

**ALL GRAVITY CONVEYORS - ASSEMBLY AND OPERATING INSTRUCTIONS**

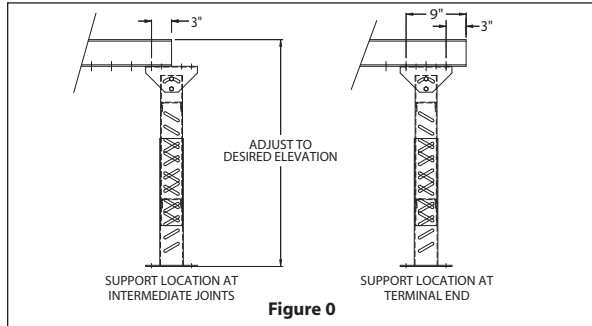
**RECEIVING INSTRUCTIONS**

- 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**

- 1) Remove conveyor sections from their skids and place upside down on floor.
- 2) Beginning with the first section 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 "0" for support positions). Finger tighten bolts only and carefully turn section over (right side up) and place into position.

- 3) Take the next intermediate section and add one stand to far end, bolting on 1/2 of pivot plate. Finger tighten stand bolts, carefully turn right side up and attach end without stand to previous section. Repeat this procedure until complete conveyor is assembled.
- 4) Do no wrench tighten bolts until unit is assembled, aligned, and lagged to the floor.
- 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) Square and level conveyors. Check each individual bed section for squareness by measuring diagonally inside corners of frame channels. When the dimensions are the same, the section is square.
- 7) Tighten bolts and nuts in butt couplings and floor supports at this time.



**SAFETY INFORMATION**

- 1) After completion of conveyor installation and **BEFORE** operation, personnel operating the conveyor must be properly trained in its use and correct loading and unloading methods. Make sure safety labels are legible and that personnel understand their meaning.

**PREVENTATIVE MAINTENANCE**

- 1) **TREAD ROLLERS** - Every 500 Hours - Make sure all rollers turn freely. Replace any that are dented, warped, binding, etc.

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