INSTALLATION AND MAINTENANCE MANUAL

SLIDER BED BELT CONVEYOR
MODEL BS100C & BSI

DO NOT OPERATE EQUIPMENT BEFORE READING

ATLANTIS TECHNOLOGIES LLC

Version 2014.1

TABLE OF CONTENTS

INTRODUCTION

This manual has been created to assist with the maintenance, operation and installation of the BS100C and BSI conveyor. It is important that all maintenance personnel are trained properly in operation and maintenance of the conveyor. Damage or injury caused by non-compliance with this manual is not the responsibility of Atlantis Technologies LLC.

RECEIVING, INSPECTION AND UNCRATING

1) Compare the bill of lading with what you have received.
2) Examine the equipment for damage during shipping.
3) Immediately report shortage or damages to the carrier.
4) Move all crates to area of installation.
5) Remove crating and packaging.
6) Look for boxes, accessories, bags or components such as fasteners, manuals, guard rails, etc. that may be banded or fastened to the crating material to ensure you do not discard any loose parts (Guards, Fasteners or other components) that were packaged for loose shipping.

ORDERING REPLACEMENT PARTS

Assembly drawings with replacement parts listings have been provided in this manual.

Procedure for ordering replacement parts:

1) Contact your Atlantis Technologies LLC Distributor.
2) Give Conveyor Model Number and/or Serial Number.
3) Give Part Number and complete description from Parts Listing.
4) Give type of drive configuration. For instance: 8” End Drive, 8” Center Drive, etc.
5) Tell us if you are in a breakdown situation.

SAFETY INFORMATION - INSTALLATION

GUARDS AND GUARDING

Interfacing of Equipment

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

Guarding Exceptions

Wherever conditions prevail that would require guarding under this standard but such guarding would render the conveyor unusable, seek guidance from your safety professional.

Overhead conveyors for which guarding would render the conveyor unusable or would be impracticable, should have prominent and legible warnings posted in the area or on the equipment and where feasible lines should be painted on the floor delineating the danger area.

When a conveyor passes over a walkway, roadway or work station, it is considered guarded by location if all moving parts are at least 2.44 meters (8 feet) above the floor or walking surface or are otherwise located so that personnel cannot inadvertently come in contact with hazardous moving parts. Check your state and local laws and codes for overall compliance.

Although overhead conveyors may be guarded by location, spill guards, pan guard or equivalent should be installed if material may fall off the conveyor and endanger personnel.

HEADROOM CLEARANCE

When conveyors are installed above exit passageways, aisles or corridors, there should be provided a minimum clearance of 2.00 meters (6 feet 8 inches) 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 2.00 meters (6 feet 8 inches) through an emergency exit, alternate passageways should be provided.

It is permissible to allow passage under conveyors with less than 2.00 meters (6 feet 8 inches) clearance from the floor for other than emergency exits if a suitable warning indicates low headroom. Check your state and local laws and codes for overall compliance.

SAFETY INFORMATION - OPERATION

Only trained, qualified personnel should be permitted to operate a conveyor. Training should include instruction in operation under normal conditions and emergency situations.

Where safety is dependent upon stopping / starting devices, they should be kept free of obstructions to permit access.

The area around loading and unloading points should be kept clear of obstructions that could endanger personnel.

Do not ride the load-carrying element of a conveyor under any circumstances. Warning labels reading **"DO NOT RIDE CONVEYOR"** should be affixed by the manufacturer of the conveyor.

Personnel working on or near a conveyor should be instructed as to the location and operation of pertinent stopping devices.

A conveyor should be used to transport only a load that it is designed to be handle safely.

Under no circumstances should the safety characteristics of the conveyor be altered.

SAFETY INFORMATION - OPERATION (Continued)

Routine inspections and preventative and corrective maintenance programs should be conducted to ensure that all safety features and guards are retained and functioning properly. Inspect equipment for safety labels. Make sure personnel are aware of and follow safety label instructions.

Alert all personnel to the potential hazard of entanglement in conveyors caused by items such as long hair, loose clothing and jewelry.

SAFETY INFORMATION - MAINTENANCE

ATTENTION: ELECTRICAL POWER MUST BE TURNED OFF AND LOCKED / TAGGED OUT following your company's machine specific procedures when servicing the conveyor to prevent accidental restarting by other persons or interconnecting equipment.

Maintenance and service should be performed by trained, qualified personnel only.

Where lack of maintenance and service would cause a hazardous condition, the user should establish a maintenance program to ensure that conveyor components are maintained in a condition that does not constitute a hazard to personnel.

ADJUSTMENTS OR MAINTENANCE/SERVICE DURING OPERATION

Conveyors should **NOT** be maintained or serviced while in operation.

When a conveyor is stopped for maintenance or service, the starting devices, prime mover, powered accessories or electrical must be locked / tagged out in accordance with your company machine specific formalized procedure designed to protect all persons or groups involved with the conveyor against an unexpected restart. Personnel should be alerted to the hazard of stored energy, which may exist after the power source is locked/tagged out. All safety devices and guards should be replaced before starting equipment for normal operation.

GUARDS AND SAFETY DEVICES

Guards and safety devices should be maintained in a serviceable and operational condition. Warning signs are the responsibility of the owner of the conveyor and should be maintained in a legible / operational condition.

LUBRICATION

Conveyors should **NOT** be lubricated while in operation.

Where the drip of lubricants or process liquids on the floor constitutes a hazard, drip pans or other means of eliminating the hazard must be provided by purchaser(s).

SAFETY INFORMATION - ELECTRICAL

ELECTRICAL CODE

All electrical installations and wiring should conform to federal, state and local codes.

When conveyor operation is not required for a maintenance procedure, electrical power must be turned off and locked / tagged out following your company's machine specific procedure.

CONTROL STATIONS

Control stations should be so arranged and located that the operation of the affected equipment is visible from them. Control stations should be clearly marked or labeled to indicate the function controlled.

A conveyor that would cause injury when started should not be started until personnel in the area are alerted by a signal or by a designated person that the conveyor is about to start.

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 associated devices), a clear, concise and legible warning sign needs to be provided. The warning sign should indicate that conveyors and associated equipment may be started at any time, that danger exists and that personnel must keep clear. These warning signs should be provided along the conveyor at areas not guarded by position or location.

Remotely and automatically controlled conveyors, and conveyors where operator stations are not manned or are beyond voice or 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 should be furnished with emergency stop buttons, pull cords, limit switches or similar emergency stop devices.

All such emergency stop devices should 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 should act directly on the control of the conveyor concerned and should not depend on the stopping of any other equipment. The emergency stop devices should be installed so that they cannot be overridden from other locations.

Inactive and unused actuators, controllers and wiring should be removed from control stations and panel board, together with obsolete diagrams, indicators, control labels and other material that might confuse the operator.

SAFETY DEVICES

All safety devices, including wiring of electrical safety devices, should be arranged to operate such that a power failure or failure of the device itself will not result in a hazardous condition.

Conveyor controls should be so arranged that, in case of emergency stop, manual reset or start at the location where the emergency stop was initiated should be required for the conveyor(s) and associated equipment to resume operation.

Before restarting a conveyor that has been stopped because of an emergency, an inspection of the conveyor should be made and the cause of the stoppage determined. The starting device and electrical power must be turned off and locked / tagged out according to your company's machine specific procedure before any attempt is made to remove the cause of the stoppage, unless operation is necessary to determine the cause or to safely remove the stoppage.

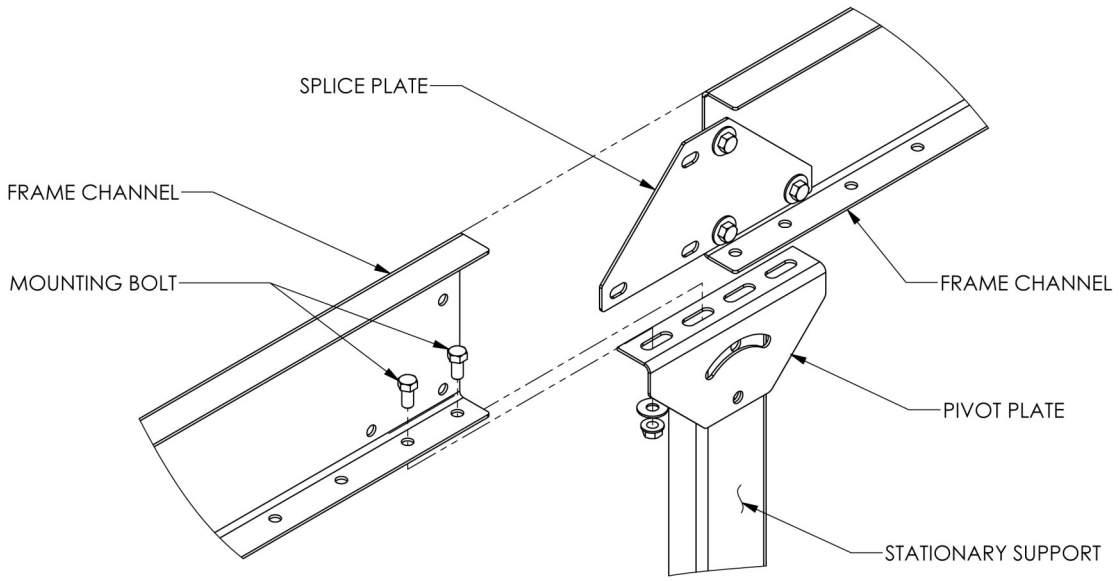
Replace all safety devices, guards and guarding prior to equipment start-up.

INSTALLATION

FLOOR SUPPORT INSTALLATION

Floor supports are typically mounted at Drive, Tail and across splice locations. Fasten leg supports to conveyor sections with the provided fasteners as shown (Figure 7.1).

FIGURE 7.1

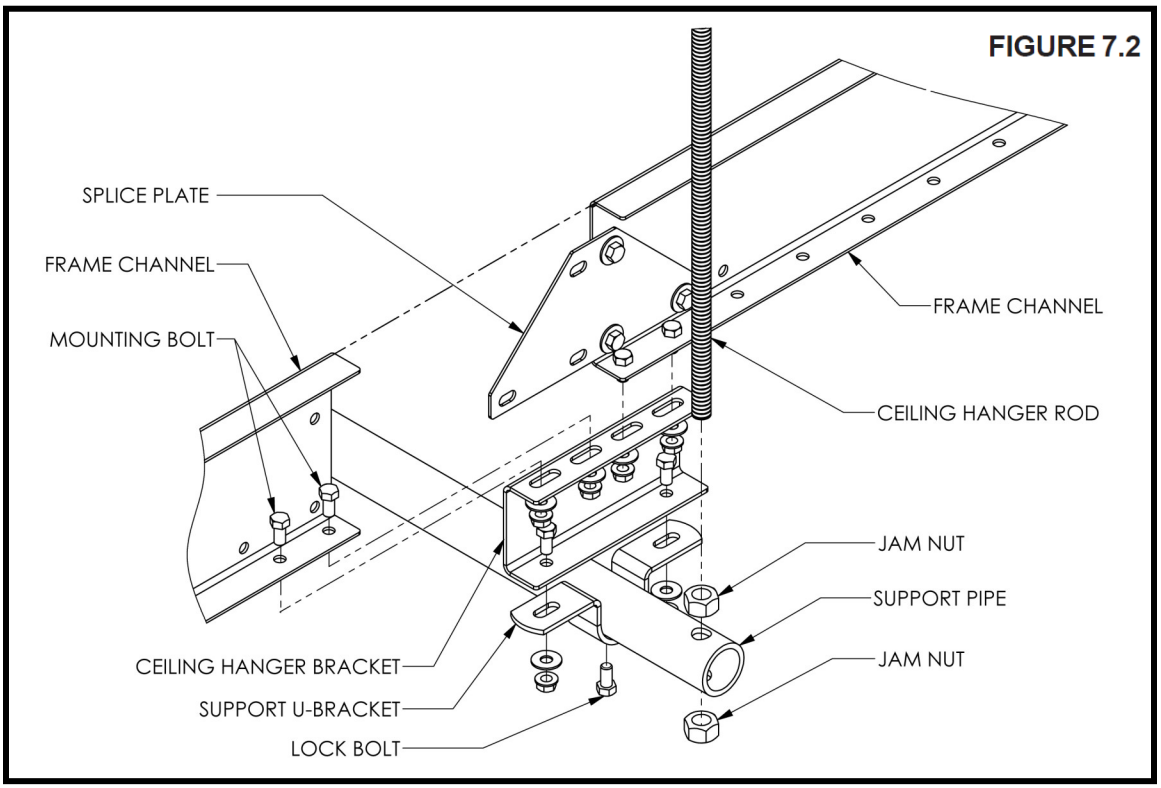


CEILING HANGERS INSTALLATION

Ceiling hangers may have been supplied in lieu of floor supports, if conveyors are to be used in an overhead application. Figure 7.2 illustrates how ceiling hangers mount to a conveyor section. Mount ceiling hangers on each section joint. See safety information regarding overhead mounted conveyors.

