

MODEL "FTC" INCLINE SLIDER BED CONVEYOR ASSEMBLY AND OPERATING INSTRUCTIONS

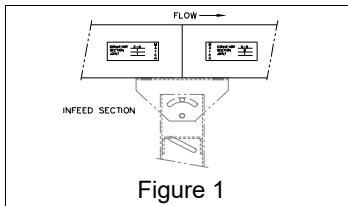
RECEIVING INSTRUCTIONS

- 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.

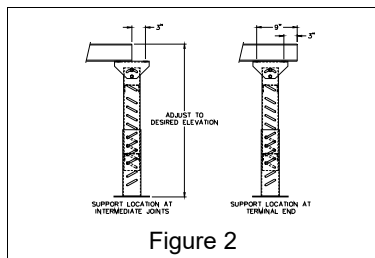
- 5) Align Conveyor – To align conveyor, tie a chalk line at each end of the conveyor and pull it tight. Take each section of the conveyor starting at one end and align the frames so that the chalk line is in the exact center of each section of the conveyor.
- 6) Place level across width of conveyor to make sure conveyor is level.
- 7) Install lag bolts (not furnished) through holes in support feet.
- 8) Wrench tighten all bolts and recheck alignment.

INSTALLATION INSTRUCTIONS - MECHANICAL

- 1) Remove conveyor sections from their skids and place on floor in proper sequence based on the match mark identification on the conveyor sections and direction of product flow (See Figure "1" for clarification). If fork lift is used make sure forks or fork extensions are long enough to support both side rails of conveyor.



- 2) Beginning with the first section in match mark sequence, bolt a support at each end, leaving a set of bolt holes for next section of conveyor. Set stands at proper elevation. (See Figure "2" for support positions). Finger tighten bolts only and place in to position.



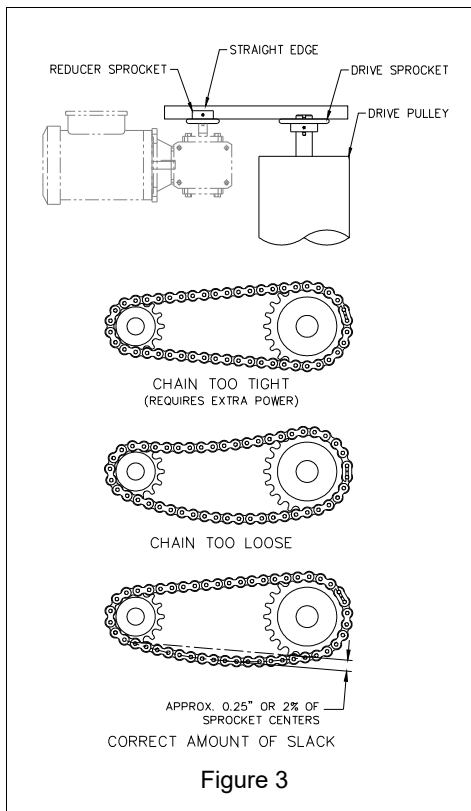
- 3) Take the next section in the match mark sequence and add one stand to far end, leaving a set of bolt holes for next section. Finger tighten stand bolts, and attach end without stand to previous section. Repeat this procedure until complete conveyor is assembled.
- 4) Do not wrench tighten bolts until unit is assembled, aligned, and lagged to the floor.

SAFETY INFORMATION

- 1) After completion of conveyor installation and **BEFORE** operation, personnel operating the conveyor must be properly trained in it's 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 that safety labels are legible and that personnel understand their meaning.
- 2) Conveyor should **NEVER** be operated with any of the guards removed as physical harm could come to the user. All pinch points of the conveyor are guarded and identified by safety labels attached to 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 motor drive from power source before 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 serial number and contact your ACSI distributor for replacement. They will need the serial number of the conveyor to secure the correct guard.

OPERATING INSTRUCTIONS

- 1) Before the electric motor is started, check the following items:
 - A) Make sure the voltage is connected to the motor in accordance with motor name plate.
 - B) The speed reducer is shipped from the factory with oil. However, remove upper most filler plug to insure reducer is oiled properly. If not, fill with oils in accordance the manufacturer's instructions sent with reduced. The reducer may have a loose breather plug attached. If so you must install breather plug in the reducer in accordance with the installation instructions furnished with the speed reducer to prevent oil seal failure.
 - C) Remove chain guard at motor and reducer. Check sprocket alignment with straight edge and proper chain tension. (See Figure "3" below")



D) Conveyor can now be started.

PREVENTIVE MAINTENANCE

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

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.

