



INSTRUCTIONS

FOR

BOTTLE AND PARTS

CONVEYOR - HORIZONTAL



PPE Conveyors are manufactured and sold direct by Plastic Process Equipment, Inc. We are not associated with any other manufacturer. Always specify genuine PPE conveyors! Do not accept substitutes.

MODEL NO.

BCH-

SERIAL NO.

Revised 9-11-18

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PLASTIC PROCESS EQUIPMENT, INC.

www.ppe.com • e-mail: sales@ppe.com

PPE
WEST

6385 Montessouri Street, Las Vegas, Nevada 89113
702-433-6385 • 800-258-8877 • Fax: 702-433-6388

PPE
SOUTH

11218 Challenger Avenue, Odessa, Florida 33556
727-834-8888 • 800-282-6783 • Fax: 727-834-8873

8303 CORPORATE PARK DRIVE, MACEDONIA (Cleveland), OHIO 44056, USA

216-367-7000 • Toll Free: 800-321-0562 • Fax: 216-367-7022 • Order Fax: 800-223-8305

Toll Free: USA, Canada & Mexico
800-362-0706

Thank you for purchasing a conveyor from Plastic Process Equipment. These instructions are intended as a guide for your new product. If you have additional questions, contact PPE at 800-362-0706.

RECEIVING

Thoroughly inspect your new conveyor before unpacking for setup. Report any damage to the motor freight carrier; they are responsible for damages incurred during transit.

ATTENTION!!

Please read through the entire booklet first.

You must be trained and authorized by your employer in the proper installation operation, maintenance and set-up of your new equipment. ***Safety First Always!***

LEGS SET-UP (REQUIRES TWO PEOPLE)

- 1) Loosen the leg brackets (*see Figure 1*) only to change position.

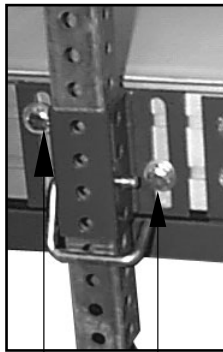


Figure 1

LOOSEN THESE BOLTS

- 2) Leg brackets are perpendicular to the floor (done at assembly).
- 3) To insert unistrut leg assembly loosen 3/8-16 x 3" hex bolt & nut - loosen 5/16-18 x 3/4" hex bolts & nuts.
- 4) Loosen CW4 casters.
- 5) Insert unistrut leg assembly into leg brackets. Set the locking pins.
- 6) Retighten 3/8-16 x 3" hex bolt & nut - retighten 5/16-18 x 3/4" hex bolts & nuts.
- 7) Adjust legs to required position and height.
- 8) Retighten CW4 casters.

This should align unistrut & leg bracket locking pins used to adjust height.

ELECTRICAL

- 1) Always use a grounded 120 volt outlet and a suitable three wire grounded extension cord.

- 2) All conveyors are equipped with a starter switch and an overload protection heater properly sized for the drive motor. The On/Off switch on some models is resettable, should the switch get overloaded for some reason it may be necessary to reset it before the conveyor will run again. See switch cover for reset instructions.

WARNING DRIVE MOTOR

The standard 1/6hp 655 drive motor is not designed for repeated start stop operation, if you turn the conveyor on and off more than 10 times per hour you damage the motor by overheating. There are special order motors available for start/stop operations, please consult the factory.

CAUTION DURING USE AND OPERATION OF CONVEYOR

- Do not wear loose clothing or jewelry around the conveyor.
- Do not wear rings, necklaces, or jewelry.
- Long hair must be tied and netted.
- Keep all hands, arms, and fingers away from any moving parts except the conveyor belt surface.
- Never stand on the conveyor belt for any reason whatsoever.
- Do not operate any conveyor with the guards removed.
- Do not operate the conveyor with parts missing, removed, or in a disassembled state.
- Pay special attention to the ON-OFF switch location.
- Wear safety glasses if your company or process requires them.
- You must unplug the conveyor before performing any repairs or maintenance.
- If you are unsure about installation, operation, maintenance, or setup call PPE!

