



# INSTRUCTIONS CONVEYORS & SEPARATORS



**Bottle & Parts**



**Conveyor/Separator  
Combination**



**Inclined & Infeed Combo**



**Vee-Guide  
Tracking**



**FIC Conveyor**



**Granulator Feed**



**Inclined**



**Parts Conveyor**

MODEL NO.
<input type="text"/>
SERIAL NO.
<input type="text"/>

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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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 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.

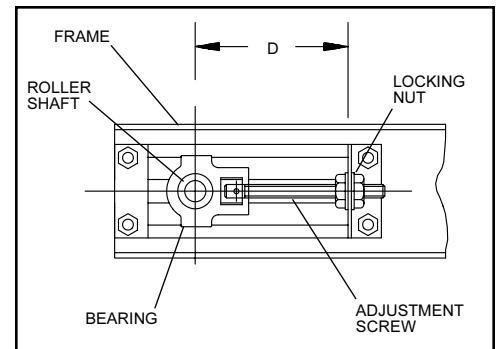


Figure 1

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

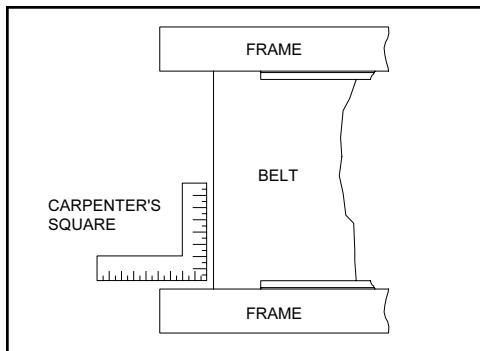


Figure 2

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 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, therefore we do not provide a grease fitting. Our experience has shown conveyor users tend to over grease bearings to the point where grease works it's way between the rollers and belts causing serious problems of contamination and belt slippage.

### **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, therefore we do not provide a grease fitting.

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

**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.



# FIC BELT REMOVAL AND INSTALLATION INSTRUCTIONS

Please read all instructions carefully before proceeding. The replacement of an endless belt requires disassembly of the conveyor. The following steps are outlined to be used as a guide.

- 1) Disconnect all power and tag out per OSHA requirements.
- 2) Remove flapper, side rails, and transition cover plate on the motor side of the conveyor.
- 3) Remove belly pan.
- 4) Remove lower side rail on drive side.
- 5) Loosen take up bearings fully.
- 6) Lay conveyor on side being sure it is properly stabilized.
- 7) Remove take up end leg.
- 8) Remove bolts on upper leg on the motor side leg. Remove leg pin and shorten to cause a gap between lower leg unit and angle tilt bracket.
- 9) Pull belt away from the transition rollers.
- 10) Remove belt from drive roller end first and pull between the frame and the legs, and lastly from the take up end.
- 11) Reinstall in opposite order.
- 12) Take up adjustment is accomplished by only applying equal pressure on take up bearings so that when you grab 2 cleats you can just stop the belt when in operation. You only need enough tension to drive the belt. Any excessive tension can cause premature wear to the drive components.
- 13) Make sure tension adjustment is equal and that cleats just clear belly pan so as not to drag.



