



INSTRUCTIONS CONVEYORS & SEPARATORS



Bottle & Parts



Separators



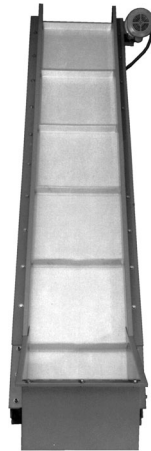
Inclined & Infeed Combo



**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. Always specify genuine PPE conveyors! Do not accept substitutes.

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PLASTIC PROCESS EQUIPMENT, INC.

www.ppe.com • e-mail: sales@ppe.com

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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 control device 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.

PROGRAMMABLE CONTROL

Fully programmable control system offers variable speed 0-30 feet per minute, indexing ability, photo-eye capable, reversible direction and can interface with an injection molding machine. Includes electronic motor overload protection, short, fault, plus over/under voltage protection. Requires 120/60/1 grounded power supply. Control converts power supply to 230/60/3 for the drive motor. Please refer to the control 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.

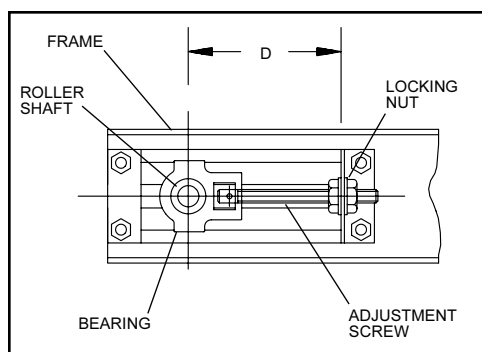
BELT TRACKING AND TENSION

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

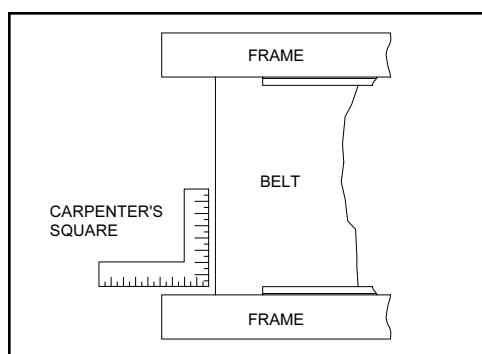
The V-Belt tracking system keeps your belt centered and tracking properly. No adjustment should be necessary if both take up bolts are adjusted the same amount during belt tension adjustment. To check the tracking of your belt, measure the take up bolts on both sides of the conveyor. The distance between 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 the locking nuts on both sides until they are equal. **BE CAREFUL NOT TO OVERTIGHTEN!**

Figure 2



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.

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.

