

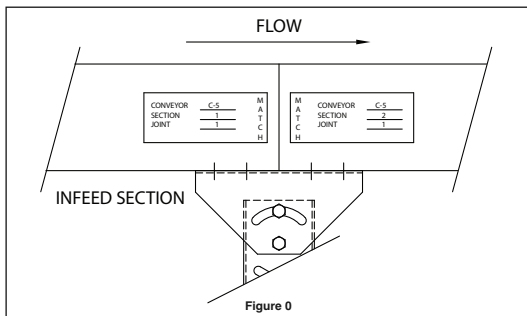
**MODEL "138CLR / 138CLRS / 138CLRSS / 190CLR / 190CLRS / 190CLRSS"
V-BELT DRIVEN - LIVE ROLLER CURVE OR SPUR
ASSEMBLY AND OPERATING INSTRUCTIONS**

RECEIVING INSTRUCTIONS

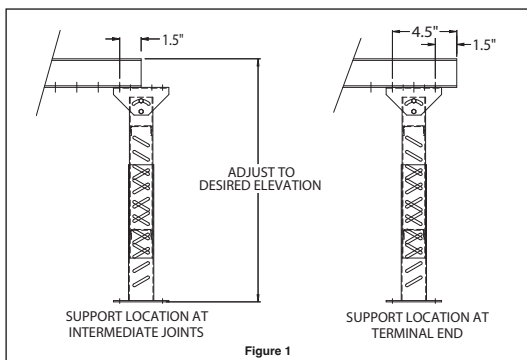
- 1) Prior to uncrating the equipment, check the number of crates, boxes, skids, etc. received against the freight bill to insure that all items shipped are on the job site.
- 2) Check to see that none of the equipment was damaged in transit. If damages occurred, note damages on freight bill and immediately contact the motor carrier and file claim for the damages.
- 3) Transport conveyors on their skids as near the installation site as possible.

INSTALLATION INSTRUCTIONS – MECHANICAL

- 1) Remove conveyor sections from their skids and place upside down on floor in proper sequence based on the match mark identification on the conveyor sections. (See Figure "0" for clarification).



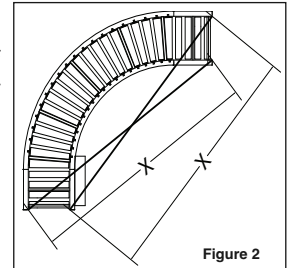
- 2) Beginning with the first section in match mark sequence, bolt a support at each end (See Figure "1" below), leaving a space for the second bed section on pivot plate. Finger tighten bolts only and turn section over to place into position.
- 3) Do not wrench tighten bolts until unit is assembled, aligned, and lagged to the floor.



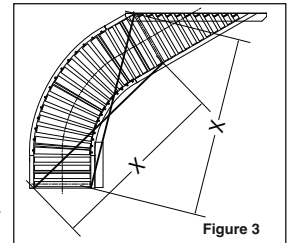
4) SQUARING:

These measurements must be within 1/4" of each other (between frames), to insure the curve or spur is square.

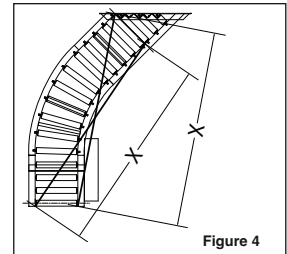
- **FOR CLR (CURVE):**
Measure the distance from each diagonal corner of the "CLR" curves. (See Figure "2" right)



- **FOR CLRS (CURVE SPUR):**
Measure the distance from the right angle end/inside corner to the outside corner. Then measure the distance between the outside right angle corner and the point on the inside rail corresponding to the corner from the previous measurement - between the same rollers (exact point found by measuring distance from center of last long roller to end of outside rail, See Figure "3", right).



