

INSTRUCTIONS FOR HI-LINE INCLINED CONVEYOR



MODEL NO.
SI
SERIAL NO.

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

Made in the U.S.A. by Plastic Process Equipment, Inc. © copyright 2011



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

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

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

Thank you for purchasing a Hi-line conveyor from Plastic Process Equipment. This instruction booklet is intended as a guide for your new product. If you have additional questions, contact PPE at 1-800-362-0706.

RECEIVING

Thoroughly inspect your new conveyor or separator 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!**

SET-UP

(REQUIRES TWO PEOPLE)

- 1) Loosen leg brackets on inclined (non-hopper) end of conveyor (*see Figure 1*).

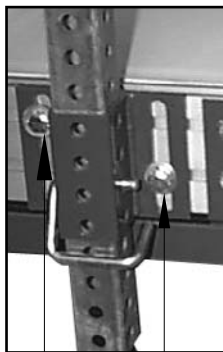


Figure 1

LOOSEN THESE BOLTS

- 2) Raise incline end and adjust leg brackets so they are perpendicular to the floor.
- 3) Insert unistrut leg assembly.
- 4) Set the locking pins.
- 5) Retighten the leg bracket bolts.
- 6) Lift hopper end of conveyor.
- 7) Insert legs.
- 8) Set locking pins.
- 9) Adjust legs to required position and height.
- 10) Keep legs perpendicular to the floor.
- 11) Adjust locks on swivel casters when conveyor is in position.

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 ADJUSTMENT AND TENSION

All conveyors and separators are thoroughly tested in our factory after final assembly. The belts are adjusted to track properly so **no adjustment should be necessary.**

LUBRICATION

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*).

Figure 2



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BELT REPLACEMENT (REQUIRES TWO PEOPLE)

- 1) Remove end caps.
- 2) Remove legs (long, drive-side legs first).
- 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 and hopper slide off with bolts attached).
- 5) Slide hopper and side rails off (away from motor end).
- 6) Back out adjustment nuts on roller support shaft (three locations) (see Figure 3).

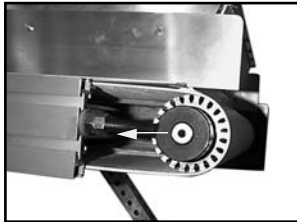


Figure 3

When retightening the roller support shaft, the distance from the edge of the frame to the roller support block should be 4" (see Figure 4).

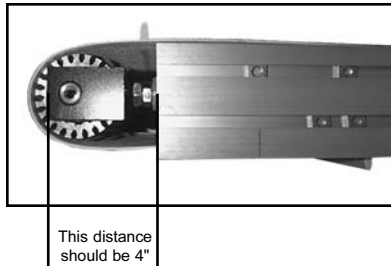


Figure 4

This distance should be 4"

- 7) Mark edge of plate against the frame on the drive end side (see Figure 5) (for adjustment during reassembly).



Figure 5

PLACE MARK HERE

- 8) Loosen the three Allen head bolts from drive side mounting plate (see Figure 5) (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 6).



Figure 6

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.



