R0015358 Conveyor chassis

Assembly details for conveyor frame

Difficulty **Medium** | Duration **4 hour(s)**

Contents

Introduction

Tools Required

standard hex key set
Standard spanner set
Standard HSS drill set
Standard tap set
Utility knife

Parts Required

B0000441 Conveyor 3580mm x 300mm x 1
B0001013 Conveyor Motor SEW - WA 10 x 1
B0001177 Pair conveyor side cheeks and bearings slave x 2
M0000133 Conveyor Belt XL-AS 7350 x 300 B x 1

Step 1 - Unless otherwise stated

Use Loctite 243 on all fasteners
Use Loctite 572 on all threaded pneumatic connection
Pen mark all fasteners to show finalised

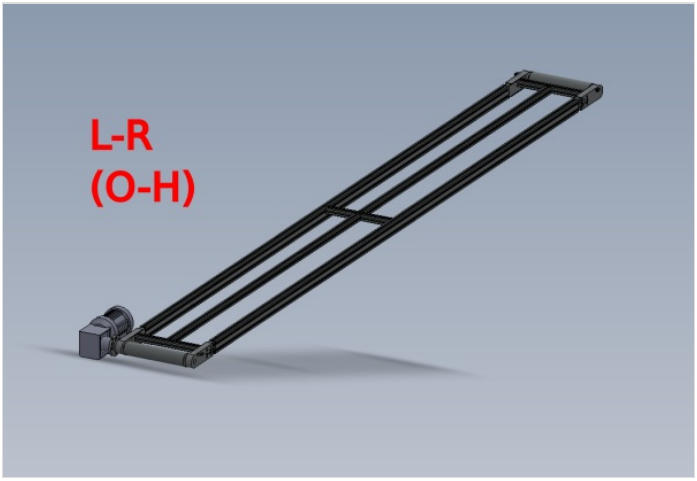
Step 2 - Handing

