

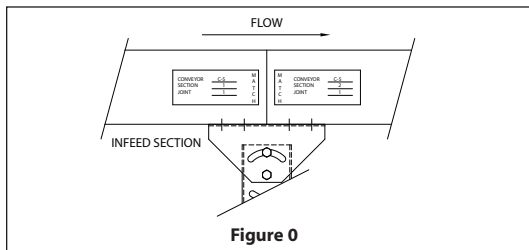
**MODEL "190ZPA" ZERO PRESSURE BELT DRIVEN LIVE ROLLER CONVEYOR
ASSEMBLY AND OPERATING INSTRUCTIONS**

RECEIVING INSTRUCTIONS

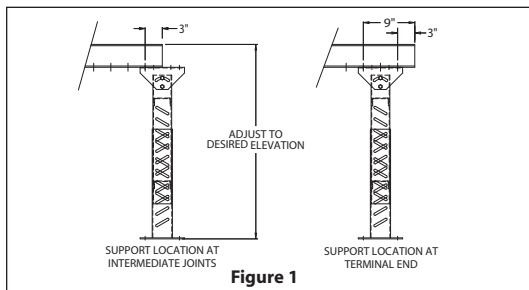
- 1) Prior to uncrating the equipment, check the number of crates, boxes, skids, etc. received against the freight bill to insure that all items shipped are on the job site.
- 2) Check to see that none of the equipment was damaged in transit. If damages occurred, note damages on freight bill and immediately contact the motor carrier and file claim for the damages.
- 3) Transport conveyors on their skids as near the installation site as possible.

INSTALLATION INSTRUCTIONS – MECHANICAL

- 1) Remove conveyor sections from their skids and place upside down on floor (without damaging sensor roller assemblies) in proper sequence based on the match mark identification on the conveyor sections and direction of product flow. (See Figure "0" for clarification).

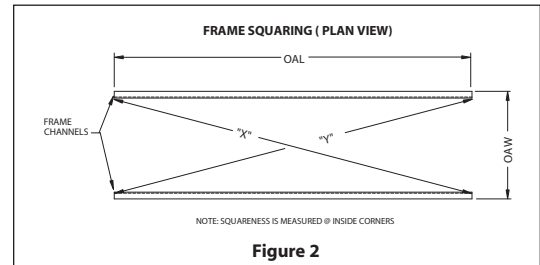


- 2) Beginning with the first section in match mark sequence, bolt a support at each end, leaving a space for the second bed section on pivot plate. Remember to set stands at proper elevation while section is inverted. (See Figure "1" for support positions). Finger tighten bolts only and turn section over (right side up) and place into position.
- 3) Take the next intermediate section in the match mark sequence and add one stand to far end, bolting on 1/2 of pivot plate. Finger tighten stand bolts, turn right side up and attach end without stand to previous section. Repeat this procedure until complete conveyor is assembled.



- 4) Do not wrench tighten bolts until unit is assembled, aligned, and lagged to the floor.
- 5) Align Conveyor - To align conveyor, tie a chalk line to the exact center of the pulleys at each end of the conveyor and pull it tight. Take each section of the conveyor starting at one end and align the frames so that the chalk line is in the exact center of each section of the conveyor.

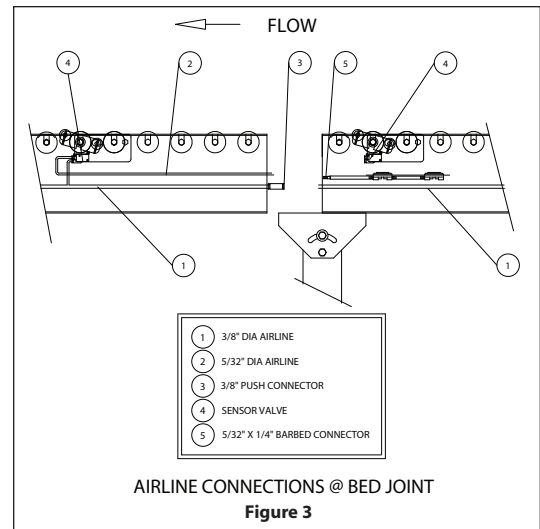
- 6) Square and level conveyors. Check each individual bed section for squareness by measuring diagonally inside corners of frame channels. (See Figure "2"). When the "X" and "Y" dimensions are the same, the section is square. Place level across width of conveyor to make sure conveyor is level.



