

Globaltek[®] Equipment

Inline Conveyors

User's Manual

WARNING:

Read this User's Manual in its entirety before setting up or operating the conveyor.

This manual covers the operation and maintenance of the following models of Globaltek's Inline Conveyors.

4.5 Inch Wide Conveyors: CON-0445PEZ, CON-0645PEZ, CON-845PEZ, CON-1045PEZ, CON-1245PEZ, CON-1645PEZ, CON-2045PEZ

7.5 Inch Wide Conveyors: CON-0475PEZ, CON-0675PEZ, CON-875PEZ, CON-1075PEZ, CON-1275 PEZ, CON-1675PEZ, CON-2075PEZ

12 Inch Wide Conveyors: CON-0412PEZ, CON-0612PEZ, CON-0812PEZ, CON-1012PEZ, CON-1212PEZ

Video Tutorials

Learn all about your new conveyor by watching our on-line video tutorials. Our video tutorials show you everything from unpacking your conveyor, operating your conveyor, and adding accessories to your conveyor.

Scan the QR code to view the video tutorials.

QR Code



Globaltek® Equipment

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CAUTION: Read this manual in its entirety before attempting to set up or operate the conveyor. Failure to do so could cause bodily harm and/or damage to the conveyor.

While reading this User's Manual, you will sometimes see call out boxes or headings with the term Note, Caution, Warning, and Danger.

Notes, Cautions, Warnings, and Dangers notify the reader that incorrectly following instructions could damage the conveyor or could cause bodily injury.

Preface:

This manual introduces you to the Globaltek® Equipment's Inline Conveyors. The manual will orient you to the many features and procedures that enable you to set up and operate the inline conveyors.



CAUTION: If the conveyor is used in a manner not specified by the manufacturer, the protection provided by the equipment may be impaired.

Globaltek® Equipment on the Internet

For further information on documentation and support for your conveyor or for information on other Globaltek® Equipment products, please visit our web site:

<https://www.globaltekequipment.com/>.

Table of Contents

Preface	2
Table of Contents	3
About Globaltek® Equipment.....	4
Safety Information	
Safety Symbols	5
Globaltek® Equipment Safety Labels	6
Electrical Safety	8
Operational Safety.....	9
Lockout/Tagout Procedures	11
Lifting Points of the Inline Conveyor	11
Specifications	12
Electrical Requirements	12
Parts of the Inline Conveyor	13
The Motor Control Box.....	13
On/Off Switch	14
On/Off Indication Light.....	15
The Speed Pot	15
The AC Power Cord.....	15
Connecting the Power Cord to an Electrical Outlet	16
Grounding Instructions.....	16
The Fuse Holder	16
Replacing the Fuse	17
The Motor	18
The Feet	18
Installing the Feet on the Legs of the Conveyor	19
Raising and Lowering the Conveyor	20
Levelling the Conveyor	21
The Legs	22
Attaching the Legs to the Conveyor	18
The Mounting Slots	23
The Guide Rail Mounting Brackets	24
Mounting a Guide Rail Mounting Bracket	24
Inserting a Guide Rail into a Guiderail Mounting Bracket	25
Adjusting the Height of the Guide Rails.....	26
Adjusting the Width of the Guide Rails	26
Connecting Guide Rails (2 Piece Guide Rail Clamps)	27
Cutting Guide Rails	27
The Belt	28
The Belt Pin and the Belt Links	28
Attaching the Belt / Adding Links to the Belt.....	29

Removing the Belt / Removing Links from the Belt	30
Unpacking the Conveyor	31
Basic Assembly (conveyors 10 feet in length and less)	35
Basic Assembly (conveyors 11 feet in length and longer)	39
Operating Instructions (Getting Started)	48
Installing & Integrating Machinery Along a Conveyor	46
Conveyor to Conveyor End Transfers	51
Conveyor to Conveyor End Transfers (Standard Type)	51
Conveyor to Conveyor End Transfers (Roller Type)	55
Conveyor to Conveyor Side Transfers	61
Conveyor to Conveyor Side Transfers (Standard Type)	61
Conveyor to Conveyor Side Transfers (Adjustable Gate System)	70
Troubleshooting	81
Maintenance Guidelines	82
Contact Technical Support	83
Warranty	83

About Globaltek® Equipment

Established in 2006, Globaltek® Equipment is a family owned and operated business. Our cutting edge manufacturing facility and headquarters are located in Miami, Florida. We manufacturer packaging conveying systems comprising inline conveyors, transporting and transfer systems, and accumulating tables.

All of our packaging systems are constructed of UL Certified and Made in the USA components. Our conveyors feature 304 stainless steel construction, as well as a made in USA Bodine motor with variable speed controller.

Safety Information:

Safety Symbols:

The purpose of safety symbols is to attract your attention to possible dangers. The safety symbols, and the explanations with them, deserve your careful attention and understanding. The symbols do not by themselves eliminate any danger. The instructions and warnings they give are not substitutes for proper accident prevention measures.



DANGER: Failure to obey this safety warning **WILL** result in death or serious injury to yourself or others.



WARNING: Failure to obey this safety warning **CAN** result in death or serious injury to yourself or others.









CAUTION: Failure to obey this safety warning **MAY** result in personal injury to yourself or others or result in damage to the conveyor.




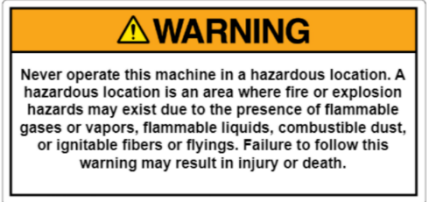


NOTE: Damage to the conveyor may result if these instructions are not followed.

Globaltek® Equipment Safety Labels:

The safety label is located on the motor side of the conveyor. It is important to be aware of the meaning of these labels to ensure safe operation of the conveyor.


Description	Label
<p>WARNING: Read and understand all of the safety label descriptions in the table below before operating the conveyor.</p> <p>Wear Eye/Ear Protection: A reminder that that the conveying process may be harmful to the eyes and ears. Always wear eye protection when operating or when performing maintenance on the conveyor. Proper ear protection is suggested when operating the equipment. Located on the motor side of the conveyor.</p>	 
<p>Machine lockout: A reminder to turn off and lock out the electrical supply before servicing any components. Located on the motor side of the conveyor.</p>	
<p>General Warning: This area can only be accessed by a trained service technician. Located on the motor side of the conveyor.</p>	
<p>Crush Hazard: Keep hands clear while operating. A reminder that various manufacturing processes can present a crush hazard if hands or objects are near the belt of the conveyor. Located on the motor side of the conveyor.</p>	
<p>Risk of Electrical Shock: A reminder to unplug the conveyor from the electrical outlet before cleaning or servicing. Located on the motor side of the conveyor.</p>	

<p>Pinch Hazard: Keep hands clear while operating. A reminder that the movement of the belt of the conveyor can be a pinch hazard if hands or objects are placed in these locations. Located on the motor side of the conveyor.</p>	
<p>Shear Hazard: Keep hands clear while operating. A reminder that movement of the belt of the conveyor can be a shear hazard if hands or objects are placed in this location. Located on the motor side of the conveyor.</p>	
<p>Entanglement Hazard: Keep hands clear while operating. A reminder that movement of the belt of the conveyor could result in entanglement should hands or objects be placed in this location. Located on the motor side of the conveyor.</p>	
<p>Risk of Fire or Explosion: A warning to never operate this machine in a hazardous location. A hazardous location is an area where fire or explosion hazards may exist due to the presence of flammable gases or vapors, flammable liquids, combustible dust, or ignitable fibers or flyings. Failure to follow this warning may result in injury or death. Located on the motor side of the conveyor.</p>	

Electrical Safety

Hazardous Locations (Explosive Atmospheres):

Never operate this machine in a hazardous location. A hazardous location is an area where fire or explosion hazards may exist due to the presence of flammable gases, vapors, or liquids, or combustible dust, or ignitable fibers or flyings. Failure to follow this warning may result in injury or death.

	<p>WARNING: Never operate this machine in a hazardous location. A hazardous location is an area where fire or explosion hazards may exist due to the presence of flammable gases, vapors, or liquids, or combustible dust, or ignitable fibers or flyings. Failure to follow this warning may result in injury or death.</p>
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Electrical Requirements:

The input voltage to the speed controller on the conveyor is 115 VAC \pm 10%, 50/60 Hz. single phase electricity with a maximum continuous input current of 5.7 amps.

	AC Voltage	Phase	Current
USA	115V	Single Phase Grounded	15A Service 5.7A
Canada	115V	Single Phase Grounded	15A Service 5.7A


Main Disconnect:

The main disconnect is accomplished by disconnecting the AC power cord at the electrical outlet. Ensure that the power cord and electrical outlet are easily accessible.

	<p>WARNING: The main disconnect is accomplished by disconnecting the AC power cord at the electrical outlet. Ensure that the power cord and electrical outlet are easily accessible.</p>
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Grounding Instructions:

The conveyor must be plugged into a properly installed outlet and grounded in accordance with all codes and ordinances. Never modify the plug in any way. Check with a qualified electrician if you think the outlet may not be properly grounded.

	<p>WARNING: The conveyor must be plugged into a properly installed outlet and grounded in accordance with all codes and ordinances. Never modify the plug in any way. Check with a qualified electrician if you think the outlet may not be properly grounded.</p>
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Operational Safety:



DANGER:

- Do not use the conveyor in the presence of flammable liquids, gases or vapors, combustible dust, or ignitable fibers or filings.
- This product is not designed for, nor intended for use in hazardous areas as defined by ATEX or the NEC (National Electric Code).



WARNING:

- Do not move the conveyor without additional personnel or mechanical assistance.
- Never operate this machine without all safety guards and covers in their proper positions.
- All service must be performed by qualified original manufacturer's service personnel.
- Disconnect and lockout all electrical power and air sources prior to any service or maintenance work.
- Keep hands and foreign objects away from all moving parts and pinch points.
- Keep hands clear of all moving parts, in particular belts, chains, sprockets, and pulleys. Failure to do so could cause injury.
- Always wear OSHA approved eye/ear protection when operating this machine.
- Do not make any changes or modifications to this machine.
- This machine may start automatically or remotely at any time.
- Never stand or climb on the conveyor - use only an OSHA approved stepladder.
- Machine design including controls and logic should not be changed or modified since it may result in injury or damage to the conveyor.
- Do not operate the conveyor if the power cord is cracked or broken.

- If the conveyor shows signs of malfunction, turn off the electric power and unplug the power cord.
- Do not operate the conveyor if there is obvious damage to the conveyor.
- Dry location use only. Do not expose the conveyor to rain, water, wet, or damp conditions or locations.
- Do not abuse the power cord. Never pull on the cord to disconnect from the electrical outlet. Keep cord away from heat, oil, and sharp edges.
- Be sure the power switch is in “off” position when plugging in the conveyor.
- If fluid splashes on the conveyor, unplug the conveyor immediately. Wipe the conveyor with an absorbent cloth to prevent damage. The conveyor must remain unplugged until it has been thoroughly dried.
- A reminder to turn off the electric power and unplug the power cord before cleaning or servicing, or when the conveyor is not in use.
- Do not block the face panel of the speed control box. The power switch must always be easy to access. The power cord must always be easy to disconnect from the electrical outlet.
- When conveying hazardous chemicals and/or biological agents, take all suitable protective measures, such as wearing protective glasses and gloves resistant to the substances used. Follow local and/or national regulations for safe operation and maintenance of the system.
- Do not wear loose or baggy clothing when you operate the conveyor. Remove anything that may cause injury, i.e. neck ties, jewelry, etc. Tie back long hair.



CAUTION:

- This product is not intended for use in washdown environments.

