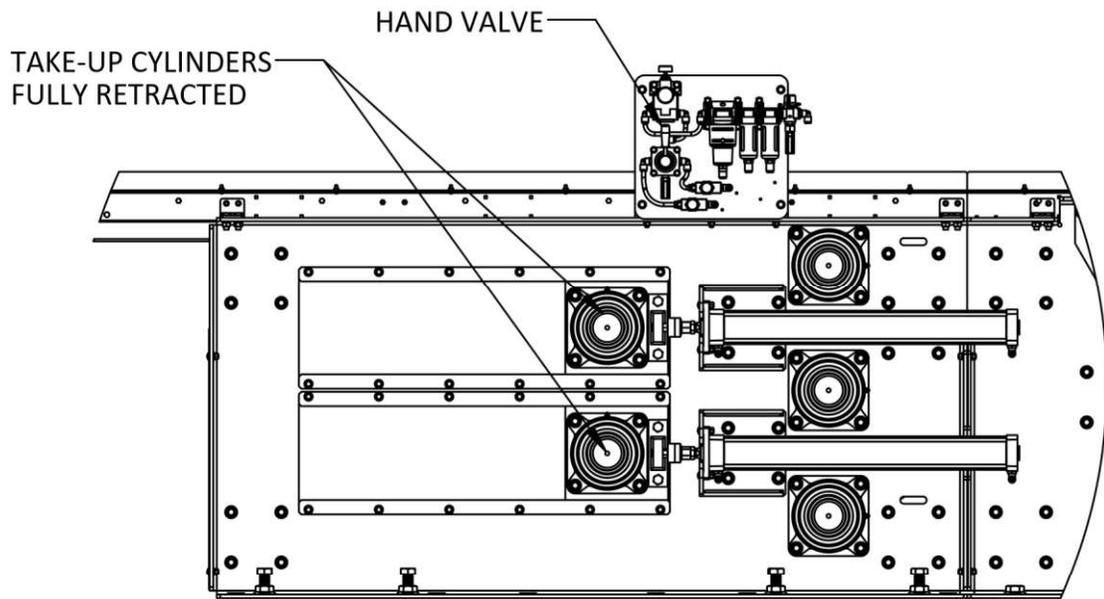
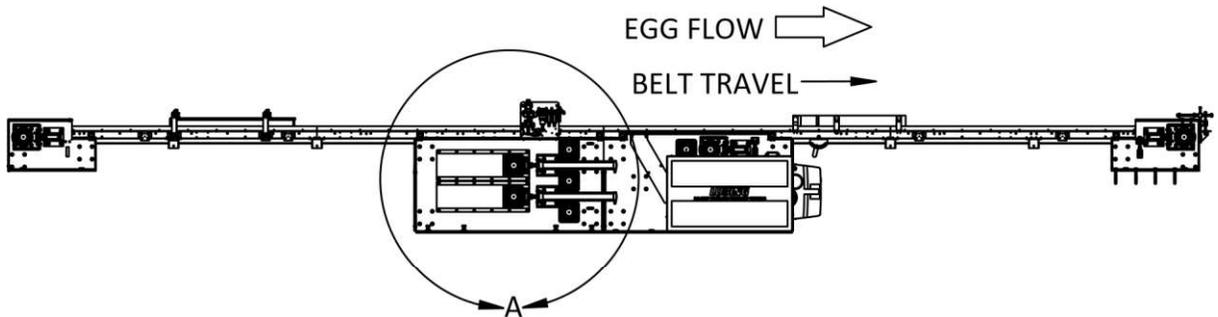
38. After cutting both Belt ends, an approximate 6-inch gap should remain.



Installation

Belt Splicing

39. Refer to *Flexco Alligator Lacing* manual for proper Belt Splicing procedures.
40. Refer to *Flexco Far-Pul HD Belt Clamp* manual for proper Belt Joining procedures.
41. Apply air pressure to tension Belt using the Hand Valve.



