INSTRUCTIONS
HEAVY DUTY INCLINE CONVEYORS



PCI Model Conveyors

MODEL NO.

PCI

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.

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WEST
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e-mail: sales@ppe.com
Toll Free: USA, Canada & Mexico
800-362-0706
Order Fax: 800-223-8305

Thank you for purchasing a conveyor 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 OPTION

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 START/STOP

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!

BELT REPLACEMENT

1) **CAUTION:** Disconnect power from unit.
2) Remove the hopper from the side rails.
3) Remove the side rails.
4) Remove the belt edge angle strips.
5) Loosen the jam nuts on the take up adjustment rods to slacken the belt for removal.
6) Remove the lacing pin from belt lacing.
7) Remove belt.
8) Repeat steps in reverse order to install belt.
9) Now refer to Belt Tracking and Tension instructions.

BELT TRACKING AND TENSION

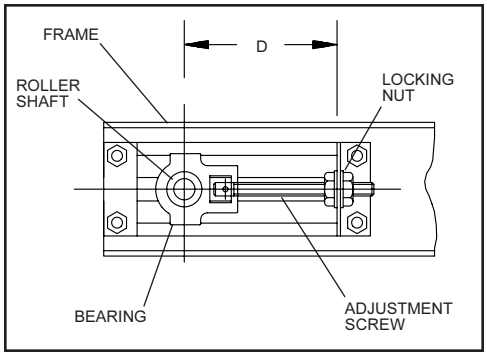
All conveyors and separators are thoroughly tested in our factory after final assembly. Although the belts are adjusted to track properly with the right amount of tension, some adjustments may be necessary during use. For best results and longevity of the drive components, the belt should be run with 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.

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BELT TRACKING: THE V-BELT STYLE

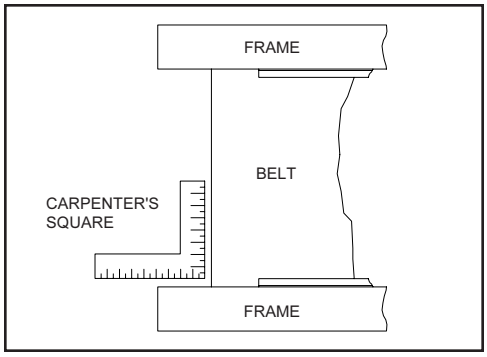
The V-Belt tracking system keeps your belt centered and tracking properly. No adjustment should be necessary if both take up bolts are adjusted the same amount during belt tension adjustment. To check the tracking of your belt, measure the take up bolts on both sides of the conveyor. The distance between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



PERMANENT LUBRICATION: DIRECT DRIVE UNITS

PPE conveyors 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.

PERMANENT LUBRICATION: CHAIN DRIVE UNITS

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:
NEVER 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.