Lockout/Tagout Procedures:

The following guidelines are provided to establish a minimum requirement for the lockout of energy isolating devices whenever maintenance or service is performed on equipment and associated parts. It is further advised that an independent safety study be performed on the machinery, its installation, and the Lockout/Tagout procedures.

1. Follow the safety procedures specified in the safety section of this manual, as well as the safety procedures specified throughout this manual.
2. Stop the equipment using the normal procedure of turning the On/Off switch to the Off position as explained on page 14 of this manual.
3. The equipment can be isolated from its electrical energy source by unplugging the main AC power cord from the electrical outlet and then enclosing the male plug of the AC power cord into an electrical plug cover (not included) such as the example shown in the picture to the right. Once the male end of the plug cover is enclosed, a padlock (not included) can be utilized to lock the male plug into the plug cover, preventing its use.



Lifting Points on the Inline Conveyor

When lifting and carrying, it is recommended that at least two people carry the inline conveyor. Before lifting, ensure that the AC power cord of the conveyor is unplugged, and the cord is organized in such a way as to not to become damaged during the



movement of the conveyor. Ensure all parts of the conveyor are tightly fastened to ensure that these parts will not move when the conveyor is lifted. Both carriers should stand on opposite ends of the conveyor, placing their hands at the bottom corners of the conveyor as is shown in the image to the right.

Specifications:

Available Widths	4.5 inches / 7.5 inches / 12 inches
Available Lengths	4 feet / 6 feet / 8 feet / 10 feet / 12 feet / 16 feet / 20 feet
Horse Power	3/8 HP
Speed	Up to 200 feet/minute
Max Weight Capacity	150 pounds per linear foot
Belt Material	Acetal (Delrin) tabletop plastic chain belt
Floor to Belt Height	Adjustable from 35 – 40 inches
Guide Rail Width	Adjustable from 0 to 1 inch wider than the width of the belt
Guide Rail Height	Adjustable from 0.5 - 4 inches above the belt
Electrical Requirements	115VAC ± 10%, 50/60 HZ, 5.7 Amp. Single Phase Electricity

Electrical Requirements

Input Voltage and Current (from electrical outlet to the motor controller):

Input Voltage: 115 VAC ± 10%, 50/60 Hz. single phase.

Maximum Input Current (Continuous): 5.7 amps.

Input Voltage & Current	AC Voltage	Phase	Current
USA	115V	Single Phase Grounded	15A Service 5.7A
Canada	115V	Single Phase Grounded	15A Service 5.7A

Output Voltage and Current (from the motor controller to the motor):

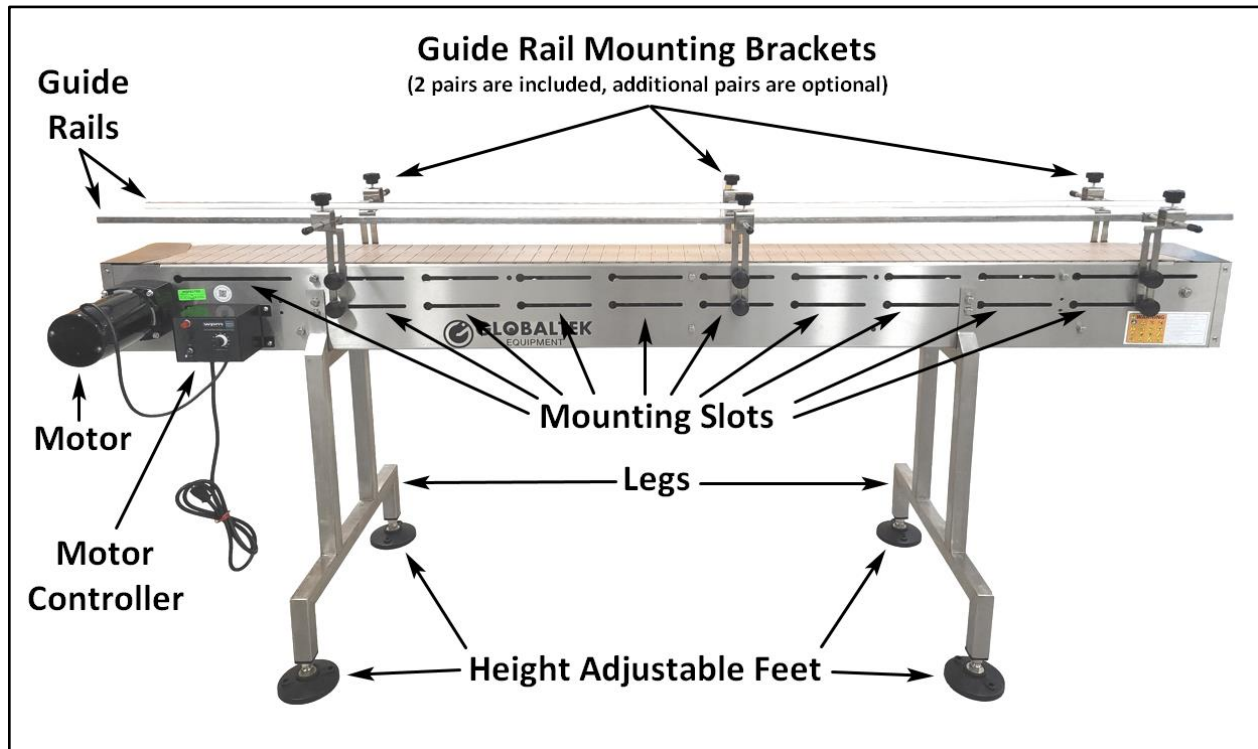
Output Voltage (from control box to the motor): 0 – 130 VDC.

Maximum Output Current (continuous): 3.2 amps DC.

Maximum Output Current (peak): 5.0 amps DC.

The Parts of the Inline Conveyor

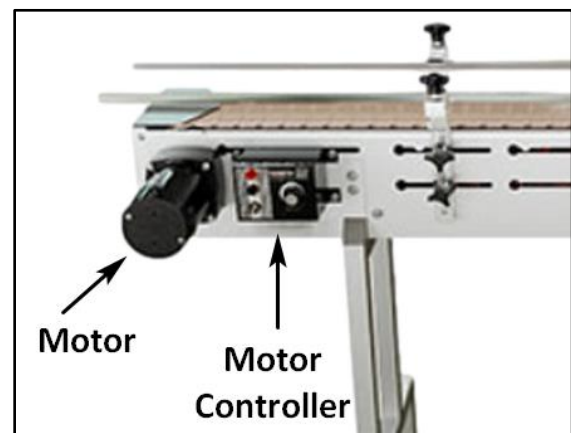
The inline conveyor is shown below. The guide rails, guide rail mounting brackets, mounting slots, legs, height adjustable feet, motor controller and the motor are indicated.



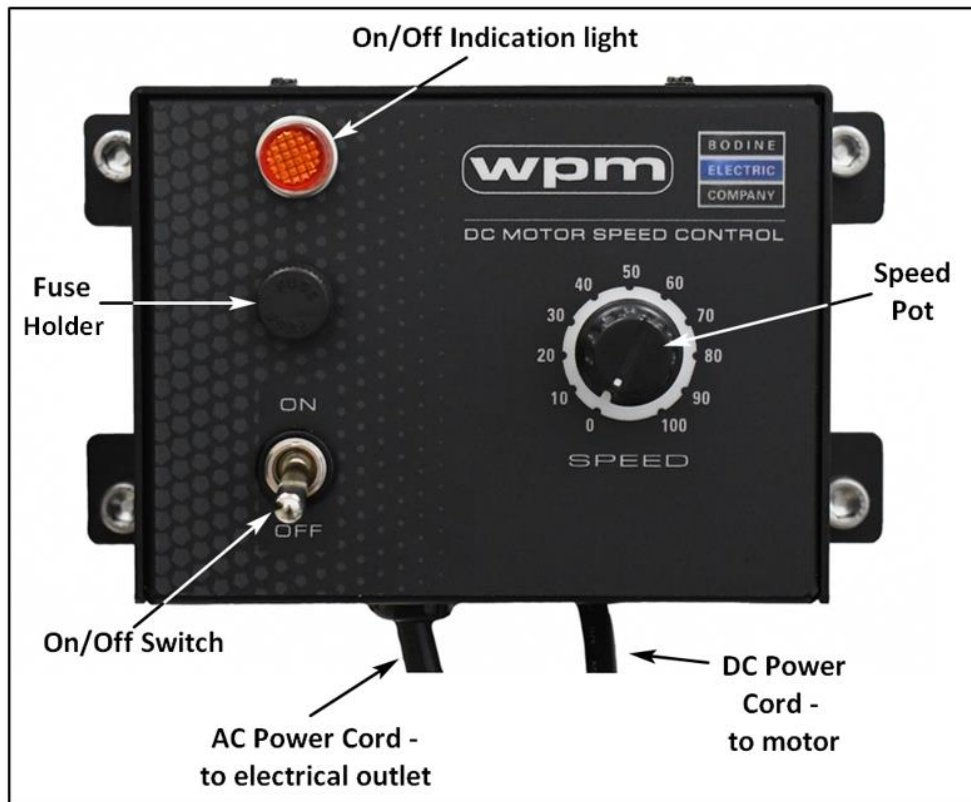
The Motor Control Box

The motor control box is located on the side of the conveyor next to the motor and is shown in the picture to the right.

The motor control box is manufactured by the Bodine Electric Company. It is their Model 0791 Filtered PWM DC basic speed control. For more information, including a downloadable user manuals, as well as downloadable schematics and drawings, you can visit the following link to their web site: <https://www.bodine-electric.com/products/dc-controls/filtered-pwm-dc-basic-speed-control/0791/>



A close up view of the motor control box is shown below, the On/Off indication light, speed pot, DC power cord, AC power cord, On/Off switch and the fuse holder are indicated.



On/Off Switch

The On/Off switch is located at the bottom left corner of the control box and is shown in the image to the right.

- To turn the power to the control box on, pivot the toggle switch to the “ON” position.
- To turn the power to the control box off, pivot the toggle switch to the “OFF” position.

Always confirm that the On/Off switch is in the off position before plugging the AC power cord into an electrical outlet.



NOTE: Confirm that the On/Off switch is in “Off” position before plugging the power cord into an electrical outlet. Failure to do so could cause injury or damage to conveyor.

On/Off Indication Light

The on/off indication light provides a visual signal that the control box is on. When the On/Off switch is turned to the on position, the On/Off indication light will illuminate.



The Speed Pot (Speed Control)

The speed pot, or speed control dial, is located on the right side of the control box and is shown in the picture to the right.

There are numbers indicated around the knob from 0 – 100 in increments of 10. These numbers can be viewed as percentages. Setting the dial at the number ten would move the conveyor at 10 percent of its potential speed. The higher the number, the faster the conveyor will go.




AC Power Cord

The inline conveyor is equipped with a 6 foot AC power cord that has a 3-prong plug with ground pin. The AC power cord is securely fastened to the bottom of the control box and cannot be removed.




Connecting the Power Cord to an Electrical Outlet:

The power cord is the mains disconnect for the inline conveyor. The power cord must be connected to an electrical outlet that provides 115 VAC \pm 10%, 50/60 Hz. single phase electricity. Make sure that the outlet is overload protected and of sufficient amperage capacity (5.7 amps). If there is any doubt that the outlet box complies with this specification, have a qualified electrician inspect the outlet box.

	<p>CAUTION: The power cord must be connected to an electrical outlet that provides 115 VAC \pm 10%, 50/60 Hz. single phase electricity. Make sure that the outlet is overload protected and of sufficient amperage capacity (5.7 amps). If there is any doubt that the outlet box complies with this specification, have a qualified electrician inspect the outlet box.</p>
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Grounding Instructions

The AC power cord must be plugged into a properly installed AC electrical outlet that is grounded in accordance with all codes and ordinances. Never modify the plug in any way. Check with a qualified electrician if you think the outlet may not be properly grounded.