NOTE: When installing ceiling hangers, refer to local building codes to ensure that materials comply. Only experienced material handling installers should attempt to install conveyors.

FIGURE 7.2

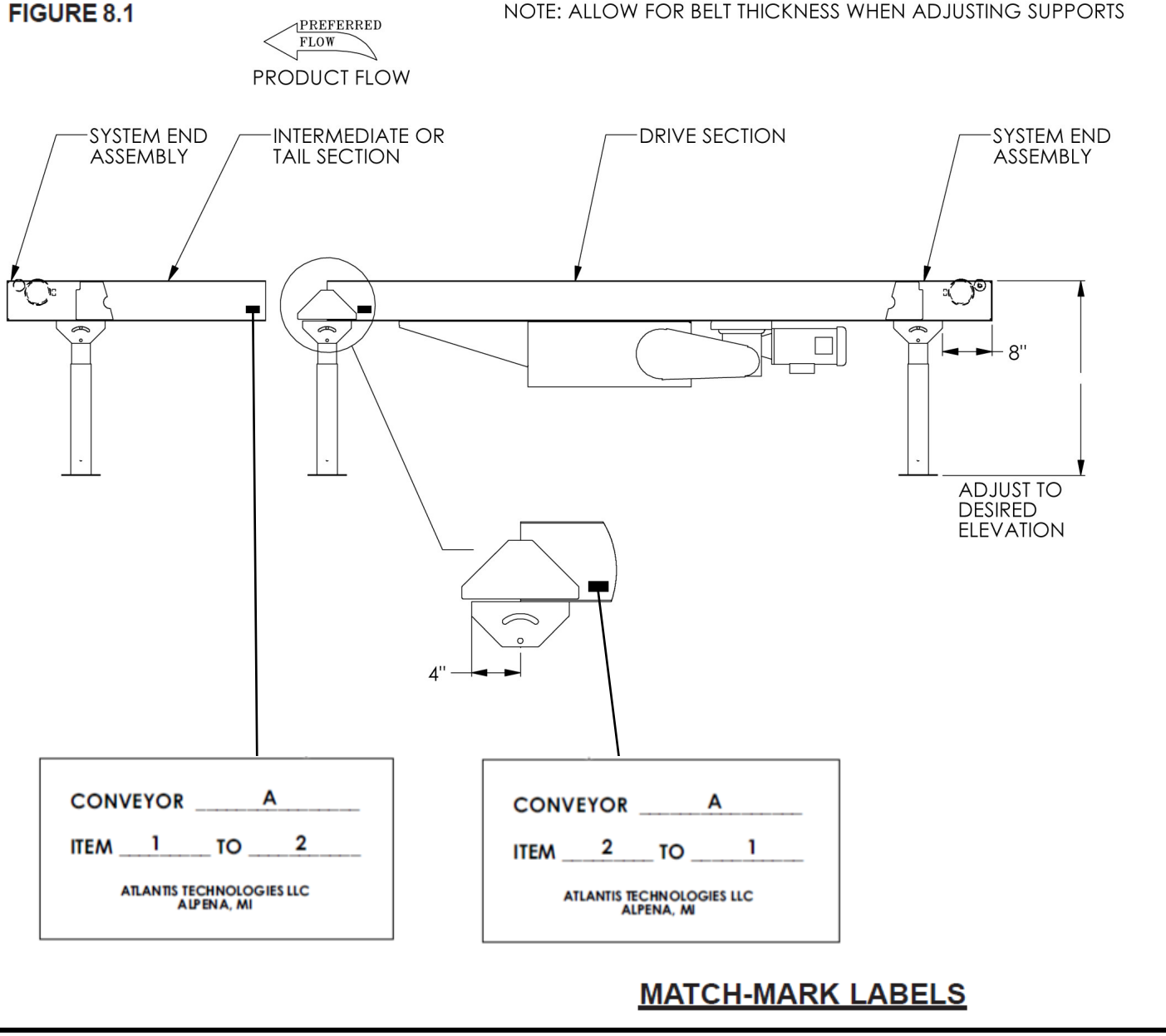


INSTALLATION

CONVEYOR SET-UP

1) Locate center line of the conveyor by marking a chalk line on floor.
2) Determine flow of conveyor related to drive.
3) Position the conveyor sections in the proper order (See Figure 8.1).
4) Fasten floor or ceiling supports to Drive, Intermediate and Tail sections.
5) Use splice and pivot plates to fasten conveyor sections together.
6) Check to ensure that the conveyor is square and level across the length. Adjust leg supports and/or ceiling hangers as necessary to achieve desired height.
7) Wire motor and install controls.
8) Install the belt and track belt per instructions on page 10-12.

FIGURE 8.1



INSTALLATION

BELT INSTALLATION

The belt has been cut and laced to the proper length at the manufacturing facility and is ready for installation. To install follow these steps:

1) Loop belt over snub rollers, return rollers and end pulleys as shown in Figure 9.1. Bring laced ends together and thread lacing pin through loops as shown in Figure 9.2.
2) Adjust the take-up or tail pulley to remove excess slack from the belt. Keep the pulley square by moving both tension bolts an equal amount. Maintain just enough tension so that the drive pulley will not slip when carrying the rated load. **Note: Over tightening the belt will make it difficult to track and may damage the belt.**
3) Check for squareness of all frame sections, end units, drive units, etc. All snubber rollers and pulleys must be squared with the frame before making any belt adjustments.
4) Use belt tracking instructions to properly track the belt.

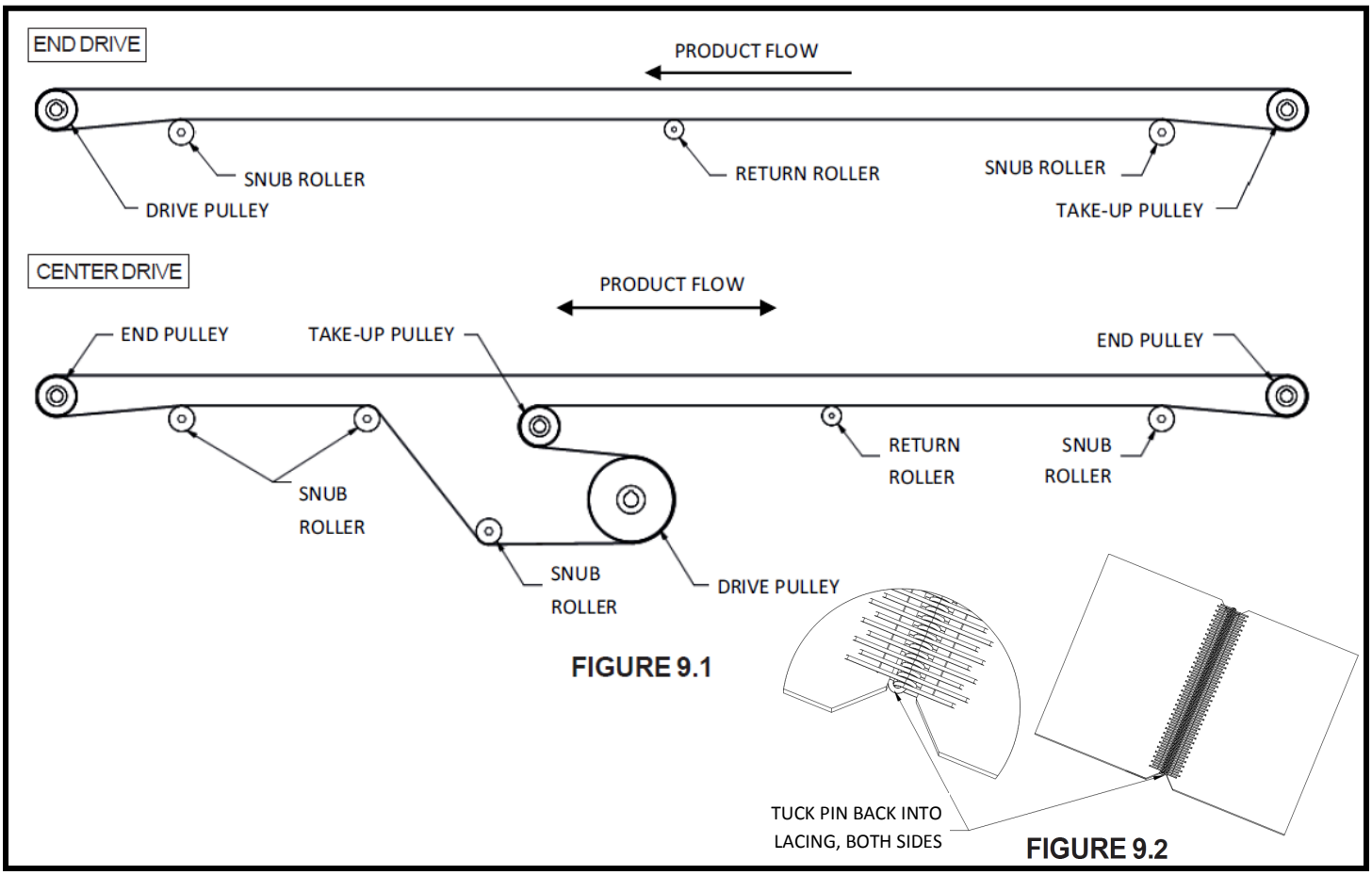


FIGURE 9.1

FIGURE 9.2

OPERATION

START-UP OVERVIEW

1) Ensure that conveyor sections, leg supports, etc. were installed properly.
2) Ensure that drive chains and sprockets are installed, aligned and tensioned properly.
3) Ensure set screws are tight in sprockets, bearings and pulleys.
4) Ensure that all drive, mounted bearings and fasteners are securely tighten.
5) Ensure that all motor and control wiring is connected properly.
6) Ensure that the conveyor is not loaded with product.
7) Ensure that gearboxes are properly filled with the correct amount of lubricant or that they were factory filled with lubricant.
8) Ensure that the gearbox has necessary vent plugs installed (if applicable).

BELT TRACKING

The belt is tracked by adjusting snub rollers, return rollers, tail pulley and drive pulley. The initial goal is to center the belt on pulley at infeed end of conveyor, then move to discharge end if needed. All adjustments should be made in small increments (1/16 in. at a time). Allow adequate time for the belt to react to each adjustment. It may take several complete belt revolutions to see the effect of each adjustment. **CONVEYOR POWER MUST BE TURNED OFF WHEN MAKE ANY ADJUSTMENTS.** The same tracking principles apply to conveyors supplied with end drives, center drives or underside take-ups.

PRIOR TO TRACKING

1) Make sure conveyor frame is cross square.
2) Confirm that conveyor is level across its width and length.
3) Make sure snubber rollers, return rollers, tail pulley and drive pulley are square with the frame. Reference dimension “A” in figures 13.1, 13.2 and 13.3.
4) Confirm belt has been properly threaded through the conveyor.

