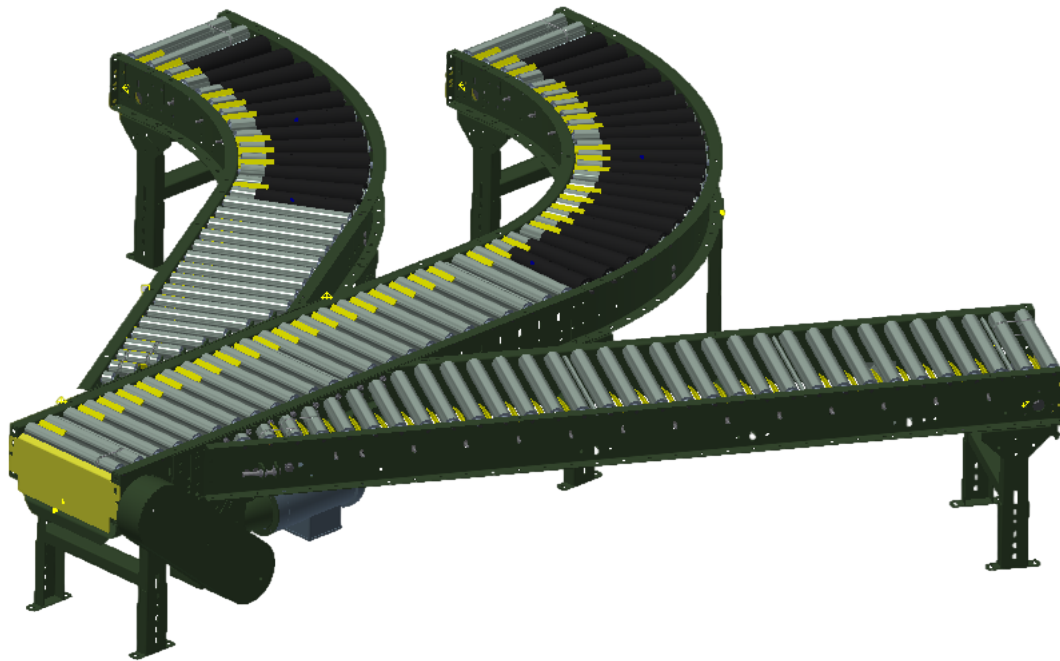




190-ACC, LRCT, LRST, LRSS INSTALLATION AND MAINTENANCE MANUAL



MODEL

**190-ACC, LRCT,
LRST, LRSS**

BULLETIN #

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EFFECTIVE DATE

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1 INTRODUCTION

This manual provides guidelines and procedures for installing, operating, and maintaining your conveyor. A complete parts list is provided with recommended spare parts highlighted in gray.

Important safety information is also provided throughout the manual. For safety to personnel and for proper operation of your conveyor, it is recommended that you read and follow the instructions provided in this manual.

1.1 RECEIVING & UNCRATING

- Check the number of items received against the bill of lading.
- Examine condition of equipment to determine if any damage occurred during shipment.
- Move all crates to area of installation.
- Remove crating and check for optional equipment that may be fastened to the conveyor. Make sure these parts (or any foreign pieces) are removed.

1.2 HOW TO ORDER REPLACEMENT PARTS

Included in this manual are parts drawings with complete replacement parts lists. Minor fasteners, such as nuts and bolts, are not included.

When ordering replacement parts:

- Contact dealer from whom conveyor was purchased or nearest Hytrol Integration Partner.
- Give Conveyor Factory Order Number/Serial Number.
- Give complete description from Parts List.
- If you are in a breakdown situation, call our Customer Care team at 1-844-4HYTROL.

NOTE

If damage has occurred or freight is missing, contact your Hytrol Integration Partner.

 Jonesboro, Arkansas	Model	QR Code YEAR
Serial # 615415		

2 SAFETY INFORMATION

2.1 INSTALLATION

GUARDS AND GUARDING

Interfacing of Equipment: When two or more pieces of equipment are interfaced, special attention shall be given to the interfaced area to ensure the presence of adequate guarding and safety devices.

Guarding Exceptions: Whenever conditions prevail that would require guarding under these standards, but such guarding would render the conveyor unusable, prominent warning means shall be provided in the area or on the equipment in lieu of guarding.

Guarded by Location or Position: Where necessary for the protection of employees from hazards, all exposed moving machinery parts that present a hazard to employees at their work station shall be mechanically or electrically guarded, or guarded by location or position.

- Remoteness from frequent presence of public or employed personnel shall constitute guarding by location.
- When a conveyor passes over a walkway, roadway, or work station, it is considered guarded solely by location or position if all moving parts are at least 8 ft. (2.44 m) above the floor or walking surface or are otherwise located so that the employee cannot inadvertently come in contact with hazardous moving parts.
- Although overhead conveyors may be guarded by location, spill guards, pan guards, or equivalent shall be provided if the product may fall off the conveyor for any reason and if personnel would be endangered.

Headroom

- When conveyors are installed above exit passageways, aisles, or corridors, there shall be provided a minimum clearance of 6 ft. 8 in. (2.032 m) measured vertically from the floor or walking surface to the lowest part of the conveyor or guards.
- Where system function will be impaired by providing the minimum clearance of 6 ft. 8 in. (2.032 m) through an emergency clearance, alternate passageways shall be provided.
- It is permissible to allow passage under conveyors with less than 6 ft. 8 in. (2.032 m) clearance from the floor for other than emergency exits if a suitable warning indicates low headroom.

2.2 OPERATION SET-UP

- A. Only trained employees shall be permitted to operate conveyors. Training shall include instruction in operation under normal conditions and emergency situations.
- B. Where employee safety is dependent upon stopping and/or starting devices, they shall be kept free of obstructions to permit ready access.
- C. The area around loading and unloading points shall be kept clear of obstructions which could endanger personnel.
- D. No person shall ride the load-carrying element of a conveyor under any circumstances unless that person is specifically authorized by the owner or employer to do so. Under those circumstances, such employee shall only ride a conveyor which incorporates within its supporting structure platforms or control stations specifically designed for carrying personnel. Under no circumstances shall any person ride on any element of a vertical conveyor.
- E. Personnel working on or near a conveyor shall be instructed as to the location and operation of pertinent stopping devices.
- F. A conveyor shall be used to transport only material it is capable of handling safely.
- G. Under no circumstances shall the safety characteristics of the conveyor be altered if such alterations would endanger personnel.
- H. Routine inspections and preventive and corrective maintenance programs shall be conducted to ensure that all safety features and devices are retained and function properly.
- I. Personnel should be alerted to the potential hazard of entanglement in conveyors caused by items such as long hair, loose clothing, and jewelry.
- J. Conveyors shall not be maintained or serviced while in operation unless proper maintenance or service requires the conveyor to be in motion. In this case, personnel should be made aware of the hazards and how the task may be safely accomplished.
- K. Owners of conveyor should ensure proper safety labels are affixed to the conveyor warning of particular hazards involved in operation of their conveyors.

CAUTION!

Because of the many moving parts on the conveyor, all personnel in the area of the conveyor need to be warned that the conveyor is about to be started.

2.3 MAINTENANCE / SAFETY LABELS

Refer to ANSI Z244.1-1982, American National Standard for Personnel Protection – Lockout/Tagout of Energy Sources – Minimum Safety Requirements and OSHA Standard Number 29 CFR 1910.147 “The Control of Hazardous Energy (Lockout/Tagout).”

- All maintenance, including lubrication and adjustments, shall be performed only by qualified and trained personnel.
- It is important that a maintenance program be established to ensure that all conveyor components are maintained in a condition which does not constitute a hazard to personnel.
- When a conveyor is stopped for maintenance purposes, starting devices or powered accessories shall be locked or tagged out in accordance with a formalized procedure designed to protect all persons or groups involved with the conveyor against an unexpected start.
- Replace all safety devices and guards before starting equipment for normal operation.
- Whenever practical, DO NOT lubricate conveyors while they are in motion. Only trained personnel who are aware of the hazard of the conveyor in motion shall be allowed to lubricate.

Safety Guards

Maintain all guards and safety devices IN POSITION and IN SAFE REPAIR.

Safety Labels

In an effort to reduce the possibility of injury to personnel working around Hytrol conveying equipment, safety labels are placed at various points on the equipment to alert them of potential hazards. Please check equipment and note all safety labels. Make certain your personnel are alerted to and obey these warnings. See Safety Manual for examples of warning labels.

REMEMBER

Do not remove, reuse, or modify material handling equipment for any purpose other than its original intended use.

3 INSTALLATION

3.1 CONVEYOR SET-UP

1. Determine primary direction of product flow. FIGURE 1 indicates the preferred flow as related to the drive.
2. Refer to “Match-Mark” numbers on ends of conveyor sections (FIGURE 1). Position them in this sequence near the area of installation. Mark a chalk line on floor to locate center of the conveyor for floor-mounted conveyors.
3. Attach supports to both ends of drive section and to one end of intermediate or tail sections with splice and pivot plates (FIGURE 2). Hand tighten bolts only at this time.
4. Conveyor’s angle of incline will determine where the knee brace mounting brackets are to be placed when required.
5. Check to see that conveyor is level across width and length of unit. Adjust elevation to required height.
6. Adjust supports and ceiling hangers as necessary.
7. Install electrical controls and wire motor.
8. Install and track belt per section

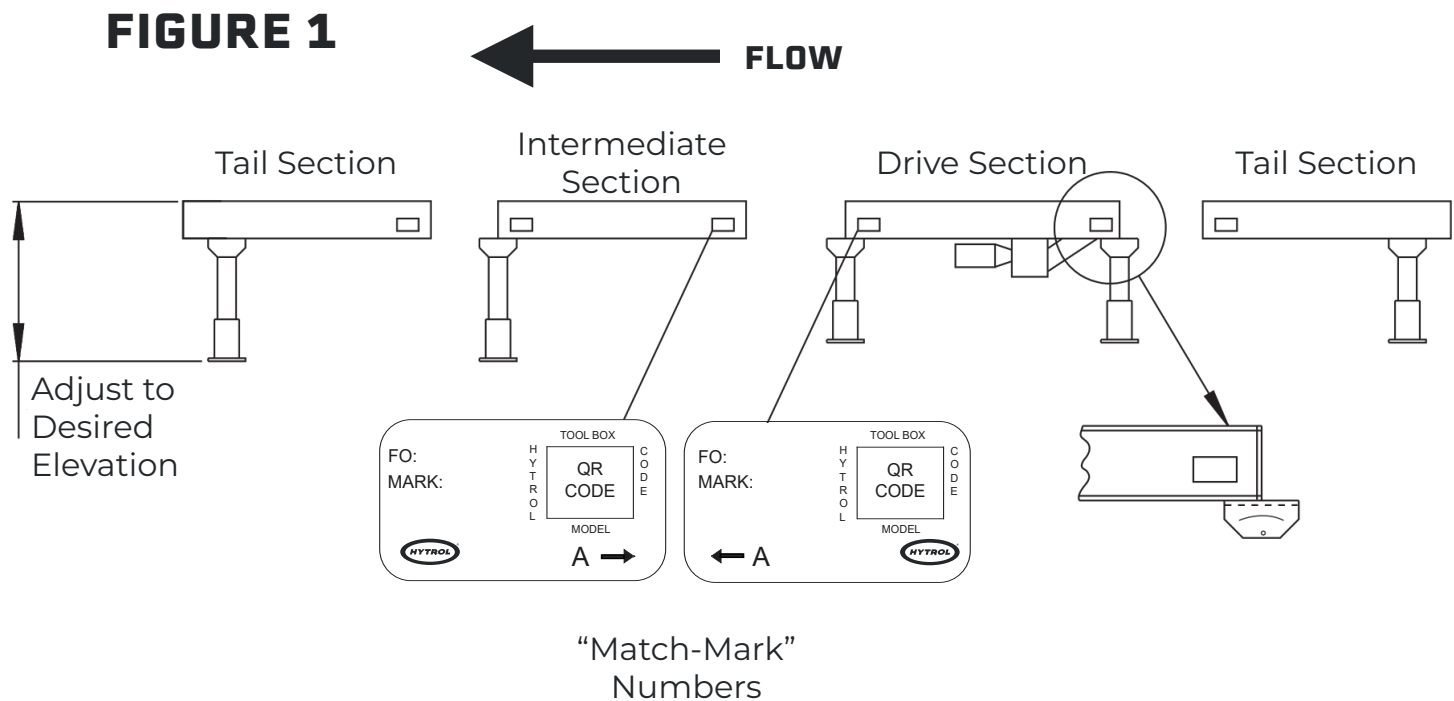


FIGURE 2

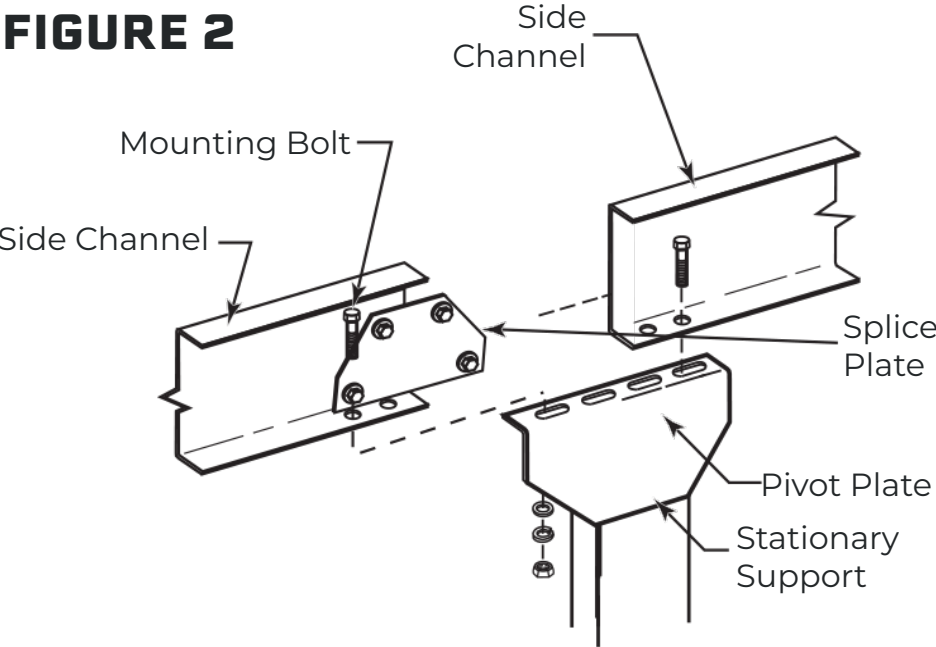


FIGURE 3

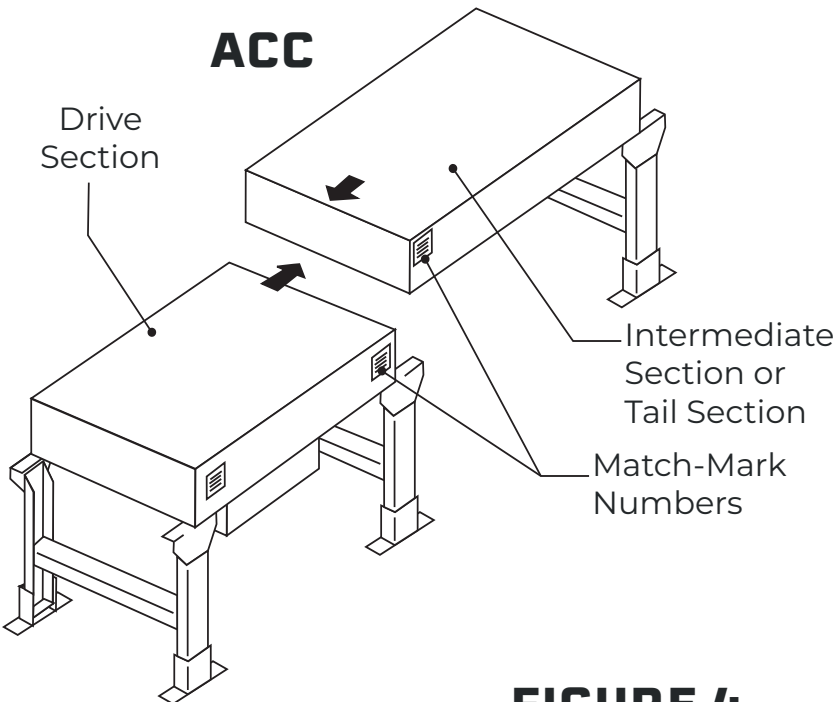
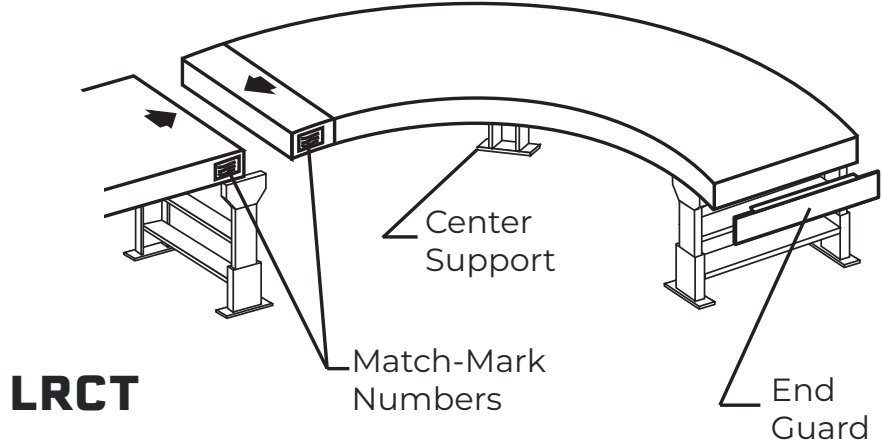


FIGURE 4



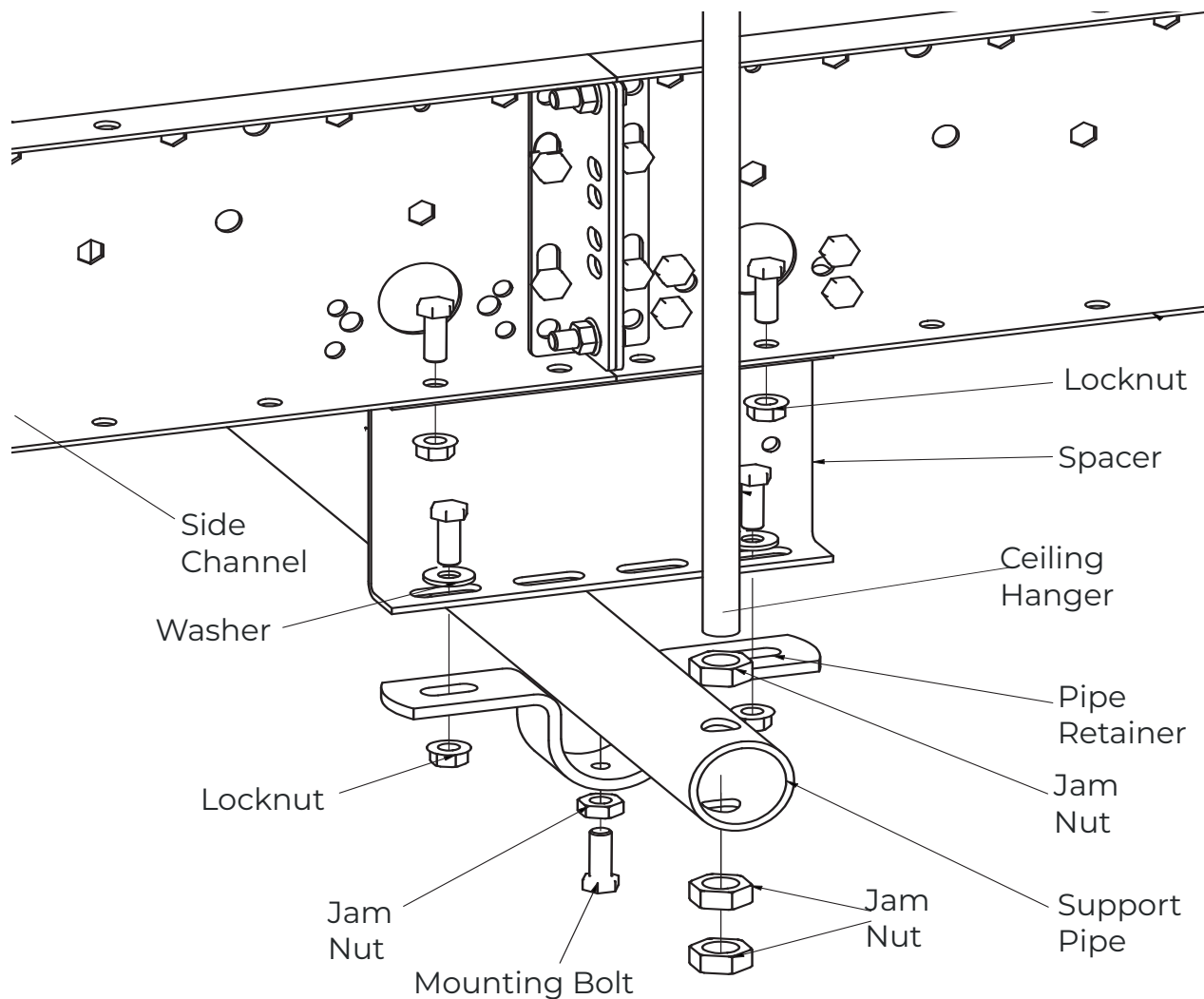
3.2 CEILING HANGER INSTALLATION

If conveyors are to be used in an overhead application, ceiling hangers may have been supplied in place of floor supports.

FIGURE 5 show how a ceiling hanger mounts to a conveyor section. Ceiling hangers should be mounted at section joints.

For safety information concerning conveyors mounted overhead, refer to section 2.1 Installation on page 5.

FIGURE 5



NOTE

When installing ceiling hanger rods in an existing building, all methods of attachment must comply with local building codes.

3.3 CONNECTING THE V-BELTS – ACC

The double groove sheave, located at one end of each conveyor section, is used to connect the driving V-Belts of the conveyor. The groove in which each belt is placed is predetermined at the factory (FIGURE 7).

Beginning with the drive bed section, the drive V-Belt is installed in the outside groove of the sheave. From this point on, (in both directions) the belts will alternate from inside to outside groove (FIGURE 8).

Note that take-up sheaves have been installed to align the V-Belt with the respective grooves on the double groove sheaves (FIGURE 7).