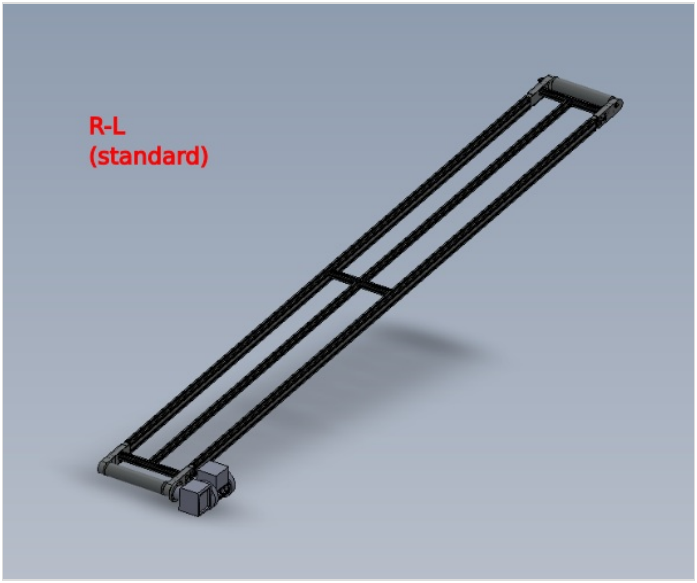
Conveyor can be built in 2 formats

L-R

R-L

Please see picture for clarification of orientation

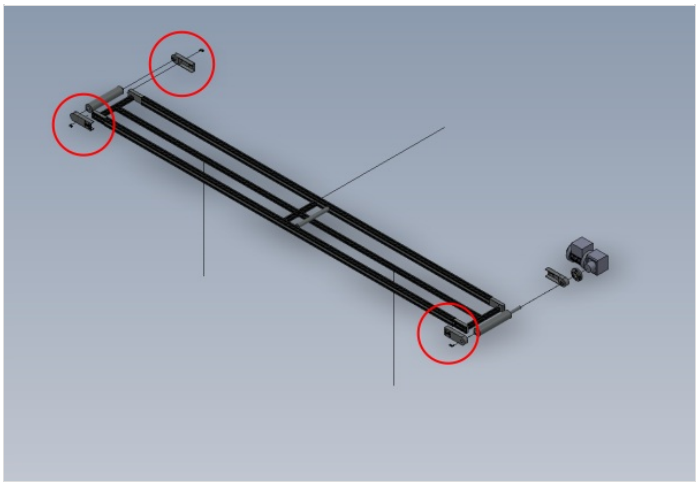




Step 3 - Drill blower points on rollers

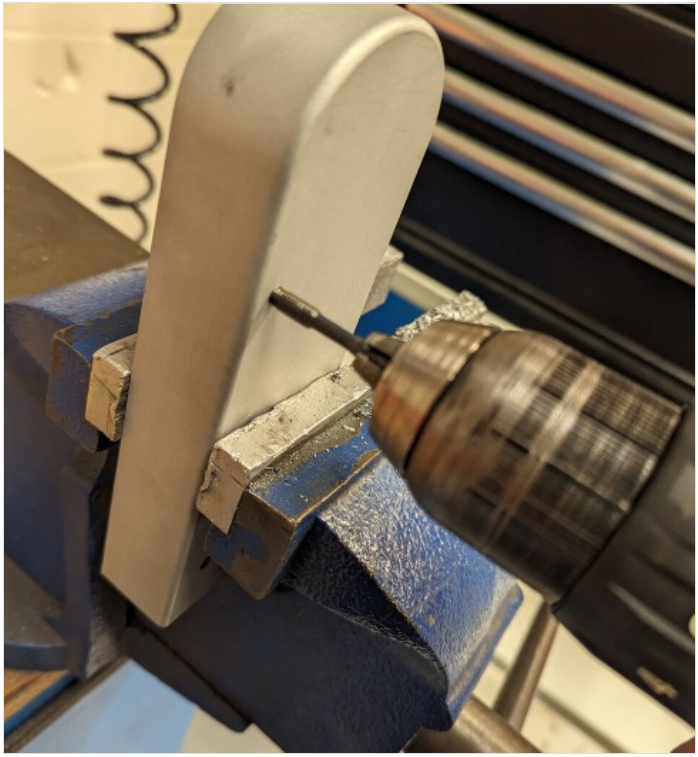
indicated 3 roller housings will require blower holes adding

Mark Blowers as shown .
Drill through with 2.5mm drill
Then drill half way from outside face with 4.2mm drill
Then tap outside face shown M5




TL
TR
BR

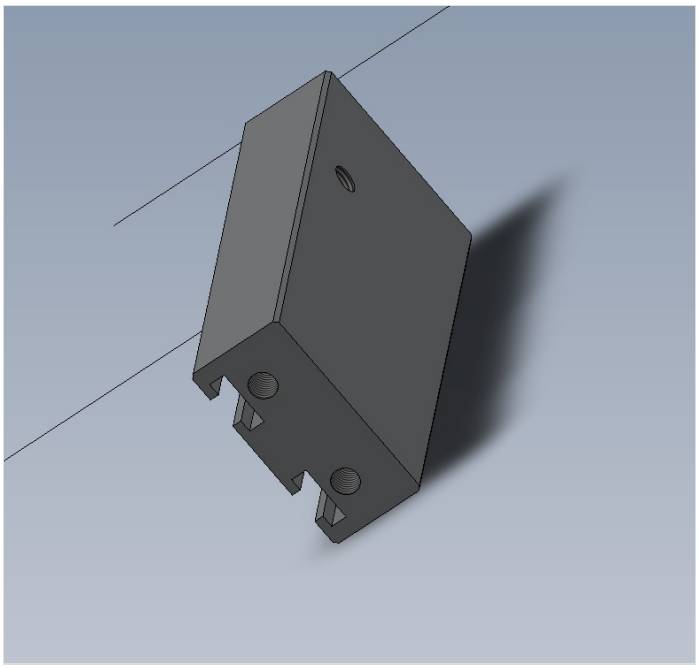

TL



Step 4 - Assemble mounts

Assemble 4 off mounts

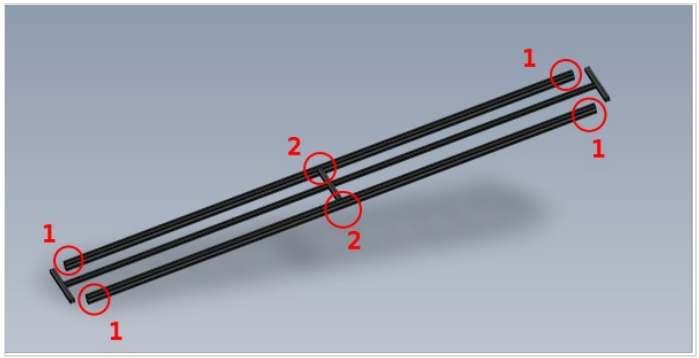
Ensure maytec fittings are orientated correctly
Ensure spring clip is fitted to D nut