BELT TRACKING PROCEDURE FOR END DRIVE

1) Run conveyor for a few minutes so the belt can take its position. Stop conveyor immediately if belt rubs against side of conveyor. Re-check all items covered under “Prior to Tracking”.
2) If belt on infeed end shifts to one side as illustrated, adjust snubber roller (C) as shown to steer belt to center of take-up pulley (B). See Figure 11.1.
3) If belt is riding at the center of take-up pulley (B) on infeed but is not at the center of drive pulley (A) on discharge, adjust drive pulley (A) as shown.
4) Adjusting drive pulley (A) may throw off alignment of take-up pulley (B). Repeat steps 2 and 3 as necessary.
5) If belt continues to track improperly, re-check all items covered under “Prior to Tracking”

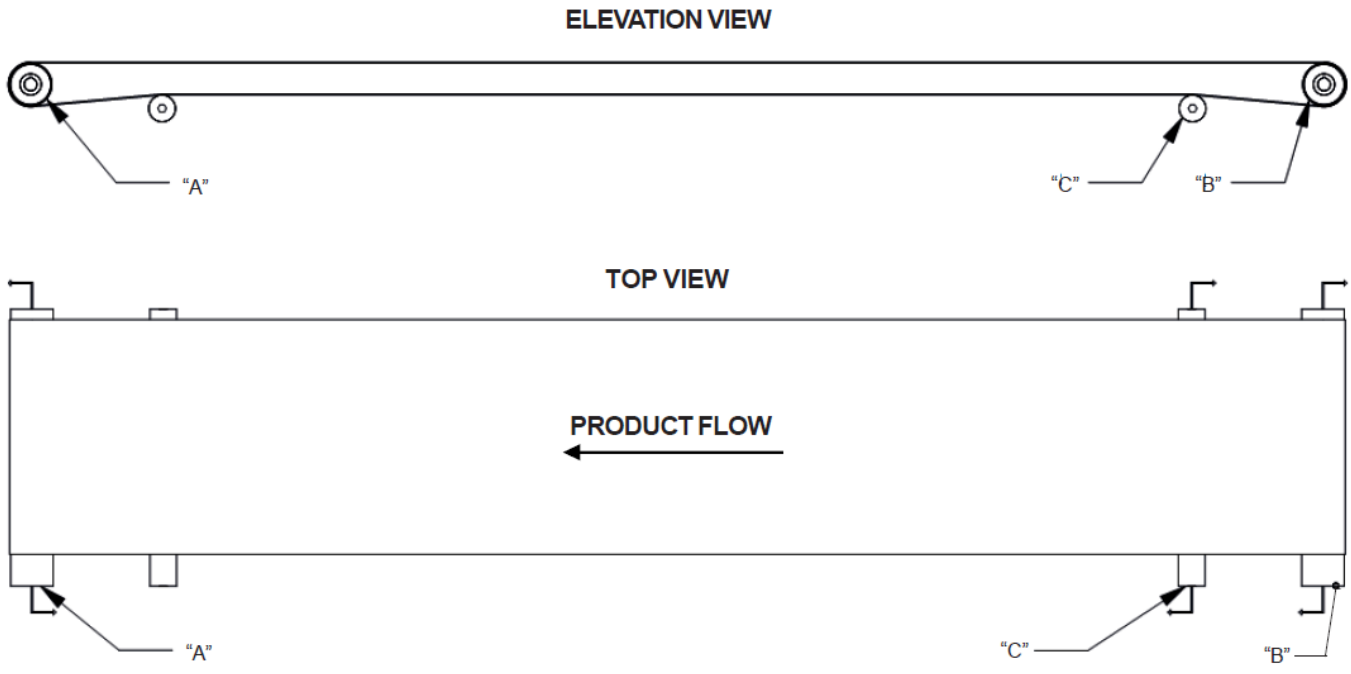


FIGURE 11.1

BELT TRACKING

BELT TRACKING PROCEDURE FOR CENTER DRIVE (FORWARD SERVICE)

1) Run conveyor in FORWARD direction for a few minutes so the belt can take its position. **Stop conveyor immediately if belt rubs against side of conveyor.** Re-check all items under “Prior to Tracking”.
2) If belt on infeed end shifts to one side as illustrated, adjust snubber rollers (D) as shown to steer belt to center of drive pulley (B) which then will center belt on end pulley (G). See Figure 12.1.
3) If belt is still not riding at center of end pulley (G), adjust snubber roller (C) as shown.
4) If belt is riding at center of end pulley (G) on infeed but not at the center of end pulley (F) on discharge, adjust end pulley (F) as shown. Note: Care is required as adjusting this pulley mat cause the belt to travel to the opposite side in REVERSE service.
5) Repeat steps 2 through 4 as necessary.
6) If belt continues to track improperly, re-check all items covered under “Prior to Tracking”

BELT TRACKING PROCEDURE FOR CENTER DRIVE (REVERSE SERVICE)

1) Run conveyor in REVERSE direction for a few minutes so the belt can take its position. **Stop conveyor immediately if belt rubs against side of conveyor.** Re-check all items under “Prior to Tracking”.
2) If belt on infeed end shifts to one side as illustrated, adjust take-up (A) as shown to steer belt to center of drive pulley (B) which then will center belt on end pulley (F). See Figure 12.1
3) If belt is still not riding at center of end pulley (F), adjust snubber roller (E) as shown.
4) If belt is riding at the center of end pulley (F) on infeed but not at the center of end pulley (G) on discharge, adjust end pulley (G) as shown. Note: Care is required as adjusting this pulley may cause the belt to travel to the opposite side in FORWARD service.
5) Repeat steps 2 through 4 as necessary.
6) If belt continues to track improperly, re-check all items covered under “Prior to Tracking”.

Note: Reversing belts may require that the belt run slightly off center to one side in the forward direction and to the opposite side in the reverse direction. This is due to the nature of the belt.

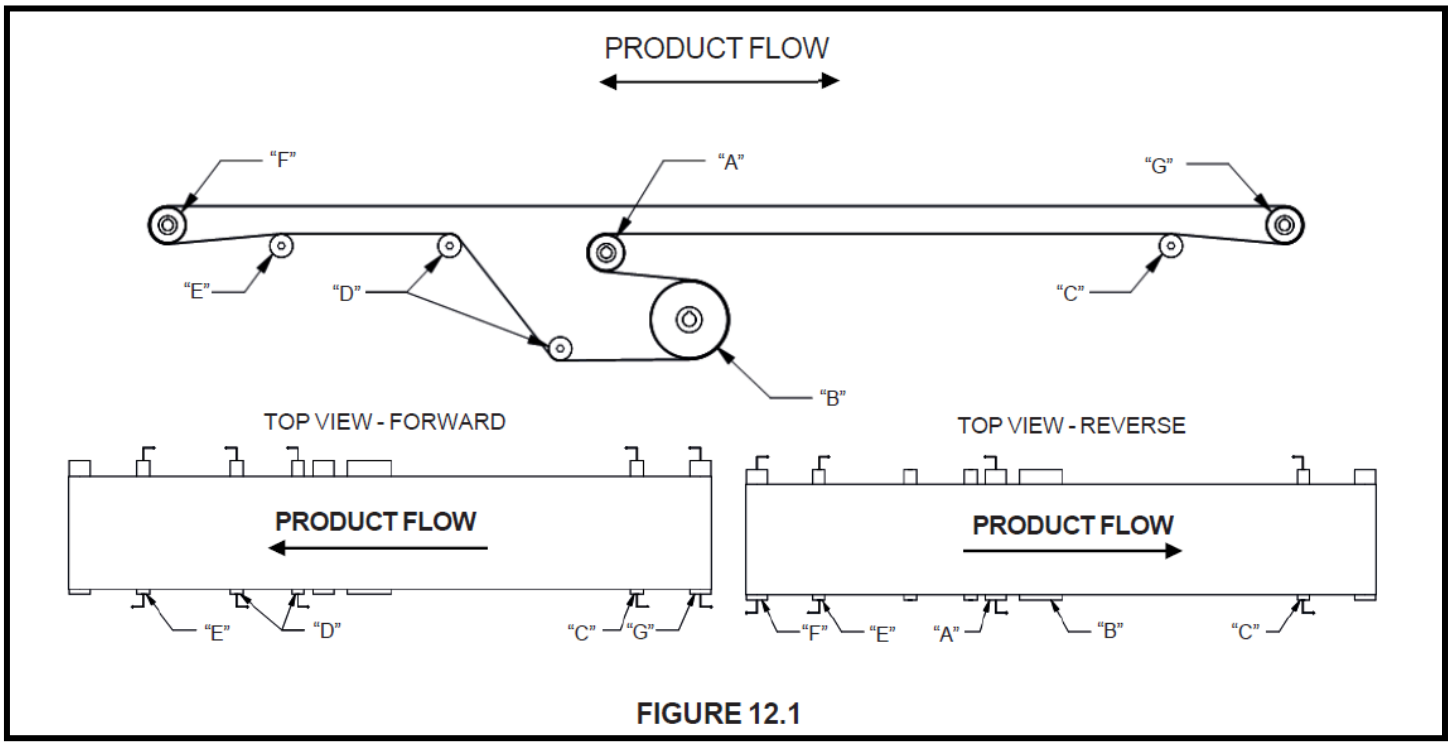


FIGURE 12.1

BELT TRACKING

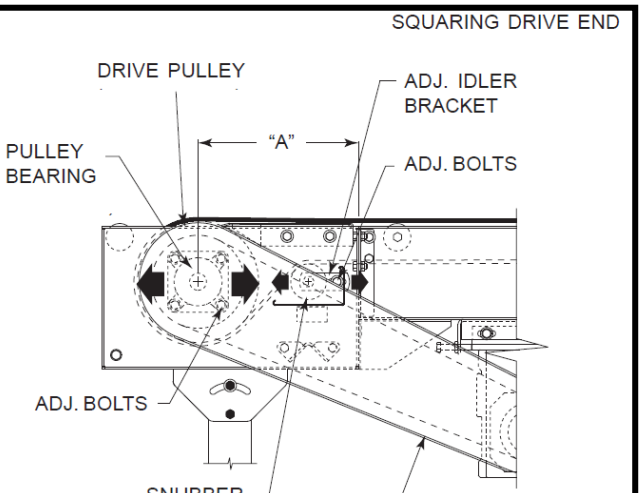
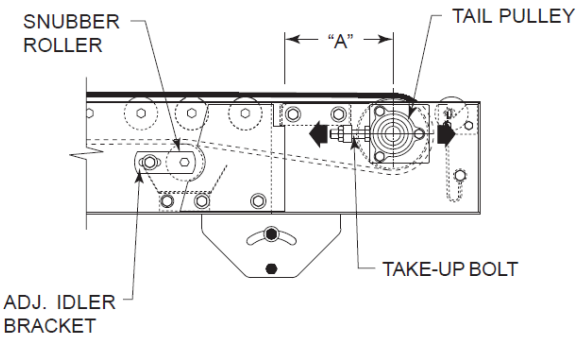


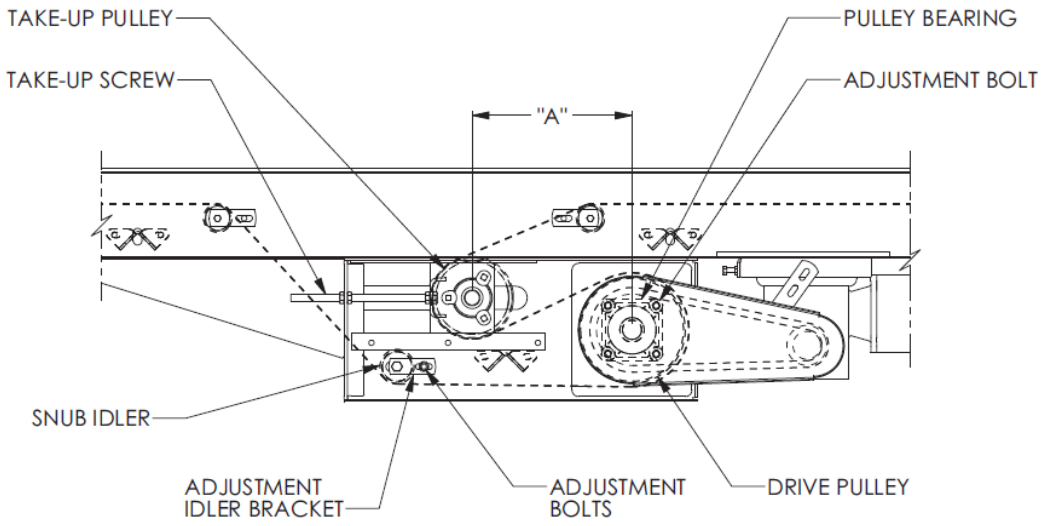
FIGURE 13.1

FIGURE 13.2



TAIL PULLEY SQUARING COMPONENTS

FIGURE 13.3



CENTER DRIVE OR UNDERSIDE PULLEY SQUARING COMPONENTS

MAINTENANCE

LUBRICATION

Chain Lubrication

Proper maintenance of any chain should include correct lubrication, periodic inspection and proper adjustment for normal wear. Periodic inspection of the chain and sprockets is required to detect any deviation from normal wear before serious damage takes place. The cost of such inspection is repaid in an extended chain life. No general rule can be given for the frequency of inspection. The frequency should be influenced by conditions of operation.