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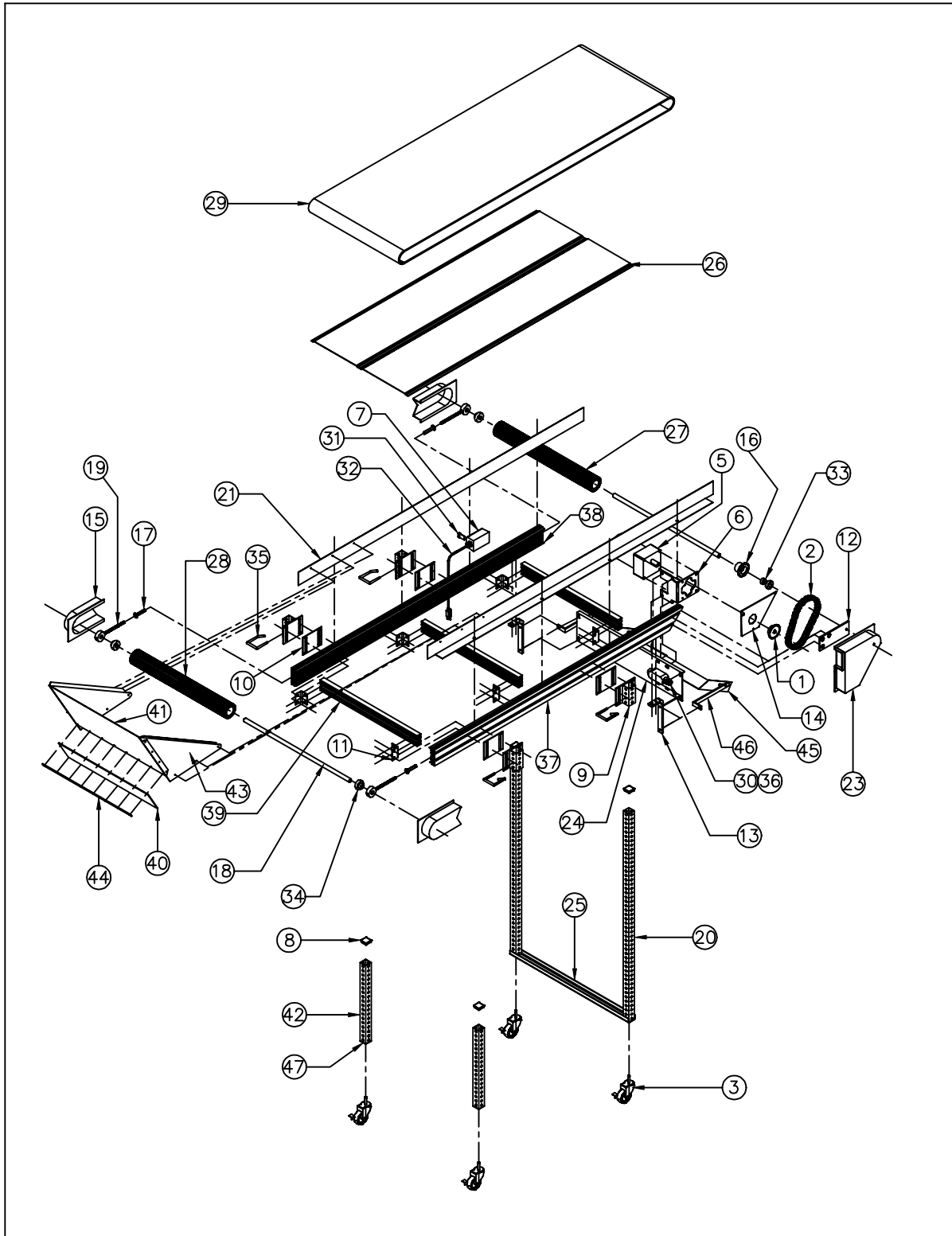
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SI CONVEYOR PARTS



PLASTIC PROCESS EQUIPMENT, INC.

8303 Corporate Park Drive, Macedonia (CLEVELAND), OHIO 44056
 (216) 367-7000 TOLL FREE: 800-321-0562 FAX (216) 367-7022 ORDER FAX: 800-223-8305 EMAIL: SALES@PPE.COM

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 FAX: (727) 834-8873

SI CONVEYORS

PARTS LIST 6"

