INSTRUCTIONS
FOR
FIXED ANGLE CONVEYOR

MODEL NO.

VICF

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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PLASTIC PROCESS EQUIPMENT, INC. www.ppe.com • e-mail: sales@ppe.com

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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

PPE **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 Fixed Angle 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) Adjust conveyor to required height.
2) 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 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.

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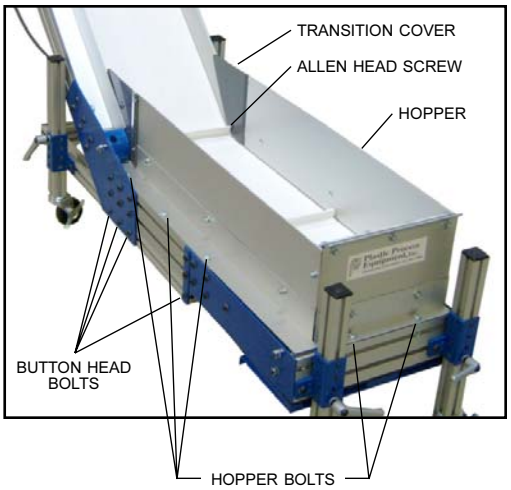
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BELT REPLACEMENT

(REQUIRES TWO PEOPLE)

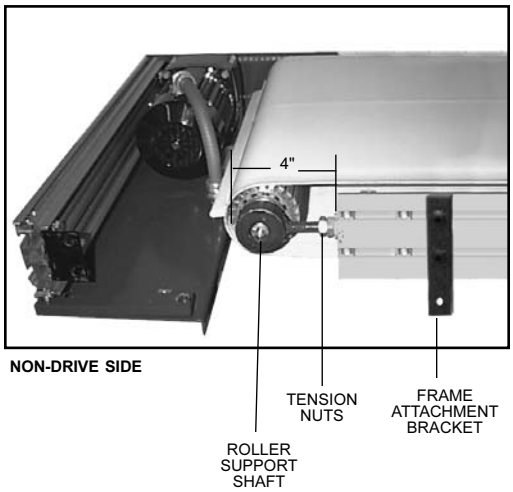
1) Disconnect all power to the conveyor.
2) Remove the eight hopper bolts on top of frame ***(see Figure 1)*** and the two Allen head screws and the A-5470 plastic transition covers where the hopper meets the incline section.

Figure 1



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) Untuck the power cord from the side base frame.
9) Remove the leg stand frame by removing the four (4) button head bolts at the bottom of each side of the frame. **DO NOT REMOVE THE FRAME ATTACHMENT BRACKETS OR TRANSITION PLATES!**
10) Carefully lift conveyor off of leg stand frame. Install button head bolts back into square nuts on frame temporarally to hold square nuts in place.
11) Place conveyor on it's side (drive side down), conveyor must be elevated to clear variable speed control.
12) Remove plate on non-drive side ***(see Figure 2)***. **DO NOT REMOVE THE FRAME ATTACHMENT BRACKET!**

Figure 2



13) 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.
14) While compressing the roller on the non-drive end, pull the belt half way up and off of the drive roller.
15) 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!

16) 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.
17) 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.