Suggested Lubrication

Only high quality oil should be used to lubricate chain. Neither heavy oil nor grease is suitable. A lubricant with the proper viscosity enables it to reach internal surfaces under normal conditions. Lubricants suggested for specific ambient temperatures and chain ranges are given in the table below.

	Temperature		
Chain No.	15 - 35 Deg (F)	35 - 105 Deg (F)	105 - 120 Deg (F)
ANSI 25 - 50	SAE10W	SAE20	SAE30
ANSI 60 - 100	SAE20	SAE30	SAE40

CHAIN ALIGNMENT AND TENSIONING

Periodically check the drive chain and sprocket for proper tension and alignment. Extensive wear to the drive component could occur due to improper chain tension and alignment. Check chain tension to be certain the slack span has an approximate 2% mid-span movement. (See Figure 14.2)

Drive Chain Tension Adjustment Procedure (See Figure 14.1 and Figure 14.2)

1) Remove the chain guard.
2) Place a straight edge across the face of both drive sprockets to check alignment. Loosen set screws and adjust as needed. Re-tighten the set screws.
3) To adjust chain tension, loosen the bolts that fasten the motor base to the mounting angles. (Both sides of the conveyor)
4) Tighten take-up bolts until the desired chain tension is reached. Re-tighten the mounting bolts.
5) Reference lubrication instructions to lubricate chain properly.
6) Replace chain guard so that it does not interfere with the drive.

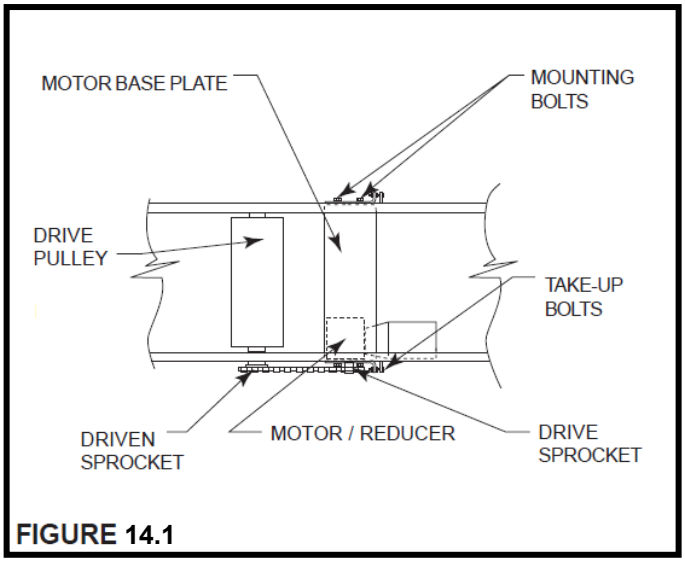


FIGURE 14.1

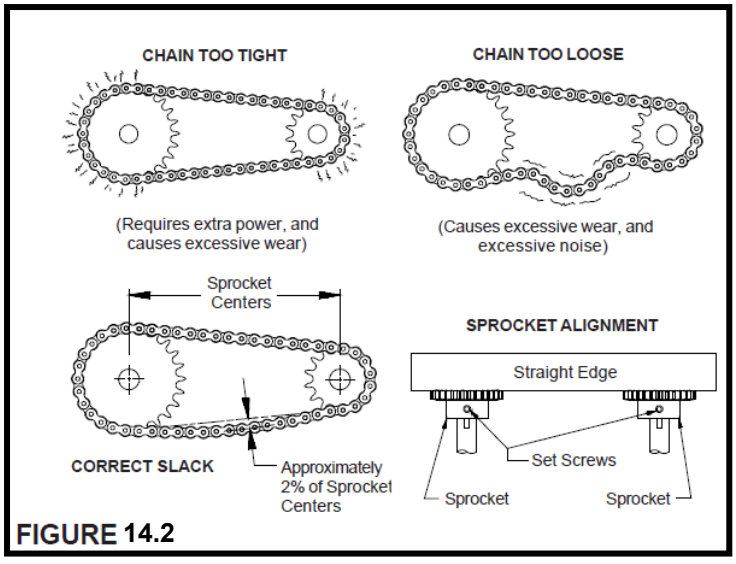


FIGURE 14.2

MAINTENANCE SCHEDULE

DAILY MAINTENANCE

- Inspect all conveyors to ensure that all guarding is securely in place.
- Inspect belt tracking for a minimum of (3) full belt revolutions.

WEEKLY MAINTENANCE

- Inspect conveyor for loose bolts and set screws.
- Inspect bearings, gear reducers, motors and chains for excessive noise or heat.
- Inspect belt to ensure that there is not excessive wear and that all splices are intact.
- Inspect belt tension. The tension should be enough to:
  - Prevent slippage between drive pulley (sheaves for spurs) and belt under a full load.
  - Force belt to conform to the crown on crowned pulleys.
- Inspect rollers to ensure that they rotate freely without excessive noise.

MONTHLY MAINTENANCE

- Inspect oil level in reducer. Fill if necessary.
- Inspect reducer for leaking seals.
- Inspect conveyor for loose bolts.
- Inspect drive chains, jump chains and sprockets for wear, alignment and proper chain tension.
- Lubricate pulley shaft bearings. Use No. 2 lithium base grease or equivalent.

QUARTERLY MAINTENANCE

- Grease all pulley shaft bearings.
- Inspect conveyors for worn or broken drive belts. Replace as necessary. If belt shows signs of abrasion, check for hindrance with the belt or foreign object in the roller groove.

SEMI-ANNUAL MAINTENANCE

- Tighten all bearing set screws if not completely tight.

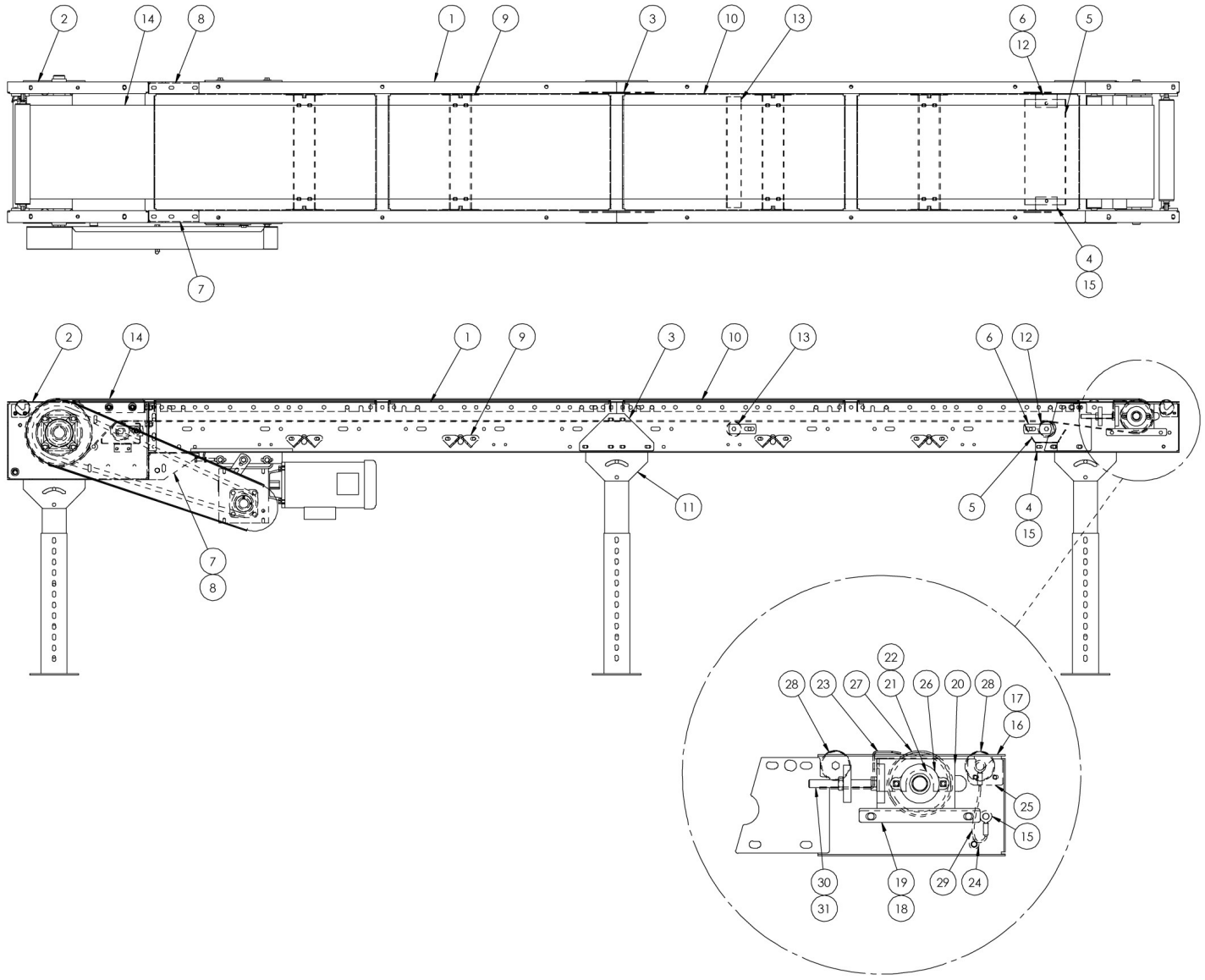
ANNUAL MAINTENANCE

- Change oil in reducers.

TROUBLE SHOOTING

TROUBLE	CAUSE	SOLUTION
Conveyor motor will not start or motor quits frequently	1. Motor is overloaded 2. Motor is drawing excessive current	1. Inspect conveyor for overloading and remove excessive load.
Excessive wear on drive sprockets and drive chain	1. Inadequate amount of lubrication on drive chain. 2. Misalignment of sprockets. 3. Loose Chain	1. Replace chain and sprockets. Apply adequate amount of lubrication to chain. 2. Align Sprockets 3. Tighten Chain
Loud popping or grinding noise.	1. Defective bearing. 2. Loose set screws in spockets or bearing. 3. Improper drive chain tension.	1. Replace defective bearing. 2. Tighten loose set screws. 3. Properly tension drive chain.
Motor or Reducer is overheating	1. Overloaded conveyor. 2. Voltage to conveyor is too low. 3. Insufficient amount of lubricant in reducer.	1. Check to ensure that the conveyor belt is not over capacity and reduce load. 2. Have a qualified electrian test the voltage and correct if necessary. 3. Add lubricant to reducers manufacturer recommended level.
Belt does not move, but drive is running.	1) Overloaded conveyor. 2) Belt is too loose. 3) Lagging on drive pulley is worn.	1) Check to ensure that the conveyor belt is not over capacity and reduce load. 2) Tighen belt using belt take-ups. 3) Replace drive pulley lagging and tighten belt.
Belt tracks off at one point along conveyor length	1) One or more idlers near trouble point are out of line. 2) Conveyor sections might be out of square or level. 3) Residue/debris build up on pulleys or idlers.	1) Adjust the idlers near the trouble point. 2) Make necessary adjustments to square the conveyor sections. 3) Remove residue/debris from pulleys and idlers.
Belt tracks to one side at drive or tail pulleys	1) Drive pulley, tail pulley or idlers located near the pulley are not aligned properly or square with the conveyor bed.	1) Adjust pulleys and idlers as necessary.
Belt tracks to one side.	1) Conveyor not level or straight. 2) Residue/debris build up on pulleys or idlers.	1) Ensure that belt sections are aligned and leveled properly. 2) Remove residue/debris from pulleys and idlers.