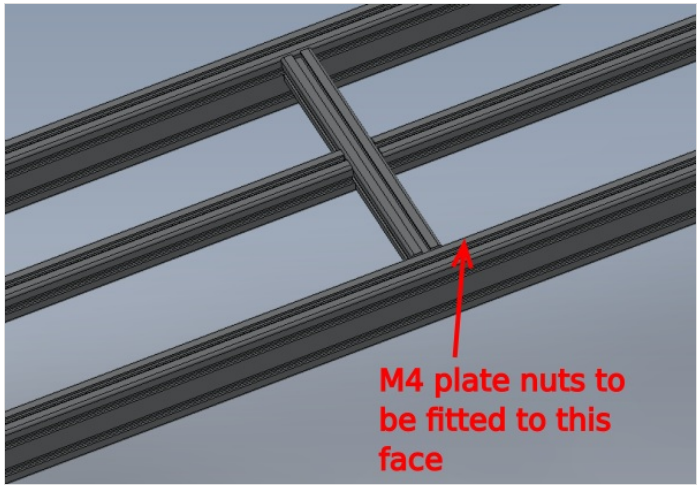


Step 5 - insert M4 plate nuts

insert 8 off supplied m4 plate nuts into correct face of long frame sections

4 off per side





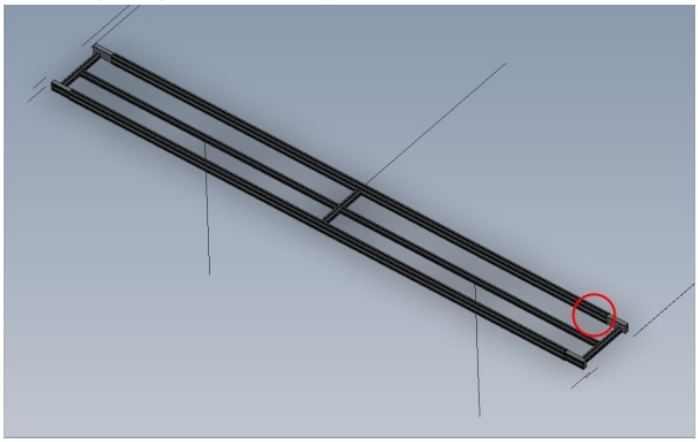
Step 6 - Assemble main frame

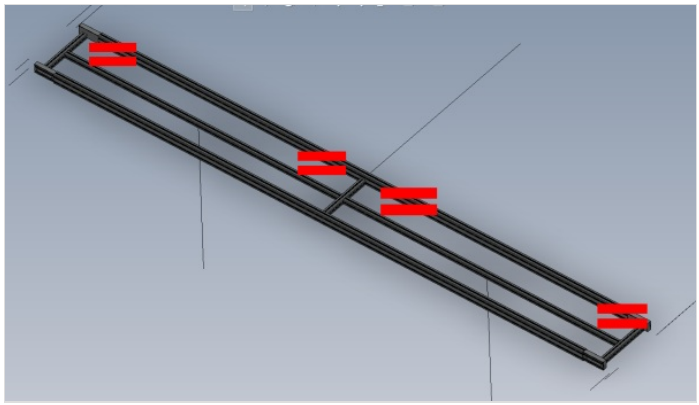
> ⚠ ...Ensure maytec barrel fittings are positioned on inside face

