



# INSTRUCTIONS CONVEYORS & SEPARATORS



**Bottle & Parts**



**Conveyor/Separator  
Combination**



**Inclined & Infeed Combo**



**Vee-Guide  
Tracking**



**FIC Conveyor**



**Granulator Feed**



**Inclined**



**Parts Conveyor**

MODEL NO.

SERIAL NO.

PPE Conveyors are manufactured and sold direct by Plastic Process Equipment, Inc. We are not associated with any other manufacturer except Budget Molder's Supply, Inc. Always specify genuine PPE or Budget Hi-Line conveyors! Do not accept substitutes.

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**PLASTIC PROCESS EQUIPMENT, INC.**

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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 or separator from Plastic Process Equipment, Inc. These instructions are intended as a guide for your new product. If you have any additional questions, contact PPE at 800-321-0562.

## RECEIVING

Thoroughly inspect your new conveyor or separator before unpacking it for set up. 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!**

## ELECTRICAL

All conveyors and separators are equipped with a starter switch and an overload protection heater. A grounded 120 volt outlet and a three wire grounded extension cord must be used at all times.

The On/Off switches on some models are 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 CONVEYORS OR SEPARATORS

- 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!

## TYPES OF CONVEYORS

PPE carries both V-Belt and non V-Belt Conveyors. The easiest way to tell if your conveyor is a V-Belt is by the serial number. If there is a "V" in the serial number your conveyor is a V-Belt. **EXAMPLE:** the serial number PC1812V251439 is a conveyor with the V-Belt system (note the V in the serial number). If the serial number on your conveyor has an **R** or an **A** following the **V**, your conveyor has direct drive. **EXAMPLE:** PC 182VR251439 is a direct drive conveyor.

## 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 (**see Figure 1**) should be the same for both bolts.

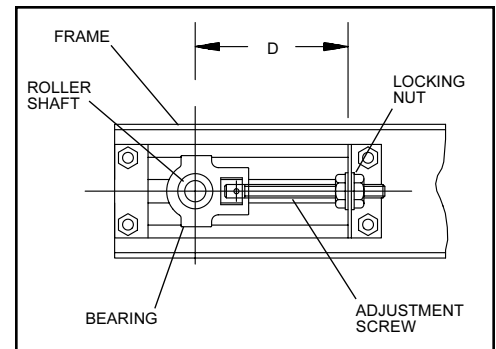


Figure 1

For another quick check, place a carpenter's square along the frame and belt of your conveyor. If it is tracking properly, the carpenter's square will fit snugly in the corner (see **Figure 2**). If your conveyor is not tracking properly, adjust

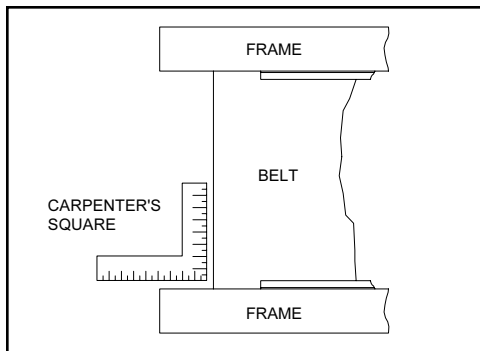


Figure 2

the locking nuts on both sides until they are equal. **BE CAREFUL NOT TO OVERTIGHTEN!**

### **BELT TRACKING: NON V-BELT CONVEYORS**

Check to ensure your conveyor is tracking properly. If your belt drifts to the left or right, it needs adjustment. To adjust your belt, loosen the locking nuts on each side of the conveyor (see **Figure 1**). With the conveyor operating, tighten the tension screw on the side of the drift 1/4 turn (**EXAMPLE:** if your belt drifts to the right, tighten the right take-up screw approximately 1/4 turn). Wait several minutes to allow the belt to drift and reposition on the rollers. Continue to adjust the appropriate take up bolt until the belt tracks evenly on both sides. **DO NOT OVERTIGHTEN THE CONVEYOR BELT!** If necessary, reset the belt tracking by loosening the opposite side. Once the belt tracking is complete, be sure to lock the take up adjustment screws with the locking nut.