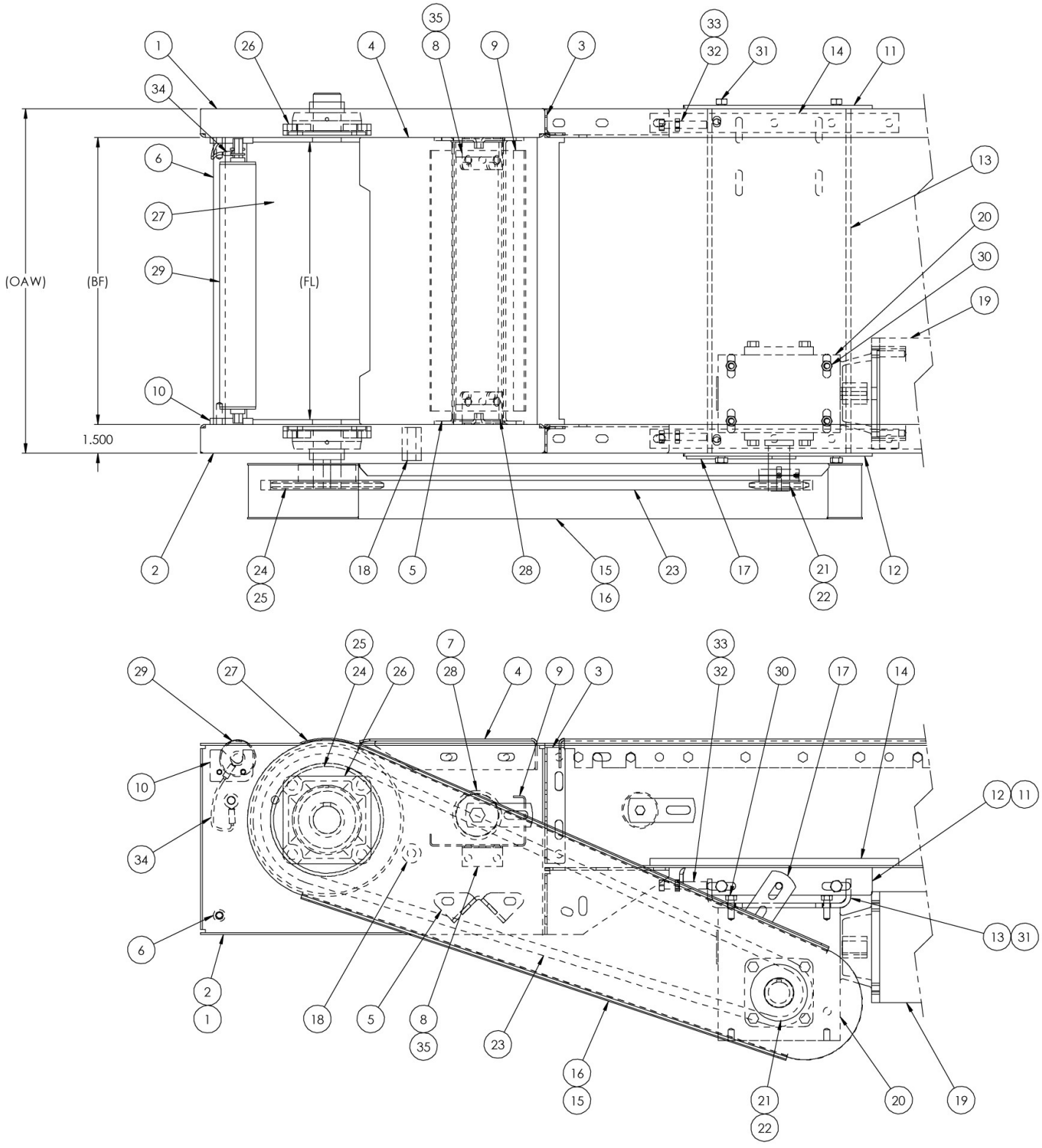
DRAWING AND PARTS LIST (8” END DRIVE)



DET.	PART NO.	DESCRIPTION	DET.	PART NO.	DESCRIPTION
1	SPECIFIC TO ORDER	FRAME CHANNEL	17	SPECIFIC TO ORDER	TAKE-UP CHANNEL WELDMENT- L.H. - 4" OR 6" PULLEY
2	SPECIFIC TO ORDER	8" END DRIVE ASSEMBLY	18	ATL-12929	TAKE-UP SPACER PLATE
3	ATL-12922	SPLICE PLATE TRAPAZOID	19	ATL-12930	TAKE-UP GUIDE PLATE
4	ATL-12940	SNUB ROLLER GUARD MOUNTING BRACKET	20	SPECIFIC TO ORDER	TAKE-UP PLATE WELDMENT - 4" OR 6" PULLEY
5	ATL-12939-BW	SNUB ROLLER GUARD	21	SPECIFIC TO ORDER	NIP POINT MOUNTING WELDMENT- R.H. 4" OR 6" PULLEY
6	ATL-12941	IDLER BRACKET - 7/16" HEX	22	SPECIFIC TO ORDER	NIP POINT MOUNTING WELDMENT- L.H. 4" OR 6" PULLEY
7	ATL-12942-RH	DRIVE GUSSET ANGLE- R.H.	23	SPECIFIC TO ORDER	NIP POINT GUARD - TAIL END- 4" OR 6" PULLEY
8	ATL-12942-LH	DRIVE GUSSET ANGLE- L.H.	24	ATL-10828-OAW	THREADED SECTION SPACER
9	ATL-11695-BF	BED SPREADER	25	ATL-12934	POP-OUT ROLLER BRACKET
10	SPECIFIC TO ORDER	SLIDER PAN	26	SPECIFIC TO ORDER	BEARING: 2-BOLT FLANGE, 1" OR 1 3/16" BORE
11	SPECIFIC TO ORDER	SMS LEG ASSEMBLY	27	SPECIFIC TO ORDER	4" OR 6" DIA. TAIL PULLEY
12	ATL-13286-BF	SNUBBER ROLLER: 2 1/8" DIA.	28	ATL-13029-BF	POP OUT ROLLER: 1.9" DIA.
13	ATL-13287-BF	RETURN ROLLER: 1.9" DIA.	29	ATL-12944	EYE/EYE LANYARD - CABLE ASSEMBLY
14	SPECIFIC TO ORDER	BELT WITH LACING	30	ATL-10791	HEX JAM NUT: 1/2-13
15	ATL-10747	U-TYPE SPEED NUT: 1/4-20	31	ATL-10750	TAKE-UP BOLT: 1/2-13 x 4" L. (FULL THREAD)
16	SPECIFIC TO ORDER	TAKE-UP CHANNEL WELDMENT- R.H. - 4" OR 6" PULLEY			

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

DRAWING AND PARTS LIST (8” END DRIVE ASSEMBLY)

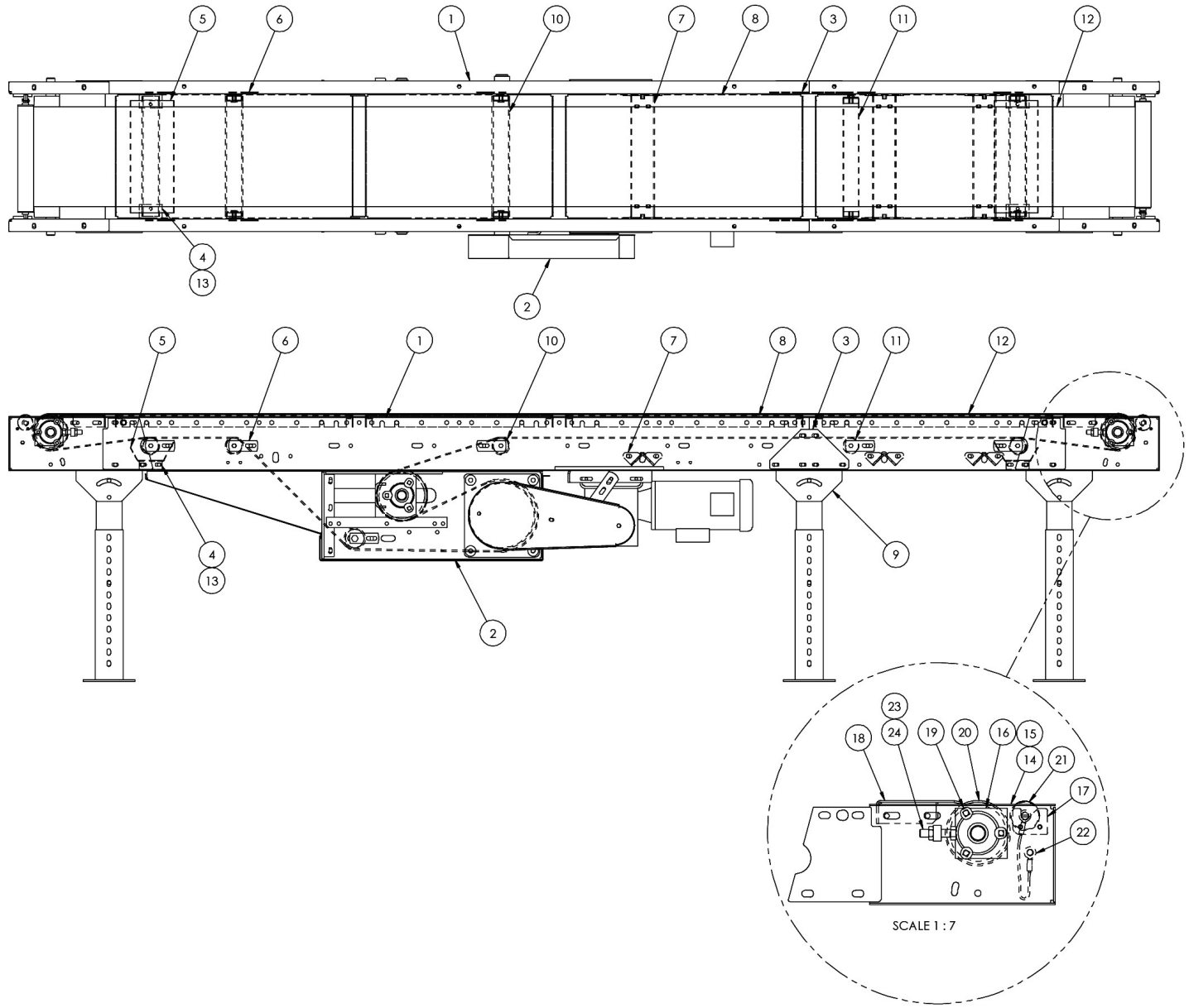


DRAWING AND PARTS LIST (8” END DRIVE ASSEMBLY)

DET.	PART NO.	DESCRIPTION	DET.	PART NO.	DESCRIPTION
1	ATL-12949-RH	DRIVE SUPPORT CHANNEL - R.H.	19	SPECIFIC TO ORDER	MOTOR
2	ATL-12949-LH	DRIVE SUPPORT CHANNEL - L.H.	20	SPECIFIC TO ORDER	REDUCER
3	ATL-12943	BUTT COUPLING ANGLE	21	SPECIFIC TO ORDER	DRIVE SPROCKET (REDUCER)
4	ATL-12945-BW	SLIDER GUARD WELDMENT	22	SPECIFIC TO ORDER	SHAFT KEY - DRIVE SPROCKET
5	ATL-11695-BF	BED SPREADER	23	SPECIFIC TO ORDER	DRIVE CHAIN WITH CONNECTING LINK
6	ATL-10828-OAW	THREADED SECTION SPACER	24	ATL-11252	DRIVEN SPROCKET (DRIVE PULLEY)
7	ATL-10019	SNUB ROLLER BRACKET - 11/16" HEX	25	ATL-10744	PULLEY SHAFT KEY: 3/8" SQ. X 1" L.
8	ATL-11083	SNUB ROLLER GUARD MOUNTING BRACKET	26	ATL-10004	BEARING: 4-BOLT FLANGE, 1 7/16" BORE
9	ATL-12950-BW	SNUB ROLLER GUARD - DRIVE END	27	ATL-10758-FL	8" DIA. DRIVE PULLEY WITH LAGGING
10	ATL-12934	POP-OUT ROLLER BRACKET	28	ATL-13028-BF	SNUBBER ROLLER: 2 9/16" DIA.
11	ATL-12850-RH	MOTOR BASE SUPPORT ANGLE - R.H.	29	ATL-13029-BF	POP OUT ROLLER: 1.9" DIA.
12	ATL-12850-LH	MOTOR BASE SUPPORT ANGLE - L.H.	30	SPECIFIC TO ORDER	REDUCER BOLT
13	SPECIFIC TO ORDER	MOTOR BASE WELDMENT	31	ATL-10749	HEX HEAD BOLT: 3/8-16 x 1" L. (GRADE 8)
14	ATL-10781	REDUCER BASE REINFORCEMENT BAR	32	ATL-10787	TAKE-UP BOLT: 3/8-16 x 2 1/4" L.
15	ATL-11090	CHAIN GUARD FRONT WELDMENT	33	ATL-10790	HEX JAM NUT: 3/8-16
16	ATL-11091	CHAIN GUARD BACK PLATE	34	ATL-12944	EYE/EYE LANYARD - CABLE ASSEMBLY
17	ATL-10780	CHAIN GUARD MOUNTING BAR	35	ATL-10747	U-TYPE SPEED NUT: 1/4-20
18	ATL-10824	SPACER			