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**PPE SOUTH**

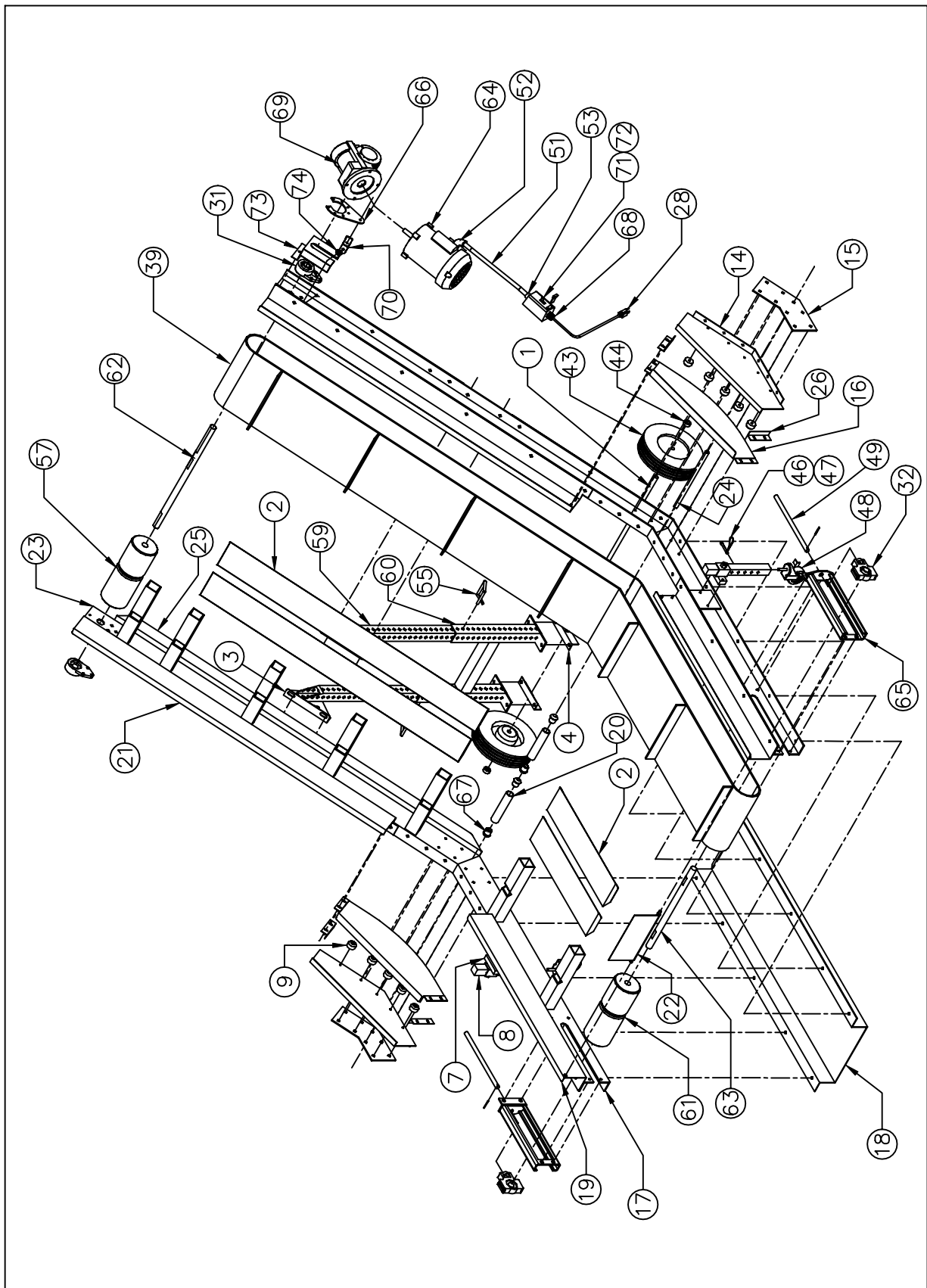
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# FIC CONVEYOR PARTS



