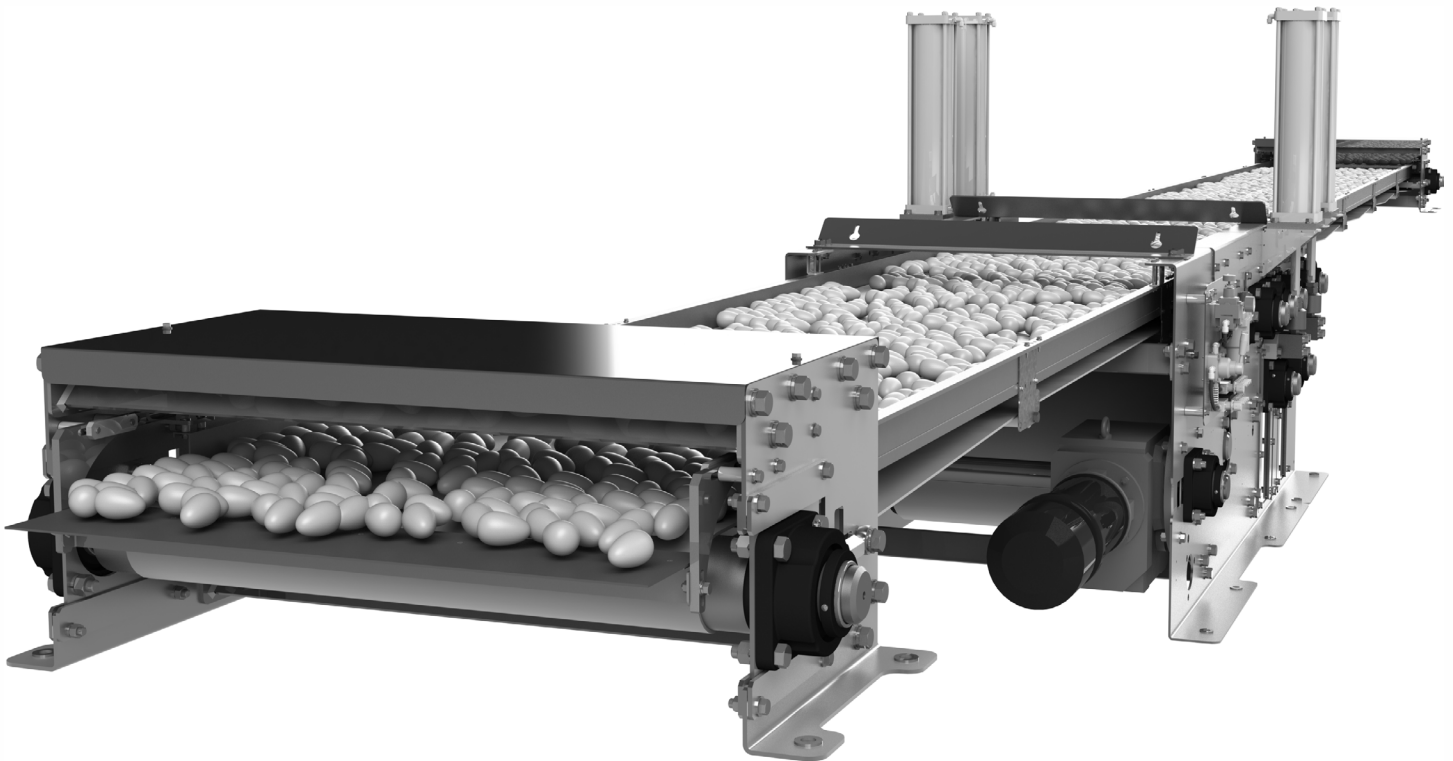


Belt Conveyor Systems

Product Manual

18-in Width

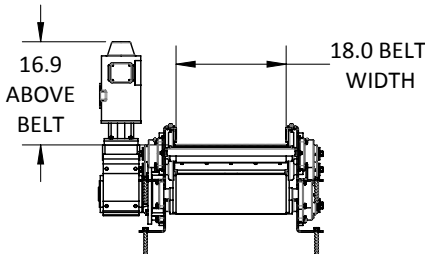
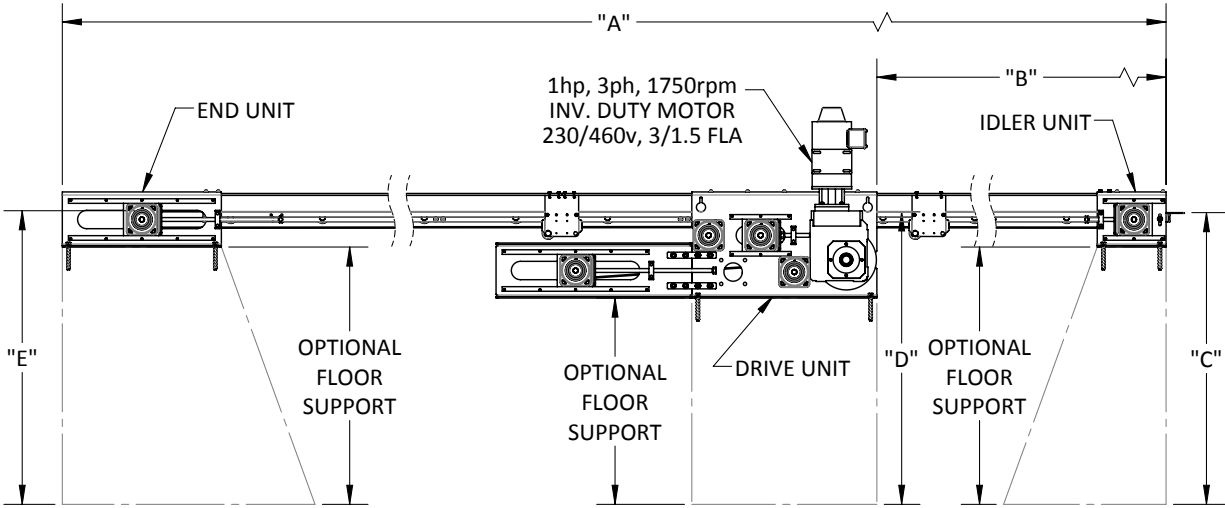


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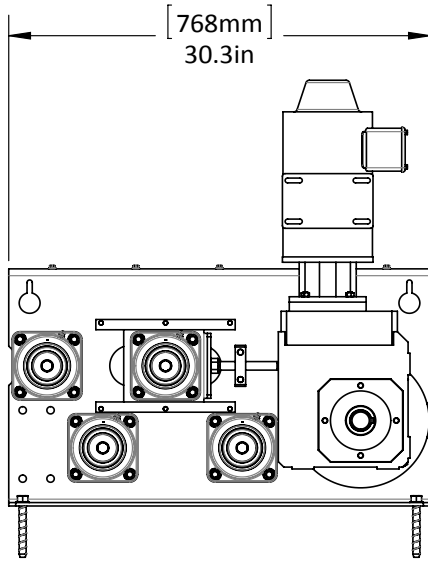
Section 1 Overview

System Length

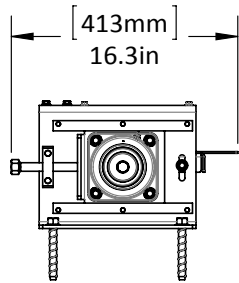
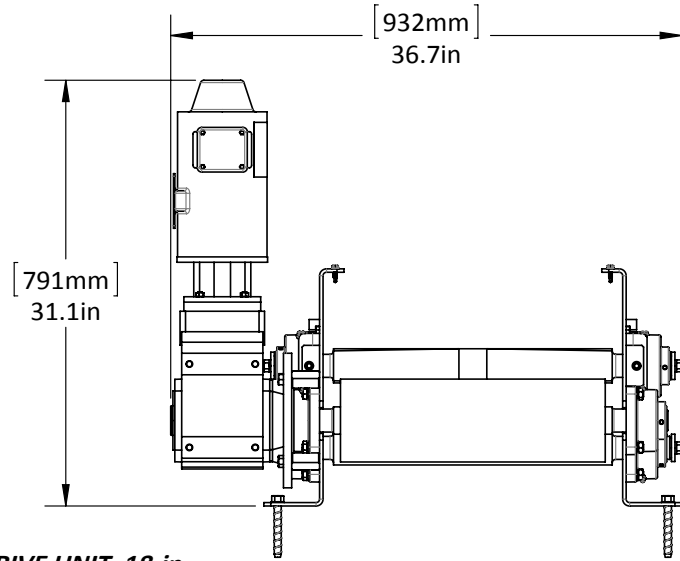


18-in BELT CONVEYOR SYSTEM DIMENSIONS					
"A" TOTAL SYSTEM LENGTH	"B" DRIVE UNIT DISTANCE FROM IDLER UNIT	"C" IDLER UNIT BELT HEIGHT	"D" DRIVE UNIT BELT HEIGHT	"E" END UNIT BELT HEIGHT	CAPACITY
100-ft. MIN.	10-ft. MIN.	6-in MIN.	14.3-in MIN.	6-in MIN.	200 CASES/HR
1,000-ft. MAX.	$\frac{A}{3}$ MAX.	(FLOOR SUPPORT HEIGHT) = (DESIRED BELT HEIGHT) - (MIN.)			

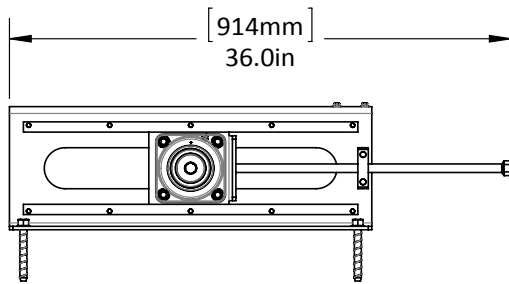
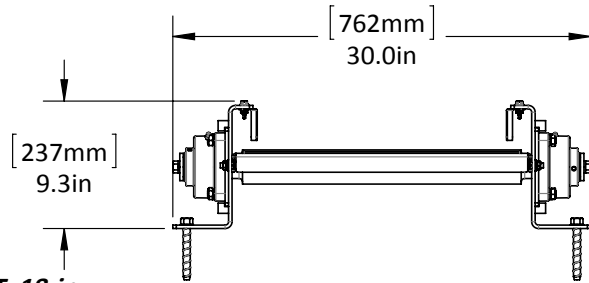
Component Dimensions



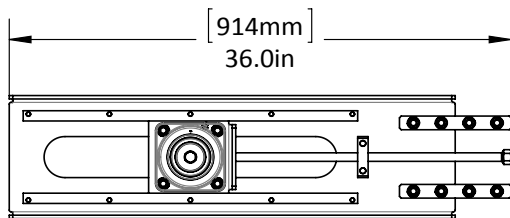
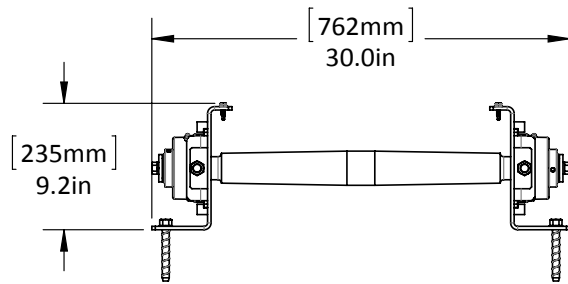
DRIVE UNIT, 18-in



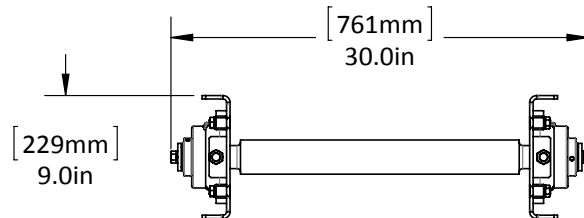
IDLER UNIT, 18-in



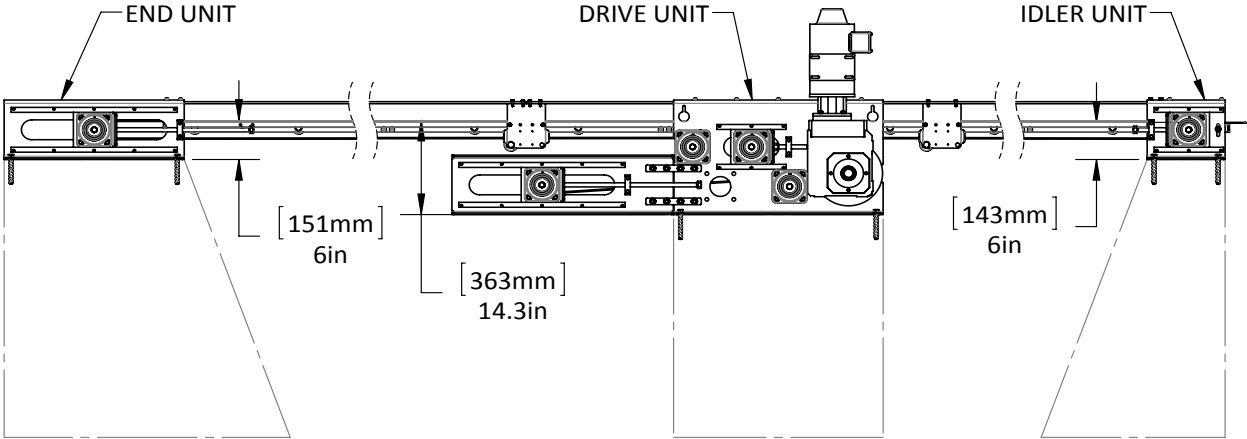
END UNIT, 18-in



TAKE-UP UNIT, 18-in

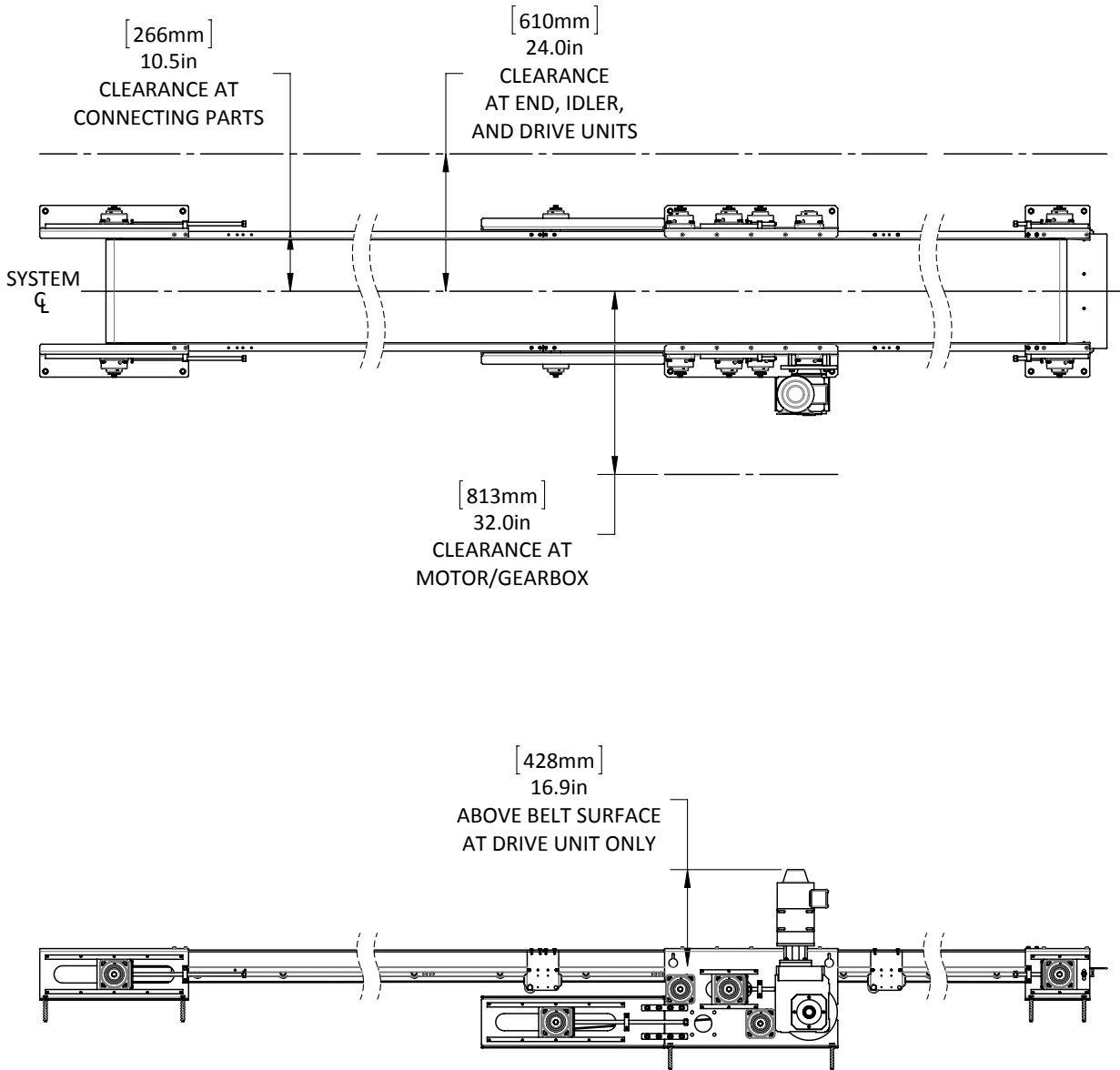


Calculating Floor Support Heights



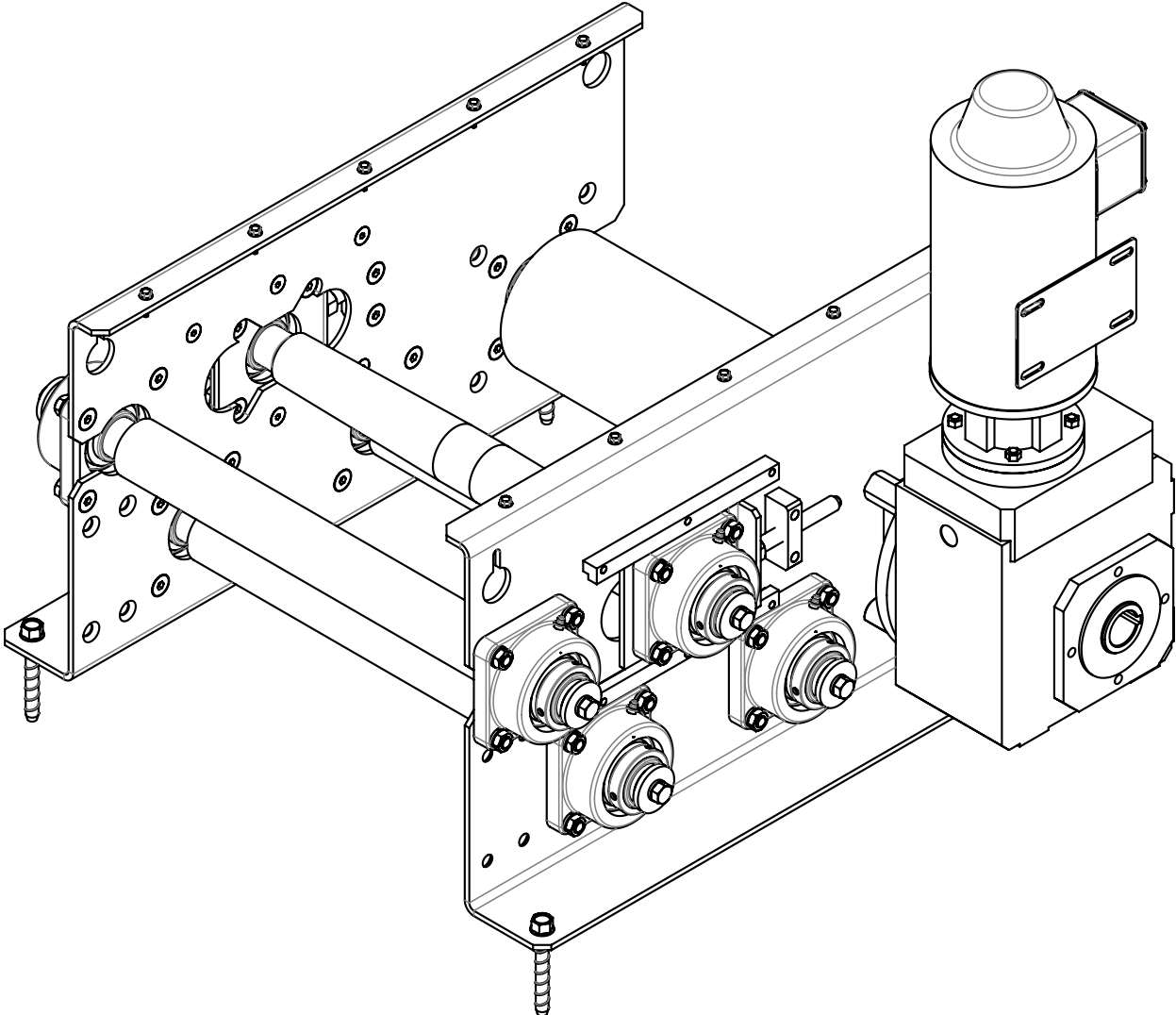
FLOOR SUPPORT HEIGHTS	
COMPONENT	FLOOR SUPPORT HEIGHT CALCULATION
DRIVE UNIT, 18-IN	(DESIRED BELT HEIGHT) - (14.3")
IDLER UNIT, 18-IN	(DESIRED BELT HEIGHT) - (6")
END UNIT, 18-IN	

Recommended Clearances



Section 2 Component Details

Drive Unit, 18-in



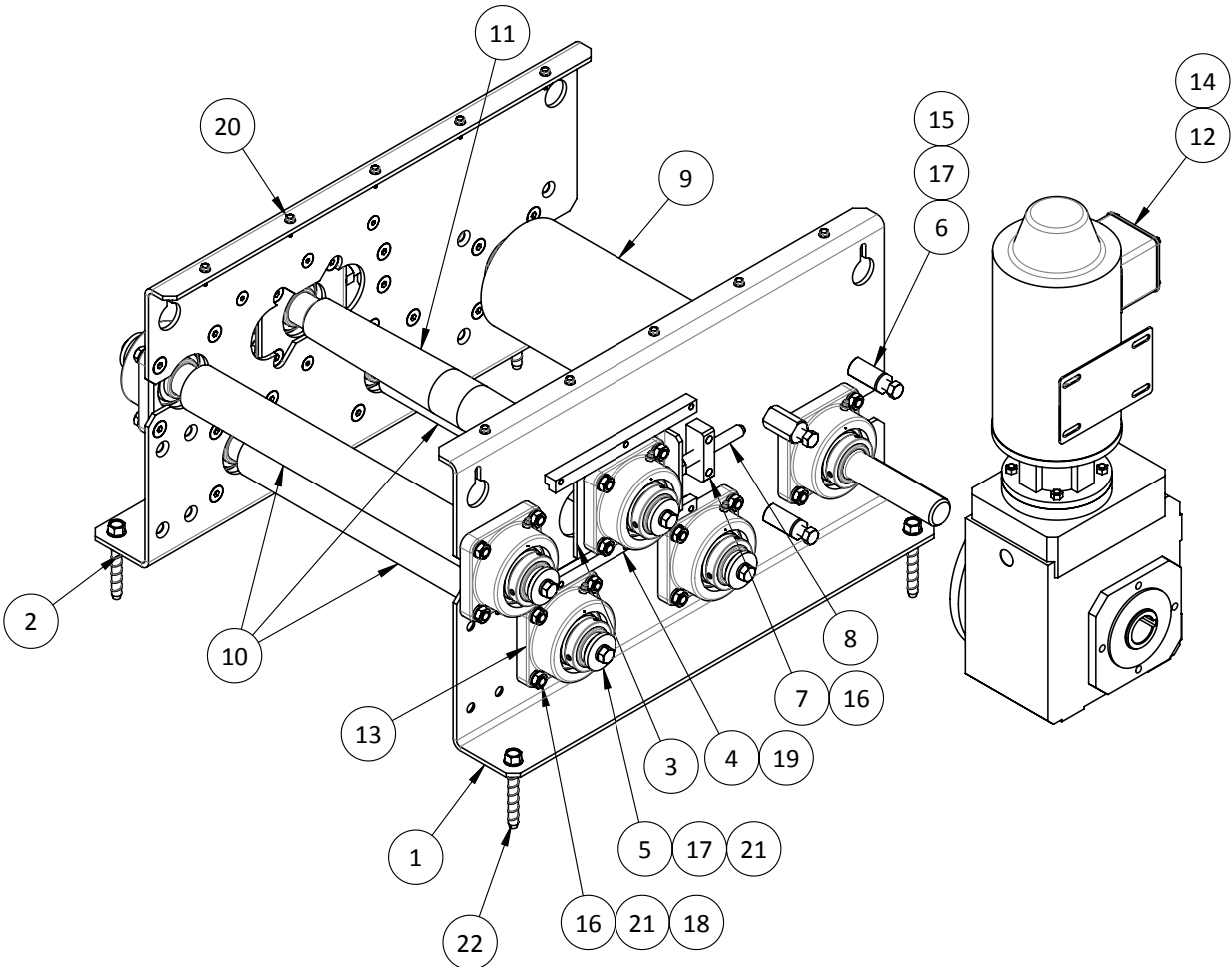
DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E A 000 00A	--	DRIVE UNIT, 18-in