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

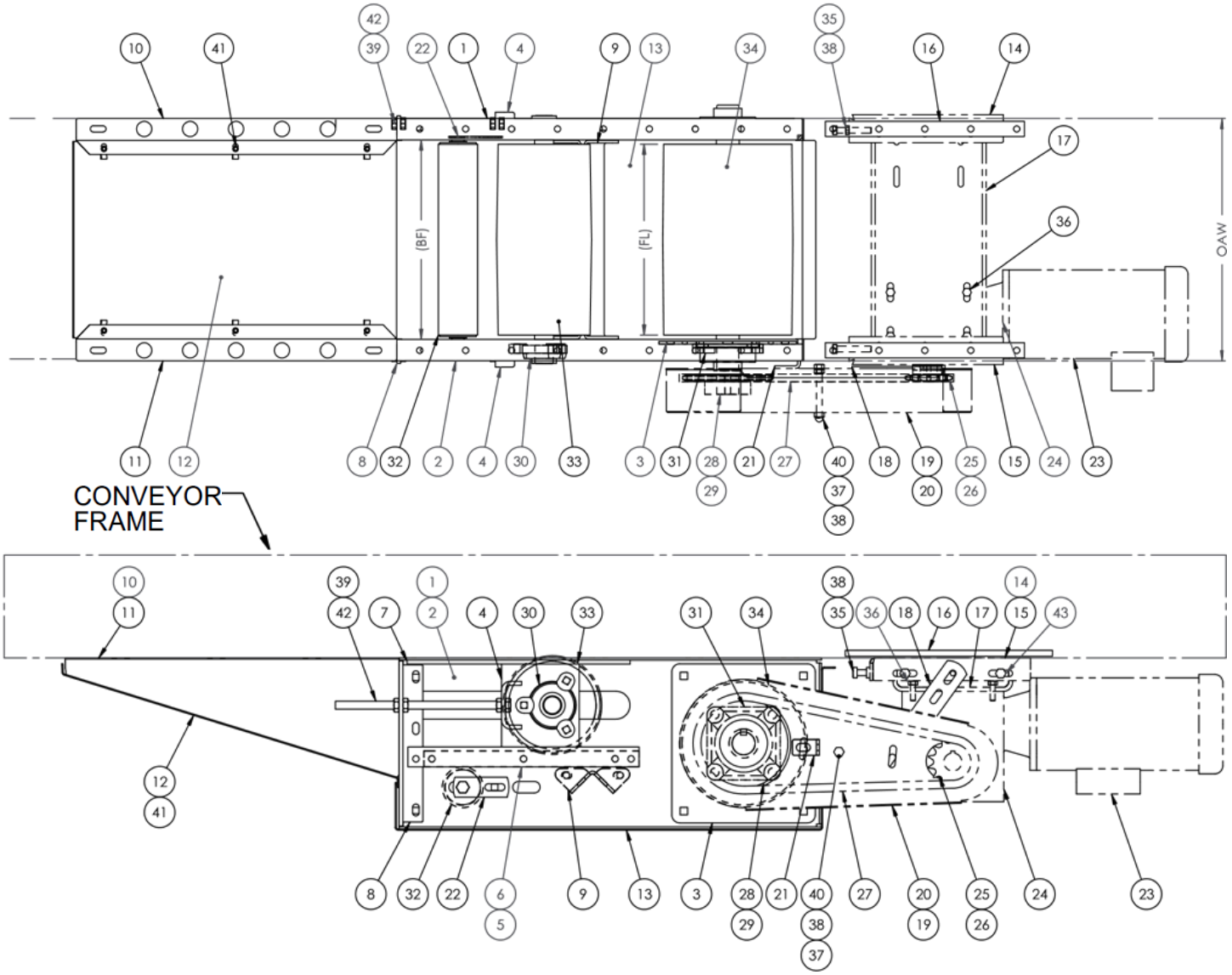
DRAWING AND PARTS LIST (8” CENTER DRIVE)



DET.	PART NO.	DESCRIPTION	DET.	PART NO.	DESCRIPTION
1	SPECIFIC TO ORDER	FRAME CHANNEL	13	ATL-10747	U-TYPE SPEED NUT: 1/4-20
2	SPECIFIC TO ORDER	8" CENTER DRIVE SUB ASSEMBLY	14	SPECIFIC TO ORDER	SYSTEM END CHANNEL-L.H.-WELDMENT-4" OR 6" PULLEY
3	ATL-12922	SPLICE PLATE TRAPAZOID	15	SPECIFIC TO ORDER	SYSTEM END CHANNEL-R.H.-WELDMENT-4" OR 6" PULLEY
4	ATL-12940	SNUB ROLLER GUARD MOUNTING BRACKET	16	SPECIFIC TO ORDER	BEARING SPACER - 1" OR 1-3/16" BORE
5	ATL-12939-BW	SNUB ROLLER GUARD	17	ATL-12934	POP-OUT ROLLER BRACKET
6	ATL-12941	IDLER BRACKET - 7/16" HEX	18	SPECIFIC TO ORDER	SLIDER PLATE-WELDMENT- 4" OR 6" PULLEY
7	ATL-11695-BF	BED SPREADER	19	SPECIFIC TO ORDER	BEARING: 3-BOLT FLANGE, 1" OR 1-3/16" BORE
8	SPECIFIC TO ORDER	SLIDER PAN	20	SPECIFIC TO ORDER	4" OR 6" DIA. TAIL PULLEY
9	SPECIFIC TO ORDER	SMS LEG ASSEMBLY	21	ATL-13029-BF	POP OUT ROLLER: 1.9" DIA.
10	ATL-13286-BF	SNUBBER ROLLER: 2 1/8" DIA.	22	ATL-12944	EYE/EYE LANYARD
11	ATL-13287-BF	RETURN ROLLER: 1.9" DIA.	23	ATL-10791	HEX JAM NUT: 1/2-13
12	SPECIFIC TO ORDER	BELT WITH LACING	24	ATL-12899	1/2-13 X 2" L. - HHCS (FULL THREAD)

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

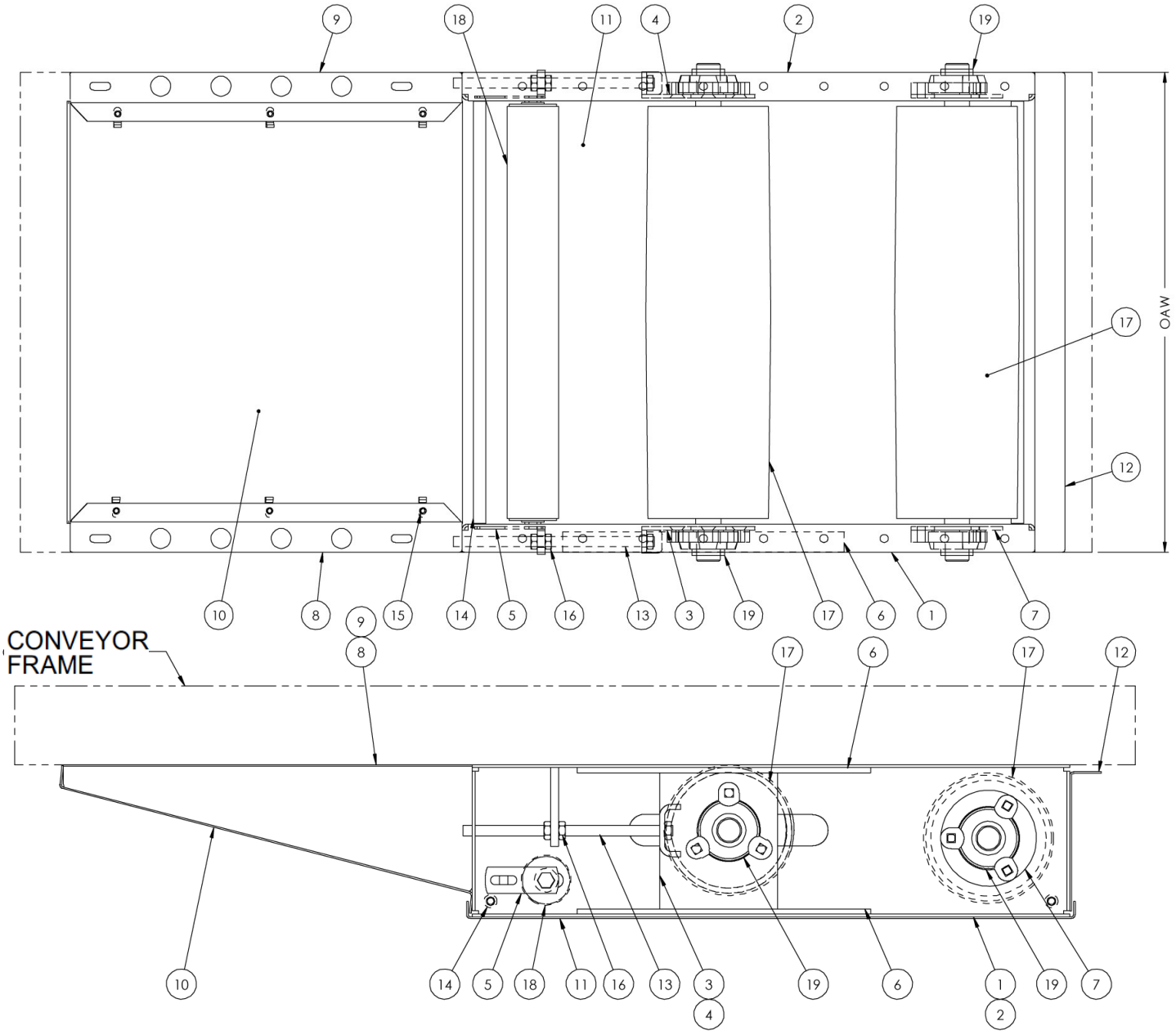
DRAWING AND PARTS LIST (8” CENTER DRIVE ASSEMBLY)



DET.	PART NO.	DESCRIPTION	DET.	PART NO.	DESCRIPTION
1	ATL-10708-RH	DRIVE PLATE WELDMENT - RIGHT HAND	23	SPECIFIC TO ORDER	MOTOR
2	ATL-10708-LH	DRIVE PLATE WELDMENT - LEFT HAND	24	SPECIFIC TO ORDER	REDUCER
3	ATL-10713	BEARING PLATE - CENTER DRIVE	25	SPECIFIC TO ORDER	DRIVE SPROCKET (REDUCER)
4	ATL-10714	TAKE-UP PLATE WELDMENT	26	ATL-10743	PULLEY SHAFT KEY 1/4" SQ X 1 1/4" L.
5	ATL-10717	BEARING GUIDE SPACER	27	SPECIFIC TO ORDER	DRIVE CHAIN: RC50 WITH CONNECTING LINK
6	ATL-10718	BEARING GUIDE	28	ATL-11252	DRIVE SPROCKET (DRIVE PULLEY)
7	ATL-10719	UPPER BEARING GUIDE	29	ATL-10744	SHAFT KEY: 3/8" SQ. X 1" L.
8	ATL-10720	TAKE UP ANGLE - CENTER DRIVE	30	ATL-10003	BEARING: 3-BOLT FLANGE, 1 3/16" BORE
9	ATL-11695-BF	BED SPREADER	31	ATL-10004	BEARING: 3-BOLT FLANGE, 1 7/16" BORE
10	ATL-10724-RH	SIDE GUARD - RIGHT HAND	32	ATL-13028-BF	SNUBBER ROLLER: 2 9/16" OD
11	ATL-10724-LH	SIDE GUARD - LEFT HAND	33	ATL-10756-FL	6" DIA. TAKE-UP PULLEY
12	ATL-10021-OAW	BOTTOM ANGLE GUARD - CENTER DRIVE	34	ATL-10758-FL	8" DIA. DRIVE PULLEY (LAGGED - 8 1/2" DIA. FINISHED)
13	ATL-10020-OAW	BOTTOM GUARD - CENTER DRIVE	35	ATL-10787	TAKE-UP BOLT: 3/8-16 x 2 1/4" L. (FULL THREAD)
14	ATL-12850-RH	MOTOR BASE SUPPORT ANGLE - RIGHT HAND	36	ATL-10789	HEX HEAD BOLT: 5/16-18 x 1" L. (GRADE 8)
15	ATL-12850-LH	MOTOR BASE SUPPORT ANGLE - LEFT HAND	37	ATL-10788	HEX HEAD BOLT: 3/8-16 x 3 1/4" L. (FULL THREAD)
16	ATL-10781	REDUCER BASE REINFORCEMENT BAR	38	ATL-10790	HEX JAM NUT: 3/8-16
17	ATL-10710-OAW	MOTOR BASE WELDMENT	39	ATL-10791	HEX JAM NUT: 1/2-13
18	ATL-10780	CHAIN GUARD MOUNTING BAR	40	ATL-10748	ACORN NUT: 3/8-16
19	ATL-12854	CHAIN GUARD FRONT WELDMENT	41	ATL-10747	U-TYPE SPEED NUT: 1/4-20
20	ATL-12855	CHAIN GUARD BACK PLATE	42	ATL-11278	THREADED ROD: 1/2-13 x 11" L.
21	ATL-12856	BRACKET - GUARD SUPPORT	43	ATL-10749	HEX HEAD BOLT: 3/8-16 x 1" L. (GRADE 8)
22	ATL-10019	RETURN ROLLER BRACKET - 11/16" HEX			