FIGURE 6

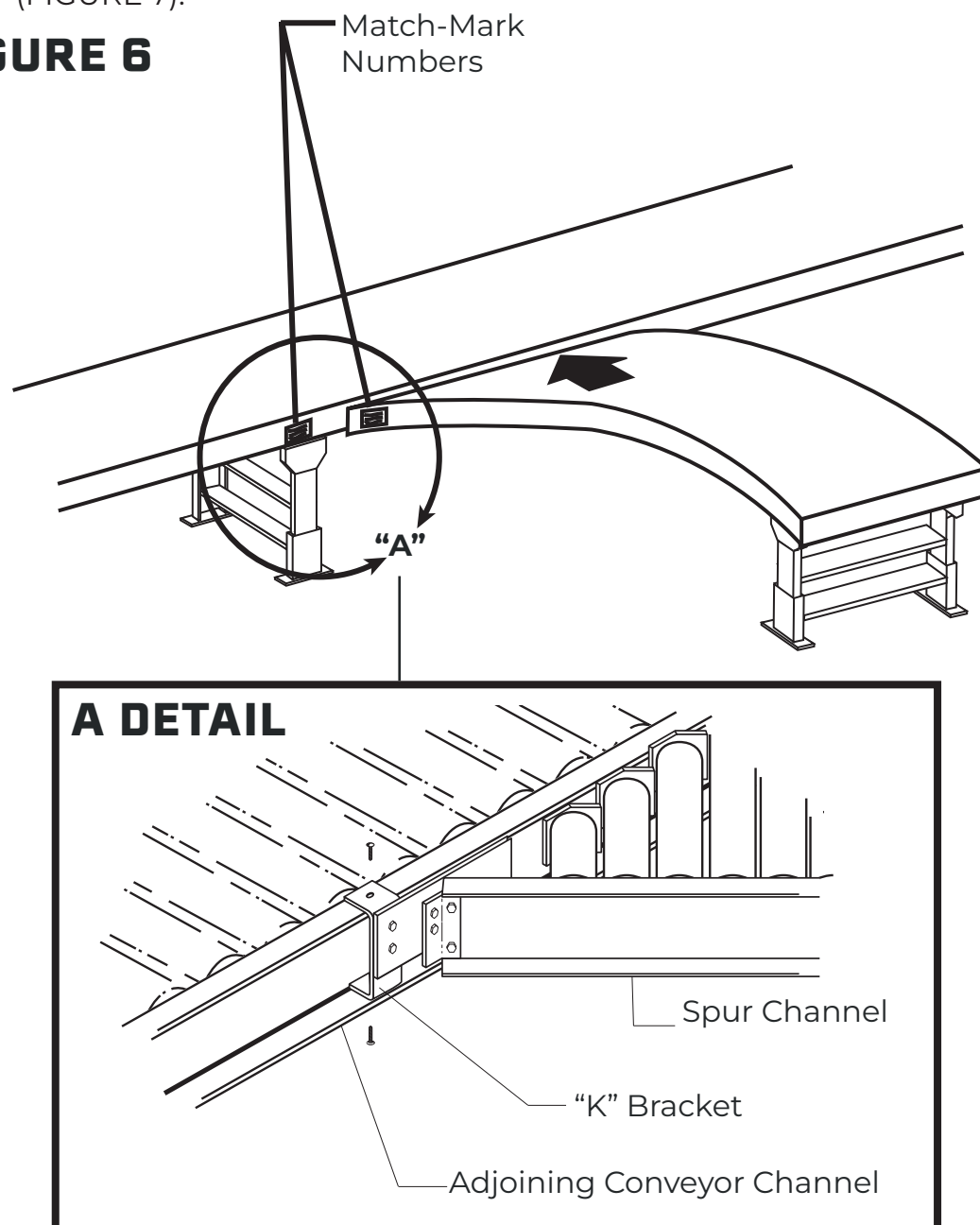


FIGURE 7 – FROM DIRECTION THE BELT IS INSTALLED

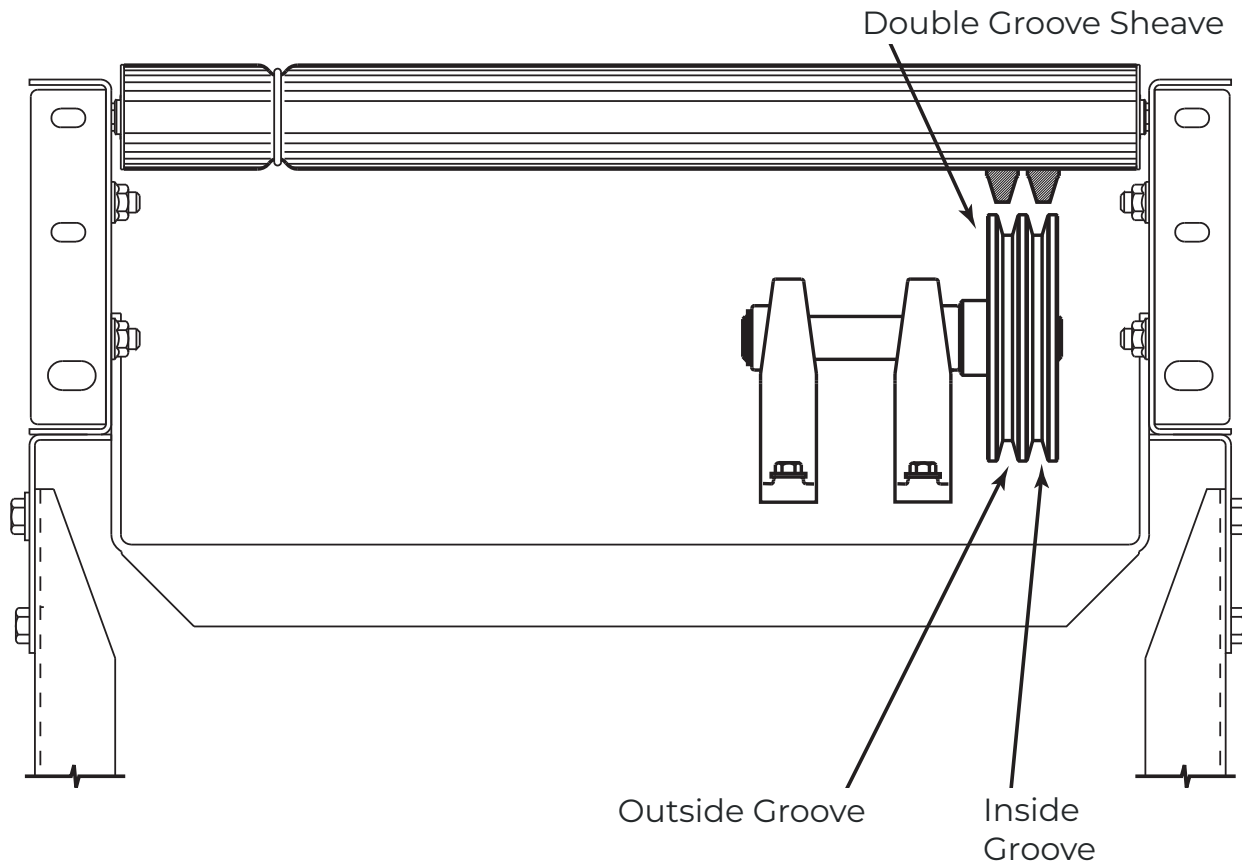
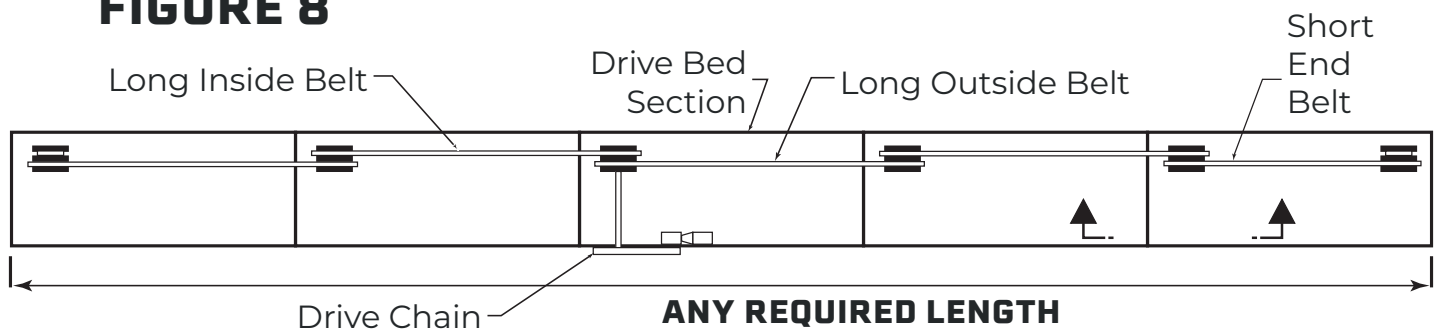


FIGURE 8



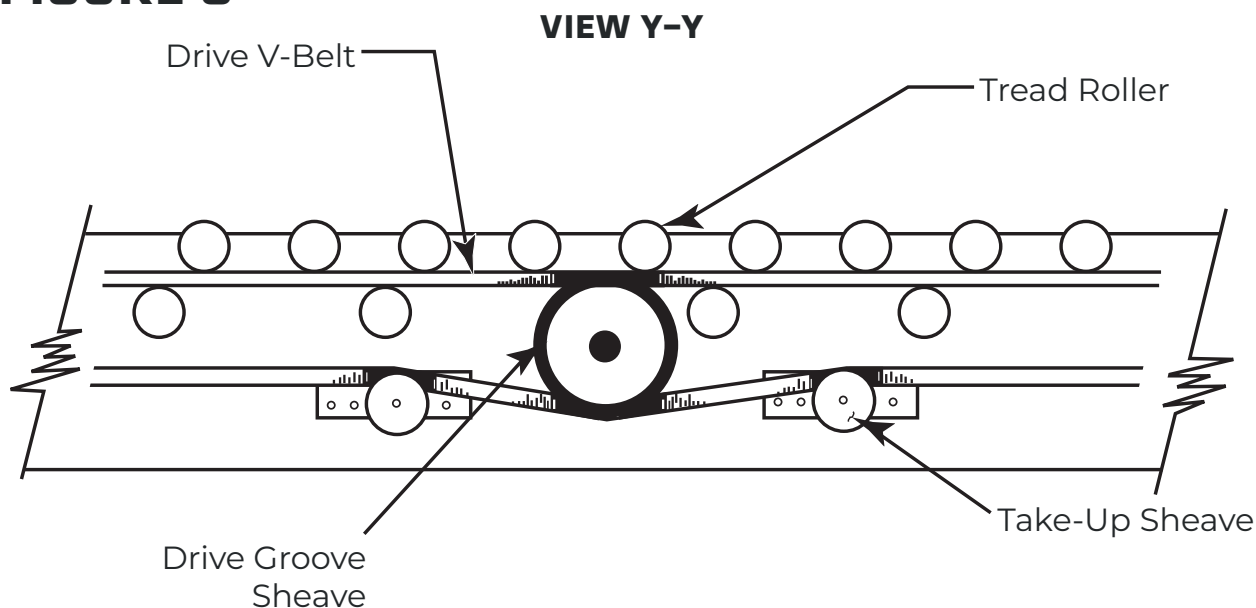
CAUTION

Under no circumstances should personnel attempt to install any V-belt while the drive motor is operating. Personal injury may occur.

INSTALLING THE V-BELT

1. Remove the front cover of the chain guard and disconnect the drive chain. This will free the drive sheave so belts may be installed.
2. Remove five tread rollers from both ends of each conveyor section (FIGURE 9). This is done by depressing one end of the spring-loaded shaft.
3. Note sections with a belt in the outside groove. Install these belts to adjoining sections first. Carefully roll the belts to the outside grooves by rotating the double sheaves.
4. Place drive belt over take-up sheave located near double groove sheave.
5. Install all remaining belts in the inside groove.
6. Reconnect the drive chain and replace the front cover of chain guard.
7. Replace all tread rollers.

FIGURE 9



CAUTION

During installation, do not use tools such as screwdrivers, wrenches, etc., or damage to the V-belts could occur.

3.4 BELT ALIGNMENT – 190-LRCT 90°, 60°, 45°, AND 30°

It is critical to align both idler sheaves with the drive sheaves so the belt runs in the middle of the drive sheave to prevent belt wear.

1. Position a straight edge on the face of the drive sheave:
 - on the bearing side for the 90° (FIGURE 10).
 - on the channel side for the 60°, 45°, and 30° s (FIGURE 11).
2. Move each idler sheave until the belt is parallel with the straight edge.

FIGURE 10

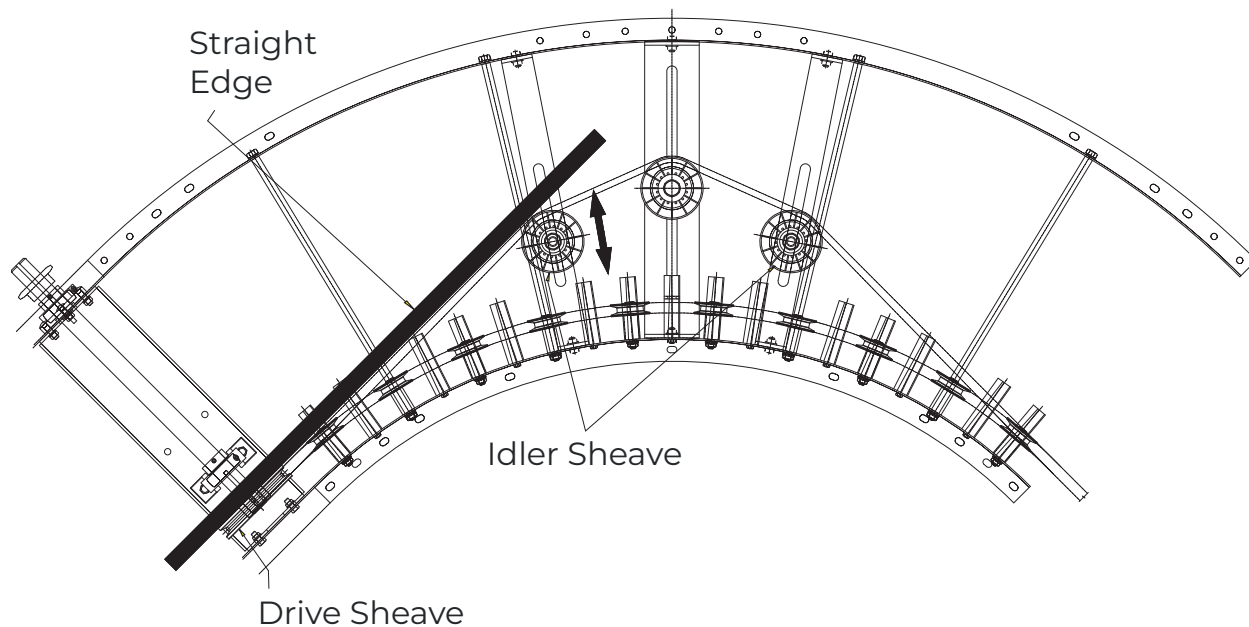
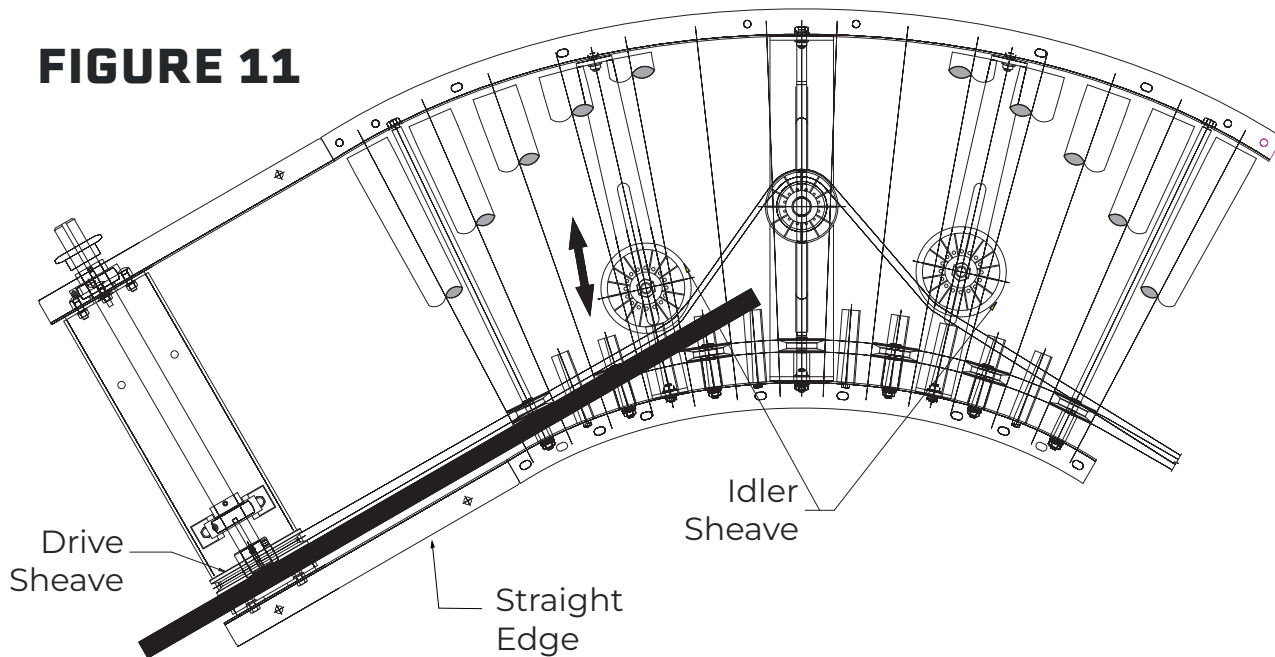


FIGURE 11



3.5 RACKED SECTIONS

It is important that each bed section be checked for a “racked” or out-of-square condition. If the conveyor is not square, tracking problems will result. FIGURE 12 depicts a racked section.

TO CORRECT AN OUT-OF-SQUARE SECTION

1. Locate points on corners of section and measure distance “A” & “B”. If the dimensions are not equal, the section will need to be squared (FIGURE 13).
2. Use crossbracing supplied on underside of conveyor to square each section. Adjust turnbuckle until Dimensions “A” & “B” are equal.
3. After all bed sections have been checked and corrected for “racked condition”, tighten all butt couplings and pivot plate bolts.
4. Make final check to see that all conveyor sections are level across width and length. If entire conveyor is level, supports can be lagged to floor.

FIGURE 12

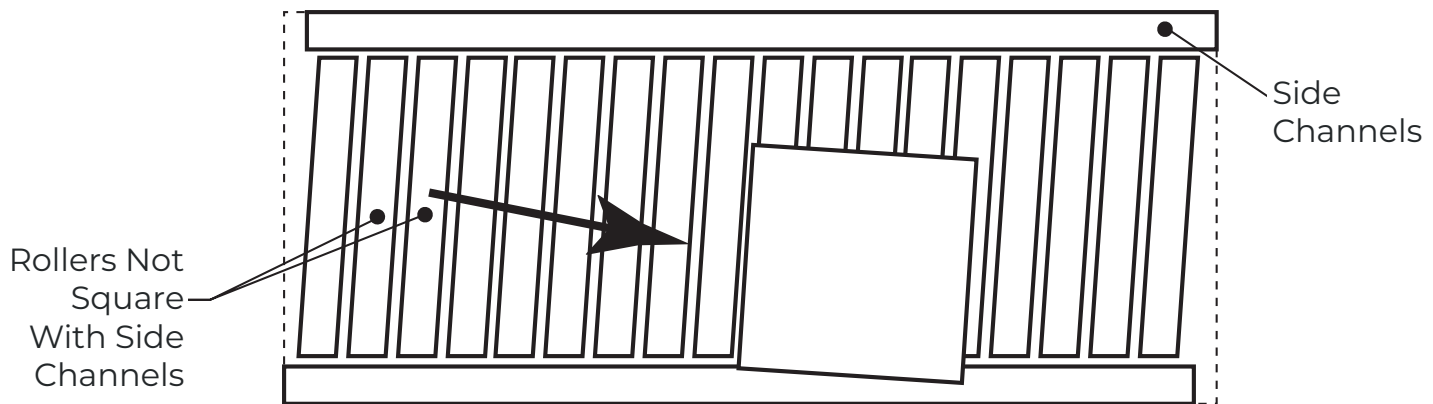
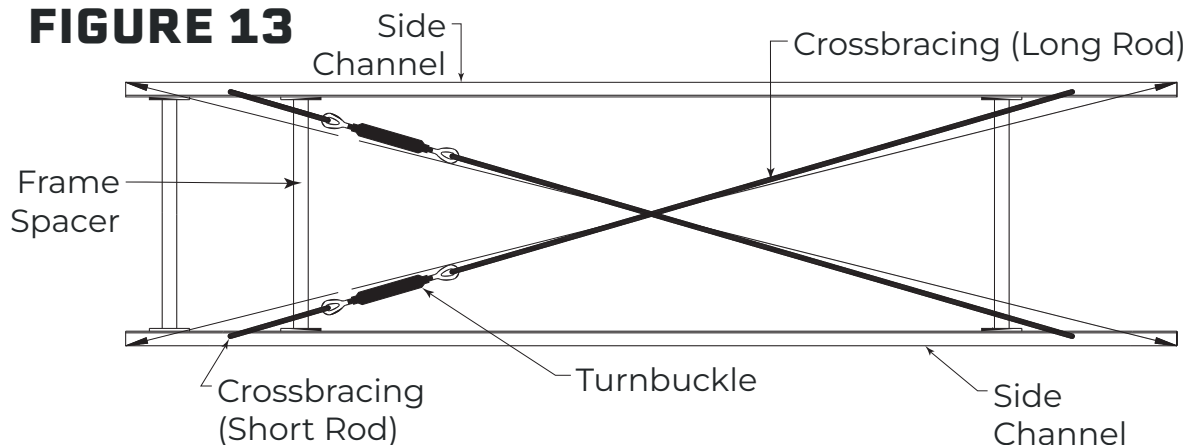


FIGURE 13



IMPORTANT

Being out of level across width of conveyor can cause package drift on long conveyor lines.

3.6 ELECTRICAL EQUIPMENT

CONTROLS

Electrical Code: All motor controls and wiring shall conform to the National Electrical Code (Article 670 or other applicable articles) as published by the National Fire Protection Association and as approved by the American Standards Institute, Inc.

CONTROL STATIONS

- A. Control stations should be so arranged and located that the operation of the equipment is visible from them, and shall be clearly marked or labeled to indicate the function controlled.
- B. A conveyor which would cause injury when started shall not be started until employees in the area are alerted by a signal or by a designated person that the conveyor is about to start.
 - When a conveyor would cause injury when started and is automatically controlled or must be controlled from a remote location, an audible device shall be provided which can be clearly heard at all points along the conveyor where personnel may be present. The warning device shall be actuated by the controller device starting the conveyor and shall continue for a required period of time before the conveyor starts. A flashing light or similar visual warning may be used in conjunction with or in place of the audible device if more effective in particular circumstances.
 - Where system function would be seriously hindered or adversely affected by the required time delay or where the intent of the warning may be misinterpreted (i.e., a work area with many different conveyors and allied devices), clear, concise, and legible warning shall be provided. The warning shall indicate that conveyors and allied equipment may be started at any time, that danger exists, and that personnel must keep clear. The warnings shall be provided along the conveyor at areas not guarded by position or location.
- C. Remotely and automatically controlled conveyors, and conveyors where operator stations are not manned or are beyond voice and visual contact from drive areas, loading areas, transfer points, and other potentially hazardous locations on the conveyor path not guarded by location, position, or guards, shall be furnished with emergency stop buttons, pull cords, limit switches, or similar emergency stop devices.
 - All such emergency stop devices shall be easily identifiable in the immediate vicinity of such locations unless guarded by location, position, or guards. Where the design, function, and operation of such conveyor clearly is not hazardous to personnel, an emergency stop device is not required.
 - The emergency stop device shall act directly on the control of the conveyor concerned and shall not depend on the stopping

of any other equipment. The emergency stop devices shall be installed so that they cannot be overridden from other locations.

- D. Inactive and unused actuators, controllers, and wiring should be removed from control stations and panel boards, together with obsolete diagrams, indicators, control labels, and other material which serve to confuse the operator.

SAFETY DEVICES

- A. All safety devices, including wiring of electrical safety devices, shall be arranged to operate in a “Fail-Safe” manner, that is, if power failure or failure of the device itself would occur, a hazardous condition must not result.
- B. Emergency Stops and Restarts. Conveyor controls shall be so arranged that, in case of emergency stop, manual reset or start at the location where the emergency stop was initiated, shall be required of the conveyor(s) and associated equipment to resume operation.
- C. Before restarting a conveyor which has been stopped because of an emergency, an inspection of the conveyor shall be made and the cause of the stoppage determined. The starting device shall be locked out before any attempt is made to remove the cause of stoppage, unless operation is necessary to determine the cause or to safely remove the stoppage.

Refer to ANSI Z244.1-1982, American National Standard for Personnel Protection – Lockout/Tagout of Energy Sources – Minimum Safety Requirements and OSHA Standard Number 29 CFR 1910.147 “The Control of Hazardous Energy (Lockout/Tagout).”

WARNING!

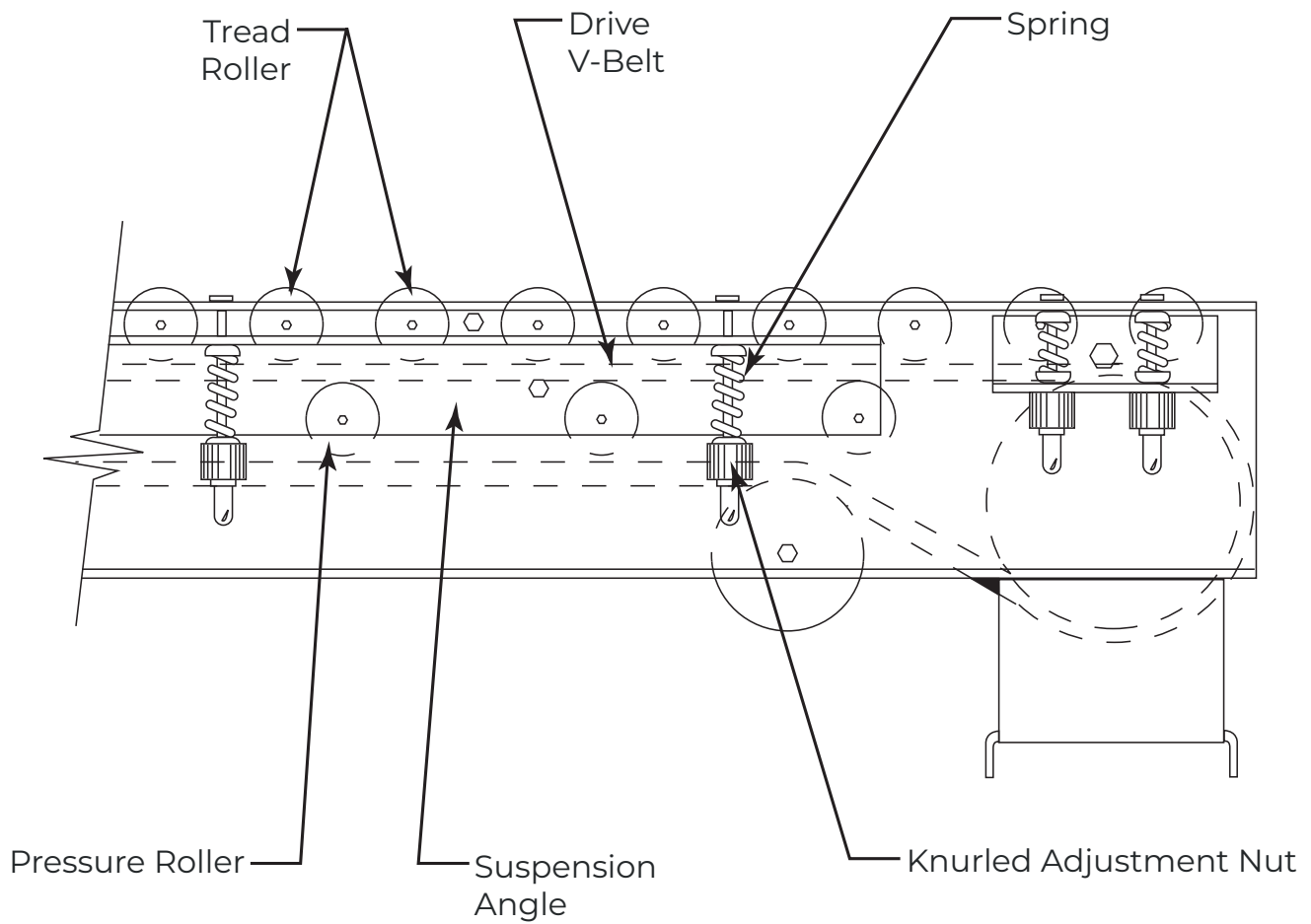
Electrical controls shall be installed and wired by a qualified electrician. Wiring information for the motor and controls are furnished by the equipment manufacturer.