09/17/15

08:00:16 AM

ID	P/N	DESCRIPTION	UOM
OPTIONAL	0791B	0791B BODINE VARIABLE SPEED CONTROL W/12FT CORD	EA
OPTIONAL	6183	1/4HP GEARMOTOR DC VERSION OF 655 NEW #5044	EA
1	35BS22HTX3/4	#35 HARDENED SPROCKET KEYED W/SET SCREW	EA
2	35CK	35 CHAIN, HALF LINK, MASTER LINK KIT	EA
3	CW4	CASTERS WITH LOCK	EA
5	655	655 1/6HP BODINE GEARMOTOR	EA
6	655L	L BRACKET FOR 655 MOTOR	EA
7	CR101Y11	SWITCH WITH PILOT LIGHT	EA
8	VG-560-1.5-11	CAP FOR SP/SI/SIV/VIB LEGS	EA
9	A-5477	LEG MOUNTING BRACKET FOR SP, SI, SIV/VIB	EA
10	A-5480	LEG MOUNTING BRACKET SPACER FOR SP, SI, SIV/VIB	EA
11	A-5486	FRAME "L" BRACKET FOR SI, SP, & SIV/VIB	EA
12	A-5535	DRIVE ROLL PLATE FOR SP & SI	EA
13	A-5545	MOTOR PLATE BRACKET FOR SP & SI	EA
14	A-5560	MOTOR DRIVE SHIELD FOR SP & SI CONVEYOR	EA
15	A-6850	PLASTIC BEARING COVER	EA
16	A-5959	MACHINED SPROCKET FOR CONVEYOR	EA
17	A-5980	PLASTIC BUSHING	EA
18	A-5982-6	SHAFTS FOR CONVEYORS 6"	EA
19	B-5479	TENSION ADJUSTMENT ROD FOR SI SIV/VIB & SP	EA
20	B-5483-48	LEG TUBE ONLY FOR SI & SIV/VIB 48"	EA
21	B-5960-4	SIDE RAIL FOR SI 4'(SET)	EA
21	B-5960-5	SIDE RAIL FOR SI 5'(SET)	EA
21	B-5960-6	SIDE RAIL FOR SI 6'(SET)	EA
21	B-5960-7	SIDE RAIL FOR SI 7'(SET)	EA
21	B-5960-8	SIDE RAIL FOR SI 8'(SET), INCLUDES ANODIZE	EA
21	B-5960-9	SIDE RAIL FOR SI 9'(SET)	EA
21	B-5960-10	SIDE RAIL FOR SI 10'(SET)	EA
21	B-5960-11	SIDE RAIL FOR SI 11'(SET)	EA
21	B-5960-12	SIDE RAIL FOR SI 12'(SET)	EA
23	B-5583	MOTOR GUARD	EA
24	B-5618-6	MOTOR MOUNTING PLATE 6" FOR SP	EA
25	B-5627-6	STAND CROSSBRACE 6" FOR SI, SIV/VIB	EA
26	B-5983-4-6G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 4' X 6"	SET
26	B-5983-5-6G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 5' X 6"	SET
26	B-5983-6-6G	GALV BEDDING FOR SI CONVEYOR (ea) 6' X 6"	SET