PC CONVEYORS BODINE DRIVE PARTS

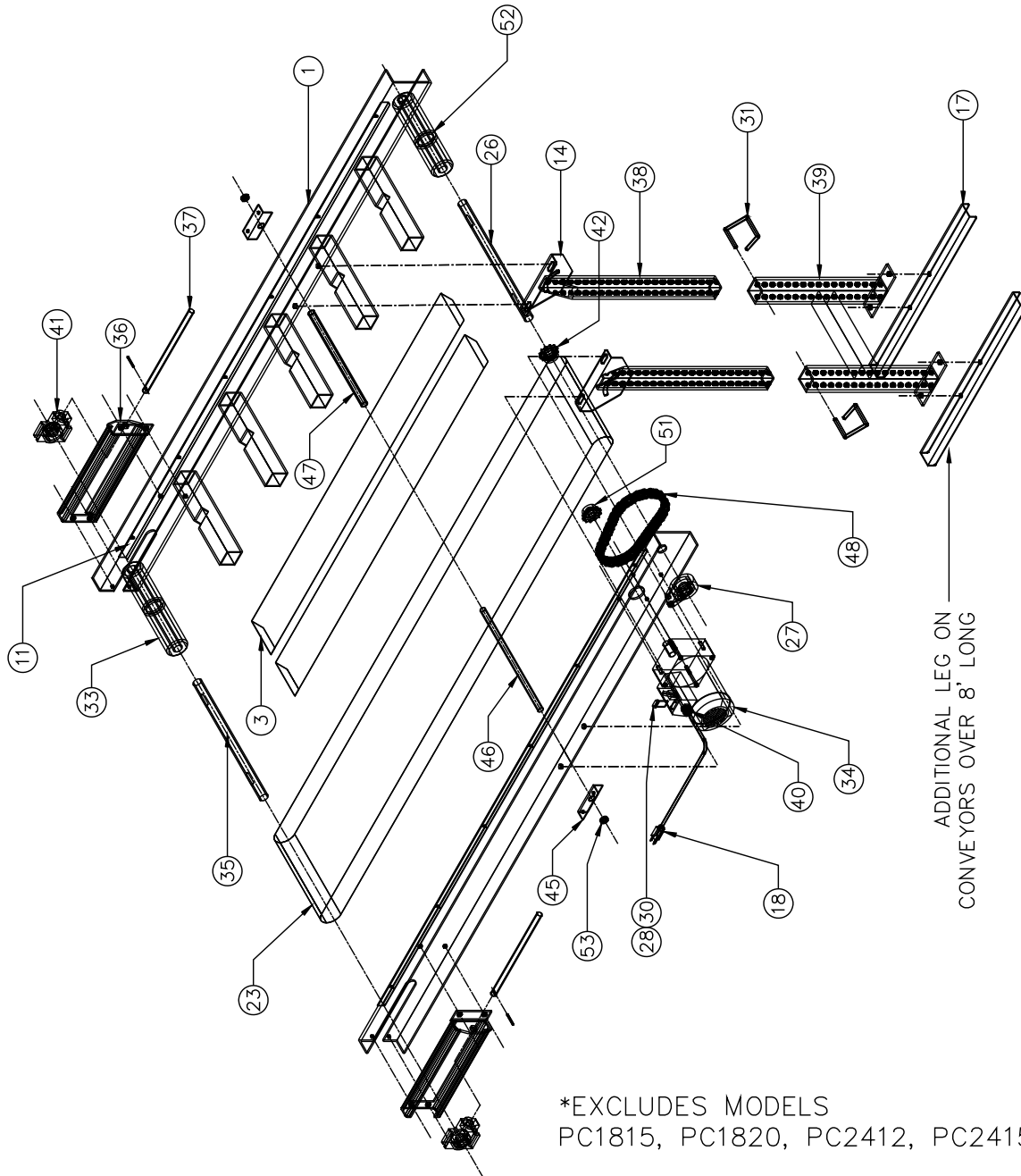
05/03/23

ID	QTY	P/N	DESCRIPTION	UOM	
OPTIONAL	1	0791B	0791B BODINE VARIABLE SPEED CONTROL W/12FT CORD	EA	
OPTIONAL	1	MM23201C	REVERSING VARI SPEED CONTROL MINARIK 1/2 - 1HP	EA	
OPTIONAL	1	C-6909-2	VARIABLE SPEED MOUNTING BRACKET 90° FOR MM23101C	EA	
OPTIONAL	1	1060	1/4 HP DC MOTOR BUILT AFTER 7/1/2010	EA	
OPTIONAL		H40B12X5/8	4012 X 5/8 HARDENED SPROCKET	EA	
OPTIONAL	1	A-5888	NEW STYLE "F" BRACKET (SET)	SET	
OPTIONAL	1	TAD-12	DISCHARGE TRAY B-1678-12	EA	
OPTIONAL	1	TAD-18	DISCHARGE TRAY B-1678-18	EA	
OPTIONAL	1	TAD-24	DISCHARGE TRAY B-1678-24	EA	
OPTIONAL	1	A-8186	MOTOR BRACKET FOR MU MOD	EA	
OPTIONAL	1	B-8181	MOTOR GUARD FOR MU MOD	EA	
OPTIONAL	1	A-7013-12	DRIVE SHAFT PCS	EA	
OPTIONAL	1	A-7013-18	DRIVE SHAFT PCS	EA	
OPTIONAL	1	A-7013-24	DRIVE SHAFT PCS	EA	
OPTIONAL	1	B-1602	SIDERAILS	EA	
OPTIONAL	1	2263	3/8 HP AC BODINE MOTOR 230V 3 PHASE	EA	
OPTIONAL	1	ESV371NO1SXB	LENZE MULTI-FUNCTION CONTROLLER	EA	
OPTIONAL	1	A-12952	LENZE CONTROLLER BRACKET FOR SOME FTP/PC CONVEYORS	EA	
OPTIONAL	1	5044	1/4 HP DC BODINE MOTOR BUILT BEFORE 7/1/2010	EA	
OPTIONAL	1	7696K31	IN-LINE FUSE HOLDER (OLD# 7696K41)	EA	
1	1	D-1096-(W)-(L)	FRAME	EA	
3	1	B-1285	BEDDING	EA	
11	1	B-1954-92	ANGLE BELT STRIPS S/S (SET) 92"	SET	
14		B-1654	LEG MOUNTING BRACKET POWERCOATED	EA	
17		B-1687	PC LEG FEET LONG CHANNEL	EA	
18	1	K5152	K5152 12' POWER CORD	EA	
23	1	BELT	SEE COST SHEET	EA	
26	1	B-6819-12	1" DRIVE SHAFT PC BCP FT 12"	EA	