3.7 PRESSURE ADJUSTMENT – ACC

The ACC (FIGURE 14 on page 18) is equipped with suspension angles that support the pressure rollers and hold the drive V-Belt in contact with the tread rollers. Knurled nuts allow the conveyor to be finely adjusted for minimum pressure accumulation. To make this adjustment, follow the steps listed below.

1. With conveyor running, reduce pressure on all tread rollers to zero by loosening the knurled adjustment nuts.
2. Place heaviest item to be conveyed on infeed end of conveyor. Increase pressure under the item by tightening the knurled nuts. Apply only enough pressure to slightly move the item.
3. As the item moves, continue adjustment ahead of item until it moves the entire length of conveyor.
4. Return item to infeed end of unit. It should now travel the entire length of conveyor. If not, repeat the adjustment procedure in the problem area.

FIGURE 14

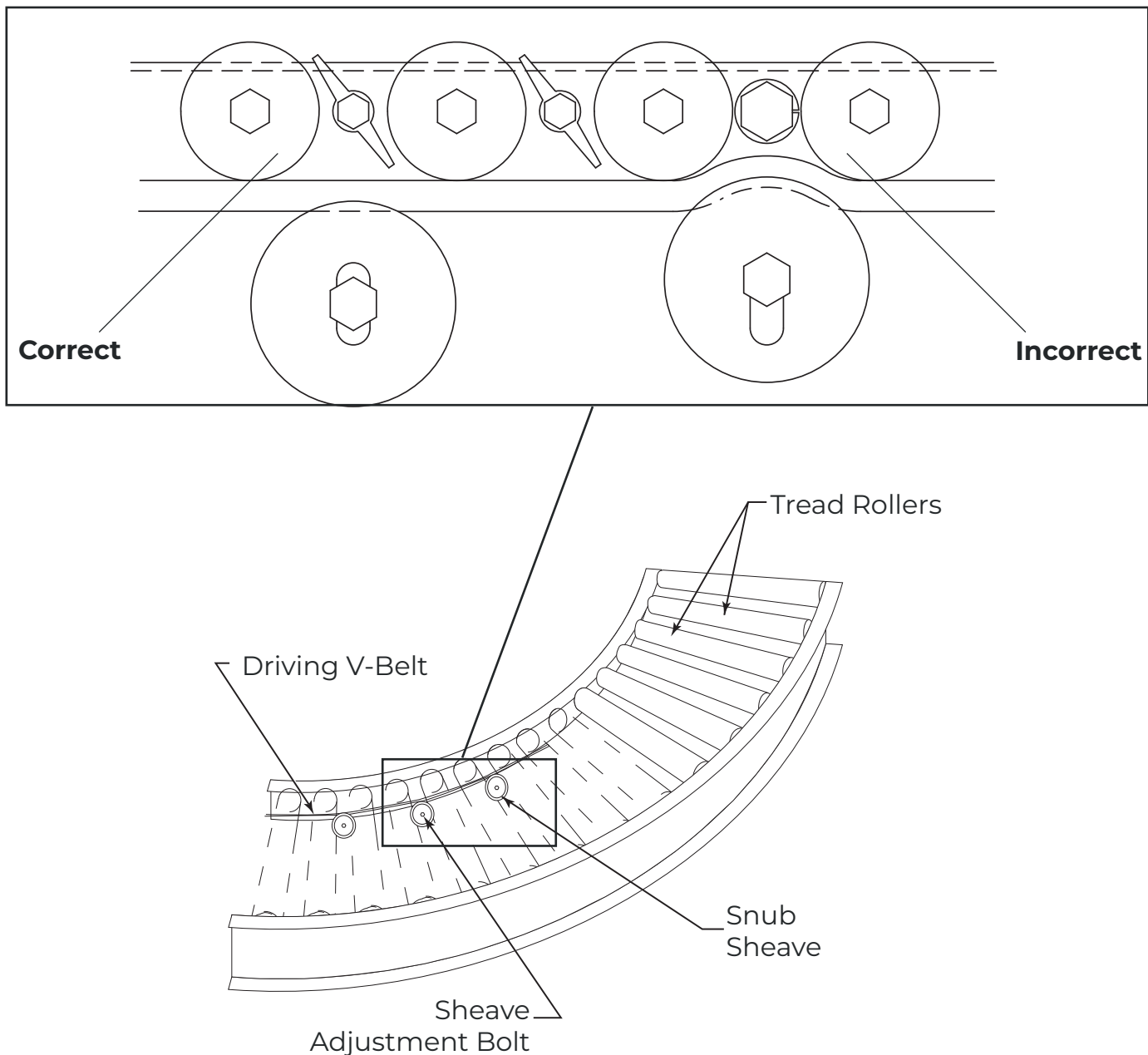


3.8 PRESSURE ADJUSTMENT – LRCT,LRST, & LRSS

Curves and spurs have snub sheaves that hold the drive V-Belt in contact with its tread rollers. For the LRCT, LRST, & LRSS (FIGURE 15 on page 19), adjustments are made by moving the snub sheaves up or down in the slotted conveyor channel.

When making adjustments, apply only enough force to move the heaviest item to be conveyed.

FIGURE 15



CAUTION

Snubbing the belt too much can cause the conveyor to stall.

4 OPERATION

4.1 CONVEYOR START-UP

Before the conveyor is turned on, check for foreign objects that may have been left inside conveyor during installation. These objects could cause serious damage during start-up.

After the conveyor has been turned on and is operating, check all moving parts to make sure they are working freely.

CAUTION!

Because of the many moving parts on the conveyor, all personnel in the area of the conveyor need to be warned that the conveyor is about to be started.

5 MAINTENANCE

5.1 LUBRICATION

The drive chain is pre-lubricated from the manufacturer by a hot dipping process that ensures total lubrication of all components. However, continued proper lubrication will greatly extend the useful life of every drive chain.

Drive chain lubrication serves several purposes including:

- Protecting against wear of the pin-bushing joint
- Lubricating chain-sprocket contact surfaces
- Preventing rust or corrosion

For normal operating environments, lubricate every **2,080 hours** of operation or every **6 months**, whichever comes first. Lubricate with a good grade of petroleum or synthetic oil (i.e., Shell Rotella or Mobil 1).

For best results, always use a brush to generously lubricate the chain. The proper viscosity of lubricant greatly affects its ability to flow into the internal areas of the chain. Refer to the table below for the proper viscosity of lubricant for your application.

AMBIENT TEMPERATURE DEGREES (°F)	SAE	ISO
20-40	20	46 or 68
40-100	30	100
100-120	40	150

The drive chain's lubrication requirement is greatly affected by the operating conditions. For harsh conditions such as damp environments, dusty environments, excessive speeds, or elevated temperatures, it is best to lubricate more frequently. It may be best, under these conditions, to develop a custom lubrication schedule for your specific application.

A custom lubrication schedule may be developed by inspecting the drive chain on regular time intervals for sufficient lubrication. Once the time interval is determined at which the chain is not sufficiently lubricated, lubricate it and schedule the future lubrication intervals accordingly.

5.2 BELT REPLACEMENT – ACC

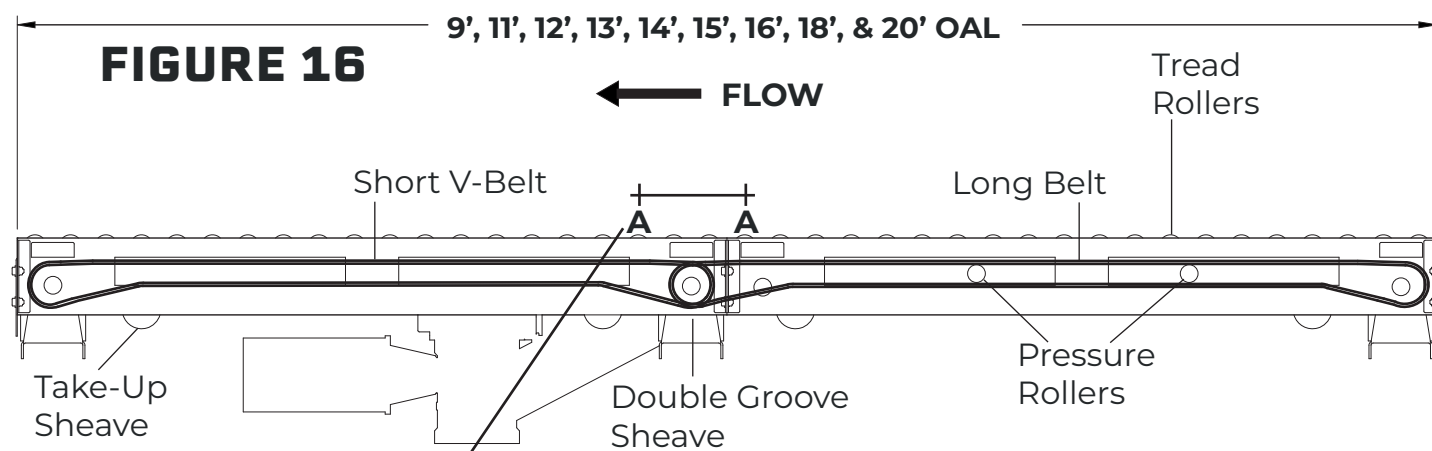
BEFOREHAND

1. Check length of section in which belt is to be replaced.
2. Determine if a “long” or “short” belt is needed (FIGURE 16 on page 22).
3. See respective parts list in Section 6 PARTS DRAWINGS for correct replacement parts.

TO REPLACE BELT

1. Using knurled nuts, lower belt away from tread rollers in section where belt is being replaced.
2. Remove five tread rollers from each end of section.
3. Remove all pressure rollers.
4. Replace belt and all rollers.
5. Adjust accumulation pressure per section 3.7 Pressure Adjustment - ACC on page 18.

FIGURE 16



**DETAIL
A-A**

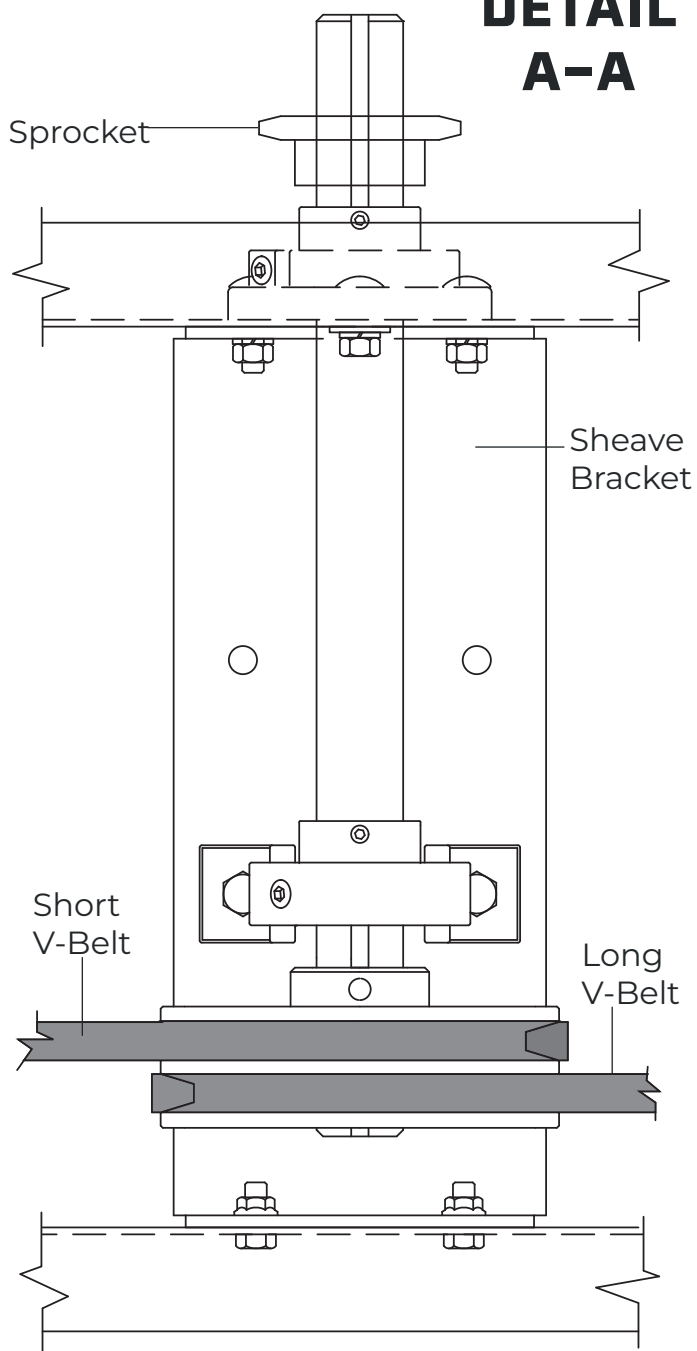
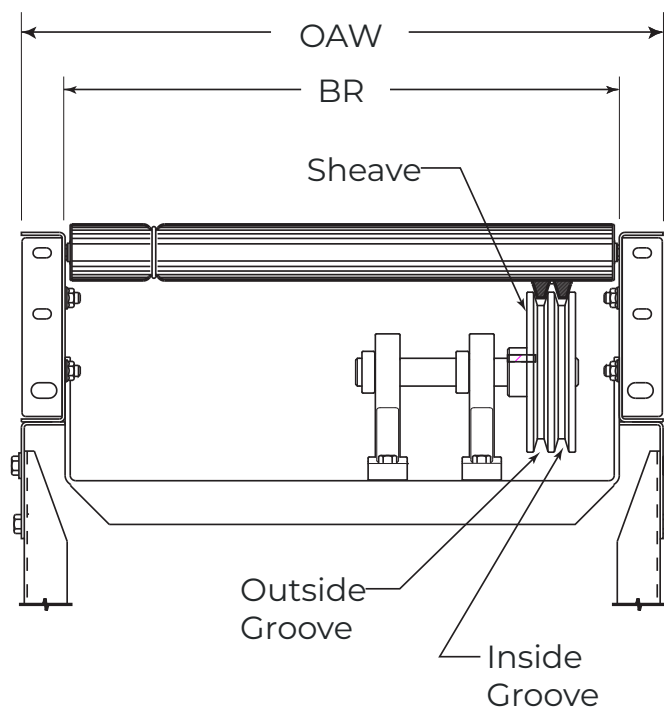


FIGURE 17



5.3 BELT REPLACEMENT – LRCT, LRST, & LRSS

BEFOREHAND

1. Check Overall Frame Width (OAW) (FIGURE 17 on page 22).
2. Determine degree of curve or spur.
3. See respective parts list in Section 6 PARTS DRAWINGS for correct replacement parts.

TO REPLACE BELT

1. Note how existing belt is installed.
2. Remove all tread rollers.
3. Replace belt and all rollers.
4. Adjust belt tension per section 5.6 Drive Chain Alignment and Tension on page 26.

NOTE: Special length V-belts are used on the **ACC & LRSS** conveyors. It is recommended that replacements be obtained from Hytrol.

The **LRCT & LRST** conveyors use standard “B” section industrial grade V-belts (Non-Glass Core). These belts may either be purchased from Hytrol or local suppliers.

CAUTION

During installation, do not use tools such as screwdrivers, wrenches, etc., or damage to the V-belts could occur.

5.4 ADJUST BELT TENSION – ACC

Take-up brackets with sheaves are located at both ends of conveyor section to adjust belt tension (FIGURE 18 on page 24).

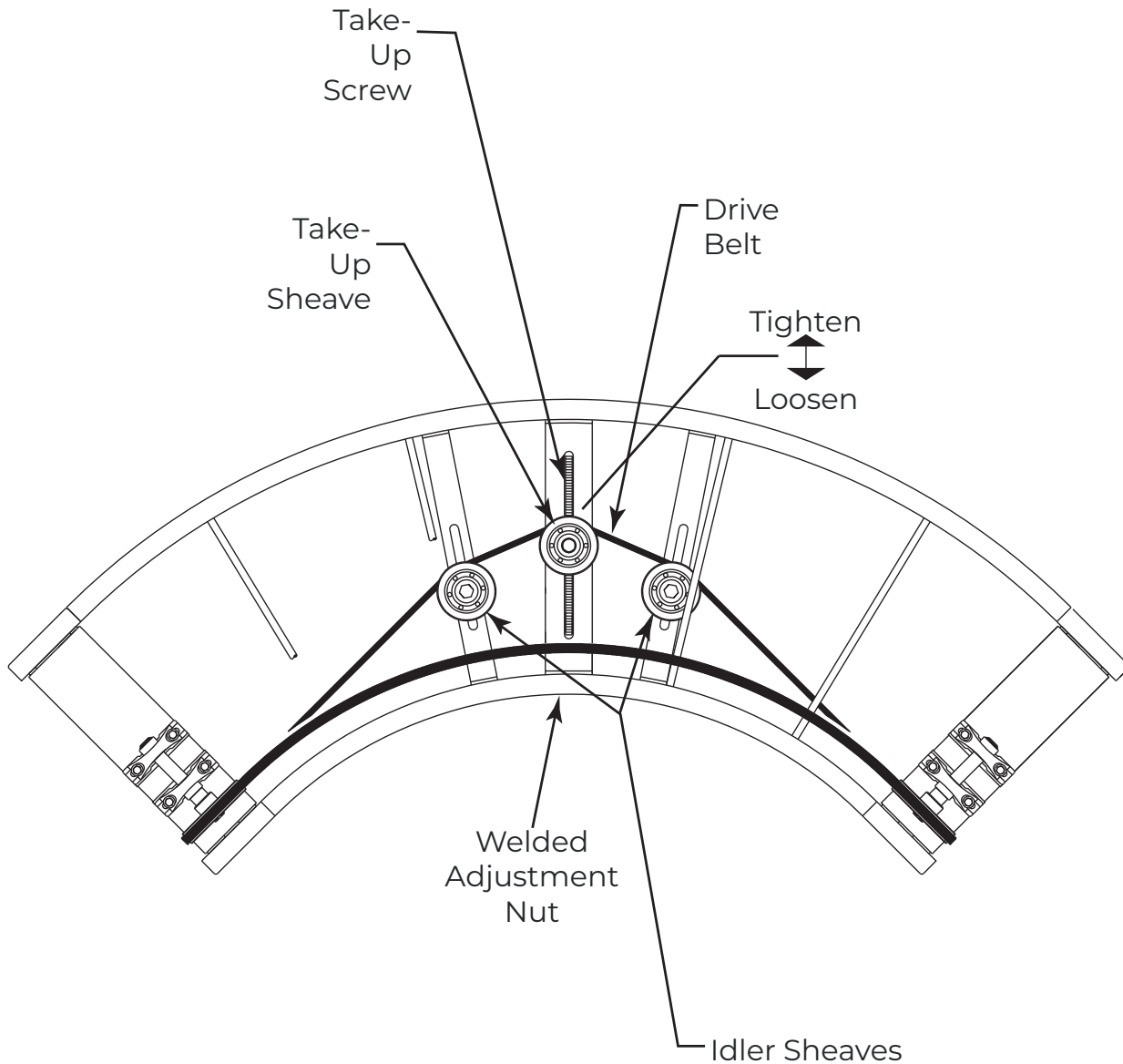
To tighten belt, remove take-up sheave and re-position in another hole closer to double groove sheave.

To loosen belt, move take-up sheave in opposite direction.

NOTE

It is recommended that both take-up sheaves be moved when making adjustments.

FIGURE 18



5.5 ADJUST BELT TENSION – LRCT, LRST, & LRSS

The LRCT and LRST have a take-up bracket located near the center on the underside of the conveyor.

To adjust the belt tension, locate the welded adjustment nut on the inside radius below the side frame. Using a wrench or socket, turn the adjustment nut counter clockwise until proper tension is achieved according to the gauge provided (FIGURE 19 on page 25).

For the LRSS, the belt take-up is provided at the spur (pointed) end (FIGURE 20 on page 25).

To adjust, loosen mounting bolt and move sheave until proper tension is reached. Re-tighten mounting bolt.

FIGURE 19

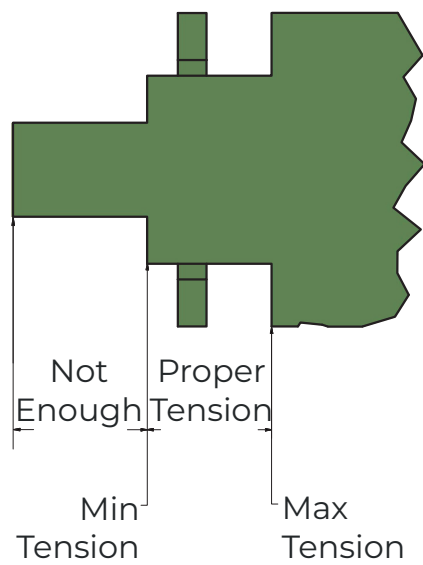
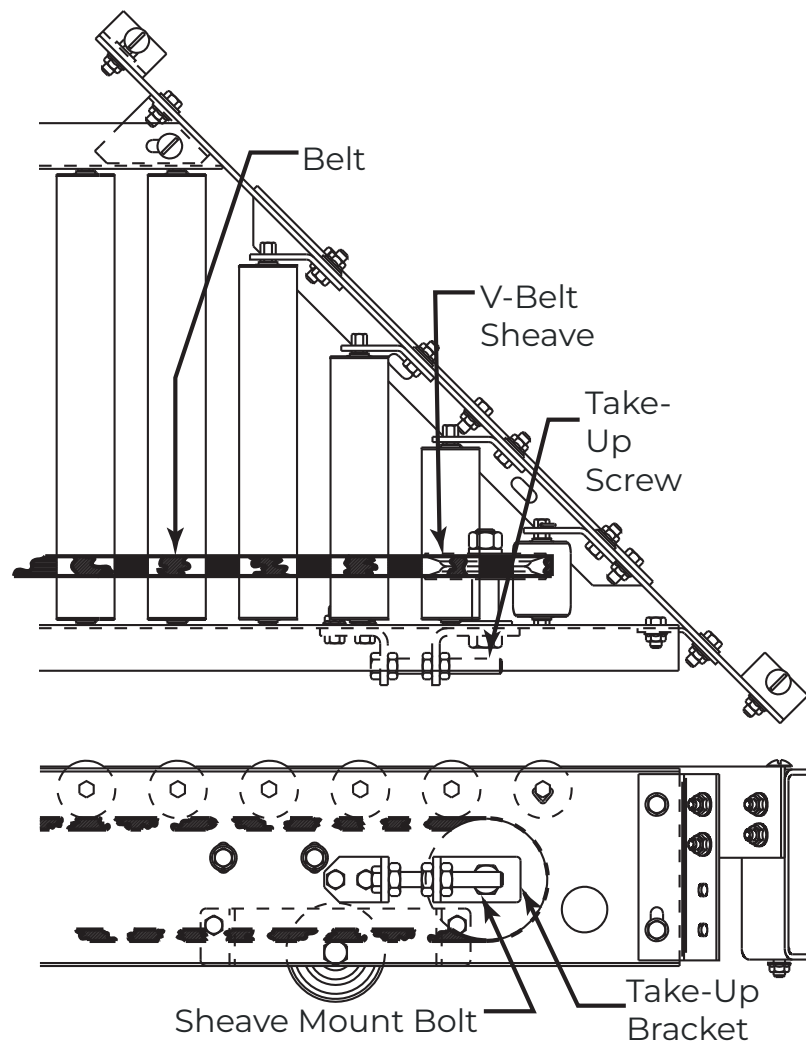


FIGURE 20



5.6 DRIVE CHAIN ALIGNMENT AND TENSION

The drive chain and sprockets should be checked periodically for proper tension and alignment. Improper adjustment will cause extensive wear to the drive components.

TO MAKE ADJUSTMENTS

1. Remove chain guard.
2. Check sprocket alignment by placing a straight edge across the face of both sprockets (FIGURE 21).
3. Loosen set screws and adjust as needed. Re-tighten set screws.
4. To adjust chain tension, loosen bolts that fasten motor base to mounting angles, both sides of the conveyor. Tighten take-up bolts until desired chain tension is reached (FIGURES 22 & 23). Re-tighten mounting bolts.
5. Lubricate chain per section 5.1 LUBRICATION on page 20.
6. Replace chain guard so that it does not interfere with drive.