### **LUBRICATION: DIRECT DRIVE UNITS**

PPE conveyors and separators (FIC, FT, ICB, PC-06, PC, PUC, SCI and FS Separator) have two lubrication areas, the drive bearings (the bearings at the motor end of the conveyor), and the take-up bearing (at the opposite end of the conveyor). All bearings are permanently lubricated, however under severe service conditions adding lubrication may extend the life of the bearing, therefore we provide a grease fitting. When lubricating bearings, add grease slowly while the shaft is rotating until the grease begins to come out of the seals. This indicates the bearings contain the proper amount of grease.

### **LUBRICATION: CHAIN DRIVE UNITS**

(BIC, FT, FS, VICB, PC 06, PC 12, PC 18, PC 24, PCS, PUC, VIB, ICG, PCS) PPE chain drive units use permanently lubricated drive chains that do not require lubrication. All

bearings are permanently lubricated, however under severe service conditions adding lubrication may extend the life of the bearing, therefore we provide a grease fitting. When lubricating bearings, add grease slowly while the shaft is rotating until the grease beginning to come out of the seals. This indicates the bearings contain the proper amount of grease.

**CAUTION:  
DO NOT ALLOW LUBRICATION TO GET  
ON THE UNDERSIDE OF THE BELT.**

For severe use service bearings should be lubricated every six months or sooner.

**CAUTION:  
BEARINGS SHOULD NOT RUN CONTINUOUS  
AT TEMPERATURES OVER 200°F  
AND SHOULD NEVER EXCEED 225°F  
FOR INTERMITTENT OPERATIONS.**