26	B-5983-7-6G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 7' X 6"	SET
26	B-5983-8-6G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 8' X 6"	SET
26	B-5983-9-6G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 9' X 6"	SET
27	B-5984-6	DRIVE ROLLER (DOES NOT INCLUDE BEARINGS) 6"	EA
28	B-5998-6	IDLER ROLLER (DOES NOT INCLUDE BEARINGS) 6"	EA
29	BELT	SEE BELT SHEET	EA
30	SEC50BA	STRAIN RELIEF FOR ELECTRIC CORD	EA
31	FUSE	FUSE	EA
32	K5152	K5152 12' POWER CORD	EA
33	RA1012NPP+COL	SPROCKET BEARING w/COLLAR FOR SP, SI, SIV/VIB	EA
34	YA012RR	BEARINGS FOR SP, SI, SIV/VIB CONVEYOR	EA
35	T092	LOCK PIN	EA
36	30432	JUNCTION BOX	EA
37	B-5994-4	RIGHT SIDE FRAME 4' FOR SI/SP	EA
37	B-5994-5	RIGHT SIDE FRAME 5' FOR SI/SP	EA
37	B-5994-6	RIGHT SIDE FRAME 6' FOR SI/SP	EA
37	B-5994-7	RIGHT SIDE FRAME 7' FOR SI/SP	EA
37	B-5994-8	RIGHT SIDE FRAME 8' FOR SI/SP	EA
37	B-5994-9	RIGHT SIDE FRAME 9' FOR SI/SP	EA
37	B-5994-10	RIGHT SIDE FRAME 10' FOR SI/SP	EA
37	B-5994-11	RIGHT SIDE FRAME 11' FOR SI/SP	EA
37	B-5994-12	RIGHT SIDE FRAME 12' FOR SI/SP	EA
38	B-5995-4	LEFT SIDE FRAME 4' FOR SI/SP	EA
38	B-5995-5	LEFT SIDE FRAME 5' FOR SI/SP	EA
38	B-5995-6	LEFT SIDE FRAME 6' FOR SI/SP	EA
38	B-5995-7	LEFT SIDE FRAME 7' FOR SI/SP	EA
38	B-5995-8	LEFT SIDE FRAME 8' FOR SI/SP	EA
38	B-5995-9	LEFT SIDE FRAME 9' FOR SI/SP	EA
38	B-5995-10	LEFT SIDE FRAME 10' FOR SI/SP	EA
38	B-5995-11	LEFT SIDE FRAME 11' FOR SI/SP	EA
38	B-5995-12	LEFT SIDE FRAME 12' FOR SI/SP	EA
39	B-5985-6	CROSS MEMBER 6"	EA
40	A-6435-6	FLAPPER BELT 6" FOR SI	EA
41	A-6433-6	ALUMINUM HOPPER FRONT 6"	EA
42	B-5483-18	LEG TUBE ONLY FOR SI 18"	EA
43	A-6432	ALUMINUM HOPPER SIDES (SET)	SET
44	A-6434-6	FLAPPER STRIP 6"	EA
45	A-6453-6	SS TRAY 6"	EA
46	A-6456	TRAY BRACKET FOR SI CONVEYOR	EA
47	VG5538B12	LEG THREADED INSERT FOR CONVEYOR LEGS	EA