26	1	B-6819-18	1" DRIVE SHAFT PC BCP FT 18"	EA	
26	1	B-6819-24	1" DRIVE SHAFT PC BCP FT 24"	EA	
27	2	FB16X1	FIXED BEARING	EA	
28	1	CR101Y11	SWITCH WITH PILOT LIGHT	EA	
30	1	FUSE	FUSE	EA	
31		T092	LOCK PIN	EA	
33	1	B-5578-12	VEE GROOVE ROLLER 12"	EA	
33	1	B-5578-18	VEE GROOVE ROLLER 18"	EA	
33	1	B-5578-24	VEE GROOVE ROLLER 24"	EA	
34	1	655	655 1/6HP AC BODINE GEARMOTOR	EA	
35	1	B-5620-12	IDLER SHAFT 12"	EA	
35	1	B-5620-18	IDLER SHAFT 18"	EA	
35	1	B-5620-24	IDLER SHAFT 24"	EA	
36	2	C-5582	1" TAKEUP BRACKET W/PAINT	EA	
37	2	C-5582B	ADJ BOLT FOR TAKE UP BRACKET 12"	EA	
38		A-4705	UNISTRUT STAND EXTENSION GALVANIZED 22"	EA	
39		A-7995-1612	UNISTRUT STAND BOTTOM 12" WIDE	EA	
39		A-7995-1618	UNISTRUT STAND BOTTOM 18" WIDE	EA	
39		A-7995-1624	UNISTRUT STAND BOTTOM 24" WIDE	EA	
40	1	S2112	STRAIN RELIEF FOR ELECTRIC CORD	EA	
41	2	TU250X1	TAKE-UP BEARING	EA	
42	1	H40B12X1	4012 X 1" HARDENED SPROCKET DRIVEN	EA	
45	2	A-2454	BELT SAG BRACKET (EA)	EA	
46	1	B-5891-R12	SAG ROLLER FOR 12"	EA	
46	1	B-5891-R18	SAG ROLLER FOR 18"	EA	
46	1	B-5891-R24	SAG ROLLER FOR 24"	EA	
47	1	B-5891-S12	SAG SHAFT FOR 12"	EA	
47	1	B-5891-S18	SAG SHAFT FOR 18"	EA	
47	1	B-5891-S24	SAG SHAFT FOR 24"	EA	
48	1	40CK	40 CHAIN, HALF LINK, MASTER LINK KIT	EA	
51	1	H40B12X3/4	4012 X 3/4 HARDENED SPROCKET DRIVE	EA	
52	1	A-6821-12N	V-GR DR ROLLER 1" SHAFT PC/PCS BODINE KNURLED	EA	
52	1	A-6821-18N	V-GR DR ROLLER 1" SHAFT PC/PCS BODINE KNURLED	EA	
52	1	A-6821-24N	V-GR DR ROLLER 1" SHAFT PC/PCS BODINE KNURLED	EA	
53	2	2X569	5/8" COLLAR	EA	