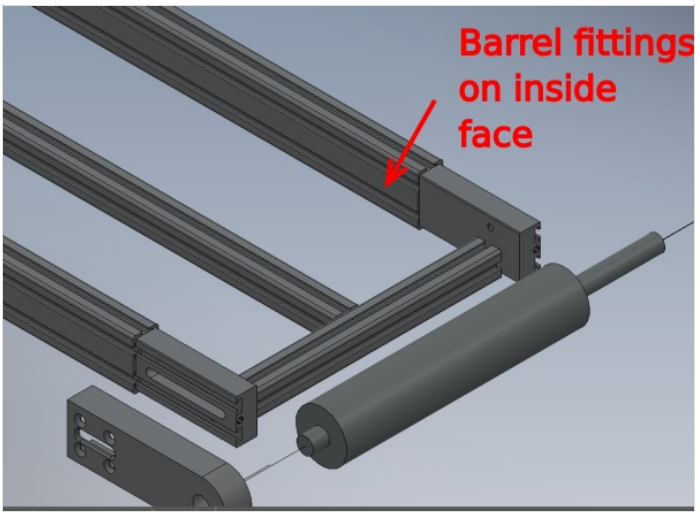
Assemble main maytec frame

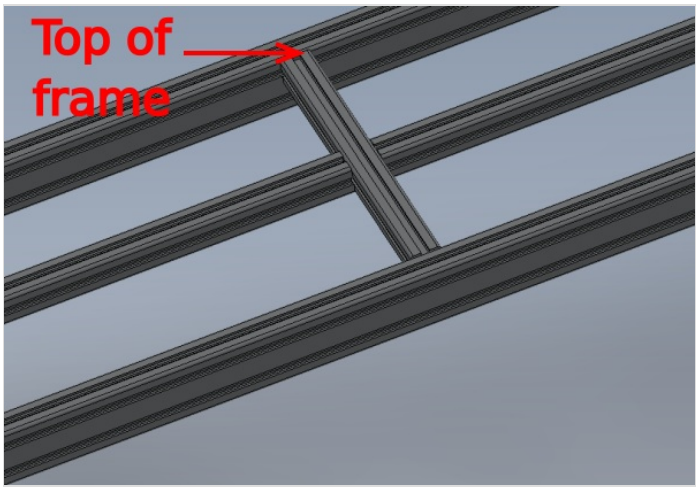
Ensure all sections are set in a parallel position

Please capture pictures for this please









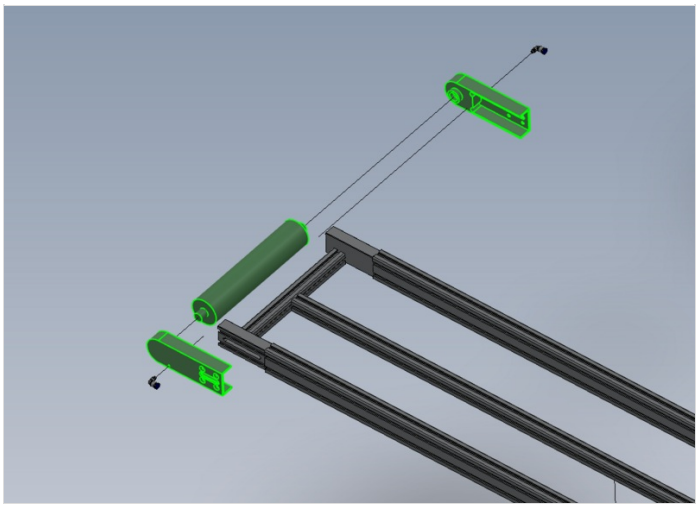
Step 7 - Finalise all fasteners

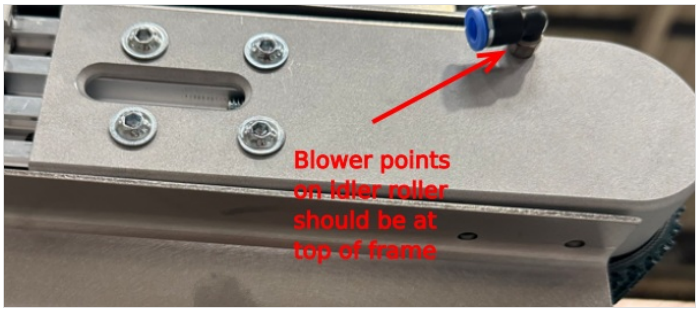
Ensure all fasteners are finalised on frame

Step 8 - Fit Slave roller (non driven)

