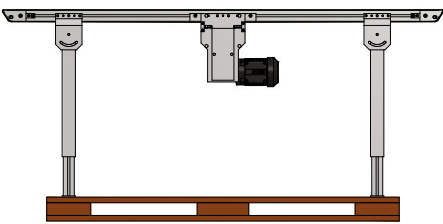


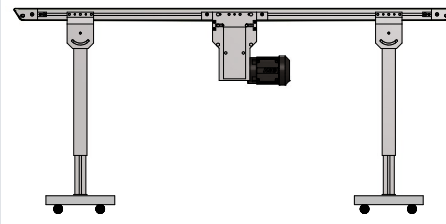
Transportation of the conveyor



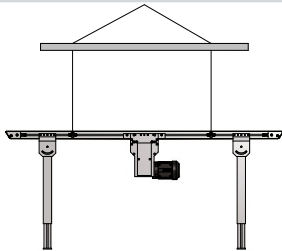
- Compliance with respective national regulations and legislations; as well as all applicable industrial accident prevention regulations (in Germany UVV); and operating instructions is mandatory
- Only qualified personnel shall be permitted transport and instant the equipment
- Do not stand under suspended loads
- Prior to the transporting, compare the equipment's weight and the load capacity of the lifting equipment. Select the transportation method with the appropriate load capacity and safety rating
- The equipment must be protected from tilting and heavy impacts



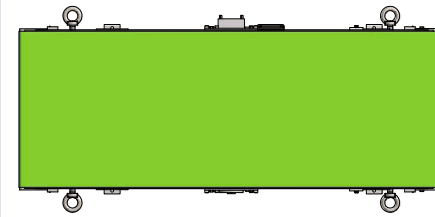
It is recommended to use a pallet during transportation



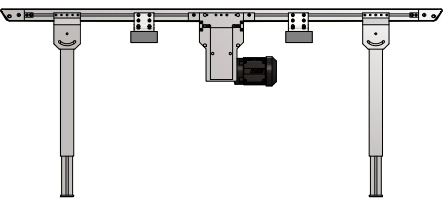
Transport on a roller trolley: Always lift the infeed and outfeed side simultaneously



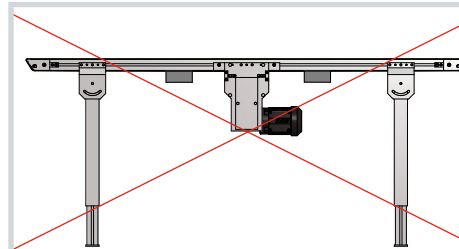
If the conveyor length exceeds 5 m in length and a crane will be used to move it, then a traverse support must be used in order to prevent sagging of the conveyor.



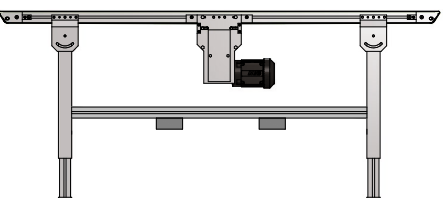
It is recommended to attach the fasteners of the transporting equipment via eye bolts.



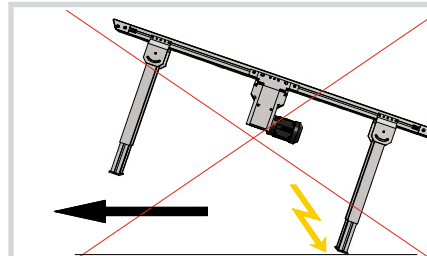
If the traverse support is not installed then use angle iron to assist during forklift transportation.



Do not transfer the load of the conveyor onto the belt. Do not attach the forklift or similar equipment to the belt.

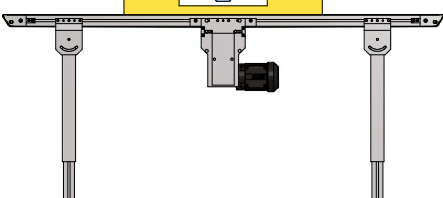


If a traverse support with the proper load capacity is available; place the forks of the forklift underneath the traverse. In order to protect the traverse, line the forks with a suitable cover.