DETAIL A

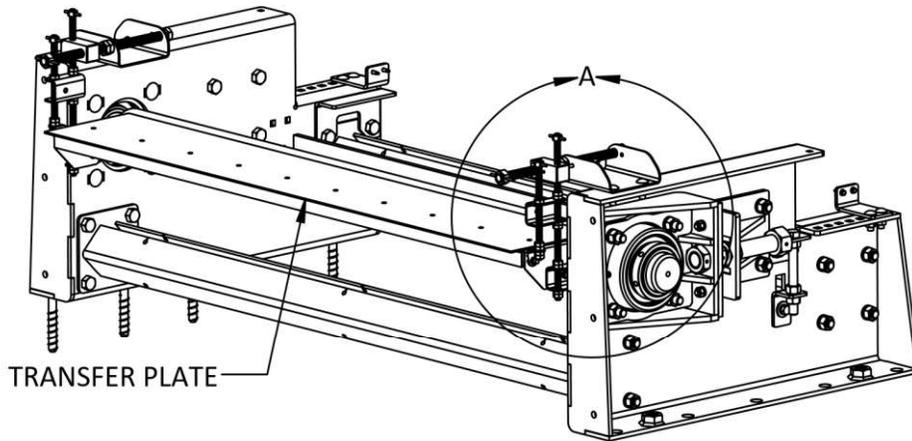
Installation

Transfer Plate Adjustment



Adjust Transfer Plate to user's needs.
Adjust Transfer Plate to allow clearance for Belt Splice(s).

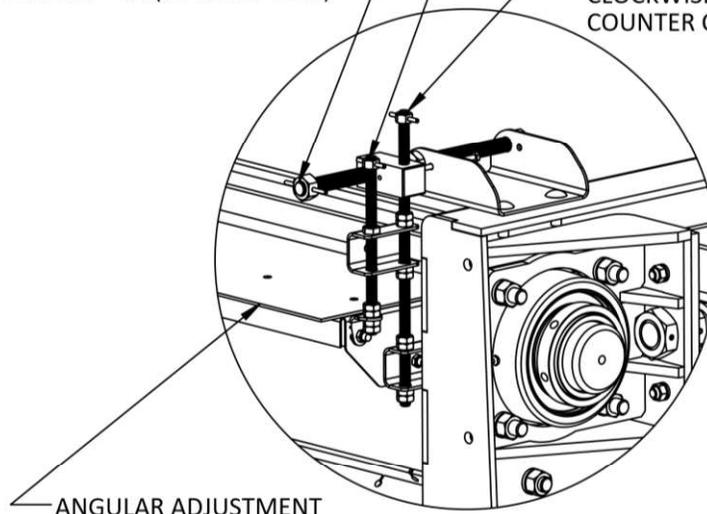
**NOTE: GAP BETWEEN TRANSFER PLATE
AND BELT MUST BE SET TO ALLOW
BELT SPLICE TO PASS WITHOUT CONTACT**



HORIZONTAL ADJUSTMENT
CLOCKWISE = OUT (AWAY FROM BELT)
COUNTERCLOCKWISE = IN (TOWARD BELT)

ANGULAR ADJUSTMENT
CLOCKWISE = ANGLE DOWN
COUNTER CLOCKWISE = ANGLE UP

VERTICAL ADJUSTMENT
CLOCKWISE = DOWN (TOWARD BELT)
COUNTER CLOCKWISE = UP (AWAY FROM BELT)