Fit slave roller assembly as shown
Ensure spacer washers are fitted

Ensure blower points are orientated correctly to suit belt rotation direction



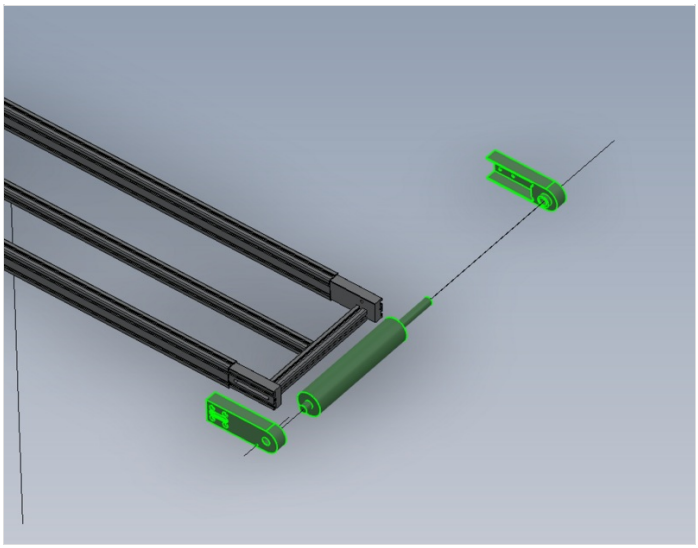


Step 9 - Fit drive roller

Fit drive roller assembly as shown

Ensure spacer washers are fitted

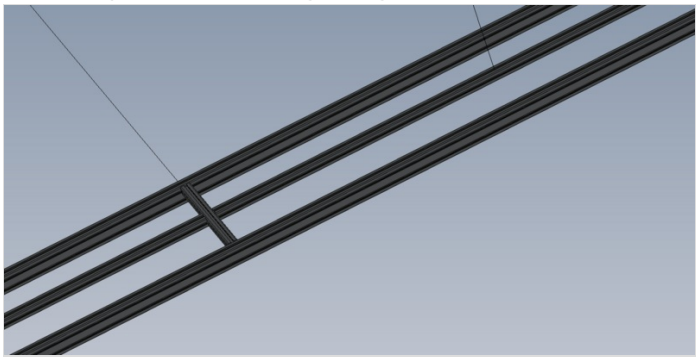
Ensure blower point is orientated correctly to suit belt rotation direction
Should be at bottom of frame on opposite side of drive motor



Step 10 - Attach adhesive tape

Fit supplied adhesive tape to top face of frame at shown points

Photos required in correct sequence please



Step 11 - Quality Check

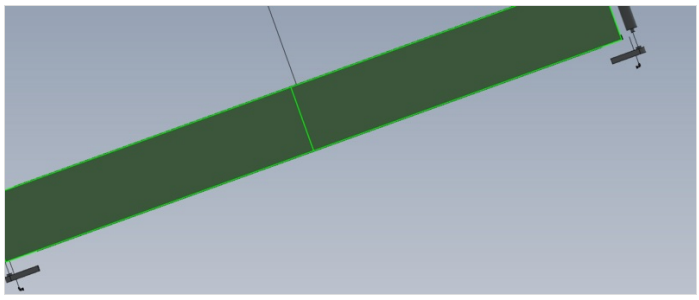
Check issued stainless plates 2 off have been countersunk correctly

M4 countersunk should sit flush, not above top of stainless sheet

Step 12 - Fit stainless top plates

Use stainless plates as a guide to align M4 plate nuts before removing adhesive tape backing

> ...Ensure stainless plates are aligned correctly. They should be parallel to maytec main frame



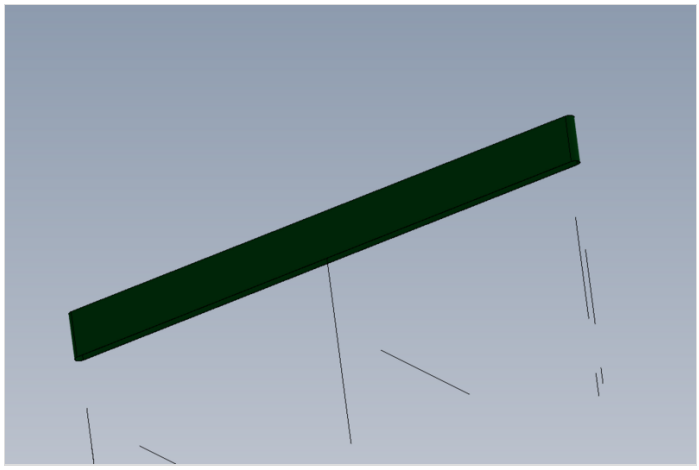
Once aligned , remove adhesive tape backing and secure stainless plates into position

Fit 8 off supplied m4 countersunk hex sockets to finalise stainless plate fitting