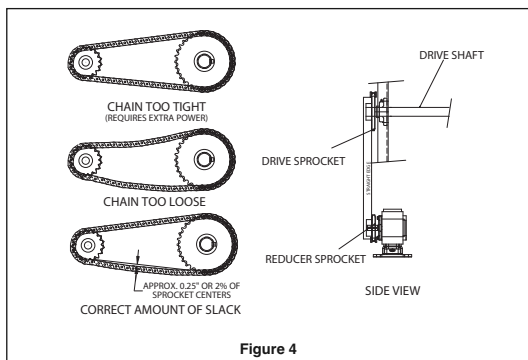
- **FOR CLRSS (STRAIGHT SPUR):**
Measure the distance from the right angle end on long side to the angled end on the short side. Then measure the distance between the other right angle end and the point on the long side rail corresponding to the corner from the previous measurement - between the same rollers (exact point found by measuring distance from center of last long roller to end of outside rail). (See Figure "4", right).



- 6) Place level across width of conveyor to ensure that conveyor is level.
- 7) Install lag bolts (not furnished) through holes in support feet. Wrench-tighten all bolts and recheck alignments.
- 8) Although these conveyors have been factory adjusted and should operate satisfactory as received, the following should be checked before start-up.
 - a) When conveyor is stopped the tread rollers should turn with a slight touch of your fingers.
 - b) The V-belt should be seated in all sheaves without any twist.

OPERATING INSTRUCTIONS – ELECTRICAL

- 1) Before the electric motor is started, check the following items:
 - a) Proper plant voltage is connected to motor.
 - b) Our standard speed reducer is a completely sealed unit shipped with proper oil from the factory, and does not require checking. However, see other special instructions that come with the reducer.
 - c) Drive chain tension, to be sure drive train is tight enough (see Figure "4" below).
 - d) Conveyor can now be started.



REPLACING V-BELT

Refer to page 3 (PARTS LIST).

- 1) Cut off old v-belt.
- 2) Loosen all pressure sheaves.
- 3) Loosen take-up sheave.
- 4) Thread new belt in pressure sheave and tighten pressure sheaves only tight enough to hold v-belt in groove. Do not use too much pressure.
- 5) Thread belt around tension sheaves and take-up.
- 6) Tighten take-up only enough for belt to drive rollers. Do not over-tighten.
- 7) Conveyor is ready to re-start. Rollers should turn with light touch of fingers. Belt around take-up should be only tight enough to drive conveyor.

SAFETY INFORMATION

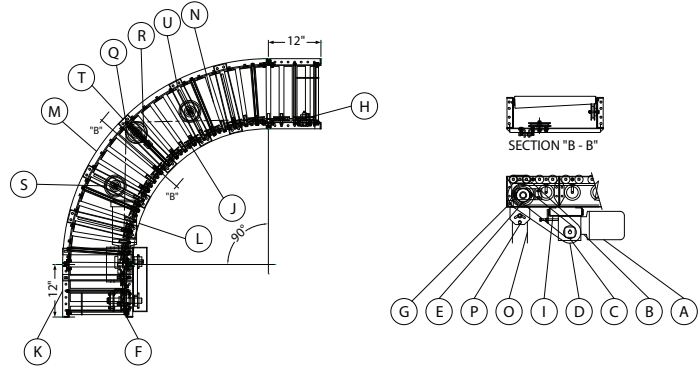
- 1) After completion of conveyor installation and **BEFORE** operation, personnel operating the conveyor must be properly trained in its use. It is recommended these employees be walked through the proper sequence of starting and stopping the motor drive, shown where hazardous areas exist along the length of the conveyor (identified by safety labels attached to the conveyor frame and drive guards) and correct loading and unloading methods. Make sure safety labels are legible and that personnel understand their meaning.
- 2) Conveyor should **NEVER** be operated with any of the safety guards removed as physical harm could come to the user. All pinch points of the conveyor are guarded and also identified by safety labels attached in the guarded pinch point area. Instruct users to turn the conveyor off and notify the proper personnel should a guard be missing and the conveyor is running.
- 3) Only qualified maintenance personnel should perform work on the conveyor. Should the unit require maintenance, **disconnect conveyor motor drive from power source before attempting to adjust or repair conveyor**. If guards were removed to perform the maintenance task, they must be replaced before attempting to operate conveyor. If guards are damaged and become unusable they must be replaced. Locate the conveyor's serial number plate, which is mounted near the motor drive, and contact your ACSI distributor for a replacement. He will need the serial number of the conveyor to secure the correct guard.