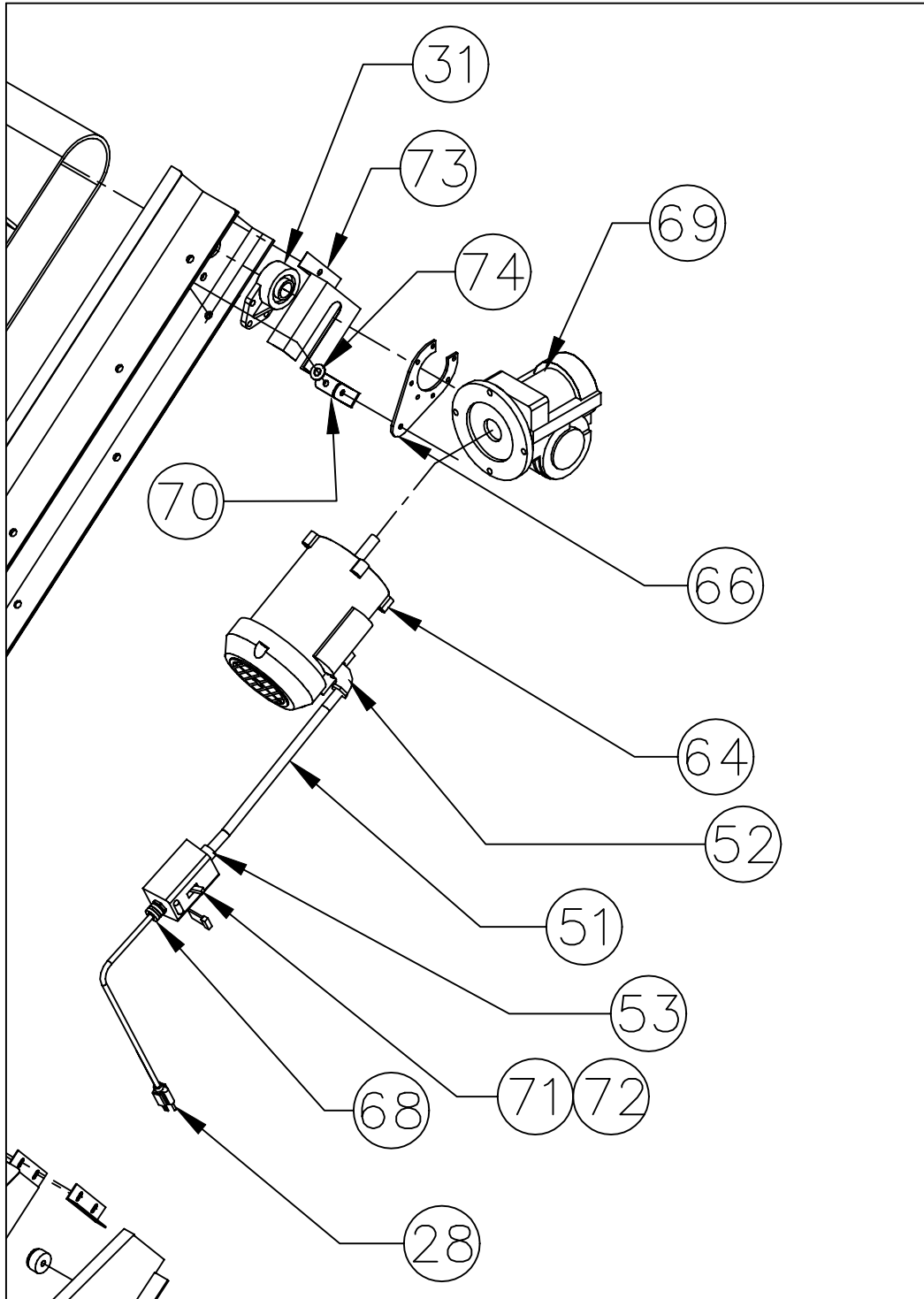
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# GEARBOX DETAIL