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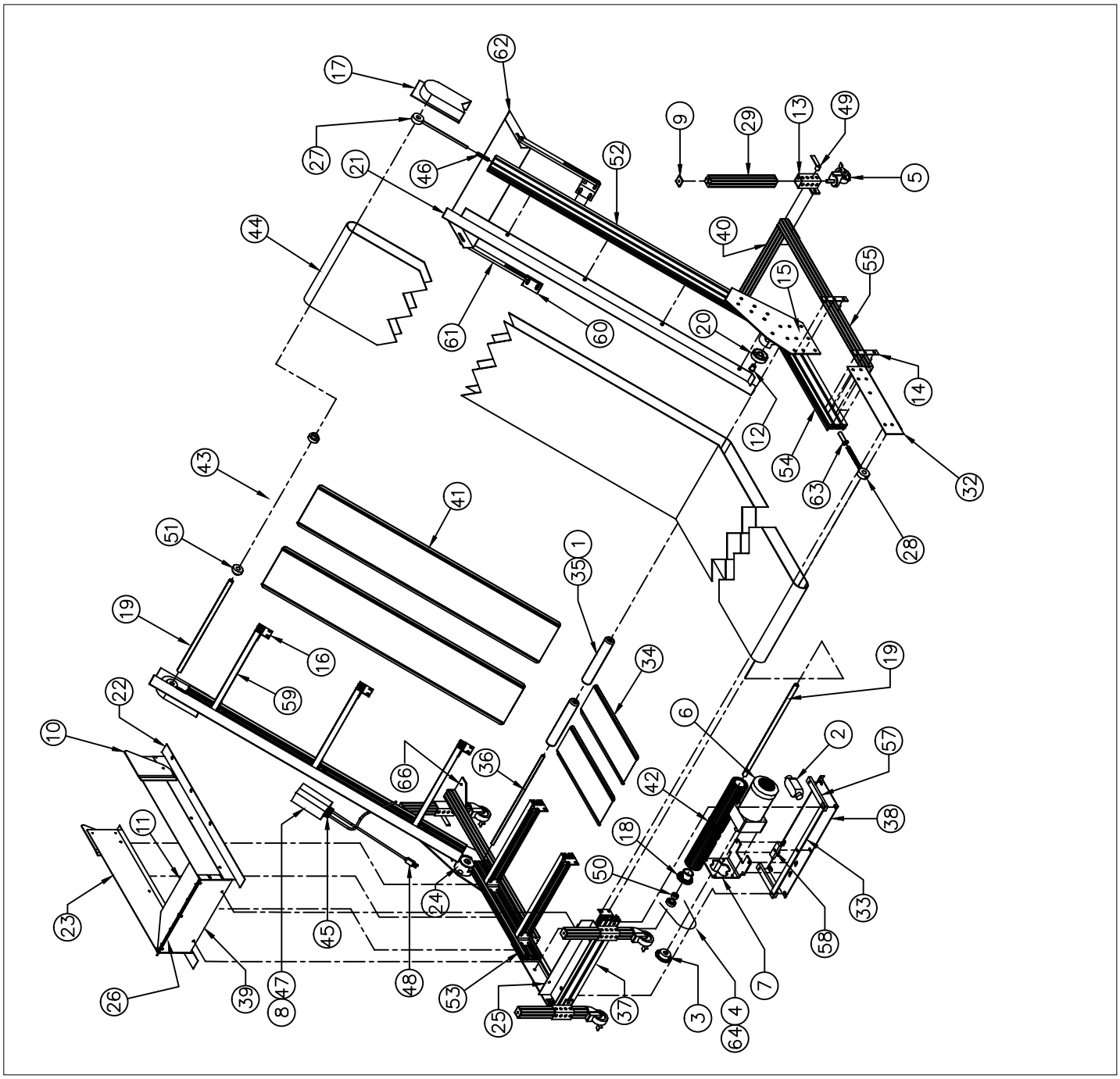
VICF CONVEYORS
PARTS LIST 12"

05/20/25

ID	QTY	P/N	DESCRIPTION	UOM	
1	4	1416D-1/2	TRANSITION ROLLER END CAP FOR SIV/VIB	EA	
2	1	30432	JUNCTION BOX	EA	
3	1	35BS19HTX3/4	#35 HARDENED SPROCKET KEYED W/SET SCREW	EA	
4	2	35C	#35 CHAIN PER FOOT	EA	
5	5	CW4	CASTERS WITH LOCK	EA	
6	1	5044	1/4 HP DC BODINE MOTOR	EA	
7	1	655L	L BRACKET FOR 655/ 6183/ 5044 MOTOR	EA	
8	1	0791B	0791B BODINE VARIABLE SPEED CONTROL W/12FT CORD	EA	
9	4	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&RIGI	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-10667	***OBS*** - SWIVEL PLATE FOR VICF	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	3	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-7026-12G	GALV BEDDING FOR VIB	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-3	FUSE 3A/250V FOR 5044 MOTOR	EA	
48	1	K5152	K5152 12' POWER CORD	EA	
49	4	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-7027	UPPER FRAME SIDE FOR VIB	EA	
53	1	B-7028	HORIZONTAL RIGHT SIDE FRAME FOR VIB	EA	
54	1	B-7038	HORIZONTAL LEFT SIDE FRAME FOR VIB	EA	
55	2	A-10656-36	SIDE BASE FRAME FOR VICF 36"	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	
66	4	EX4351	JOINING PLATE FOR EXT1515	EA	

SEE BELT SHEET FOR BELTS

VICF CONVEYOR PARTS



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