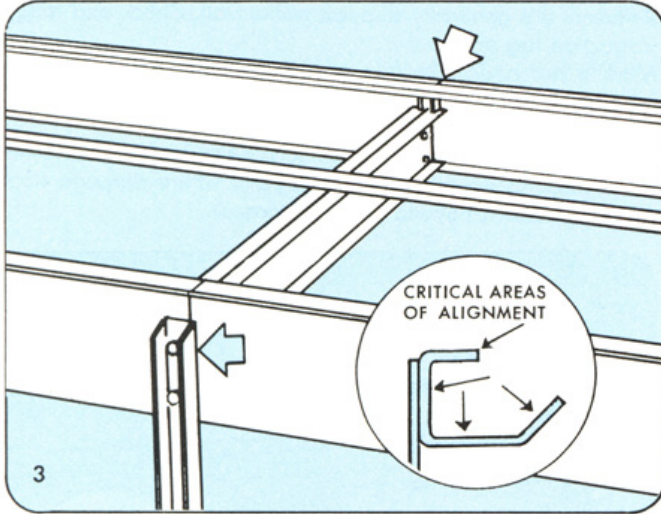


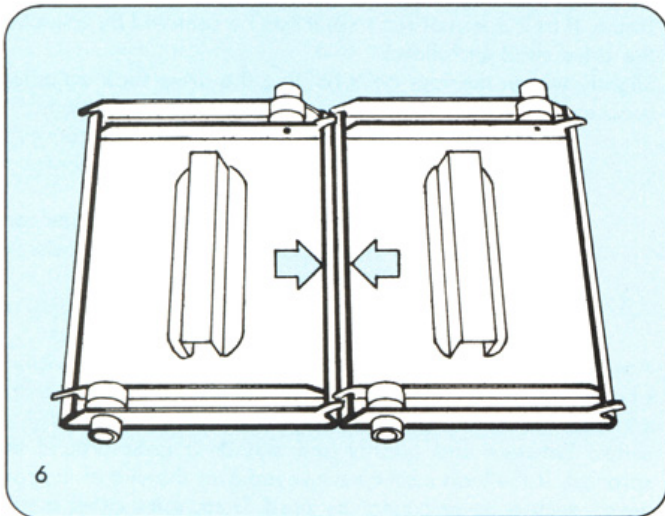
ARMORBELT INTALLATION

Instructions for level Armorbelt, 6" Pitch, 2-7/16" Shafts



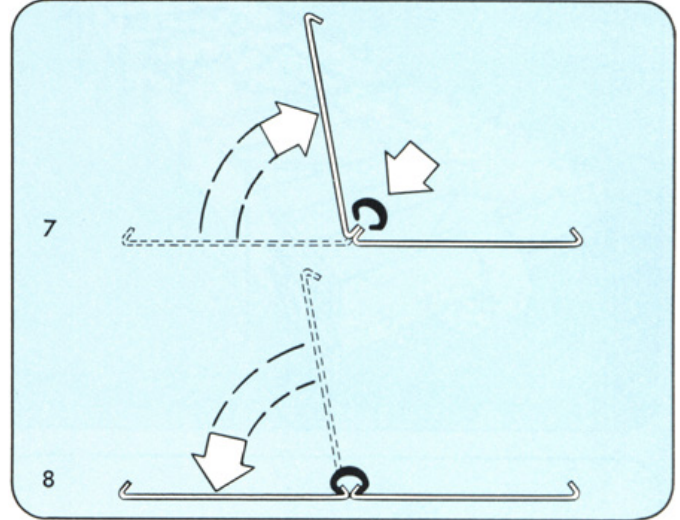
Frame Assembly

1. Set conveyor frame sections on the floor and assemble according to match-marks (if any).
2. Align with a tautly stretched wire or a transit.
3. Connect frame units. Make sure tracks are aligned flush and straight. This assures smooth, straight belt travel.
4. Fasten legs to floor. Recheck to make sure machine is still level and straight. If not, make corrections.