BELT TRACKING AND TENSION

All conveyors and separators are thoroughly tested in our factory after final assembly. Although the belts are adjusted to track properly with the right amount of tension, some adjustments may be necessary during use. For best results and longevity of the drive components, the belt should be run with the **LEAST** tension needed to transport the load without slipping. If the belt is too loose, it will slip causing wear to the belt's underside. **CAUTION: DO NOT OVERTIGHTEN THE CONVEYOR BELT.** An overtightened belt will cause premature failure of your bearings, shafts and, on some models, the drive unit.

BELT TRACKING: THE V-BELT STYLE

The V-Belt tracking system keeps your belt centered and tracking properly. No adjustment should be necessary if both take up bolts are adjusted the same amount during belt tension adjustment. To check the tracking of your belt, measure the take up bolts on both sides of the conveyor. The distance between the center of the roller shaft and the bracket behind the locking nut should be the same for both bolts.

LUBRICATION

NOTE: Roller bearings are permanently lubricated. Do not lubricate! Chain drives should be inspected every month and lubricated with a light oil every three to six months under normal operating conditions. If your conveyor is used on a continuous basis, you may need to lubricate more often. To inspect your chain drive, disconnect the power and remove the chain guard on the drive side of the conveyor (*see Figure 2*). Re-torque bearing set screws after 24 hours of operation.



Figure 2

BELT REPLACEMENT (REQUIRES TWO PEOPLE)

- 1) Remove end caps (*see Figure 2*).
- 2) Remove legs.
- 3) Using a pencil draw a vertical line across the frame and siderails (used to align side rails during reassembly).
- 4) Loosen side rail bolts, but do not remove the bolts (side rails slide off with bolts attached).
- 5) Slide side rails off (away from motor end).
- 6) Back out adjustment nuts on roller support shaft (three locations) (*see Figure 3*).
When retightening the roller support shaft, the distance from the edge of the frame to the center of the shaft should be 3-5/8" (*see Figure 3*).

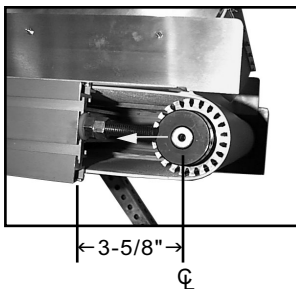


Figure 3

- 7) Mark edge of plate against the frame on the drive end side (*see Figure 4*) (for adjustment during reassembly).

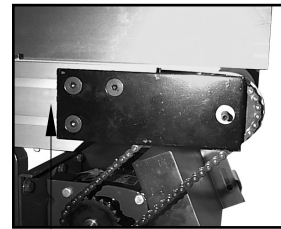


Figure 4

PLACE MARK HERE

- 8) Loosen the three Allen head bolts from drive side mounting plate (*see Figure 4*) (allows plate to move towards center of conveyor).
- 9) Place conveyor on drive side (must be supported to clear on-off switch).
- 10) Remove two bolts from motor mounting plate (*see Figure 5*).



Figure 5

REMOVE THESE
TWO BOLTS

- 11) Pull belt halfway off the non-drive side roller.
- 12) Remove the belt from the drive roller.
- 13) To reassemble the conveyor, follow the instructions in reverse order. When reinstalling the belt, the Vee-Guide on the bottom of the belt is seated in the groove of the rollers.

WARRANTY

All PPE Conveyors have a full **two year warranty**. This warranty doesn't include conveyor belts because they are subject to excessive wear damage and abuse by the user. This Warranty should not extend to goods subjected to misuse, abuse, neglect, accident or improper installation or maintenance, or products or goods which have been altered, modified or repaired by anyone other than seller or its authorized and approved representatives.

MODIFICATIONS:

WARNING! Do not modify this machine in any way. Modifications of any kind not only void any warranty, but it can cause serious injury or damage to the equipment and/or personnel.