Component Details

Drive Unit, 18-in

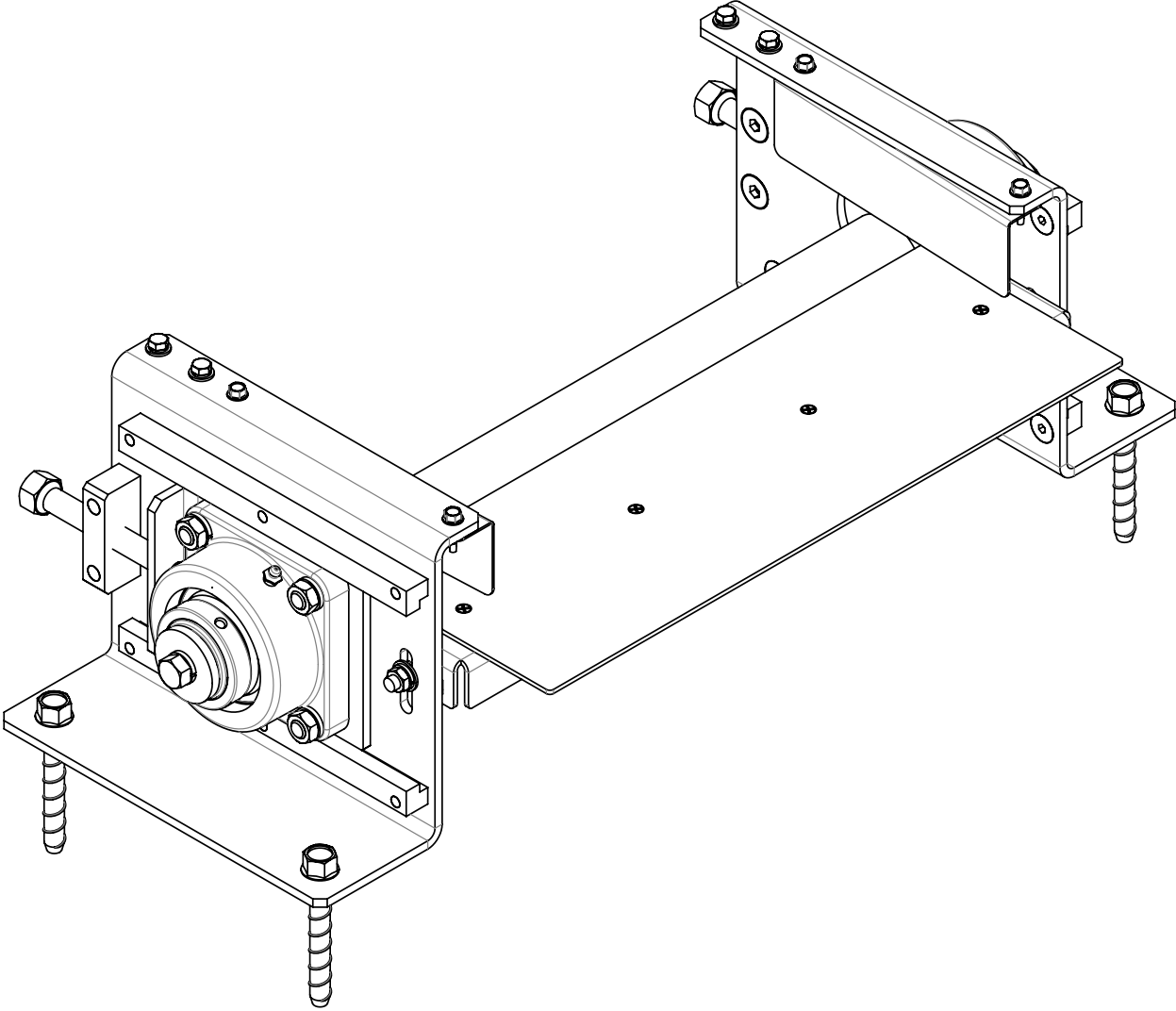
ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	13E A 000 01A		Side Sheet, RH	1
2	13E A 000 02A		Side Sheet, LH	1
3	13E A 000 03A		Bearing Subplate	2
4	13E A 000 04A		Tracking Gib	4
5	13E A 000 05A		Shaft Washer	8
6	13E A 000 06A		Reducer Standoff	4
7	13E A 000 07A		Jack Bar	2
8	13E A 000 08A		Tracking Bolt	2
9	13E A 000 09A		Drive Roller Weldment, 18-in	1
10	13E A 000 10A		Idler Roller, 2.5-in	3
11	13E A 000 11A		Tracking Roller, 2.5-in	1
12		Y535	1hp, 230/460 3ph, 1800rpm Inv Duty Motor	1
13		USFB5000-111-C	4-Bolt Flange Bearing, 1-11/16"	10
14		K403AF1090MR140/050 EL5	109:1 K Series Gearbox, Hollow Output, Side #3 Flange	1
15		F8-4-23-2-16	1/2-13 x 1" FHCS, Stainless	4
16		F8-4-23-2-24	1/2-13 x 1-1/2" FHCS, Stainless	44
17		F8-7-23-2-16	1/2-13 x 1" Hex Bolt, Stainless	12
18		F8-23-23-2-0	1/2-13 Jam Nut, Stainless	40
19		F8-58-21-2-16	3/8-16 x 1", Stainless	12
20		F8-66-19-0-16	1/4" x 1" Hex Head Self-Tapping Screw, Stainless	10
21		F8-96-23-0-0	1/2" Lock Washer, Stainless	48
22		F9-77-23-0-64	1/2" x 4" Tapcon Masonry Hex Screw, Zinc	4

Drive Unit, 18-in



DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E A 000 00A	--	DRIVE UNIT, 18-in

Idler Unit, 18-in



DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E B 000 00A	--	IDLER UNIT, 18-in

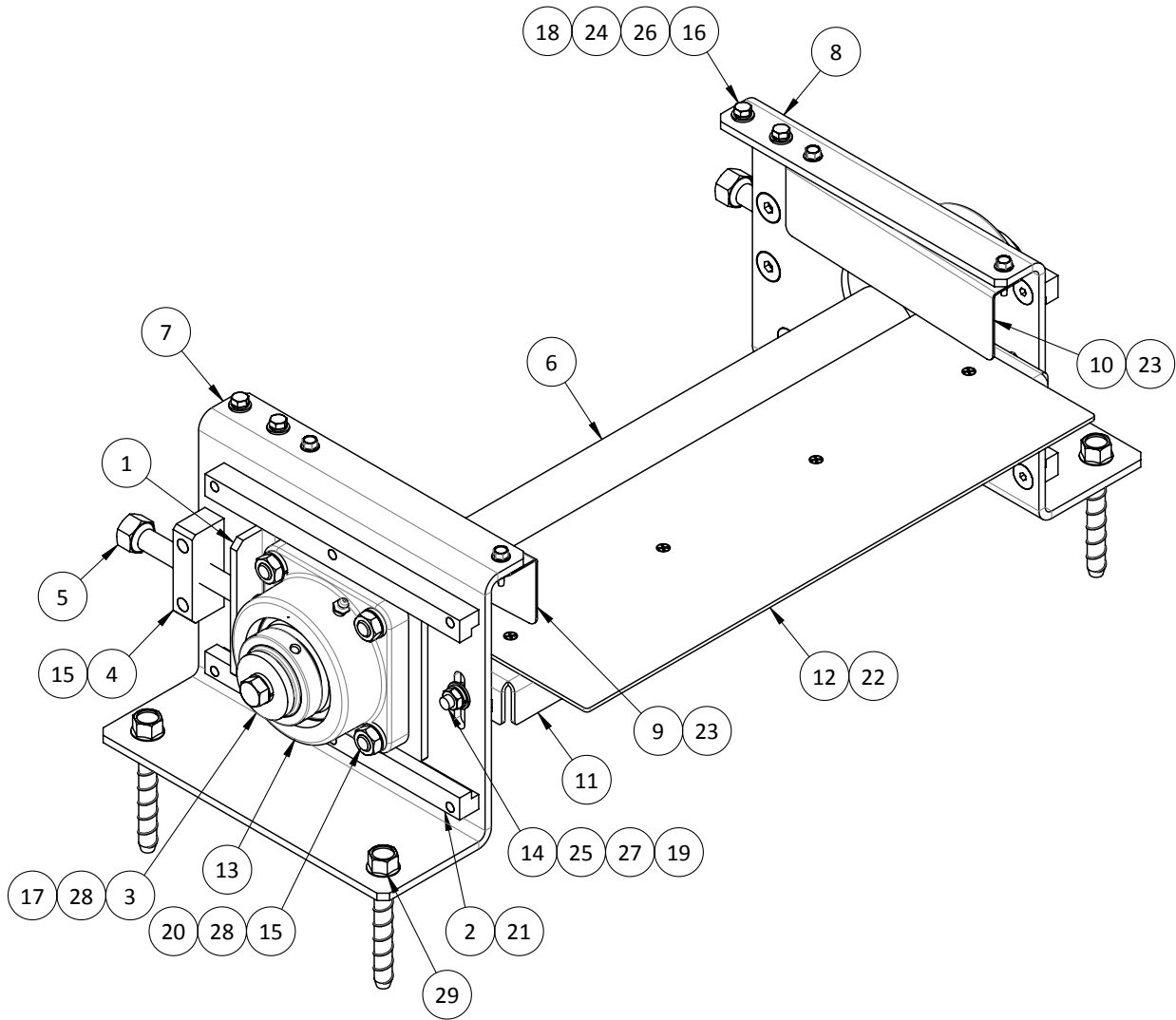
Component Details

Idler Unit, 18-in

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	13E A 000 03A		Bearing Subplate	2
2	13E A 000 04A		Tracking Gib	4
3	13E A 000 05A		Shaft Washer	2
4	13E A 000 07A		Jack Bar	2
5	13E A 000 08A		Tracking Bolt	2
6	13E A 000 10A		Idler Roller, 2.5-in	1
7	13E B 000 01A		Side Sheet, RH	1
8	13E B 000 02A		Side Sheet, LH	1
9	13E B 000 03A		Diverter Angle, RH	1
10	13E B 000 04A		Diverter Angle, LH	1
11	13E B 000 05A		Transfer Angle	1
12	13E B 000 06A		Transfer Plate, 18-in	1
13		USFB5000-111-C	4-Bolt Flange Bearing, 1-11/16"	2
14		F8-3-21-2-16	3/8-16 x 1" Carriage Bolt, Stainless	2
15		F8-4-23-2-24	1/2-13 x 1-1/2" FHCS, Stainless	12
16		F8-7-19-2-12	1/4-20 x 3/4" Hex Bolt, Stainless	4
17		F8-7-23-2-16	1/2-13 x 1" Hex Bolt, Stainless	2
18		F8-22-19-2-0	1/4-20 Hex Nut, Stainless	4
19		F8-23-21-0-0	3/8-16 Jam Nut, Stainless	2
20		F8-23-23-2-0	1/2-13 Jam Nut, Stainless	8
21		F8-58-21-2-16	3/8-16 x 1", Stainless	12
22		F8-61-8-3-8	#10-32 x 1/2" Flat Head Phillips Screw, Stainless	4
23		F8-66-19-0-16	1/4" x 1" Hex Head Self-Tapping Screw, Stainless	4
24		F8-92-19-0-0	1/4" Flat Washer, Stainless	4
25		F8-92-21-0-0	3/8" Flat Washer, Stainless	2
26		F8-96-19-0-0	1/4" Lock Washer, Stainless	4
27		F8-96-21-0-0	3/8" Lock Washer, Stainless	2
28		F8-96-23-0-0	1/2" Lock Washer, Stainless	10
29		F9-77-23-0-64	1/2" x 4" Tapcon Masonry Hex Screw, Zinc	4

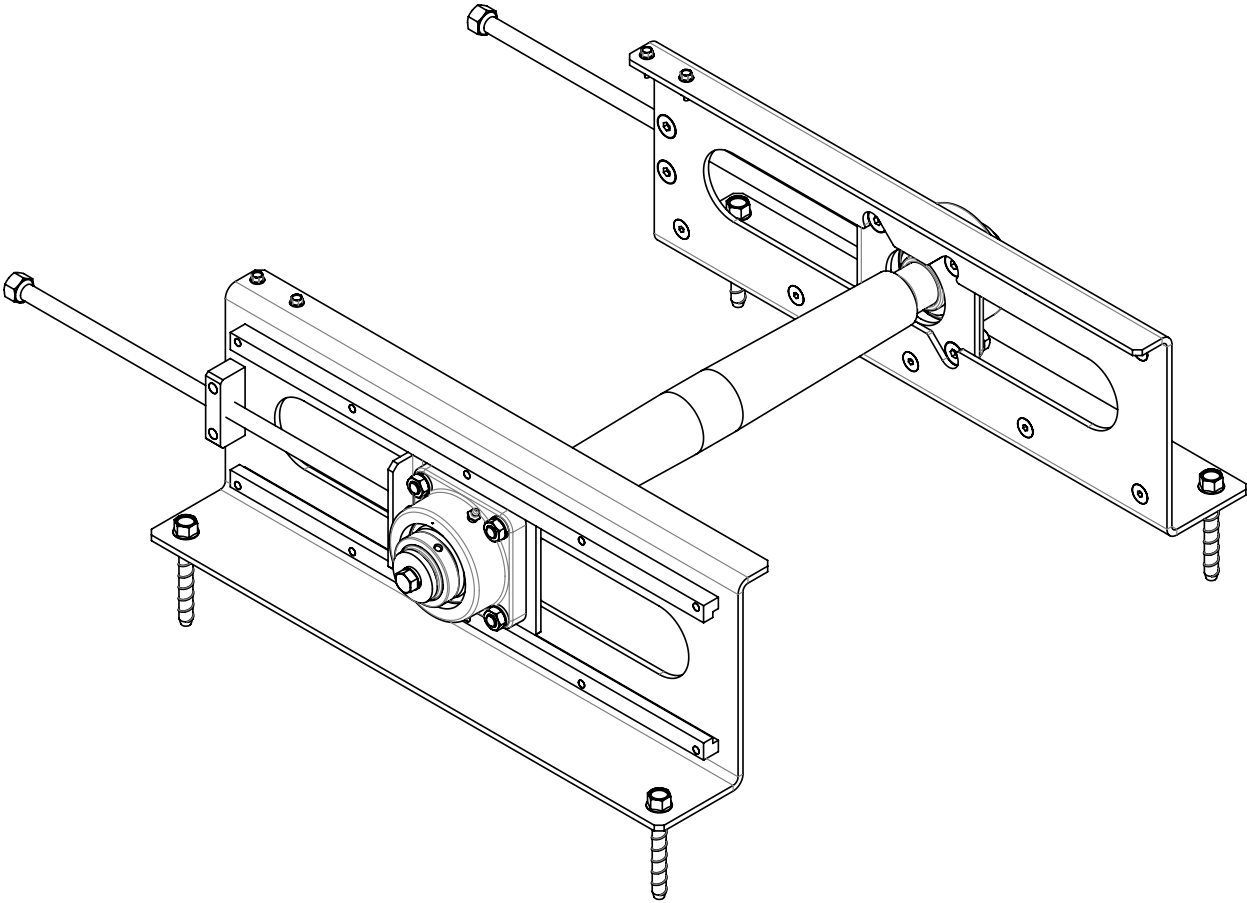
Component Details

Idler Unit, 18-in



DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E B 000 00A	--	IDLER UNIT, 18-in

End Unit, 18-in

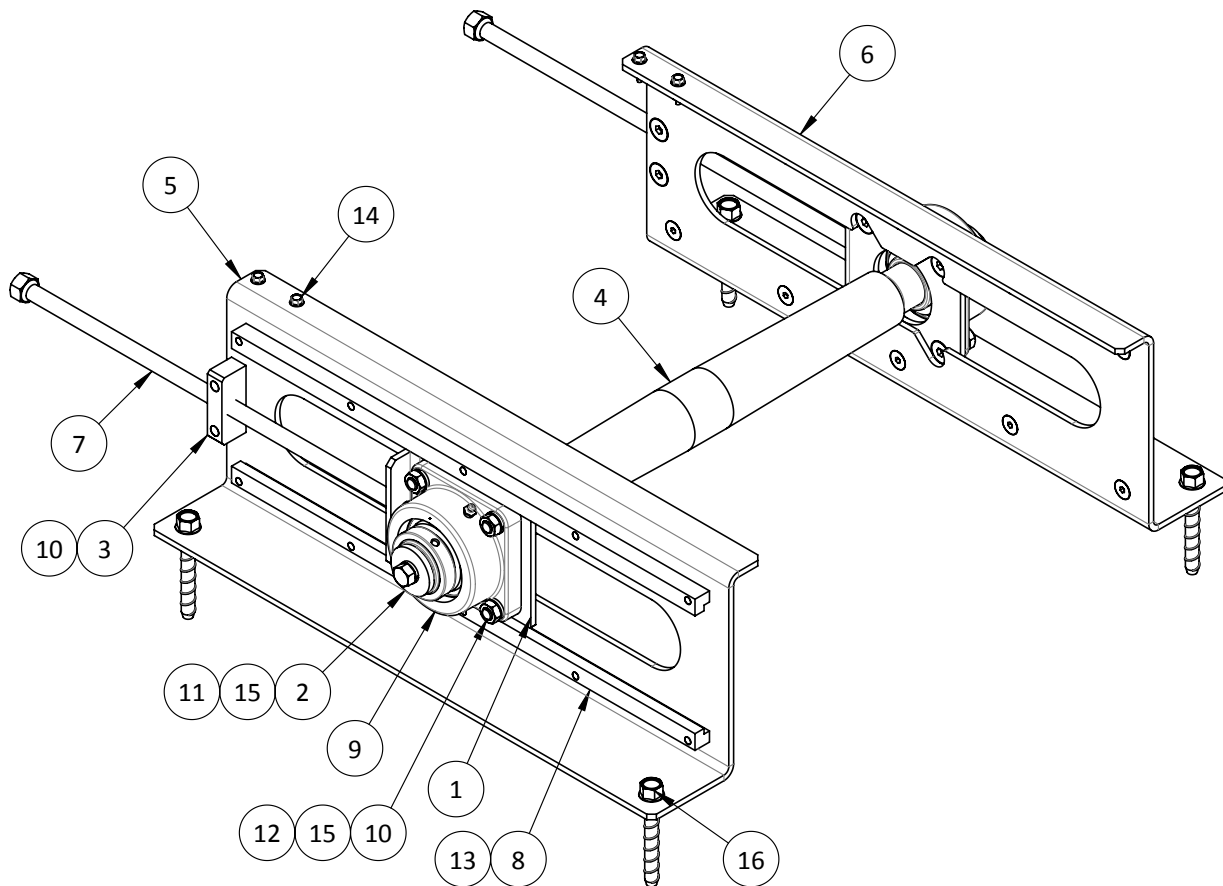


DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E C 000 00A	--	END UNIT, 18-in

Component Details

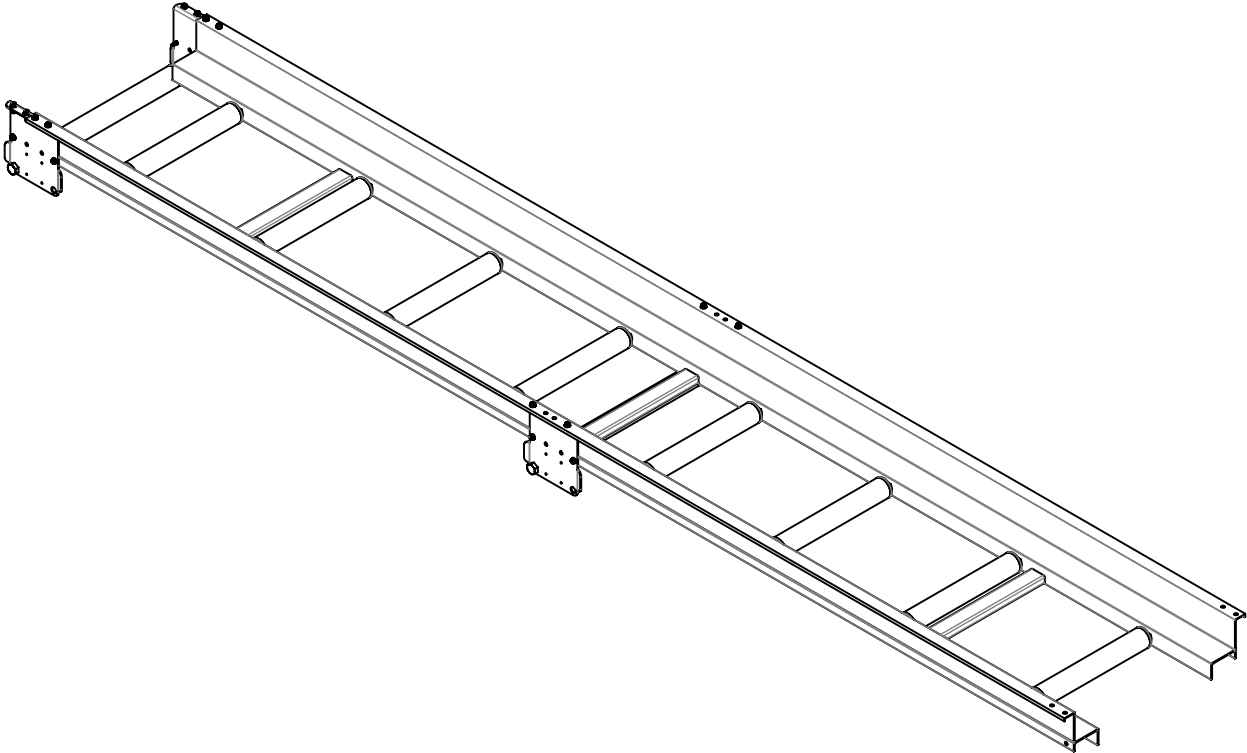
End Unit, 18-in

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	13E A 000 03A		Bearing Subplate	2
2	13E A 000 05A		Shaft Washer	2
3	13E A 000 07A		Jack Bar	2
4	13E A 000 11A		Tracking Roller, 2.5-in	1
5	13E C 000 01A		Side Sheet, RH	1
6	13E C 000 02A		Side Sheet, LH	1
7	13E C 000 03A		End Tracking Bolt	2
8	13E C 000 04A		Take-up Gib	4
9		USFB5000-111-C	4-Bolt Flange Bearing, 1-11/16"	2
10		F8-4-23-2-24	1/2-13 x 1-1/2" FHCS, Stainless	12
11		F8-7-23-2-16	1/2-13 x 1" Hex Bolt, Stainless	2
12		F8-23-23-2-0	1/2-13 Jam Nut, Stainless	8
13		F8-58-21-2-16	3/8-16 x 1", Stainless	20
14		F8-66-19-0-16	1/4" x 1" Hex Head Self-Tapping Screw, Stainless	4
15		F8-96-23-0-0	1/2" Lock Washer, Stainless	10
16		F9-77-23-0-64	1/2" x 4" Tapcon Masonry Hex Screw, Zinc	4



DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E C 000 00A	--	END UNIT, 18-in

Connecting Part, 18-in

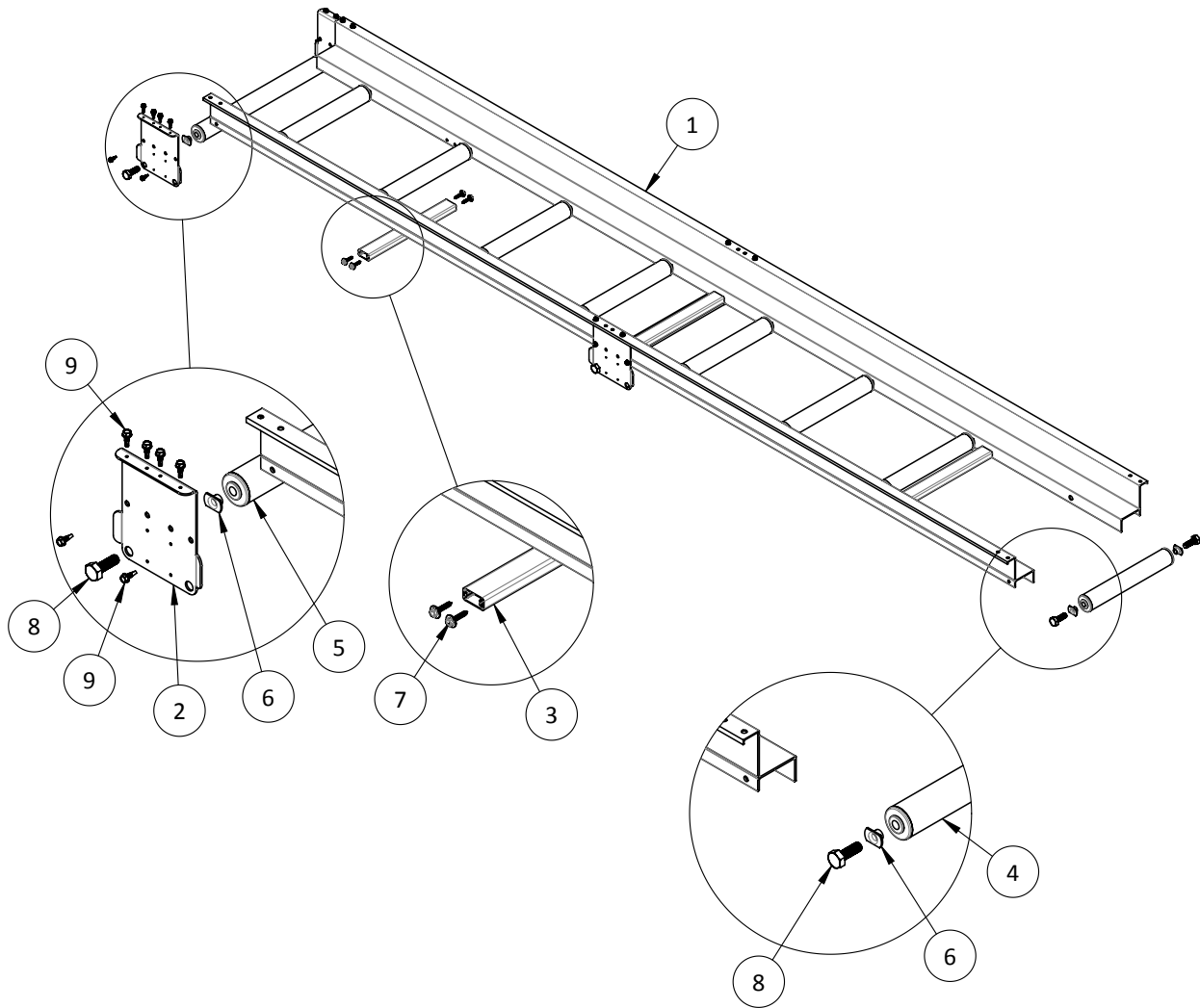


DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E E 000 00A	--	CONNECTING PART, 18-in

Component Details

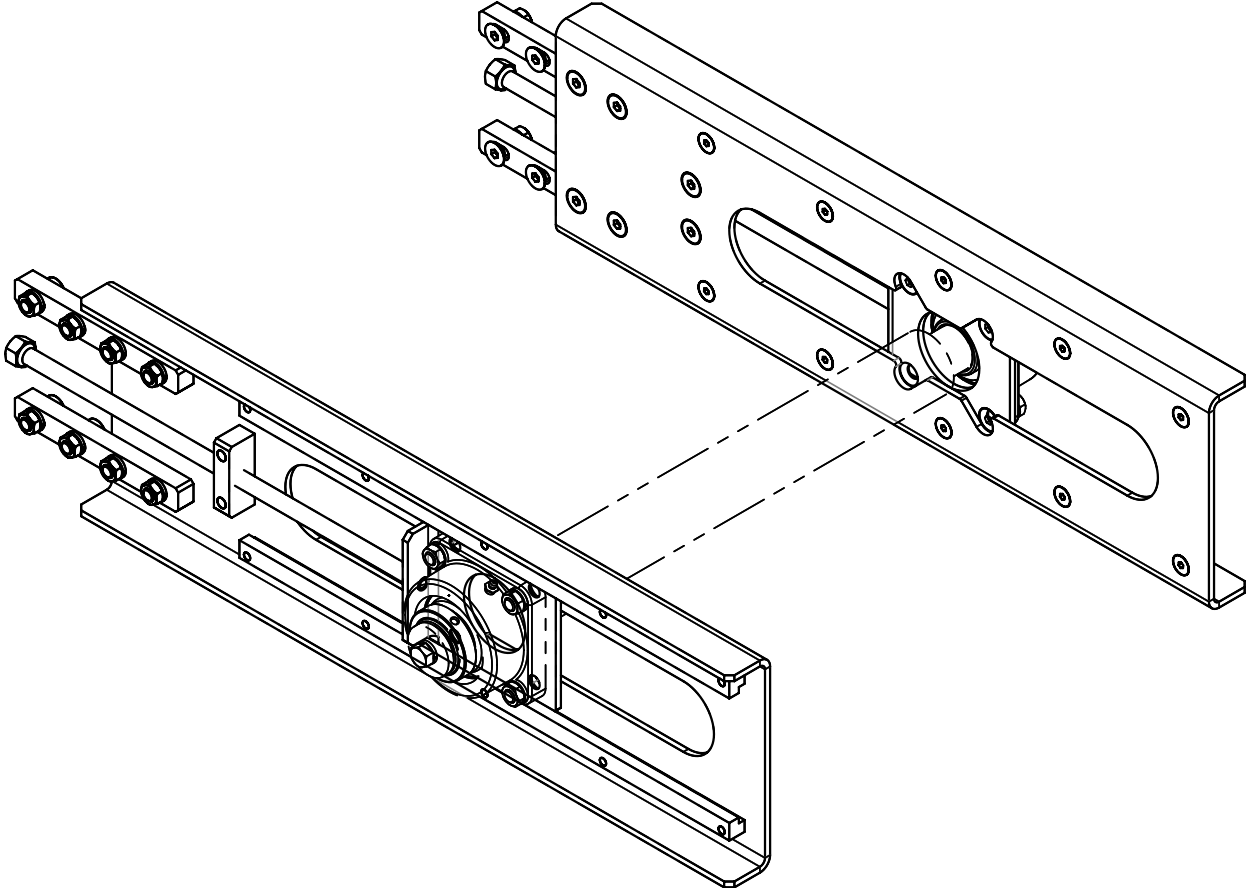
Connecting Part, 18-in

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	702 030 06 00		Side Sheet, 10-ft	2
2	702 030 08 00		Connecting Plate	4
3	740 030 02 00		Traverse, 18-in	3
4	740 130 01 03		Top Roller Assembly, 18-in Belt	8
5	740 130 02 03		Bottom Roller Assembly, 18-in Belt	2
6		90594A033	1/2-13 x 3/8 Tab Base Weld Nut	20
7		21 69 041	M6.3 x 32mm Sheetmetal Screw	12
8		F9-7-23-2-24	1/2-13 x 1-1/2" Hex Bolt, Zinc	20
9		F9-66-19-0-12	1/4" x 3/4" Sheet Metal Screw, Zinc	20



DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E E 000 00A	--	CONNECTING PART, 18-in

Take-up Unit, 18-in (Optional)

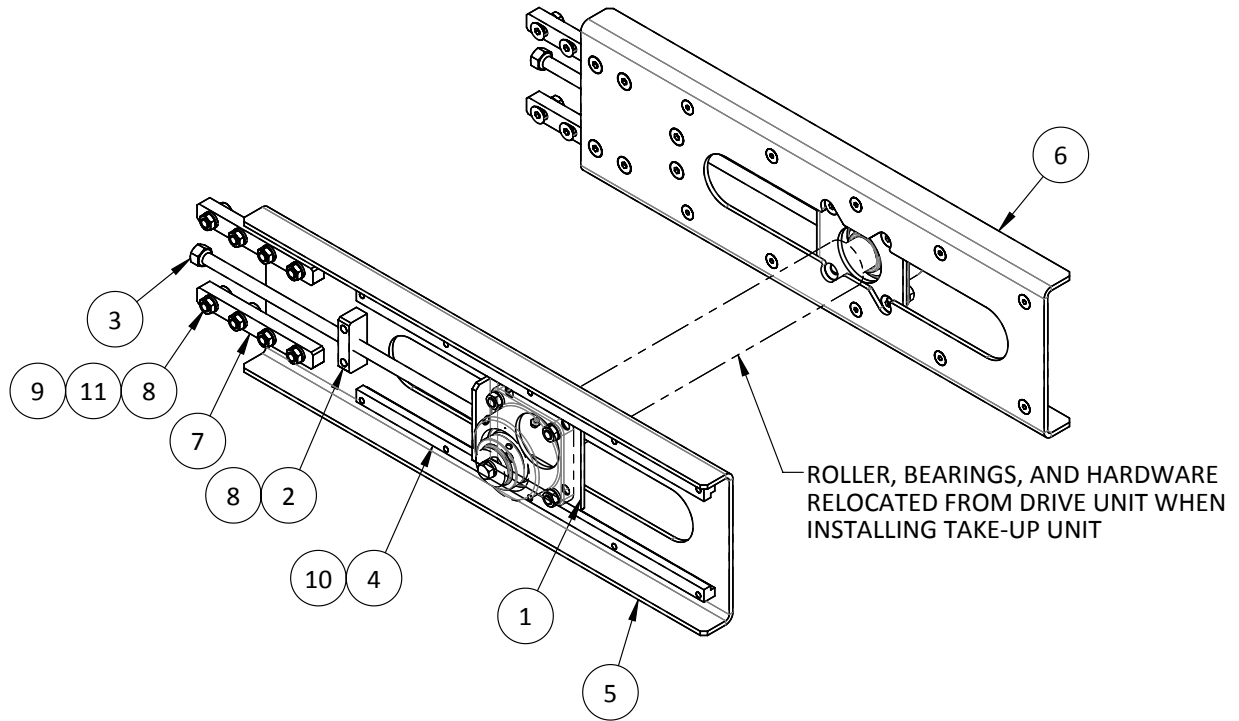


DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E D 000 00A	--	TAKE-UP UNIT, 18-in

Component Details

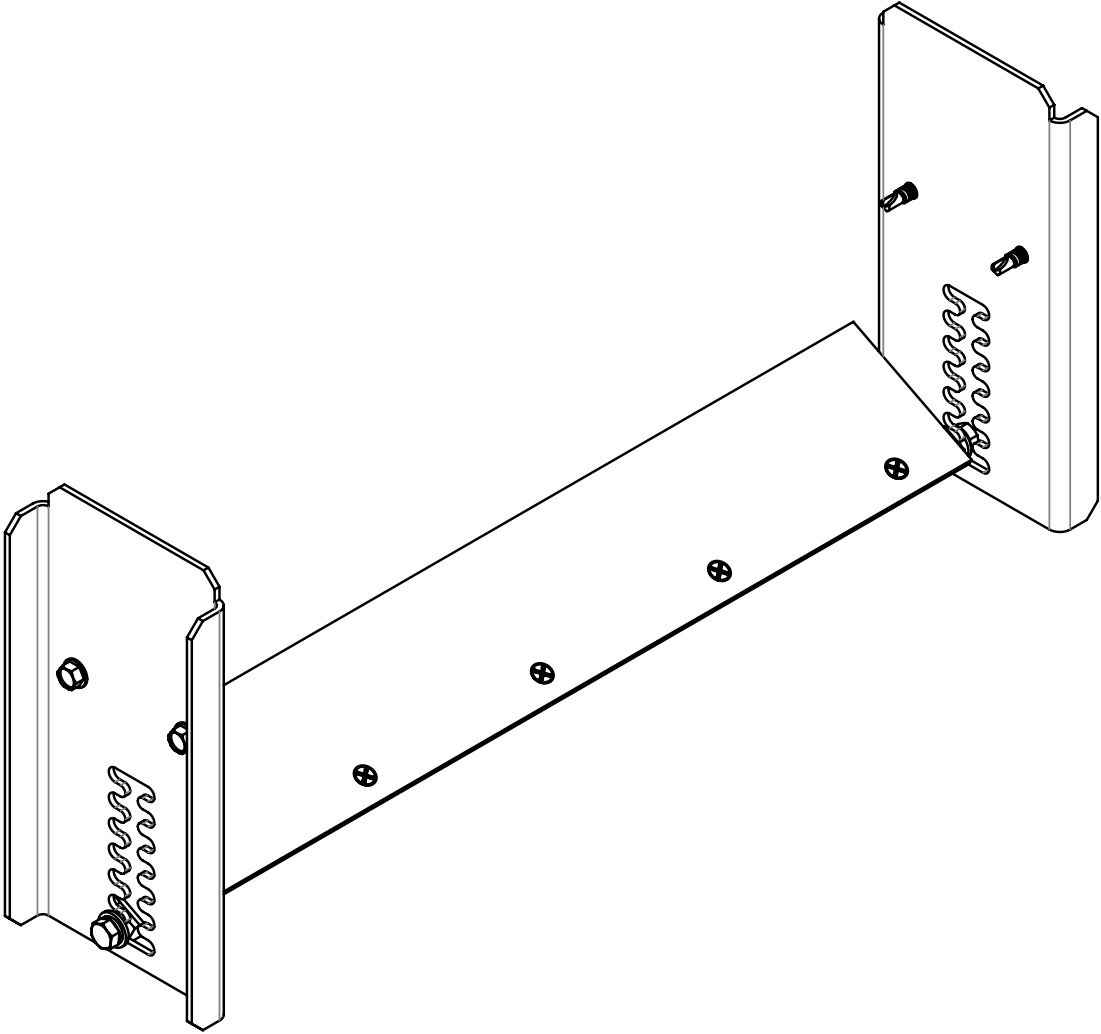
Take-up Unit, 18-in (Optional)

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	13E A 000 03A		Bearing Subplate	2
2	13E A 000 07A		Jack Bar	2
3	13E C 000 03A		End Tracking Bolt	2
4	13E C 000 04A		Take-up Gib	4
5	13E D 000 01A		Side Sheet, RH	1
6	13E D 000 02A		Side Sheet, LH	1
7	13E D 000 03A		Connector Plate	4
8		F8-4-23-2-24	1/2-13 x 1-1/2" FHCS, Stainless	20
9		F8-23-23-2-0	1/2-13 Jam Nut, Stainless	16
10		F8-58-21-2-16	3/8-16 x 1", Stainless	20
11		F8-96-23-0-0	1/2" Lock Washer, Stainless	16



DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E D 000 00A	--	TAKE-UP UNIT, 18-in

Belt Scraper, 18-in

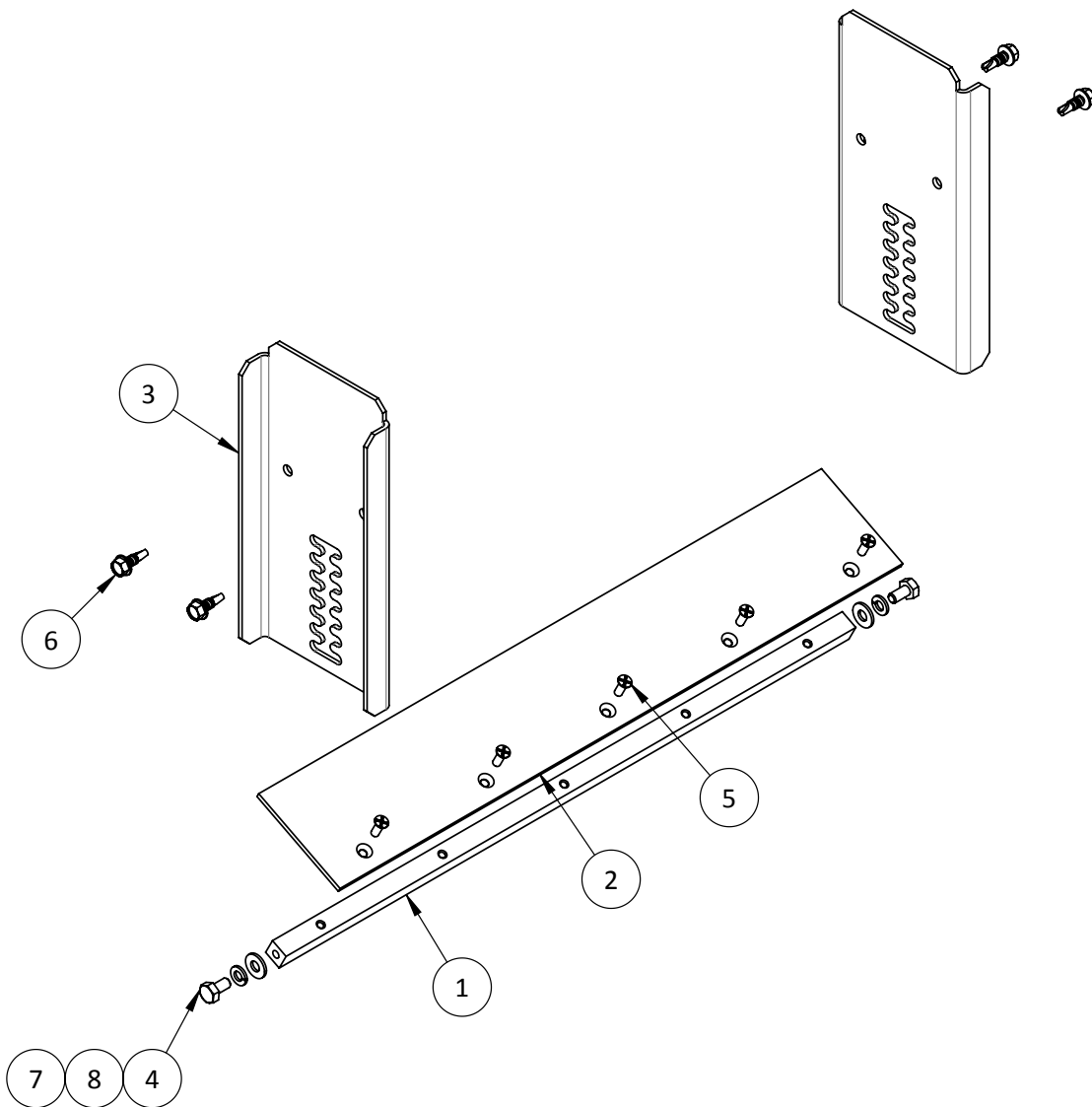


DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E 1 000 00A	--	BELT SCRAPER, 18-in

Component Details

Belt Scraper, 18-in

ITEM NO.	DRAWING NO.	PART NO.	DESCRIPTION	QTY.
1	13E I 000 01A		Scraper Support, 18-in	1
2	13E I 000 02A		Scraper Blade, 18-in	1
3	13E I 000 03A		Scraper Hanger Bracket	2
4		F8-7-19-2-8	1/4-20 x 1/2" Hex Bolt, Stainless	2
5		F8-61-8-3-8	#10-32 x 1/2" Flat Head Phillips Screw, Stainless	5
6		F9-66-19-0-12	1/4" x 3/4" Sheet Metal Screw, Zinc	4
7		F8-92-19-0-0	1/4" Flat Washer, Stainless	2
8		F8-96-19-0-0	1/4" Lock Washer, Stainless	2



DRAWING NUMBER	PART NUMBER	DESCRIPTION
13E I 000 00A	--	BELT SCRAPER, 18-in

Section 3 Installation

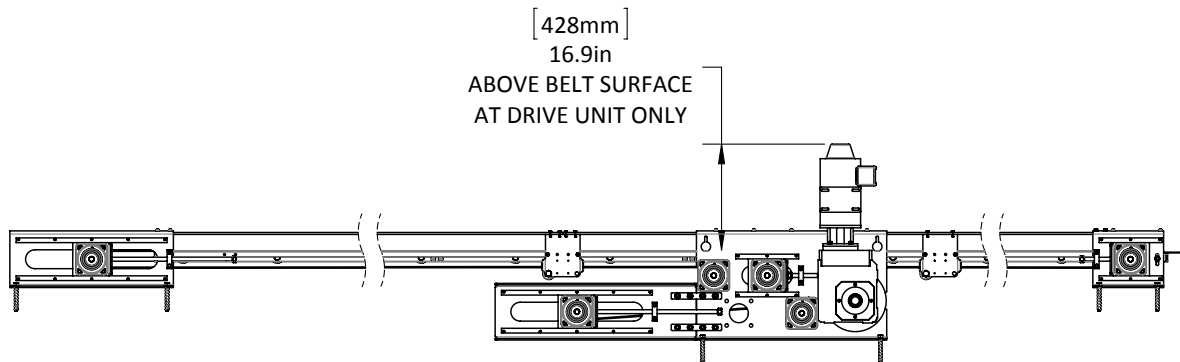
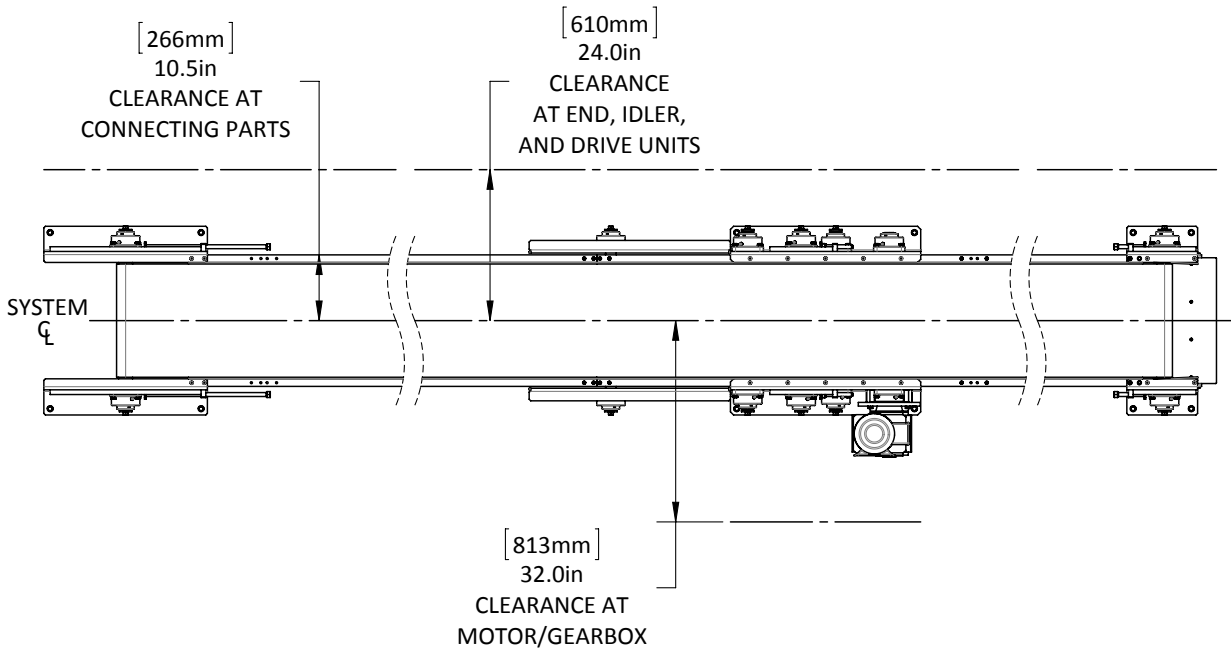
Preparing for Installation