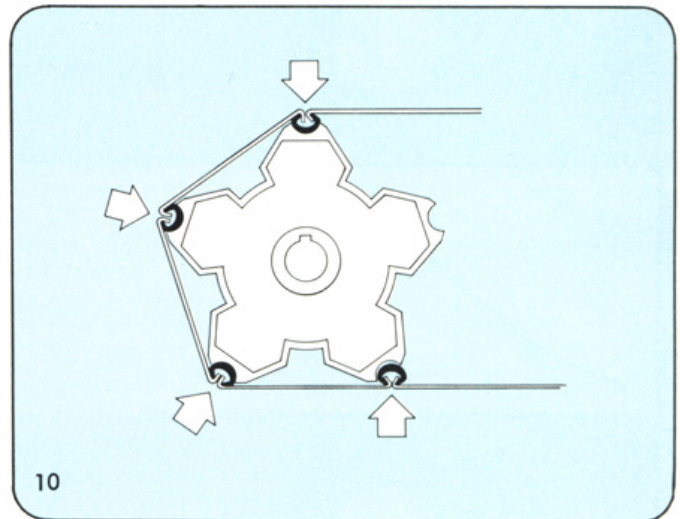


Belt Assembly

5. Starting at the take-up end (opposite drive end) place a slat face down in the bottom track.
6. Place another slat against the edge of the first slat (keep slat level so tabs overlap.)
7. Tilt the second slat until flanges of the two slats are flush. Slip a connector over the flanges and return slat to horizontal position.
8. Repeat until the bottom track is filled and add four more slats to wrap belt around the drive-end.

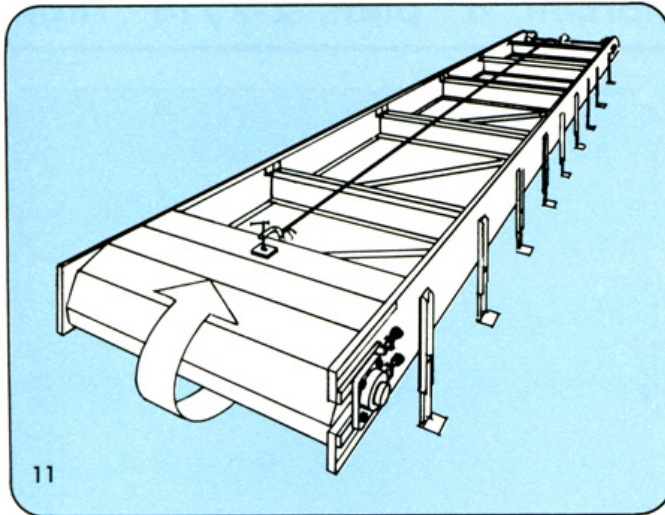


9. Disconnect drive chain from head shaft to permit sprockets to turn freely. Also, dab fibregrease in teeth of 5-point sprockets at both ends of conveyor.
10. Make sure the slat connectors are properly seated in the sprockets as you wrap the belt around the drive-end. Keep tension on belt to maintain engagement with sprockets.