SEE BELT SHEET FOR BELTS

**SI CONVEYORS
PARTS LIST 12"**

09/17/15

08:03:47 AM

ID	P/N	DESCRIPTION	UOM
OPTIONAL	0791B	0791B BODINE VARIABLE SPEED CONTROL W/12FT CORD	EA
OPTIONAL	6183	1/4HP GEARMOTOR DC VERSION OF 655 NEW #5044	EA
1	35BS22HTX3/4	#35 HARDENED SPROCKET KEYED W/SET SCREW	EA
2	35CK	35 CHAIN, HALF LINK, MASTER LINK KIT	EA
3	CW4	CASTERS WITH LOCK	EA
5	655	655 1/6HP BODINE GEARMOTOR	EA
6	655L	L BRACKET FOR 655 MOTOR	EA
7	CR101Y11	SWITCH WITH PILOT LIGHT	EA
8	VG-560-1.5-11	CAP FOR SP/SI/SIV/VIB LEGS	EA
9	A-5477	LEG MOUNTING BRACKET FOR SP, SI, SIV/VIB	EA
10	A-5480	LEG MOUNTING BRACKET SPACER FOR SP, SI, SIV/VIB	EA
11	A-5486	FRAME "L" BRACKET FOR SI, SP, & SIV/VIB	EA
12	A-5535	DRIVE ROLL PLATE FOR SP & SI	EA
13	A-5545	MOTOR PLATE BRACKET FOR SP & SI	EA
14	A-5560	MOTOR DRIVE SHIELD FOR SP & SI CONVEYOR	EA
15	A-6850	PLASTIC BEARING COVER	EA
16	A-5959	MACHINED SPROCKET FOR CONVEYOR	EA
17	A-5980	PLASTIC BUSHING	EA
18	A-5982-12	SHAFTS FOR CONVEYORS 12"	EA
19	B-5479	TENSION ADJUSTMENT ROD FOR SI SIV/VIB & SP	EA
20	B-5483-48	LEG TUBE ONLY FOR SI & SIV/VIB 48"	EA
21	B-5960-4	SIDE RAIL FOR SI 4'(SET)	EA
21	B-5960-5	SIDE RAIL FOR SI 5'(SET)	EA
21	B-5960-6	SIDE RAIL FOR SI 6' (SET)	EA
21	B-5960-7	SIDE RAIL FOR SI 7'(SET)	EA
21	B-5960-8	SIDE RAIL FOR SI 8'(SET), INCLUDES ANODIZE	EA
21	B-5960-9	SIDE RAIL FOR SI 9'(SET)	EA
21	B-5960-10	SIDE RAIL FOR SI 10'(SET)	EA
21	B-5960-11	SIDE RAIL FOR SI 11'(SET)	EA
21	B-5960-12	SIDE RAIL FOR SI 12'(SET)	EA
23	B-5583	MOTOR GUARD	EA
24	B-5618-12	MOTOR MOUNTING PLATE 12" FOR SP, SI	EA
25	B-5627-12	STAND CROSSBRACE 12" FOR SI, SIV/VIB	EA
26	B-5983-4-12G	GALV BEDDING FOR SI/SP/SIV CONVEYOR (ea) 4' X 12"	SET
26	B-5983-5-12G	GALV BEDDING FOR SI/SP/SIV CONVEYOR (ea) 5' X 12"	SET
26	B-5983-6-12G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 6' X 12"	SET
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27	B-5984-12	DRIVE ROLLER (DOES NOT INCLUDE BEARINGS) 12"	EA
28	B-5998-12	IDLER ROLLER (DOES NOT INCLUDE BEARINGS) 12"	EA
29	BELT	SEE BELT SHEET	EA
30	SEC50BA	STRAIN RELIEF FOR ELECTRIC CORD	EA
31	FUSE	FUSE	EA
32	K5152	K5152 12' POWER CORD	EA
33	RAL012NPP+COL	SPROCKET BEARING w/COLLAR FOR SP, SI, SIV/VIB	EA
34	YA012RR	BEARINGS FOR SP, SI, SIV/VIB CONVEYOR	EA
35	T092	LOCK PIN	EA
36	30432	JUNCTION BOX	EA
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21	B-5960-9	SIDE RAIL FOR SI 9' (SET)	EA
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37	B-5994-7	RIGHT SIDE FRAME 7' FOR SI/SP	EA
37	B-5994-8	RIGHT SIDE FRAME 8' FOR SI/SP	EA
37	B-5994-9	RIGHT SIDE FRAME 9' FOR SI/SP	EA
37	B-5994-10	RIGHT SIDE FRAME 10' FOR SI/SP	EA
37	B-5994-11	RIGHT SIDE FRAME 11' FOR SI/SP	EA
37	B-5994-12	RIGHT SIDE FRAME 12' FOR SI/SP	EA
38	B-5995-4	LEFT SIDE FRAME 4' FOR SI/SP	EA
38	B-5995-5	LEFT SIDE FRAME 5' FOR SI/SP	EA
38	B-5995-6	LEFT SIDE FRAME 6' FOR SI/SP	EA
38	B-5995-7	LEFT SIDE FRAME 7' FOR SI/SP	EA
38	B-5995-8	LEFT SIDE FRAME 8' FOR SI/SP	EA
38	B-5995-9	LEFT SIDE FRAME 9' FOR SI/SP	EA
38	B-5995-10	LEFT SIDE FRAME 10' FOR SI/SP	EA
38	B-5995-11	LEFT SIDE FRAME 11' FOR SI/SP	EA
38	B-5995-12	LEFT SIDE FRAME 12' FOR SI/SP	EA
39	B-5985-18	CROSS MEMBER 18"	EA
40	A-6435-18	FLAPPER BELT 18" FOR SI	EA
41	A-6433-18	ALUMINUM HOPPER FRONT 18" (INCLUDING ANODIZE)	EA
42	B-5483-18	LEG TUBE ONLY FOR SI 18"	EA
43	A-6432	ALUMINUM HOPPER SIDES (SET)	SET
44	A-6434-18	FLAPPER STRIP 18"	EA
45	A-6453-18	SS TRAY 18"	EA
46	A-6456	TRAY BRACKET FOR SI CONVEYOR	EA
47	VG5538B12	LEG THREADED INSERT FOR CONVEYOR LEGS	EA

SEE BELT SHEET FOR BELTS

SI CONVEYORS

PARTS LIST 24"

