

# INSTRUCTIONS FOR VARIABLE INCLINE CONVEYOR



MODEL NO.

VIC

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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Thank you for purchasing a Variable Incline Conveyor from Plastic Process Equipment. This instruction booklet is intended as a guide for your new product. If you have additional questions, contact Plastic Process Equipment, Inc. at 1-800-321-0562.

## RECEIVING

Thoroughly inspect your new conveyor 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 setup of your new equipment. ***Safety First Always!***

## SETUP

**(REQUIRES TWO PEOPLE)**

Your new conveyor is crated and shipped from the factory fully assembled.

After uncrating:

- 1) Loosen the pivot bolts (*see Figure 1*) on both sides of the conveyor.

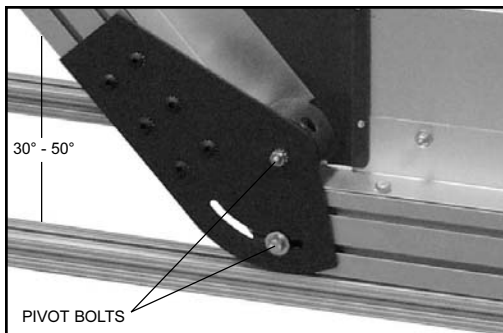


Figure 1

- 2) Elevate the incline end while pushing on the belt near the pivot point (*see Figure 2*).



Figure 2

- 3) Set conveyor at desired angle (between 30° and 50°) and retighten the pivot bolts, after setting the conveyor to the desired angle (*see Figure 1*).
- 4) Remember to lock the casters after adjusting the conveyor and setting it into 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 drive motor is not designed for repeated start stop operation, if you turn the conveyor on and off more than 10 times per minute 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, TENSION & TRACKING

PPE conveyors feature automatic spring loaded belt tension adjustment. All conveyors and separators are thoroughly tested in our factory after final assembly. The belts are adjusted to track properly so **no adjustment will be necessary**. Because of the endless 2-ply monofilament belt (no lacing to snag or tear) and Vee-guide tracking, there should never be a tracking problem with a PPE conveyor.

## LUBRICATION: CHAIN DRIVE UNITS

(BIC, FT, FS, VICB, PC 06, PC 12, PC 24, PCS, PUC, VIB, ICG, PCS, VIC, VICF) 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.

## BELT REPLACEMENT

(REQUIRES TWO PEOPLE)

- 1) Disconnect all power to the conveyor.
- 2) Remove the eight hopper bolts on top of frame (see **Figure 1**) and the two Allen head screws and the A-5470 plastic transition covers where the hopper meets the incline section.

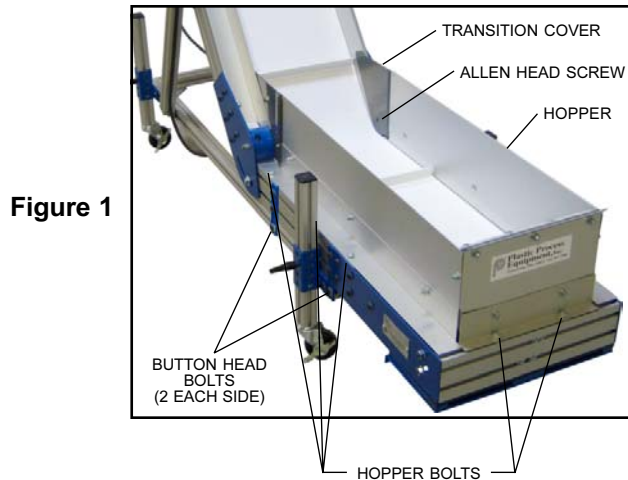


Figure 1

- 13) Carefully lift conveyor off of leg stand frame. Install button head bolts back into square nuts on frame temporarily to hold square nuts in place.
- 14) Place conveyor on it's side (drive side down), conveyor must be elevated to clear variable speed control.
- 15) Remove plate on non-drive side (see **Figure 2**). **DO NOT REMOVE THE FRAME ATTACHMENT BRACKET!**