WARRANTY

All PPE Conveyors have a full **one 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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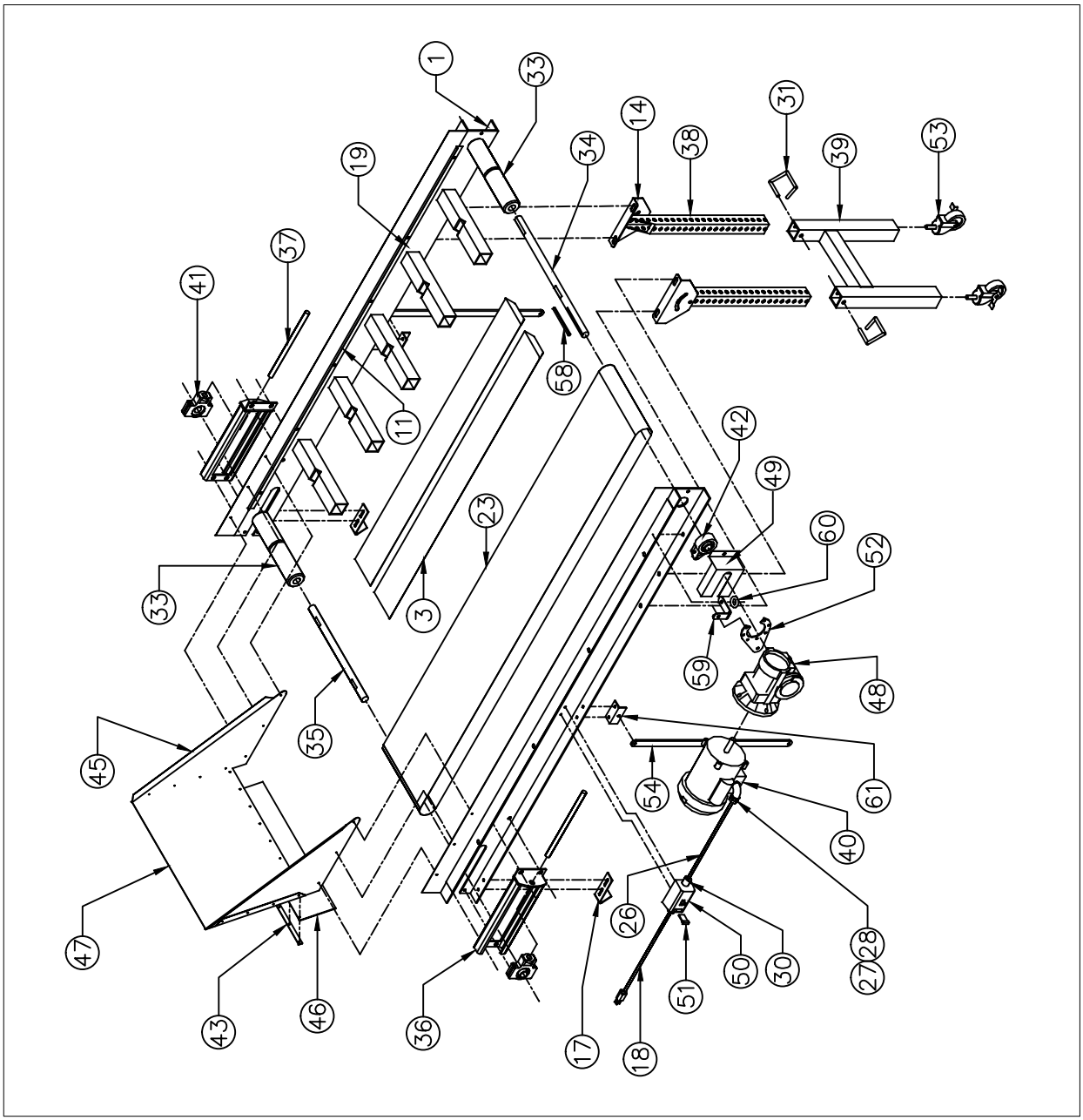
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PARTS LIST RIGHT ANGLE DRIVE