SEE BELT SHEET FOR BELTS

PC CONVEYOR PARTS

12" 18" & 24" MOTOR SIDE MOUNT *



PLASTIC PROCESS EQUIPMENT, INC.

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PC CONVEYORS MOTOR UNDER DRIVE PARTS

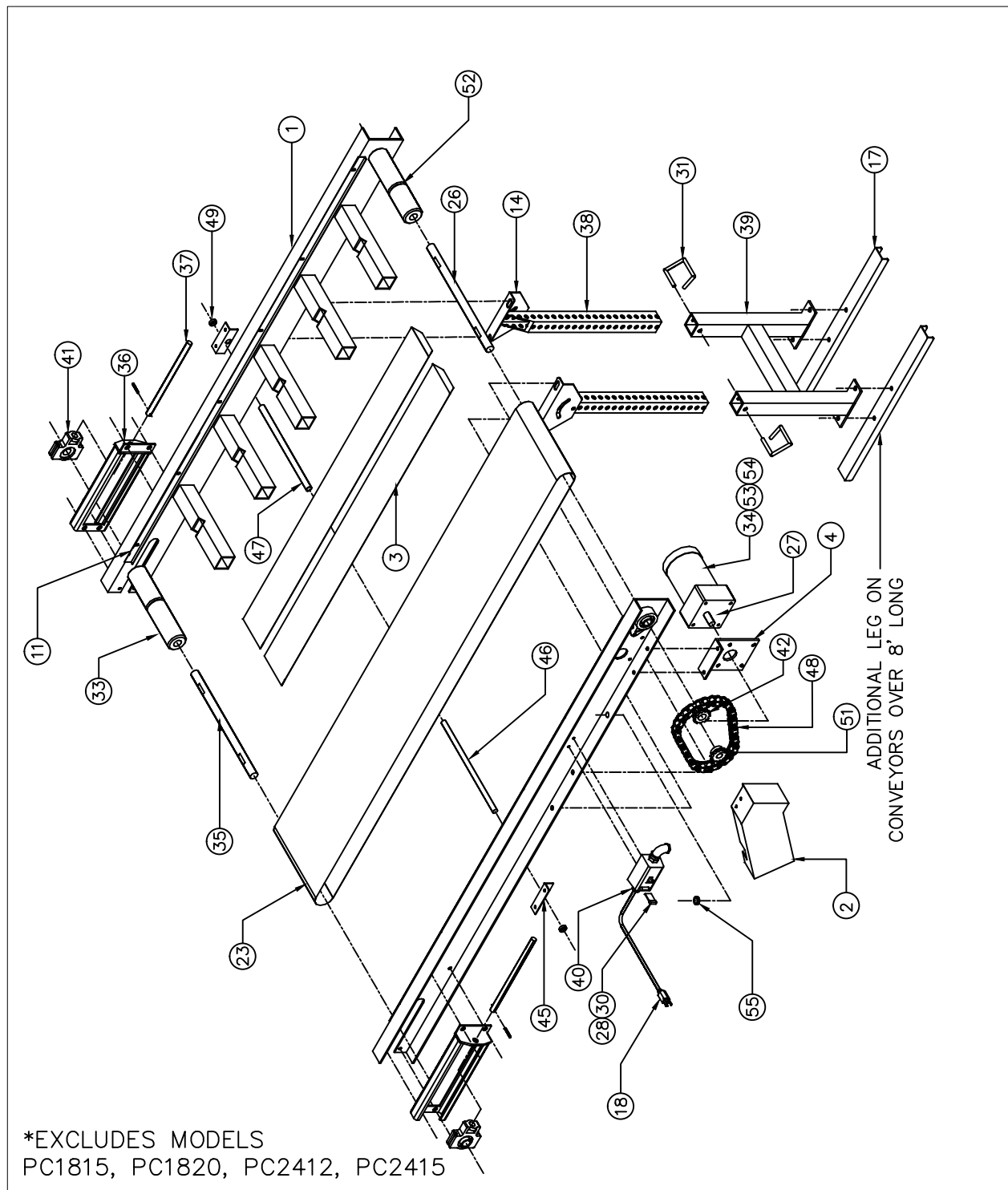
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ID	QTY	P/N	DESCRIPTION	UOM	
OPTIONAL	1	0791B	0791B BODINE VARIABLE SPEED CONTROL W/12FT CORD	EA	
OPTIONAL	1	MM23201C	REVERSING VARI SPEED CONTROL MINARIK 1/2 - 1HP	EA	
OPTIONAL	1	C-6909-2	VARIABLE SPEED MOUNTING BRACKET 90° FOR MM23101C	EA	
OPTIONAL	1	1060	1/4 HP DC MOTOR BUILT AFTER 7/1/2010	EA	
OPTIONAL	1	MDL-2	FUSE 2A/250V FOR 6183 & 1060 MOTOR	EA	
OPTIONAL	1	H40B12X5/8	4012 X 5/8 HARDENED SPROCKET	EA	
OPTIONAL	1	A-5888	NEW STYLE "F" BRACKET (SET)	SET	
OPTIONAL	1	TAD-12	DISCHARGE TRAY B-1678-12	EA	
OPTIONAL	1	TAD-18	DISCHARGE TRAY B-1678-18	EA	
OPTIONAL	1	TAD-24	DISCHARGE TRAY B-1678-24	EA	
OPTIONAL	1	B-1602	SIDERAILS	EA	
OPTIONAL	1	2263	3/8 HP AC BODINE MOTOR 230V 3 PHASE	EA	
OPTIONAL	1	ESV371NO1SXB	LENZE MULTI-FUNCTION CONTROLLER	EA	