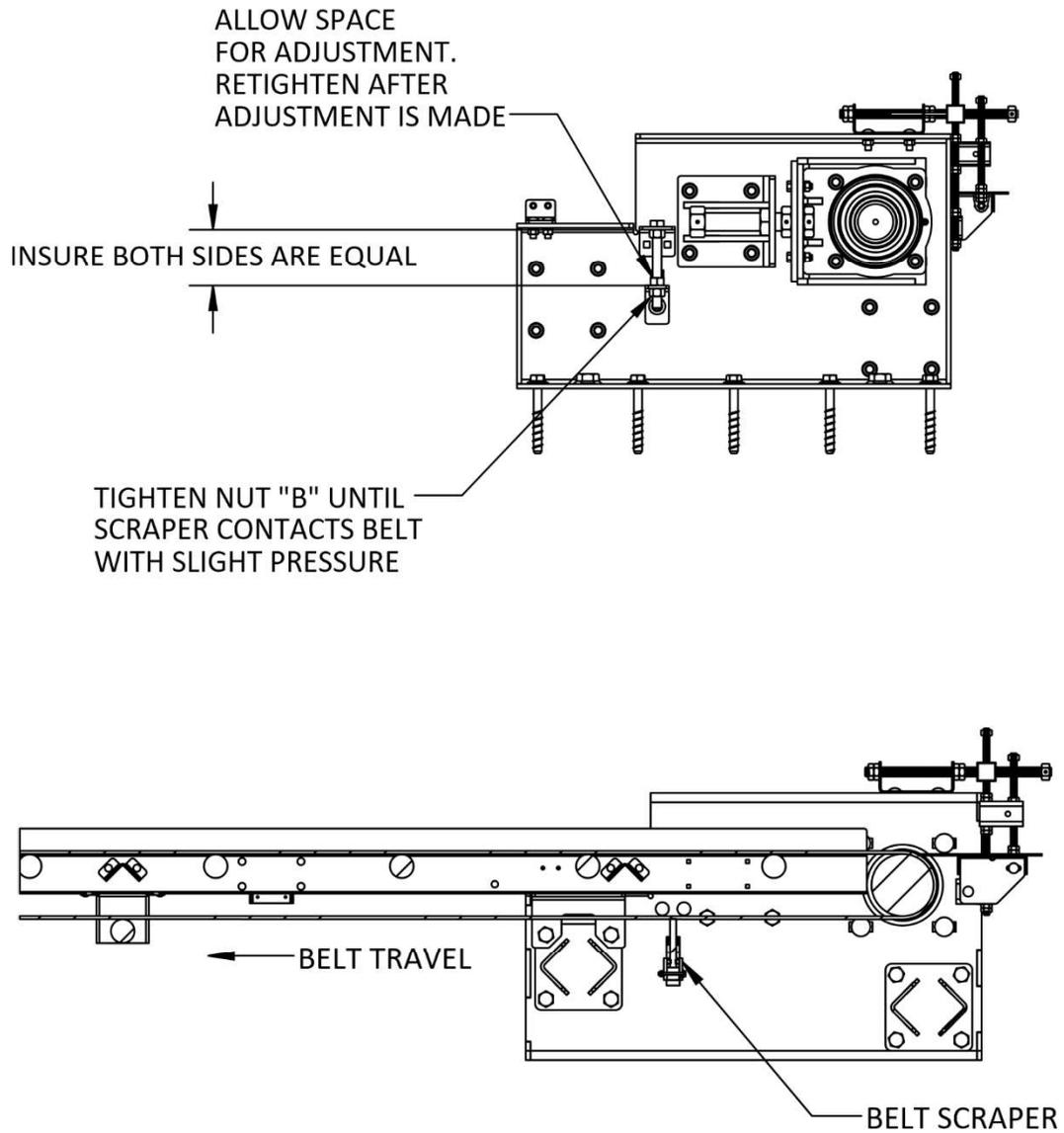


ANGULAR ADJUSTMENT
CLOCKWISE = THIS EDGE DOWN
COUNTER CLOCKWISE = THIS EDGE UP

DETAIL A
ADJUSTMENTS SAME FOR BOTH SIDES OF TRANSFER PLATE

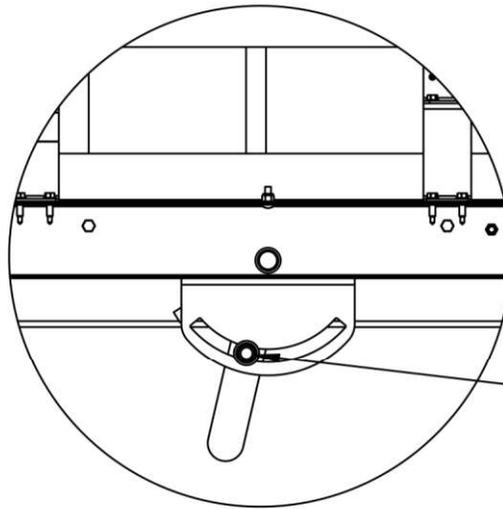
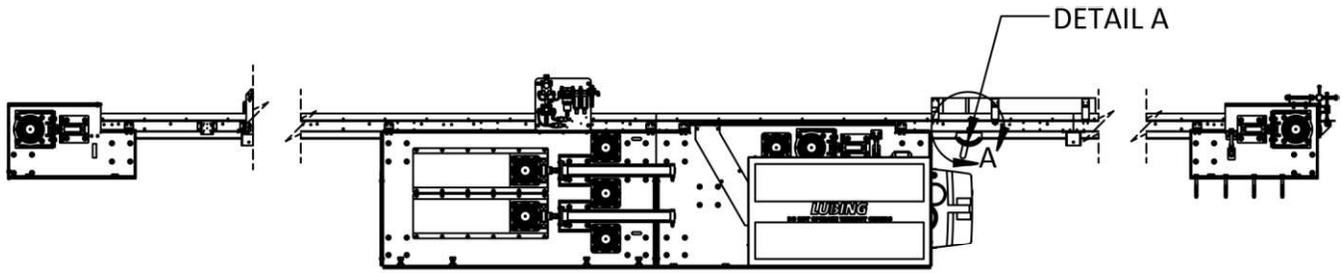
Installation