ID	QTY	P/N	DESCRIPTION	UOM	
OPTIONAL	1	0791B	0791B BODINE VARIABLE SPEED CONTROL W/12FT CORD	EA	
OPTIONAL	1	MM23101C	VARI SPEED CONTROL MINARIK	EA	
OPTIONAL	1	C-6909-3	VARIABLE SPEED MOUNTING BRACKET 45° 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	098000	1/2 HP DC LEESON MOTOR	EA	
OPTIONAL	1	MDL-6	FUSE 6A/250V FOR 098000 MOTOR	EA	
OPTIONAL	1	GB20-1	RIGHT ANGLE GEAR BOX 20:1 RATIO w/REACTION ARM	EA	
1	1	D-7997-RA	FRAME	EA	
3		B-1285	BEDDING	EA	
11	1	B-1954-92	ANGLE BELT STRIPS S/S (SET) 92"	SET	
14	2	B-1654	LEG MOUNTING BRACKET POWERCOATED	EA	
17	2	A-1274	INCLINED FEET	EA	
18	1	K5152	K5152 12' POWER CORD	EA	
19	1	B-8112-5	SIDE RAIL FOR PCI/PCIS 5'(SET) INCLUDING ANODIZE	EA	
19	1	B-8112-6	SIDE RAIL FOR PCI/PCIS 6' (SET)	EA	
19	1	B-8112-7	SIDE RAIL FOR PCI/PCIS 7'(SET)	EA	
19	1	B-8112-8	SIDE RAIL FOR PCI/PCIS 8'(SET)	EA	
19	1	B-8112-A-10	SIDE RAIL FOR PCI/PCIS 10'(SET) INCLUDES EXTENSIONS	EA	
19	1	B-8112-A-12	SIDE RAIL FOR PCI/PCIS 12'(SET) INCLUDES EXTENSIONS	EA	
19	1	B-8112-A-15	SIDE RAIL FOR PCI/PCIS 15'(SET) INCLUDES EXTENSIONS	EA	
23	1	BELT	BELT	EA	
26	1	10101G	3/8" SEALTITE HOSE 14" LONG	EA	
27	1	ST-38	APPLETON CONNECTOR STRAIGHT	EA	
28	1	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-7994	UNISTRUT STAND EXTENSION (GALV) 34"	EA	
38	2	A-4705	UNISTRUT STAND EXTENSION GALVANIZED 22"	EA	
38	2	A-4703	UNISTRUT STAND EXTENSION (GALV) 36"	EA	
39	1	A-7995-1612	UNISTRUT STAND BOTTOM 12" WIDE	EA	
39	1	A-7995-2612	UNISTRUT STAND BOTTOM 12" WIDE	EA	
39	1	A-7995-3212	UNISTRUT STAND BOTTOM 12" WIDE	EA	
39	1	A-7995-1618	UNISTRUT STAND BOTTOM 18" WIDE	EA	
39	1	A-7995-2618	UNISTRUT STAND BOTTOM 18" WIDE	EA	
39	1	A-7995-3218	UNISTRUT STAND BOTTOM 18" WIDE	EA	
39	1	A-7995-1624	UNISTRUT STAND BOTTOM 24" WIDE	EA	
39	1	A-7995-2624	UNISTRUT STAND BOTTOM 24" WIDE	EA	
39	1	A-7995-3224	UNISTRUT STAND BOTTOM 24" WIDE	EA	
40	1	G1515	1/2 HP AC MARATHON MOTOR (FORMERLY 110056)	EA	
41	2	TU250X1	TAKE-UP BEARING	EA	
42	2	FB16X1	FIXED BEARING	EA	
43	1	A-6434-18	FLAPPER STRIP 18"	EA	
43	1	A-6434-24	FLAPPER STRIP 24"	EA	
45	1	A-6432	ALUMINUM HOPPER SIDES (SET)	EA	
46	1	A-6435-18	FLAPPER BELT 18" FOR SI	EA	
46	1	A-6435-24	FLAPPER BELT 24" FOR SI	EA	
47	1	A-6433-18	ALUMINUM HOPPER FRONT 18" (INCLUDING ANODIZE)	EA	
47	1	A-6433-24	ALUMINUM HOPPER FRONT 24"	EA	
48	1	GB60-1	RIGHT ANGLE GEAR BOX 60:1 RATIO w/REACTION ARM	EA	
49	1	A-6042	GUARD FOR RIGHT ANGLE DRIVE	EA	
50	1	CR101Y11	SWITCH WITH PILOT LIGHT	EA	
51	1	QOA162	HEATER/FUSE FOR G1515 MOTOR	EA	
52	1	G175202.00	TORQUE REACTION ARM	EA	
53	2	CW4	CASTERS WITH LOCK	EA	
54	2	B-1614-3	LEG SUPPORT BAR FOR SCI (SET)	EA	
55	1	BL-50	1/2" TIGER GRIPS	EA	
56		98330A280	LEG CLEVIS PIN 7/16 dia	EA	
57		90149A032	HAIR PIN	EA	
58		2481250	1/4 X 1/4 X 3-1/4 SQ KEY FOR R/A DRIVE SHAFT	EA	
59	1	A-8788	GEAR BOX TORQUE ARM	EA	
60	1	9307K48	RUBBER GROMMET FOR GEARBOX MOUNT	EA	
61	1	B-1614-4	ANGLE LEG SUPPORT BRACKET	EA	

SEE BELT SHEET FOR BELTS

PCI CONVEYOR PARTS
18" & 24" RIGHT ANGLE



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