

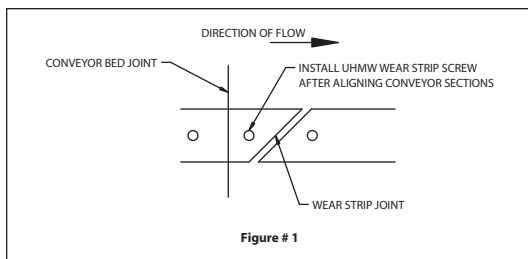
**MODEL "SL" SLAT CONVEYOR
ASSEMBLY AND OPERATING INSTRUCTIONS**

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

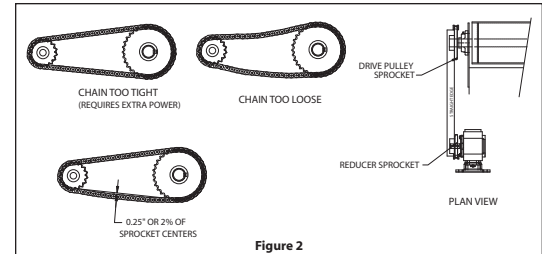
- 1) Remove conveyor sections from their skids and beginning with infeed section, place sections in proper sequence based on the match mark identification located on the conveyor sections. The lowest match mark number will be the infeed section with numbers increasing towards discharge section.
- 2) Set desired elevation as sections are installed, using leveling bolts on bottom of supports. Only finger tighten joint connection bolts at this time.
- 3) Continue this procedure until all sections are installed.
- 4) Pull a string or wire down one side full length of conveyor to make sure conveyor is perfectly straight. Using a level, make sure conveyor sections are level across width and length. If conveyor is extremely long, it may be easier to level conveyor length with a transit.
- 5) Once conveyor has been leveled and aligned, tighten all bolts and nuts securely and lag conveyor to floor.
- 6) One end of UHMW wear strip, which is attached to upper chain track, is cut on a bias and extends into next section. Secure this end of wear strip with 5/16" x 1-1/4" bolt supplied with unit. (See Figure "1")



DRIVE INSTALLATION

- 1) The Model "SL" is equipped with a floor mounted drive unit as standard. Position motor/reducer base along the side of the conveyor discharge section (this is side which has drive shaft extension), with drive chain looped over reducer and drive sprockets. Make sure drive chain adjustment screws are at minimum adjustment so that the full range of chain adjustment will be available. Take slack out of chain by moving motor/reducer base away from drive shaft, towards infeed section. Align

reducer sprocket and conveyor drive shaft sprocket with straight edge (see Figure "2"). Move the motor base on the floor to accomplish this alignment.



- 2) Once motor/reducer alignment has been accomplished, lag base to floor with lag bolts, sized for holes in base plate. (Bolts not provided.) Recheck sprocket alignment.
- 3) Tighten drive chain to proper tension. (See Figure "2")
- 4) Speed reducer has been filled with oil at factory. However, before motor is started, remove pipe plug located near center of reducer housing and check oil level. If oil is required, fill to proper level in accordance with instruction sheet supplied with reducer.
- 5) Install chain guard.
- 6) Connect electrical power to drive motor in accordance with wiring schematic shown on motor name plate. Check for proper voltage. Start motor and check rotation of conveyor drive shaft to ensure drive sprockets will pull SR196 chain towards discharge end.

CHAIN AND SLAT INSTALLATION

- 1) Chains are shipped in pairs in 10 ft. lengths. Join subsequent lengths of chain together using master links provided.
- 2) Once two (2) 10 ft. pieces of chain are installed parallel, install one slat near each end of the parallel chains to keep chain in conveyor track. Continue to add strands of chain and slats in this manner until all chains are installed. Use 5/16" x 1" bolts and nuts along with one (1) spacer under each end of slat to attach slats to chain. These bolts and nuts are provided.
- 3) Because the Model "SL" is completely enclosed, it will be necessary to remove the access panel, located on each side of the infeed section, to install the last few slats. Replace access panels after completion of slat installation.
- 4) Conveyor is now ready to run.

SPECIAL NOTE: Conveyor drive may be used to assist in installation of chains and slats.

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 -

SL

① DRIVE SECTION ASSEMBLY	①⑦ DRIVE TRACK ANGLE
② TAIL SECTION ASSEMBLY	①⑧ CHAIN ALIGNMENT BAR
③ INTERMEDIATE SECTION ASSY (5'-0")	①⑨ 6-TOOTH CHAIN SPROCKET
④ SLAT	②① DRIVE SHAFT BEARING
⑤ 0.3125"-18 X 1.25" F.H. SLT'D M/S	②② SUPPORT (SHORT)
⑥ 0.3125"-18 UNC NUT	②③ SUPPORT (LONG)
⑦ SLAT SPACER-(2 PER SLAT)	②④ BOLT-IN CROSSBRACE
⑧ 0.3125" LOCK WASHER	②⑤ DRIVE SHAFT
⑨ FLOOR MOUNT MOTORBASE	②⑥ FOOTPLATE
⑩ MOTOR	②⑦ BUTT COUPLING
⑪ REDUCER	②⑧ ACCESS DOOR
⑫ DRIVE SPROCKET	②⑨ TAIL TRACK ANGLE
⑬ REDUCER SPROCKET	②⑩ TAKE-UP BEARING
⑭ DRIVE CHAIN	③① TAKE-UP GUIDE
⑮ SR 196 CHAIN WITH A-2 ATTACHMENTS	③② TAIL SHAFT
⑯ UHMW WEAR STRIP	③③ INTERMEDIATE TRACK ANGLE