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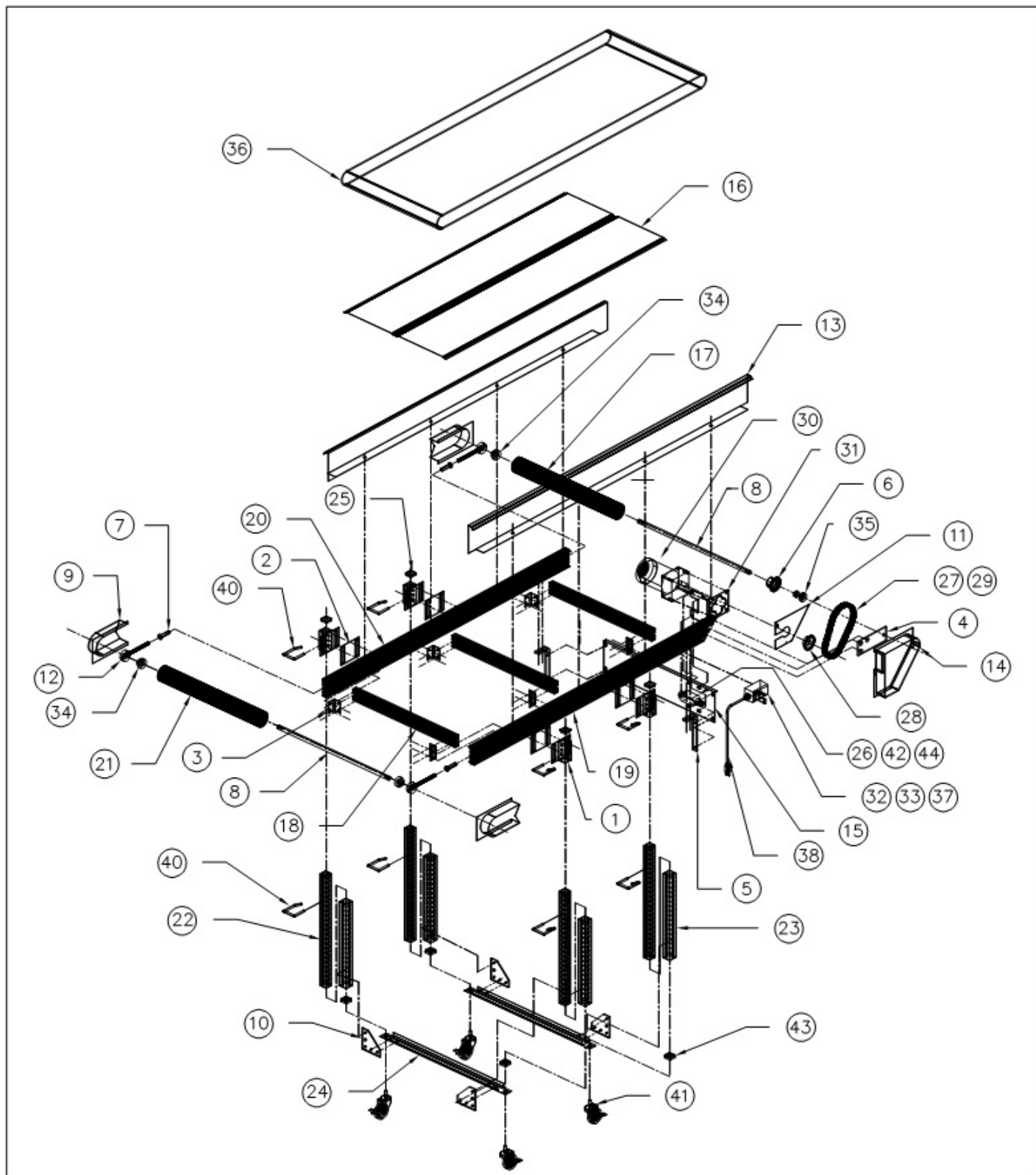
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**BCH CONVEYORS
PARTS LIST 12"**

01/12/22

VARIABLE SPEED OPTIONAL

1060	1/4 HP DC MOTOR		
0791B	0791B BODINE VARIABLE SPEED CONTROL W/12FT CORD		
0970	BRACKET FOR 1060 MOTOR		
35BS22HTX5/8	#35 HARDENED SPROCKET FOR BCH & SI CONVEYOR		