- 7) Conveyors over 30 ft. long are supplied with a frame squaring device (shipped loose) for every other section. Use this device to square the bed sections. Tighten bolts and nuts in butt couplings and floor supports at this time.
- 8) Install lag bolts (not furnished) through holes in support feet.
- 9) Wrench tighten all bolts and recheck alignment.
- 10) All sensor rollers are wired in the "DOWN" position for shipment. Prior to running conveyor, remove these wires so sensor rollers will move to the "UP" or operating position. **DO NOT RUN CONVEYOR BEFORE REMOVING WIRES.**

INSTALLATION INSTRUCTIONS – PNEUMATIC

- 1) Airline connections must be made at each bed joint during field installation (See Figure "3").
- 2) Connect loose end of 3/8" tubing, manifold line



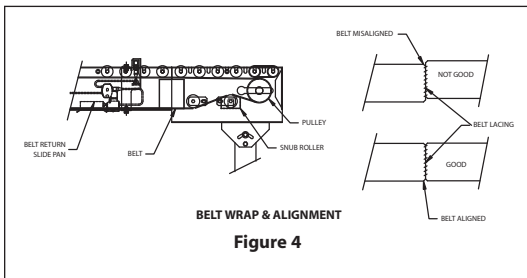
(item #1), from end zone of infeed section to push connect fitting (item#3) in infeed zone of second section. Since this is a push-connect fitting, make

sure that a good connection is made by gently pulling back on the tubing after insertion. This ensures the tubing is locked into place. Make this same connection on all intermediate sections.

- 3) Connect the 5/32" air line (item #2) from end zone of infeed section to sensor valve (item #4) in infeed zone of the second section. Since this is a push-connect fitting, ensure a good connection by gently pulling back on the tubing after insertion. Again this ensures a good lock between the tubing and the connector. Make this same connection on all intermediate sections.
- 4) Connect plant air to filter-regulator located near center of conveyor length. **AIR MUST BE CLEAN AND NON-LUBRICATED.** Lubricated air could damage air diaphragms and void warranty.
- 5) After plant air has been connected to filter-regulator check for air leaks in the system. Air leaks may cause line pressure drop which could result in erratic operation of the air valves.
- 6) The filter-regulator has been preset by the factory at 30 PSI, which has been determined to be the ideal operating pressure. If faster response time is needed, air pressure may be increased to a **MAXIMUM** of 40 PSI. **CAUTION:** If air pressure exceeds 40 PSI, damage to the air diaphragms may occur and will void warranty.

CONVEYOR BELTING INSTALLATION

- 1) Belting has been cut to length and laced at factory.
- 2) Install belting around pulleys and over snub and return rollers. If end drive and end take-up, make sure take-up pulley adjustment has pulley all the way in towards bed section. Insert lacing pin provided with belt to connect the two ends. Ensure belt edges are in line when inserting pin. If they are not in line, belt may be difficult to track. (See Figure "4").
- 3) InTension belt by adjusting bolts at take-up pulley. Do not over tighten the belt. **CAUTION:** Equal adjustment of both take-up bolts is necessary for proper belt tracing.
- 4) Install conveyor tread rollers.



- 5) The belt should be tight enough to prevent belt slippage at drive pulley when conveyor is loaded. Proper tail pulley position in take-up slot is directly under second roller from end of frame. Center line of second roller and tail pulley should be the same. If necessary, cut and replace belt to ensure proper pulley position.").
- 6) Because there is initial belt stretch during the first few weeks of conveyor use, careful attention should be given to proper belt tightness during break in. Also, high humidity can cause belt tightness and low humidity can cause belt stretch. Check belt tightness after severe

changes in humidity.

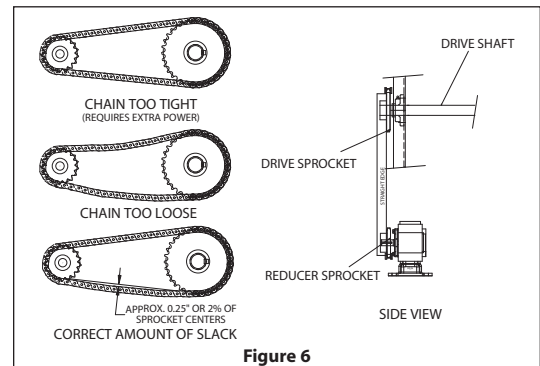
- 7) **NEVER** apply any type of chemical to aid belt grip at drive pulley. This procedure could cause severe damage to conveyor drive components or belting and void warranty.