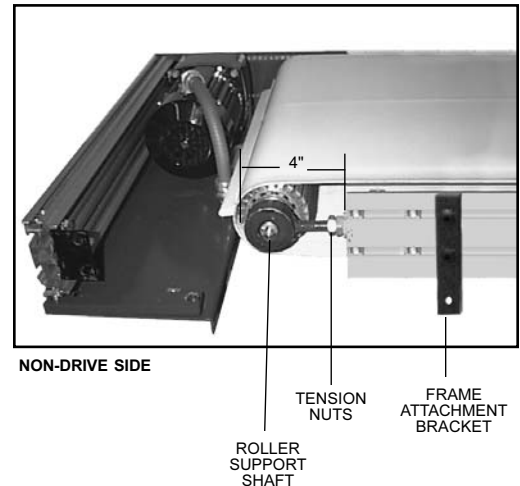


Figure 2

- 3) Remove hopper.
- 4) Remove end caps (and optional part drop tray if purchased).
- 5) Using a pencil draw a vertical line across the frame and side rails (used to align side rails during reassembly).
- 6) Loosen the bolts on the incline side rails (**DO NOT REMOVE BOLTS**).
- 7) Slide the incline side rails up & out of the conveyor upper side frame.
- 8) Adjust the conveyor to a flat position by:  
First, loosen the pivot nuts & bolts. (Note: the pivot nut on the left side is a left hand thread).  
Second, loosen the bolts at the bottom of each support arm that attach to the leg stand frame.  
Third, loosen the locking handles on the angle brackets.
- 9) Untuck the power cord from the side base frame.
- 10) Disconnect the angle support arm on drive side by removing the bolt at the bottom of the arm attaching it to the leg stand frame. Tighten locking handle.
- 11) Disconnect the angle bracket on non-drive side by removing the four (4) button head bolts. Install button head bolts back into square nuts on frame temporarily to hold square nuts in place.
- 12) Remove the leg stand frame by removing the two (2) button head bolts at the bottom of each side of the frame. **DO NOT REMOVE THE FRAME ATTACHMENT BRACKETS!**

- 16) Free the top belt edges from under the transition rollers and free the bottom belt edges from within the frame track so the belt hangs below the frame.
- 17) While compressing the roller on the non-drive end, pull the belt half way up and off of the drive roller.
- 18) Continue compressing the non-drive roller while pulling the belt halfway off the non-drive end. When belt is halfway off both ends, it can be removed the rest of the way.

**CAUTION:**  
**ROLLER AND ENDS UNDER SPRING TENSION!**

- 19) To reassemble conveyor, follow 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.
- 20) After installing the new belt and reassembling the conveyor, return conveyor to required height and angle of operation.