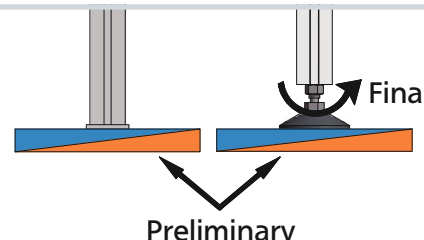


Do not pull/push the conveyor across the floor.

Setting up the machine



Do not install the conveyor with a twisted frame. Align the conveyor plane horizontally; use a spirit level to verify the longitudinal and transverse alignment.



Adjusting the stands should only be done for final alignment; to do this adjust the leveling pads. For preliminary adjustment, or if there are no leveling pads, use shims or spacer blocks.

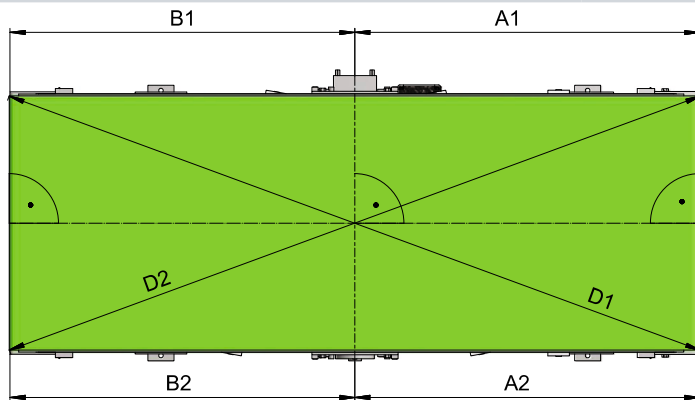
Belt adjustment

Belt travel – Observe prior to adjustment

The belt was tensioned and adjusted at the factory before delivery. Due to the transportation and installation, adjustment of the belt (such as tracking and tensioning) may be required following the first two weeks of initial start-up.

General rule:

- After a shutdown exceeding 2 hrs, -> the belt must be operated for 5 to 10 minutes at its normal operating speed; this will allow the belt to adjust properly.
- During the adjustment, the belt must circulate 2 - 10 times in order to respond to the changes being made. Only then should additional adjustments be made.
- All rollers must be clean. Damaged or severely worn parts must be replaced.



The belt tension of wide conveyors requires special attention. Components such as bushings must not be overloaded. Any distortion must be kept to a minimum.

All rollers (drive, idlers, and return rollers) must be aligned so that they are parallel to the axis and perpendicular to the path of the belt.

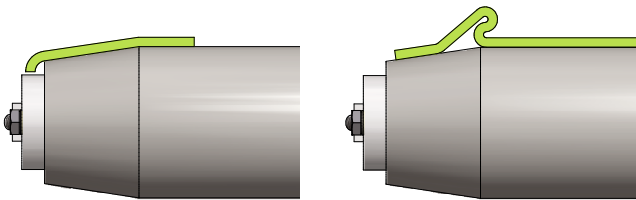
$$\begin{aligned} A1 &= A2 \\ B1 &= B2 \\ D1 &= D2 \end{aligned}$$



Caution!

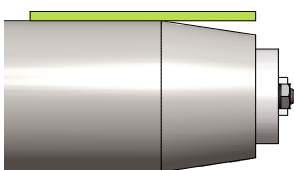
Adjustments must be carried out **while the conveyor belt is running**. There is a risk of entanglement!

Belt tension too high



If the belt bows downward at the edge of the roller, or it is dragging on the top pieces of the roller, or the belt wrinkles, then the belt tension is too high.

Belt tension too low



If a gap occurs between the belt and the roller, the belt tension is too low.