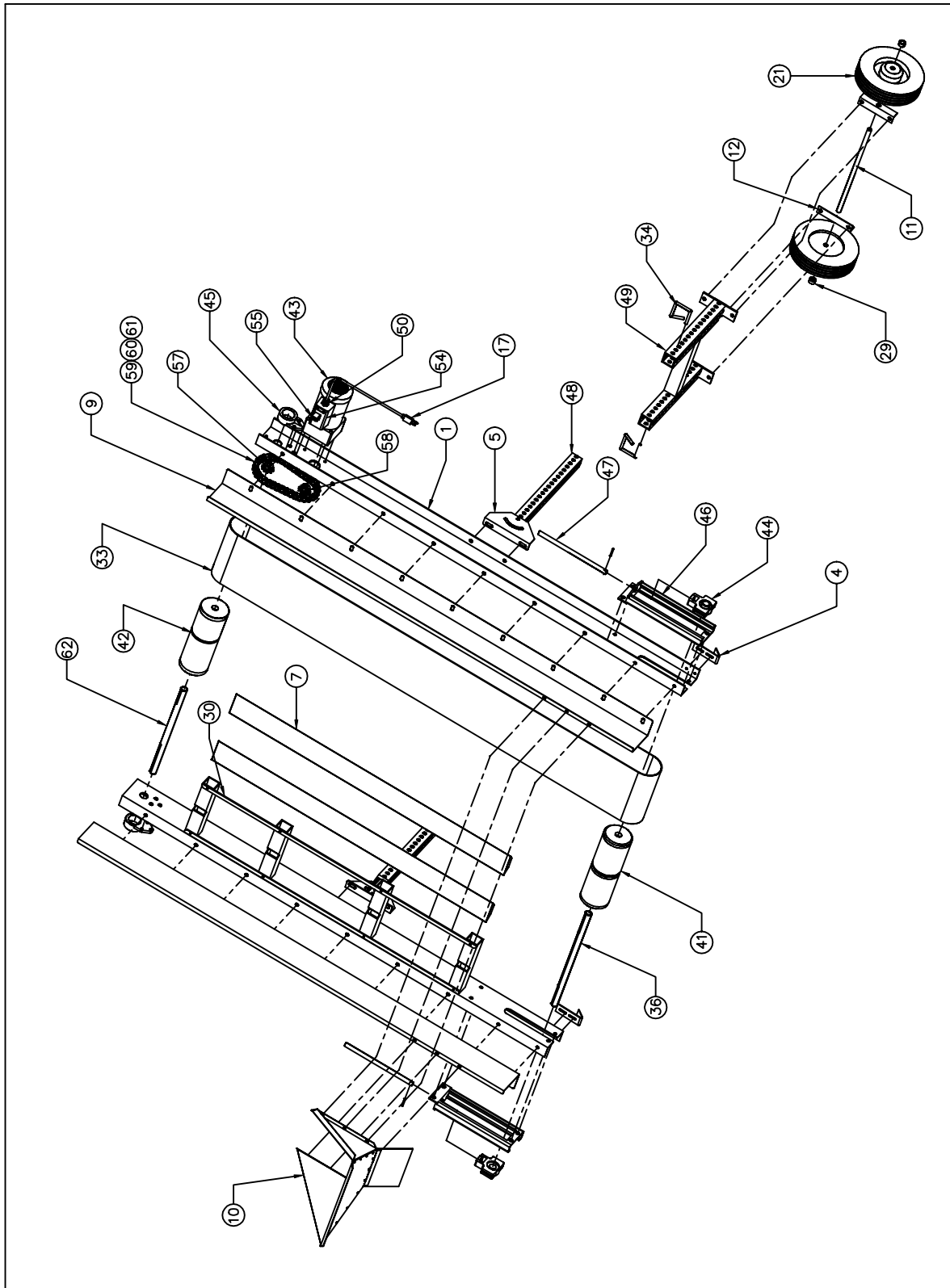
### **PCS SEPARATOR ATTACHMENTS**

The PCS separator is driven off of the main conveyor unit using a belt drive system. This allows slippage if the separator roller unit were to catch on something. **DO NOT OVERTIGHTEN** the drive belt, it should have just enough tension to drive the roller. This is a safety feature.

### **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.

# BIC CONVEYOR PARTS



## PLASTIC PROCESS EQUIPMENT, INC.

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 FAX: (727) 834-8873

**BIC CONVEYORS PARTS LIST BODINE DRIVE**

09/16/15

ID	PART		
NUMBER	NUMBER	DESCRIPTION	UOM
OPTIONAL	0791B	0791B BODINE VARIABLE SPEED CONTROL W/12FT CORD	EA
OPTIONAL	MM23201C	REVERSING VARI SPEED CONTROL MINARIK 1/2 - 1HP	EA
OPTIONAL	C-6909-3	VARIABLE SPEED MOUNTING BRACKET 45° FOR MM23101C	EA
OPTIONAL	1060	1/4 HP DC MOTOR	EA
1	D-1310	ALUMINUM CHANNEL FRAME	EA
4	A-1274	INCLINED FEET	EA
5	B-1654	LEG MOUNTING BRACKET POWERCOATED	EA
7	B-1285	BEDDING	EA
9	D-1311S	SIDERAILS (SET) FOR BIC MILD STEEL	SET
10	D-1311-3	HOPPER END PLATE	EA
10	D-1311-2	HOPPER SIDES (SET)	EA
10	D-1311-1	FLAPPER PLATE	EA
11	B-2663	WHEEL SHAFT	EA
12	A-1946	WHEEL SHAFT BRACKET	EA
17	K5152	K5152 12' POWER CORD	EA
21	95779362	10" DIA WHEELS	EA
29	2X569	5/8" COLLAR	EA
30	B-3720	PLASTIC STRIP BELT GUIDE	EA
33	BBIC0806V	BELT	
34	T092	LOCK PIN	EA
36	A-6867-8	1" TU SHAFT PUC, BIC, ICB BODINE	EA
41	C-5581-8	IDLER ROLLER 8"	EA
42	C-6836-8	V-GD DR ROLLER ICB/BIC/PUC BODINE KNURLED	EA
43	655	655 1/6HP BODINE GEARMOTOR	EA
44	TU250X1	TAKE-UP BEARING	EA
45	FB16X1	FIXED BEARING	EA
46	C-5582	1" TAKEUP BRACKET	EA
47	C-5582B	ADJ BOLT FOR TAKE UP BRACKET	EA
48	A-4705	UNISTRUT STAND EXTENSION GALVANIZED 22"	EA
49	A-7995-1608	UNISTRUT STAND BOTTOM 8" WIDE	EA
50	SEC50BA	STRAIN RELIEF FOR ELECTRIC CORD	EA
54	CR101Y11	SWITCH WITH PILOT LIGHT	EA
55	FUSE	FUSE	EA
57	H40B18X1	4018 X 1" HARDENED SPROCKET DRIVEN	EA
58	H40B10X3/4	4010 X 3/4" HARDENED SPROCKET DRIVE	EA
59	40C	#40 DRIVE CHAIN PER FT	EA
61	40MCL	40 MASTER CONNECTOR LINK	EA
62	B-6820-8	1" DR SHAFT PUC, BIC, ICB BODINE	EA