Step 13 - Fit belt

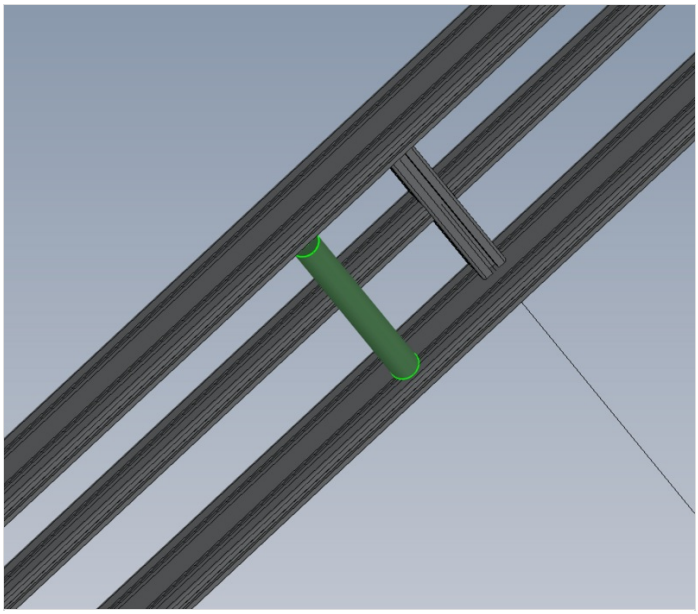
Fit belt to assembly

Photos required in correct sequence please



Step 14 - Fit mid rollers

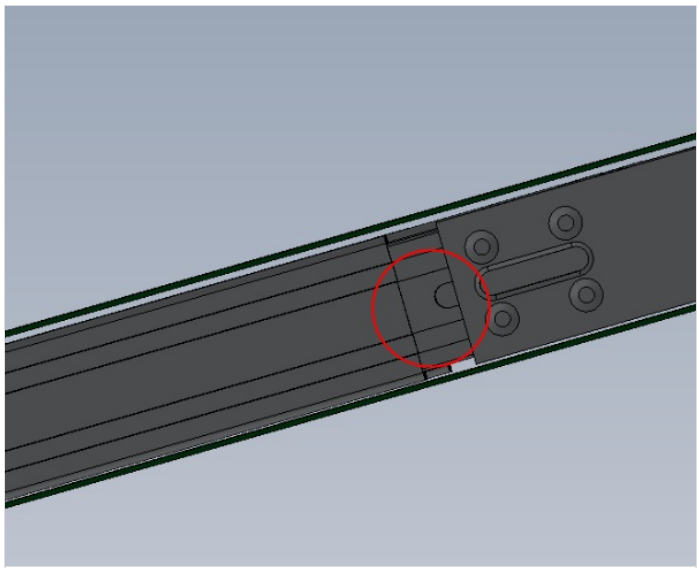
Fit mid rollers



Step 15 - Tension drive roller

Set lower roller tension (motor end)