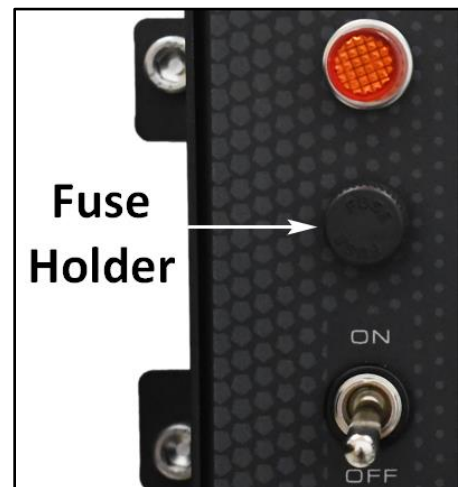
	<p>CAUTION: The AC power cord must be plugged into a properly installed AC electrical outlet that is grounded in accordance with all codes and ordinances. Never modify the plug in any way. Check with a qualified electrician if you think the outlet may not be properly grounded.</p>
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Fuse Holder:

The fuse holder is located on the face of the control box and is shown in the picture to the right. The fuse holder contains the fuse.

The fuse is an 8 amp, 250 VAC, fast acting fuse.

The fuse protects the conveyor from excessive electrical current. The fuse will blow when the conveyor is supplied with too much voltage by mistake, or from a power surge. The fuse will also blow if there is a short created in the circuits of the conveyor. The blown fuse will terminate the power supply to the conveyor.



 	<p>NOTE: For continued protection against risk of fire, replace the fuse with the same type of fuse having the same electrical rating, 8A, 250VAC.</p>
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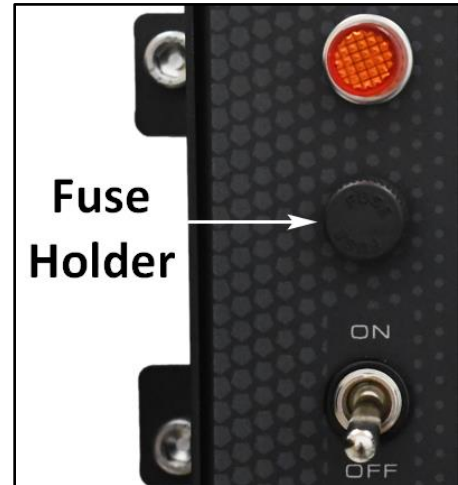
Replacing the Fuse



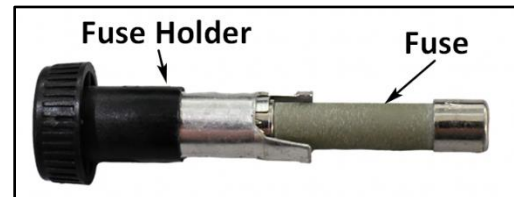
WARNING:

Be sure to unplug the AC power cord from the electrical outlet prior to replacing the fuse. Failure to do so could cause injury.

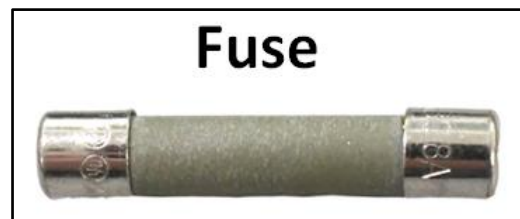
1. Turn the power to control box off following the instructions found on page 14 of this manual.
2. Unplug the AC power cord from the electrical outlet prior to replacing the fuse. Failure to do so could cause injury.
3. Remove the fuse holder from the control box by pushing the fuse holder in and then rotating the fuse holder counterclockwise until it releases.



4. Pull the fuse holder out of the control box. An image of the fuse holder with attached fuse is shown to the right.



5. Remove the blown fuse from the fuse holder and insert a new fuse into the fuse holder. It does not matter which end of the fuse is inserted into the fuse holder. Be sure to replace the fuse with the same type of fuse having the same electrical rating, 8A, 250VAC.



NOTE:

For continued protection against risk of fire, replace the fuses with the same type of fuses having the same electrical rating, 8A, 250VAC.

6. Gently slide the fuse holder with inserted fuse back into the control box. You may need to rotate it slightly in order to be able to insert it fully. Once the fuse holder is fully inserted into the control box, press it in and rotate it clockwise to lock it in place.

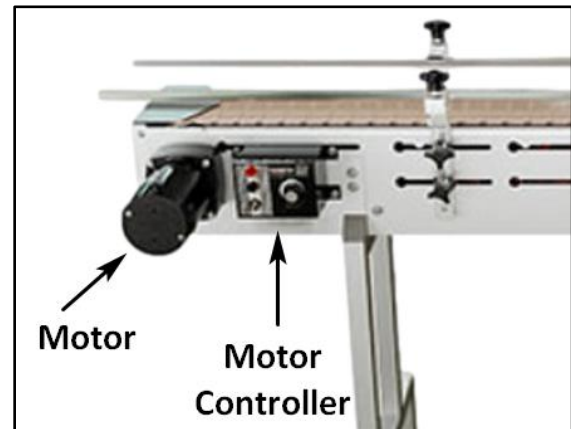
7. Plug the power cord back into the electrical outlet.
8. Turn the On/Off switch to the On position to test.

If the new fuse blows shortly after it has been installed, there is a problem with the electrical system of the conveyor, and it will need to be serviced. Do not attempt to repair the conveyor. Within the United States and Canada, call Globaltek® Equipment at (305) 418-9632 to arrange for repair service.

The Motor

The motor is located on the side of the conveyor next to the motor controller and is shown in the picture to the right.

The motor is manufactured by the Bodine Electric Company. It is their model 5044 42A5-FX parallel shaft DC gearmotor. For more information, including a downloadable wiring diagram, as well as downloadable schematics and drawings, you can visit the following link to their web site: <https://www.bodine-electric.com/products/dc-parallel-shaft-gearmotors/42a5-fx-parallel-shaft-dc-gearmotor/5044/>.

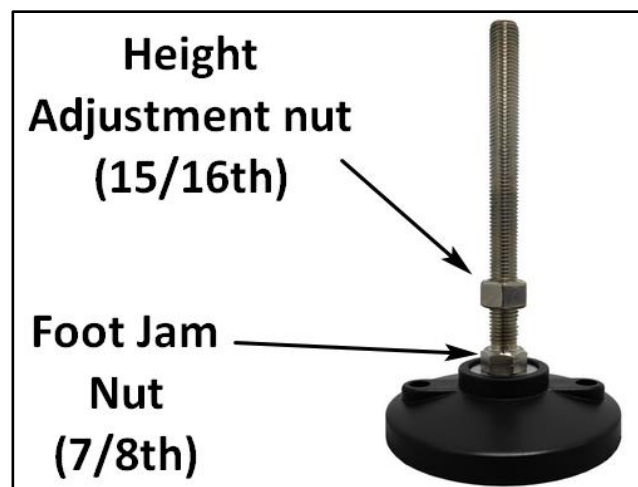


Height Adjustable Feet

An adjustable foot is shown to the right. The height adjustment nut and foot jam nut are indicated.

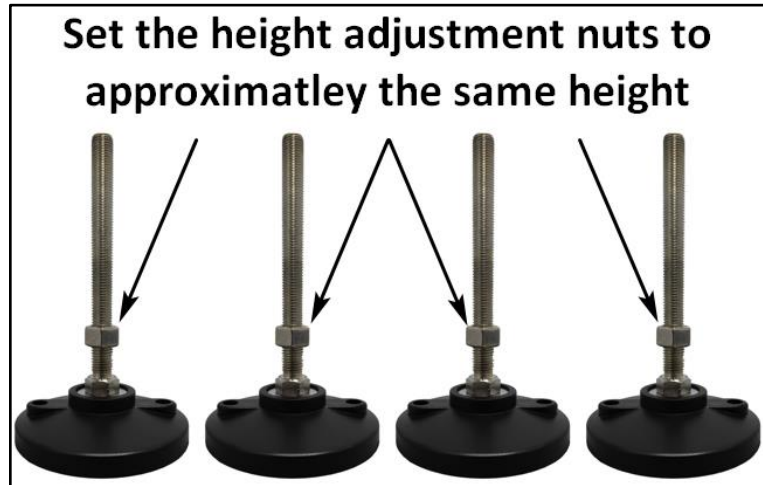
The height adjustment nut locks the foot in place once the desired height of the conveyor is determined.

The foot jam nut is locked to the round foot. Rotating the foot jam nut rotates the foot. The foot jam nut provides an easy means of rotating the foot when raising, lowering, or leveling the conveyor.



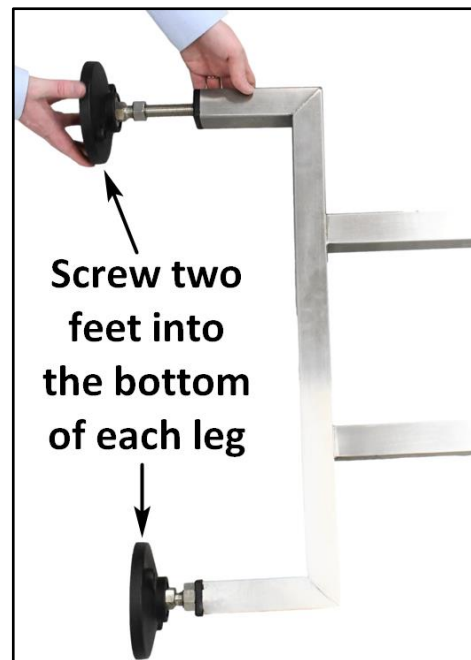
Installing the Feet onto the Legs of the Conveyor

Set the height adjustment nuts to approximately the same height on the threads of all four feet as is shown in the image to the right. Do not be concerned with determining the exact final height of the conveyor at this time. Adjustments can be made later to adjust the final height of the conveyor.



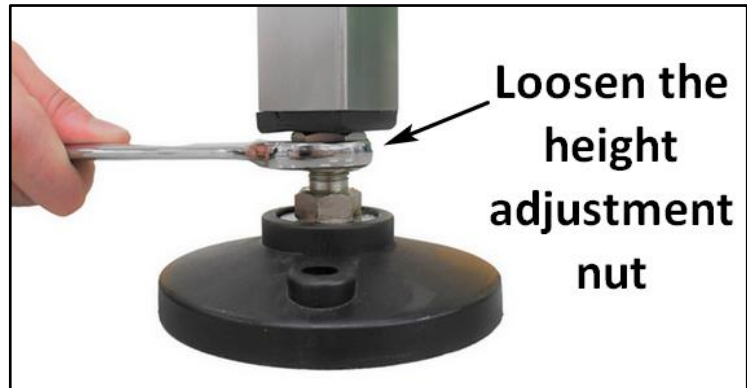
The adjustable feet are threaded into the legs of the conveyor by hand as shown in the picture to the right. The height of the conveyor is adjustable from 35 – 40 inches. The further you thread the feet into the conveyor legs, the lower the height of the conveyor will be.

Thread the adjustable foot into the leg until the height adjustable nut contacts the leg of the conveyor. Leave the nut only snug for now.