Belt Scraper Adjustment, Drive Unit/End Units

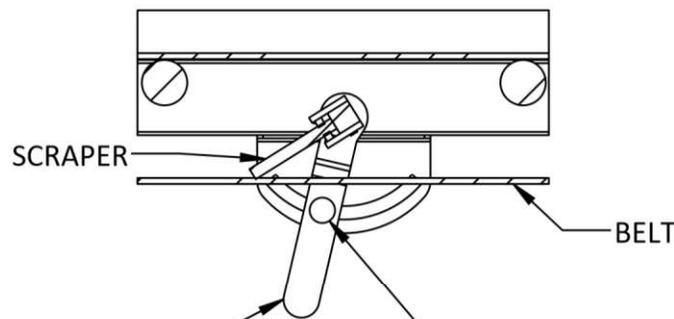


NOTE: ADJUSTMENT FOR DRIVE UNIT SCRAPER SAME AS ABOVE

Belt Scraper Adjustment, Connecting Part



DETAIL A



PUSH HANDLE UNTIL
SCRAPER CONTACTS
BELT WITH SLIGHT PRESSURE

WHILE HOLDING PRESSURE
TIGHTEN NUT. THEN TIGHTEN
NUT ON OTHER SIDE OF
CONNECTING PART

Start-Up and Troubleshooting

SECTION 4 - START-UP & TROUBLESHOOTING

System Start-Up



Verify all electrical and pneumatic systems for proper operation before System Start-Up. Wear necessary Personal Protective Equipment prior to any work.

Observe all Lockout/Tagout procedures prior to performing work on system.

1. Verify all components are installed and anchored properly according to installation manual.

Note: Failure to install system as engineered by Lubing Systems may result in poor system performance and/or damage to system and product.

2. Ensure any obstructions or foreign objects are clear of Belt.
3. Verify all personnel are clear prior to starting system or engaging Take-up Assembly.
4. Engage Take-Up Assembly.
5. Set Variable Frequency Drive at a minimum frequency to ensure Belt will move at a minimum rate of travel. Place observers at each End Unit and Drive Unit, prepared to adjust Belt tracking.
6. Start the system at a minimum rate of travel, verifying the Belt is centered in system, and for slippage at the Drive Roller. If slippage is observed, increase pressure at Regulator on Pneumatic Panel. Do not exceed recommended maximum air pressure for any pneumatic components.

Note: Failure to start system at a minimum rate of travel could result in Belt tracking off rollers or cause damage to Belt and/or other components of system.