Recommended Tool / Equipment List	
Forklift or equivalent	1,000lb. Capacity (minimum)
Lifting Slings	Lifting lugs are designed for approximately 7/32" chain
6-ft Level	Locating center of belt
Framing Square	Marking center of belt
Speed Square	Marking Connecting Parts
Reciprocating Saw / Hacksaw	Modifying Connecting Part
Hammer Drill / Bit	Anchoring
Tape Measure	Various measurements required
1-in x 2,000-ft Rope	Pulling belt
True RMS Meter	Electrical readings when using VFD

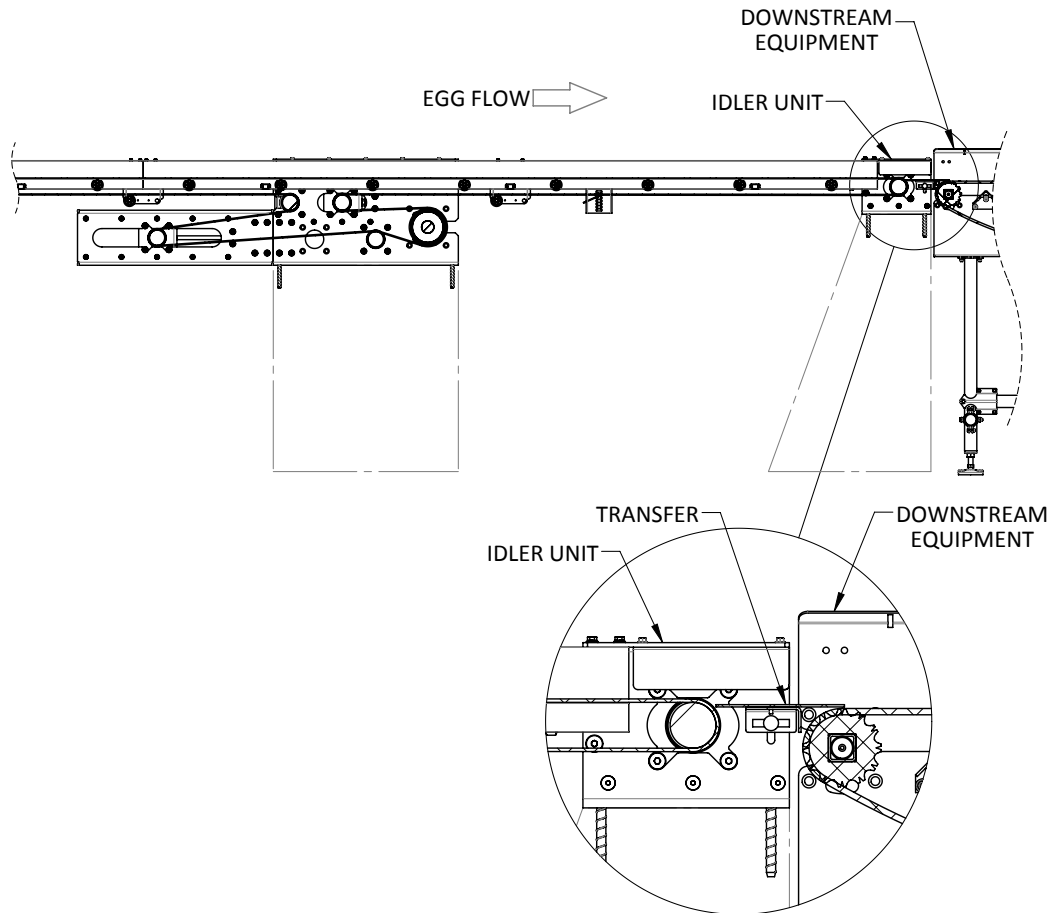
Installation

1. Determine the belt path through the entire length of the system checking for the minimum clearances from centerline as noted below.

Note: Centerline must be straight to ensure proper tracking of belt and level for best product transport.



2. Verify that downstream equipment is level and at the proper height before beginning installation of Idler Unit. Correct if needed.

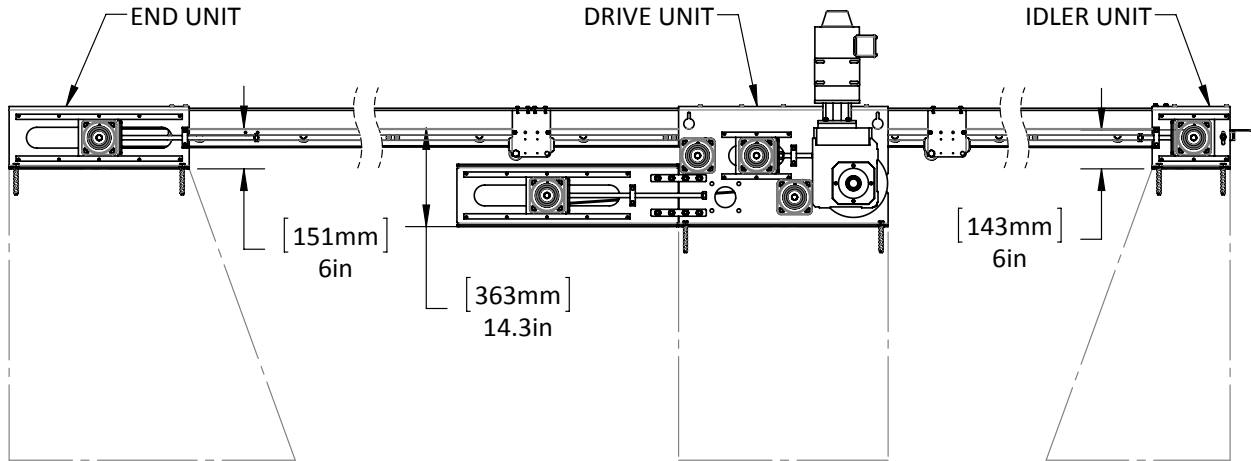


Installation

- Determine location and height for Idler Unit based on downstream equipment and desired transfer level and anchor the Idler Unit.

Note: Floor Supports may be required (see chart below for calculating Floor Support heights).

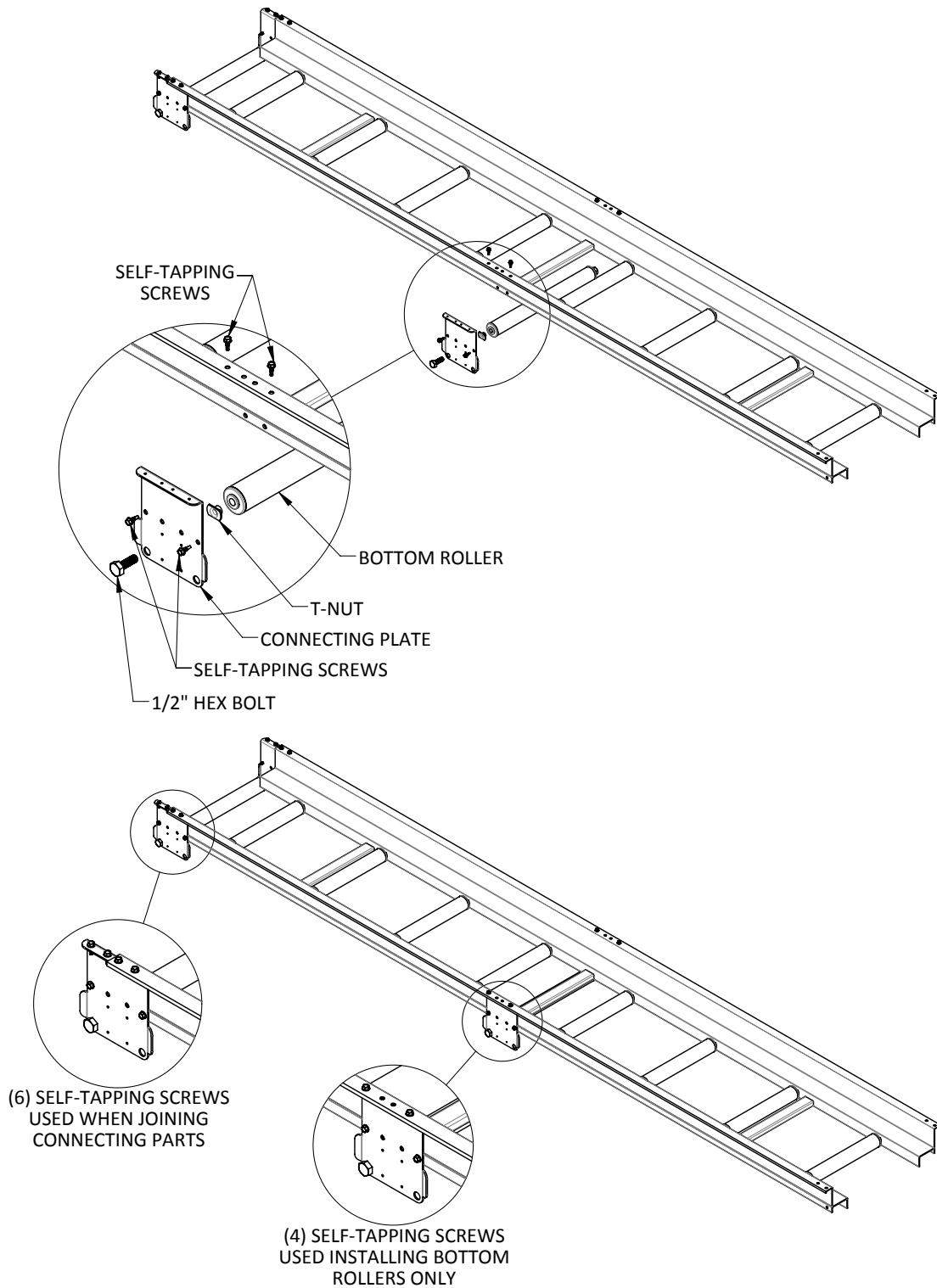
Note: Do not set transfer gap at this time!



FLOOR SUPPORT HEIGHTS	
COMPONENT	FLOOR SUPPORT HEIGHT CALCULATION
DRIVE UNIT, 18-IN	(DESIRED BELT HEIGHT) - (14.3")
IDLER UNIT, 18-IN	(DESIRED BELT HEIGHT) - (6")
END UNIT, 18-IN	

4. Attach Bottom Rollers to all Connecting Parts using the provided Connecting Plates and Self-Tapping Screws.

Note: Four Self-Tapping Screws are required per side when installing Connecting Plates in the middle of the Connecting Part. Six Self-Tapping Screws are required per side when installing Connecting Plates between two Connecting Parts. See view below.

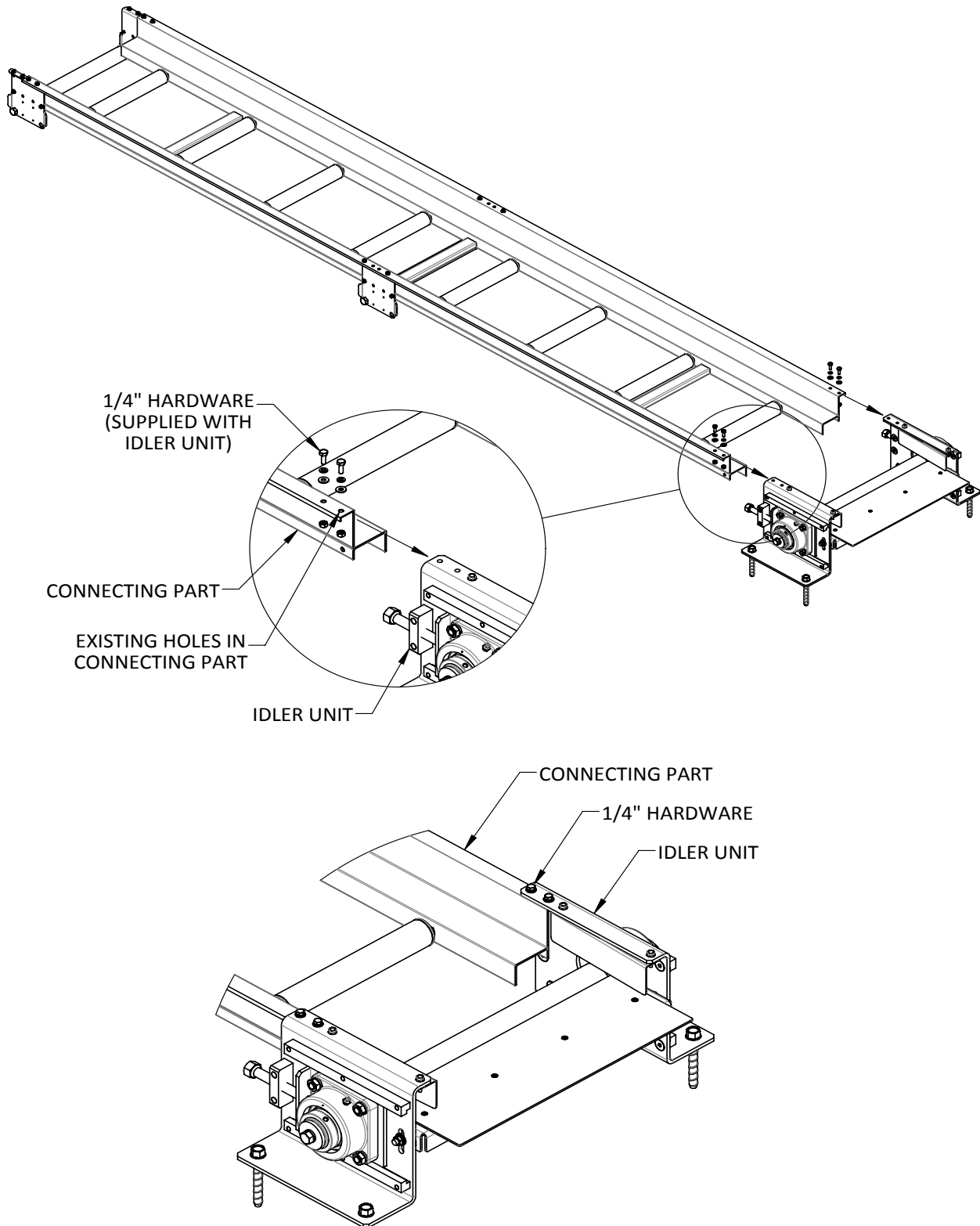


Installation

5. Attach first Connecting Part to Idler Unit utilizing the existing holes and provided 1/4" hardware.

Note: Verify all components as level and at the correct height before proceeding with installation.

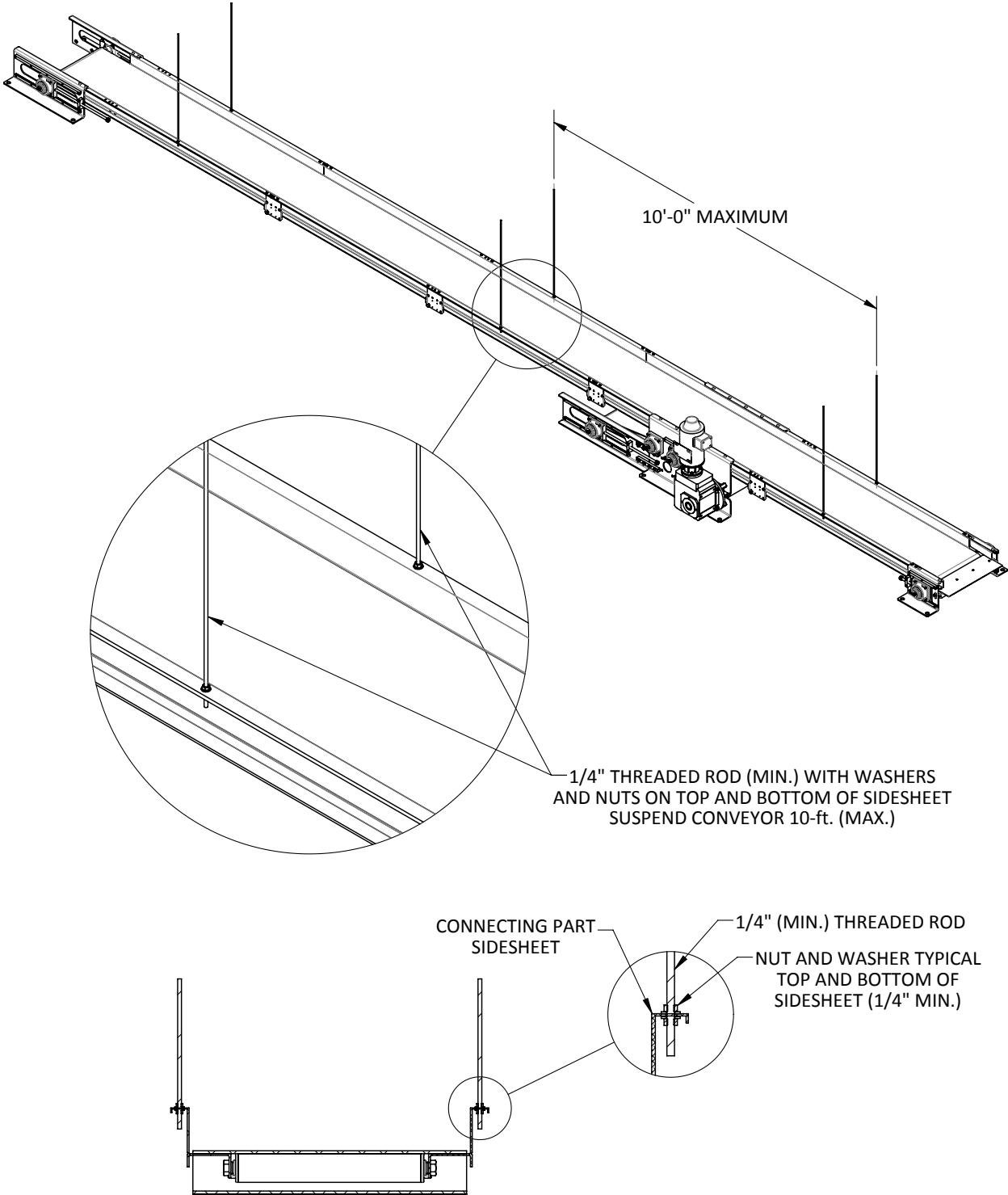
Connecting Parts are intended for suspension, if anchoring to the floor, contact Lubing Systems for Floor Supports.



6. See the view below for recommended suspension practices.

Note: Suspension should be attached to overhead construction in a manner that satisfies all safety and building codes. Customer to supply all suspension.

Note: Only Connecting Parts can be suspended!

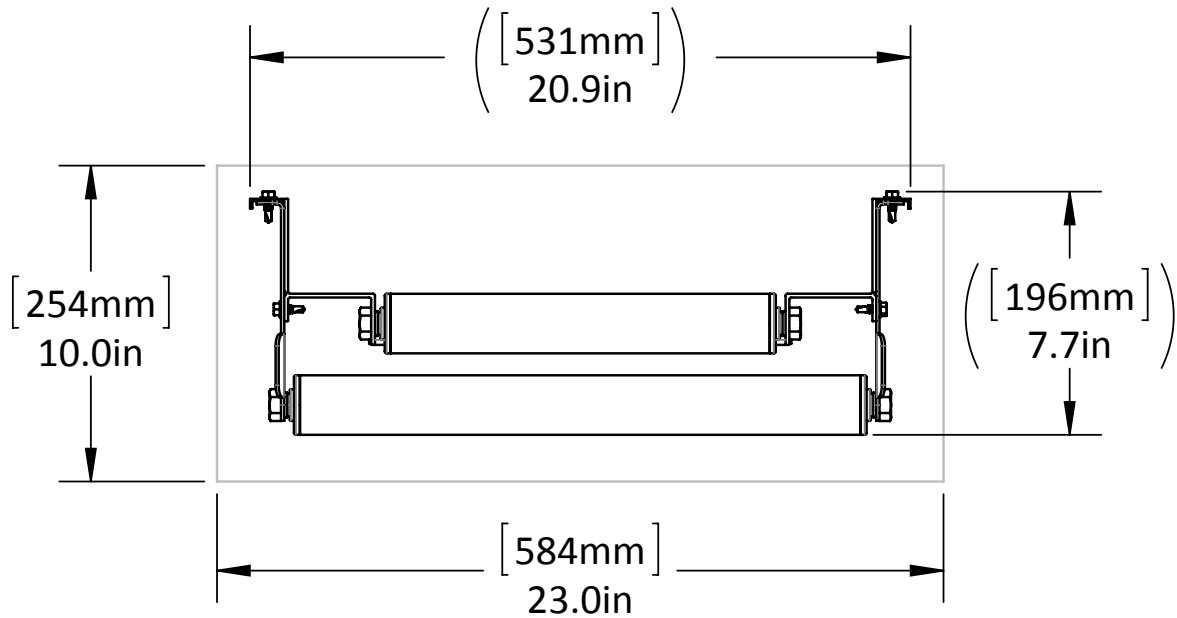


Installation

7. See the view below for recommended clearances for Connecting Parts penetrating walls.

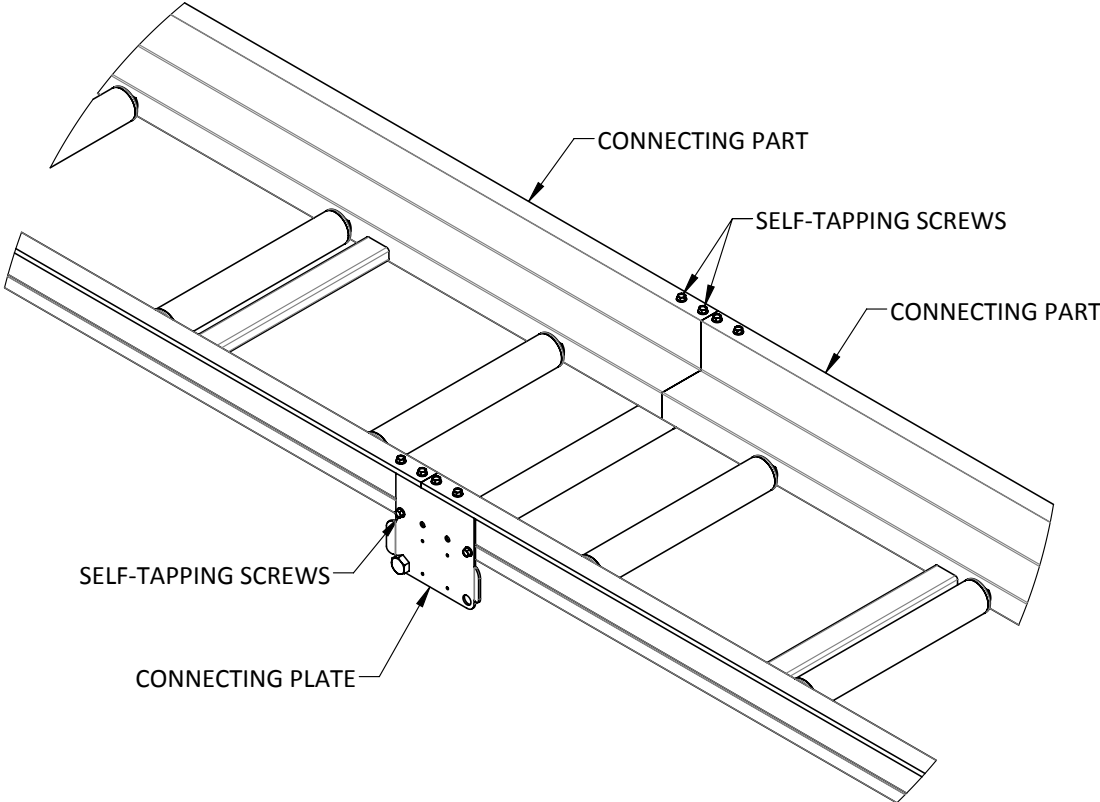
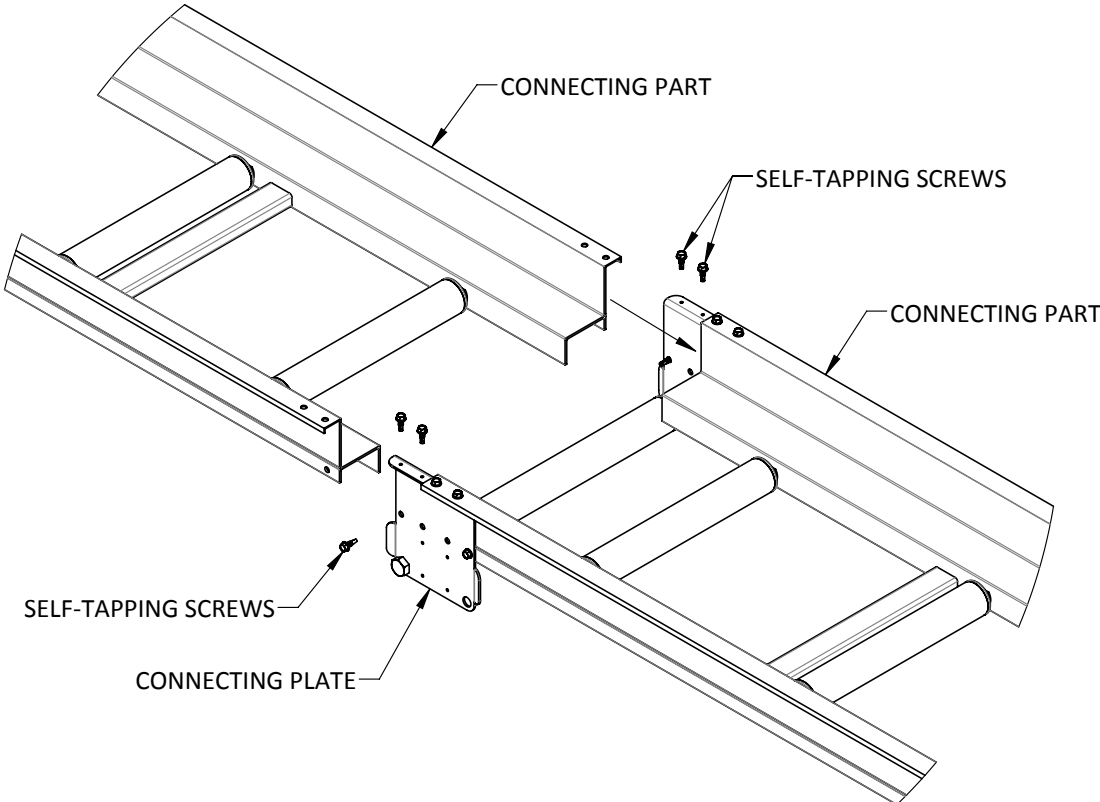
Note: Cutout dimensions are finished sizes. If flashing, trim, etc. is to be added, account for materials when making initial cuts.