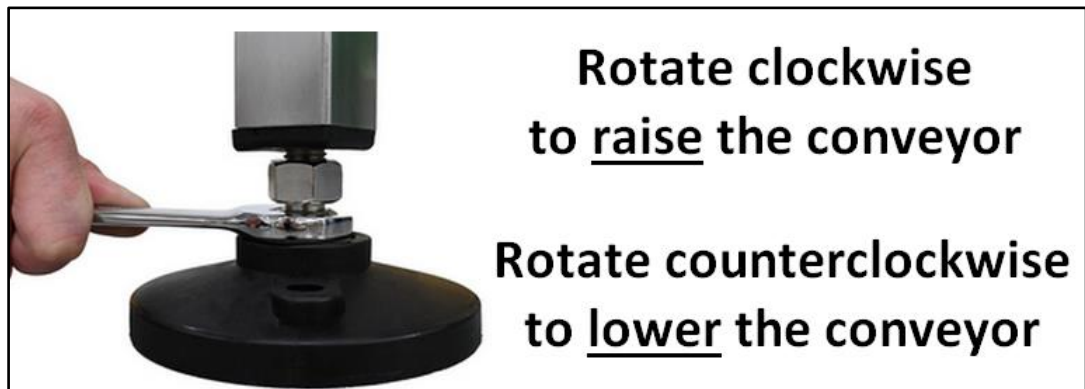


Raising and Lowering the Conveyor

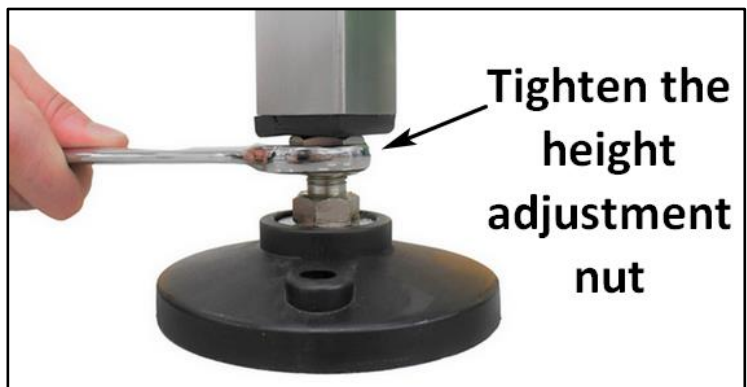
To raise, lower or level the conveyor, first loosen the height adjustment nut with a 15/16th wrench as is shown in the image to the right.



With the height adjustment nut loose, rotate the foot jam nut with a 7/8th wrench. To raise the conveyor, rotate the foot jam nut clockwise. To lower the conveyor, rotate the foot jam nut counterclockwise.



When the conveyor is at the desired height, tighten the height adjustment nut against the leg of the conveyor with a 15/16th wrench.

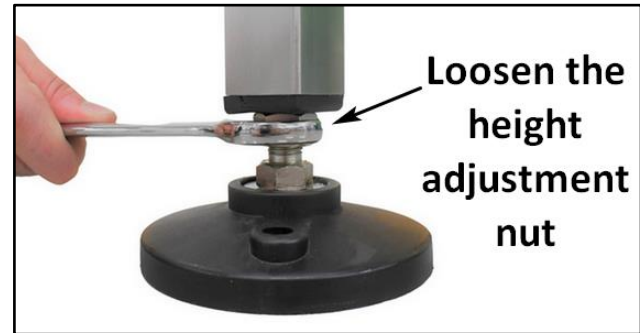


Leveling the Conveyor

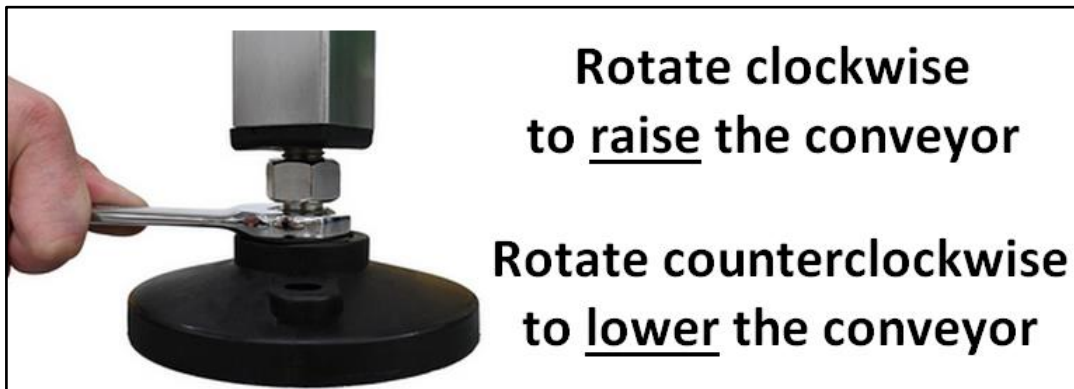
To level the conveyor, place a level along the belt of the conveyor as shown in the picture to the right.



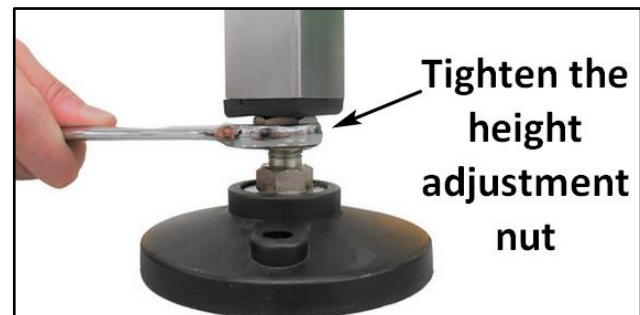
If adjustments are required, loosen the height adjustment nuts on the feet of the conveyor with a 15/16th wrench.



With the height adjustment nut loose, rotate the foot jam nut with a 7/8th wrench. To raise the conveyor, rotate the foot jam nut clockwise. To lower the conveyor, rotate the foot jam nut counterclockwise.



When the conveyor is level, tighten the height adjustment nut against the leg of the conveyor with a 15/16th wrench.



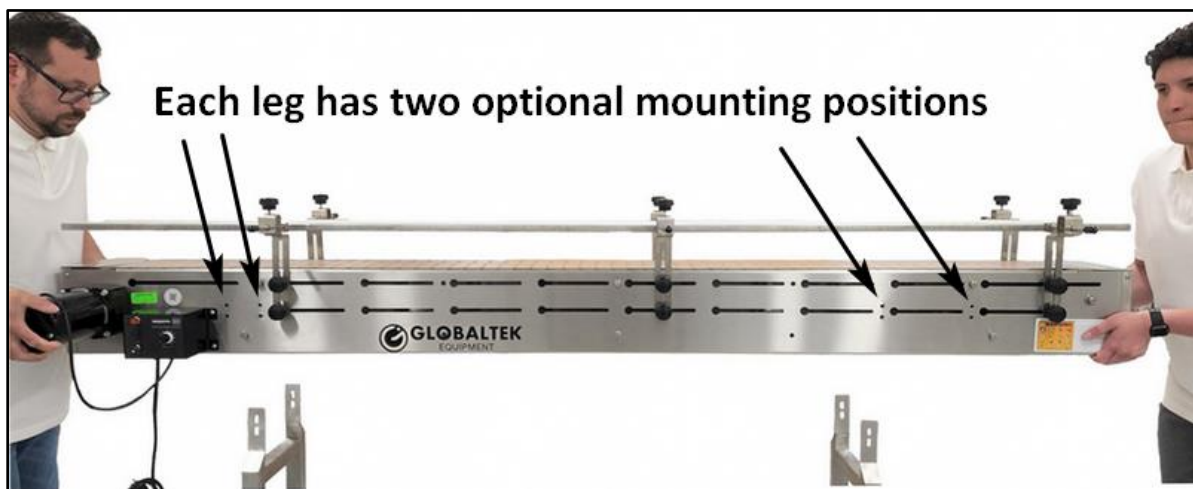
The Legs

Attaching the Legs to the Conveyor

1. Attach the feet to the legs of the conveyor as explained on page 19 of this manual.
2. With the feet mounted onto the legs, stand the legs on the floor next to the conveyor as shown in the image to the right.
3. Have at least 2 people lift the conveyor and place the conveyor onto the legs.



As is shown in the image below, each leg can be mounted into two optional positions, more toward the middle, or more towards the ends of the conveyor. Give thought to the final layout of the conveyor when choosing which set of mounting holes to use to fasten the legs to the conveyor. If you will be attaching an accumulation table at either end of the conveyor, you should choose the mounting holes toward the middle of the conveyor so that you will have more room at the ends of the conveyor. If you will be mounting accessories in the middle of the conveyor, choose the outer mounting holes to fasten the legs to the conveyor.



CAUTION:

Lifting the conveyor requires at least two people. Do not move or assemble the conveyor without additional personnel or mechanical assistance as this may cause injury or damage to the conveyor.

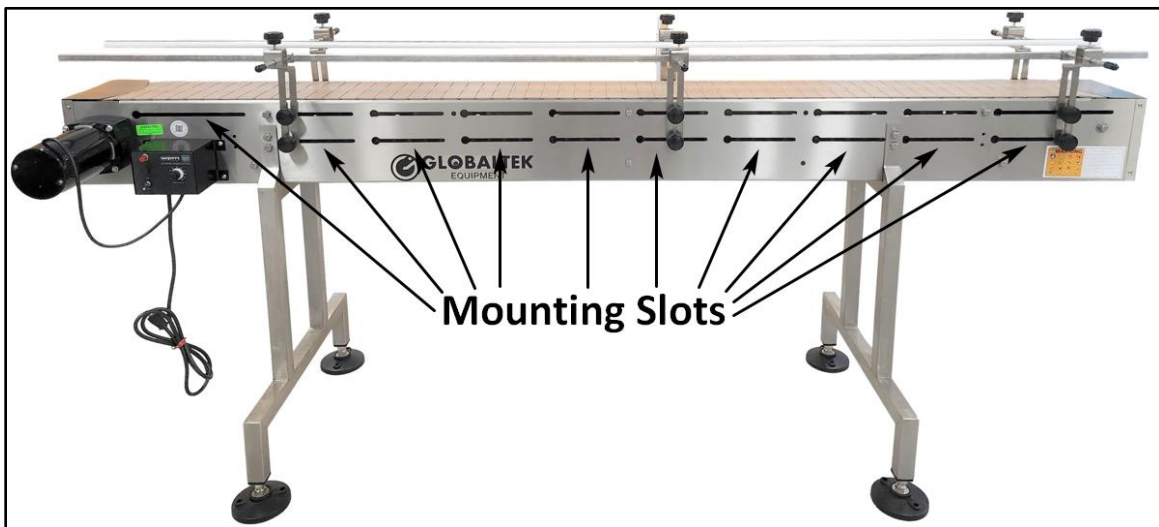
- Using the 8 screws and 8 lock washers included with the conveyor shown below, fasten the legs to the conveyor with a 9/16 wrench or socket as shown in the image to the right.



The Mounting Slots

The mounting slots are found on the two side panels of the conveyor and are indicated in the image below.

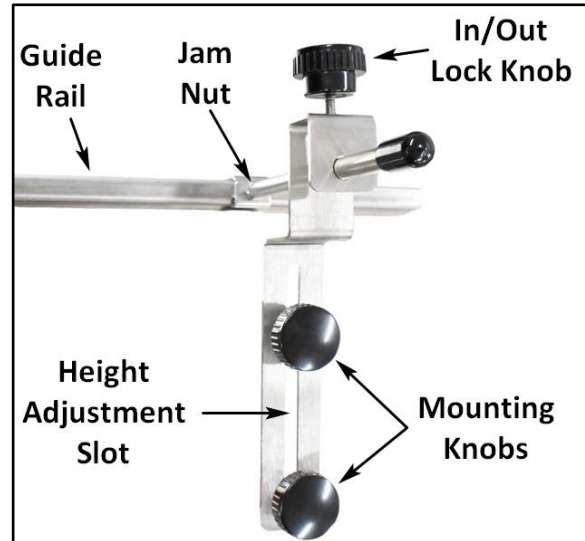
The mounting slots are arranged in pairs and provide multiple and adjustable mounting positions for guide rail brackets, and other conveyor accessories.



