

## Section III. Assembly & Installation Instructions

### Pulley Removal and Installation - External Direct Drive Pulley



(Fig. H1)



(Fig. H2)



(Fig. H3)



(Fig. H4)

1. Run conveyor until lacing is at the drive pulley. (Fig. H1)
2. Tighten tail pulley take-ups to put slack in the conveyor belt. (Fig. H2)
3. Remove the lacing pin and allow belt to move away from pulley. (Fig. H3)
4. Loosen / remove bolt in the end of the pulley shaft. (Fig. H4)

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(Fig. H5)



(Fig. H6)



(Fig. H7)



(Fig. H8)

5. Remove bolt from reaction rod and G/B lower bracket. Use caution as the gearbox / motor can swing down. (Fig. H5)
6. Remove gearbox / motor from the end of pulley drive shaft. Use caution not to lose drive key when removing G/B. (Fig. H6)
7. Loosen the take-ups allowing them to slide off the frame. (Fig. H7)
8. Slide take-ups off the pulley shaft. Bearings may be replaced at this time. (Fig. H8)

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(Fig. H9)

9. Remove setscrews from pulley end cap (2 each side) (Fig. H9)

10. Slide shaft out of pulley. Use caution not to lose drive keys. (Fig. H10)



(Fig. H10)

11. Remove tapered screws from drive end cap / pulley. (4 each side) These parts are threadlocked at the factory and may require heat to dis-assemble. (Fig. H11)

12. Pulley, shaft, or end cap's may be replaced at this time. (Fig. H12)

13. Re-install in reverse order. Heavy duty threadlock (red) must be used on the (4) tapered screws in each end cap. Serviceable threadlock must be used on small set screws (2) in each end cap.



(Fig. H11)



(Fig. H12)