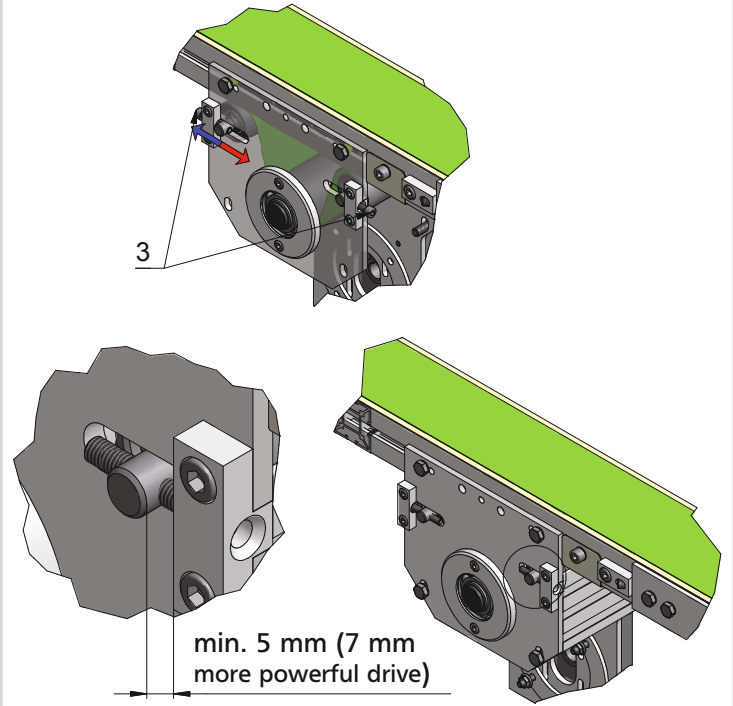
The following guideline applies: Pretension of belt \approx belt length \times 0.15% to 0.3% As a rule, the pretension should only be as high enough to allow for proper traction when the belt is loaded.

Level marking: There are two marks on the belt, spaced of 1,000 mm apart. After tensioning, there must be a distance of 1,001.5 mm to 1,003 mm between the marks.

Center Drive BC

The snub pulleys (3) are used to adjust and keep the belt centered as it runs through the drive.

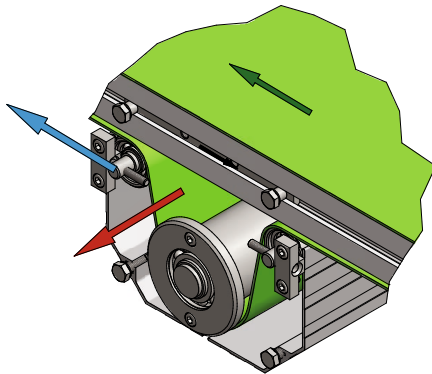
The distance of the snub pulley to the rear bearing must be at least 5 mm (more powerful motor require the distance to be at least 7 mm); otherwise, the roller will contact the protective cover of the motor.



Belt reaction

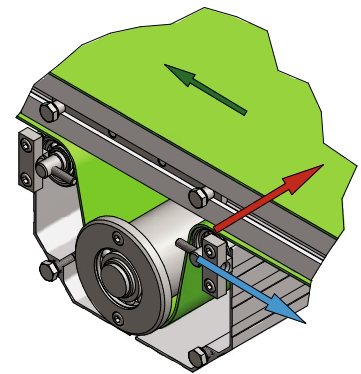
Toward infeed

The belt travels toward the exposed roller side



Toward outfeed

Opposite to the infeed, the belt travels away from the exposed roller side



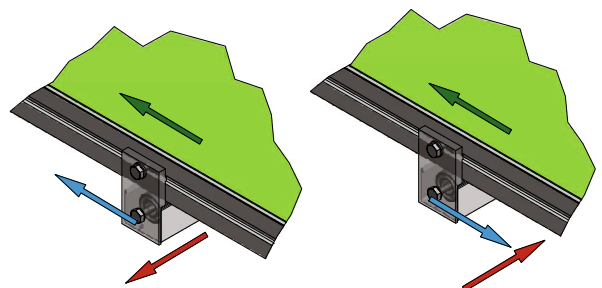
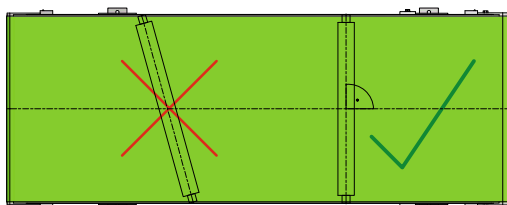
→ = Roller adjustment

→ = Belt reaction

→ = Travel direction

Adjust bearing rollers and ensure they are parallel to the axis and perpendicular.