FIGURE 21

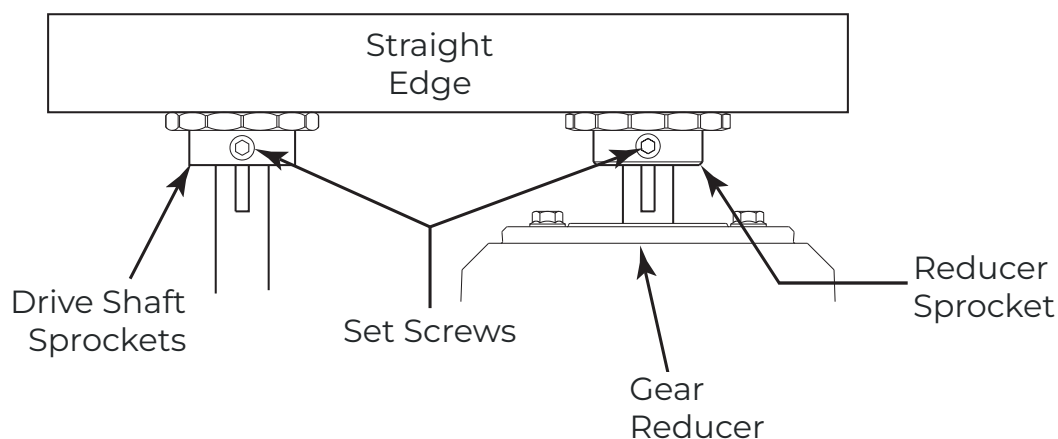


FIGURE 22

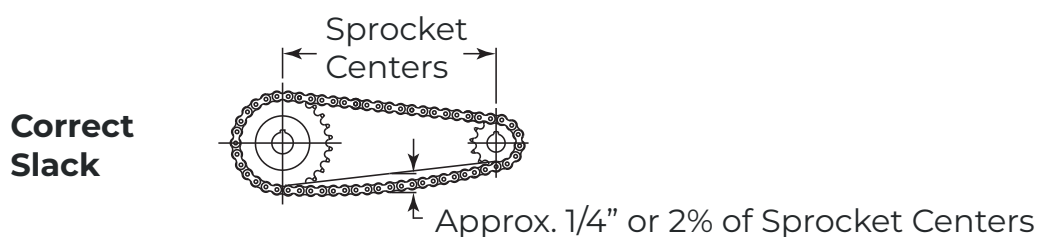
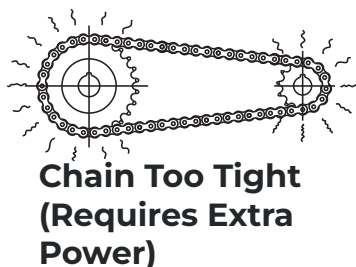
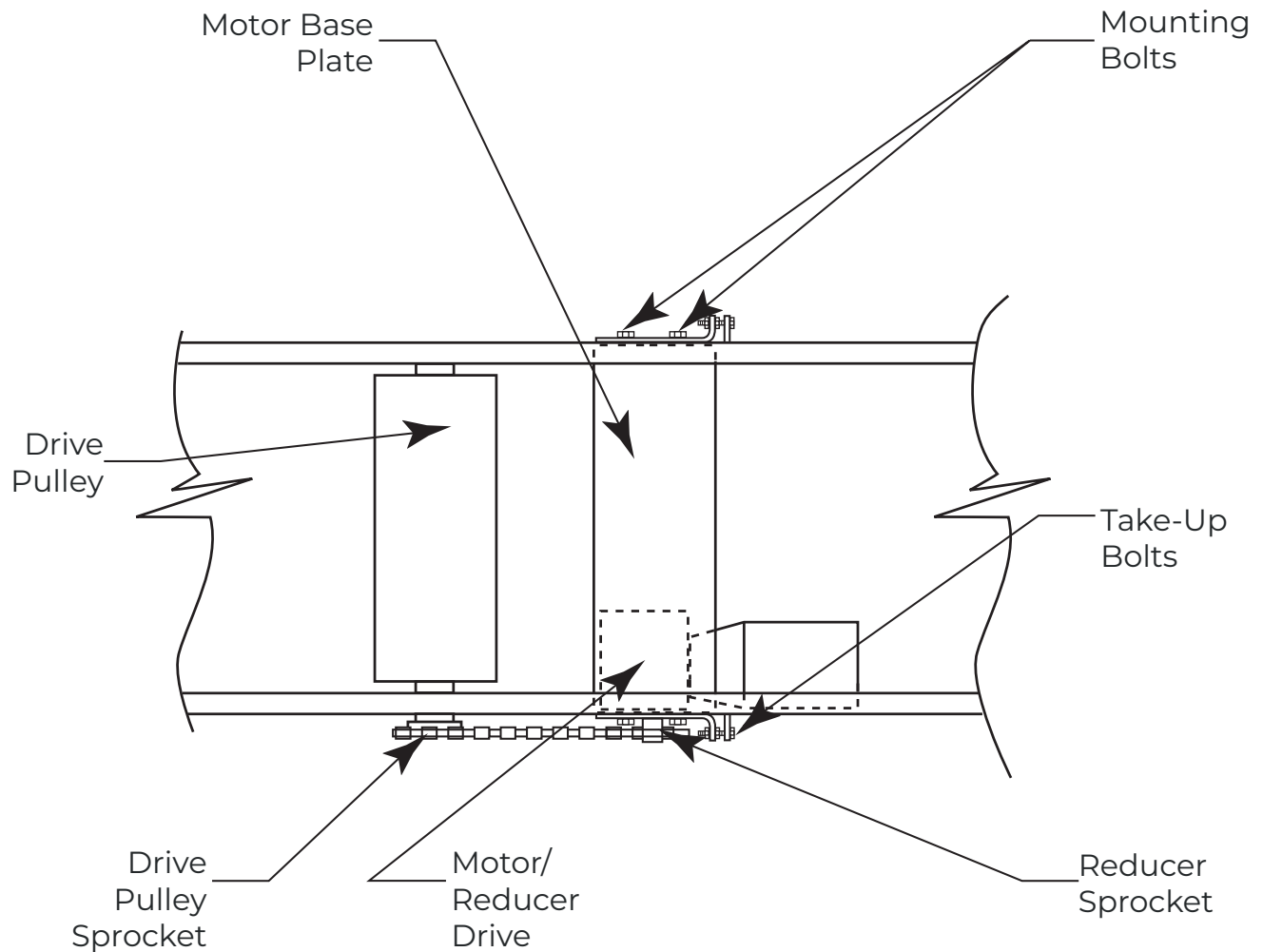


FIGURE 23



5.7 EXTERNAL SLAVE DRIVE

TO INSTALL THE CONNECTING CHAIN:

1. Remove sprockets and chain guard back plate as necessary so conveyors can be connected together.
2. Fasten conveyors together with butt couplings and pivot plates (FIGURE 2 on page 9).
3. Attach chain guard back plate to bottom of conveyor frame (FIGURE 25 on page 28).
4. Install sprockets and keys on shafts and align by placing straight edge across the face of both sprockets (FIGURE 20 on page 25). Adjust as needed and tighten set screws.
5. Install chain around sprockets and insert connecting link (FIGURE 24 on page 28). Tighten chain by adjusting take-up block.
 - **NOTE:** If conveying in one direction only, position take-up block on slack side of chain. If conveying in both directions, position take-up block at bottom of chain (FIGURES 24 AND 25 on page 28).
6. Install chain guard front plate.

FIGURE 24

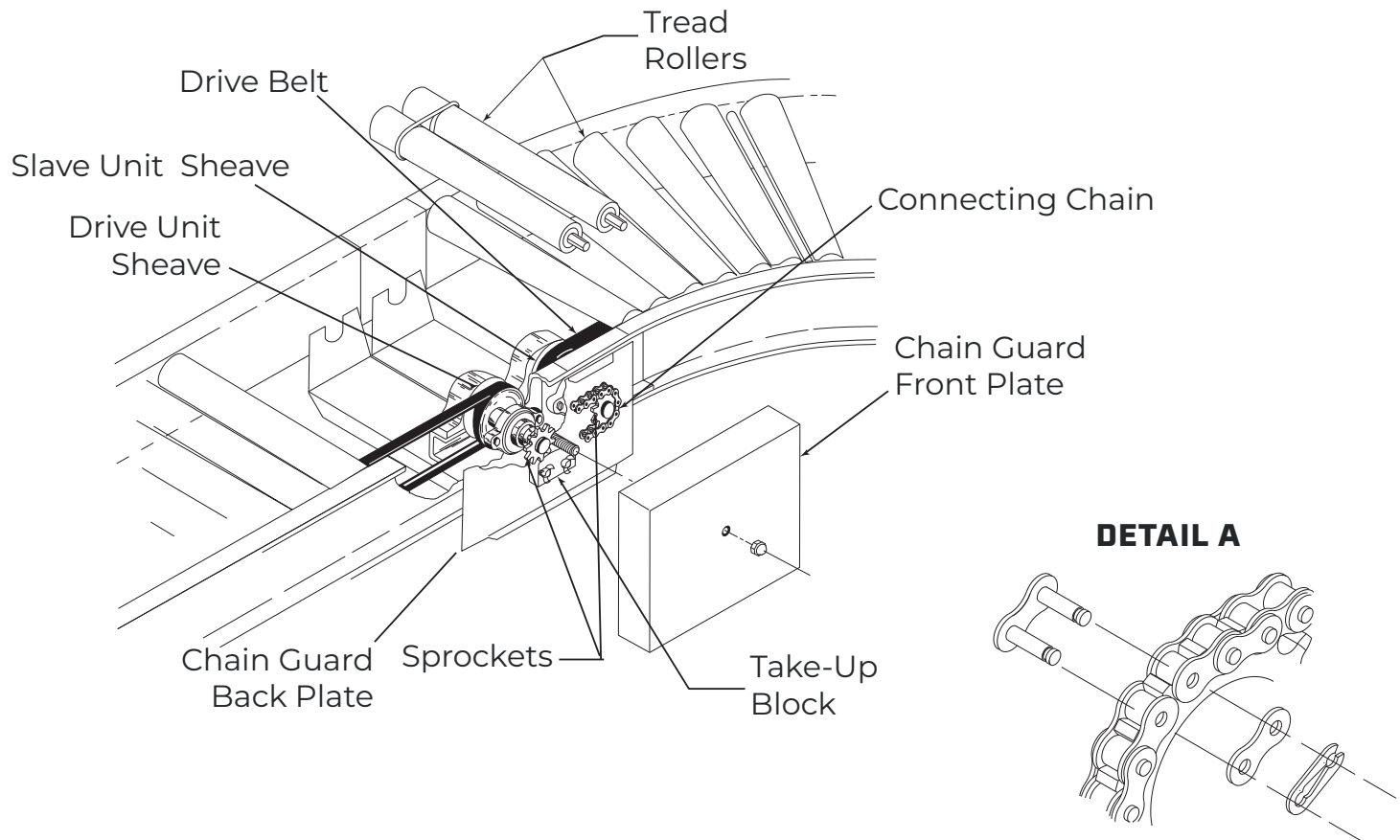
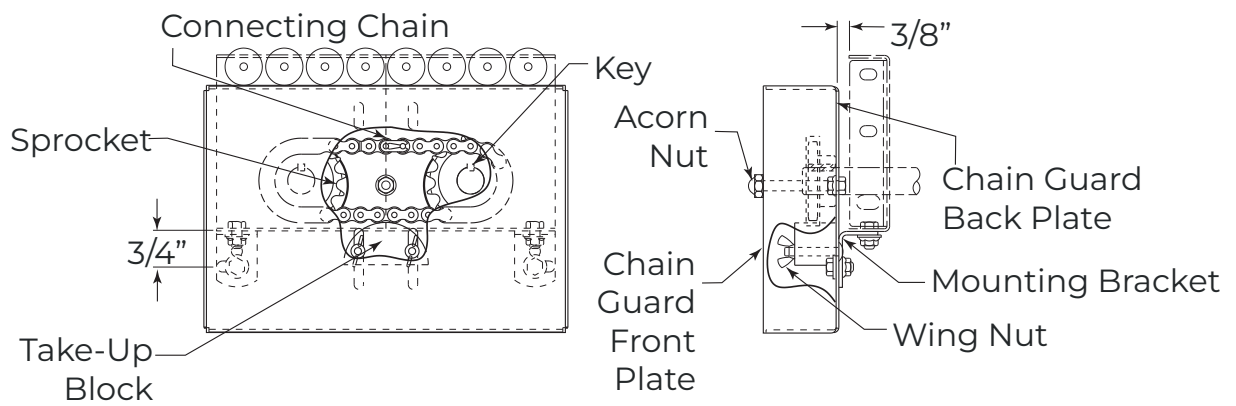
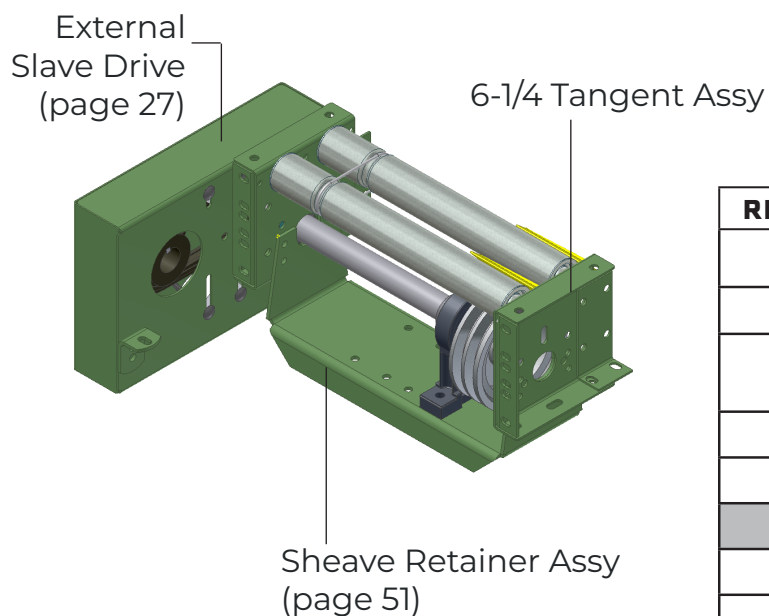
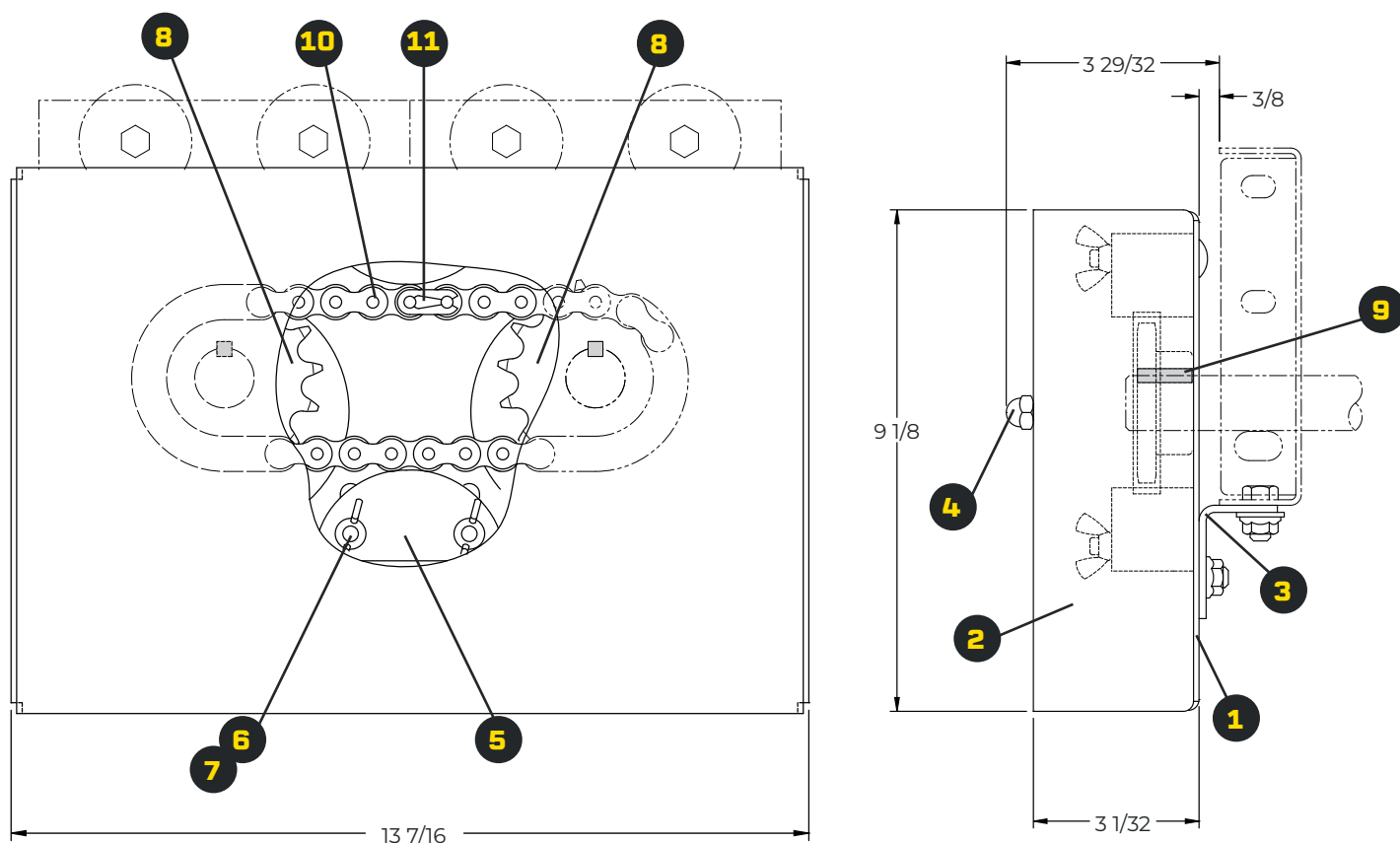


FIGURE 25



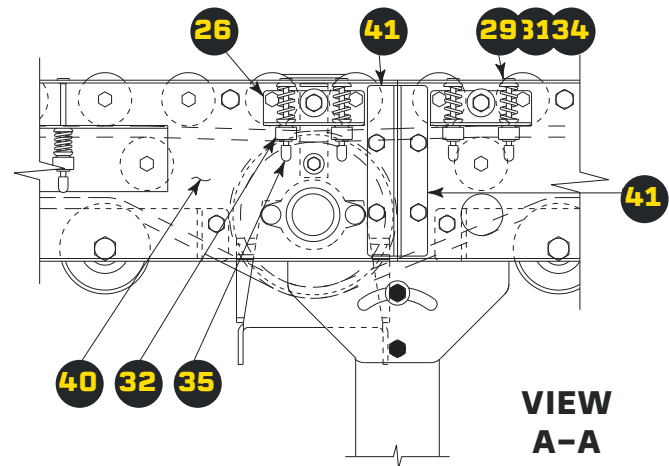
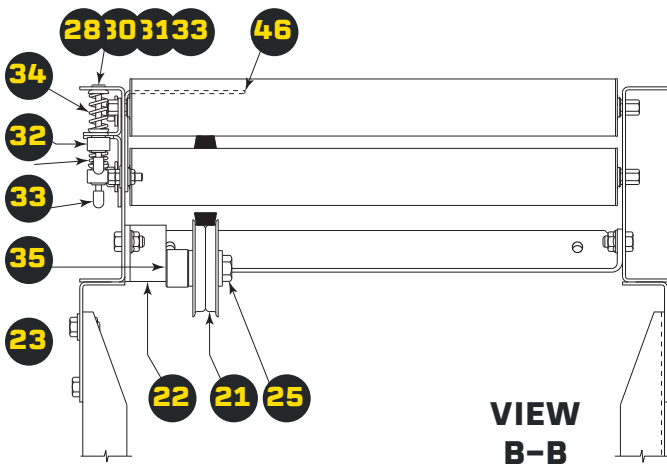
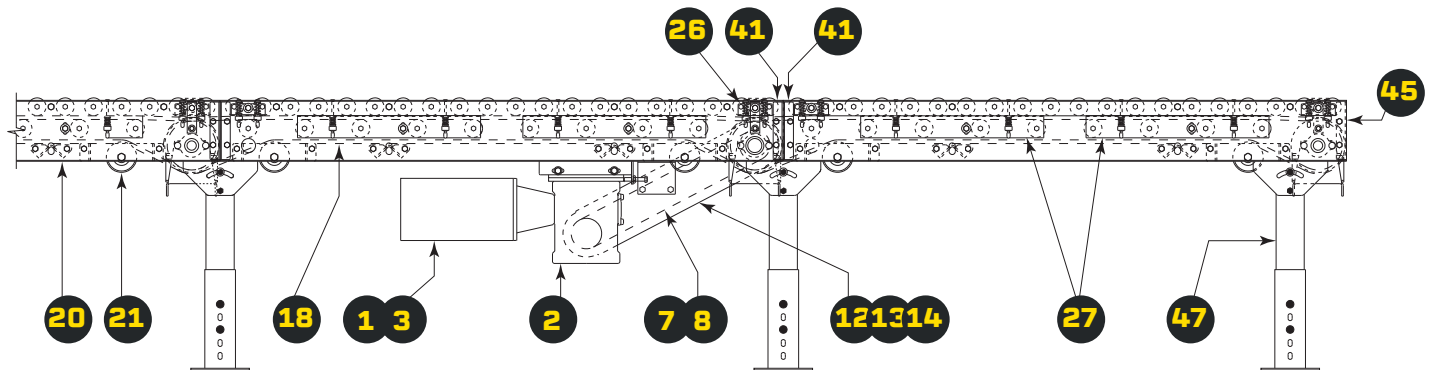
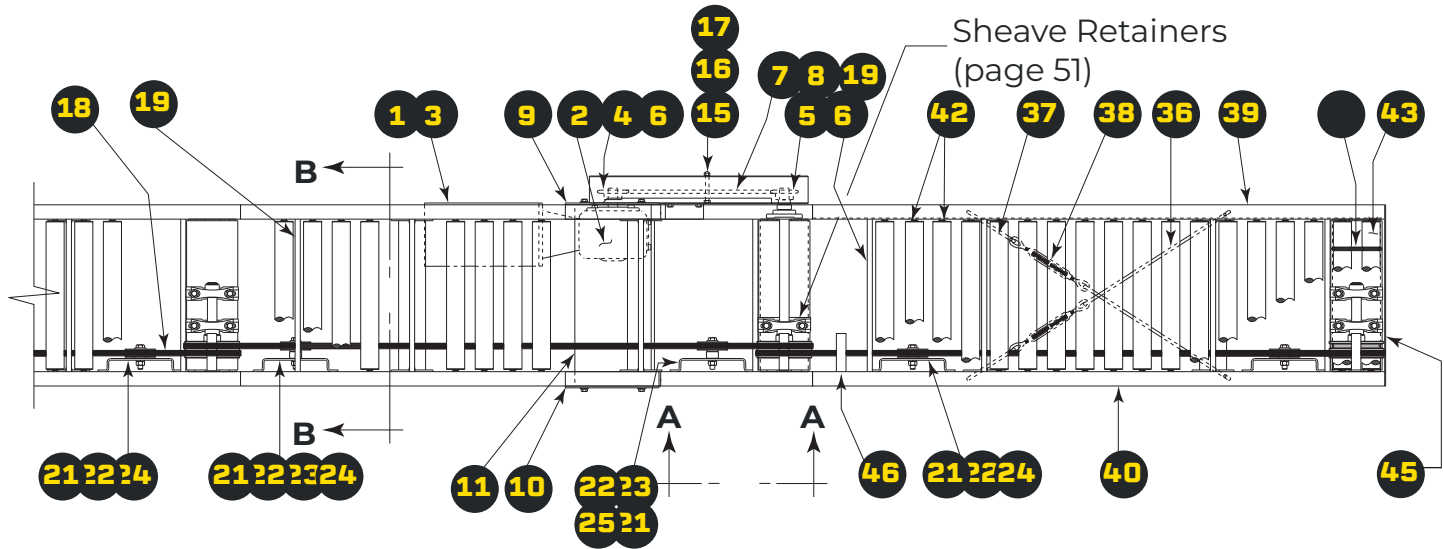
6 PARTS DRAWINGS

6.1 SLAVE CONNECTION DRAWINGS & PARTS LIST

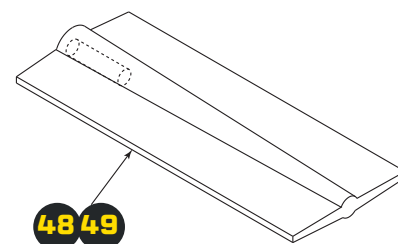


REF #	DESCRIPTION
1	CHAIN GUARD BACK PLATE
2	CHAIN GUARD FRONT PLATE
3	CHAIN GUARD MOUNTING BRACKET
4	ACORN NUT - 3/8-16
5	TAKE-UP BLOCK
6	CARRIAGE BOLT - 5/16-18 X 2 IN. LONG
7	WING NUT - 5/16-18
8	SPROCKET
9	SHAFT KEY - 1/4 IN. SQUARE X 1 IN. LONG
10	#50 ROLLER CHAIN
11	CONNECTOR LINK - #50 ROLLER CHAIN