Note: Only Connecting Parts should be installed through obstructions such as a wall. If other components land at these locations, install additional Connecting Parts to relocate the component outside such obstacles. Check for proper clearances as noted previously before installing said component.



8. See the view below for attaching two Connecting Parts.

Note: Verify all components as level and at the correct height before proceeding with installation.

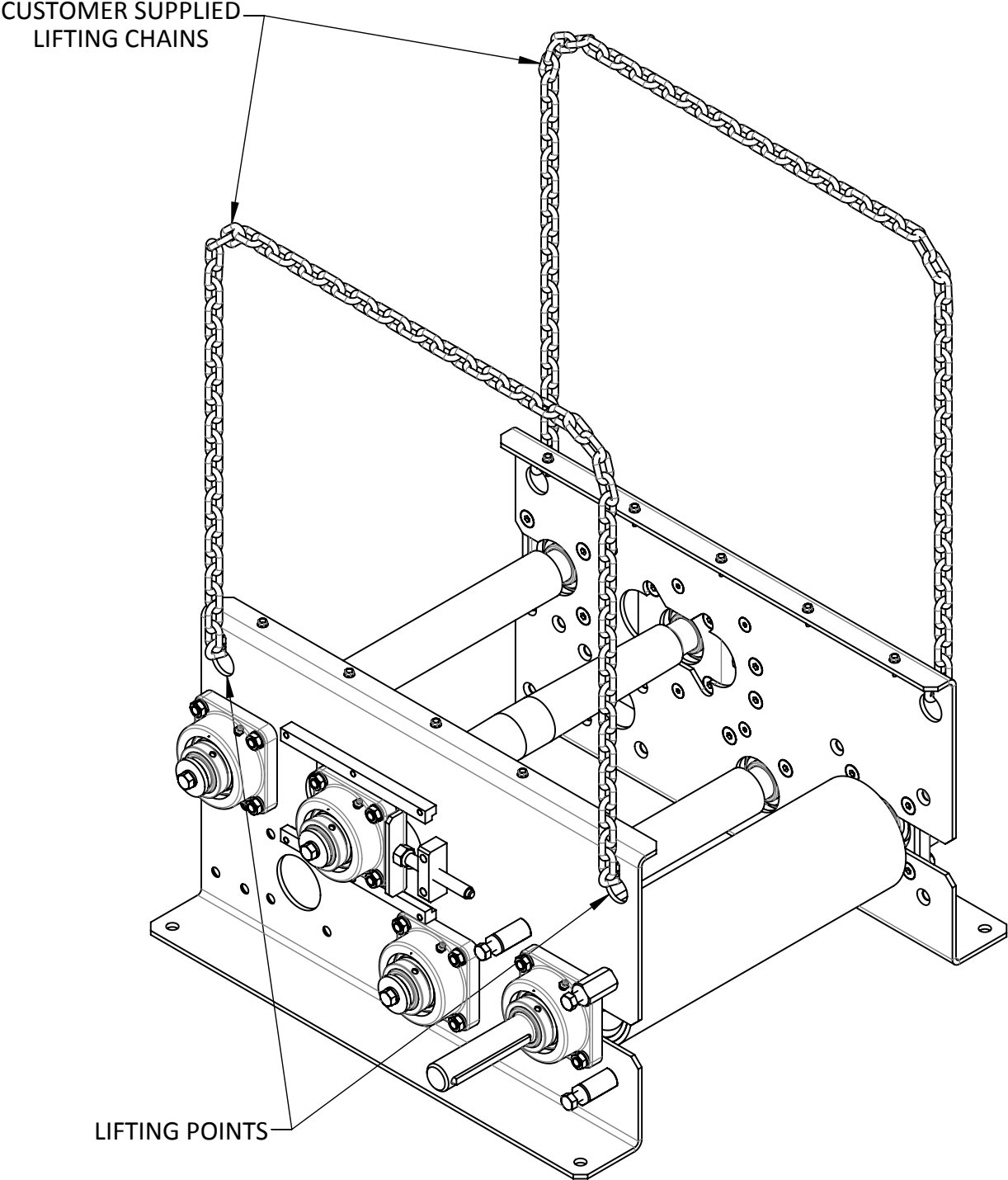


Installation

9. Lifting points are provided on the Drive Unit.

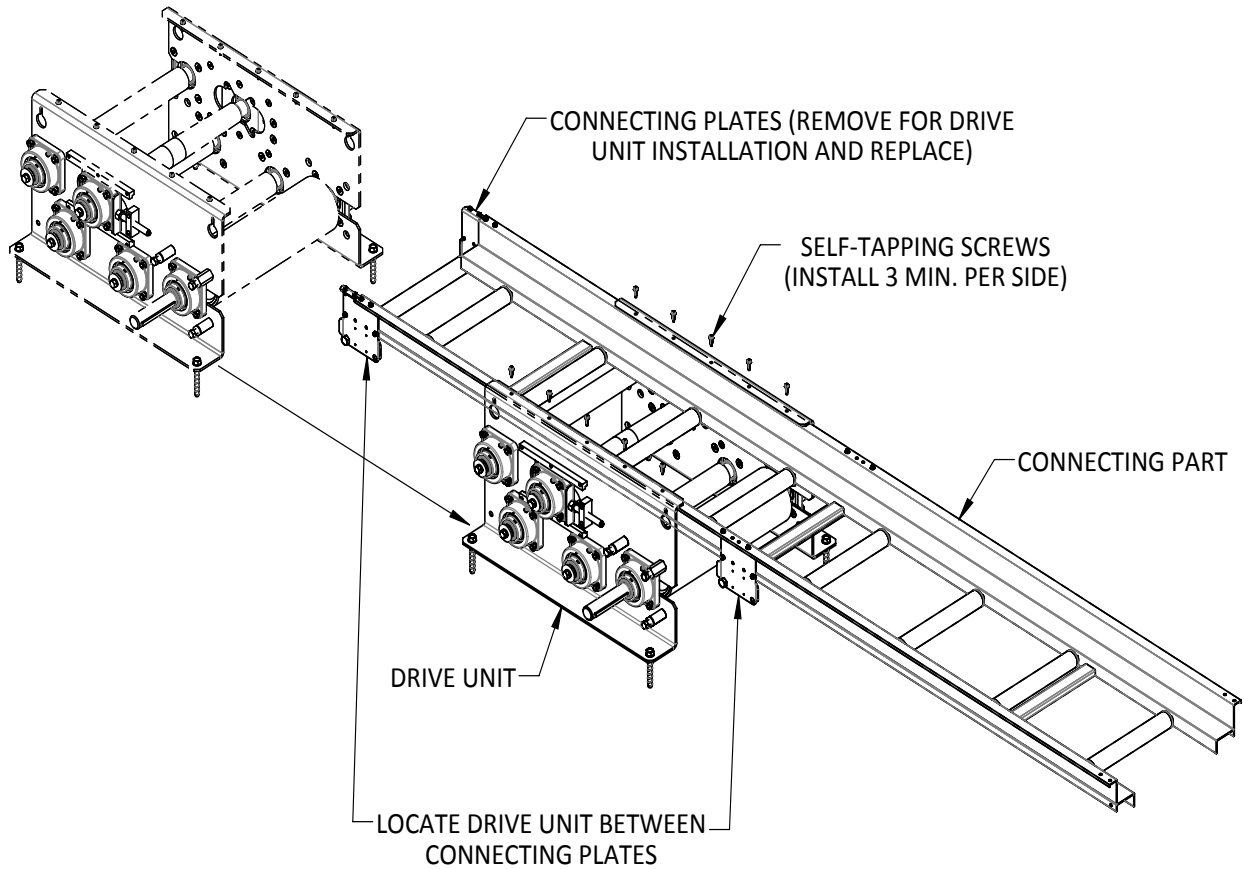
Note: Observe safe practices when lifting Drive Unit.

Note: Chains must remain vertical when lifting, excessive side loading may cause damage to the bearings.



10. When approaching the desired location of the Drive Unit, install the Drive Unit between two sets of Connecting Plates as shown below. Remove Connecting Plates and Bottom Roller to allow Drive Unit to slide onto the last Connecting Part. When installed, replace Connecting Plates and Bottom Roller.

Note: Verify all components as level and at the correct height before proceeding with installation.

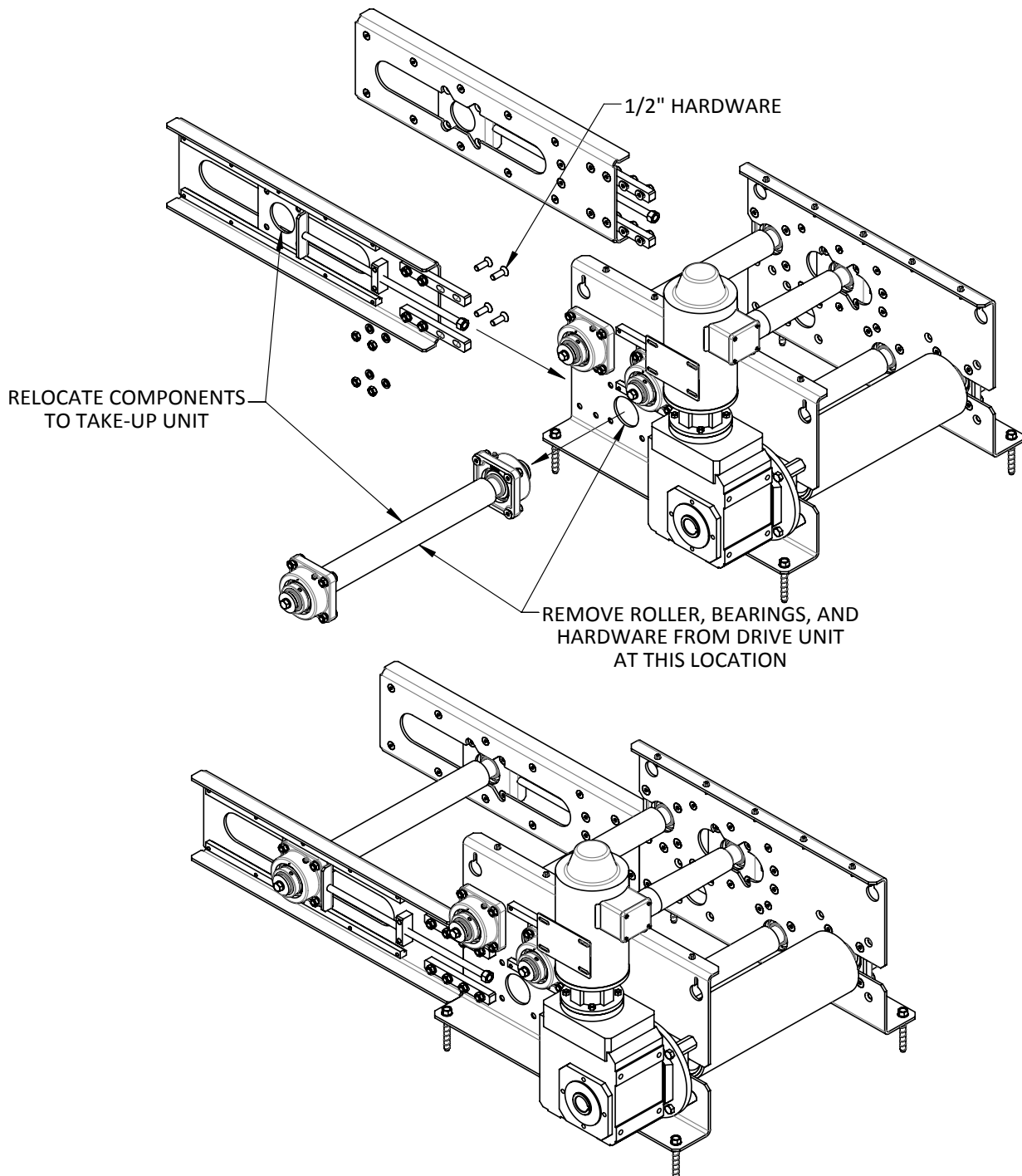


**NOTE: MOTOR/GEARBOX
REMOVED FOR CLARITY**

Installation

11. Anchor the Drive Unit.
12. If the optional Take-up Unit is required, remove the Roller, Bearings, and Hardware shown below from the Drive Unit.
13. Attach the Take-up Unit components to the Drive Unit, relocate the removed Roller, Bearings, and Hardware to the Take-up Unit.

Note: Drive Unit must be anchored before attaching Take-up Unit.

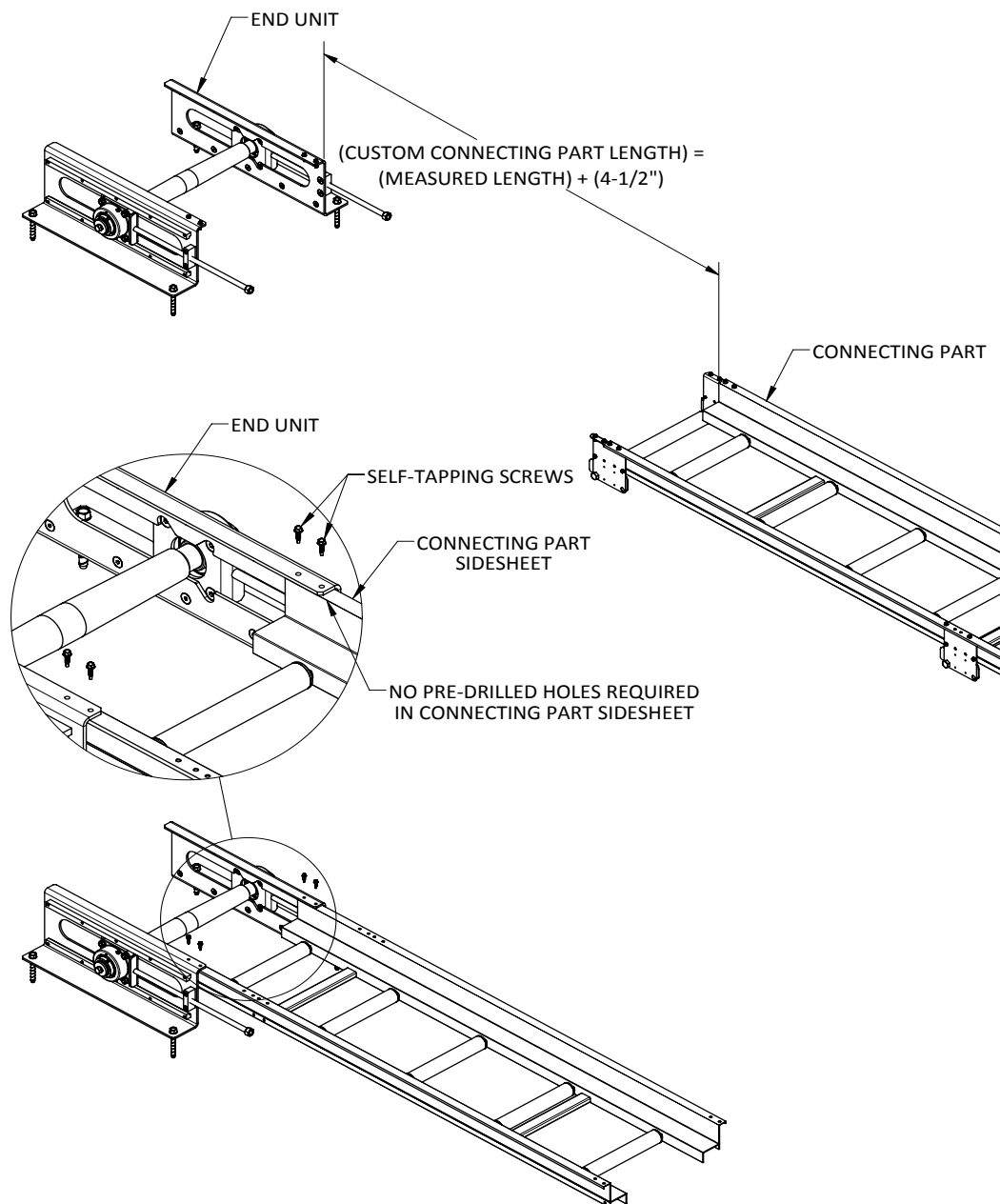


14. Continue installation of Connecting Parts until approaching the End Unit location. Remove the Connecting Plates and Bottom Roller from the last Connecting Part and secure to End Unit with provided Self-Tapping Screws.

Note: If location requires the last Connecting Part length to be modified, use the view below to measure and calculate the proper length after removing the Connecting Plates and Bottom Roller. See next page for proper cutting procedures.

Note: All components must be verified as level and at the correct height before proceeding.

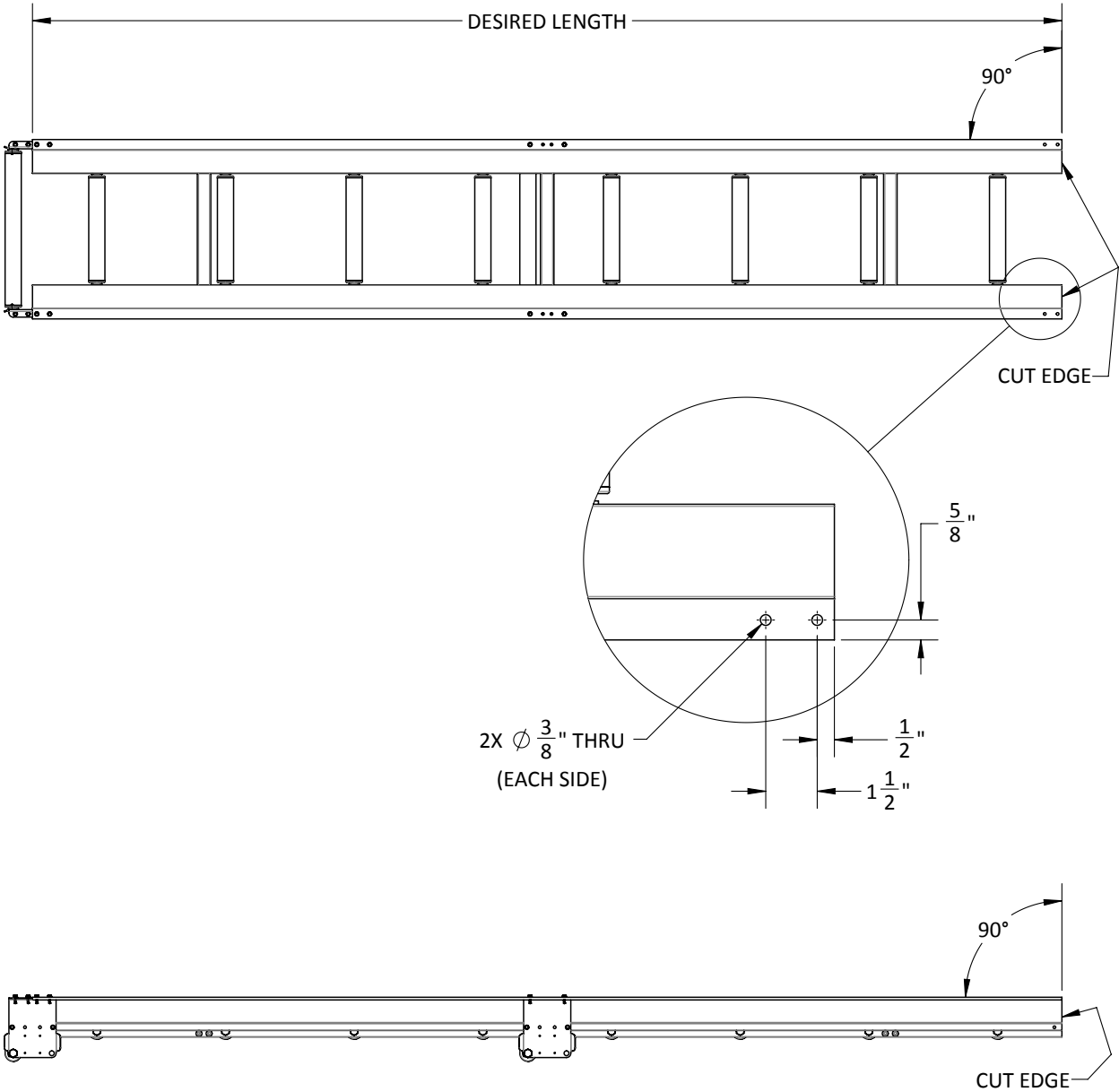
15. Anchor the End Unit.