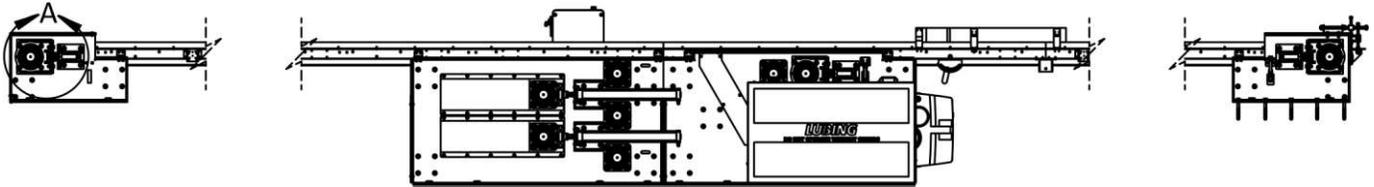
Start-Up and Troubleshooting

Belt Tracking

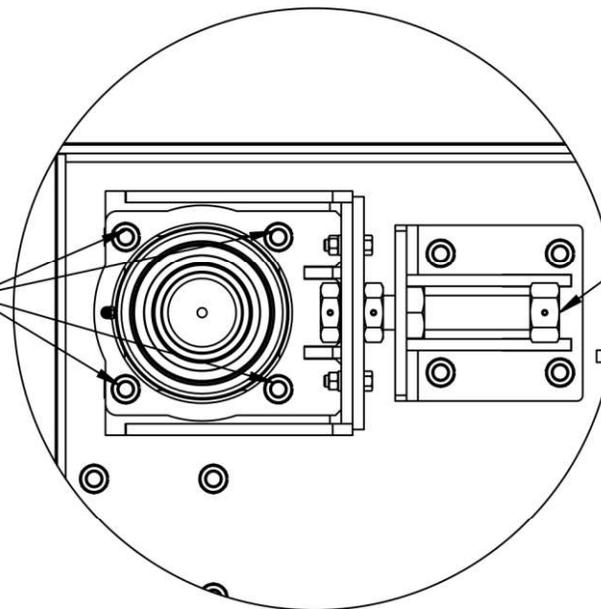
7. Loosen 4 bolts at each tracking location (shown below). Loosen bolts just enough to allow the tracking bracket to slide. DO NOT REMOVE NUTS FROM BOLTS.
8. Turn threaded rod (shown below) to move the end of the shaft in the direction needed to track belt.



Tracking adjustments on Drive Unit affect Belt alignment through Drive Unit only.
Tracking adjustments on End Units affect Belt alignment through End Units only.
Tracking adjustments must be performed while system is running.
Make slight tracking adjustments and allow Belt to respond before proceeding.



LOOSEN BOLT FOR
ADJUSTMENT RETIGHTEN
WHEN BELT IS TRACKING
PROPERLY (4) PLCS



AFTER BEARING BOLTS
ARE LOOSE TURN
THREADED
ROD TO TRACK BELT

DETAIL A

Start-Up and Troubleshooting

9. Once Belt is tracking properly, increase rate of travel while ensuring tracking remains consistent. Increase rate until desired speed and tracking are obtained.
10. Beginning at the End Unit, Front, walk system looking and listening for any potential issues that may indicate improper operation. If any issues are found, stop system immediately and resolve.

Note: Do not continue running system if there are indications of improper operation, it is important to make necessary corrections before starting system again.

11. After confirming system is free of issues, begin trial runs of product.
12. With system running, begin applying product to Belt.

Note: Make adjustments to upstream equipment to ensure a smooth transfer of product onto system.

13. With product on Belt, follow the product as it advances through system, looking for issues occurring under load.

Note: System will respond differently as load is applied. It is important to observe the operation of system as product passes through. If issues occur during this process, stop system and refer to the *Troubleshooting* section of the manual.

14. Follow the product as it advances through system until reaching the end, being certain to monitor the transition of product onto downstream equipment.

Note: Refer to the End Unit, Front *Component Assembly and Installation Instructions* for assistance in adjusting the Transfer Plate.

Start-Up and Troubleshooting

Belt Speeds

Belt Width (inches)	Belt Speed (ft/min)	VFD Frequency (Hz)
60	25	60

System Break-In

Note: System will require special attention during the first weeks of operation. During this time, inspect the system and adjust as needed to ensure proper break-in. Use the *Break-In Inspection Schedule* below to monitor system during this period.

Note: The *Break-In Inspection Schedule* should be followed anytime a new component or section of belt is added or removed from system.

Note: The duration of the break-in period will vary depending upon operating load, run time, start/stop occurrences, and other factors.

Break-In Inspection Schedule

Hourly	Drive Unit	<ul style="list-style-type: none">Inspect the Drive roller for slippageMonitor for unusual sounds and/or vibrationsInspect Belt tracking
	End Unit, Front	<ul style="list-style-type: none">Monitor for unusual sounds and/or vibrationsVerify Transfer Plate adjustmentInspect belt tracking
	End Unit, Back	<ul style="list-style-type: none">Monitor for unusual sound and/or vibrationsInspect Belt tracking

