

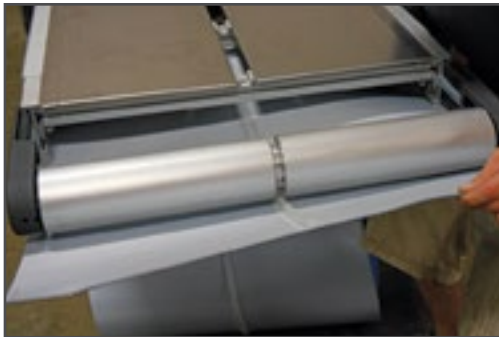
Section III. Assembly & Installation Instructions

Laced Belt Installation for Extruded Aluminum Conveyors

It is necessary to ship longer conveyors disassembled due to the length. In this case, the conveyor frames will need to be assembled and the belt will need to be installed and tracked. After the frames are assembled and the legs (if so equipped) are assembled on the conveyor, the belt is ready to be installed.



(Fig. A1)



(Fig. A2)



(Fig. A3)



(Fig. A4)

1. To install the belt, first remove the take-up slot adjustment cover to expose the take-up adjusting screws on both sides. Set the tail or idler pulley all the way into the frame. Do not change the factory setting of the drive pulley. (Fig. A1)
2. The belt is shipped rolled up and should be placed on a clean surface at the drive end of the conveyor. Remove the lacing pin from the belt lacing. Start feeding the belt through on the underneath side of the conveyor, making sure the topside of the belt is down. (Fig. A2)
3. For flat and cleated belt EA conveyors, make sure the belt is on top of the bottom belt return supports or rollers, and top of the slide tray. (Fig. A3 & A4)

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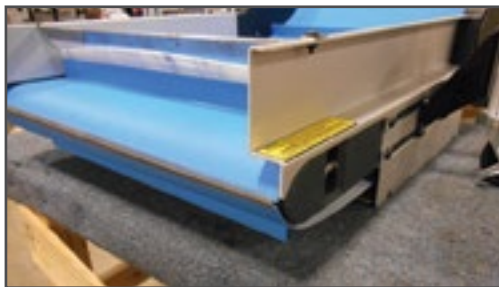
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(Fig. A5)



(Fig. A6)



(Fig. A7)

4. For adjustable angle EA conveyors, make sure the belt is under the transition rollers on both the top and bottom of the conveyor. (Fig. A5 and Fig. A6)
5. Start at the tail pulley end and feed the belt along the slide bed making sure the belt is under the side rails. Wrap around the drive pulley and feed the belt back on top of the bottom slide trays.
6. When the leading end of the belt gets back to the tail pulley or idler pulley, the lacing pin is ready to be installed. (Fig. A7)

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(Fig. A8)

7. Make sure the center V-guide is aligned. (Fig. A8)

8. Install the lacing pin. (Fig. A9)



(Fig. A9)

9. Bend the lacing pin at each end to keep it from working out. The bent portion of the pin should fit in the notched portion of the belt. (Fig. A10)



(Fig. A10)