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

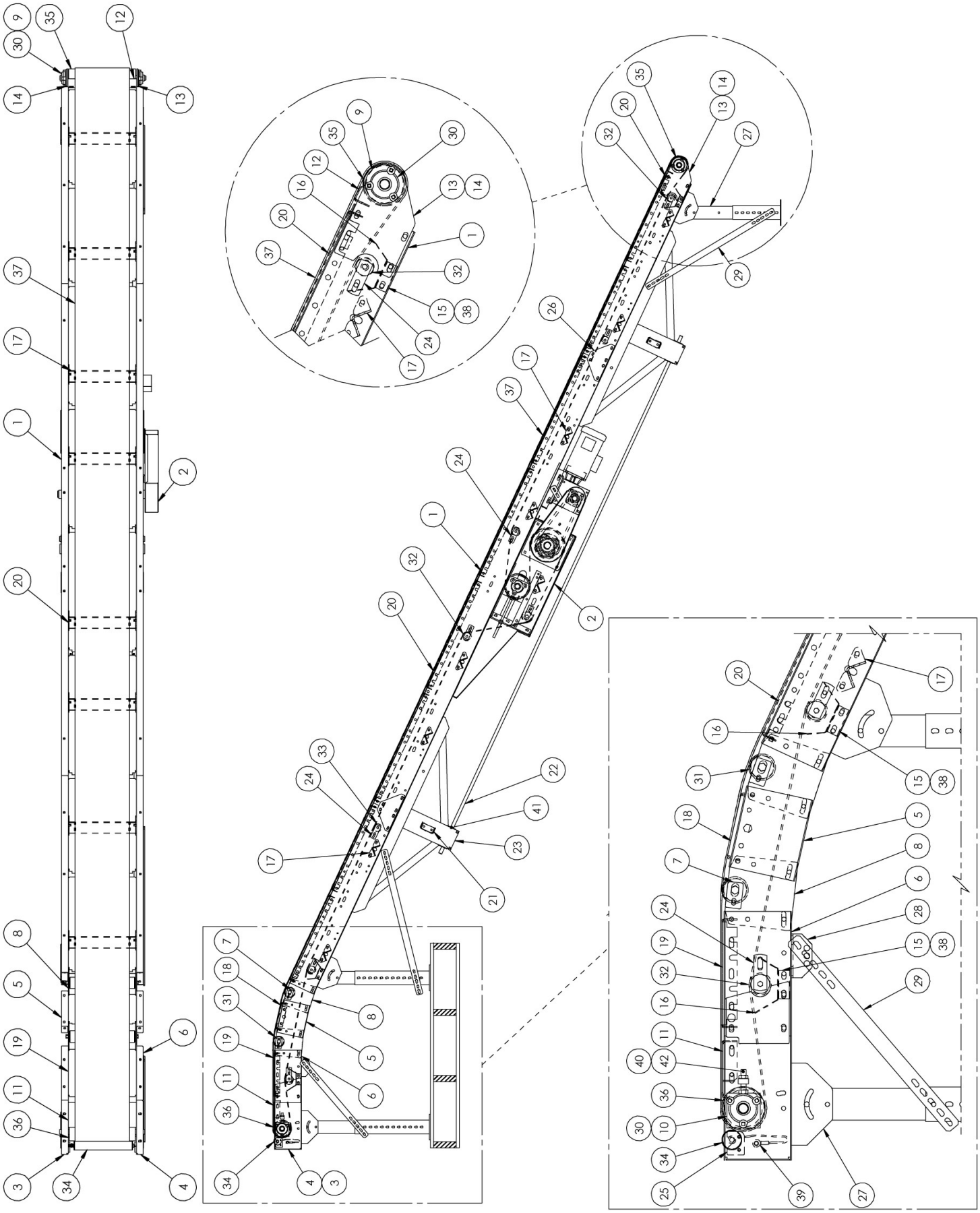
DRAWING AND PARTS LIST (6” UNDERSIDE TAKE-UP ASSEMBLY)



DET.	PART NO.	DESCRIPTION
1	ATL-13843-LH	SIDE CHANNEL WELDMENT - LEFT HAND
2	ATL-13843-RH	SIDE CHANNEL WELDMENT - RIGHT HAND
3	ATL-13844-LH	TAKE-UP PLATE WELDMENT - LEFT HAND
4	ATL-13844-RH	TAKE UP PLATE WELDMENT - RIGHT HAND
5	ATL-10019	RETURN ROLLER BRACKET - 11/16" HEX
6	ATL-10719	UPPER BEARING GUIDE
7	ATL-11099	BEARING SPACER (1 3/16" SHAFT)
8	ATL-13847-LH	SIDE GUARD - LEFT HAND
9	ATL-13847-RH	SIDE GUARD - RIGHT HAND
10	ATL-13846-OAW	BOTTOM ANGLE GUARD
11	ATL-13842-OAW	BOTTOM GUARD
12	ATL-13845-OAW	REAR GUARD - UNDERSIDE TAKE-UP
13	ATL-11279	THREADED ROD: 1/2-13 X 10" L.
14	ATL-10828-OAW	THREADED SECTION SPACER
15	ATL-10747	U-TYPE SPEED NUT: 1/4-20
16	ATL-10791	HEX JAM NUT: 1/2-13
17	ATL-10756-FL	6" DIA. TAIL/TAKE-UP PULLEY
18	ATL-13028-BF	SNUBBER ROLLER: 2 9/16" OD
19	ATL-10003	BEARING: 3-BOLT FLANGE, 1 3/16" BORE
20	ATL-12904	SERRATED FLANGE HEX LOCKNUT: 3/8-16

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

DRAWING AND PARTS LIST (BSI CONVEYOR)

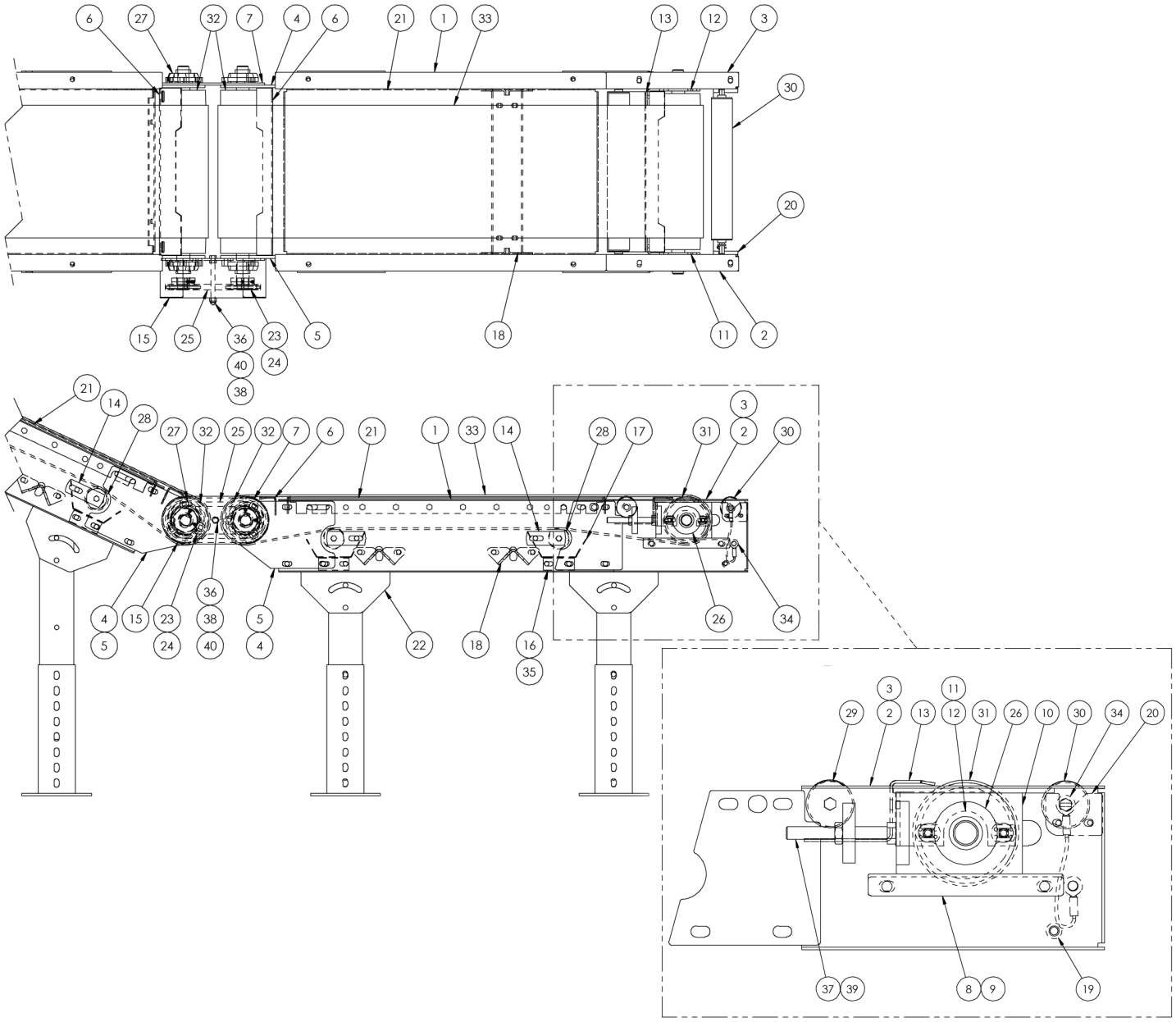


DRAWING AND PARTS LIST (BSI CONVEYOR)