OPTIONAL	1	A-12952	LENZE CONTROLLER BRACKET FOR SOME FTP/PC CONVEYORS	EA	
OPTIONAL	1	5044	1/4 HP DC BODINE MOTOR BUILT BEFORE 7/1/2010	EA	
OPTIONAL	1	7696K31	IN-LINE FUSE HOLDER (OLD# 7696K41)	EA	
1	1	D-1096- (W) - (L)	FRAME	EA	
2	1	B-8181	MOTOR GUARD FOR MU MOD	EA	
3	1	B-1285	BEDDING	EA	
4	1	A-8186	MOTOR BRACKET FOR MU MOD	EA	
11	1	B-1954-92	ANGLE BELT STRIPS S/S (SET) 92"	SET	
14		B-1654	LEG MOUNTING BRACKET POWERCOATED	EA	
17		B-1687	PC LEG FEET LONG CHANNEL	EA	
18	1	K5152	K5152 12' POWER CORD	EA	
23	1	BELT	SEE COST SHEET	EA	
26	1	A-7013-12	DRIVE SHAFT PCS	EA	
26	1	A-7013-18	DRIVE SHAFT PCS	EA	
26	1	A-7013-24	DRIVE SHAFT PCS	EA	
27	1	FB16X1	FIXED BEARING	EA	
28	1	CR101Y11	SWITCH WITH PILOT LIGHT	EA	
30	1	QOA578	HEATER/FUSE FOR 655 MOTOR	EA	
31		T092	LOCK PIN	EA	
33	1	B-5578-12	VEE GROOVE ROLLER 12"	EA	
33	1	B-5578-18	VEE GROOVE ROLLER 18"	EA	
33	1	B-5578-24	VEE GROOVE ROLLER 24"	EA	
34	1	655	655 1/6HP AC BODINE GEARMOTOR	EA	
35	1	B-5620-12	IDLER SHAFT 12"	EA	
35	1	B-5620-18	IDLER SHAFT 18"	EA	
35	1	B-5620-24	IDLER SHAFT 24"	EA	
36	2	C-5582	1" TAKEUP BRACKET W/PAINT	EA	