The Guide Rail Mounting Brackets

The inline conveyor comes with 4 guide rail mounting brackets. Extra pairs can be purchased as an option.

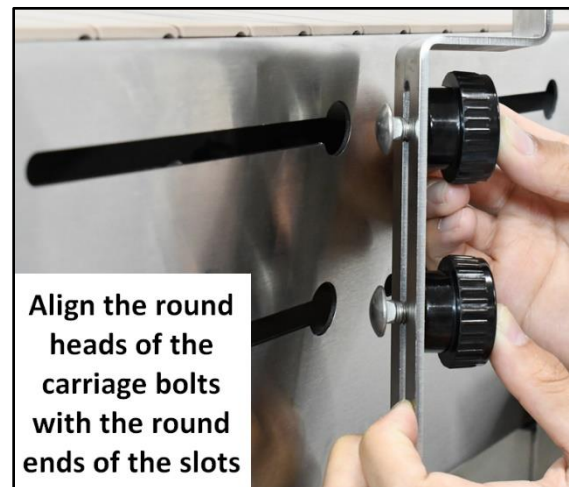
The guide rail mounting brackets mount the guide rails to the conveyor and allow the guide rails to move in and out or up and down to accommodate objects of different heights or widths.



Mounting a Guide Rail Bracket

Choose the location along the conveyor at which you would like to install the guide rail mounting bracket.

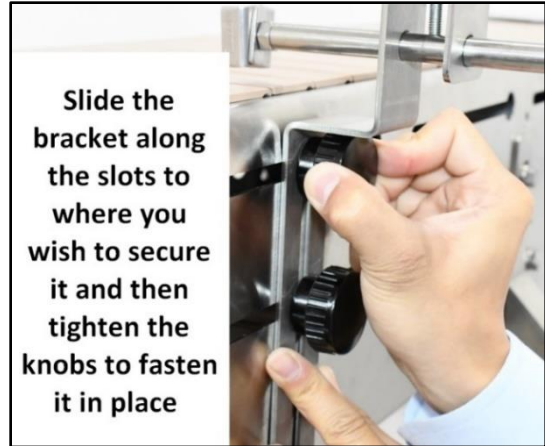
Align the round heads of the carriage bolts with the round opening at the ends of the two mounting slots as shown in the picture to the right.



Insert the round heads of the carriage bolts through the round openings at the end of the slots as is shown in the picture to the right.

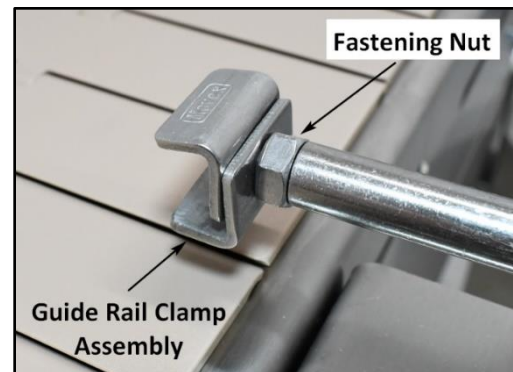


Slide the bracket along the slots to where you wish to secure it. When it is in place, tighten the mounting knobs to fasten the bracket in place.



Inserting a Guide Rail into a Guide Rail Bracket

The guide rail clamp assembly is shown in the picture to the right. The clamp and the fastening nut are indicated.



To insert a guide rail into the clamp, slide the bracket from either end through the clamp as shown in the picture to the right. When the bracket is at the desired position, rotate the fastening nut clockwise to lock the guide rail in place.



When the guide rail is in the desired position, tighten the nut with a 13mm wrench to fasten in place.

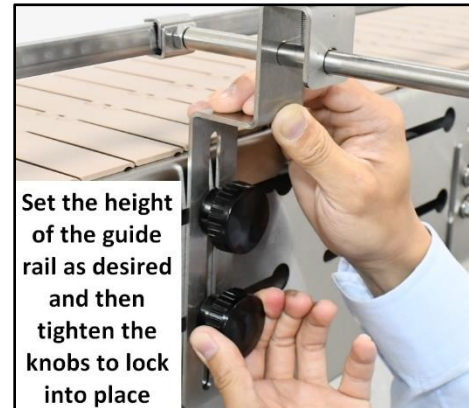
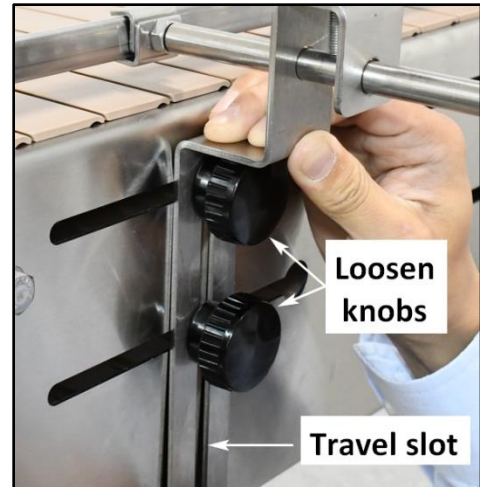


Adjusting the Height of the Guide Rails

There is a travel slot machined into the guide rail bracket which is indicated in the image to the right. The travel slot allows you to adjust the height of the guide rail from 0.5 inches above to belt to 5 inches above the belt.

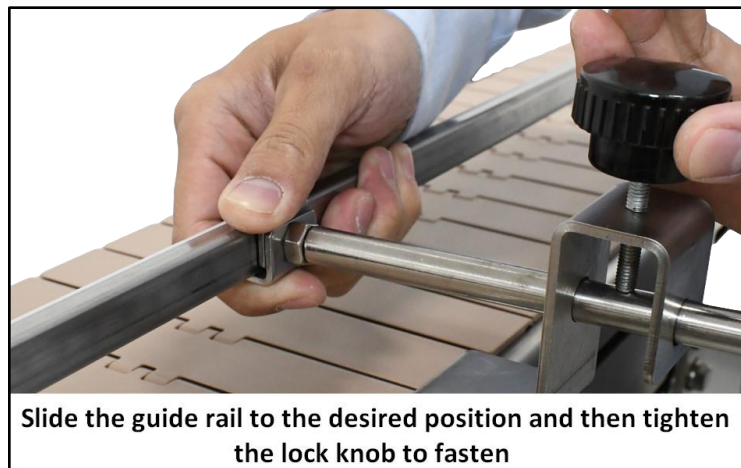
To adjust the height of the guide rails, loosen the two mounting knobs that fasten the guide rail bracket to the conveyor.

Raise or lower the guide rail to the desired height and then tighten the lock knobs to lock the height of the guide rail into place.



Adjusting the Width of the Guide Rails

To move the guide rail in or out, loosen the In/Out lock knob as shown in the image below and to the left. With the knob loose, the guide rail is free to slide in or out. Slide the guide rail to the desired position and then tighten the lock knob to fasten into place.



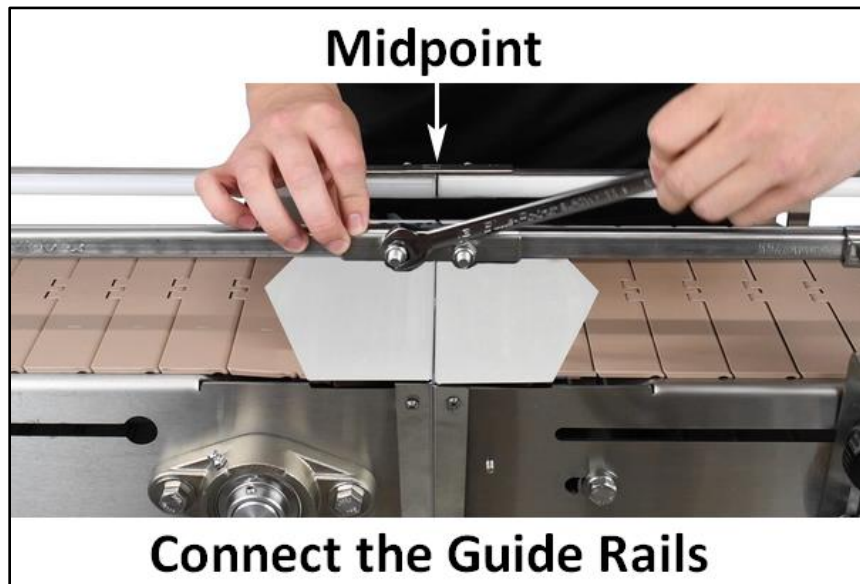
Connecting Guide Rails

Two piece guiderail clamps are used to connect separate lengths of guiderails. A two piece guiderail clamp is shown to the right.



To connect lengths of guide rails, first loosen, but do not remove the two nuts on each guide rail clamp with a 13mm wrench or socket. This allows the guiderail clamp to slide freely along the guiderails.

Align the guiderails you are going to connect and then slide the guiderail clamp so that the midpoint of the clamp is aligned at the point where the two guide rails come together as is shown in the picture below.



Once the clamps are in place, tighten the two nuts on each guiderail clamp with a 13mm wrench or socket to lock the guiderails together as shown in the picture to the right.

Cutting Guide Rails

Depending on how you will be setting up your conveyor, and the machinery you will be installing along the conveyor, it is frequently necessary to cut guide rails. The guide rails are constructed of stainless steel and UHMW plastic. A hacksaw designed to cut metal is a good choice to cut guide rails.

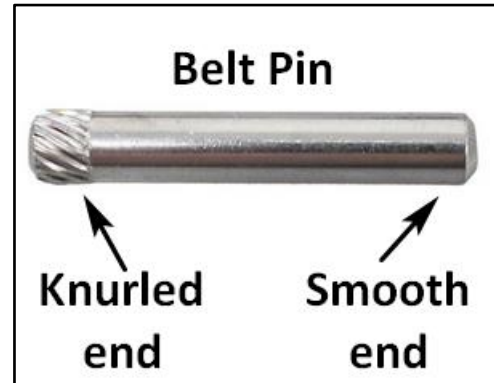


The Belt

The belt on the standard conveyor is a low friction acetal (Delrin®) tabletop plastic chain belt.

The Belt Pin and the Belt Links

The links of the belt are connected by stainless steel belt pins. A belt pin is shown in the image to the right.



Shown below are opposite end images of two belt links joined together by a belt pin. Notice that the tab at one end of the joint has a smaller opening (the image below and to the left), while the tab at the other end of the joint has a larger opening (the image below and to the right).

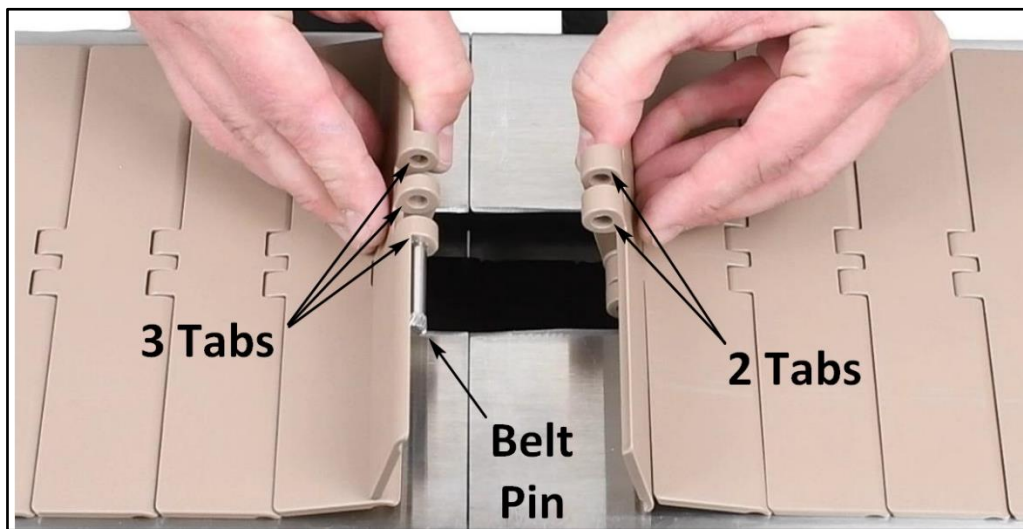
When inserting a belt pin, the belt pin must be pushed through the outer tab with the larger opening. The belt pin will then slide through the joint and then come to a stop within the tab with the narrow opening.