Start-Up and Troubleshooting

Troubleshooting

General Troubleshooting	Improper belt alignment	<ul style="list-style-type: none"> Inspect splices to ensure no separation has occurred Inspect Rollers for debris
	Belt Splice separation	<ul style="list-style-type: none"> Verify clearance at collectors Inspect for any contact as Splice passes through system
	Drive Roller slippage	<ul style="list-style-type: none"> Verify Take-Up Assembly is engaged Verify incoming air pressure Inspect air lines for restrictions or leaks Inspect Drive Roller for debris (dry or wet)
	Drive Unit or End Unit noise	<ul style="list-style-type: none"> Inspect Unit for loose components or fasteners Inspect for damaged bearings Inspect Drive Chain for proper tension Inspect Drive Chain Tensioner for proper operation Verify all drive components are properly secured Verify Belt Scrapers are secured
	Excessive dirt on belt	<ul style="list-style-type: none"> Check belt scrapers to ensure proper alignment Check scraper plates on belt scraper to ensure they do not need replacing
	Product damage	<ul style="list-style-type: none"> Inspect transfer points onto and off the system for proper adjustment Verify product path is clear through entire system Verify Sidesheet cutouts at collectors are properly deburred Check Drive Unit and End Units for excessive vibrations and harmonics

Maintenance

SECTION 5 - MAINTENANCE

Preventive Maintenance

- The Drive Roller should be checked for debris before each startup. If present, clean prior to startup.
- The airlines should be visually checked for restrictions and leaks prior to startup. Replace as needed.
- All Belt Scrapers should be checked daily for proper engagement prior to startup.
- Maintain all bearings on the Drive Unit and End Units per the manufacturer's recommendations.
- Maintain the Air Filter and Mist Separator per the manufacturer's recommendations.
- The Drive Chain should be inspected and maintained per the manufacturer's recommendations.
- The Gearbox and Motor should be inspected and maintained per the manufacturer's recommendations.

Maintenance

Inspection Schedule

Daily	General	<ul style="list-style-type: none"> • Verify all guards and covers are in place and secure. • After start-up inspect the Drive Roller for slippage, adjust air pressure as needed at the Regulator. Do not exceed manufacturer's recommendations. • While system is running, walk the entire length looking for abnormalities and listening for sounds that could indicate damage to one or more of the system components.
	Drive Unit	<ul style="list-style-type: none"> • Before running system, inspect all rollers to ensure rolling surface is free of debris (dry or wet). • After system is running, monitor for unusual sounds and/or vibrations. • Inspect Belt Scraper for proper adjustment.
	End Unit, Back	<ul style="list-style-type: none"> • Before running system, inspect all rollers to ensure they are free of debris (dry or wet). • After system is running, monitor for unusual sounds and/or vibrations. • Inspect Belt Scraper for proper adjustment.
	End Unit, Front	<ul style="list-style-type: none"> • Before running system, inspect all rollers to ensure they are free of debris (dry or wet). • After system is running, monitor for unusual sounds and/or vibrations. • Inspect Transfer Plate for proper adjustment.
1 to 3 Months	General	<ul style="list-style-type: none"> • Inspect Belt Splices for signs of wear or separation.
	Drive Unit	<ul style="list-style-type: none"> • Inspect the Gearbox for leaks and proper fluid level. • Inspect all bearings for excessive wear. • Inspect roller journals for excessive wear.
	End Unit, Back	<ul style="list-style-type: none"> • Inspect all bearings for excessive wear.
	End Unit, Front	<ul style="list-style-type: none"> • Inspect all bearings for excessive wear.

Maintenance

Inspection Schedule Cont'd

3 to 6 Months	Drive Unit	<ul style="list-style-type: none">• Inspect Chain Sprockets for excessive wear on teeth• Inspect Drive Chain for proper tensioning.• Inspect Drive Roller for wear of rubber cladding.• Inspect for loose components or fasteners.• Inspect Belt Scraper, replace Scraper Plate if adjustment does not allow contact with Belt.
	End Unit, Back	<ul style="list-style-type: none">• Inspect Belt Scraper, replace Scraper Plate if adjustment does not allow contact with Belt.• Inspect for loose components or fasteners.
	End Unit, Front	<ul style="list-style-type: none">• Inspect for loose components or fasteners.• Inspect Transfer Plate for proper adjustment.
12 to 18 Months	General	<ul style="list-style-type: none">• Clean and inspect all belt contact surfaces.• Inspect Drive Roller for wear of rubber cladding.