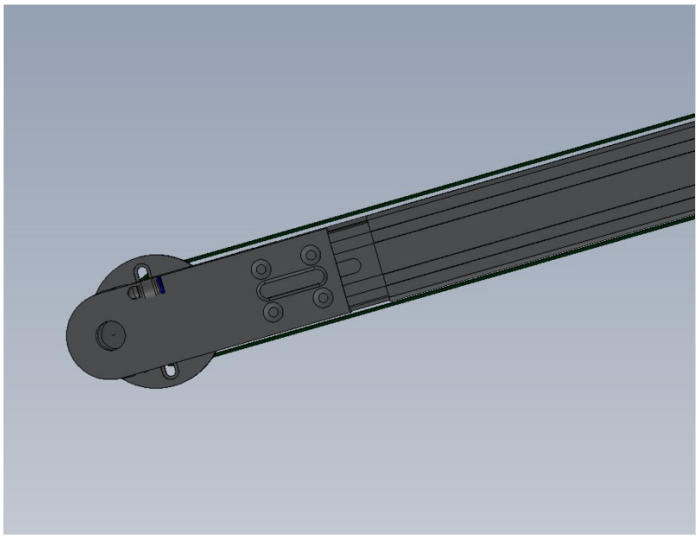
Measure and set gap to 15mm either side

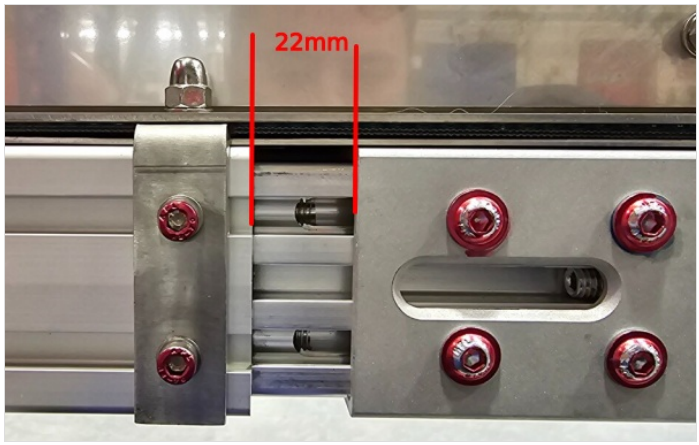


Step 16 - Tension slave roller

Tension drive roller to 22mm gap at both sides of roller

Ensure both sides are set to the same measurement





Step 17 - Check all fasteners

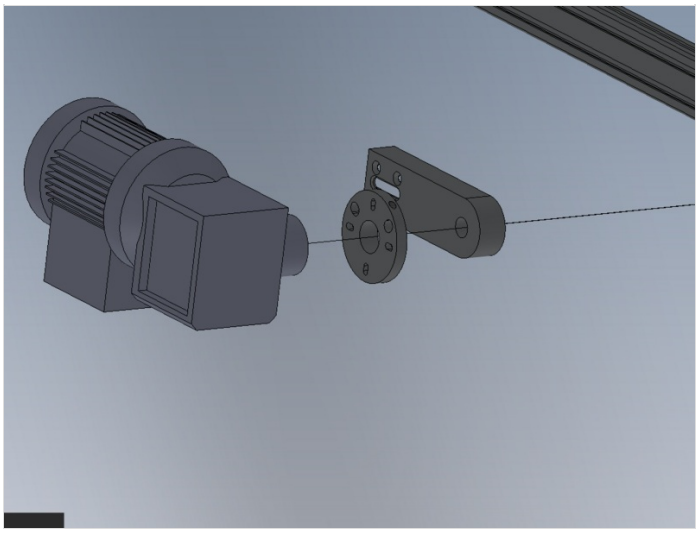
Quality check all fasteners

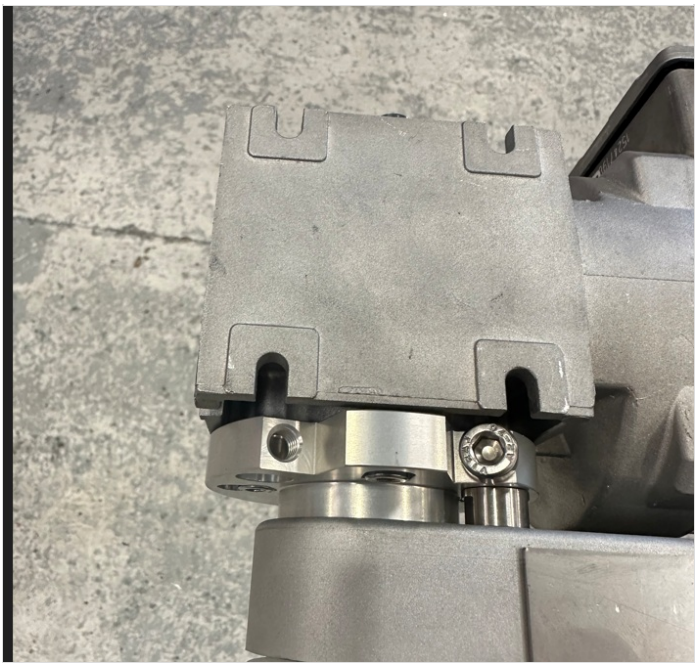
ensure all fasteners have adhesive applied, are correctly tensioned and are pen marked to indicate finalised