PREVENTATIVE MAINTENANCE

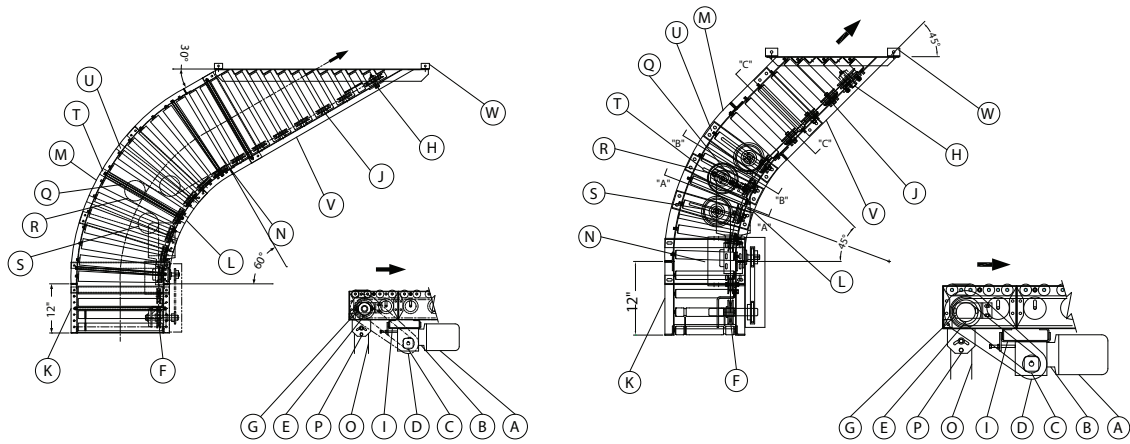
(See Lubrication and Maintenance Check List for more details.)

- 1) DRIVE CHAINS - Every 500 hours - Wipe off grease with solvent and apply clean SAE 20 motor oil. Check tension on main drive chain (1/4" - 2% (of sprocket centers) movement midway between sprockets). Use straight edge and check sprocket alignment.
- 2) ELECTRIC MOTOR - Every 1000 hours - Remove grease plugs (if supplied on motor) and grease motor bearings sparingly with ball bearing grease.
- 3) SPEED REDUCER - Every 750 hours - Remove filler and drain plugs. Flush and refill with lubricant suggested by reducer manufacturer.
- 4) TREAD ROLLERS - Every 500 Hours - Make sure all rollers turn freely. Replace any that are dented, warped, binding, etc.
- 5) FLANGE MOUNTED BEARINGS (PULLEYS) - Every 1000 hours - Grease pulley bearings through grease fittings using grease gun. CAUTION: Do not over grease.
- 6) ENTIRE CONVEYOR - Daily, weekly. - Look for any abnormal action of conveyor, oil leaks, unusual noises, etc. Repair at once.

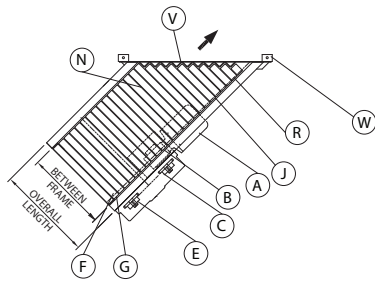
- PARTS LIST -
138CLR / 138CLRS / 138CLRSS / 190CLR / 190CLRS / 190CLRSS



CLR (CURVE)



CLRS (CURVE with SPUR)



CLRSS (SPUR)

(A) ELECTRIC MOTOR	(N) TREAD ROLLER
(B) GEAR REDUCR	(O) FLOOR SUPPORT
(C) REDUCER SPROCKET	(P) FLOOR SUPPORT PIVOT PLATE
(D) CHAIN GUARD	(Q) TAKE-UP ADJUSTMENT BOLT
(E) DRIVEN SPROCKET	(R) TAKE-UP SHEAVE
(F) DRIVE SHEAVE	(S) GUIDE SHEAVE
(G) FLANGE BEARING	(T) TAKE-UP SHEAVE MTG RAIL
(H) TAIL SHEAVE	(U) GUIDE SHEAVE MOUNTING RAIL
(I) MOTOR BASE	(V) SPUR FRAME WELDMENT
(J) PRESSURE SHEAVE	(W) SPUR ATTACHMENT BRACKET
(K) TANGENT RAIL	(X) CROSS BRACE
(L) INSIDE RAIL	
(M) OUTSIDE RAIL	



NOTES:

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