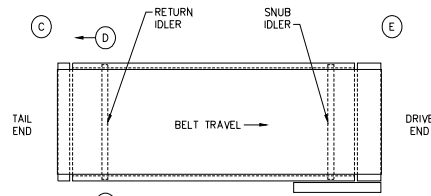


Figure 4

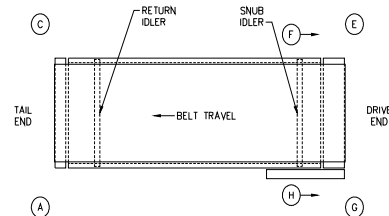


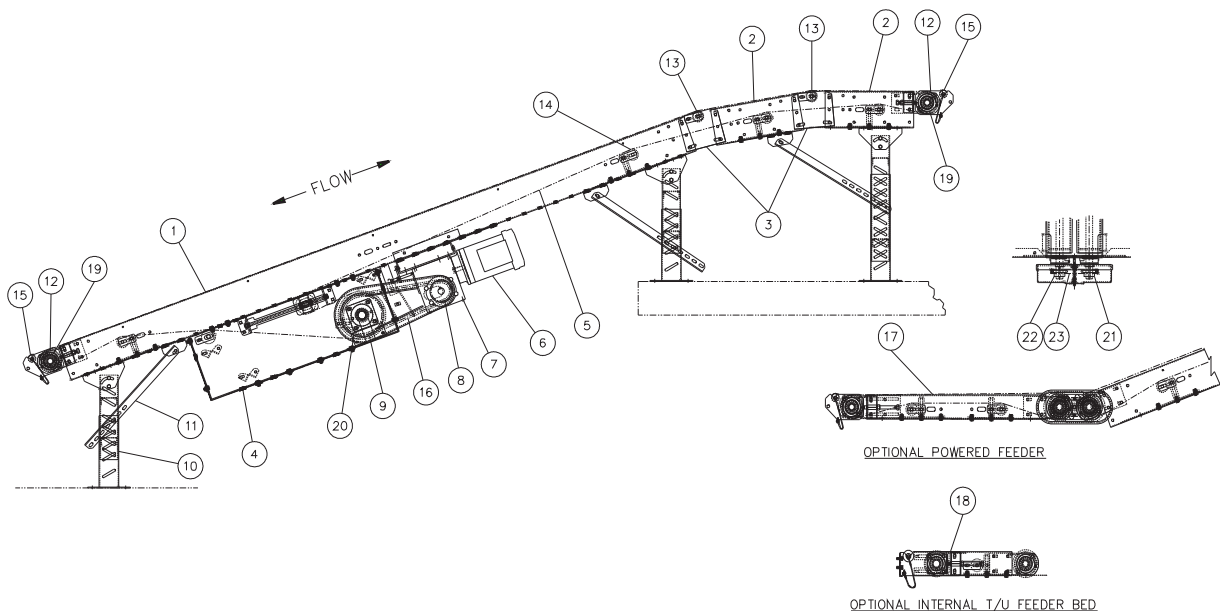
Figure 5

TRACKING THE CONVEYOR BELT (continued)

- | | |
|--|---|
| <p>1) When belt is running toward drive pulley: (See "Figure 4")</p> <ul style="list-style-type: none"> If belt runs to right side (A) of tail pulley, move right side (B) of return idler toward tail pulley. If belt runs to the left side of tail pulley (C) move left side (D) of idler back towards tail pulley. If belt runs off right side of drive pulley (G) but is centered on tail pulley, move drive pulley out slightly on right side (G) using squaring adjustment. If belt runs off left side of drive pulley (E) move left side of drive pulley (E) out. <p>2) When belt is running toward tail pulley: (See "Figure 5")</p> <ul style="list-style-type: none"> If belt runs to right side (E) of drive pulley, move right side (F) of snub roller toward drive pulley. | <p>2) continued</p> <ul style="list-style-type: none"> If belt runs to left side (G) of drive pulley, move left side (H) of snub roller toward drive pulley. If belt runs to left side of tail pulley (A) but is centered on drive pulley, move left side of tail pulley (A) out slightly using adjusting screws provided. if belt runs to right side of tail pulley (C) but is centered on drive pulley, move right side of tail pulley (C) out. Follow same procedure for conveyor with center drive. IMPORTANT NOTE:When making adjustments on snub and return idlers and pulleys, make adjustments in small increments (1/16" to 1/8" and give belt time to react before adjusting further. |
|--|---|

PARTS LIST

1 INTERMEDIATE BED	9 DRIVE SPROCKET	17 OPTIONAL POWER FEEDER
2 NOSE-OVER BED	10 SUPPORT	18 OPTIONAL POWER FEEDER W/INTERNAL TAKE-UP
3 NOSE-OVER PLATE	11 KNEE BRACE	19 2-BOLT BEARING
4 CENTER DRIVE	12 TAIL PULLEY	20 4-BOLT BEARING
5 BELT	13 NOSE-OVER ROLLER	21 FEEDER DRIVE SPROCKET
6 MOTOR	14 RETURN ROLLER	22 FEEDER DRIVEN SPROCKET
7 REDUCER	15 POP-OUR ROLLER	23 DRIVE CHAIN
8 REDUCER SPROCKET	16 CHAIN GUARD	





-INSTALLATION-

-MAINTENANCE-

-PARTS MANUAL-