DET.	PART NO.	DESCRIPTION
1	SPECIFIC TO ORDER	FRAME CHANNEL
2	SPECIFIC TO ORDER	8" CENTER DRIVE SUB ASSEMBLY
3	SPECIFIC TO ORDER	SYSTEM END CHANNEL WELDMENT - RIGHT HAND
4	SPECIFIC TO ORDER	SYSTEM END CHANNEL WELDMENT - LEFT HAND
5	ATL-13090	8" LONG - NOSE-OVER CHANNEL
6	ATL-13098	12" LONG - FRAME CHANNEL
7	ATL-13089	ROLLER BRACKET - NOSE-OVER
8	ATL-13088	SPLICE PLATE - NOSE-OVER
9	SPECIFIC TO ORDER	BEARING SPACER ROUND END
10	SPECIFIC TO ORDER	BEARING SPACER
11	SPECIFIC TO ORDER	SLIDER PLATE WELDMENT
12	SPECIFIC TO ORDER	NIP POINT GUARD
13	SPECIFIC TO ORDER	DRIVE PLATE WELDMENT 4" OR 6" PULLEY - RIGHT HAND (ROUND END)
14	SPECIFIC TO ORDER	DRIVE PLATE WELDMENT 4" OR 6" PULLEY - LEFT HAND (ROUND END)
15	ATL-12940	SNUB ROLLER GUARD MOUNTING BRACKET
16	ATL-12939-BW	SNUB ROLLER GUARD
17	ATL-11695-BF	BED SPREADER
18	ATL-13093-BW	SLIDER PAN - 6 1/2" L.
19	ATL-13094-BW	SLIDER PAN - 10 1/2" L.
20	SPECIFIC TO ORDER	SLIDER PAN
21	ATL-12864-BW	CROSS BRACE
22	SPECIFIC TO ORDER	TRUSS ROD
23	ATL-12860	TRUSS ROD END BRACKET
24	ATL-12941	IDLER BRACKET - 7/16" HEX
25	ATL-12934	POP-OUT ROLLER BRACKET
26	ATL-12922	SPLICE PLATE TRAPAZOID
27	SPECIFIC TO ORDER	SMS LEG ASSEMBLY
28	ATL_10413	KNEE BRACE FRAME MOUNTING BRACKET
29	SPECIFIC TO ORDER	KNEE BRACE
30	SPECIFIC TO ORDER	BEARING: 3-BOLT FLANGE
31	ATL-13028-BF	SNUBBER ROLLER: 2 9/16" DIA.
32	ATL-13286-BF	SNUBBER ROLLER: 2 1/8" DIA.
33	ATL-13287-BF	RETURN ROLLER: 1.9" DIA.
34	ATL-13029-BF	POP-OUT ROLLER: 1.9" DIA.
35	SPECIFIC TO ORDER	4" OR 6" DIA. DRIVING TAIL PULLEY
36	SPECIFIC TO ORDER	4" OR 6" DIA. TAIL PULLEY
37	SPECIFIC TO ORDER	BELT WITH LACING
38	ATL-10747	U-TYPE SPEED NUT: 1/4-20
39	ATL-12944	EYE/EYE LANYARD - CABLE ASSEMBLY
40	ATL-10791	HEX JAM NUT: 1/2-13
41	ATL-13144	FLAT WASHER: 3/4"
42	ATL-12899	HEX HEAD BOLT: 1/2-13 X 2" LONG (FULL THREAD)

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

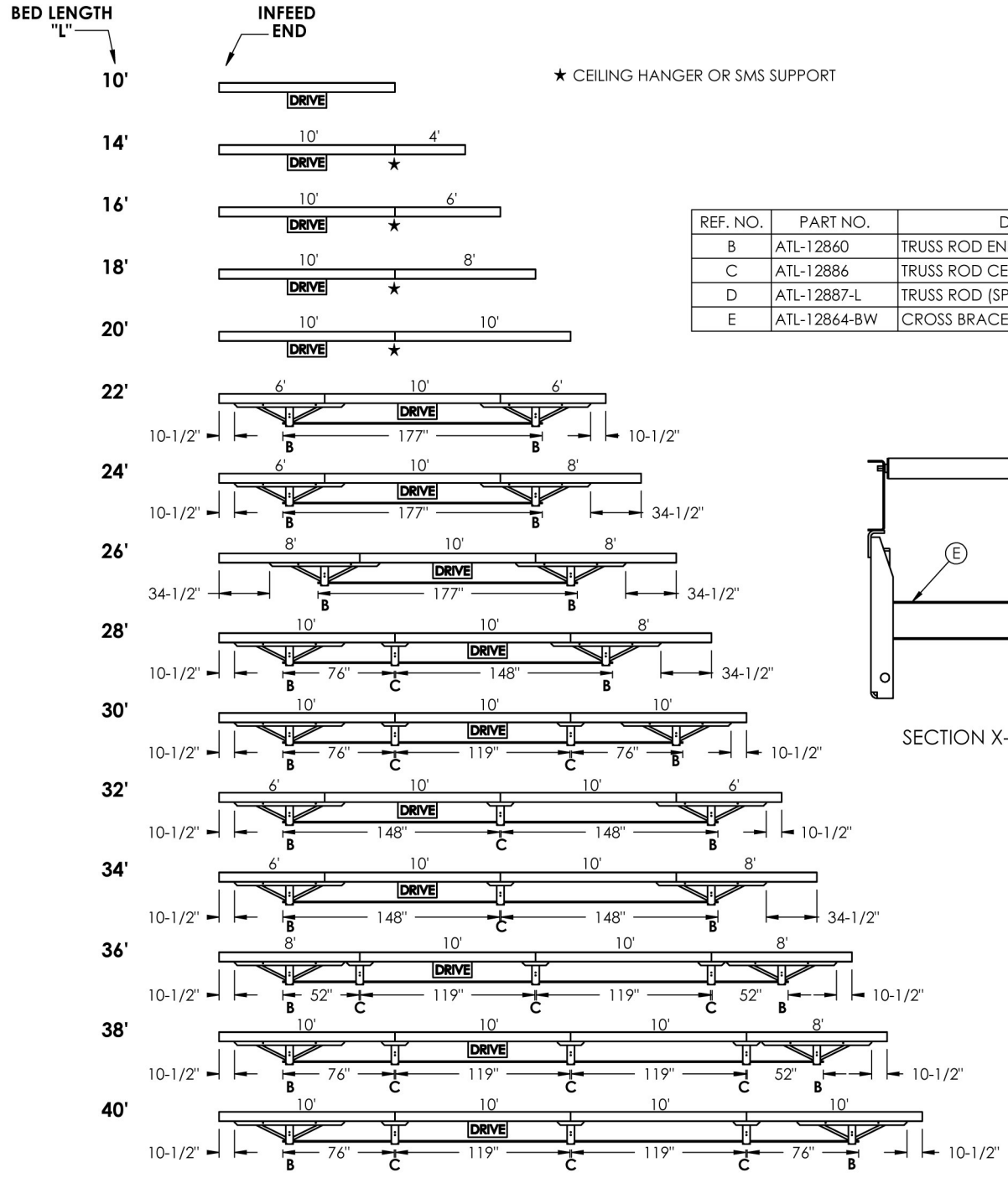
DRAWING AND PARTS LIST (BSI POWER FEEDER)



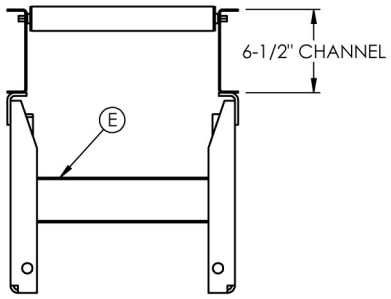
DET.	PART NO.	DESCRIPTION	DET.	PART NO.	DESCRIPTION
1	SPECIFIC TO ORDER	FRAME CHANNEL	21	SPECIFIC TO ORDER	SLIDER PAN
2	SPECIFIC TO ORDER	TAKE-UP CHANNEL WELDMENT - RIGHT HAND - 4" OR 6" PULLEY	22	SPECIFIC TO ORDER	SMS LEG ASSEMBLY
3	SPECIFIC TO ORDER	TAKE-UP CHANNEL WELDMENT - RIGHT HAND - 4" OR 6" PULLEY	23	SPECIFIC TO ORDER	POWER TRANSITION SPROCKET
4	SPECIFIC TO ORDER	DRIVE PLATE WELDMENT - 4" OR 6" PULLEY - RIGHT HAND (ROUND END)	24	SPECIFIC TO ORDER	PULLEY SHAFT KEY
5	SPECIFIC TO ORDER	DRIVE PLATE WELDMENT - 4" OR 6" PULLEY - LEFT HAND (ROUND END)	25	SPECIFIC TO ORDER	POWERED FEEDER CHAIN
6	SPECIFIC TO ORDER	NIP POINT GUARD - 4" OR 6" DRIVING TAIL PULLEY	26	SPECIFIC TO ORDER	BEARING: TAKE-UP, 1" OR 1 3/16" BORE
7	SPECIFIC TO ORDER	PIVOT PLATE - 4" OR 6" PULLEY	27	SPECIFIC TO ORDER	BEARING: 3-BOLT FLANGE, 1" OR 1 3/16" BORE
8	ATL-12930	TAKE-UP GUIDE PLATE	28	ATL-13286-BF	SNUBBER ROLLER: 2 1/8" DIA.
9	ATL-12929	TAKE-UP SPACER PLATE	29	ATL-13287-BF	RETURN ROLLER: 1.9" DIA.
10	SPECIFIC TO ORDER	TAKE-UP PLATE WELDMENT - 4" OR 6" PULLEY	30	ATL-13029-BF	POP-OUT ROLLER: 1.9" DIA.
11	SPECIFIC TO ORDER	NIP POINT MOUNTING WELDMENT - RIGHT HAND - 4" OR 6" PULLEY	31	SPECIFIC TO ORDER	4" OR 6" DIA. TAIL PULLEY
12	SPECIFIC TO ORDER	NIP POINT MOUNTING WELDMENT - LEFT HAND - 4" OR 6" PULLEY	32	SPECIFIC TO ORDER	4" OR 6" DIA. DRIVING TAIL PULLEY
13	SPECIFIC TO ORDER	NIP POINT GUARD - 4" OR 6" PULLEY TAIL END	33	SPECIFIC TO ORDER	BELT WITH LACING
14	ATL-12941	IDLER BRACKET - 7/16" HEX	34	ATL-12944	EYE/EYE LANYARD - CABLE ASSEMBLY
15	SPECIFIC TO ORDER	CHAIN GUARD WELDMENT - 4" OR 6" PULLEY	35	ATL-10747	U-TYPE SPEED NUT: 1/4-20
16	ATL-12940	SNUB ROLLER GUARD MOUNTING BRACKET	36	ATL-10748	ACORN NUT: 3/8-16
17	ATL-12939-BW	SNUB ROLLER GUARD	37	ATL-10750	HEX HEAD BOLT: 1/2-13 x 4" L. (FULL THREAD)
18	ATL-11695-BF	BED SPREADER	38	ATL-10790	HEX JAM NUT: 3/8-16
19	ATL-10828-OAW	THREADED SECTION SPACER	39	ATL-10791	HEX JAM NUT: 1/2-13
20	ATL-12934	POP-OUT ROLLER BRACKET	40	ATL-13121	HEX HEAD BOLT: 3/8-16 X 4" L.

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

DRAWING AND PARTS LIST (UNDER TRUSSING)

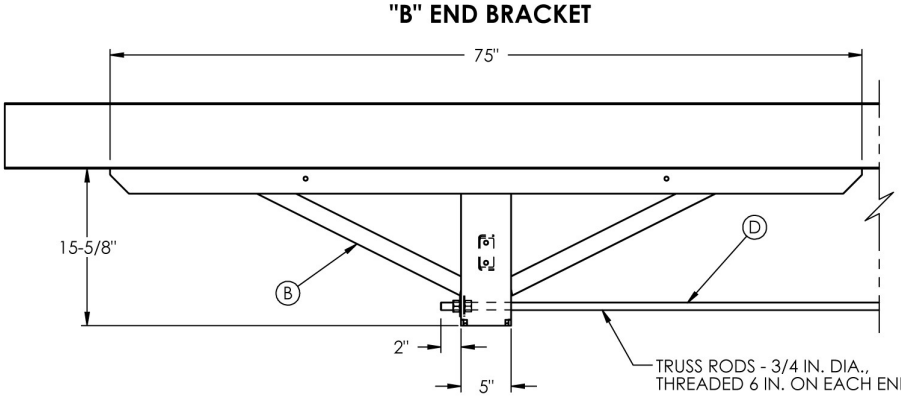


REF. NO.	PART NO.	DESCRIPTION
B	ATL-12860	TRUSS ROD END BRACKET
C	ATL-12886	TRUSS ROD CENTER BRACKET
D	ATL-12887-L	TRUSS ROD (SPECIFY LENGTH)
E	ATL-12864-BW	CROSS BRACE (SPECIFY BELT WIDTH)

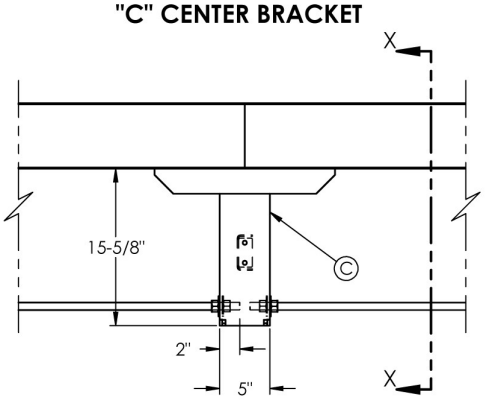


SECTION X-X

"B" END BRACKET



"C" CENTER BRACKET



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