When removing a belt pin, it must be pushed out with a punch that will contact the pin through the tab with the narrow opening. Pushing from the narrow end allows the pin to slide out through the end with the larger opening.



Attaching the Belt/Adding Links to the Belt

1. See the image below. Each link of the belt contains three tabs on one end and two tabs on the other. By hand, insert the smooth end of the belt pin into the outer tab of the belt link that has the larger opening. Do not insert the pin further than the outer tab at this time.



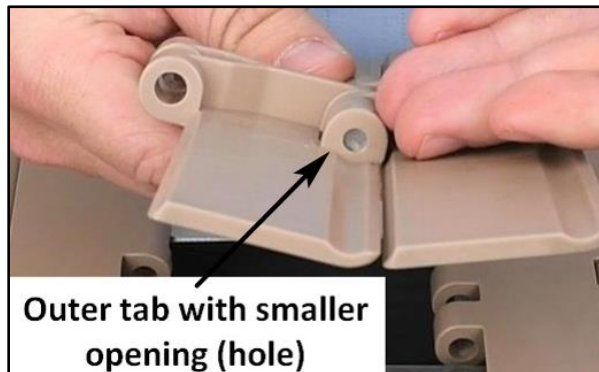
2. Merge the two ends of the belt as shown in the image below. Insert a punch under the belt aligned with the knurled head of the belt pin. Opposite the pin and punch, press and hold the belt down against the conveyor firmly, to create a solid backing. With the hammer and punch, drive the belt pin through the tabs.



Removing the Belt/Removing Links from the Belt

When removing a belt pin, it must be pushed out with a punch that will contact the pin through the tab with the smaller opening as shown in the picture below and to the left.

Pushing from the narrow end allows the pin to slide out through the end with the larger opening, shown below and to the right.



1. To remove a link, or separate the belt, lift the belt off of the conveyor slightly and then align 3/16th or smaller punch through the tab with the small opening and against the belt pin as shown in the picture to the right.
2. While holding the punch against the belt pin, lower the punch to the surface of the conveyor as shown in the image below and to the right.

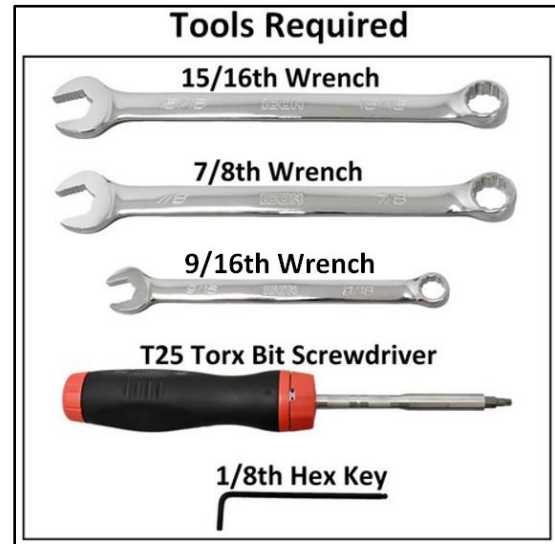


Tap the end of the punch with the hammer until the belt pin is removed.



Unpacking the Conveyor

1. The tools shown in the image to the right are required to unpack and assemble the inline conveyor.



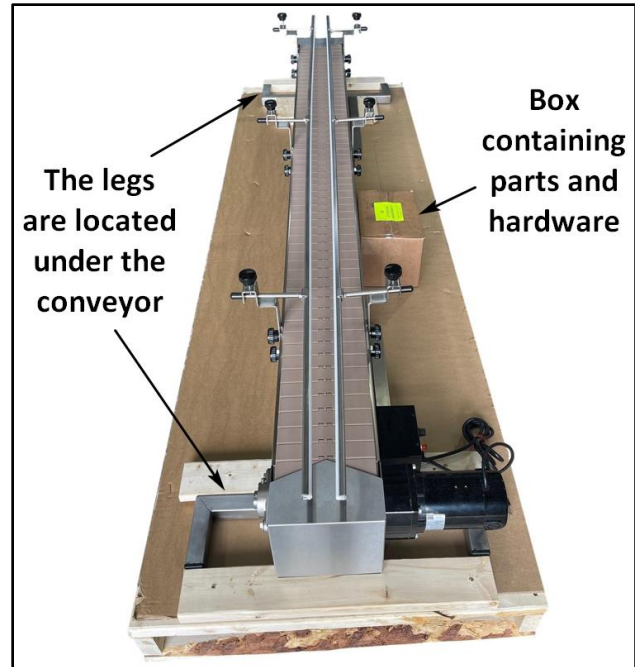
2. The conveyor will arrive in a crate as shown in the picture below and to the right. A T25 torx bit is included within the packing slip at the top of the crate. Open the packing slip to remove the T25 torx bit. The packing slip with enclosed T25 torx bit is shown in the image to the right.



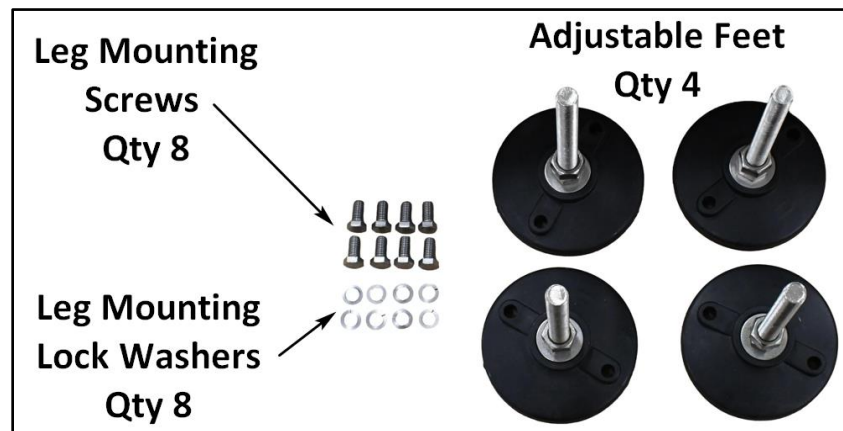
3. The top and sides of the conveyor are fastened by T25 torx screws. Remove the top and sides of the crate by removing the T25 torx screws that fasten it together.



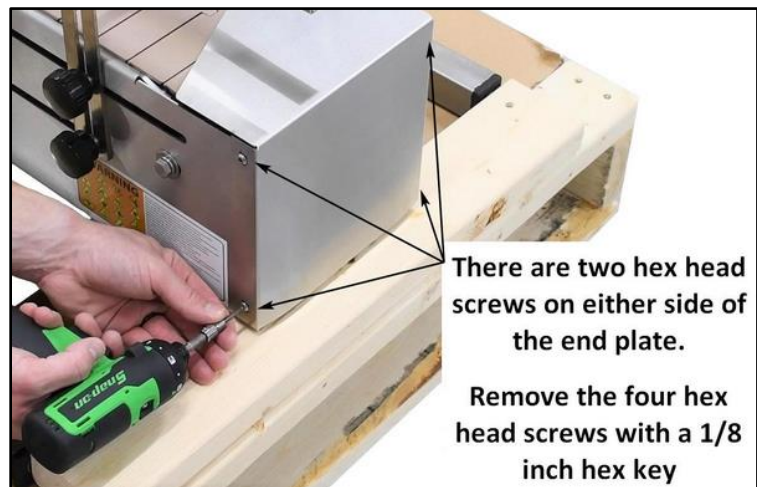
4. The contents of the crate are now exposed. The legs, which were detached from the conveyor prior to shipping, are located under the conveyor and indicated in the picture to the right. Also included is a box that contains the parts and hardware required to assemble the conveyor.



5. The box contains the four adjustable feet for the conveyor, 8 leg mounting screws and 8 lock washers for the leg mounting screws. The contents of the box are shown in the image to the right.



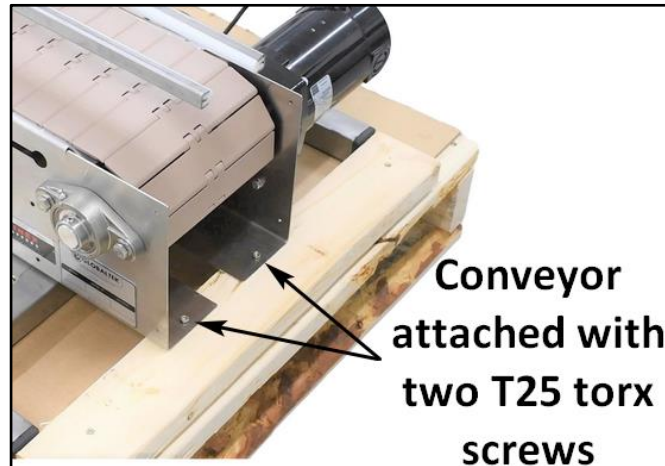
6. To unfasten the conveyor from the pallet, the two end plates, one at each end of the conveyor, must be removed. Each end plate is fastened to the conveyor with 4 hex screws. Remove the 4 hex screws with a 1/8 inch hex key as is shown in the image to the right.



7. With the four hex screws removed, the end plate can be removed from the body of the conveyor as shown in the image to the right.



8. With the end plates removed, the two T25 torx screws that fasten each end of the conveyor to the pallet are exposed. These screws are installed to secure the conveyor to the pallet during transit. They are indicated in the image to the right.



Remove the T25 torx screws to free the conveyor from the pallet.



9. The end plates can now be reattached to the conveyor. When reattaching each end plate, place a spacer between the belt of the conveyor and the end plate as shown in the image to the right. A spacer about $1/32^{\text{nd}}$ – $1/16^{\text{th}}$ inch thick is ideal. This will ensure that the end plate will not be rubbing against the belt of the conveyor when the belt of the conveyor is moving. Tighten the four hex screws with a $1/8^{\text{th}}$ inch hex key to fasten each end plate in place.



You do not have to use a spacer. If you do not have a spacer, that is fine. Just use your eyes to ensure that end plate is not rubbing against the belt when you refasten the endplate to the conveyor.

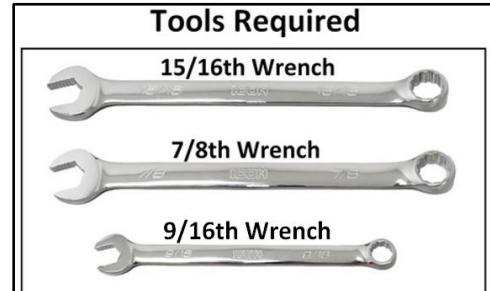
10. Lifting one end of the conveyor at a time, remove each of the two legs from under the conveyor and set them off to the side for later assembly. Rest the conveyor back onto the pallet after each leg has been removed.


The conveyor is now unpacked. You can now move onto assembly on the following page.