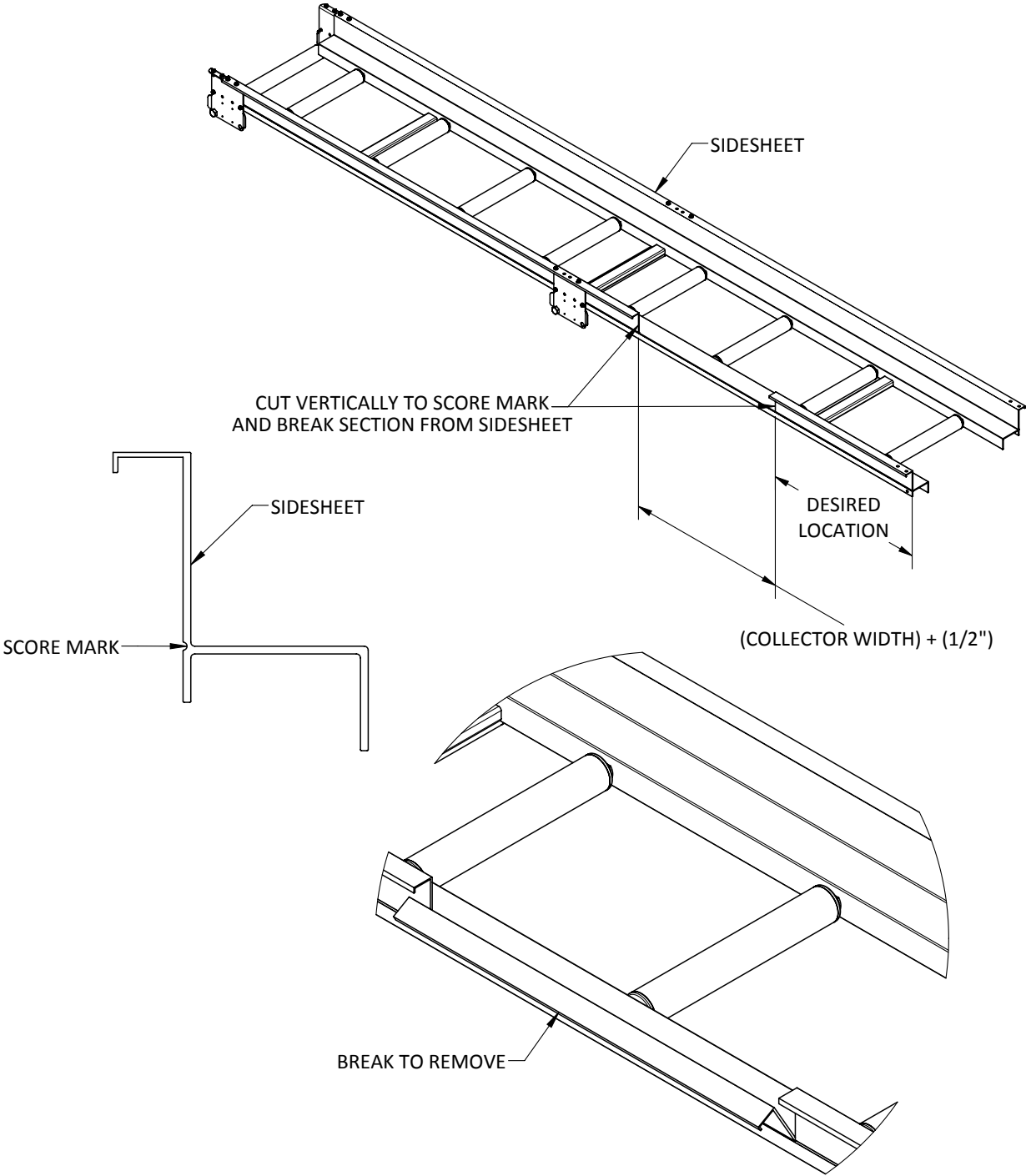
Installation

16. See the view below for modifying the Connecting Part length.

Note: Cut edges must be square to ensure proper belt tracking.

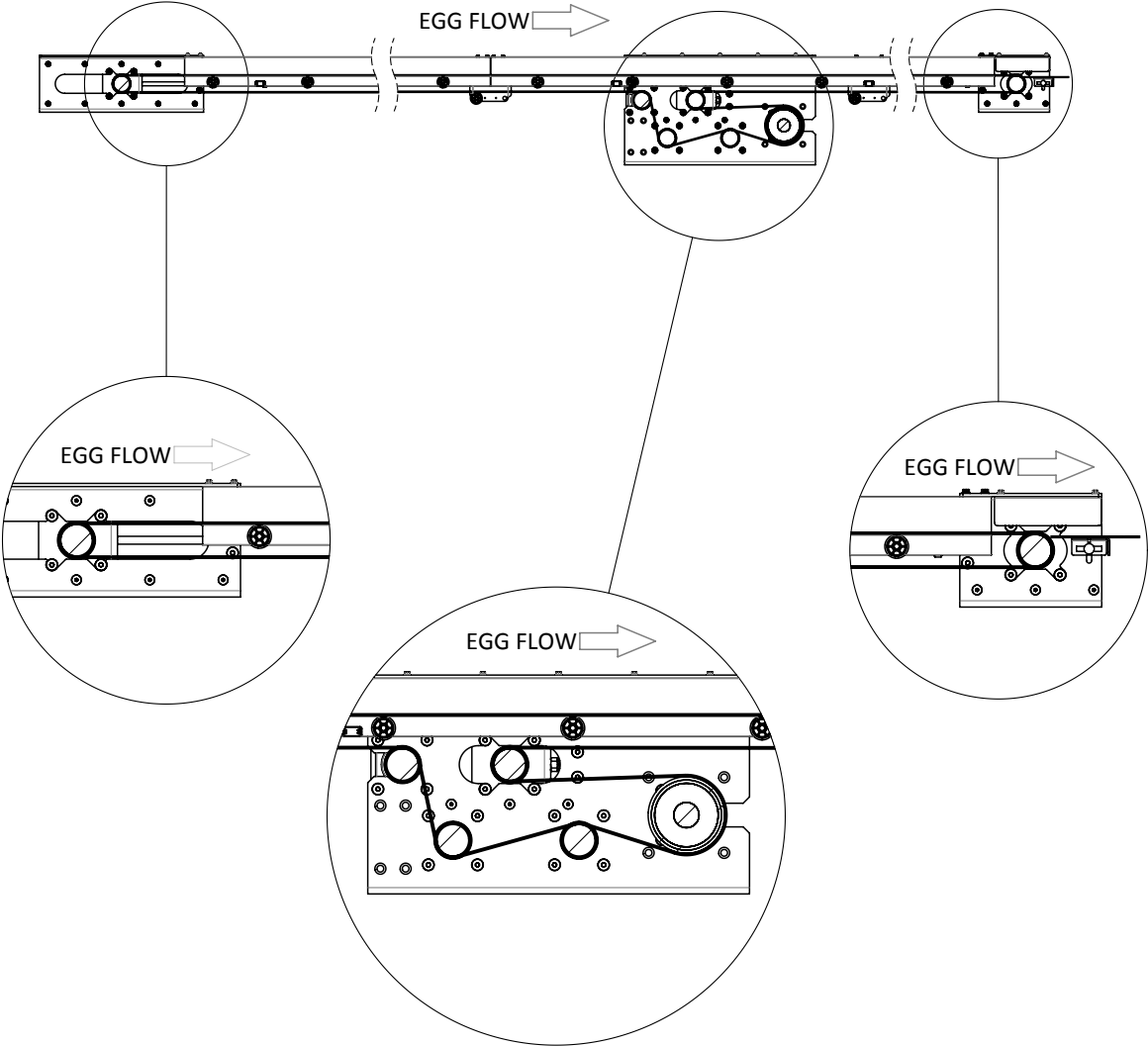


17. Modify Sidesheets as needed for collectors. Measure and mark the Sidesheet for vertical cuts at the desired location, cut sidesheet down to score mark, and break section to remove.



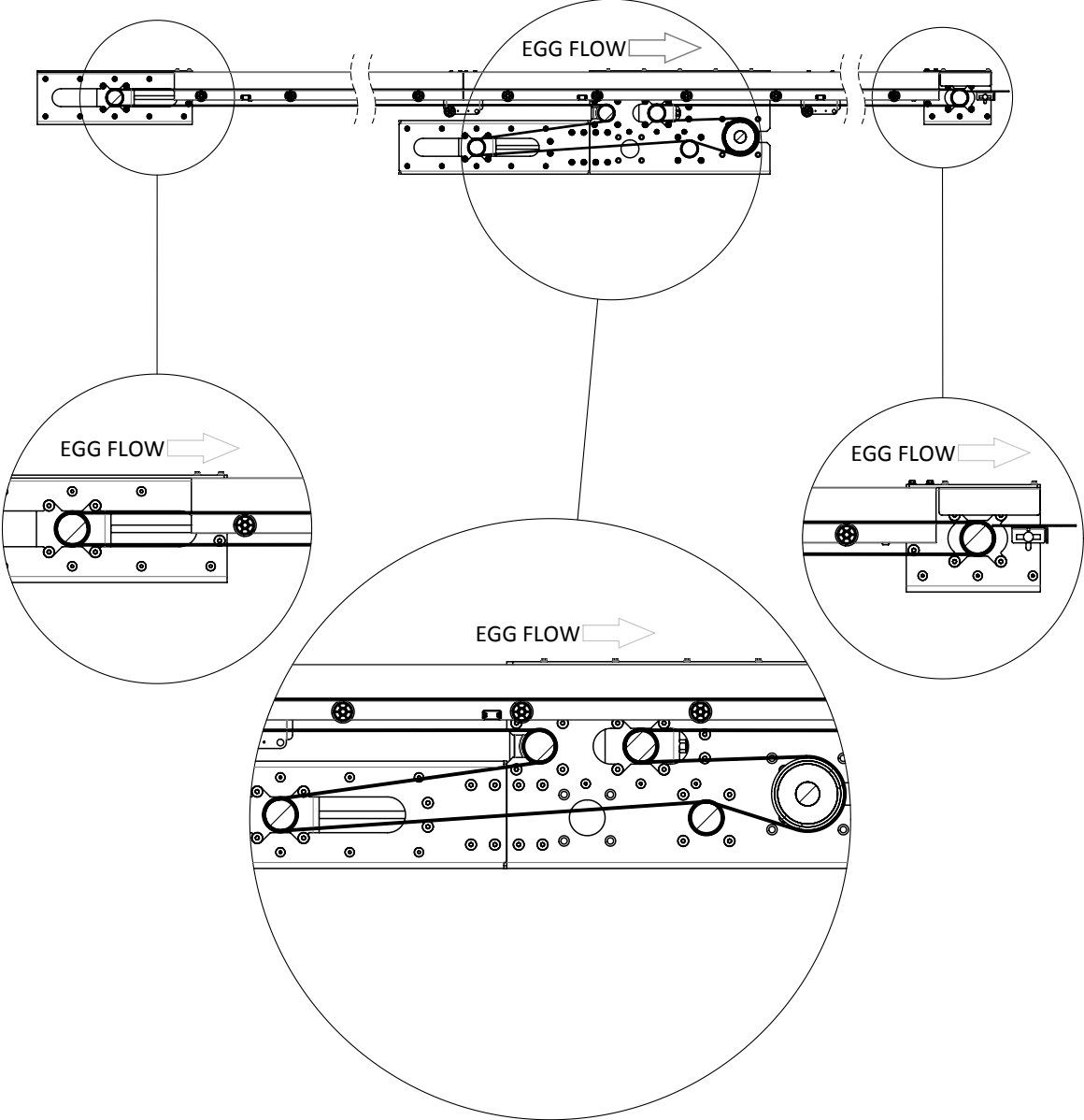
Belt Threading

18. See the view below for belt threading through the major components when no optional Take-up Unit is used.



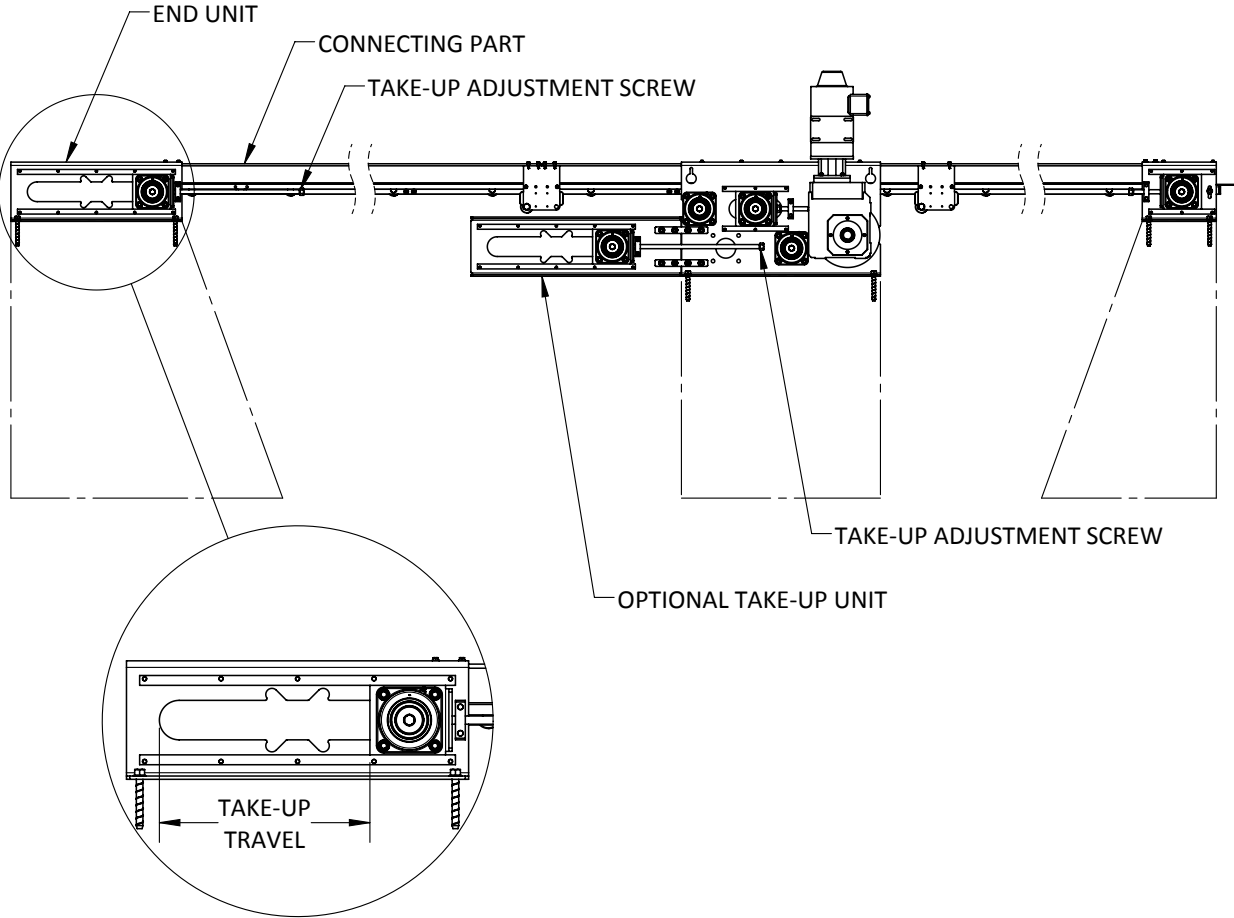
Belt Threading Modular Take-Up (Optional)

19. See the view below for belt threading through the major components when the optional Take-up Unit is used.



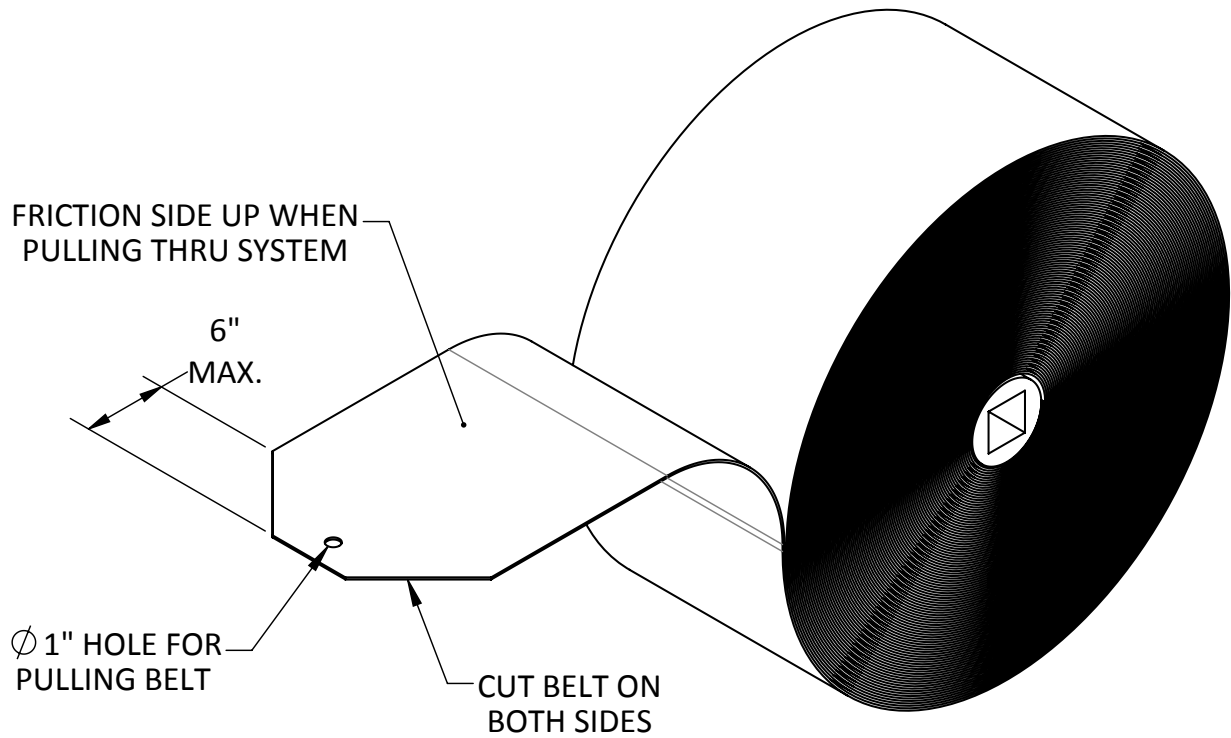
Belt Installation

20. Before threading belt, retract all take-ups within the system.



21. Trim the corners of the belt and add a 1" hole for pulling as shown in the view below.

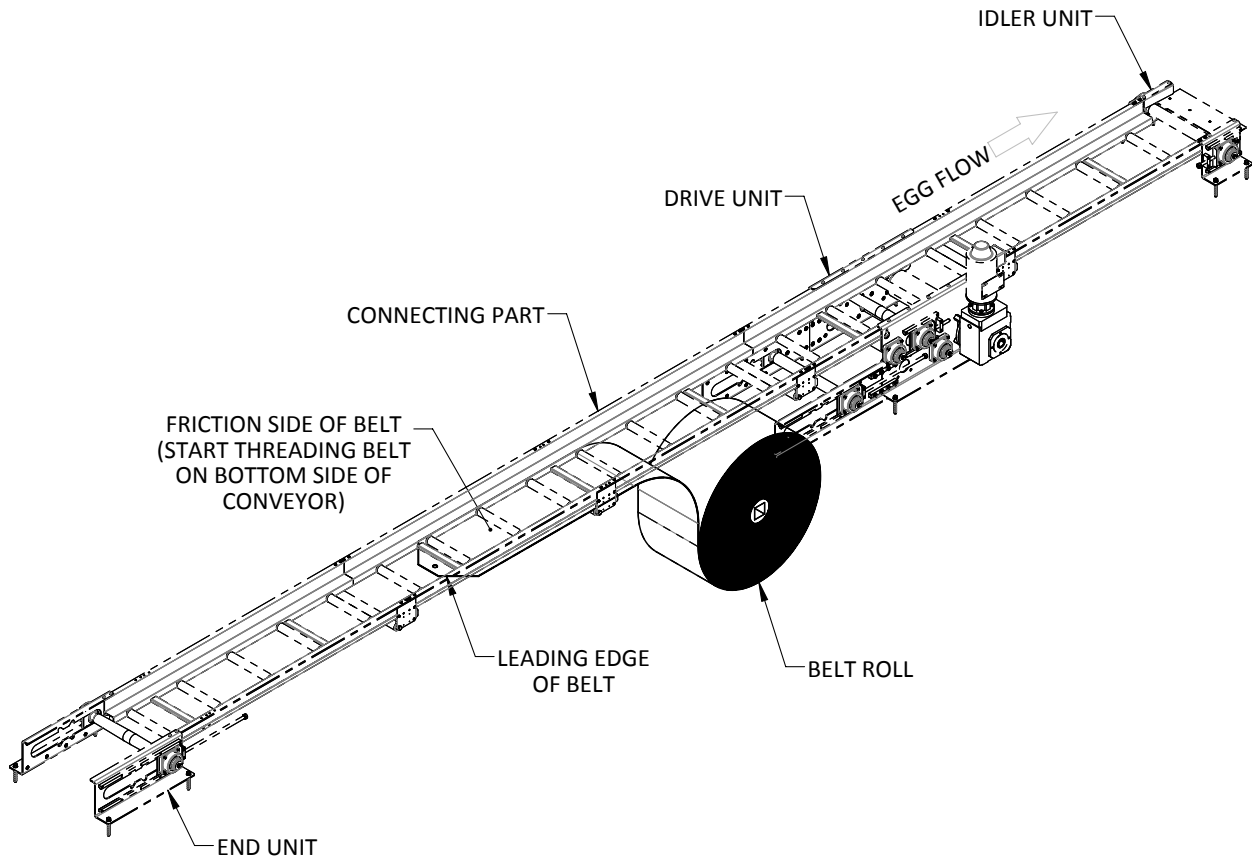
Note: The trimmed corners aid in pulling the belt through the system.



Installation

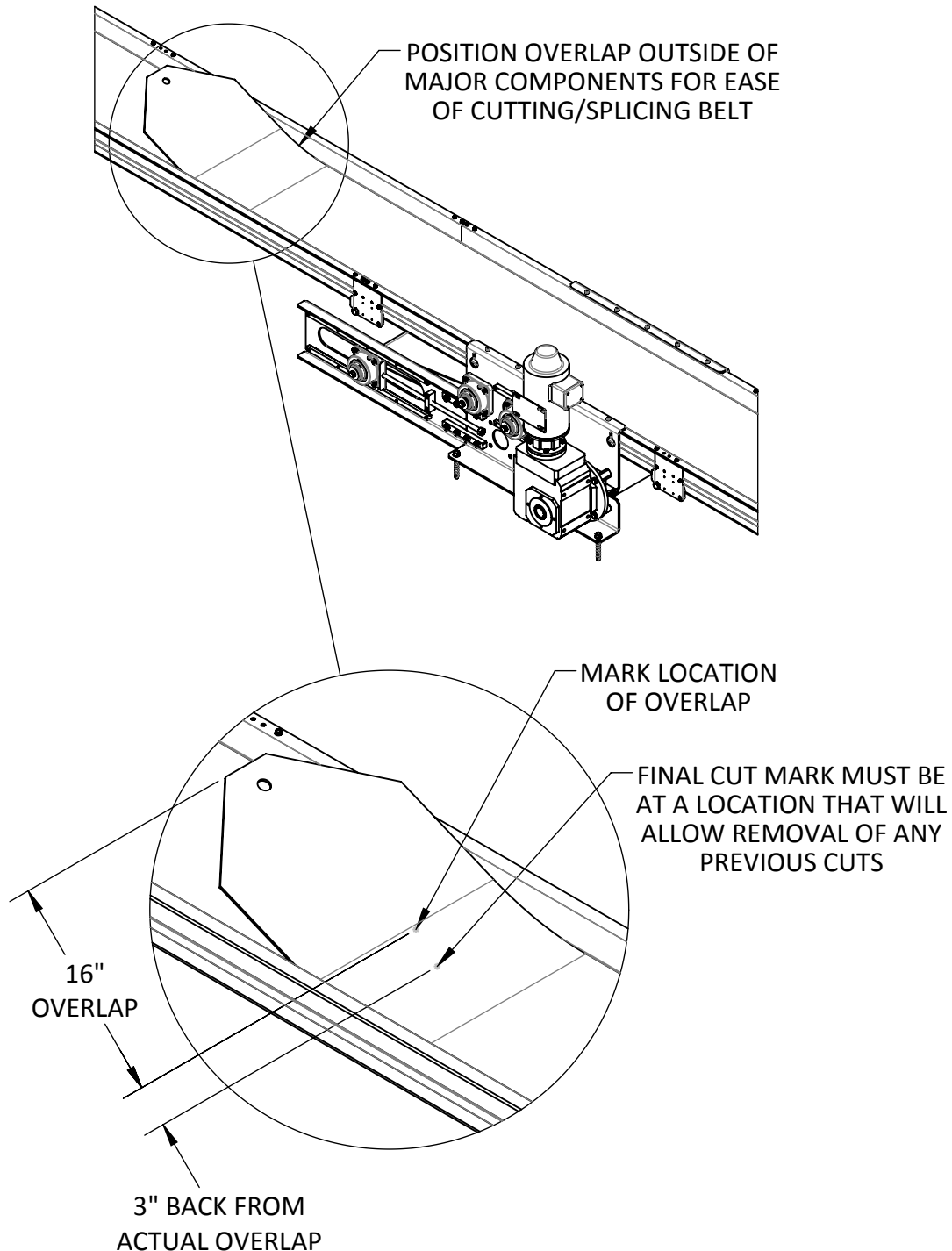
22. Tie the 1" pull rope through the hole in the belt and use to thread the belt through the system.
23. Position the Belt Roll under the system near the Drive Unit and begin pulling the belt on the bottom side toward the End Unit.

