



LUBRICATION AND MAINTENANCE CHECK LIST

This check list gives the user a comprehensive guide of periodic maintenance. This check list is to be used as an additional reference of lubrication and maintenance to supplement preventive maintenance instructions noted in the manual.

NOTE: BEFORE ANY MAINTENANCE IS PERFORMED ON ANY CONVEYOR, ELECTRIC POWER SHOULD BE DISCONNECTED FROM DRIVE MOTOR TO PREVENT HARM TO PERSONNEL.

SCHEDULED MAINTENANCE

ITEM	FREQUENCY	MAINTENANCE
Belt (Power)	Every 200 Hours	Make sure belt is tracking and not wearing abnormally. Check belt tension and adjust take-up as necessary. Check pulley assemblies to insure proper alignment.
Drive Chain (Power)	Every 500 Hours	Stop conveyor and wipe off oil and grease with solvent. Check chain tension (and sprocket alignment). Apply clean SAE 20 Motor Oil.
Speed Reducer (Gear Box) (Power)	Every 750 Hours	Remove filler and drain plugs. Flush and refill with lubricant suggested by reducer manufacturer.
Electric Motor (Power)	Every 1000 Hours	Remove grease plugs (if supplied on motor) and grease motor bearings sparingly with ball bearing grease.
Flange Mounted Pulley Bearings with Grease Fittings Take-Up Pulleys (Power)	Every 1000 Hours	Grease bearings with grease gun through grease fittings. CAUTION: Do not over grease.
Tread Rollers / Wheels (Power & Gravity)	Every 500 Hours	Make sure all rollers and wheels turn freely. Replace any that are dented, warped, binding, etc.
Entire Conveyor (Power & Gravity)	Daily, Weekly Walk Through of System	Look for any abnormal action of conveyor, oil leaks (where applicable), unusual noises, etc. Repair at once.

POWER / GRAVITY

ROLLERS, PULLEYS, & WHEELS: Check Take-Up Pulleys, End Pulleys, Belt Carrying Rollers, Tread Rollers, Snubber, Idler Rollers, and Gravity Wheels for lubrication. Some are sealed and require no lubrication, others do.

POWER

MOTORS: To check lubrication of motor, see manufacturer's sheets listed in other parts of manual.

POWER

SPROCKETS: Sprocket alignment is very critical. Sprockets should be checked with a straight edge for proper alignment. See figure "1".

POWER

DRIVE CHAIN: (Main Drive or Power Feeder) Keep Drive Chain clean and lubricated. Remove chain and soak in solvent, or wipe off oil and grease with a cleaning solvent. Afterwards, apply SAE 20 Motor Oil.

POWER

CHAIN TENSION: Chain should have approximately 0.25" (or 2% of sprocket centers) movement midway between sprockets. See figure "2"

POWER / GRAVITY

MOBILITY: All mechanisms with moving parts should be checked for mobility and kept clean and oiled at regular intervals.

POWER

BELT CLEANING: Belt should be scrubbed cross-wise with a stiff brush and detergent. CAUTION: Never under any circumstances use gasoline, kerosene, or any petroleum based product to clean a rubber belt.

POWER / GRAVITY

MAINTENANCE PROGRAM: Set up a systems maintenance program to inspect conveyors to prevent major, unexpected problems.

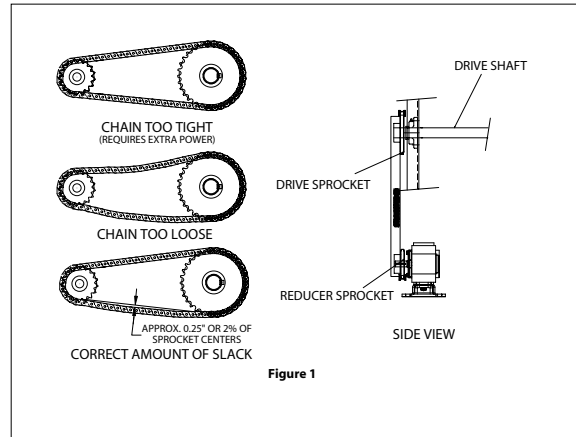


Figure 1

SAFETY INFORMATION

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.

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 ACSI distributor for a replacement. He will need the serial number of the conveyor to secure the correct guard.

PROBLEM	POSSIBLE CORRECTION
1. Belt does not track properly. (Belt conveyor only)	<ol style="list-style-type: none"> 1. Square pulleys with conveyor frame. 2. Level conveyor. 3. Square conveyor sections. 4. Adjust snub idlers in accordance with assembly and operating instructions sent with conveyor. 5. Check belt lacing for squareness. Cut and relace if necessary.
2. Excessive wear on chain and sprockets.	<ol style="list-style-type: none"> 1. Lubricate per lubrication instructions. 2. Align sprockets. 3. Tension chain per figure "1". 4. Replace chain and sprockets, if necessary.
3. Gear reducer leaks oil.	<ol style="list-style-type: none"> 1. Make sure breather plug is installed in upper most fitting. 2. Make sure all pipe plugs are tight. 3. Make sure reducer is not over filled with oil. 4. If seals are leaking, reducer should be removed and repaired as necessary.
4. Noise / vibration coming from drive train (drive chain).	<ol style="list-style-type: none"> 1. Make sure sprockets are aligned, use straight edge to check. 2. Check chain tightness. Chain could be rubbing on guard. 3. Tighten chain.
5. Rollers making noise. (ie: Loud popping or grinding noise in bearing).	<ol style="list-style-type: none"> 1. Bearings could be dry, use SAE 20 oil to lubricate. 2. Tighten set screw, if possible. 3. Bearings could be worn out. Replace bearings, if possible, or complete roller.
6. Drive or End Pulleys making noise.	<ol style="list-style-type: none"> 1. Bearings could be dry. Grease bearings with grease gun through grease fittings, or replace bearings.
7. Motor or reducer is over-heating.	<ol style="list-style-type: none"> 1. Conveyor may be overloaded. Check conveyor capacity and reduce load to recommended levels.
8. Product won't accumulate. (Accumulation conveyor only).	<ol style="list-style-type: none"> 1. Adjust linkage rods per zero pressure instructions.