## 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.

**VIC CONVEYORS  
PARTS LIST 12"**

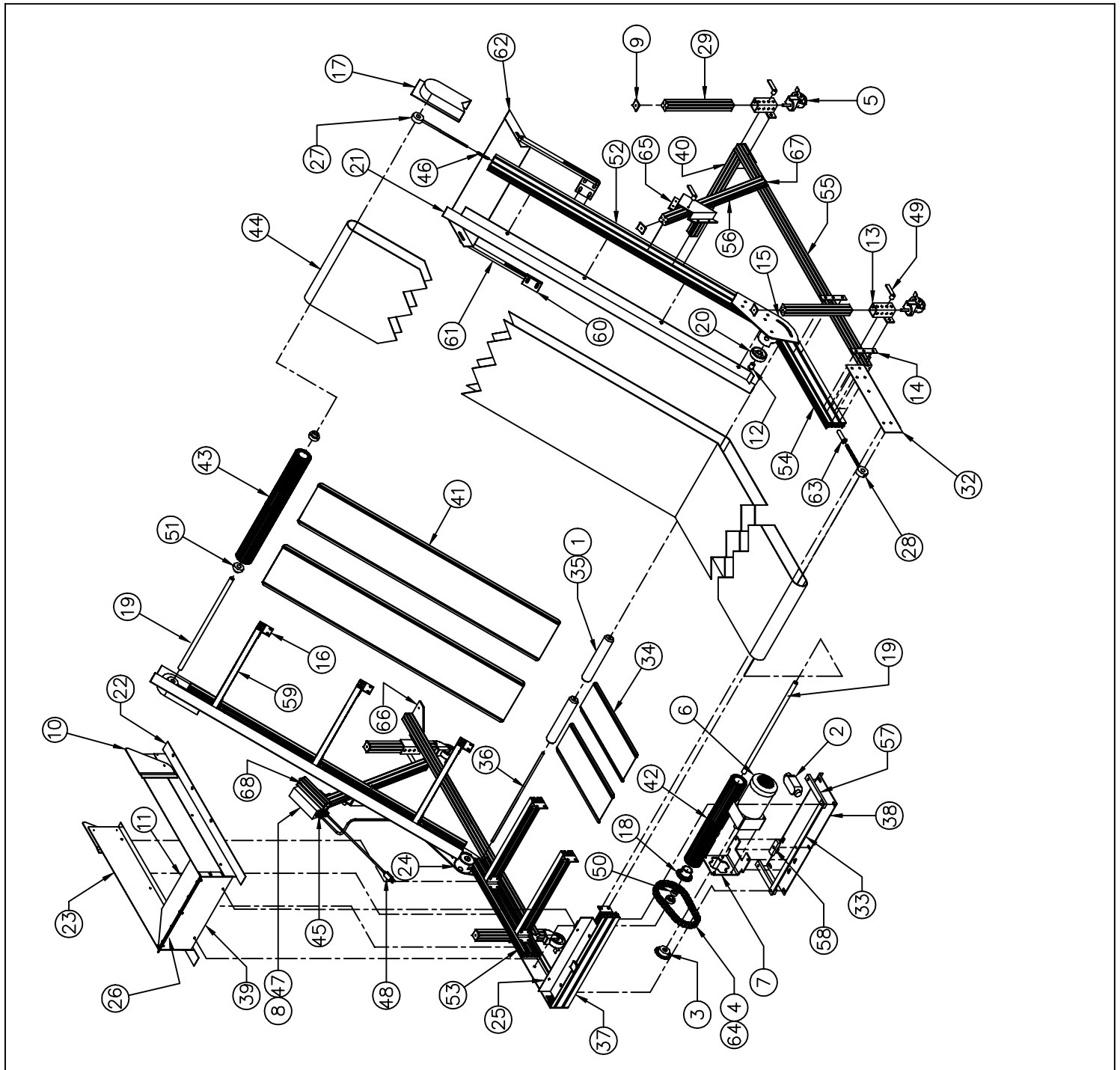
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| ID       | QTY | P/N           | DESCRIPTION   | UOM |
|----------|-----|---------------|---|-----|
| OPTIONAL | 1   | 35BS19HTX3/4  | #35 HARDENED SPROCKET KEYED W/SET SCREW - BUILT BEFORE 3/1/2019       | EA  |
| OPTIONAL | 1   | 5044          | 1/4 HP DC BODINE MOTOR - BUILT BEFORE 3/1/2019                        | EA  |
| OPTIONAL | 1   | 655L          | L BRACKET FOR 655/ 6183/ 5044 MOTOR - BUILT BEFORE 3/1/2019           | EA  |
| OPTIONAL | 1   | MDL-3         | FUSE 3A/250V FOR 5044 MOTOR   | EA  |
| 1        | 4   | 1416D-1/2     | TRANSITION ROLLER END CAP FOR SIV/VIB                                 | EA  |
| 2        | 1   | 30432         | JUNCTION BOX  | EA  |
| 3        | 1   | 35BS19HTX5/8  | #35 HARDENED SPROCKET FOR SIV & VIB CONVEYOR - BUILT AFTER 3/1/2019   | EA  |
| 4        | 2   | 35C           | #35 CHAIN PER FOOT  | EA  |
| 5        | 5   | CW4           | CASTERS WITH LOCK   | EA  |
| 6        | 1   | 1060          | 1/4 HP DC MOTOR - BUILT AFTER 3/1/2019                                | EA  |
| 7        | 1   | 0970          | BRACKET FOR 1060 MOTOR - BUILT AFTER 3/1/2019                         | EA  |
| 8        | 1   | KB9380C       | VARI SPEED CONTROL  | EA  |
| 9        | 7   | 2030-3274     | BLACK PLASTIC CAP FOR EXT1515 EXTRUSION                               | EA  |
| 10       | 2   | A-5470        | PLASTIC TRANSITION COVER FOR SIV/VIB (set)                            | EA  |
| 11       | 1   | A-5474-12     | PLASTIC FLAPPER 12" FOR SIV/VIB (WHITE)                               | EA  |
| 12 KIT   | 2   | A-5476K       | PLASTIC WHEEL, ROLLER HUB WITH STUD, WASHER, AND NUT (SET LEFT&RIGHT) | EA  |
| 13       | 4   | A-10661       | LEG BRACKET FOR VIC AND VICF  | EA  |
| 14       | 4   | A-10660       | FRAME ATTACHMENT BRACKET FOR VIC                                      | EA  |
| 15       | 2   | A-5481        | SWIVEL PLATE FOR SIV/VIB  | EA  |
| 16       | 12  | A-5486        | FRAME "L" BRACKET FOR SI, SP, SIV/VIB, BCH                            | EA  |
| 17       | 2   | A-6850        | PLASTIC BEARING COVER   | EA  |
| 18       | 1   | A-5959        | MACHINED SPROCKET FOR CONVEYOR  | EA  |