SAFETY INFORMATION

- 1) After completion of conveyor installation and **BEFORE** operation, personnel operating the conveyor must be properly trained in its use. It is recommended these employees be walked through the proper sequence of starting and stopping the motor drive, shown where hazardous areas exist along the length of the conveyor (identified by safety labels attached to the conveyor frame and drive guards) and correct loading and unloading methods. Make sure safety labels are legible and that personnel understand their meaning.
- 2) Conveyor should **NEVER** be operated with any of the safety guards removed as physical harm could come to the user. All pinch points of the conveyor are guarded and also identified by safety labels attached in the guarded pinch point area. Instruct users to turn the conveyor off and notify the proper personnel should a guard be missing and the conveyor is running.
- 3) Only qualified maintenance personnel should perform work on the conveyor. Should the unit require maintenance, disconnect conveyor motor drive from power source before attempting to adjust or repair conveyor. If guards were removed to perform the maintenance task, they must be replaced before attempting to operate conveyor. If guards are damaged and become unusable they must be replaced. Locate the conveyor's serial number plate, which is mounted near the motor drive, and contact your ACS distributor for a replacement. He will need the serial number of the conveyor to secure the correct guardy.

OPERATING INSTRUCTIONS

- 1) Before the electric motor is started, check the following:
 - A) Be sure proper voltage is connected to motor in accordance with motor name plate.
 - B) The speed reducer is shipped from the factory with oil. However, remove the plug nearest center of reducer and check to see that the reducer has the proper amount of oil. If it does not, fill according to instruction sheet sent with reducer .
 - C) Remove chain guard at motor and reducer.



Check sprocket alignment with straight edge and proper chain (or drive belt) tension. (See Figure "5" on page 2).

- D) If any guards have been removed during installation, they must be re-installed to prevent injury to personnel.
- Remove wires holding sensor rollers down during shipment.
 - Remove galvanized plates holding grooved rollers in terminal sections.
 - Conveyor is now ready to run.

TRACKING THE CONVEYOR BELT

CAUTION: Before attempting to track conveyor belt, determine that all pulleys and rollers are square with the conveyor bed section. Also check bed/frame sections for level and squareness. After completion of these checks and after adjustments, if necessary, have been made to bring sections level and square, follow belt tracking instruction as show below.

NOTE: On belt-driven live roller conveyors, product flow is opposite the direction of belt travel.

- With belt turning toward drive end: (See Figure "6")
 - If belt runs to right side (A) of take-up pulley at the take-up end, move right side (B) of snub roller toward take-up pulley.
 - If belt runs to left side (C) of take-up pulley at

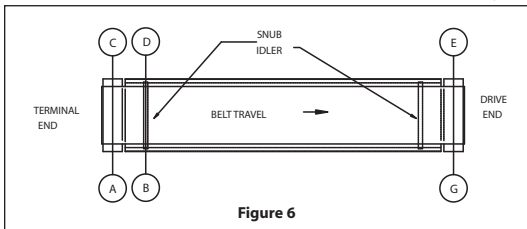


Figure 6

the take-up end, move left side (D) of snub roller toward take-up pulley.

- If belt runs off right side of drive pulley but is centered on take-up pulley at opposite end, move drive pulley out slightly on right side (G) using adjustment bolt.
- If belt runs off left side of drive pulley but is centered on take-up pulley at opposite end, move drive pulley out slightly on left side (E) using adjustment bolt.

SEQUENCE OF OPERATION

LOADING THE CONVEYOR (See Figure "7")

- The Model "190ZPA" is loaded at infeed end of conveyor. The first load travels to Zone #1 and comes to rest against a blade stop, roller stop, or brake belt (all optional), and depresses sensor roller "A,"

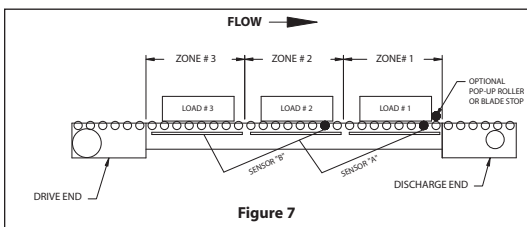


Figure 7

deactivating Zone #2.

NOTE: If stop or brake belt is not supplied, product will not stop in Zone #1. Some type of stop device must be used in Zone #1 for conveyor to accumulate.

- With belt turning toward drive end: (See Figure "6")
- The Model "190ZPA" will continue to accumulate at "zero pressure" until conveyor is fully loaded.

NOTE: Zone #1 at discharge and is supplied with low pressure accumulation feature (not zero pressure).

UNLOADING THE CONVEYOR

- Lower step in Zone #1 or start brake belt to remove load from Zone #1. When load in Zone #1 clears sensor roller in Zone #1, sensor roller will come up allowing load in Zone #2 to advance to Zone #1. When load in Zone #2 clears sensor roller in Zone #2, the load in Zone #3 will advance into Zone #2. All loads will continue to advance in this fashion as long as empty zones exist down stream.
- An optional batch unloading feature is available on this conveyor. Check pneumatic schematic to see if this option has been provided on this unit.