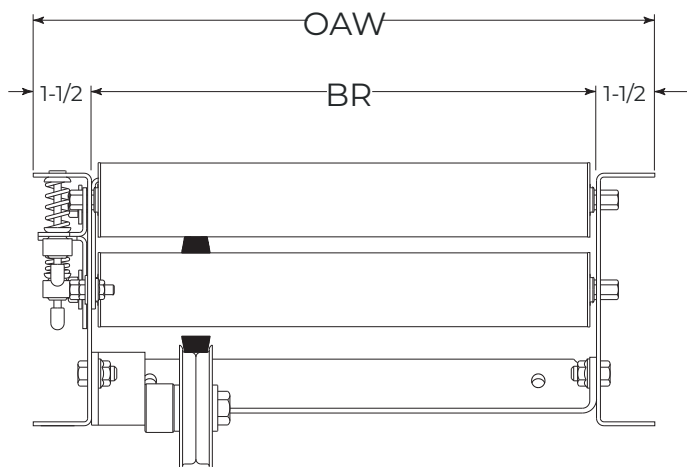
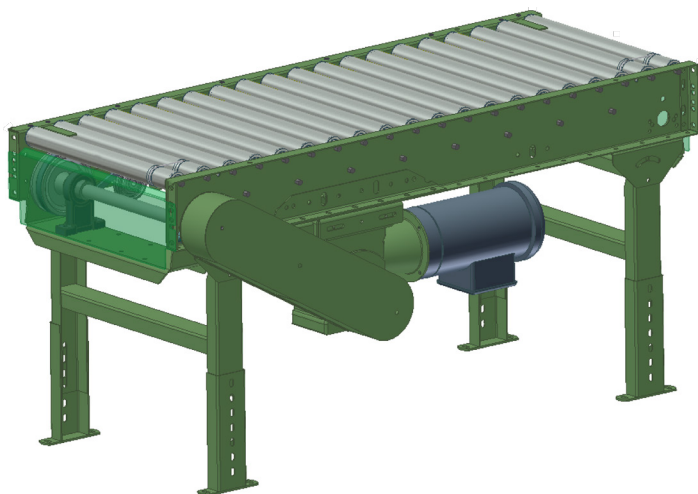
6.2 190-ACC PARTS DRAWING



Ref page 29 for Slave Connections



6.3 190-ACC PARTS LIST

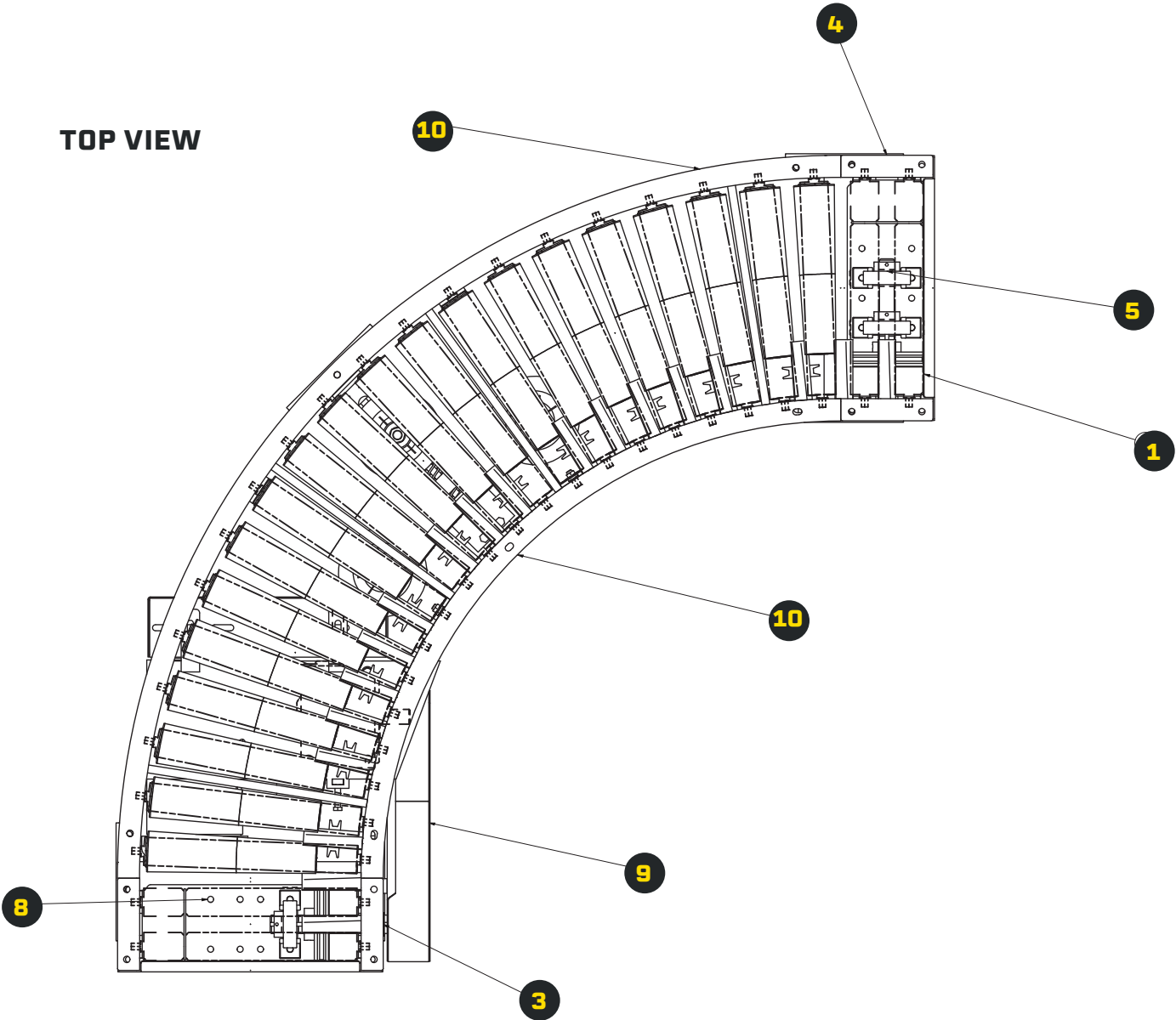


REF #	DESCRIPTION
1	MOTOR - C-FACE
2	SPEED REDUCER
3	COUPLING KIT - MOTOR TO REDUCER
4	SPROCKET - REDUCER
5	SPROCKET - DRIVE SHAFT, 50B13 X 1-1/4 IN. BORE
6	SHAFT KEY - 1/4 IN. SQUARE X 1 IN. LONG
7	#50 RIVETED ROLLER CHAIN
8	#50 CONNECTOR LINK
9	MOTOR BASE SUPPORT ANGLE - LH
10	MOTOR BASE SUPPORT ANGLE - RH
11	MOTOR BASE WELDED ASSEMBLY (SPECIFY BR)
12	CHAIN GUARD BACK PLATE
13	CHAIN GUARD FRONT PLATE WELDMENT
14	CHAIN GUARD SUPPORT ANGLE
15	HEX HEAD BOLT - 3/8-16 X 4 IN. LONG
16	SMALL FLANGE LOCKNUT - 3/8-16
17	ACORN NUT—3/8-16
18	V-BELT (DRIVE)
19	THREADED SECTION SPACER (SPECIFY BR)
20	BED SPACER (SPECIFY BR)
21	FLAT IDLER SHEAVE - 3-1/4 IN. OD X 1/2 IN. BORE
22	SNUB RETURN IDLER BRACKET
23	SPACER -33/64 IN. ID X 1-1/4 IN. OD X 3/4 IN. LONG
24	HEX HEAD CAP SCREW - 1/2-13 X 2 IN. LG. (INSIDE GROOVE)

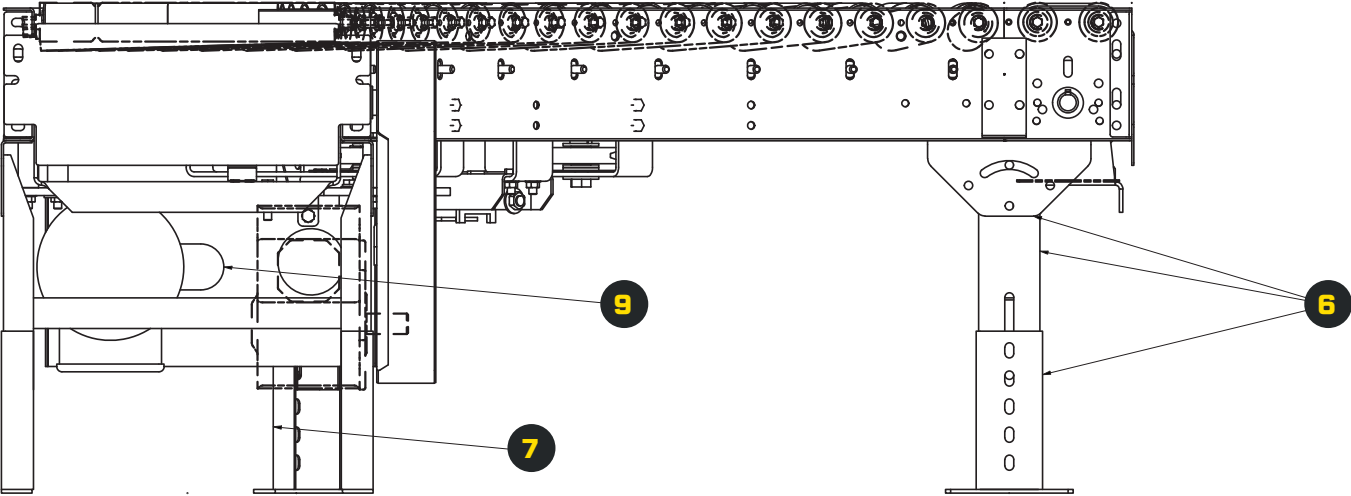
25	HEX HEAD CAP SCREW - 1/2-13 X 3 IN. LG. (OUTSIDE GROOVE)
26	SUSPENSION ANGLE - END ROLLER
27	SUSPENSION ANGLE
28	SHOULDER BOLT - SUSPENSION ANGLE
29	CARRIAGE BOLT - 1/4-20 X 2-3/4 IN. LONG
30	CARRIAGE BOLT - 1/4-20 X 4 IN. LONG
31	FINISHING WASHER - #12
32	ADJUSTMENT NUT - SUSPENSION ANGLE
33	SPRING - ROLLER SUSPENSION
34	SPRING - END ROLLER SUSPENSION
35	RED VINYL PLASTISOL CAP
36	CROSS BRACE ROD - 70 IN. LONG
37	CROSS BRACE ROD - 6 IN. LONG
38	TURNBUCKLE
39	FRAME CHANNEL - RH
40	FRAME CHANNEL - LH
41	BUTT COUPLING
42	1.9 IN. DIA. ROLLER (SPECIFY BR)
43	1.9 IN. DIA. ROLLER - ONE GROOVE (SPECIFY BR)
44	O-RING - 1/8 IN. DIA.
45	END GUARD (SPECIFY OAW)
46	NIP POINT GUARD
47	FLOOR SUPPORT (REF PAGE 49)
48	V-BELT SHIELD
49	SELF-TAPPING HEX SCREW - 1/4 IN. DIA. X 3/4 IN. LONG

6.4 190-LRCT 90° DRAWING

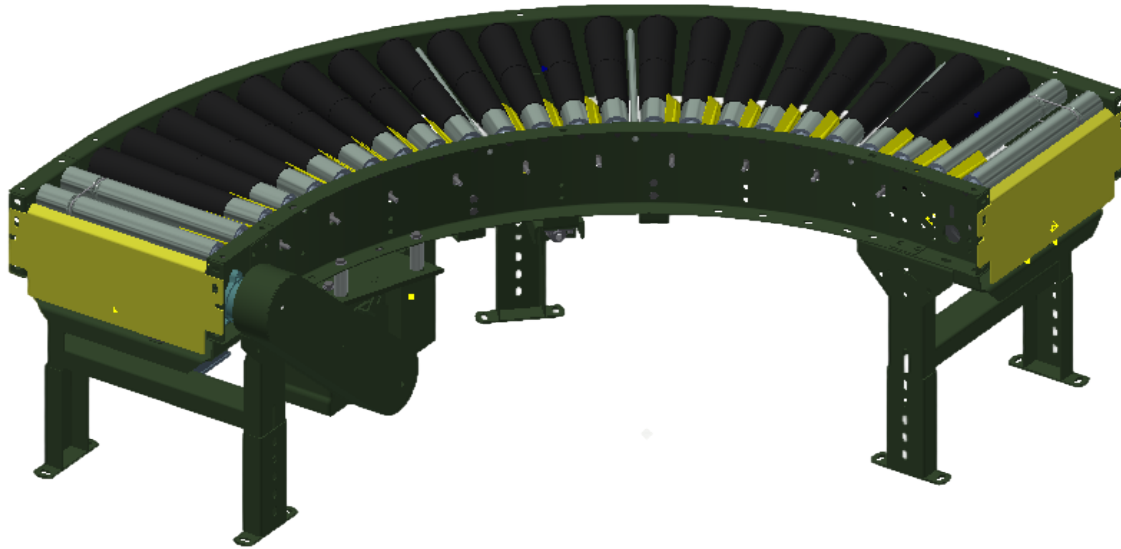
TOP VIEW



END VIEW



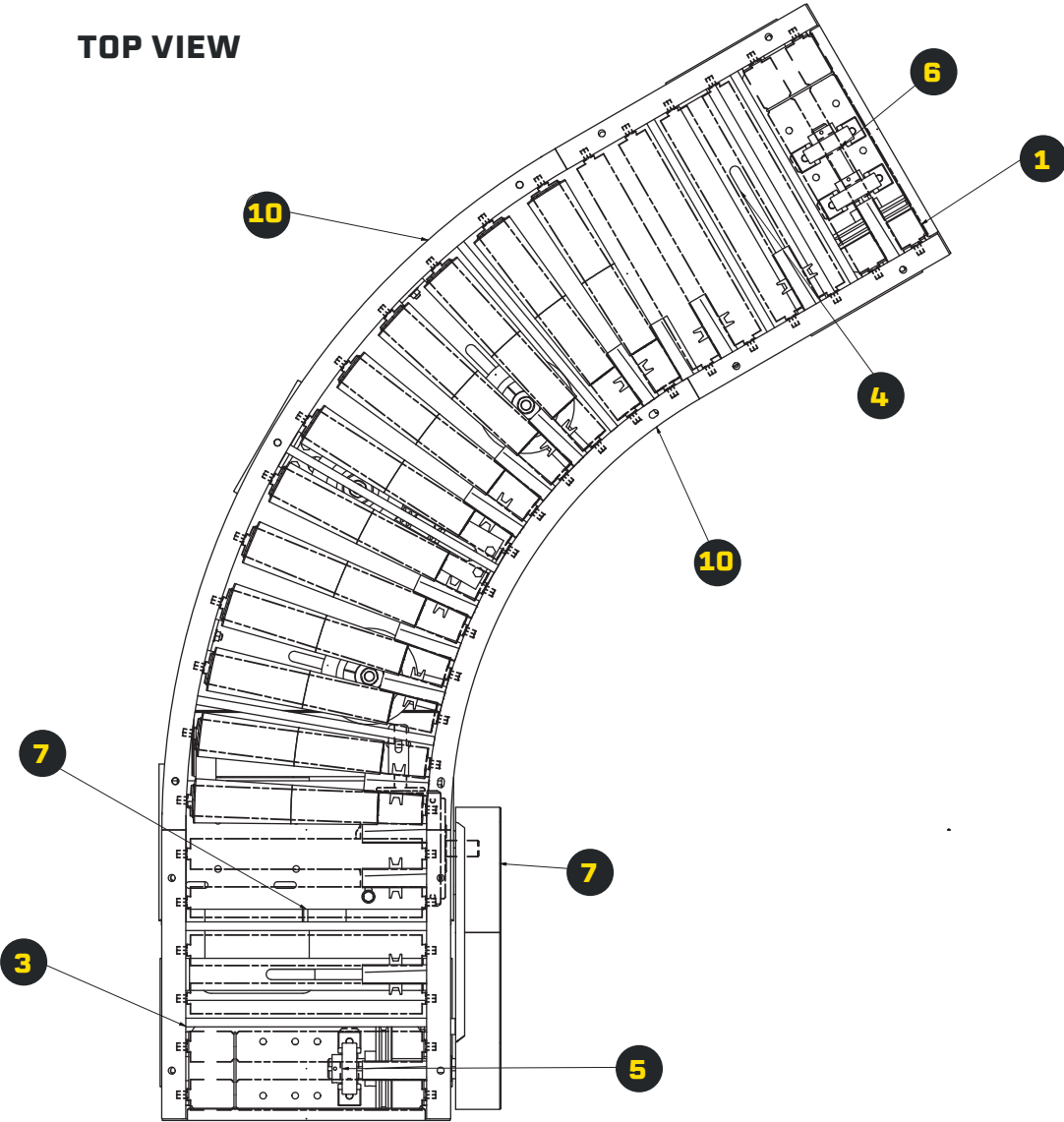
6.5 190-LRCT 90° PARTS LIST



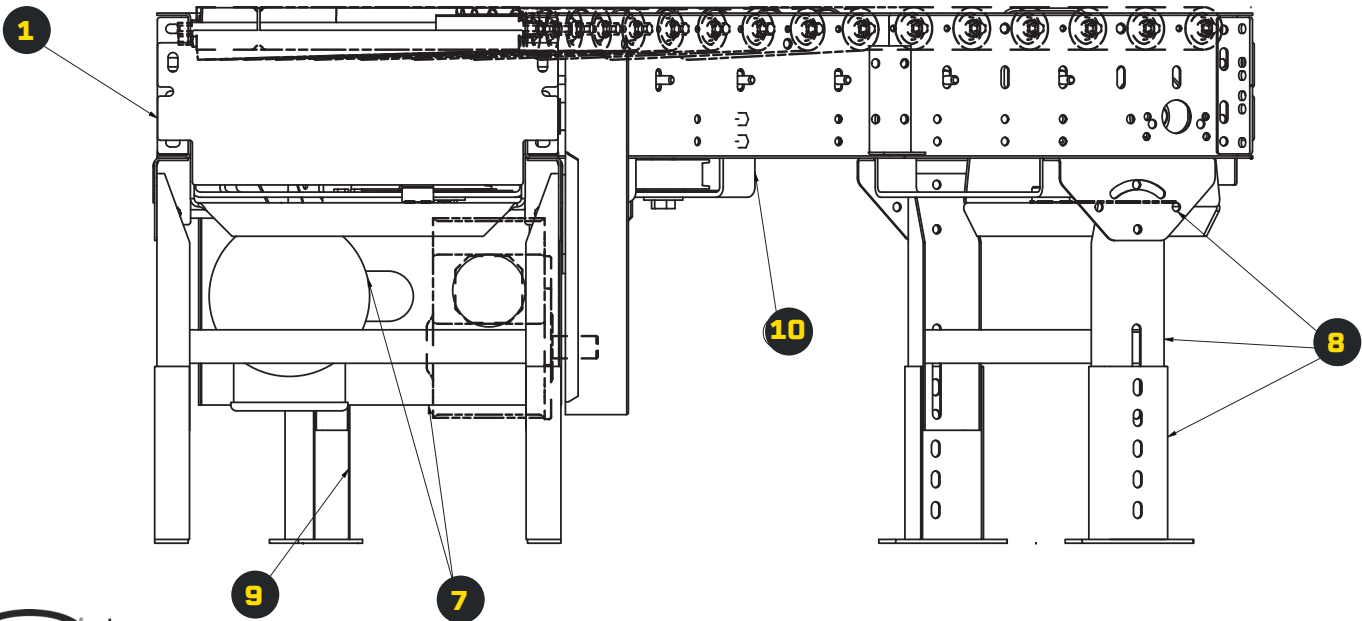
REF #	DESCRIPTION
1	END GUARD - 18"OAW, ACC,ABEZ
2	V-BELT - B-144 POWER CURVE/BARE BACK (NOT PICTURED)
3	6" LG TANGENT (SPECIFY BR) 190LRC
4	6" LG TANGENT (SPECIFY BR) 190LRC
5	SHV RET ASSY 18"W, IDLER
6	SUPT ASSY- 12.63"-15.63"ADJ,18"OAW
7	CTR SUPT LEG - 12.63"-15.63"ADJ
8	SHV RET ASSY 18"W, IDLER/SLAVE
9	UNDERSIDE DRIVE RH, 4A, 18" OAW
10	TTC-90D,(SPECIFY BR),(SPECIFY IR), I/S,AUTO,LRCT