ID	QTY	P/N	DESCRIPTION	UCM	
1	4	A-5477	LEG MOUNTING BRACKET FOR SP, SI, SIV/VIB, BCH	EA	
2	4	A-5480	LEG MOUNTING BRACKET SPACER FOR SP, SI, SIV/VIB, BCH	EA	
3	6	A-5486	FRAME "L" BRACKET FOR SI, SP, SIV/VIB, BCH	EA	
4	1	A-5535	DRIVE ROLL PLATE FOR SP, SI, BCH	EA	
5	2	A-5545	MOTOR PLATE BRACKET FOR SP, SI, BCH	EA	
6	1	A-5959	MACHINED SPROCKET FOR CONVEYOR	EA	
7	3	A-5980	PLASTIC BUSHING	EA	
8	2	A-5982-12	SHAFTS FOR CONVEYORS 12"	EA	
9	3	A-6850	PLASTIC BEARING COVER	EA	
10	4	A-12789	90 DEG JOINING PLATE MODIFIED EX4351	EA	
11	1	A-5560	MOTOR DRIVE SHIELD FOR SP & SI CONVEYOR	EA	
12	3	B-5479	TENSION ADJUSTMENT ROD FOR SI SIV/VIB, SP, BCH	EA	
13	1	B-12909-6SS	18 GA. S.S. SIDE RAILS FOR BCH 6' LONG 5" HIGH (SET)	SET	
14	1	B-5583	MOTOR GUARD	EA	
15	1	B-5618-12	MOTOR MOUNTING PLATE 12" FOR SP, SI, BCH	EA	
16	1	B-5983-6-12	SS BEDDING FOR SI/SP/BCH CONVEYOR (SET) 6' X 12"	SET	
17	1	B-5984-12	DRIVE ROLLER (DOES NOT INCLUDE BEARINGS) 12"	EA	
18	3	B-5985-12	CROSS MEMBER 12"	EA	
19	1	B-5994-6	RIGHT SIDE FRAME 6' FOR SI/SP/BCH	EA	
20	1	B-5995-6	LEFT SIDE FRAME 6' FOR SI/SP/BCH	EA	
21	1	B-5998-12	IDLER ROLLER (DOES NOT INCLUDE BEARINGS) 12"	EA	
22	4	B-12553	24" X 1-1/2" X 1-1/2" UNISTRUT	EA	
23	4	B-12554	18" X 1-3/4" X 1-3/4" UNISTRUT	EA	
24	2	B-12555-12	STAND CROSSBRACE 12" FOR BCH CONVEYORS	EA	
25	4	VG-560-1.5-11	CAP FOR SP/SI/SIV/VIB/BCH LEGS	EA	
26	1	30432	JUNCTION BOX	EA	
27	23	35C	#35 CHAIN PER FOOT	EA	
28	1	35BS22HTX3/4	#35 HARDENED SPROCKET FOR 655/6183/5044 MOTOR	EA	
29	1	35ML	#35 MASTER LINK	EA	
30	1	655	655 1/6HP AC BODINE GEARMOTOR	EA	
31	1	655L	L BRACKET FOR 655/ 6183/ 5044 MOTOR	EA	
32	1	CR101Y11	SWITCH WITH PILOT LIGHT	EA	
33	1	QOA578	HEATER/FUSE FOR 655 MOTOR	EA	
34	3	YA012RR	BEARINGS FOR SP, SI, SIV/VIB, BCH CONVEYOR	EA	
35	1	RA1012NPP+COL	SPROCKET BEARING w/COLLAR FOR SP, SI, SIV/VIB, BCH	EA	
36	1	SPB-1206	Belt	EA	
37	3	S2112	STRAIN RELIEF FOR ELECTRIC CORD	EA	
38	1	K5152	K5152 12' POWER CORD	EA	
39	60	16/3	50 FT CORD BLACK (PER FOOT)	EA	
40	8	T092	LOCK PIN	EA	
41	4	CW4	CASTERS WITH LOCK	EA	
42	1	CN-50	CHASE NIPPLES (APPLETON)	EA	
43	4	VG5538B12	LEG THREADED INSERT FOR CONVEYOR LEGS	EA	
44	1	BX-MC	3/8" 1 HOLE FLEX STRAP	EA	

SEE BELT SHEET FOR BELTS

BCH CONVEYORS
PARTS LIST 18"

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