SENSOR ROLLER ASSEMBLY ADJUSTMENTS

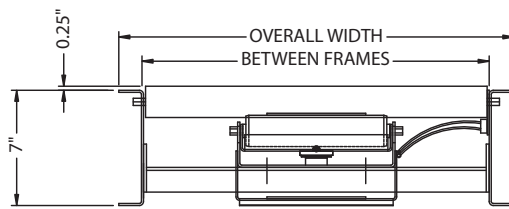
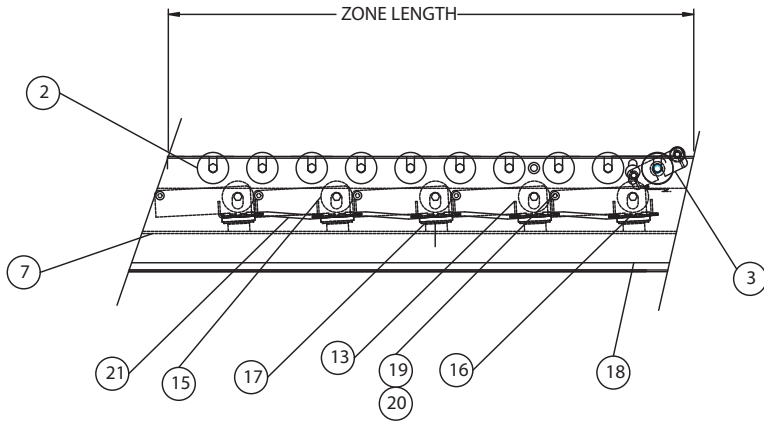
- The sensor roller assemblies are factory pretested and set at approximately 3/16" above the tread rollers. No adjustment should be necessary for proper operation.
- To increase the driving force of the pressure rollers, air pressure may be increased to 40 PSI max. Do not increase air pressure above 40 PSI as warranty may be voided.

PREVENTATIVE MAINTENANCE

(See Lubrication and Maintenance Check List for more details.)

- DRIVE CHAINS - Every 500 hours - Wipe off grease with solvent and apply clean SAE 20 motor oil. Check tension on main drive chain (1/4" - 2% (of sprocket centers) movement midway between sprockets). Use straight edge and check sprocket alignment.
- ELECTRIC MOTOR - Every 1000 hours - Remove grease plugs (if supplied on motor) and grease motor bearings sparingly with ball bearing grease.
- SPEED REDUCER - Every 750 hours - Remove filler and drain plugs. Flush and refill with lubricant suggested by reducer manufacturer.
- TREAD ROLLERS - Every 500 Hours - Make sure all rollers turn freely. Replace any that are dented, warped, binding, etc.
- FLANGE MOUNTED BEARINGS (PULLEYS) - Every 1000 hours - Grease pulley bearings through-grease fittings using grease gun. CAUTION: Do not over grease.
- ENTIRE CONVEYOR - Daily, weekly. - Look for any abnormal action of conveyor, oil leaks, unusual noises, etc. Repair at once.

**- PARTS LIST -
 190ZPA**



SECTION VIEW "A-A"

- ① MOTORBASE PLATE
- ② 190SR ROLLER
- ③ SENSOR ROLLER ASSEMBLY
- ④ MD SUPPORT
- ⑤ PIPEBRACE
- ⑥ SIDE RAIL
- ⑦ PRESSURE BED
- ⑧ 8" DIA DRIVE PULLEY
- ⑨ 4" DIA TAIL PULLEY
- ⑩ CROSSBRACE
- ⑪ REDUCER PUSH PLATE
- ⑫ SPLICE PLATE
- ⑬ ZONE ACTUATOR BRKT
- ⑭ BELT RETURN SLIDE PAN
- ⑮ 190SR PRESSURE ROLLER
- ⑯ SINGLE END DIAPHRAGM ACTUATOR
- ⑰ DOUBLE END DIAPHRAGM ACTUATOR
- ⑱ 120 PVC FSXFS BELT
- ⑲ 0.25" O.D. NYLON PUSH-IN FASTENER
- ⑳ 0.25" DIA I.D. NYLON BUSHING
- ㉑ 0.25" PVC AIR LINE
- ㉒ C-FACE MOTOR
- ㉓ C-FACE REDUCER
- ㉔ REDUCER SPROCKET
- ㉕ DRIVE PULLEY SPROCKET
- ㉖ ROLLER CHAIN
- ㉗ CONNECTING LINK
- ㉘ CHAIN GUARD
- ㉙ MOTORBASE MOUNTING ANGLES

FLOW →