6.6 190-LRCT 60° DRAWING

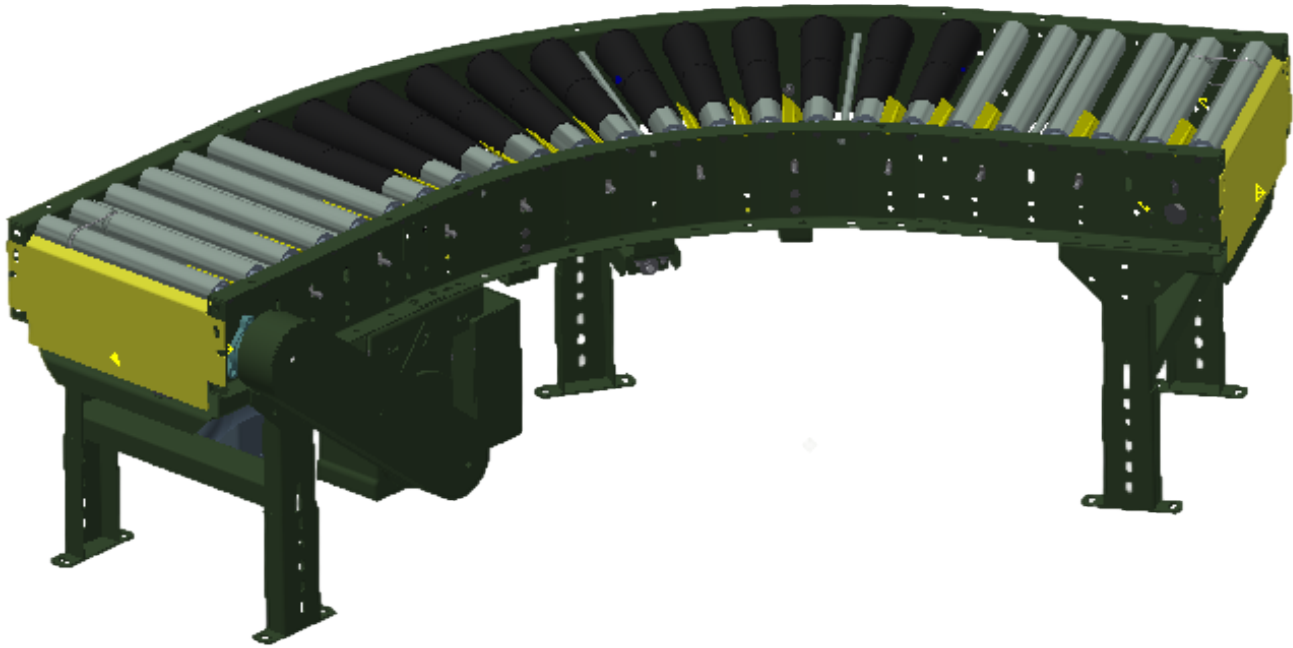
TOP VIEW



END VIEW



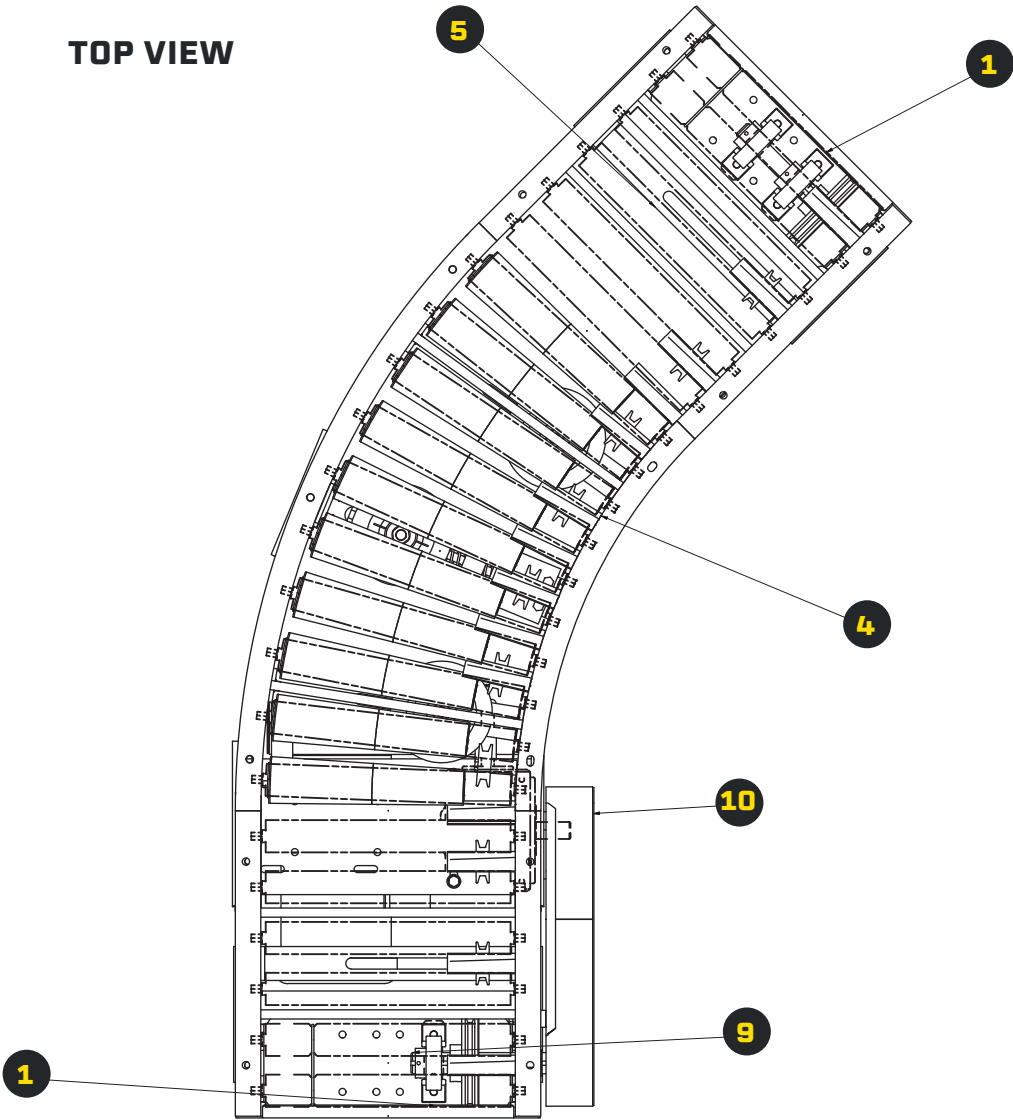
6.7 190-LRCT 60° PARTS LIST



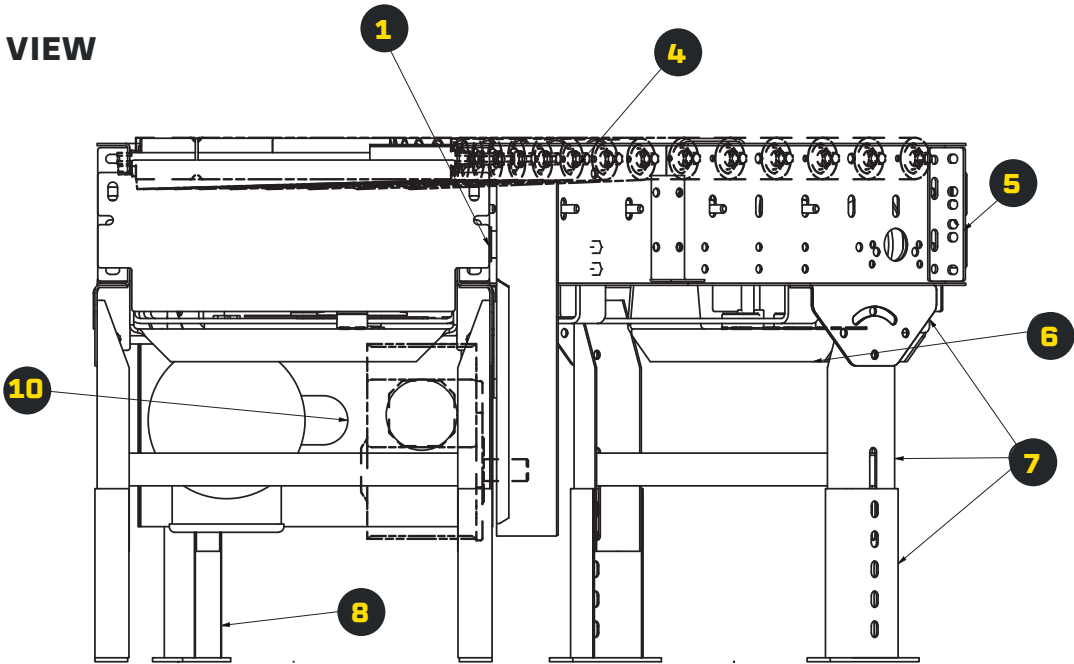
REF #	DESCRIPTION
1	END GUARD - 18"OAW, ACC,ABEZ
2	V-BELT - B-154 POWER CURVE (NOT PICTURED)
3	18" LG TANGENT (SPECIFY BR) 190LRC
4	18" LG TANGENT (SPECIFY BR) 190LRC
5	SHV RET ASSY 18"W, IDLER/SLAVE
6	SHV RET ASSY 18"W, IDLER
7	UNDERSIDE DRIVE RH, 4A, 18" OAW
8	SUPT ASSY- 12.63-15.63"ADJ,18"OAW
9	CTR SUPT LEG - 12.63"-15.63"ADJ
10	TTC-60D,(SPECIFY BR),(SPECIFY IR), I/S,AUTO,LRCT

6.8 190-LRCT 45° DRAWING

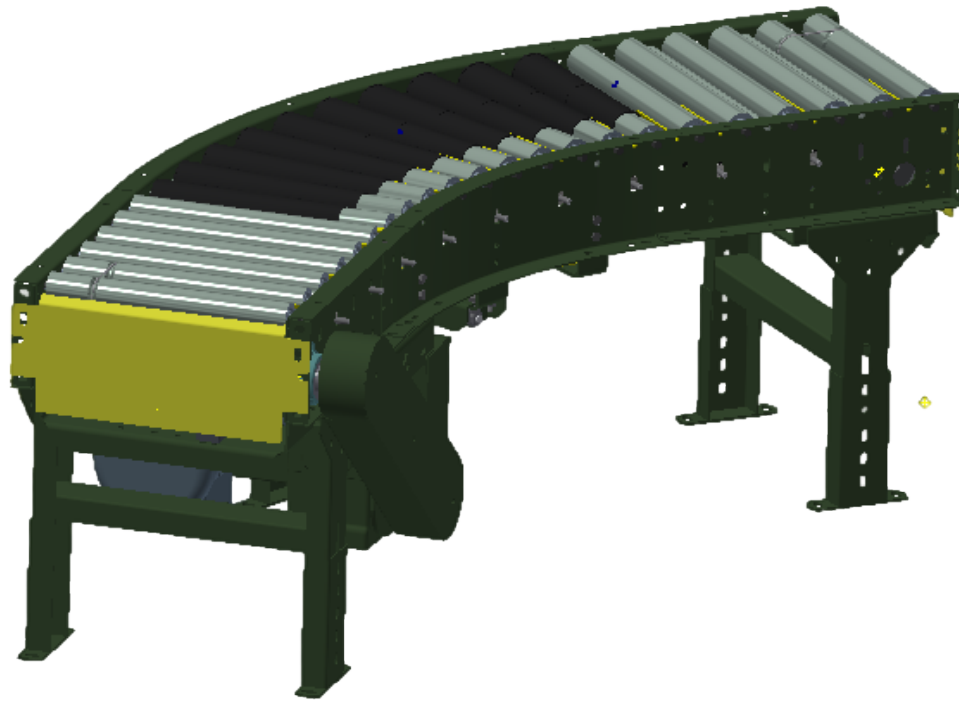
TOP VIEW



END VIEW



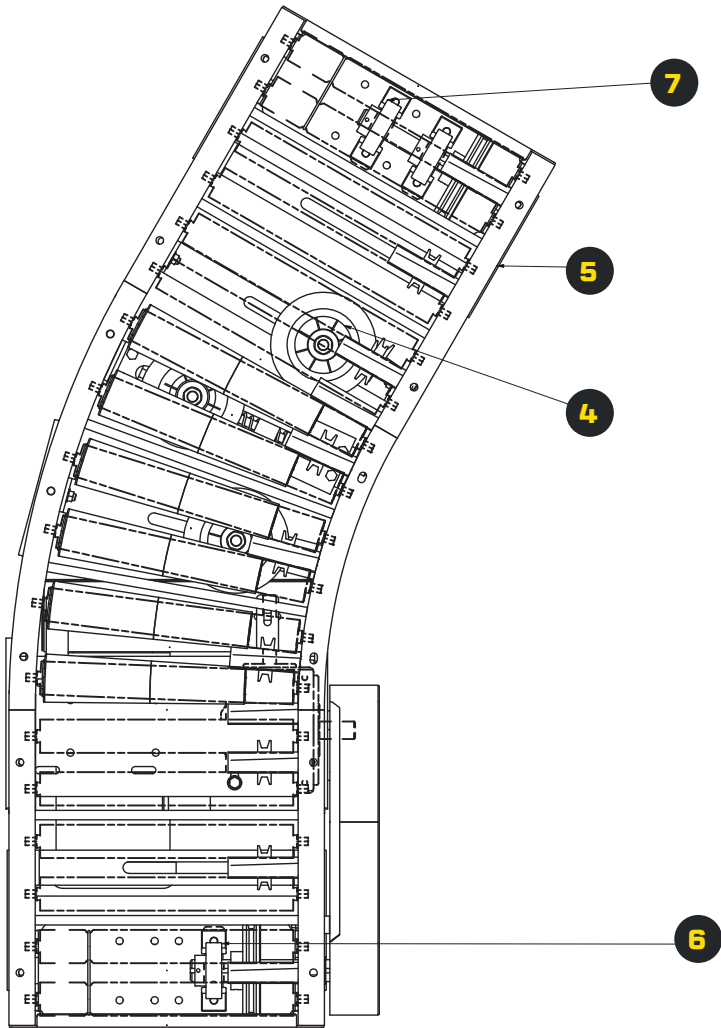
6.9 190-LRCT 45° PARTS LIST



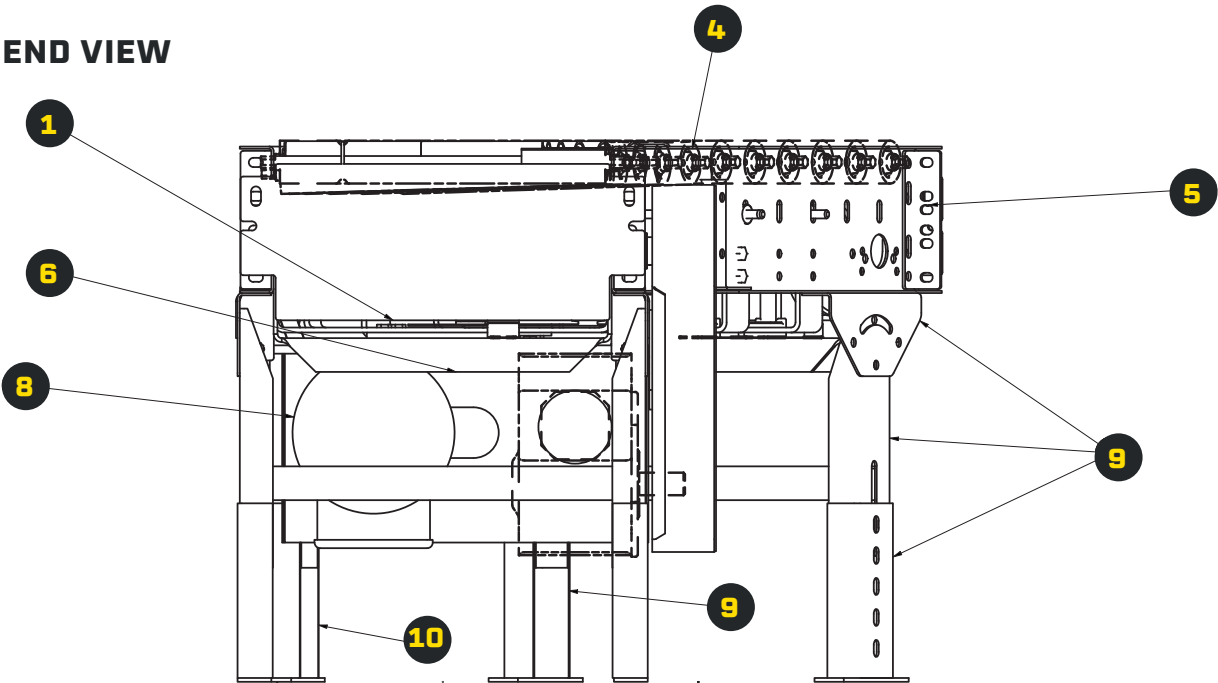
REF #	DESCRIPTION
1	END GUARD - 18"OAW, ACC,ABEZ
2	V-BELT - B-133 POWER CURVE/BARE BACK (NOT PICTURED)
3	18" LG TANGENT 15BR 190LRC
4	TTC-45D,(SPECIFY BR),(SPECIFY IR),I/S,AUTO,LRCT
5	18" LG TANGENT (SPECIFY BR) 190LRC
6	SHV RET ASSY 18"W, IDLER
7	SUPT ASSY- 12.63-15.63"ADJ,18"OAW
8	CTR SUPT LEG - 12.63"-15.63"ADJ
9	SHV RET ASSY 18"W, IDLER/SLAVE
10	UNDERSIDE DRIVE RH, 4A, 18" OAW

6.10 190-LRCT 30° DRAWING

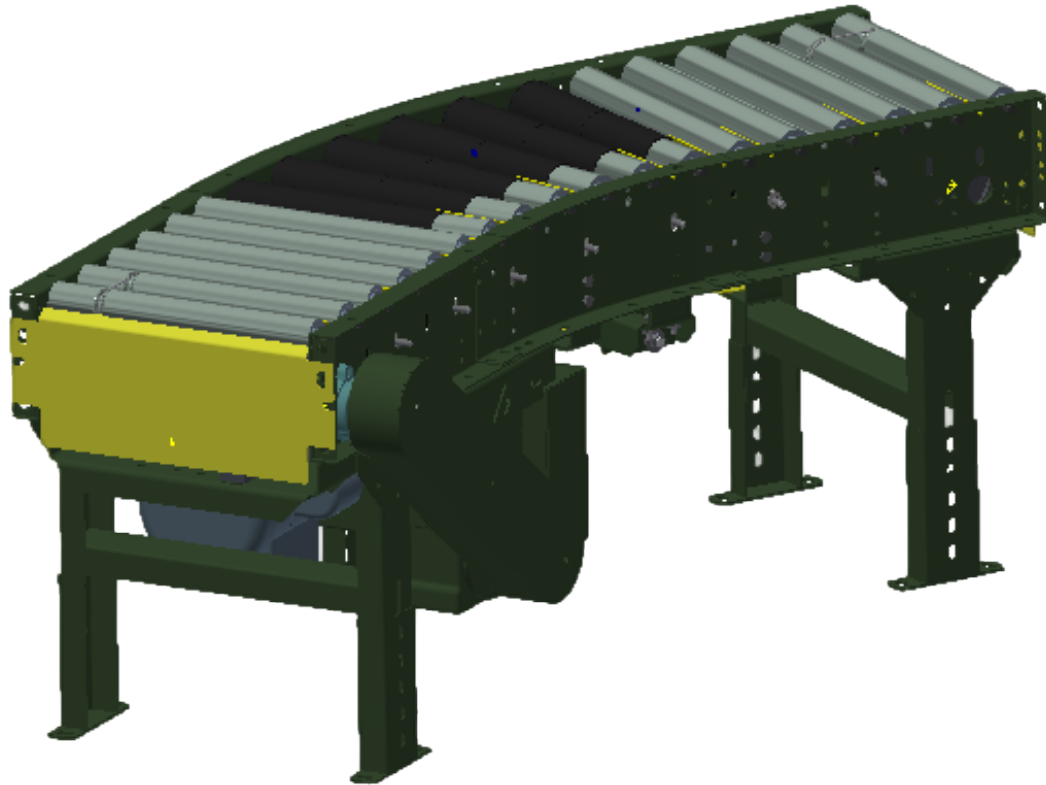
TOP VIEW



END VIEW



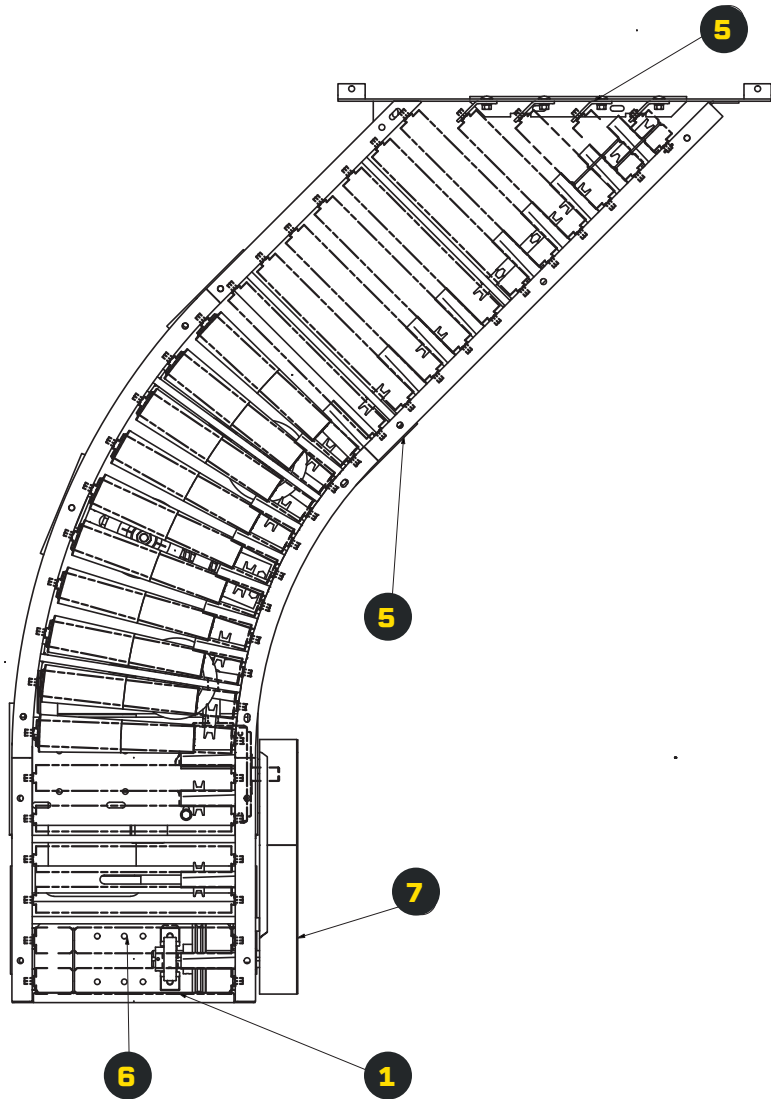
6.11 190-LRCT 30° PARTS LIST



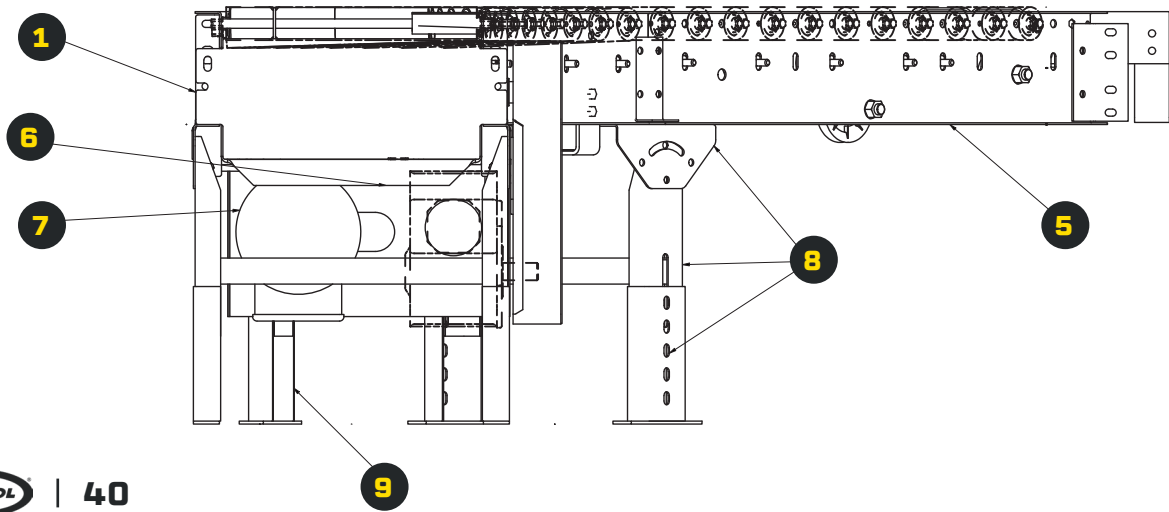
REF #	DESCRIPTION
1	END GUARD - 18"OAW, ACC,ABEZ
2	V-BELT - B-120 POWER CURVE/BARE BACK (NOT PICTURED)
3	18"LG TANGENT (SPECIFY BR) 190LRC
4	TTC-30D,(SPECIFY BR), (SPECIFY IR) I/S,AUTO,LRCT
5	18"LG TANGENT 15BR 190LRC
6	SHV RET ASSY 18"W, IDLER/SLAVE
7	SHV RET ASSY 18"W, IDLER
8	UNDERSIDE DRIVE RH, 4A, 18" OAW
9	SUPT ASSY- 12.63-15.63"ADJ,18"OAW
10	CTR SUPT LEG - 12.63"-15.63"ADJ