37	2	C-5582B	ADJ BOLT FOR TAKE UP BRACKET 12"	EA	
38		A-4705	UNISTRUT STAND EXTENSION GALVANIZED 22"	EA	
39		A-7995-1612	UNISTRUT STAND BOTTOM 12" WIDE	EA	
39		A-7995-1618	UNISTRUT STAND BOTTOM 18" WIDE	EA	
39		A-7995-1624	UNISTRUT STAND BOTTOM 24" WIDE	EA	
40	1	S2112	STRAIN RELIEF FOR ELECTRIC CORD	EA	
41	2	TU250X1	TAKE-UP BEARING	EA	
42	1	H40B12X1	4012 X 1" HARDENED SPROCKET DRIVEN	EA	
45	2	A-2454	BELT SAG BRACKET (EA)	EA	
46		B-5891-R12	SAG ROLLER FOR 12"	EA	
46		B-5891-R18	SAG ROLLER FOR 18"	EA	
46		B-5891-R24	SAG ROLLER FOR 24"	EA	
47		B-5891-S12	SAG SHAFT FOR 12"	EA	
47		B-5891-S18	SAG SHAFT FOR 18"	EA	
47		B-5891-S24	SAG SHAFT FOR 24"	EA	
48	1	40CK	40 CHAIN, HALF LINK, MASTER LINK KIT	EA	
49	2	2X569	5/8" COLLAR	EA	
51	1	H40B12X3/4	4012 X 3/4 HARDENED SPROCKET DRIVE	EA	
52	1	B-5578-12N	VEE GROOVE ROLLER 12" KNURLED	EA	
52	1	B-5578-18N	VEE GROOVE ROLLER 18" KNURLED	EA	
52	1	B-5578-24N	VEE GROOVE ROLLER 24" KNURLED	EA	
53	1	XC290	3/8 CONNECTOR	EA	
54	1	0984	JUNCTION BOX FOR BODINE MOTOR	EA	
55	1	Z2168	RUBBER GROMMET	EA	