The bearing rollers act on the path of the belt, as illustrated.



→ = Roller adjustment

→ = Belt reaction

→ = Travel direction

Tail: Knife Edge

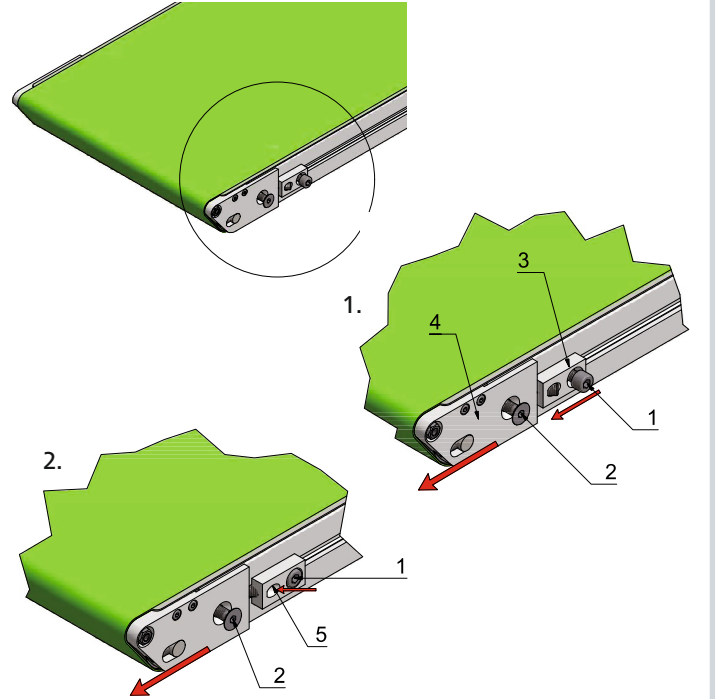
Tightening

All tasks are carried out on as shown and on the opposite side of the conveyor frame.

→ Always tighten parallel to the axis.

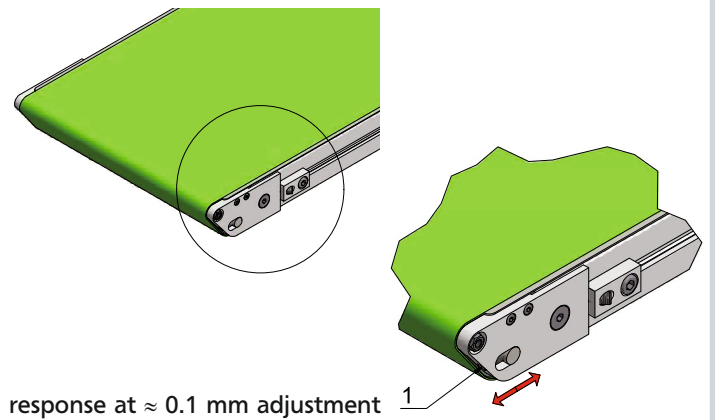
1. Loosen screws (1) and (2) and push the alignment block (3) and roll holder (4) (in the direction of the arrow) to pretension on the belt.

2. Tighten screw (1), use the set screw (5) to pretension the belt; finally tighten the screw (2).



Fine adjustment

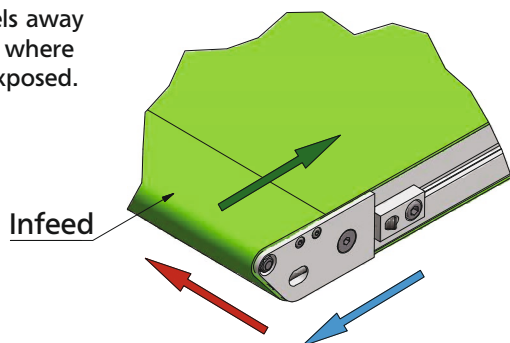
1. Use the adjustment of the set screw (1) to adjust the belt until it runs along the center of the roller.