6.12 190-LRST 45° DRAWING

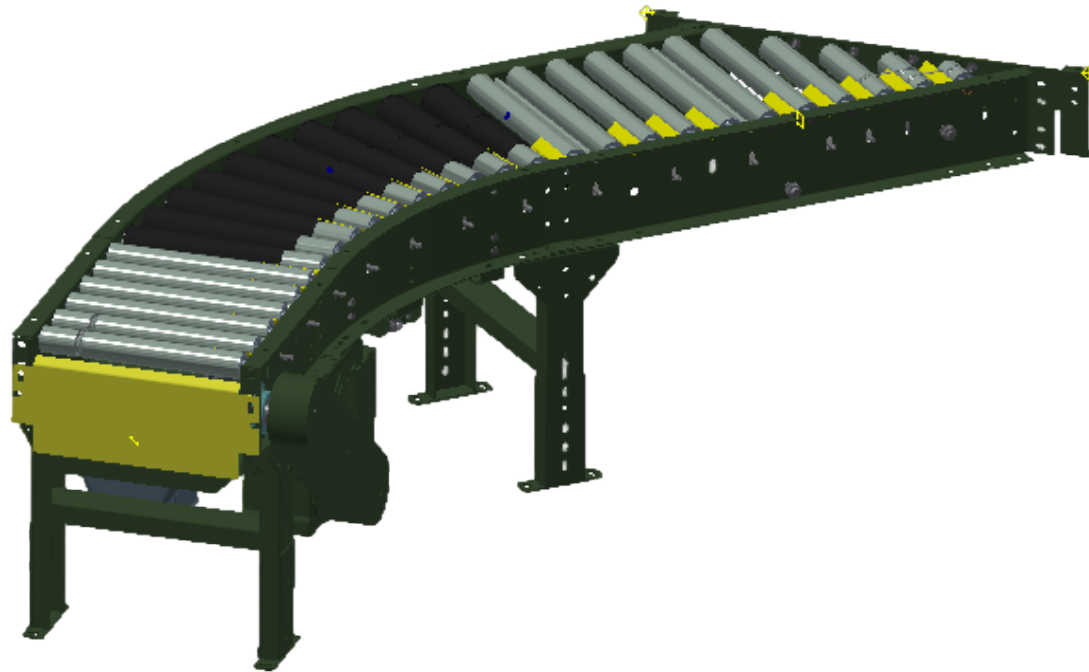
TOP VIEW



END VIEW



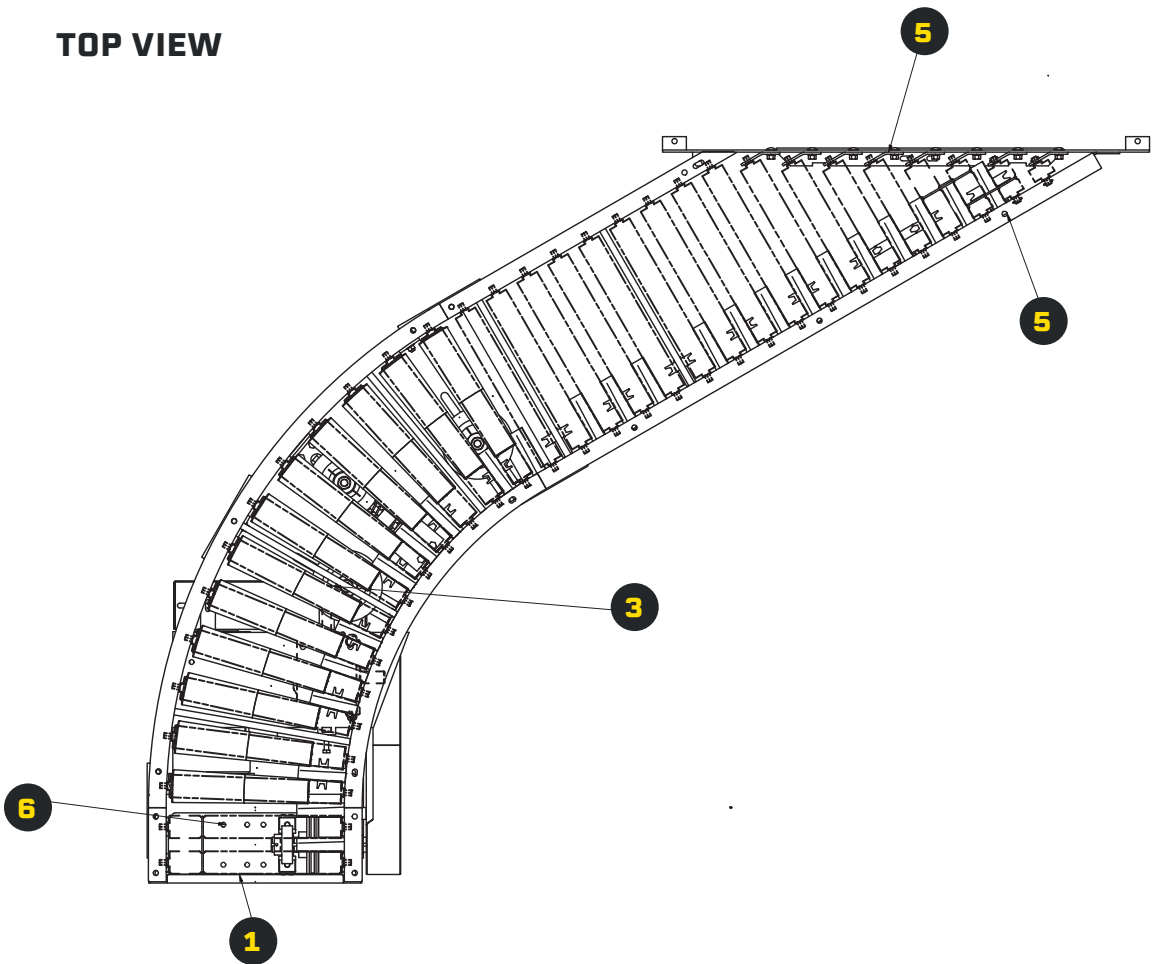
6.13 190-LRST 45° PARTS LIST



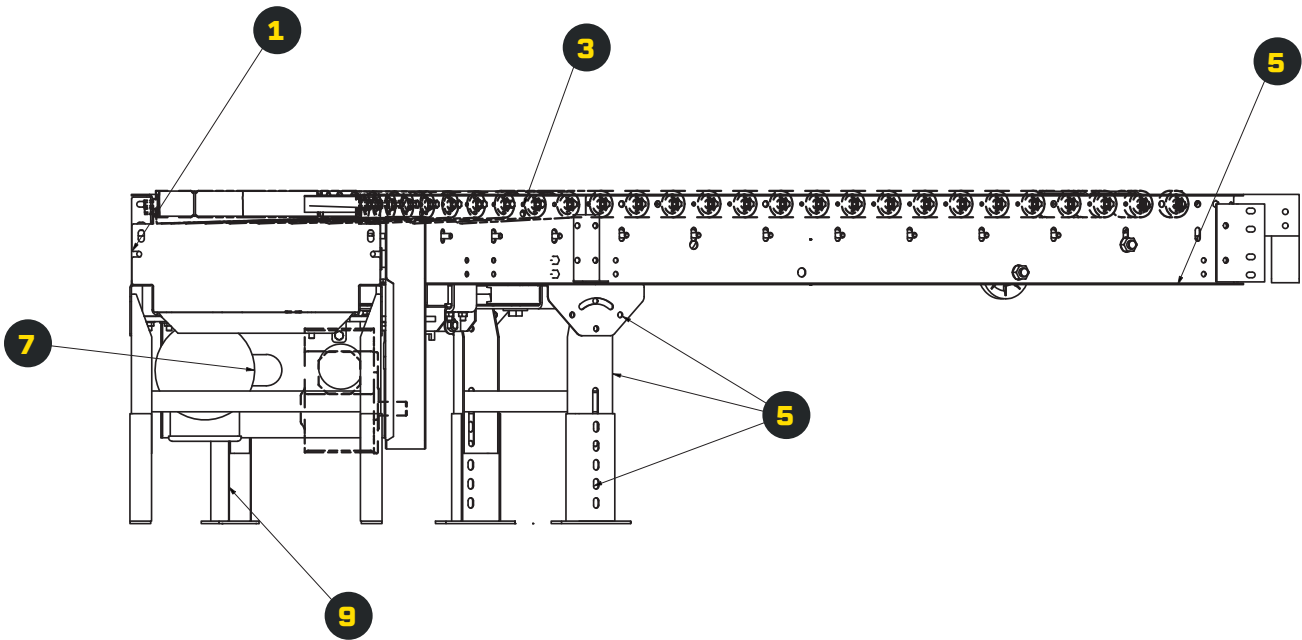
REF #	DESCRIPTION
1	END GUARD - 18"OAW, ACC,ABEZ
2	V-BELT - B-162 POWER CURVE/BARE BACK (NOT PICTURED)
3	TTC-45D,(SPECIFY BR), (SPECIFY IR), I/S,AUTO,LRST
4	18" LG TANGENT (SPECIFY BR) 190LRC
5	3'0"LG SPUR -RH,(SPECIFY BR),3"RC,A-BEC,45D
6	SHV RET ASSY 18"W, IDLER/SLAVE
7	UNDERSIDE DRIVE RH, 4A, 18" OAW
8	SUPT ASSY- 12.63-15.63"ADJ,18"OAW
9	CTR SUPT LEG - 12.63"-15.63"ADJ

6.14 190-LRST 30° DRAWING

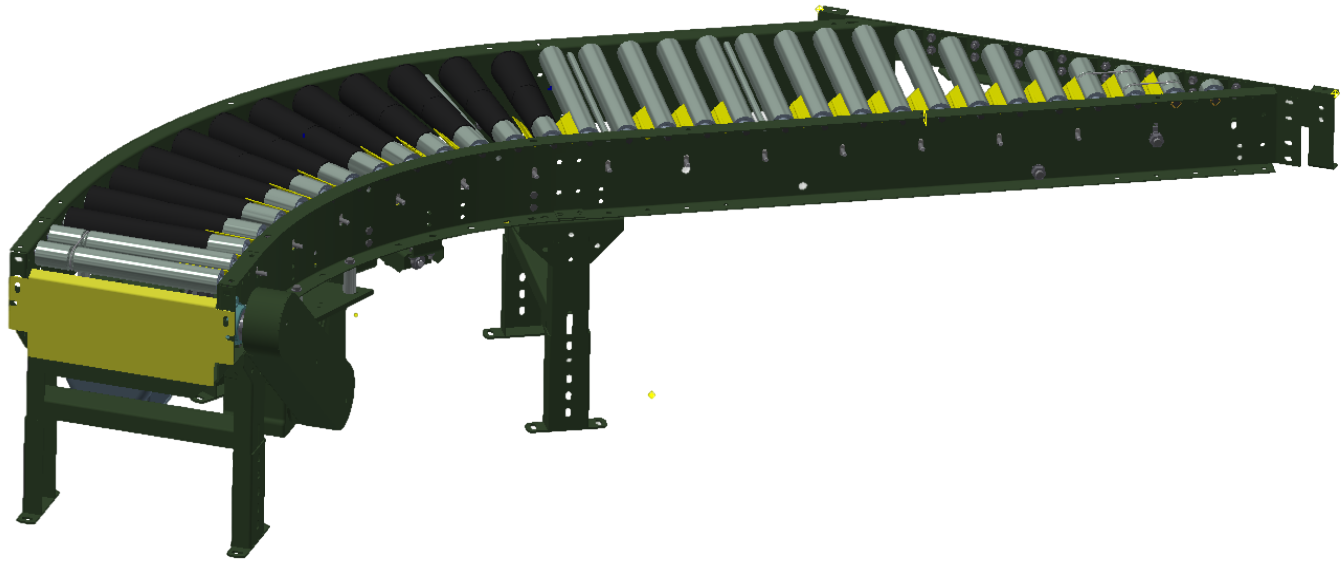
TOP VIEW



END VIEW

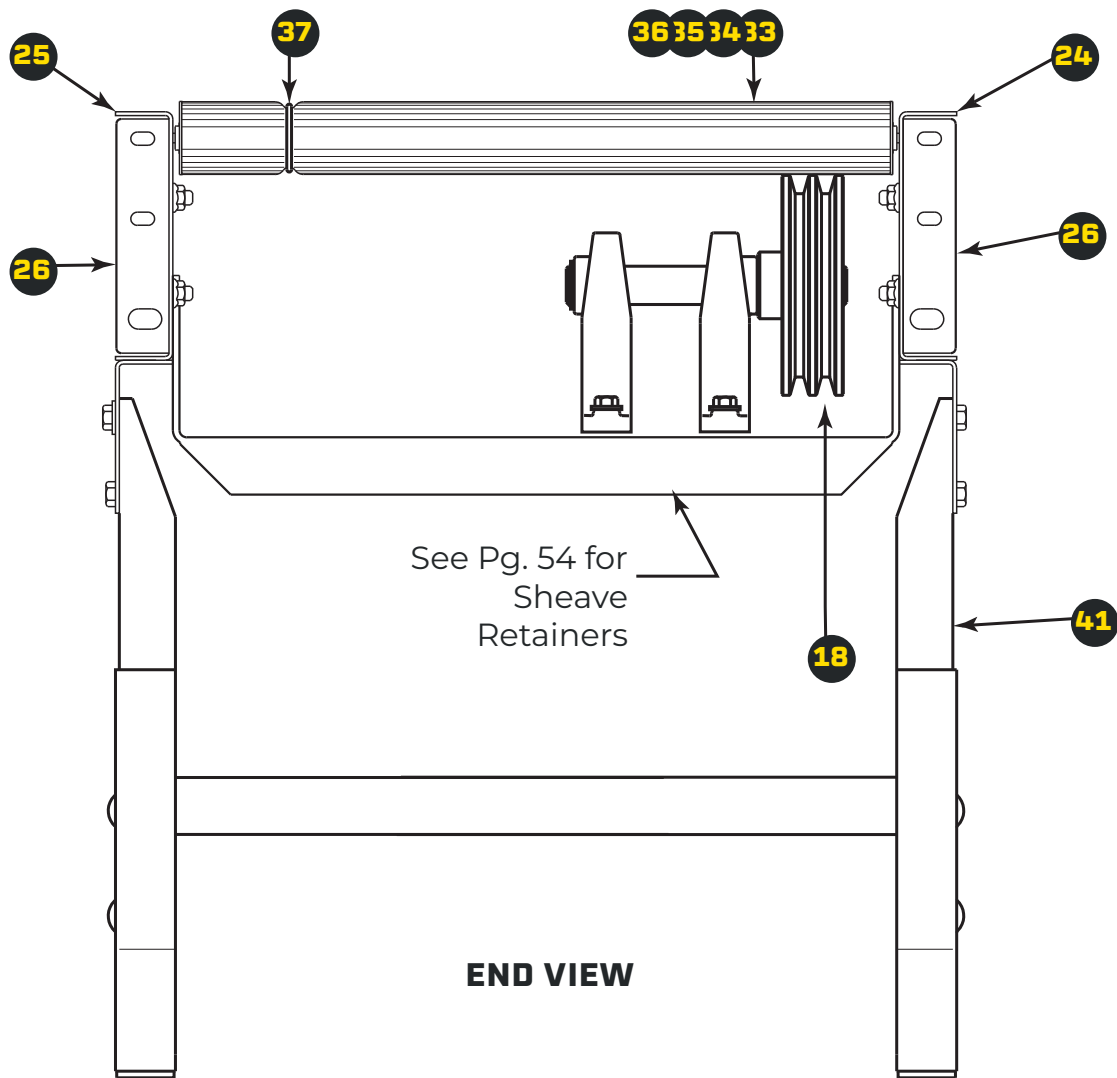
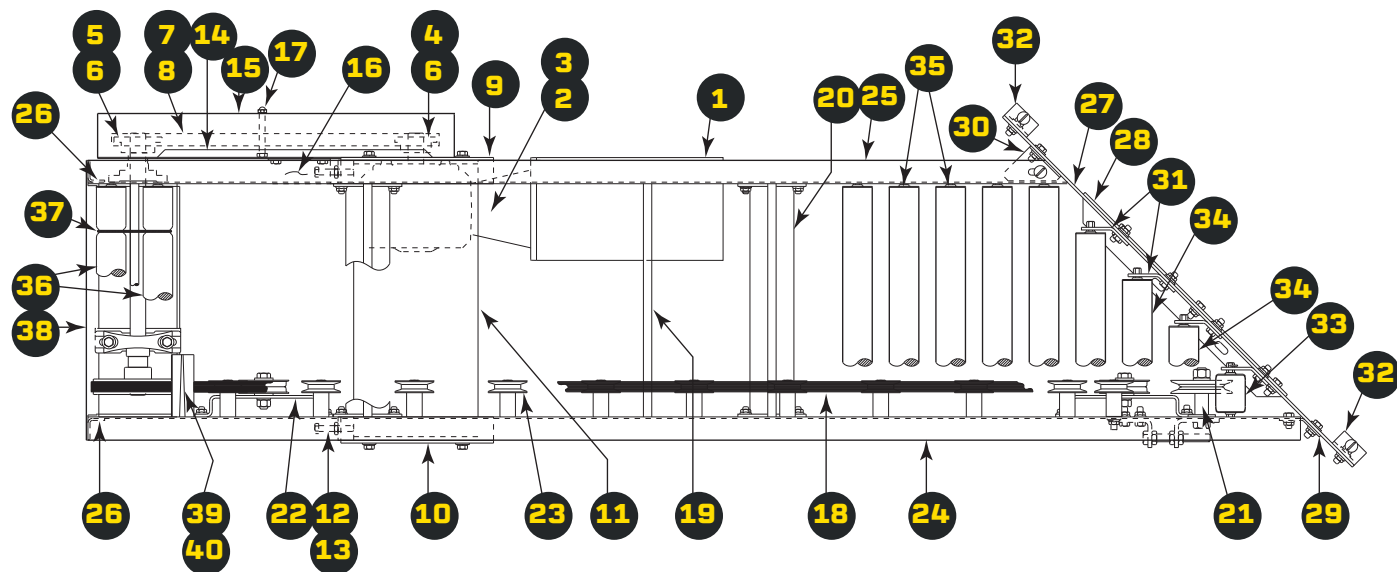


6.15 190-LRST 30° PARTS LIST

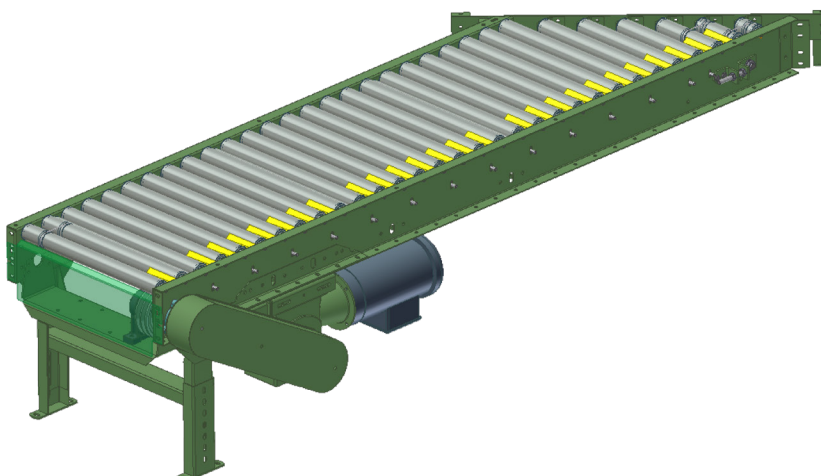


REF #	DESCRIPTION
1	END GUARD - 18"OAW, ACC,ABEZ
2	V-BELT - B-190 POWER CURVE/BARE BACK (NOT PICTURED)
3	TTC-RH,60D,(SPECIFY BR), (SPECIFY IR), I/S,AUTO,LRST
4	6" LG TANGENT (SPECIFY BR) 190LRC
5	4'6" LG SPUR -RH,(SPECIFY BR), 3"RC,A-BEC,30D
6	SHV RET ASSY 18"W, IDLER/SLAVE
7	UNDERSIDE DRIVE RH, 4A, 18" OAW
8	SUPT ASSY- 12.63-15.63"ADJ,18"OAW
9	CTR SUPT LEG - 12.63"-15.63"ADJ

6.16 190-LRSS 45° DRAWING



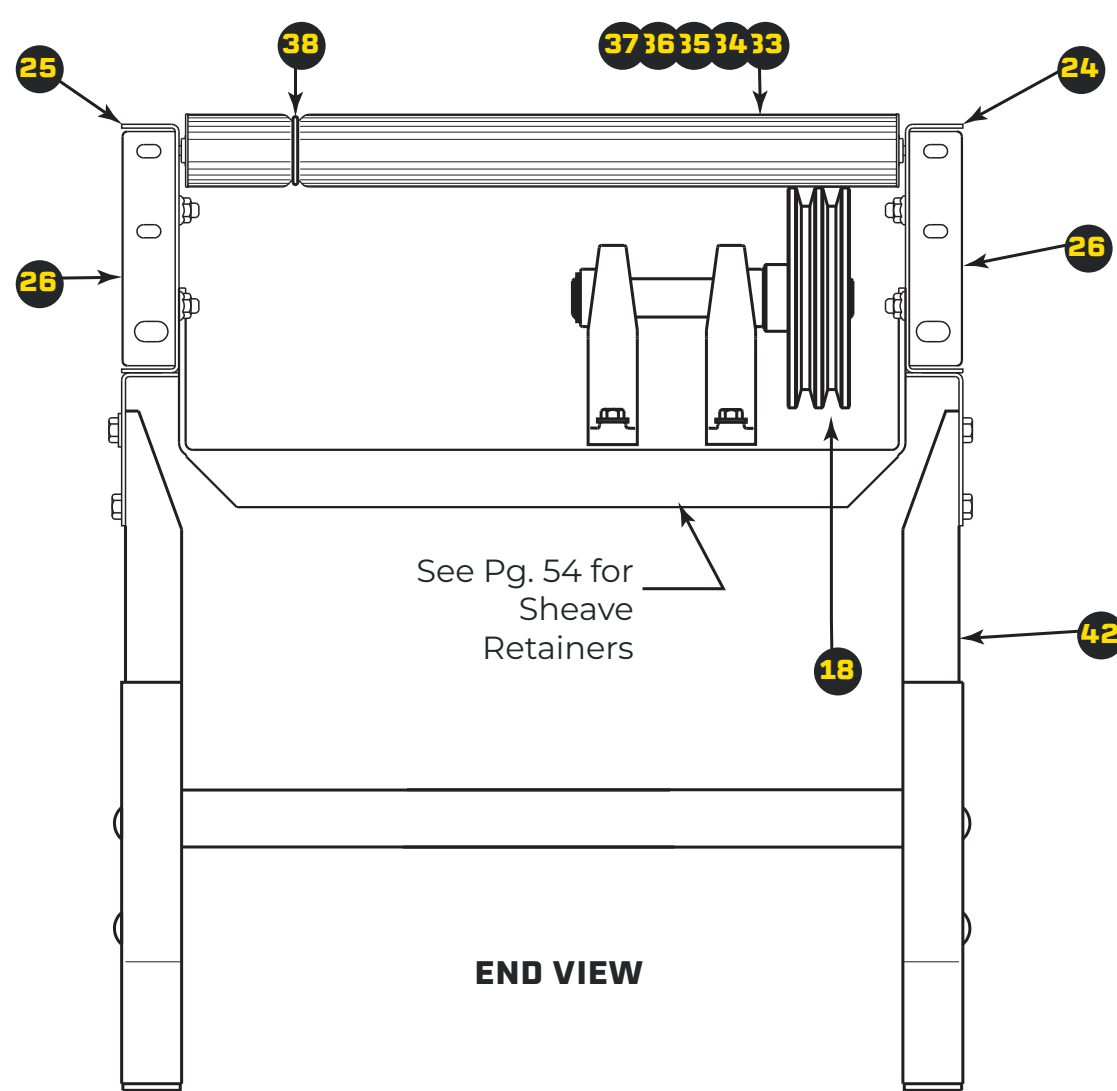
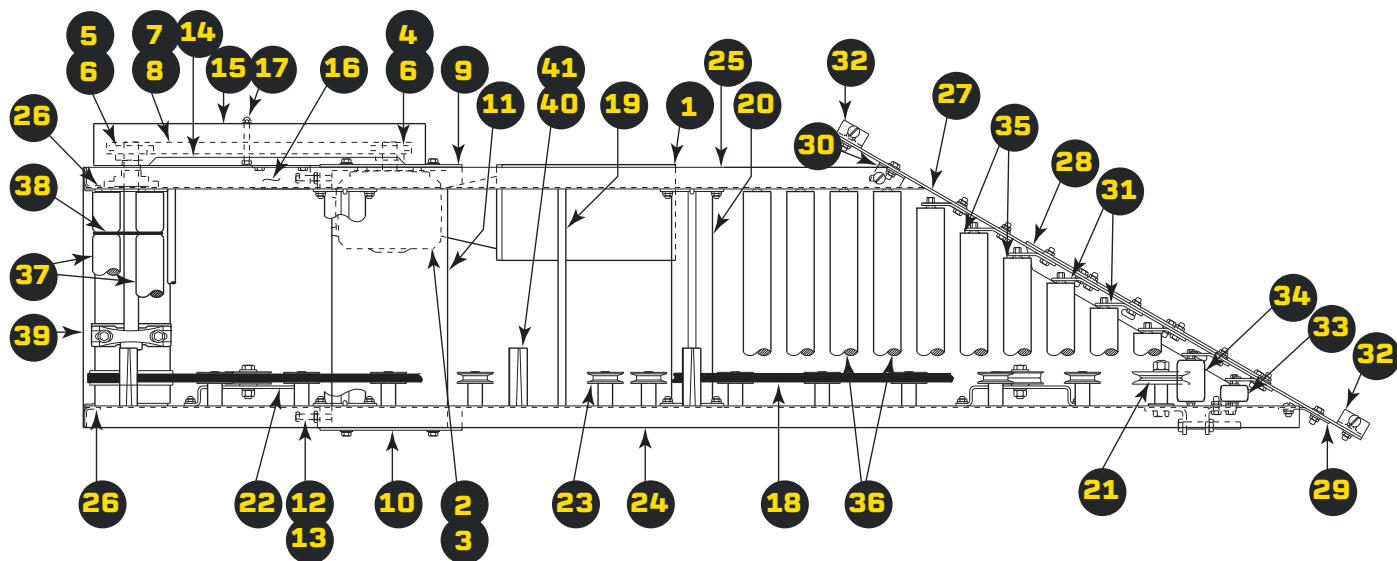
6.17 190-LRSS 45° PARTS LIST



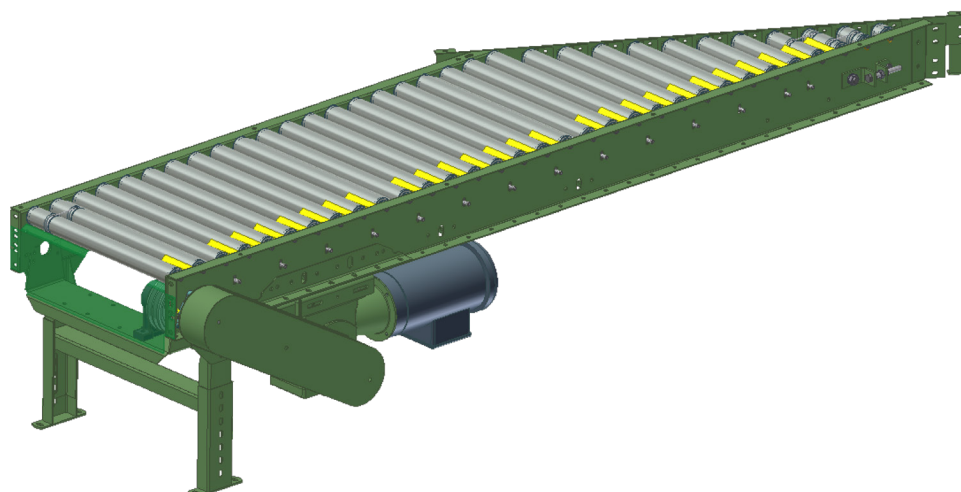
REF #	DESCRIPTION
1	MOTOR - C-FACE
2	SPEED REDUCER
3	COUPLING KIT - MOTOR TO REDUCER - 1/2-1HP
4	SPROCKET - REDUCER
5	SPROCKET - DRIVE SHAFT, 50B13 X 1-1/4 IN. BORE
6	SHAFT KEY - 1/4 IN. SQUARE X 1 IN LONG
7	#50 RIVETED ROLLER CHAIN
8	#50 CONNECTOR LINK
9	MOTOR BASE SUPPORT ANGLE - LH
10	MOTOR BASE SUPPORT ANGLE - RH
11	MOTOR BASE ASSEMBLY (SPECIFY OAW)
12	TAKE-UP BOLT - 3/8-16 X 2-1/4 IN. LONG
13	HEX JAM NUT - HEAVY - 3/8-16
14	CHAIN GUARD BACK PLATE
15	CHAIN GUARD FRONT PLATE
16	CHAIN GUARD MOUNTING ANGLE
17	ACORN NUT—3/8-16
18	DRIVE V-BELT
19	THREADED SECTION SPACER (SPECIFY BR)
20	BED SPACER (SPECIFY BR)
21	TAKE-UP SHEAVE ASSEMBLY
22	SNUB IDLER ASSEMBLY

23	2.5 IN. OD SNUB IDLER ASSEMBLY
24	LONG STRAIGHT CHANNEL
25	SHORT STRAIGHT CHANNEL
26	BUTT COUPLING
27	SPUR PLATE (SPECIFY BR)
28	SPUR PLATE STIFFENER (SPECIFY BR)
29	COUPLING - LONG SPUR CHANNEL
30	COUPLING - SHORT SPUR CHANNEL
31	SPUR ROLLER BRACKET
32	K-BRACKET - 6-1/2 IN. CHANNEL
33	1.9 IN. DIA. ROLLER - 3 IN. BETWEEN BRACKETS
34	1.9 IN. DIA. SPUR ROLLER (SPECIFY BETWEEN BRACKETS)
35	1.9 IN. DIA. ROLLER (SPECIFY BR)
36	1.9 IN. DIA. ROLLER - ONE GROOVE (SPECIFY BR)
37	O-RING - 1/8 IN. DIA.
38	END GUARD (SPECIFY OAW)
39	V-BELT SHIELD
40	SELF-TAPPING HEX SCREW - 1/4 IN. DIA. X 3/4 IN. LONG
41	FLOOR SUPPORT (REF PAGE 49)