SEE BELT SHEET FOR BELTS

PC CONVEYOR PARTS

12" 18" & 24" MOTOR MOUNTED UNDER *



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PC CONVEYORS

05/03/23

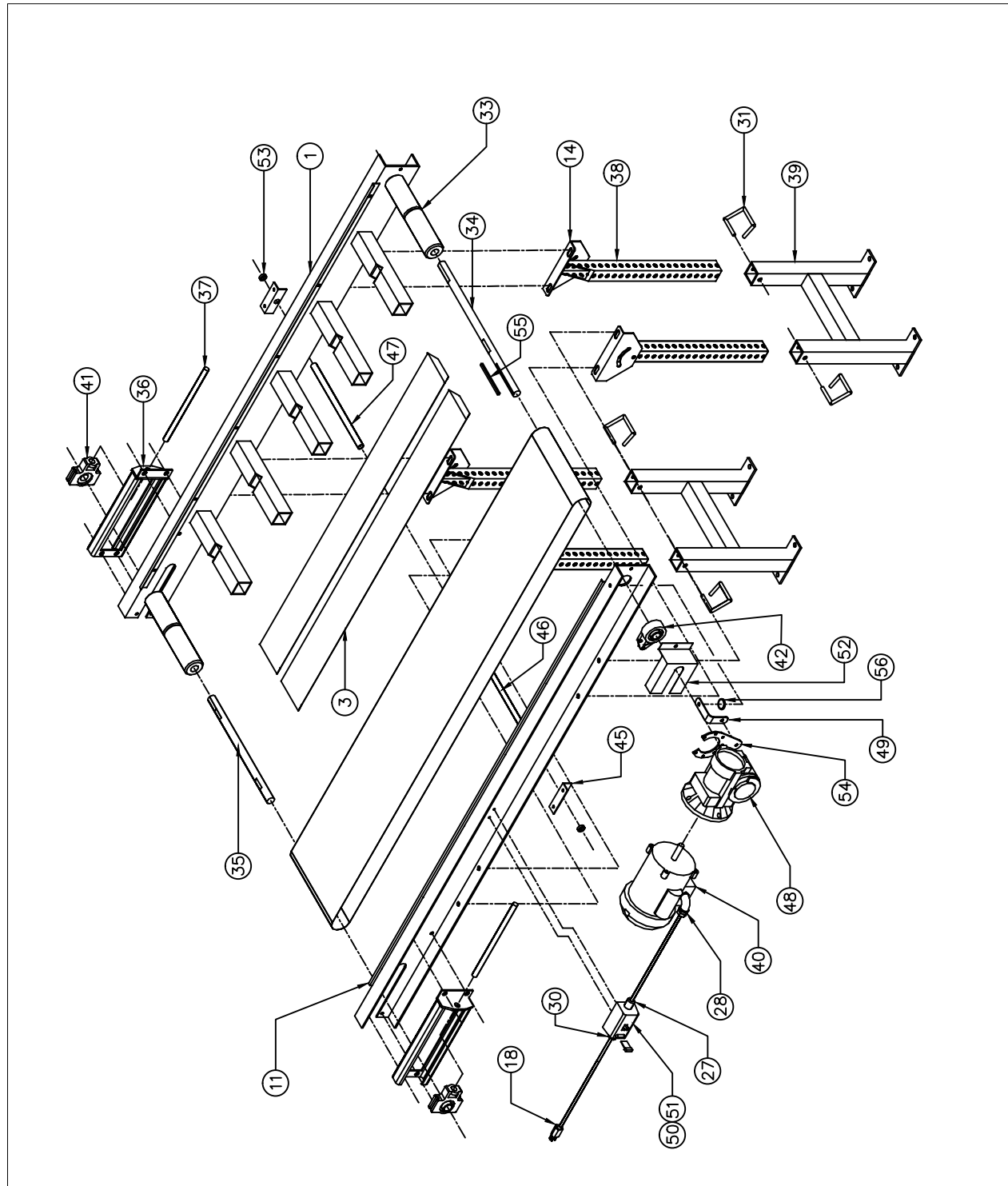
PARTS LIST 1815, 1820, 2412, 2415

ID	QTY	P/N	DESCRIPTION	UOM	
OPTIONAL	1	0791B	0791B BODINE VARIABLE SPEED CONTROL W/12FT CORD	EA	
OPTIONAL	1	MM23201C	REVERSING VARI SPEED CONTROL MINARIK 1/2 - 1HP	EA	
OPTIONAL	1	C-6909-2	VARIABLE SPEED MOUNTING BRACKET 90° FOR MM23101C	EA	
OPTIONAL	1	098004	1/3 HP DC LEESON MOTOR	EA	
OPTIONAL	1	MDL-4	FUSE 4A/250V FOR 098004 MOTOR	EA	
OPTIONAL	1	GB20-1	RIGHT ANGLE GEAR BOX 20:1 RATIO w/REACTION ARM	EA	
OPTIONAL	1	A-5888	NEW STYLE "F" BRACKET (SET)	SET	
OPTIONAL	1	2263	3/8 HP AC BODINE MOTOR 230V 3 PHASE	EA	
OPTIONAL	1	ESV371NO1SXB	LENZE MULTI-FUNCTION CONTROLLER	EA	
OPTIONAL	1	A-12952	LENZE CONTROLLER BRACKET FOR SOME FTP/PC CONVEY	EA	
OPTIONAL	1	7696K31	IN-LINE FUSE HOLDER (OLD# 7696K41)	EA	
OPTIONAL	1	102860.00	1/2 HP 230V 3PH MOTOR	EA	
OPTIONAL	1	MM23101C	VARI SPEED CONTROL MINARIK	EA	
OPTIONAL	1	9307K48	RUBBER GROMMET FOR GEARBOX MOUNT	EA	
OPTIONAL	1	098000	1/2 HP DC LEESON MOTOR	EA	
1	1	D-1096- (W) - (L)	FRAME	EA	
3	1	B-1285	BEDDING	EA	
11	1	B-1954-92	ANGLE BELT STRIPS S/S (SET) 92"	SET	
14	1	B-1654	LEG MOUNTING BRACKET POWERCOATED	EA	
18	1	K5152	K5152 12' POWER CORD	EA	
23	1	BELT	SEE COST SHEET	EA	
26	1	10101G	3/8" SEALTITE HOSE 14" LONG	EA	
27		ST-38	APPLETON CONNECTOR STRAIGHT	EA	
28		ST-9038	SEAL TITE FITTINGS 90 DEG	EA	
30	1	S2112	STRAIN RELIEF FOR ELECTRIC CORD	EA	