Belt reaction

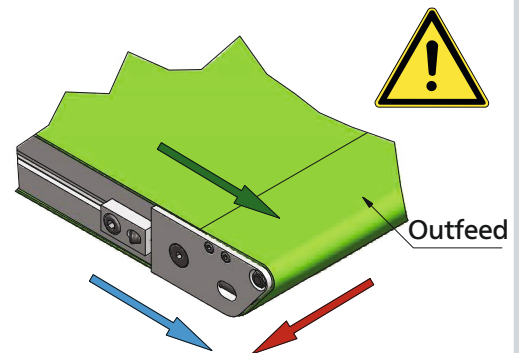
Infeed

The belt travels away from the side where the roller is exposed.



Outfeed

Opposite to the infeed, the belt travels towards the side on which the roller is exposed



Applicable to the tails with rolling knife edge.

→ = Roller adjustment

→ = Belt reaction

→ = Travel direction

Tails: Without knife edge

Tightening

All tasks are carried out on as shown and on the opposite side of the conveyor frame.

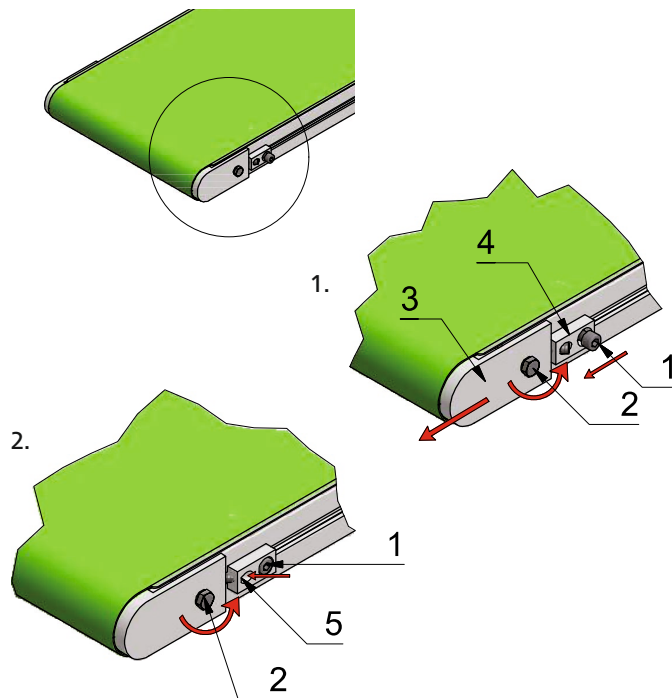
-> Always tighten parallel to the axis.

1. Loosen screws (1) and (2) and push the alignment block (4) along with the roll holder (3) (in the direction of the arrow) to pretension the belt.

2. Tighten screw (1), pre-tension the belt using set screw (5) and then finely adjust (see Fine Adjustment).

3. Tighten screw (2) and adjust the alignment blocks (4).

Repeat steps 2 to 3 until the correct belt tension is achieved.



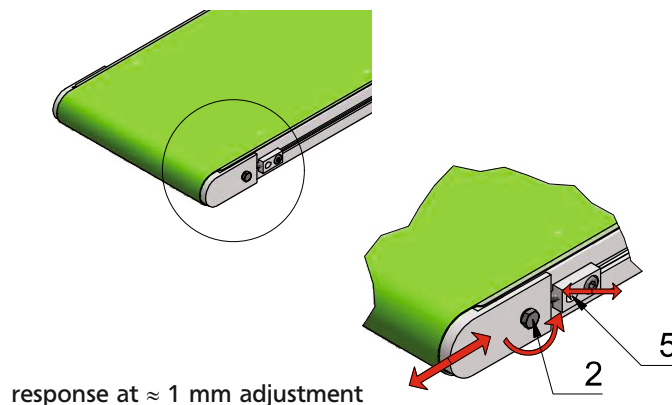
Fine adjustment

1. Loosen bolt (2).

2. Adjust the set screw (5) in order to push the top piece outward. Wait for the belt to react. If you have already exceeded the adjustment, turn the set screw back again.

It is sufficient to adjust the path of the belt on one side of the tail only (left- or right-hand side).