Note: The friction side of the belt should face up, see view below.



24. Continue pulling the belt until reaching the Drive Unit on the top side of the system.
25. Uncoil the remaining Belt Roll and feed through the Drive Unit toward the Idler Unit on the bottom side of the system.
26. Continue threading on the top side until all belting is in the system. Edges should overlap by a minimum of 16".

Note: If overlap is more than 16", trim all excess leaving 16" overlap. Remove excess belting.

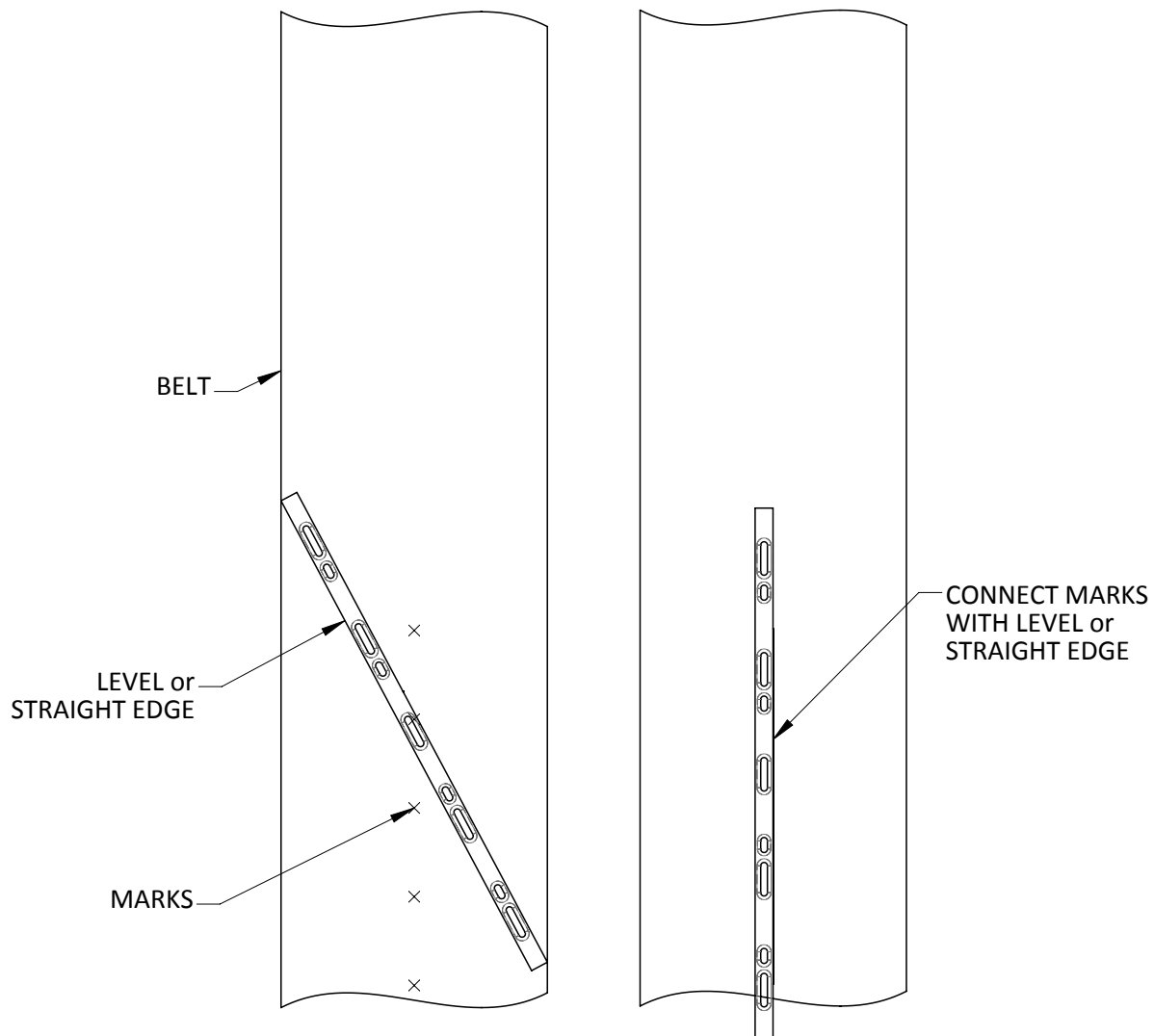


Belt Cutting

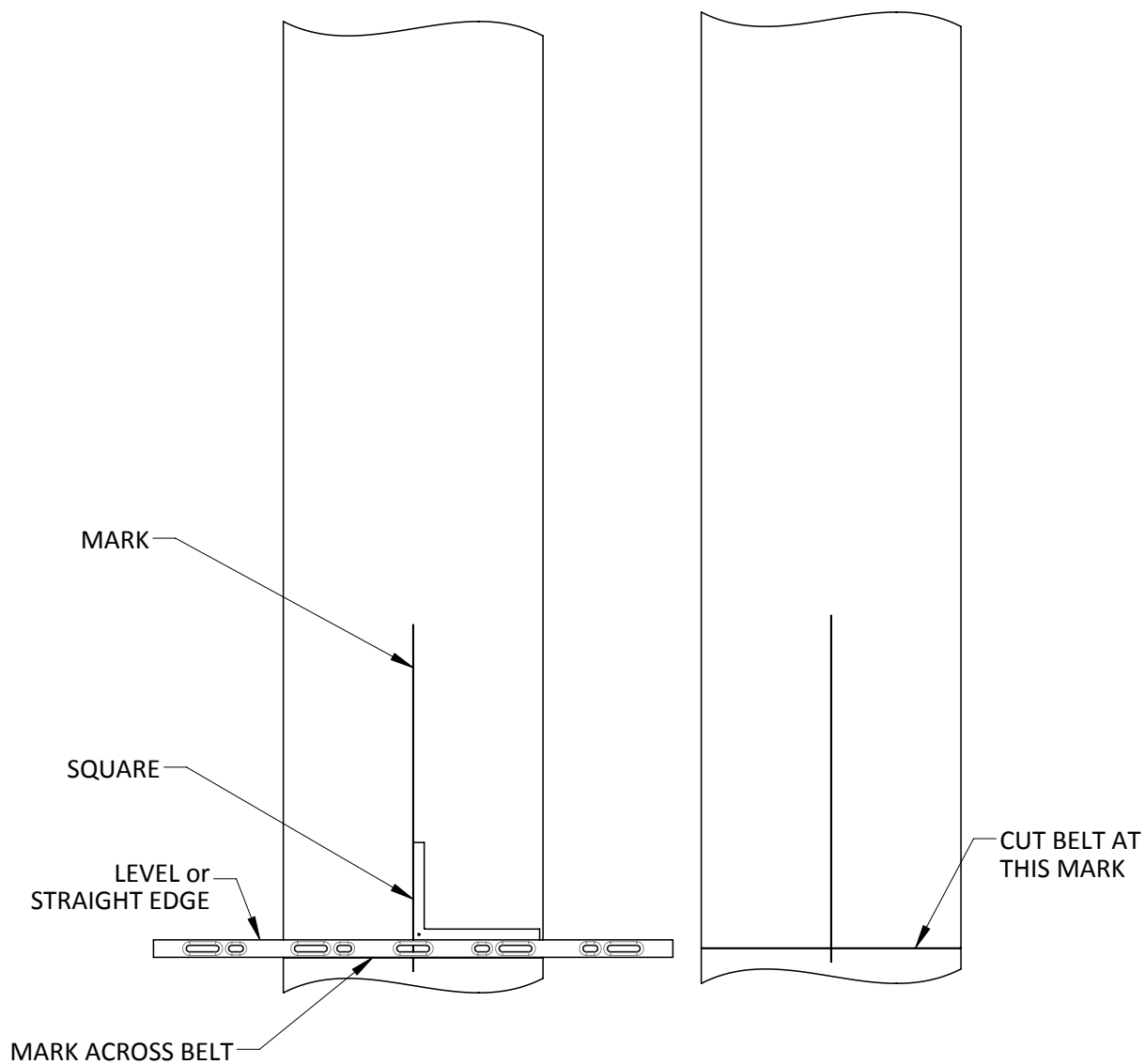
27. Mark the approx. overlap and measure 3" back on both ends of the belt, this will become the final cut locations.

Note: Do not cut belt at this time.

28. On the 6-ft level, mark the approximate center as a reference point.
29. Align the corners of the level with the sides of Belt.
30. Move the level down Belt, transferring marks on Belt that corresponds to the center mark on the level. Ensure the corners of level are aligned with the sides of Belt before each mark is made. A minimum of five marks should be transferred onto Belt.
31. Align level with marks and draw a line. Line is parallel with Belt Travel and does not have to be centered.



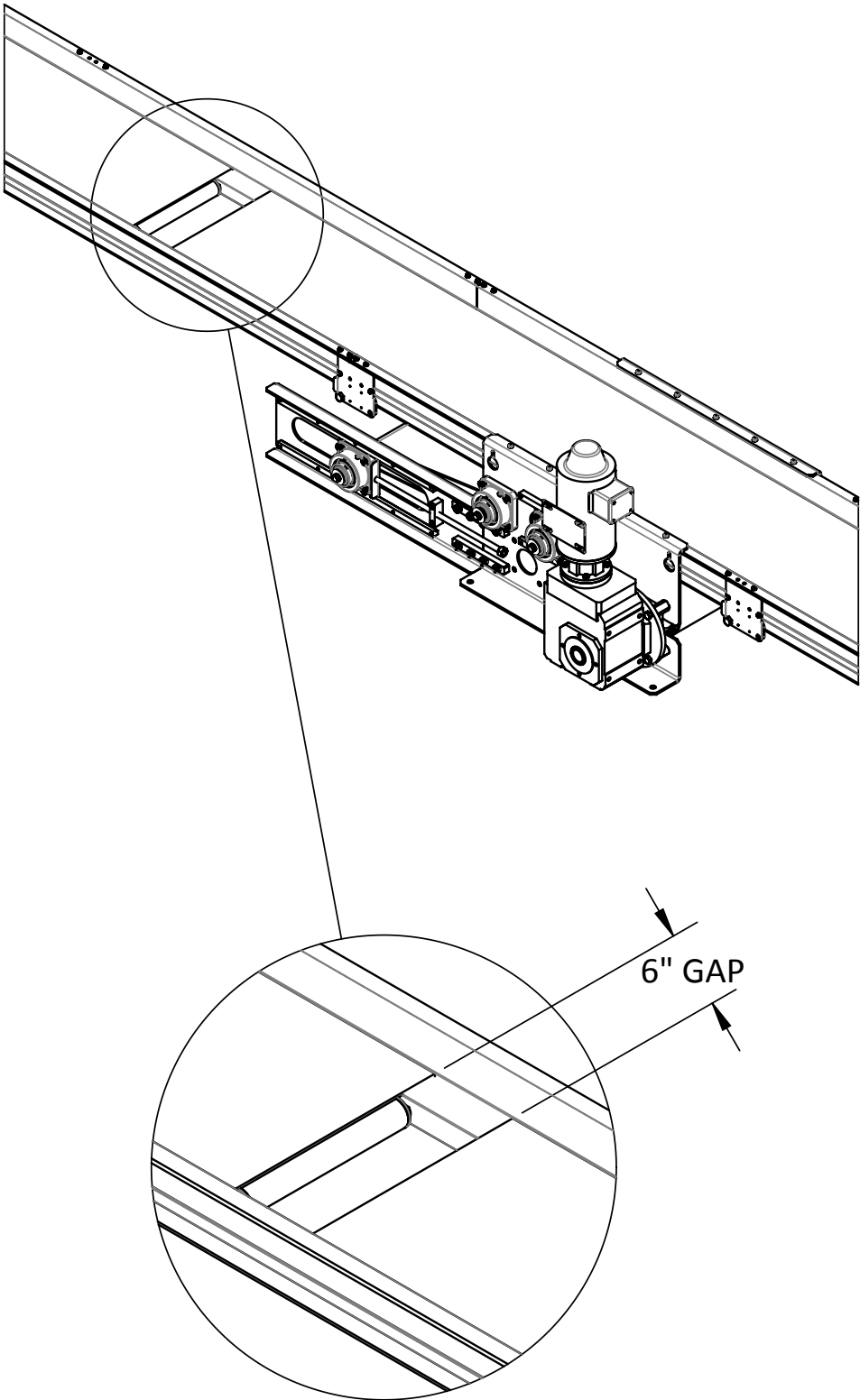
32. Align framing square with parallel line.
33. Align level with framing square and draw perpendicular line at cut location.
34. Use level to ensure straight cut.



Installation

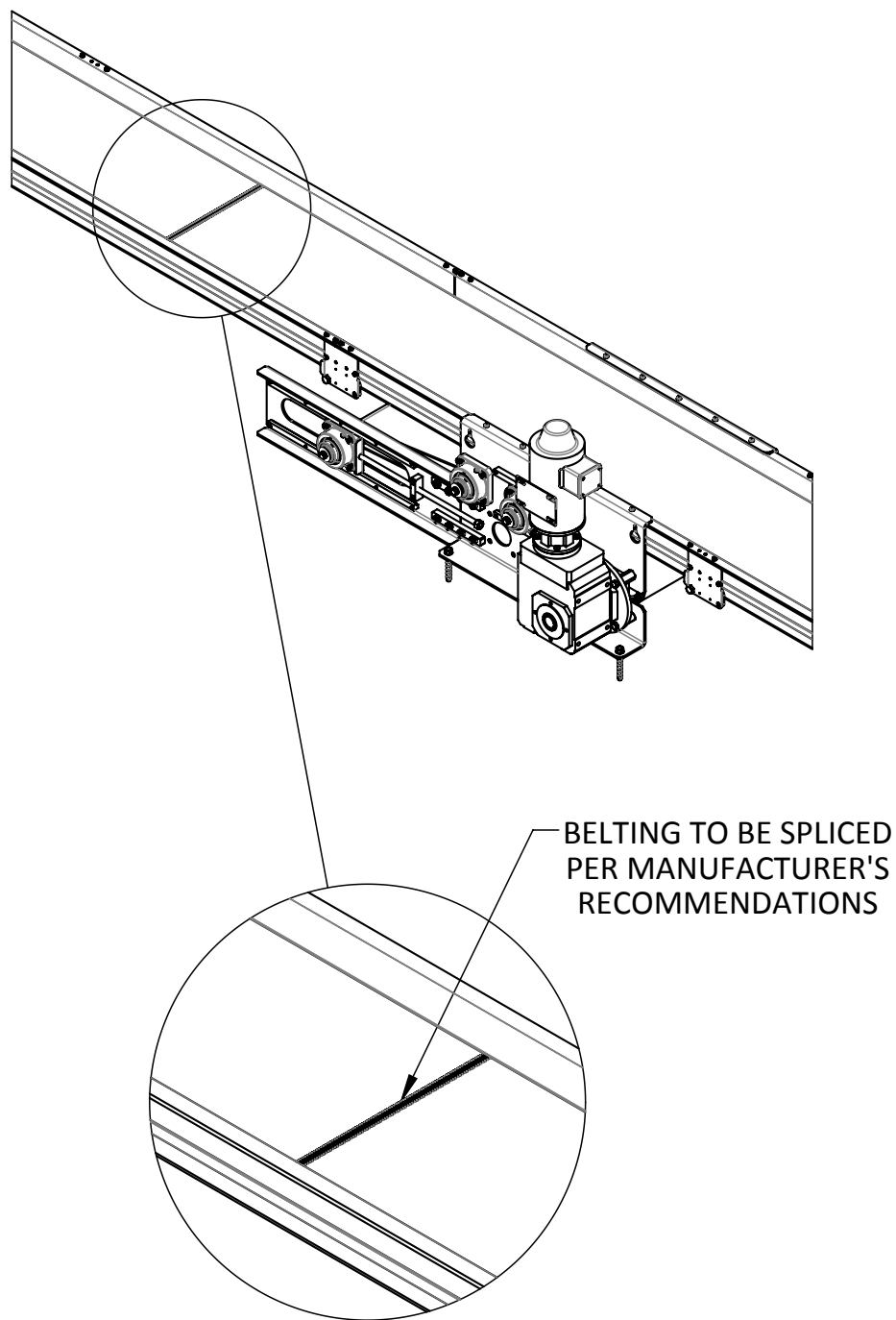
35. After cutting both Belt ends, an approximate 6-inch gap should remain.

Note: This splice area should be located outside the Drive Unit for ease of joining.



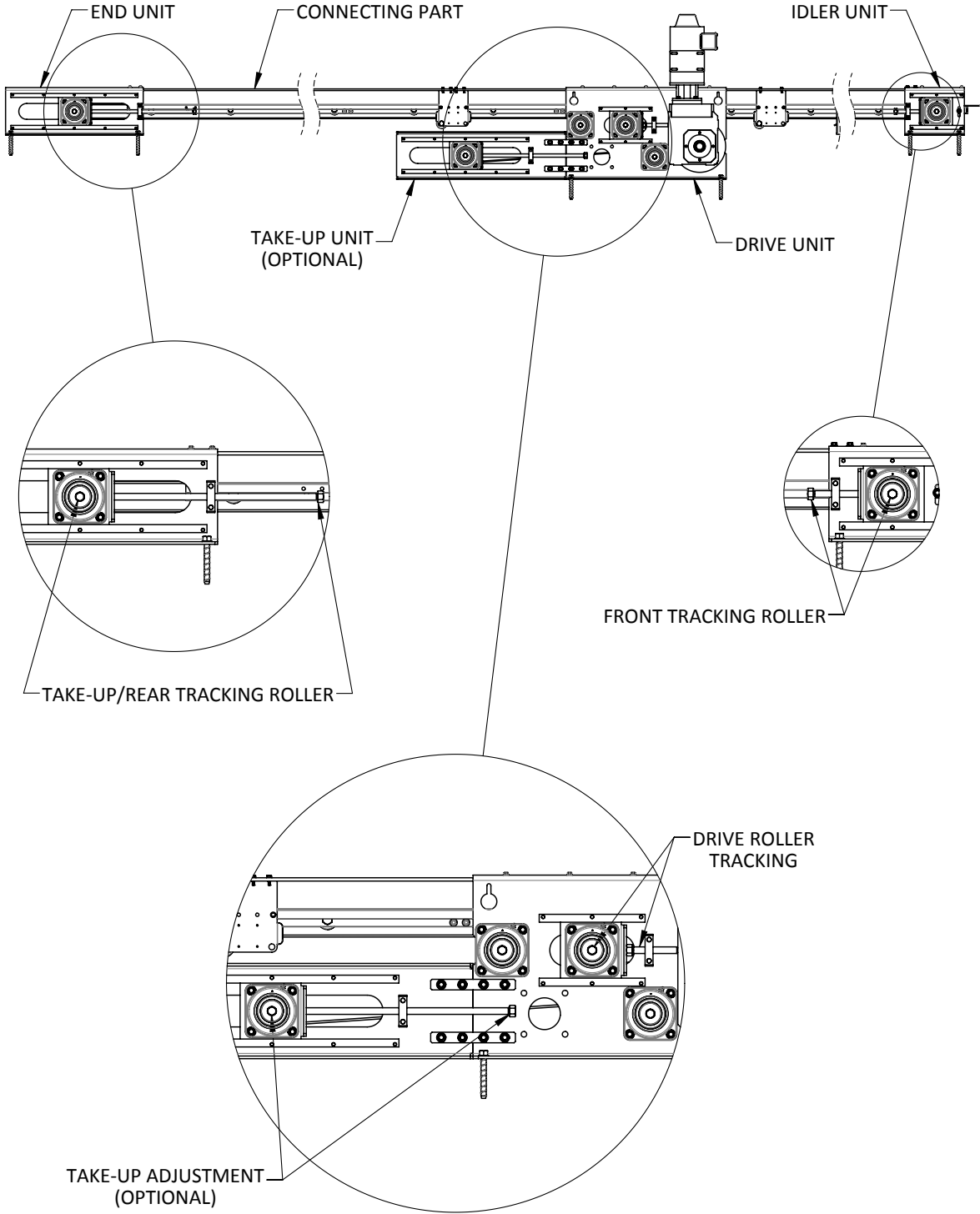
Belt Splicing

36. Refer to Flexco Alligator Lacing manual for proper Belt Splicing procedures.
37. Refer to Flexco Far-Pul HD Belt Clamp manual for proper Belt Joining procedures.



Installation

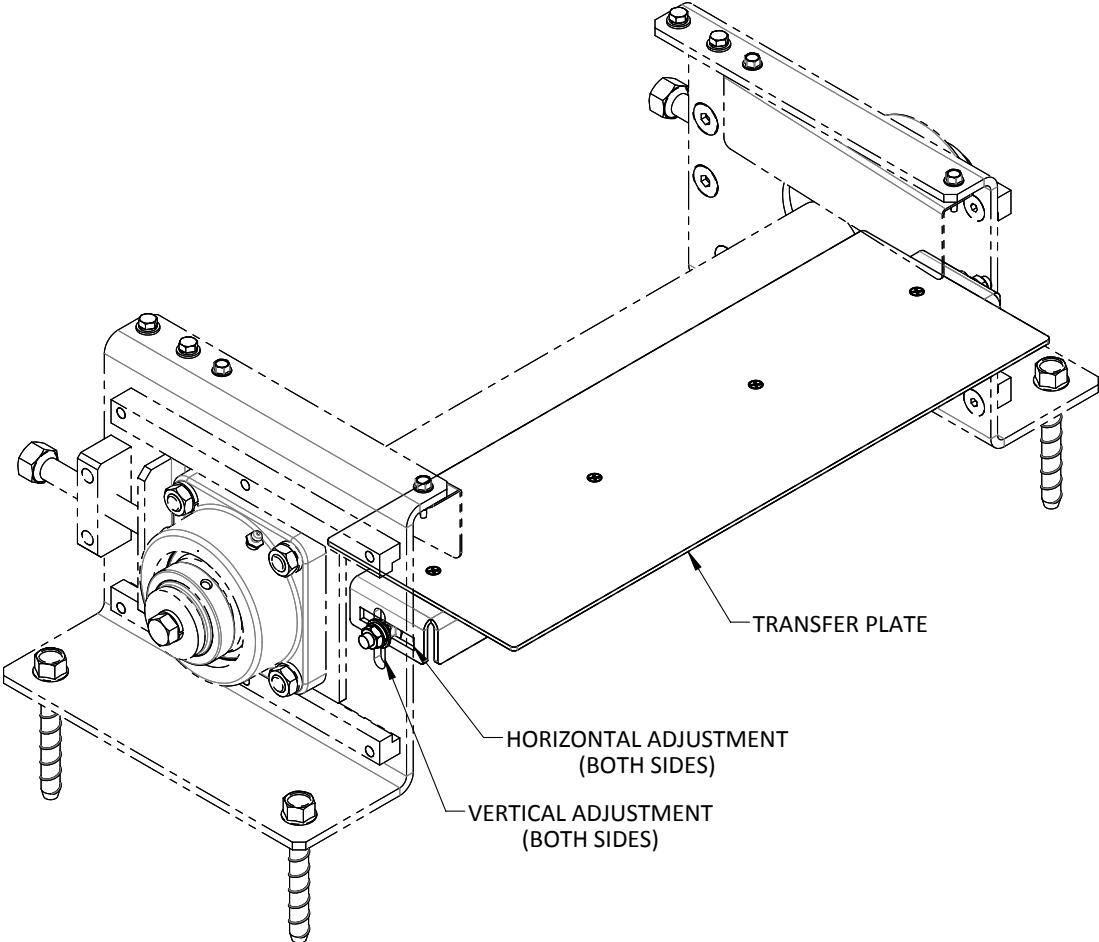
- 38. Tension all Take-ups within the system. It is recommended that all Take-ups be adjusted equally for initial startup.
- 39. Set all Tracking Rollers to be perpendicular to belt travel.