31	2	T092	LOCK PIN	EA	
33	1	B-5578-18	VEE GROOVE ROLLER 18"	EA	
33	1	B-5578-18N	VEE GROOVE ROLLER 18" KNURLED	EA	
33	1	B-5578-24	VEE GROOVE ROLLER 24"	EA	
33	1	B-5578-24N	VEE GROOVE ROLLER 24" KNURLED	EA	
34	1	B-5579-18	DRIVE SHAFT 18"	EA	
34	1	B-5579-24	DRIVE SHAFT 24"	EA	
35	1	B-5620-18	IDLER SHAFT 18"	EA	
35	1	B-5620-24	IDLER SHAFT 24"	EA	
36	2	C-5582	1" TAKEUP BRACKET W/PAINT	EA	
37	2	C-5582B	ADJ BOLT FOR TAKE UP BRACKET 12"	EA	
38	2	A-4705	UNISTRUT STAND EXTENSION GALVANIZED 22"	EA	
39	1	A-7995-1618	UNISTRUT STAND BOTTOM 18" WIDE	EA	
39	1	A-7995-1624	UNISTRUT STAND BOTTOM 24" WIDE	EA	
40	2	G1515	1/2 HP AC MARATHON MOTOR (FORMERLY 110056)	EA	
41	1	TU250X1	TAKE-UP BEARING	EA	
42	2	FB16X1	FIXED BEARING	EA	
45	2	A-2454	BELT SAG BRACKET (EA)	EA	
46	2	B-5891-R18	SAG ROLLER FOR 18"	EA	
46	1	B-5891-R24	SAG ROLLER FOR 24"	EA	
47	1	B-5891-S18	SAG SHAFT FOR 18"	EA	
47	1	B-5891-S24	SAG SHAFT FOR 24"	EA	
48	1	GB60-1	RIGHT ANGLE GEAR BOX 60:1 RATIO w/REACTION ARM	EA	
49		A-8788	GEAR BOX TORQUE ARM	EA	
50	1	CR101Y11	SWITCH WITH PILOT LIGHT	EA	
51	1	QOA162	HEATER/FUSE FOR 110056 MOTOR	EA	
52	1	A-6042	GUARD FOR RIGHT ANGLE DRIVE	EA	
53	2	2X569	5/8" COLLAR	EA	
54		G175202.00	TORQUE REACTION ARM	EA	
55	1	2481250	1/4 X 1/4 X 3-1/4 SQ KEY FOR R/A DRIVE SHAFT	EA	
56	1	9307K48	RUBBER GROMMET FOR GEARBOX MOUNT	EA	

SEE BELT SHEET FOR BELTS

PC CONVEYOR PARTS

1815,1820,2412,2415 RIGHT ANGLE MOTOR



PLASTIC PROCESS EQUIPMENT, INC.

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