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**FIC CONVEYOR PARTS LIST**

09/16/15

ID	P/N	DESCRIPTION	UOM
OPTIONAL	MM23101C	VARI SPEED CONTROL MINARIK	EA
OPTIONAL	C-6909-3	VARIABLE SPEED MOUNTING BRACKET 45° FOR MM2	EA
OPTIONAL	098004	1/3 HP DC LEESON MOTOR	EA
OPTIONAL	098000	1/2 HP DC LEESON MOTOR	EA
OPTIONAL	GB20-1	RIGHT ANGLE GEAR BOX 20:1 RATIO w/REACTION	EA
1	B-7179-12	WHEEL SHAFT FOR FIC 12	EA
1	B-7179-18	WHEEL SHAFT FOR FIC 18	EA
1	B-7179-24	WHEEL SHAFT FOR FIC 24	EA
2	B-1285	BEDDING	EA
3	B-1654	LEG MOUNTING BRACKET POWERCOATED	EA
4	A-1946	WHEEL SHAFT BRACKET	EA
7	B-2353	LEG BRACKETS (NICKEL PLATED)	EA
8	B-2354	LEGS (LESS WHEELS)	EA
9	A-4529	HOLD DOWN ROLLER	EA
14	A-4631	TRANSITION ROLLER PLATE	EA
15	A-4632	SPLICE PLATE	EA
16	A-4633	TRANSITION RAIL FOR FIC (EA.)	EA
17	A-4634	LOWER FRAME	EA
18	A-4636-12	BELLY PAN 12"	EA
18	A-4636-18	BELLY PAN 18"	EA
18	A-4636-24	BELLY PAN 24"	EA
19	A-4709	LOWER SIDE RAIL (SET) M/S	SET
20	A-4711-12	TRANSITION ROLLER TUBE 12"	EA
20	A-4711-18	TRANSITION ROLLER TUBE 18"	EA
20	A-4711-24	TRANSITION ROLLER TUBE 24"	EA
21	A-4728	UPPER SIDE RAIL (SET)	SET
22	A-4768-12	STAINLESS STEEL FLAPPER 12"	EA
22	A-4768-18	STAINLESS STEEL FLAPPER 18"	EA
22	A-4768-24	STAINLESS STEEL FLAPPER 24"	EA
23	A-4772	UPPER FRAME	EA
24	A-4779-12	TRANSITION ROLLER SHAFT 12"	EA
24	A-4779-18	TRANSITION ROLLER SHAFT 18"	EA
24	A-4779-24	TRANSITION ROLLER SHAFT 24"	EA
25	A-4783	BELLY RAIL (SET)	SET
26	A-4785	TRANSITION COVER PLATE	EA
28	K5152	K5152 12' POWER CORD	EA
31	FB16X1	FIXED BEARING	EA
32	TU250X1	TAKE-UP BEARING	EA
39	BELT	BELT - SEE BELT SHEET	
43	95779362	10" DIA WHEELS	EA
44	2X569	5/8" COLLAR	EA
46	90149A032	HAIR PIN	EA
47	98306A278	LEG CLEVIS PIN 3/8 dia	EA
48	CW4	CASTERS WITH LOCK	EA
49	C-5582B	ADJ BOLT FOR TAKE UP BRACKET	EA
51	10101G	3/8" SEALTITE HOSE 14" LONG	EA
52	ST-9038	SEAL TITE FITTINGS 90 DEG	EA
53	ST-38	APPLETON CONNECTOR STRAIGHT	EA
55	T092	LOCK PIN	EA
57	A-4611N-12	V-GROOVE ROLLER 4-1/2 X KNURLED 12"	EA
57	A-4611N-18	V-GROOVE ROLLER 4-1/2 X KNURLED 18"	EA
57	A-4611N-24	V-GROOVE ROLLER 4-1/2 X KNURLED 24"	EA
59	A-4705	UNISTRUT STAND EXTENSION GALVANIZED 22"	EA
60	A-7995-1612	UNISTRUT STAND BOTTOM 12" WIDE	EA
60	A-7995-1618	UNISTRUT STAND BOTTOM 18" WIDE	EA
60	A-7995-1624	UNISTRUT STAND BOTTOM 24" WIDE	EA
61	A-4611-12	V-GROOVE ROLLER 4-1/2 X 12"	EA
61	A-4611-18	V-GROOVE ROLLER 4-1/2 X 18"	EA
61	A-4611-24	V-GROOVE ROLLER 4-1/2 X 24"	EA
62	B-5579-12	DRIVE SHAFT 12"	EA
62	B-5579-18	DRIVE SHAFT 18"	EA
62	B-5579-24	DRIVE SHAFT 24"	EA
63	B-5620-12	IDLER SHAFT 12"	EA
63	B-5620-18	IDLER SHAFT 18"	EA
63	B-5620-24	IDLER SHAFT 24"	EA
64	110056	1/2 HP AC LEESON MOTOR	EA
65	C-5582	1" TAKEUP BRACKET	EA
66	G175202.00	TORQUE REACTION ARM	EA
67	A-4711-B	TRANSITION ROLLER ENDS	EA
68	SEC50BA	STRAIN RELIEF FOR ELECTRIC CORD	EA
69	GB60-1	RIGHT ANGLE GEAR BOX 60:1 RATIO w/REACTION	EA
70	A-8788	GEAR BOX TORQUE ARM	EA
71	CR101Y11	SWITCH WITH PILOT LIGHT	EA
72		FUSE	EA
73	A-6042	GUARD FOR RIGHT ANGLE DRIVE	EA
74	9307K48	RUBBER GROMMET FOR GEARBOX MOUNT	EA