09/17/15

08:16:00 AM

ID	P/N	DESCRIPTION	UOM
OPTIONAL	0791B	0791B BODINE VARIABLE SPEED CONTROL W/12FT CORD	EA
OPTIONAL	6183	1/4HP GEARMOTOR DC VERSION OF 655 NEW #5044	EA
1	35B522HTX3/4	#35 HARDENED SPROCKET KEYED W/SET SCREW	EA
2	35CK	35 CHAIN, HALF LINK, MASTER LINK KIT	EA
3	CW4	CASTERS WITH LOCK	EA
5	655	655 1/6HP BODINE GEARMOTOR	EA
6	655L	L BRACKET FOR 655 MOTOR	EA
7	CR101Y11	SWITCH WITH PILOT LIGHT	EA
8	VG-560-1.5-11	CAP FOR SP/SI/SIV/VIB LEGS	EA
9	A-5477	LEG MOUNTING BRACKET FOR SP, SI, SIV/VIB	EA
10	A-5480	LEG MOUNTING BRACKET SPACER FOR SP, SI, SIV/VIB	EA
11	A-5486	FRAME "L" BRACKET FOR SI, SP, & SIV/VIB	EA
12	A-5535	DRIVE ROLL PLATE FOR SP & SI	EA
13	A-5545	MOTOR PLATE BRACKET FOR SP & SI	EA
14	A-5560	MOTOR DRIVE SHIELD FOR SP & SI CONVEYOR	EA
15	A-6850	PLASTIC BEARING COVER	EA
16	A-5959	MACHINED SPROCKET FOR CONVEYOR	EA
17	A-5980	PLASTIC BUSHING	EA
18	A-5982-24	SHAFTS FOR CONVEYORS 24"	EA
19	B-5479	TENSION ADJUSTMENT ROD FOR SI SIV/VIB & SP	EA
20	B-5483-48	LEG TUBE ONLY FOR SI & SIV/VIB 48"	EA
21	B-5960-4	SIDE RAIL FOR SI 4' (SET)	EA
21	B-5960-5	SIDE RAIL FOR SI 5' (SET)	EA
21	B-5960-6	SIDE RAIL FOR SI 6' (SET)	EA
21	B-5960-7	SIDE RAIL FOR SI 7' (SET)	EA
21	B-5960-8	SIDE RAIL FOR SI 8' (SET), INCLUDES ANODIZE	EA
21	B-5960-9	SIDE RAIL FOR SI 9' (SET)	EA
21	B-5960-10	SIDE RAIL FOR SI 10' (SET)	EA
21	B-5960-11	SIDE RAIL FOR SI 11' (SET)	EA
21	B-5960-12	SIDE RAIL FOR SI 12' (SET)	EA
23	B-5583	MOTOR GUARD	EA
24	B-5618-24	MOTOR MOUNTING PLATE 24" FOR SP, SI	EA
25	B-5627-24	STAND CROSSBRACE 24" FOR SI, SIV/VIB	EA
26	B-5983-4-24G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 4' X 24"	SET
26	B-5983-5-24G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 5' X 24"	SET
26	B-5983-6-24G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 6' X 24"	SET
26	B-5983-7-24G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 7' X 24"	SET
26	B-5983-8-24G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 8' X 24"	SET
26	B-5983-9-24G	GALV BEDDING FOR SI/SP CONVEYOR (ea) 9' X 24"	SET
27	B-5984-24	DRIVE ROLLER (DOES NOT INCLUDE BEARINGS) 24"	EA
28	B-5998-24	IDLER ROLLER (DOES NOT INCLUDE BEARINGS) 24"	EA
29	BELT	SEE BELT SHEET	EA
30	SEC50BA	STRAIN RELIEF FOR ELECTRIC CORD	EA
31	FUSE	FUSE	EA
32	K5152	K5152 12' POWER CORD	EA
33	RAL012NPP+COL	SPROCKET BEARING w/COLLAR FOR SP, SI, SIV/VIB	EA
34	YA012RR	BEARINGS FOR SP, SI, SIV/VIB CONVEYOR	EA
35	T092	LOCK PIN	EA
36	30432	JUNCTION BOX	EA
37	B-5994-4	RIGHT SIDE FRAME 4' FOR SI/SP	EA
37	B-5994-5	RIGHT SIDE FRAME 5' FOR SI/SP	EA
37	B-5994-6	RIGHT SIDE FRAME 6' FOR SI/SP	EA
37	B-5994-7	RIGHT SIDE FRAME 7' FOR SI/SP	EA
37	B-5994-8	RIGHT SIDE FRAME 8' FOR SI/SP	EA
37	B-5994-9	RIGHT SIDE FRAME 9' FOR SI/SP	EA
37	B-5994-10	RIGHT SIDE FRAME 10' FOR SI/SP	EA
37	B-5994-11	RIGHT SIDE FRAME 11' FOR SI/SP	EA
37	B-5994-12	RIGHT SIDE FRAME 12' FOR SI/SP	EA
38	B-5995-4	LEFT SIDE FRAME 4' FOR SI/SP	EA
38	B-5995-5	LEFT SIDE FRAME 5' FOR SI/SP	EA
38	B-5995-6	LEFT SIDE FRAME 6' FOR SI/SP	EA
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