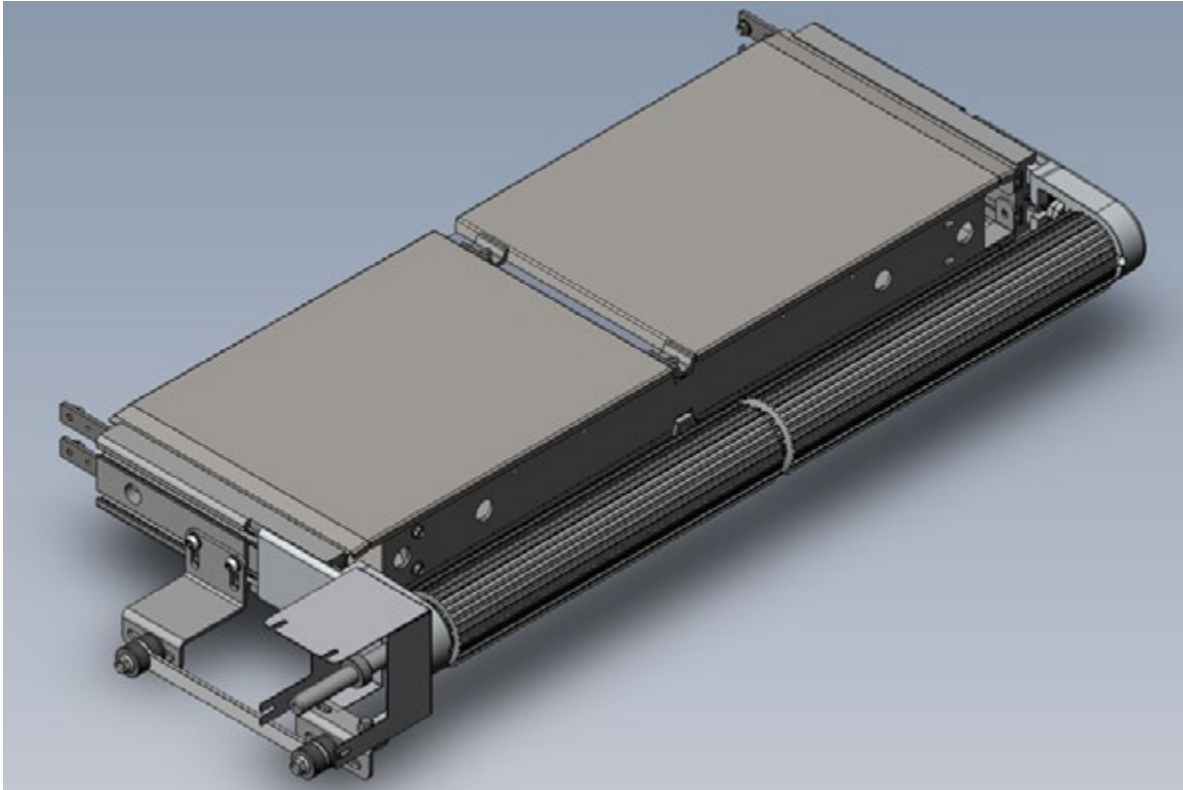


# EA Conveyor M1 – M2 Motor Flip (Direct Drive)



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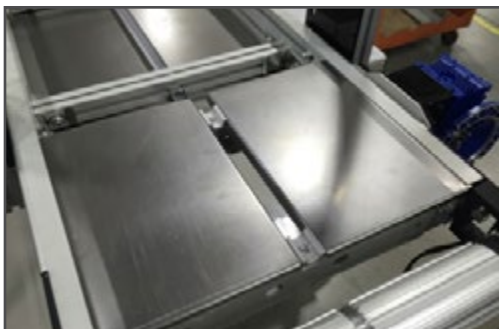
(Fig. 1)



(Fig. 2)



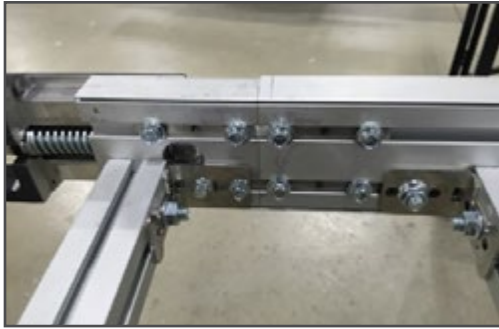
(Fig. 3)



(Fig. 4)

1. Remove side rails at the drive end of the conveyor (Fig. 1)
2. Operate conveyor until conveyor belt lacing appears at the drive end of the conveyor. (Fig. 2)
3. Stop conveyor and unplug the conveyor. (If hard wired perform LOTO to prevent accidental start up of the machine)
4. Relieve conveyor belt tension by tightening tension bolts in the tail (non-drive) end of the conveyor. (Fig. 3)
5. Remove belt lacing and roll belt back exposing the drive head of the conveyor.
6. Remove the (2) ¼" flat head screws holding the slide trays on the top and underside of the conveyor. (Fig. 4)
7. Remove slide tray retainers and remove both top and bottom trays. (retain all parts for re-assembly later) (Fig. 4)

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(Fig. 5)

8. Loosen the ¼" X ½" hex head bolts in the frame splice brackets ( 4-6 bolts on each side) (Fig. 5)
9. Remove the reducer guard. (Fig. 10) Disconnect the reaction rod from the reducer (use caution, motor can revolve freely). (Fig. 6) Remove 3/8" bolt from the pulley shaft and remove motor / reducer assembly. Use caution not to lose the reducer drive key.



(Fig. 6)

10. Drive head can now be separated from the main frame inverted 180 degrees and re-installed.
11. Tighten the bolts into the splice brackets while holding the drive assembly into the frame to insure proper seating between the head and frame.



(Fig. 7)

12. Invert reaction rod bracket as required.
13. Move motor control as required or lengthen electrical leads to motor as required. Electrical connection box on motor can be rotated as required. (customer preference) (Fig. 7)



(Fig. 8)

14. Install the motor / reducer combo onto the driveshaft with the square drive key and secure with 3/8" bolt against collar. Use of anti seize compound on the square drive key is recommended. (Fig. 8)

## EA Conveyor M1 – M2 Motor Flip (Direct Drive)



(Fig. 9)



(Fig. 10)

15. Re-attach the reaction rod to the reducer with 3/8" bolt. (Fig. 9)

16. Install the reducer guard (Fig. 10)

17. Re-install the slide trays to the top and bottom side of the conveyor using the retainers and 1/4"-20 flat head screws previously removed in step 7.

18. Complete the remaining re-assembly in reverse order. Use the operators manual to set belt tension and tracking beginning on page 13. (Manual originally shipped with conveyor or available online at [EMInc.com](http://EMInc.com))