Maintenance

Critical Spares

Part Number	Description	Recommended Min. Qty.	Drive Unit	Take-up Unit	End Unit, Front	End Unit, Back
19C F 000 12B	4-Bolt Flange Bearing, 3-1/2"	2	•	•	•	•
19C F 000 13A	4-Bolt Flange Bearing, 4"	2	•			
19C F 000 19A	4-Bolt Flange Bearing, 3-1/2" w/90° Grease Fitting	2	•		•	•
19C F 000 03A	10HP 3PH AC Brake Motor	1	•			
TIUB11B-20	Polyurethane Tubing, 3/8", 20m Roll	1		•		
19C G 000 15A	3-1/4" Bore, 27-1/2" Stroke Cylinder	1		•		

Maintenance

Belt Cleaning

Cleaning Practices

If the conveyor must be cleaned; it is imperative that only water is used and not a chemical solution as damage could occur due to incompatibility with the belt material. Care must be taken to not wet the underside (friction surface) of the belt as this can cause corrosion and/or the accumulation of debris along the sliding surfaces. When possible, use cloths or other cleaning methods to spot clean the affected areas without introducing excessive amounts of running water onto the belt and sliding surfaces. It is the best practice to perform any cleaning near the front of the conveyor to allow the belt maximum dry time as it travels on the underside of the conveyor before reaching the sliding surfaces on the top side.

Things to Avoid

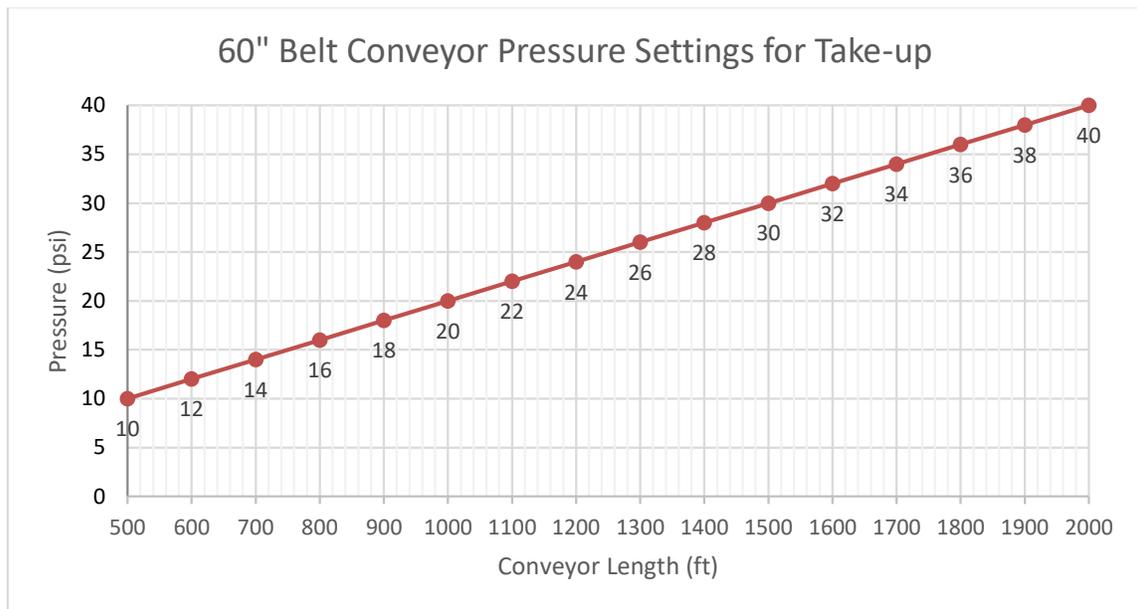
- UV light is becoming another common sanitizer due to its effectiveness. However, over time, this will also cause damage to the belt.
- Do not use chemical solutions to clean the belt surface. Possible incompatibility with the belt material could cause corrosion and splice damage.
- The belt should be set to the appropriate pressure setting according to the charts in the PRESSURE SETTINGS section on the next page. Failure to use the correct pressure setting will result in damage to the splices and belt.

Maintenance

Pressure Setting Recommendation

The belt air pressure must be adjusted depending on conveyor length. The following chart provides a visual and the maximum air pressure should not be exceeded.

It is recommended that the air pressure setting be adjusted to the lowest pressure possible that does not allow belt slippage on the Drive Roller during peak egg load.



General Information

SECTION 6 - GENERAL INFORMATION

OEM Contact Information

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