6.18 190-LRSS 30° DRAWING



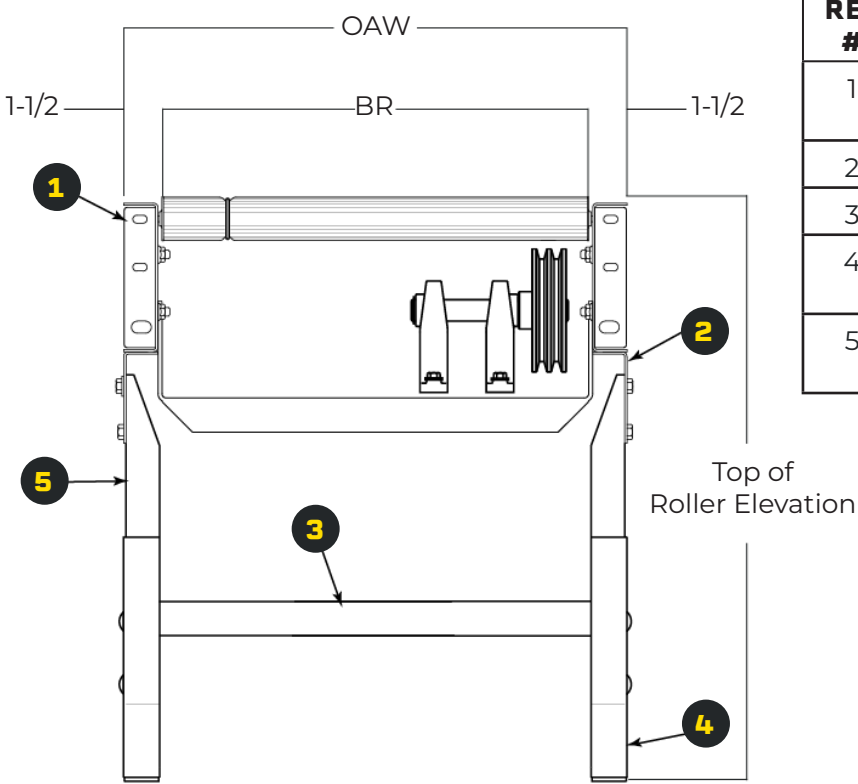
6.19 190-LRSS 30° PARTS LIST



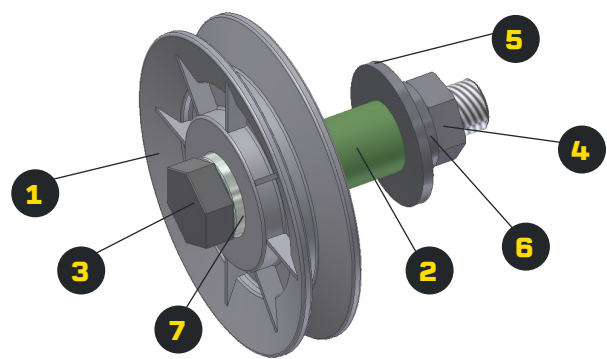
REF #	DESCRIPTION
1	MOTOR - C-FACE
2	SPEED REDUCER
3	COUPLING KIT - MOTOR TO REDUCER - 1/2-1HP
4	SPROCKET - REDUCER
5	SPROCKET - DRIVE SHAFT, 50B13 X 1-1/4 IN. BORE
6	SHAFT KEY - 1/4 IN. SQUARE X 1 IN LONG
7	#50 RIVETED ROLLER CHAIN
8	#50 CONNECTOR LINK
9	MOTOR BASE SUPPORT ANGLE - LH
10	MOTOR BASE SUPPORT ANGLE - RH
11	MOTOR BASE ASSEMBLY (SPECIFY OAW)
12	TAKE-UP BOLT - 3/8-16 X 2-1/4 IN. LONG
13	HEX JAM NUT - HEAVY - 3/8-16
14	CHAIN GUARD BACK PLATE
15	CHAIN GUARD FRONT PLATE
16	CHAIN GUARD MOUNTING ANGLE
17	ACORN NUT—3/8-16
18	DRIVE V-BELT
19	THREADED SECTION SPACER (SPECIFY BR)
20	BED SPACER (SPECIFY BR)
21	TAKE-UP SHEAVE ASSEMBLY
22	SNUB IDLER ASSEMBLY

23	2.5 IN. OD SNUB IDLER ASSEMBLY
24	LONG STRAIGHT CHANNEL
25	SHORT STRAIGHT CHANNEL
26	BUTT COUPLING
27	SPUR PLATE (SPECIFY BR)
28	SPUR PLATE STIFFENER (SPECIFY BR)
29	COUPLING - LONG SPUR CHANNEL
30	COUPLING - SHORT SPUR CHANNEL
31	SPUR ROLLER BRACKET
32	K-BRACKET - 6-1/2 IN. CHANNEL
33	1.9 IN. DIA. ROLLER - 1-5/8 IN. BETWEEN BRACKETS
34	1.9 IN. DIA. ROLLER - 3-3/8 IN. BETWEEN BRACKETS
35	1.9 IN. DIA. SPUR ROLLER (SPECIFY BETWEEN BRACKETS)
36	1.9 IN. DIA. ROLLER (SPECIFY BR)
37	1.9 IN. DIA. ROLLER - ONE GROOVE (SPECIFY BR)
38	O-RING - 1/8 IN. DIA.
39	END GUARD (SPECIFY OAW)
40	V-BELT SHIELD
41	SELF-TAPPING HEX SCREW - 1/4 IN. DIA. X 3/4 IN. LONG
42	FLOOR SUPPORT (REF PAGE 49)

6.20 SUB-ASSEMBLIES DRAWINGS & PARTS LISTS



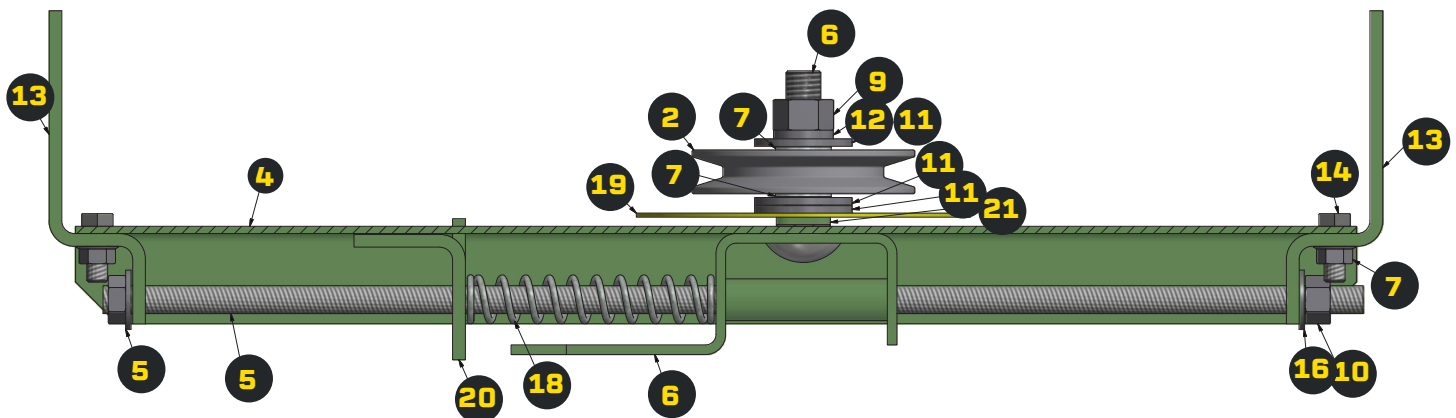
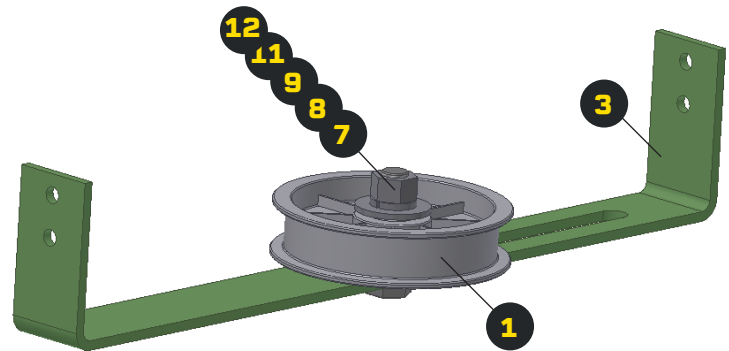
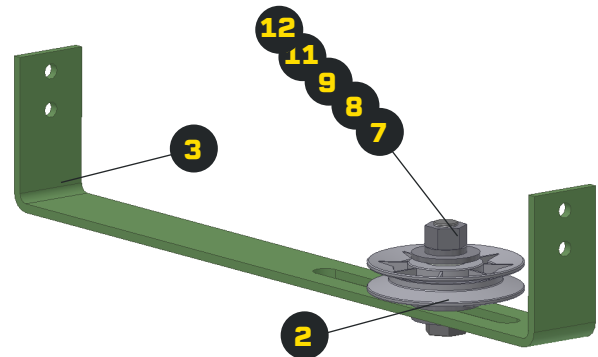
REF #	DESCRIPTION
1	CONVEYOR SECTION (SPECIFY)
2	MS TYPE PIVOT PLATE - 1-1/2 IN. FLANGE
3	FLOOR SUPPORT FRAME
4	ADJUSTABLE FOOT ASSEMBLY (SPECIFY LENGTH)
5	MS TYPE SINGLE CENTER LEG (SPECIFY ELEVATION)



REF #	DESCRIPTION
1	SHEAVE V-IDLER, 3.8125 IN. OD X 5/8 IN.BORE
2	.635 IN. ID X 7/8 IN. OD X 1-3/8 IN. LG. SPACER
3	5/8-11 X 3-1/2 IN. LG. HEX BOLT
4	5/8-11 NC2B HEX NUT
5	5/8 IN. ID FLAT STEEL WASHER
6	5/8 IN. ID SPLIT LOCKWASHER
7	.687 IN. ID X 1 IN. OD X .25 IN. LG. SPACER

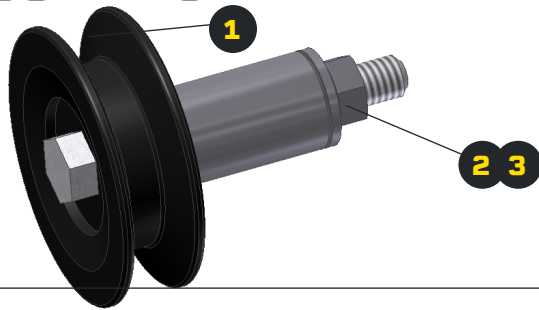
6.21 SUB-ASSEMBLIES DRAWINGS & PARTS LIST CONTINUED

REF #	DESCRIPTION
1	FLAT IDLER SHEAVE
2	SHEAVE V-IDLER, 4 IN. OD X 5/8 IN. BORE
3	FIXED IDLER SHEAVE BRACKET (SPECIFY BR)
4	TAKE-UP CROSS BRACKET (SPECIFY BR)
5	AUTO TENSION ROD WELD (SPECIFY BR)
6	ANGLE CLIP WELD - SHEAVE TAKE-UP
7	.687 IN. ID X 1 IN. OD X .25 IN. LG. SPACER
8	5/8-11 X 2-3/4 IN. LG. HEX BOLT
9	5/8-11 NC2B HEX NUT
10	1/2-13 NC2B HEX JAM NUT
11	5/8 IN. ID FLAT STEEL WASHER
12	5/8 IN. ID SPLIT LOCKWASHER
13	END BRACKET
14	3/8-16 X 1" LG. HEX HEAD CAP SCREW, ZP
15	1/2-13 NC2B HEX 2-WAY LOCKNUT - REG, ZP
16	1/2" ID FLAT STEEL WASHER, TYPE A, ZP
17	3/8-16 SMALL FLANGE LOCKNUT, ZP
18	SPRING - COMPRESSION, LRCT TAKE-UP
19	SHEAVE GUARD - 6" DIA
20	AUTO TENSION SPRING BRACKET - LRCT
21	SPACER - AUTO TENSIONER

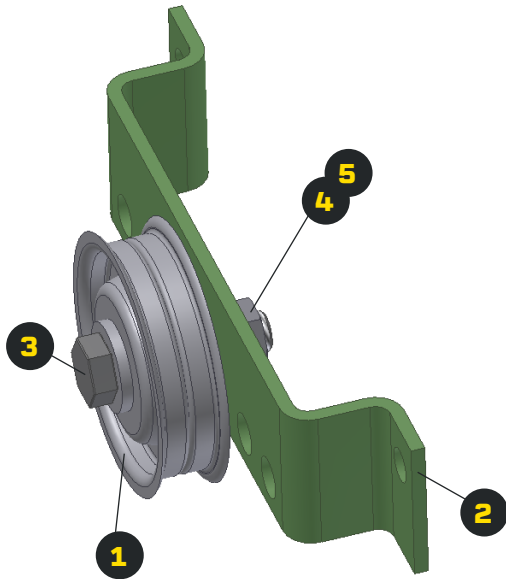


6.22 SUB-ASSEMBLIES DRAWINGS & PARTS LIST

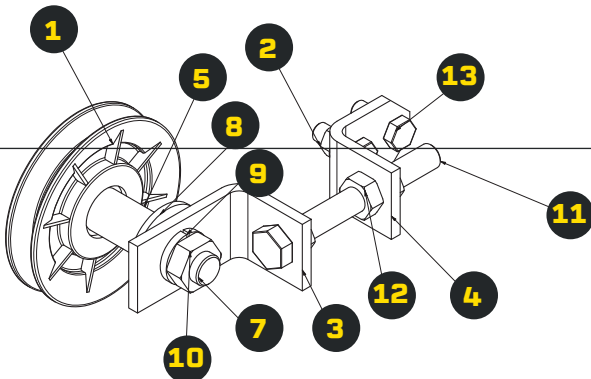
CONTINUED



REF #	DESCRIPTION
1	V-IDLER SHEAVE, 2.50 IN. OD X 3/8 IN. BORE
2	3/8-16 SMALL FLANGE LOCKNUT
3	5/16 IN. ID FLAT WASHER

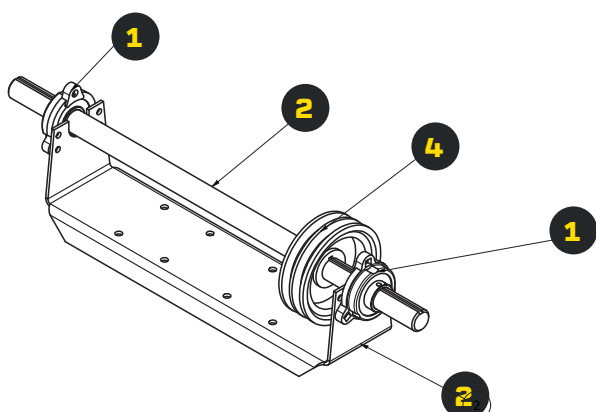


REF #	DESCRIPTION
1	SNUB RETURN IDLER BRACKET - 190ACC
2	SHEAVE - FLAT IDLER, 3.25"OD X 1/2"BORE
3	3/8-16 X 3/4"LG HEX HEAD CAP SCREW, ZP
4	1/2-13 X 1-3/4"LG HEX HEAD CAP SCREW, ZP
5	1/2-13 NC2B HEX NUT - SEMI-FIN, REG, ZP
6	1/2"ID SPLIT LOCKWASHER, MEDIUM, ZP
7	3/8-16 SMALL FLANGE LOCKNUT, ZP

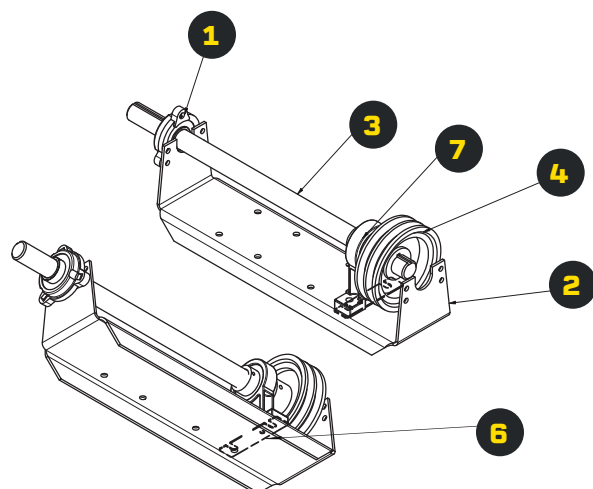


REF #	DESCRIPTION
1	ANGLE BRACKET (SHEAVE)
2	ANGLE BRACKET - LRSS
3	SPACER - .635"ID X 7/8"OD X 1-19/32"LG
4	SHEAVE - V-IDLER, 3.8125"OD X 5/8"BORE
5	3/8-16 X 1"LG HEX HEAD CAP SCREW, ZP
6	1/2-13 X 4"LG HEX BOLT - FULL THREAD, ZP [NOT PICTURED]
7	5/8-11 X 3-1/2"LG HEX HEAD CAP SCREW, ZP
8	1/2-13 NC2B HEX JAM NUT -SEMI-FIN,REG,ZP
9	5/8-11 NC2B HEX JAM NUT -SEMI-FIN,REG,ZP
10	5/8"ID FLAT STEEL WASHER, ZP
11	5/8"ID SPLIT LOCKWASHER, ZP
12	3/8-16 SMALL FLANGE LOCKNUT, ZP
13	SPACER - .687"ID X 1"OD X .250"LG

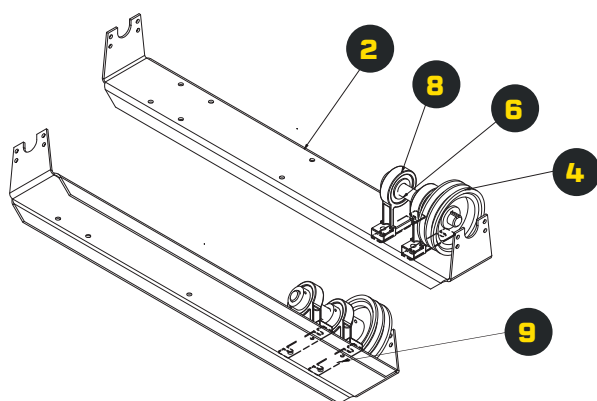
6.23 SHEAVE RETAINERS DRAWINGS & PARTS LIST



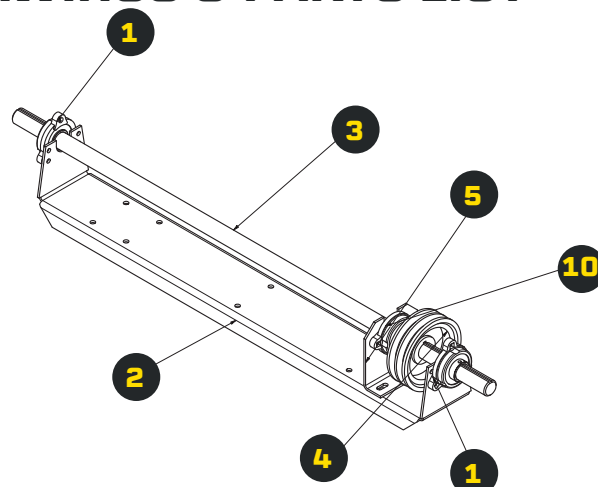
13" - 27" BR Drive with Slave



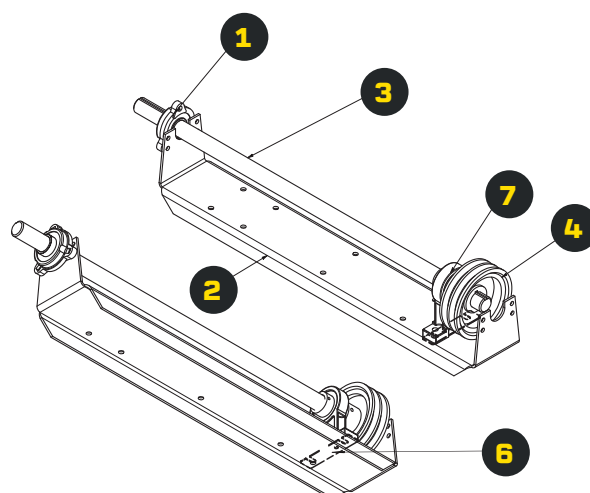
13" - 27" BR Drive End



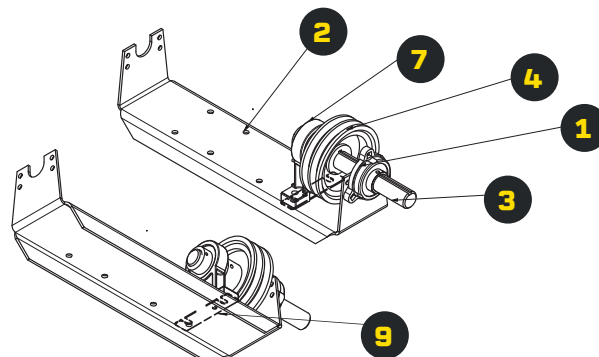
13" - 39" BR Idler End



31 - 39" BR Drive with Slave



31" - 39" BR Drive End



31" - 39" BR Idler End with Slave

REF #	DESCRIPTION
1	BEARING - DUCTILE IRON, 3-BOLT, 1-1/4" BORE
2	SHEAVE RETAINER BRKT (SPECIFY BR), 190ACC
3	DRIVE WITH SLAVE SHAFT- (SPECIFY BR)
4	SHEAVE - 2B, 5.75" OD X 1-1/4" B, 5.6" PD
5	FLANGE BRG BRKT - 5-1/4" X 5-3/8"

6	IDLER SHAFT - 138ACC, LRC, LRS, LRSS
7	BEARING - CAST IRON PILLOW BLOCK, 1-1/4" BORE
8	BEARING - CAST IRON PILLOW BLOCK, 1" BORE
9	SHIM - PILLOW BLOCK STAMPING, 14GA
10	BEARING - DUCTILE IRON, 2-BOLT, 1-1/4" BORE

7 TROUBLESHOOTING

7.1 TROUBLESHOOTING GUIDE

TROUBLE	CAUSE	SOLUTION
Conveyor will not start or motor quits frequently.	1. Motor is overloaded. 2. Motor is drawing too much current.	1. Checking for overloading of conveyor. 2. Check heater or circuit breaker and change if necessary.
Drive chain and sprockets wear excessively.	1. Lack of lubrication on chain causing chain stretch which creates improper chain to sprocket mesh. 2. Sprockets are out of alignment. 3. Loose chain.	1. Replace chain and sprockets. Provide adequate lubrication. • NOTE: If problem reoccurs, a chain take-up may be required. 2. Align sprockets. See section 5.6 Drive Chain Alignment and Tension on page 26 for more information. 3. Tighten chain.
Loud popping or grinding noise.	1. Defective bearing. 2. Loose set screws in bearing. 3. Loose drive chain.	1. Replace bearing. 2. Tighten set screw. 3. Tighten chain.
Motor or reducer overheating.	1. Conveyor is overloaded. 2. Accumulation pressure too great. 3. Low voltage to motor. 4. Low lubricant level in reducer. 5. One or more V-belts too tight.	1. Check capacity of conveyor and reduce load to recommended level. 2. Refer to section 3.7 Pressure Adjustment - ACC on page 18. 3. Have electrician check and correct as necessary. 4. Relubricate per manufacturer's recommendations. For Hytrol reducer, refer to separate manual. 5. Reposition take-up sheaves further from double groove sheave.

7.2 TROUBLESHOOTING DRIVE BELT TRACKING

TROUBLE	CAUSE	SOLUTION
Belt slips or won't move, but drive runs.	1. Conveyor is overloaded. 2. Belt is too loose. 3. Too much pressure against belt.	1. Check capability of conveyor and reduce load to recommended level. 2. Reposition take-up sheaves closer to double groove sheave. 3. Loosen spring tension on pressure roller. See section 3.7 Pressure Adjustment - ACC on page 18 for more information.
Belt moving, but tread rollers not turning.	1. Not enough pressure against the belt from the pressure rollers. 2. Bolt in suspension angle binding and not allowing adjustment of pressure rollers. 3. Missing or broken springs or adjustment nuts.	1. Tighten spring tension on pressure rollers in area of stalled roller. See section 3.7 Pressure Adjustment - ACC on page 18 for more information. 2. Loosen bolt and adjust spring tension as required. Check for burrs or foreign material behind angles. 3. Replace and readjust.

8 PREVENTIVE MAINTENANCE

8.1 PREVENTIVE MAINTENANCE CHECKLIST

The following is a general maintenance checklist which covers the major components of your conveyor. This will be helpful in establishing a standard maintenance schedule.

COMPONENT	SUGGEST ACTION	SCHEDULE		
		WEEKLY	MONTHLY	QUARTERLY
Motor	Check Noise			
	Check Temperature			
	Check Mounting Bolts			
Reducer	Check Noise			
	Check Temperature			
	Check Oil Level			
Drive Chain	Check Tension			
	Lubricate			
	Check for Wear			
	Check Bearing Lubrication			
Bearings (Pulleys & Rollers)	Check Noise			
	Check Mounting Bolts			
Sprockets and Rollers	Check Sprocket Alignment			
	Check for Wear			
	Check Noise			
	Check Bearing Lubrication			
Structural	General Check: All loose bolts, etc., tightened			

NOTE

Check set screws for proper torque value after the first 24 hours of operation.



Need Assistance?
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