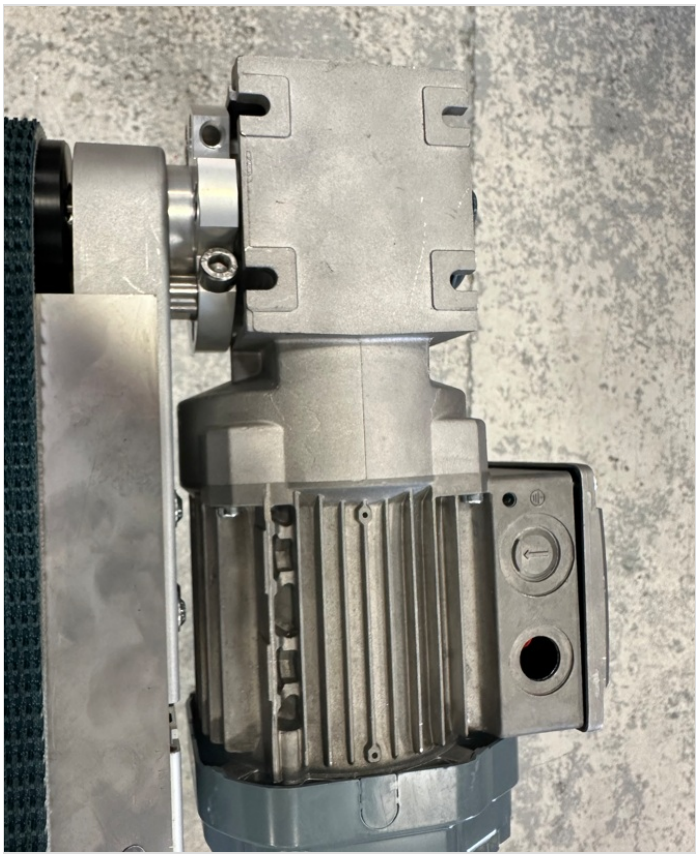
Step 18 - Fit drive motor and flange

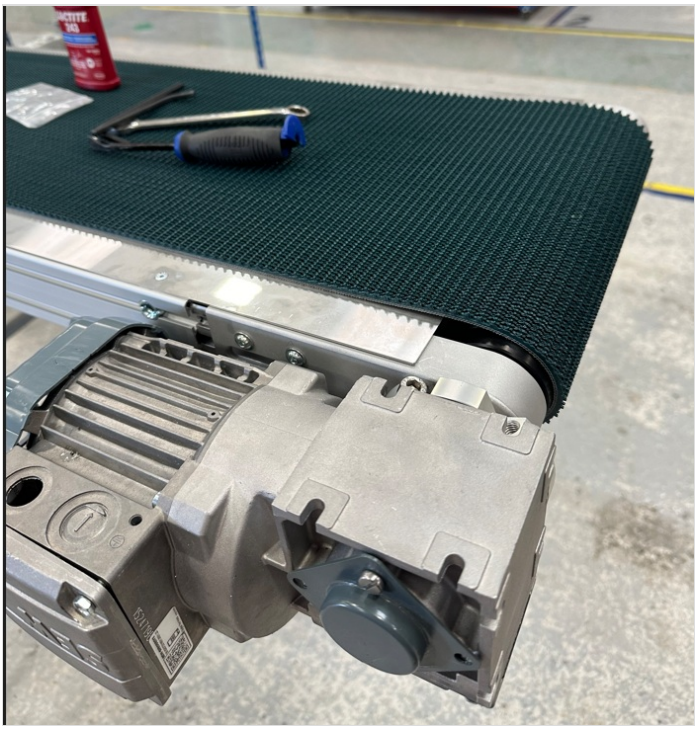
Fit drive flange to bearing cheek ensuring correct orientation to allow correct fitment of motor

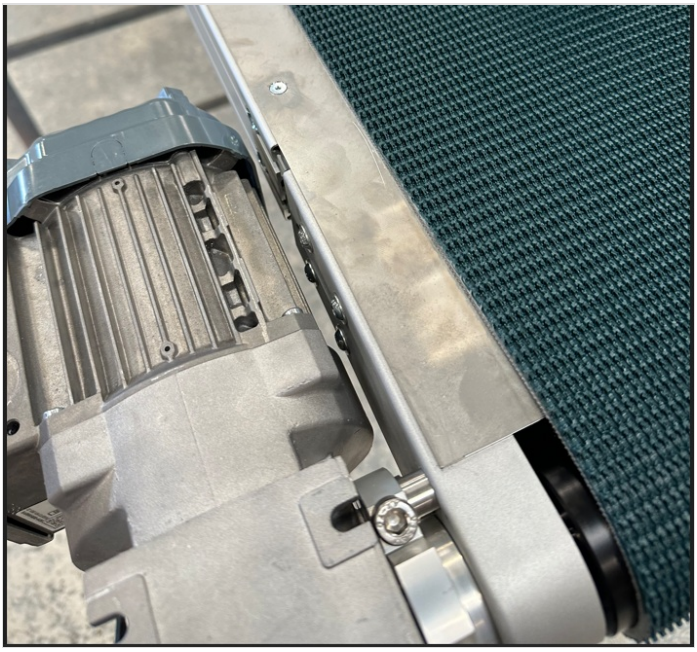
Fit motor to bearing flange, do not apply final tension or adhesive to locating grubscrew as motor will need to be removed later on
It is important to test fit at this stage to identify correct fitment











Step 19 - Fit blower fittings

Fit 3 off blower fittings to mounting points on bearing cheeks