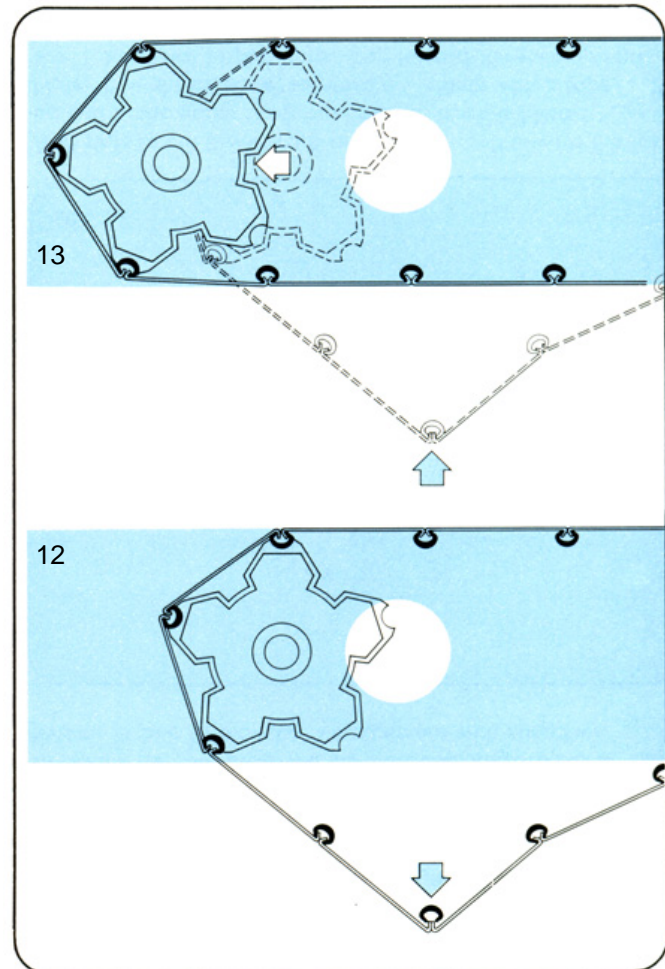


11. Add slats to the lower track and pull the belt toward the take-up end in the upper track until the top track is filled. Note: It might be easier to place a C clamp with a rope on the leading slat (as shown) to pull upper belt toward the take-up end. (Use wood blocks between contact points of C clamp and belt slat.) Belt should pull through conveyor freely. Tight operation indicates a crooked installation or a damaged frame.
12. Hand move the belt so that the upper end wraps around the take-up sprockets. Remove the lower guard so that the lower end of the belt can hang down. Loosen both take-up screws to move the sprockets forward and allow the belt ends to meet as shown. Slip the last connector in to join the ends.

Instructions for level Armorbelt, 6" Pitch, 2-7/16" Shafts



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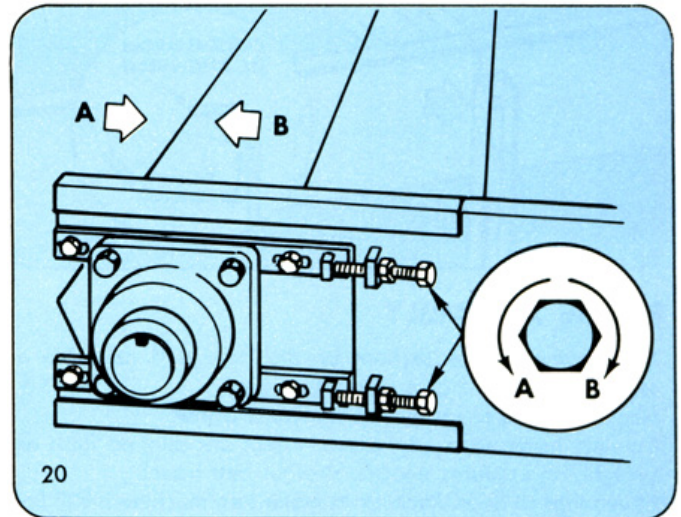
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13. Tighten take-up screws to remove belt slack and apply compression to the springs. Leave about .02" separation between the coils. You should be able to move the belt by hand.

Belt Check and Corrections

14. Sight through inspection hole to check that sprockets are properly engaged with belt connectors. Reconnect drive chain.

15. Check clearance between the edge of the belt and the frame. The clearance should be approximately 1/8" on either side.
16. Set drive unit if shipped separate and install chain.
17. Reducers are generally shipped without oil. Check and follow instruction tag on reducer.
18. Mark a slat and make two complete revolutions of start-stop jogging to make sure everything is set right before continuous running of conveyor.
19. Clutch (if furnished) should be set so it slips when starts with rated load. Gradually adjust to a point where slippage stops (never set clutch beyond required torque).



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20. Recheck clearance between the edge of the conveyor and the frame. If belt does not run true, it can be centered by adjusting the drive shaft as follows: Slightly loosen the four bolts holding the drive shaft adjusting bracket. This is on the side opposite the drive connection.
 - A. If the belt rubs against the drive side of the conveyor frame, turn the adjusting screw counter clockwise to slacken the belt on the adjusting side.
 - B. If the belt rubs against the adjusting side of the conveyor frame, turn the adjusting screw clockwise to tighten the belt on the adjusting side. After the belt runs true, tighten the four adjusting block screws and the adjusting screw lock nut.
21. Always replace guards. If operators must work in the vicinity of either end of the conveyor, covers should be placed over the conveyor ends to prevent damage to fingers accidentally inserted between end guards and slat as it goes around the sprocket. If the load must be conveyed over the end of the conveyor, such a cover cannot be used. If so, some other means must be provided to prevent operators from inserting their hands into the guard area.

Lubrication

22. Armorbelt which run continuously will require republication of the slat rollers every six months. This can be done by removing the take-up end guard and running the conveyor in start-stop fashion, oiling the rollers with machine oil as they are exposed. Lubricate head and tail shaft bearings once a year.