| 19       | 2   | A-5982-12     | SHAFTS FOR CONVEYORS 12"  | EA  |
| 20       | 2   | A-6987        | TRANSITION ROLLER FOR VIB/SIV   | EA  |
| 21       | 1   | B-6885        | UPPER SIDE RAILS ALUM FOR VIB (set)                                   | SET |
| 22       | 1   | B-5441-3      | ALUM SIDE RAIL FOR SIV (SET) , INCLUDES ANODIZE                       | SET |
| 23       | 1   | B-5442-3      | ALUM LOWER SIDE RAIL FOR SIV/VIB (SET) , INCLUDES ANODIZE             | SET |
| 24       | 2   | B-5471        | ALUM ROLLER COVER FOR SIV/VIB (SET)                                   | EA  |
| 25       | 1   | B-5472-12     | ALUM FLAPPER ANGLE FOR SIV/VIB 12"                                    | EA  |
| 26       | 1   | B-5475-12     | FLAPPER HINGE 12" FOR SIV/VIB   | EA  |
| 27       | 3   | B-10164       | TENSION ADJUSTMENT ROD FOR SIV/VIB NEW STYLE 1/2"                     | EA  |
| 28       | 1   | B-5479        | TENSION ADJUSTMENT ROD FOR SI SIV/VIB, SP, BCH                        | EA  |
| 29       | 4   | A-10654       | EXTRUDED LEG FOR VIC VICF   | EA  |
| 32       | 1   | B-5490        | DRIVE SIDE PLATE FOR SIV (SET)  | SET |
| 33       | 1   | B-5491-12     | PLASTIC END RAIL SPACER FOR SIV/VIB 12"                               | EA  |
| 34       | 2   | B-5494-2-12G  | GALV LOWER BEDDING FOR SIV/VIB 2' X 12"                               | EA  |
| 35       | 2   | B-5504-12     | TRANSITION ROLLER TUBE FOR SIV/VIB 12"                                | EA  |
| 36       | 1   | B-5516-12     | TRANSITION ROLLER SHAFT FOR SIV/VIB 12"                               | EA  |
| 37       | 1   | B-5566-12     | FRAME END FOR SIV/VIB 12"   | EA  |
| 38       | 1   | B-5623-12     | MOTOR BASE PLATE 12" FOR SIV/VIB                                      | EA  |
| 39       | 1   | B-5626-12     | ALUM FLAPPER MOUNT 12" FOR SIV/VIB (INCLUDING ANODIZE)                | EA  |
| 40       | 4   | A-10655-12    | REAR STAND CROSSBRACE FOR VIC 12"                                     | EA  |
| 41       | 2   | B-5983-4-12   | SS BEDDING FOR SI/SP/SIV CONVEYOR (SET) 4' X 12"                      | EA  |
| 42       | 1   | B-5984-12     | DRIVE ROLLER (DOES NOT INCLUDE BEARINGS) 12"                          | EA  |
| 43       | 1   | B-5998-12     | IDLER ROLLER (DOES NOT INCLUDE BEARINGS) 12"                          | EA  |