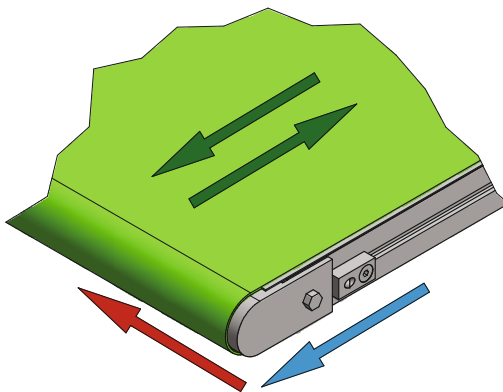
3. Tighten screw (2) and adjust the alignment block.



Belt reaction

Infeed and outfeed

The belt travels away from the side with the exposed roller.



→ = Roller adjustment

→ = Belt reaction

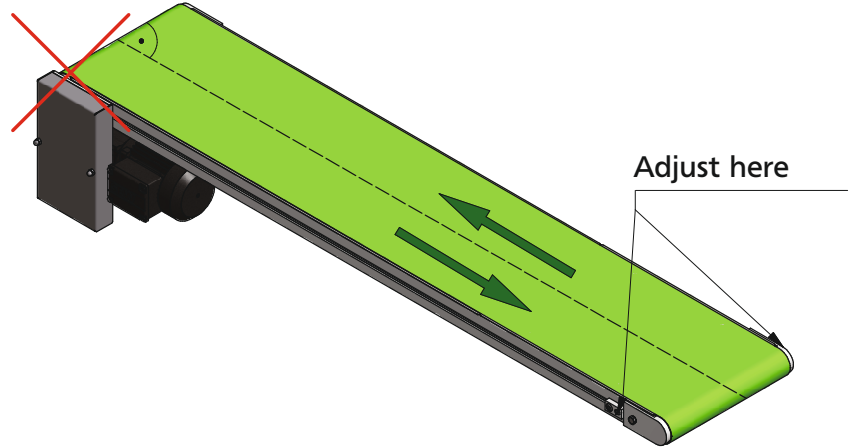
→ = Travel direction

Head drive

DO NOT adjust the belt at the drive.
 All adjustment should be done at the
 opposite end.

Performing belt adjustment at the
 drive may cause damage to the bea-
 rings and motor.

This applies to all tails, regardless of
 the conveyor travel direction.



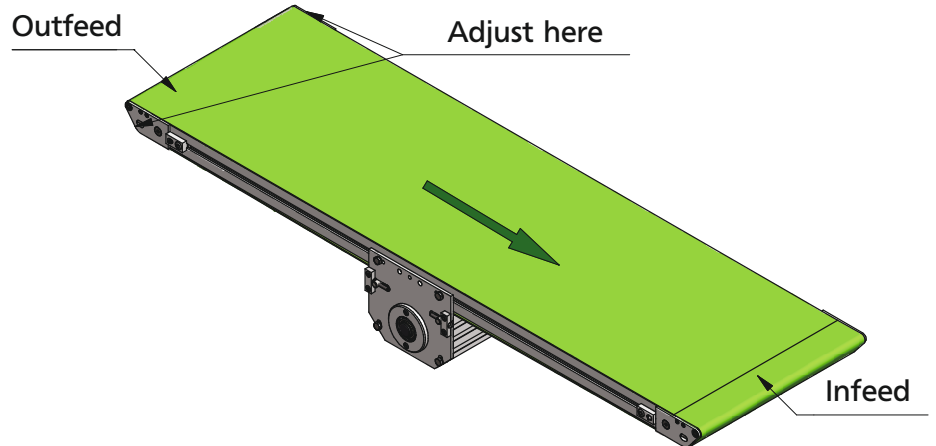
Center drive – only one travel direction

A stable movement of the belt is
 achieved if the belt runs across the
 tail at the center of the infeed.

Therefore, it is recommended to only
 make adjustments at the infeed.

If access to the infeed side is not pos-
 sible, then make the adjustments at
 the outfeed.

This applies to all tails.



Center drive – reversing mode

If the tails are properly adjusted for
 single travel direction, then during
 the reversing mode, this often causes
 the belt to deflect.

Therefore, adjust the snub pulley at
 the drive.

This applies to all tails.