Basic Assembly (Conveyors 10 feet of less)

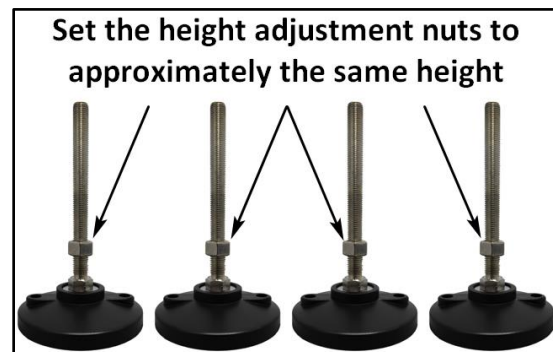
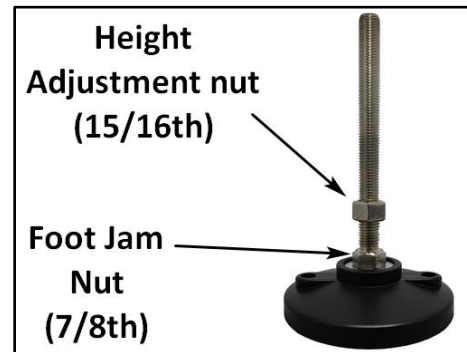
Assembling the conveyor requires at least 3 people. Do not move or assemble the conveyor without additional personnel or mechanical assistance as this may cause injury or damage to the conveyor.



 **CAUTION:** Assembling the conveyor requires at least 3 people. Do not move or assemble the conveyor without additional personnel or mechanical assistance as this may cause injury or damage to the conveyor.

1. The conveyor comes with four adjustable feet. A close up view of an adjustable foot is shown to the right. The height adjustment nut and foot jam nut are indicated.

The height of the conveyor is adjustable from 35 – 40 inches. The further you thread the feet into the conveyor legs, the lower the overall height of the conveyor will be.



Set the height adjustment nuts to approximately the same height on the threads of all four feet before proceeding to step 2. Do not be concerned with determining the exact final height of the conveyor at this time. Adjustments can be made later to adjust the final height of the conveyor.

2. Thread the adjustable feet into the legs of the conveyor as shown in the picture to the right. Thread the foot into the legs of the conveyor until the height adjustment nut is snug against the leg. There is no need to fully tighten the height adjustment nut at this time.

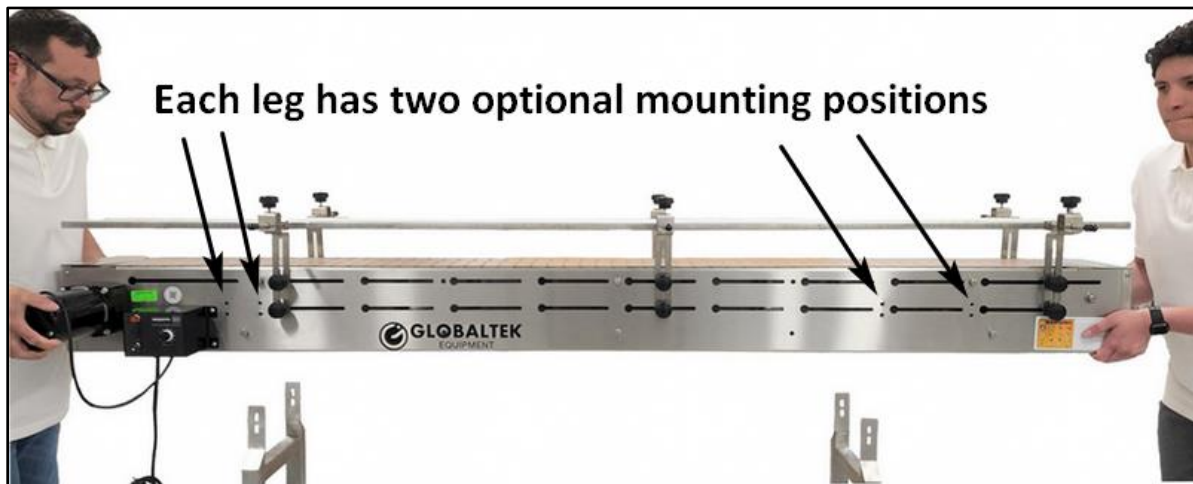
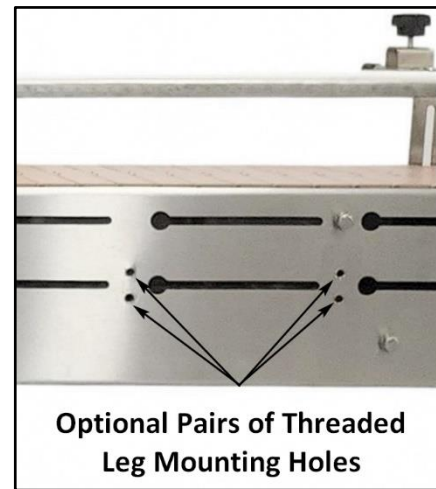


3. With the feet mounted onto the legs, stand the legs on the floor next to the conveyor as shown in the image to the right.



4. Have at least 2 people lift the conveyor and place the conveyor onto the legs.

As is shown in the images below and to the right, each leg can be mounted into two optional positions, more toward the middle, or more towards the end of the conveyor. Give thought to the final layout of the conveyor when choosing which set of mounting holes to use to fasten the legs to the conveyor. If you will be attaching an accumulation table at either end of the conveyor, you should choose the leg mounting holes toward the middle of the conveyor so that you will have more room at the ends of the conveyor. If you will be mounting accessories in the middle of the conveyor, choose the outer mounting holes to fasten the legs to the conveyor.



5. Using the 8 screws and 8 lock washers included with the conveyor shown below, fasten the legs to the conveyor with a 9/16 wrench or socket as shown in the image to the right.

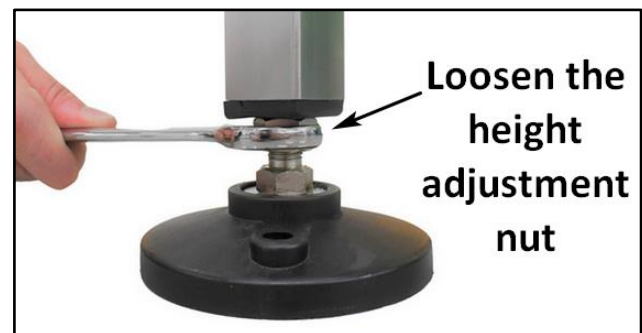


6. With the legs now attached, the conveyor can now be safely transported to where it will be used. When moving the conveyor, be sure to utilize additional personnel or mechanical assistance. Failure to do so may cause injury or damage to the conveyor.

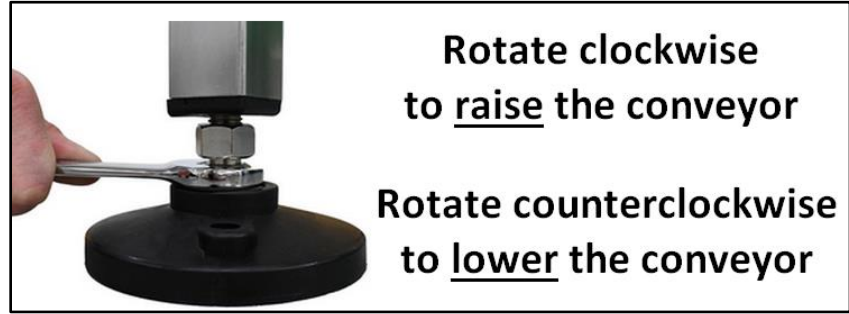


7. Level the Conveyor. To level the conveyor, place a level along the belt of the conveyor as shown in the picture to the right.

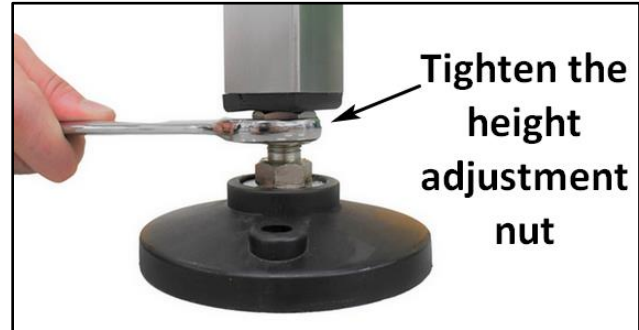
If adjustments are required, loosen the height adjustment nuts on the feet of the conveyor with a 15/16th wrench.



With the height adjustment nut loose, rotate the foot jam nut with a 7/8th wrench. To raise the conveyor, rotate the foot jam nut clockwise. To lower the conveyor, rotate the foot jam nut counterclockwise.



When the conveyor is level, tighten the height adjustment nut against the leg of the conveyor with a 15/16th wrench.

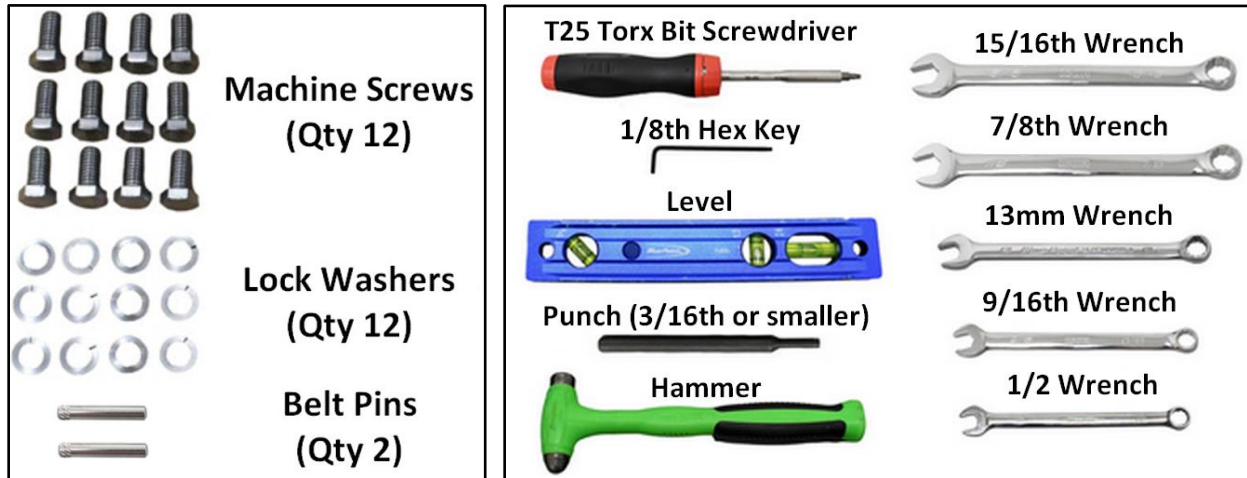


11. The conveyor is now fully assembled.



Basic Assembly (Conveyors 11 feet of longer)

1. Conveyors 11 feet and longer are split into two sections for shipping purposes. The hardware required to join the two conveyors together is shown in the image below and to the left. The tools required are shown in the image below and to the right.

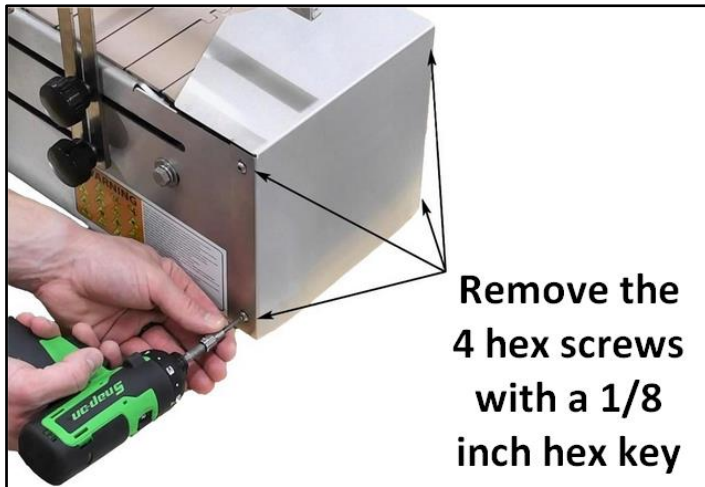


2. Following the basic assembly instructions for conveyors 10 feet and less, found on pages 35-38 of this manual, fully assemble the two sections of conveyors as if they are individual conveyors.