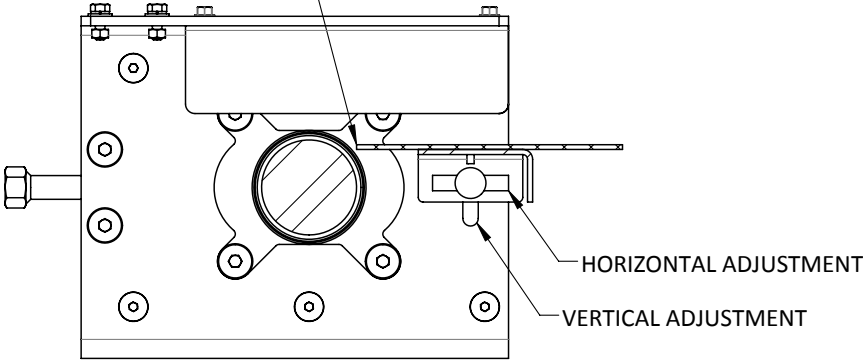
Transfer Plate Adjustment

40. Adjust Transfer Plate for desired transfer.

Note: Transfer gap must allow passage of any belt splice(s) in system.

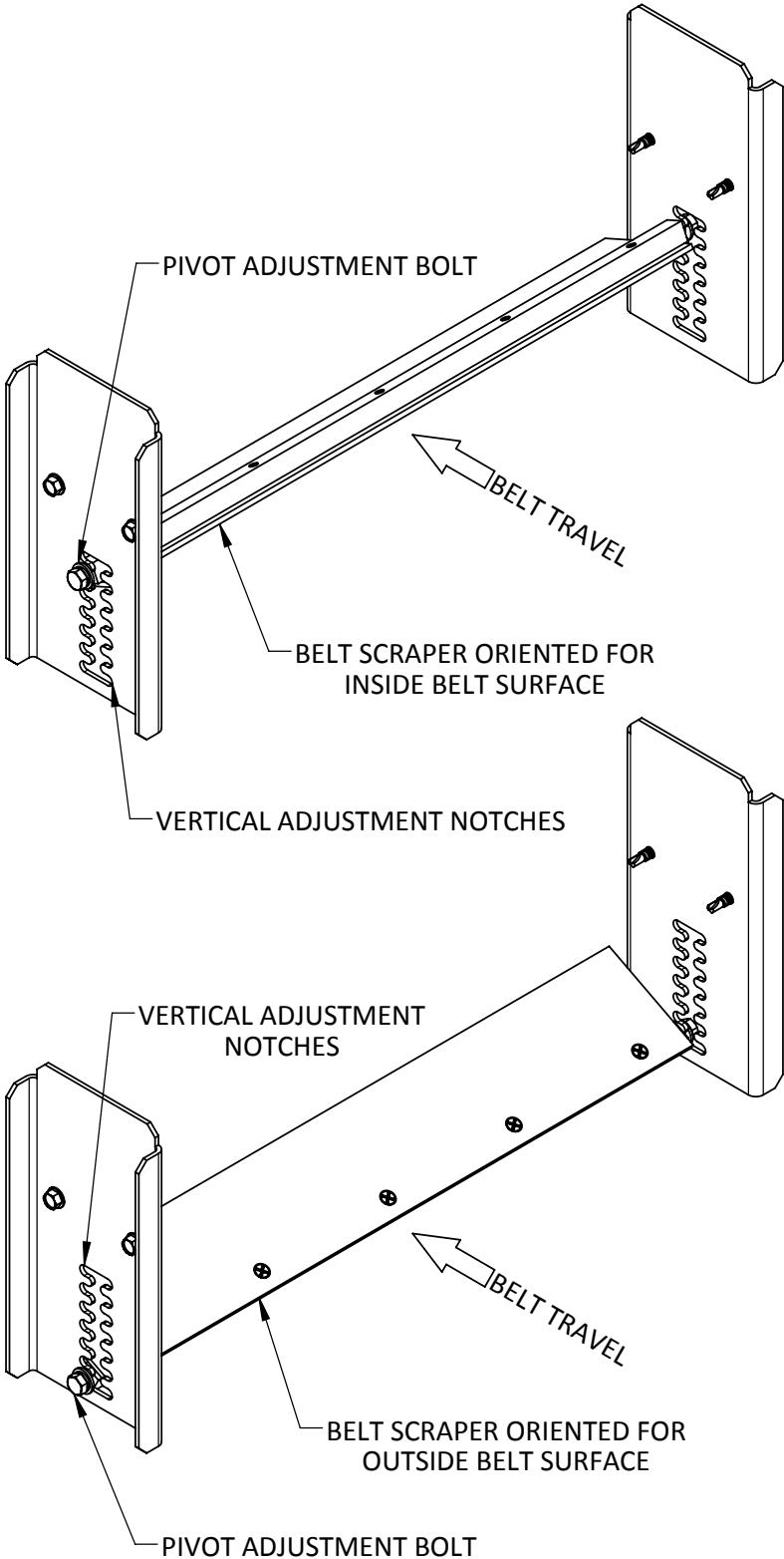


NOTE: GAP BETWEEN BELT AND TRANSFER MUST ALLOW BELT SPLICE(S) TO CLEAR WITHOUT CONTACTING TRANSFER PLATE



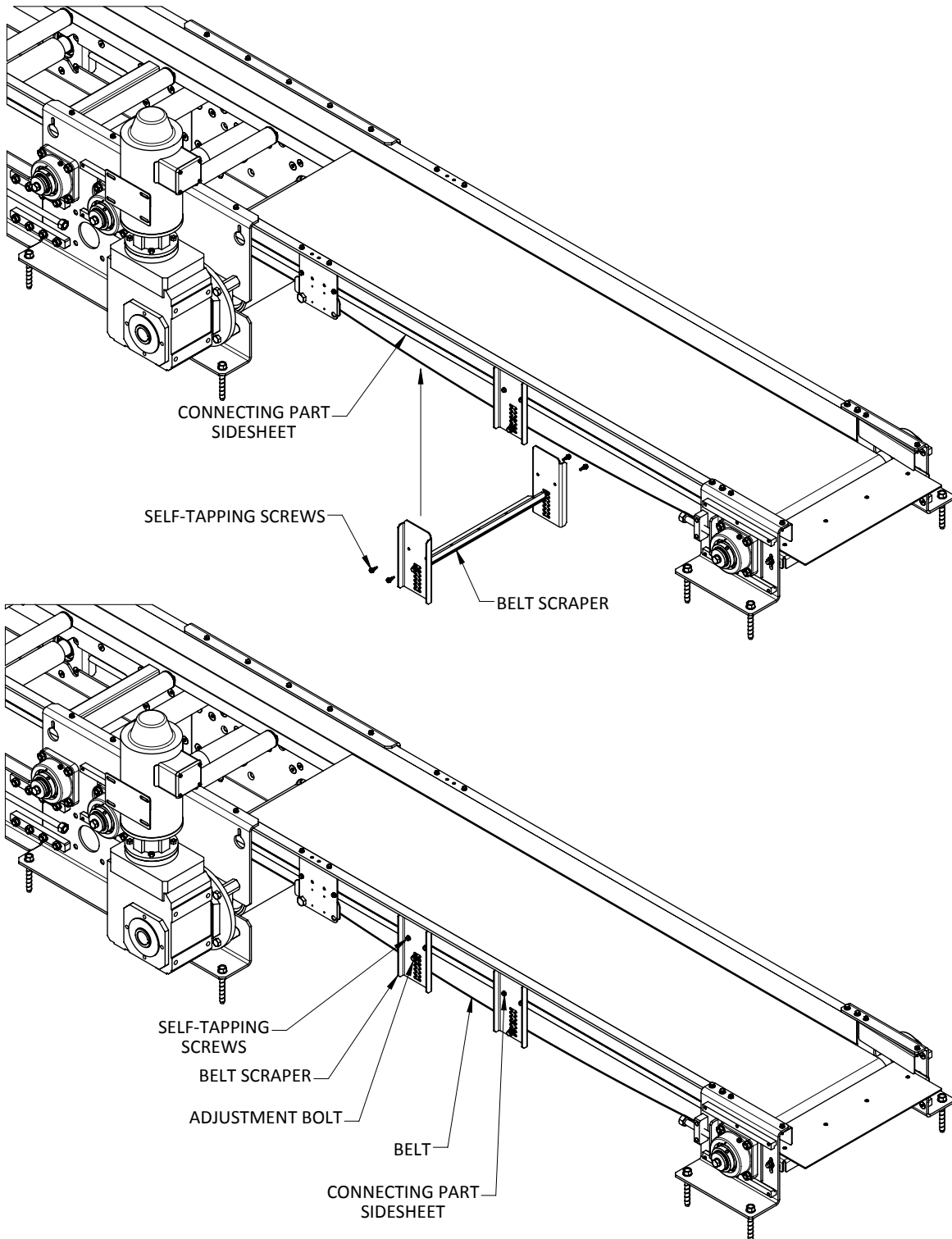
Belt Scraper Installation

41. Belt Scraper assemblies can be oriented for the inside or outside belt surface.



42. Install the Belt Scraper(s) at any location along the Connecting Part Sidesheet using the provided Self-Tapping Screws.

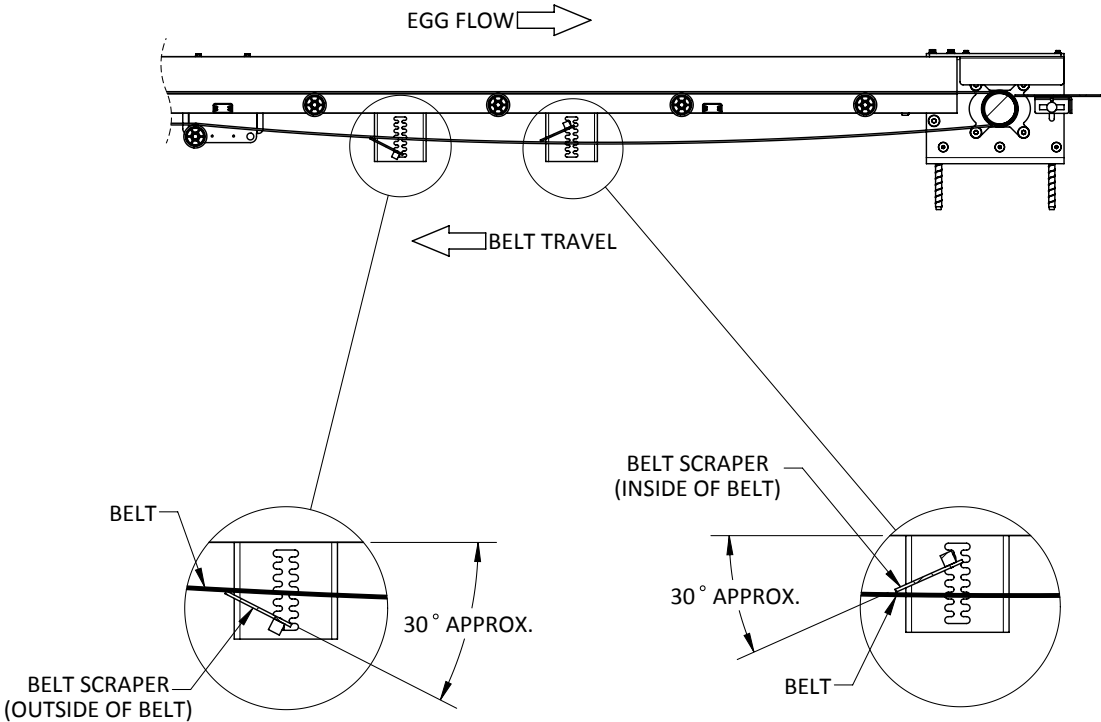
Note: It is recommended that one Belt Scraper oriented for the inside belt surface be installed before the Drive and End Units.



Installation

43. Using the adjustment slots, set the Belt Scraper at approx. 30 degrees from the belt surface.

Note: Any belt splice(s) must pass through the Belt Scraper.



Section 4 Start-Up and Troubleshooting

System Start-Up



Verify electrical and safety systems operate properly before System Start-Up.
Wear necessary Personal Protective Equipment prior to any work.
Observe all Lockout/Tagout procedures prior to performing work on system.

1. Verify components are installed and anchored according to installation manual.

Note: Failure to install system as engineered by Lubing Systems may result in poor performance or damage to system.

2. Clear Belt of foreign objects.
3. Verify all personnel are clear before startup.
4. Set Variable Frequency Drive (VFD) at minimum frequency to ensure slow startup. Place observers at each end and Drive Unit to adjust Belt tracking.
5. Start system at low speed, verify the Belt is centered in the system, and for slippage at the Drive Roller. If slippage is observed, increase pressure at system take-ups.

Note: Failure to start system at low speed could result in damage to Belt or other components of system.

6. Adjust Belt tracking as needed.

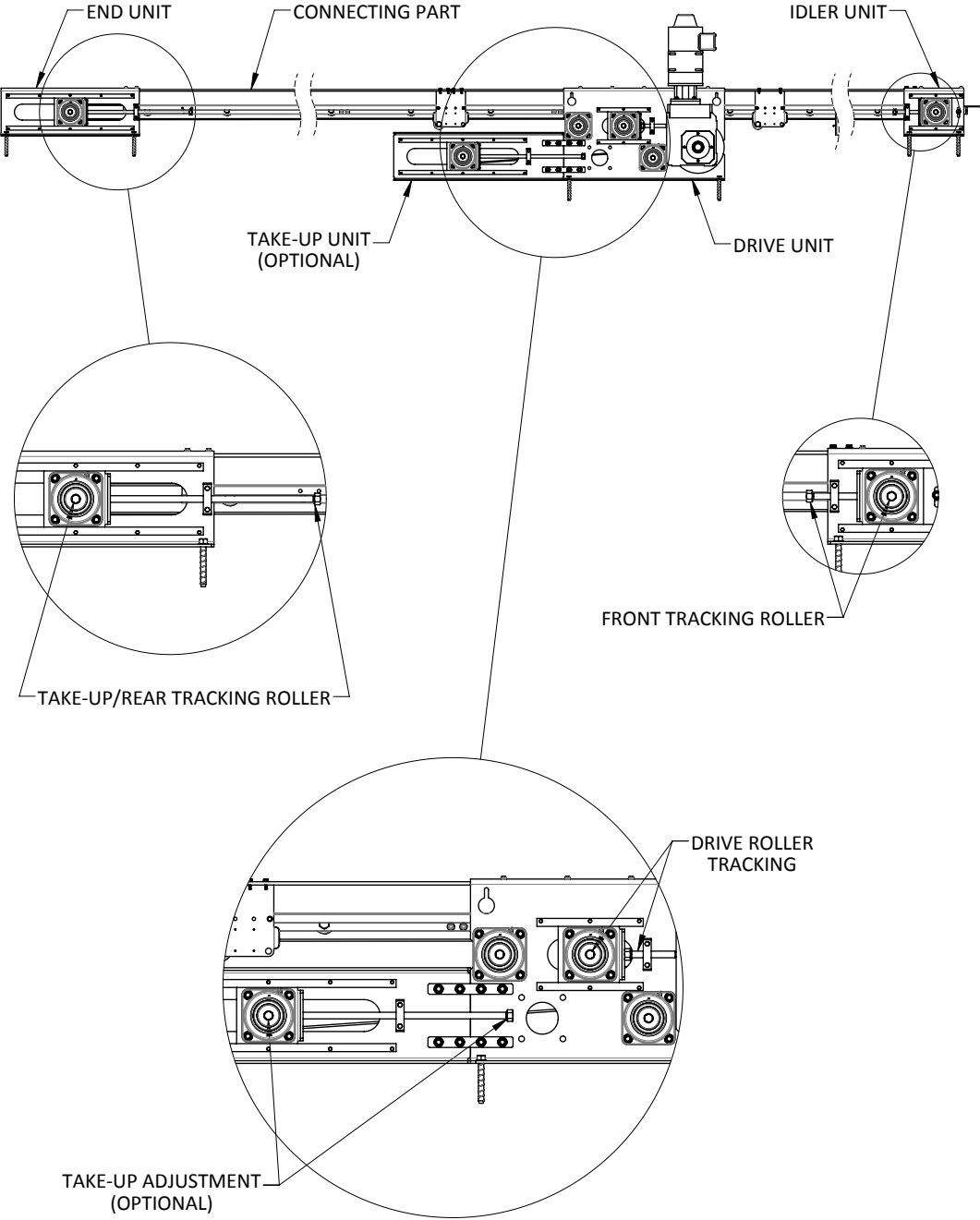
Start-Up and Troubleshooting

Belt Tracking

7. Once Belt is tracking properly, increase speed. Verify tracking remains consistent. Increase speed until desired rate is obtained.



Tracking adjustments at a location affect Belt tracking at that component only.
Tracking adjustments must be performed while system is running.
Make slight tracking adjustments and allow Belt to respond.



Start-Up and Troubleshooting

8. Walk total length of system looking for indications of improper operation. Stop system and resolve any issues.

Note: Stop system if improper operation is observed. Make corrections before re-starting system.

9. With system running, begin loading product onto Belt.

Note: Make adjustments to upstream equipment for smooth transfer of product onto system.

10. Check for issues occurring under load as the product travels completely through the system.

Note: Stop system and correct if needed.

Start-Up and Troubleshooting

Belt Speeds

System Width	Belt Speed	VFD Frequency
18 inch	26 ft/min	60 Hz

System Break-In

Note: The system requires close attention during the first weeks of operation. During this time, inspect the system and adjust as needed to ensure proper break-in. Use the “Break-In Inspection Schedule” on the next page during this period.

Note: The “Break-In Inspection Schedule” should be followed when any new component(s) or belt is added or removed.

Note: The duration of the break-in period will vary based on load, run time, start/stop frequency, and other factors.

Break-In Inspection Schedule

Hourly	Drive Unit	<ul style="list-style-type: none">• Inspect the Drive roller for slippage• Monitor for unusual sounds and/or vibrations• Inspect Belt tracking
	Idler Unit	<ul style="list-style-type: none">• Monitor for unusual sounds and/or vibrations• Verify Transfer Plate adjustment and gap• Inspect belt tracking
	End Unit	<ul style="list-style-type: none">• Monitor for unusual sound and/or vibrations• Inspect Belt tracking
	Belt	<ul style="list-style-type: none">• Inspect Belt edges for wear• Inspect splice(s) for wear
	Connecting Parts	<ul style="list-style-type: none">• Check any suspended components for stability and/or movement• Inspect product transfer at collectors

Start-Up and Troubleshooting

Troubleshooting

General Troubleshooting	Improper belt alignment	<ul style="list-style-type: none">• Ensure no separation has occurred at splices• Inspect Rollers for buildup
	Belt Splice separation	<ul style="list-style-type: none">• Verify clearance at Collectors• Inspect for any contact as Splice passes through system
	Drive Roller slippage	<ul style="list-style-type: none">• Verify Take-Ups are adjusted• Inspect for wear• Inspect Drive Roller for buildup (dry or wet)
	Idler, Drive, or End Unit noise	<ul style="list-style-type: none">• Inspect Unit for loose components or fasteners• Inspect for damaged bearings• Verify all drive components are properly secured
	Excessive dirt on belt	<ul style="list-style-type: none">• Check belt scrapers for proper alignment and contact• Replace Scraper Plate if required
	Product damage	<ul style="list-style-type: none">• Inspect any transfer points for proper adjustment• Verify path is clear through system• Verify Collector cutouts are properly deburred• Check Idler, Drive, and End Units for excessive vibrations and harmonics

Section 5 Maintenance

Preventive Maintenance

- Drive Roller should be checked for buildup before starting. Clean if needed.
- Check Belt Scrapers daily for proper engagement before starting.
- Maintain all bearings through the system per manufacturer recommendations.
- Gearbox and Motor should be inspected and maintained per manufacturer recommendations.

Inspection Schedule

Daily	General	<ul style="list-style-type: none"> • Verify guards and covers are secured. • Inspect Drive Roller for slippage, tension at nearest Take-up if required. • While running, check the entire length for indications of damage or poor operation.
	Drive Unit	<ul style="list-style-type: none"> • Before starting, inspect all rollers for buildup (dry or wet). • While running, monitor for unusual sounds and/or vibrations. • Inspect Belt Scrapers for proper adjustment.
	End Unit	<ul style="list-style-type: none"> • Before starting, inspect all rollers for buildup (dry or wet). • While running, monitor for unusual sounds and/or vibrations. • Inspect Belt Scrapers for proper adjustment.
	Idler Unit	<ul style="list-style-type: none"> • Before starting, inspect all rollers for buildup (dry or wet). • While running, monitor for unusual sounds and/or vibrations. • Inspect Transfer Plate for proper adjustment.
1 to 3 Months	General	<ul style="list-style-type: none"> • Inspect Belt Splices for wear or separation.
	Drive Unit	<ul style="list-style-type: none"> • Inspect the Gearbox for leaks and proper fluid level. • Inspect all bearings for excessive wear. • Inspect roller journals for excessive wear.
	End Unit	<ul style="list-style-type: none"> • Inspect all bearings for excessive wear.
	Idler Unit	<ul style="list-style-type: none"> • Inspect Transfer Plate for wear. • Inspect all bearings for excessive wear.

Inspection Schedule Continued

3 to 6 Months	Drive Unit	<ul style="list-style-type: none"> • Inspect Drive Roller for wear of rubber cladding. • Inspect for loose components or fasteners. • Inspect Belt Scraper, replace Scraper Plate if adjustment does not allow contact with Belt.
	End Unit	<ul style="list-style-type: none"> • Inspect Belt Scraper, replace Scraper Plate if adjustment does not allow contact with Belt. • Inspect for loose components or fasteners.
	Idler Unit	<ul style="list-style-type: none"> • Inspect for loose components or fasteners. • Inspect Transfer Plate for proper adjustment and wear.
12 to 18 Months	General	<ul style="list-style-type: none"> • Clean and inspect all belt contact surfaces. • Inspect Drive Roller for wear of rubber cladding.

Spare Parts

18-in Belt Conveyor Spare Parts

Part Number	Description	Recommended Minimum Qty.
U3S12	Unibar SS Lace 12'	1
USFB5000-111-C	1-11/16" Four Bolt Flange Bearing	2
NYSO93	Nylostainless Pin, 25' Coil	1
740 050 01 00	Belt PVC 120# 18" COSXMSK White	50-ft
13E E 000 00A	Connecting Part, 18-in	1
K403AF109MR140/050 EL5	Gearbox, 109:1 Ratio	1
Y535	Motor, 1hp, 3ph, 1750rpm, Inverter Duty, TENV	1
13E B 000 06A	Transfer Plate, 18-in	1
13E I 000 02A	Scraper Blade, 18-in	2

Section 6 General Information

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