| 44       | 1   | BELT          | BELT  | EA  |
| 45       | 2   | S2112         | STRAIN RELIEF FOR ELECTRIC CORD                                       | EA  |
| 46       | 2   | DS-233        | BELT ADJUSTMENT SPRINGS 11" NEW STYLE 9/07                            | EA  |
| 47       | 1   | MDL-2         | FUSE 2A/250V FOR 6183 & 1060 MOTOR                                    | EA  |
| 48       | 1   | K5152         | K5152 12' POWER CORD  | EA  |
| 49       | 6   | 64835K69      | TEAR DROP HANDLE  | EA  |
| 50       | 1   | RAL012NPP+COL | SPROCKET BEARING w/COLLAR FOR SP, SI, SIV/VIB, BCH                    | EA  |
| 51       | 3   | YA012RR       | BEARINGS FOR SP, SI, SIV/VIB, BCH CONVEYOR                            | EA  |
| 52       | 2   | B-5993-4      | UPPER FRAME SIDE FOR SIV  | EA  |
| 53       | 1   | B-5996-3      | HORIZONTAL RIGHT SIDE FRAME FOR SIV                                   | EA  |
| 54       | 1   | B-6192-3      | HORIZONTAL LEFT SIDE FRAME FOR SIV                                    | EA  |
| 55       | 2   | A-10656-41    | SIDE BASE FRAME FOR VIC 41"   | EA  |
| 56       | 2   | A-10666       | ANGLE SUPPORT ARM FOR VIC   | EA  |
| 57       | 2   | A-6549A       | STEEL MOTOR PLATE SPACER FOR SIV/VIB                                  | EA  |
| 58       | 1   | A-6549B       | STEEL MOTOR PLATE SPACER FOR SIV/VIB                                  | EA  |
| 59       |     | B-5985-12     | CROSS MEMBER 12"  | EA  |
| 60       | 2   | A-6902        | CONVEYOR TRAY BRACKET   | EA  |
| 61       | 2   | B-4016        | FS ATTACHMENT ADJ BAR (set)   | EA  |
| 62       | 1   | A-6453-12     | SS TRAY 12"   | EA  |
| 63       | 2   | A-5980        | PLASTIC BUSHING   | EA  |
| 64       | 1   | 35ML          | #35 MASTER LINK   | EA  |
| 65       | 2   | A-10663       | ANGLE BRACKET FOR VIC (SET) NICKEL PLATED                             | EA  |
| 66       | 4   | EX4351        | JOINING PLATE FOR EXT1515   | EA  |
| 67       | 4   | EX4302        | 2 HOLE INSIDE CORNER FOR EXT1515                                      | EA  |
| 68       | 1   | A-10662       | CONTROL BOX MOUNTING ARM FOR VIC                                      | EA  |

SEE BELT SHEET FOR BELTS

# VIC CONVEYOR PARTS



## PLASTIC PROCESS EQUIPMENT, INC.

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