

### Section III. Assembly & Installation Instructions

## Pulley Removal and Installation - Internal Motor Drive Pulley



(Fig. F1)

1. Run conveyor until the lacing is at the drive pulley. (Fig. F1)
2. Tighten tail pulley take-up bolts to put slack in the conveyor belt. (Fig. F2)
3. Remove lacing pin and allow belt to move away from pulley and off the top slide trays. (Fig. F3)



(Fig. F2)

4. Remove the (2) screws and slide tray retainers. (Fig. F4)



(Fig. F3)



(Fig. F4)

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(Fig. F5)

5. Remove slide tray over the motor exposing the internal drive belt. (Fig. F5)

6. Tighten the take-up bolts pulling the pulley in and putting slack in the internal drive belt. (Fig. F6)



(Fig. F6)

7. Slide internal drive belt off of 19 tooth drive pulley. (Fig. F7). If frame to pulley clearance prohibits belt removal you will need to remove the bolts at the motor end of the frame cross member and loosen bolts at the opposite end allowing the cross member to shift and provide clearance for belt removal.

8. Loosen the set screw in the end of each take-up. (Fig. F8)



(Fig. F7)



22 (Fig. F8)

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(Fig. F9)

9. Loosen take-up bolts allowing the take-ups to slide off the frame. (Fig. F9)

10. Slide take-ups off the pulley shaft. (Fig. F10)

11. Remove pulley spacers. (Fig. F11)



(Fig. F10)

12. Pulley, Bearings, drive belt, or shaft may be replaced at this time.

13. Re-install in reverse order. Use serviceable threadlock on take-up set screws during re-assembly. Set internal drive belt tension to  $\frac{1}{4}$ " deflection.



(Fig. F11)