Once they are assembled, arrange them end to end, about 6 inches apart, as shown in the image below.



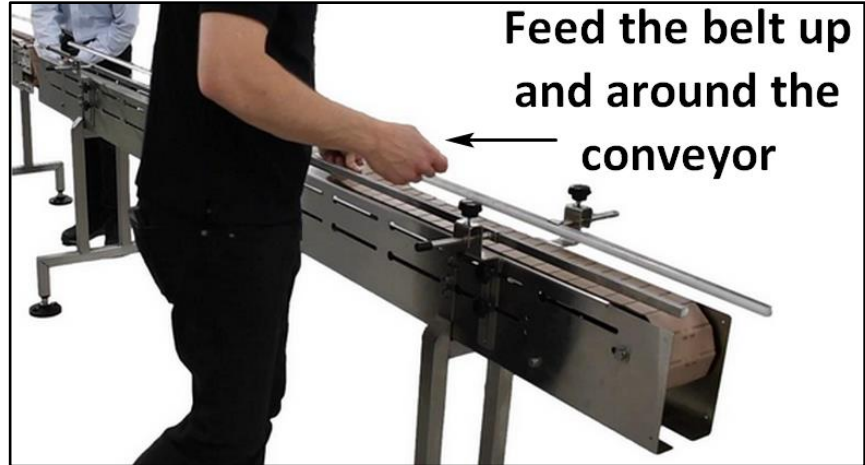
2. Remove the end plates from both conveyors by removing the 4 hex screws with a 1/8 inch hex key as shown in the image below and to the left.



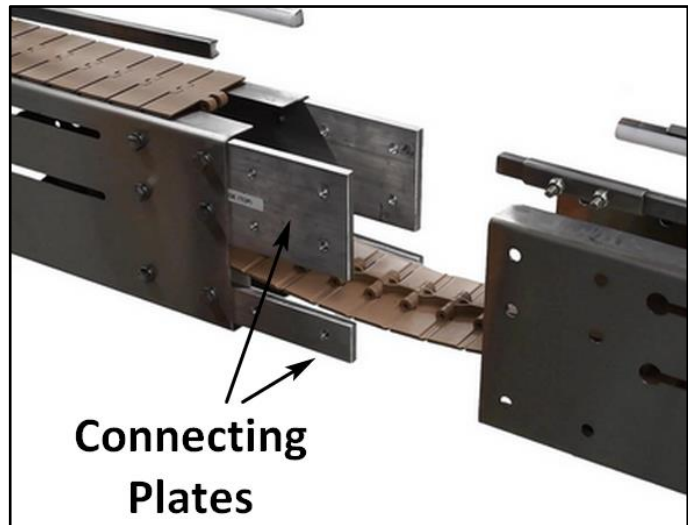
3. With the four hex screws removed, the end plates can be removed from the conveyors as shown in the image above and to the right.
4. When the two conveyor sections are delivered, the belt is attached to the section that includes the motor. The belt must now be attached to the section that does not have a belt. Begin feeding the belt through the bottom of the beltless conveyor as is shown in the image below.



5. Continue to feed the belt first through the bottom of the belt-less conveyor, and then wrapping around the end and then on top of the conveyor as shown in the image below. It is useful to have at least two people perform this operation.



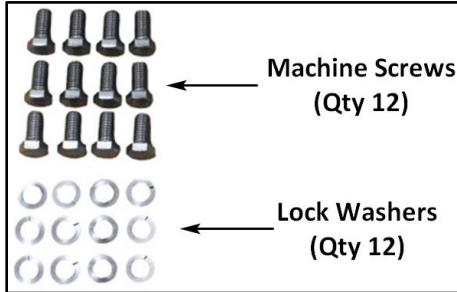
6. The conveyor connecting plates are shown in the image to the right. They typically come attached to one of the two conveyor sections prior to shipping.



Slide the two conveyors and the belt together as shown in the picture to the right. Continue to slide the conveyors together until the 6 through holes at the end of the one section are aligned with the 6 threaded holes on the connecting plates.

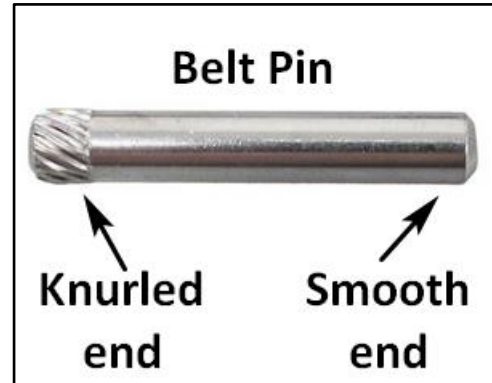


7. With the holes aligned, use a 9/16th wrench or socket to fasten the conveyors together with the 12 included machine screws and washers shown in the image below.



8. It is now time to attach the two ends of the belt. The links of the belt are connected by stainless steel belt pins. A belt pin is shown in the image to the right.

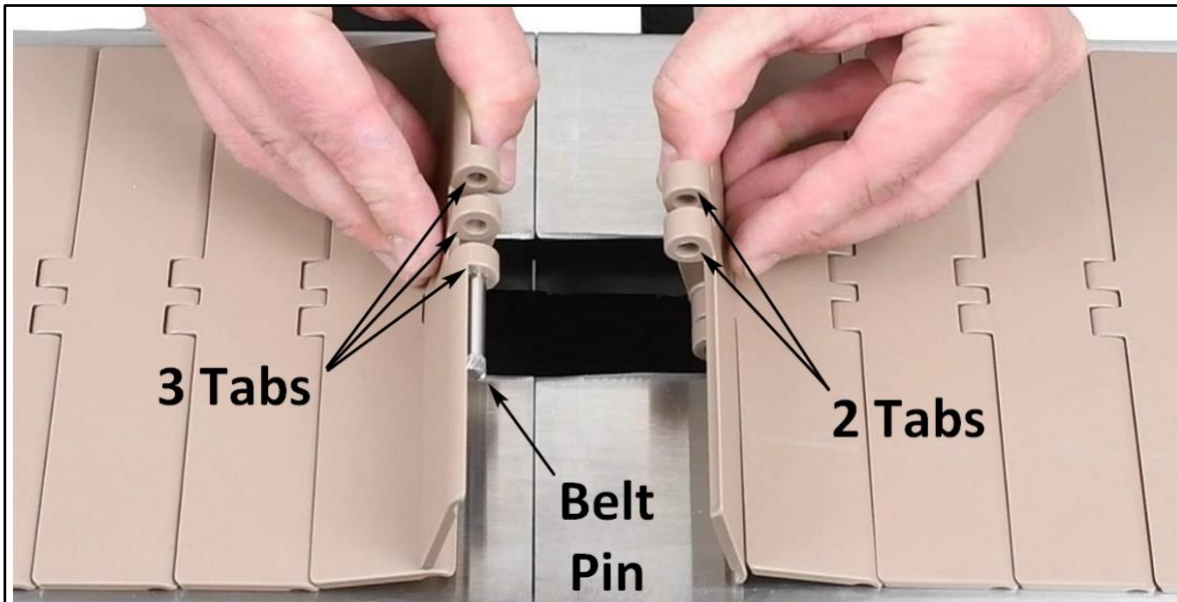
Shown below are opposite end images of two belt links joined together by a belt pin. Notice that the tab at one end of the joint has a smaller opening (the image below and to the left), while the tab at the other end of the joint has a larger opening (the image below and to the right).



When inserting a belt pin, the belt pin must be pushed through the outer tab with the larger opening (image below and to the right). The belt pin will then slide through the joint and then come to a stop within the tab with the narrow opening.



9. See the image below. Each link of the belt contains three tabs on one end and two tabs on the other. By hand, insert the smooth end of the belt pin into the outer tab of the belt link that has the larger opening. Do not insert the pin further than the outer tab at this time.



10. Merge the two ends of the belt as shown in the image below. Insert a punch under the belt aligned with the knurled head of the belt pin. Opposite the pin and punch, press and hold the belt down firmly to the conveyor, to create a solid backing. With the hammer and punch, drive the belt pin through the tabs.



12. Check the tension of the belt. If you determine that the belt is too loose, remove links from the belt to reduce its overall length.

a. To remove a link, lift the belt off of the conveyor slightly and then align the punch through the tab with the small opening and against the belt pin as shown in the picture to the right.



b. While holding the punch against the belt pin, lower the punch to the surface of the conveyor as shown in the image to the right.

Tap the end of the punch with a hammer until the belt pin is removed.

After the appropriate number of links have been removed, reconnect the ends of the belt following steps 8 -10 described above.



12. The end plates can now be reattached to the conveyor. When reattaching each end plate, place a spacer between the belt of the conveyor and end plate as shown in the image to the right. A spacer about 1/32nd – 1/16th inch thick is ideal. This will ensure that the end plate will not be rubbing against the belt of the conveyor when the belt of the conveyor is moving. Tighten the four hex screws with a 1/8th inch hex key to fasten each end plate in place.



You do not have to use a spacer. If you do not have a spacer, that is fine. Just use your eyes to ensure that end plate is not rubbing against the belt when you refasten the endplate to the conveyor.

13. Now that the two sections of the conveyor have been merged, level the conveyor once again following the instructions found on page 21 of this manual.

14. Connect the guiderails. Two piece guiderail clamps are used to connect separate lengths of guiderails. A two piece guiderail clamp is shown to the right.



The two piece guiderail clamps come pre-fastened to either pair of guiderails as shown in the picture to the right. Loosen, but do not remove the two nuts on each guide rail clamp with a 13mm wrench or socket as is shown in the picture to the right. This allows the guiderail clamp to freely slide along the guiderail.



15. Align the guiderails you are going to merge and then slide the guiderail clamp down to connect the two guiderails together.

Once the clamps are in place, tighten the two nuts on each guiderail clamp with a ½ inch wrench or socket to lock the guiderails together as shown in the picture to the right.

Assembly is now complete.



Operating Instructions (Getting Started):

1. Unpack the conveyor following the instructions found on pages 31-34 of this manual.
2. If the conveyor is 10 feet or less in length, assemble the conveyor following the instructions found on pages 35-38 of this manual.

If the conveyor is 11 feet or greater in length, assemble the conveyor following the instructions found on pages 39-45 of this manual.


3. Choose the object you wish to move with the conveyor and adjust the guiderails to fit the object following the instructions found on page 26 of this manual.



4. Before plugging the AC power cord into an electrical outlet, turn the On/Off switch on the motor controller to the off position. For more information on the controller, and turning the conveyor on and off, please see pages 13-15 of this manual.
5. Plug the AC power cord into an electrical outlet that provides 115 VAC \pm 10%, 50/60 Hz. single phase electricity. Make sure that the outlet is overload protected, grounded, and of sufficient amperage capacity (5.7 amps). If there is any doubt that the outlet box complies with this specification, have a qualified electrician inspect the outlet box.




For more information on the AC power cord, see page 15 of this manual. For more information on the electrical requirements of the conveyor, see page 12 of this manual.

	<p>CAUTION: Plug the AC power cord into an electrical outlet that provides 115 VAC \pm 10%, 50/60 Hz. single phase electricity. Make sure that the outlet is overload protected, grounded, and of sufficient amperage capacity (5.7 amps). If there is any doubt that the outlet box complies with this specification, have a qualified electrician inspect the outlet box.</p>
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6. The conveyor is now ready for use. Turn the On/Off switch on the motor controller to the on position. For more information of the controller, and turning the conveyor on and off, please see pages 13-15 of this manual.
7. To start the belt moving, rotate the speed pot, or speed control dial, clockwise. The speed control knob is located on the right side of the control box and is shown in the picture to the right. For more information on the speed pot, see page 15 of this manual.



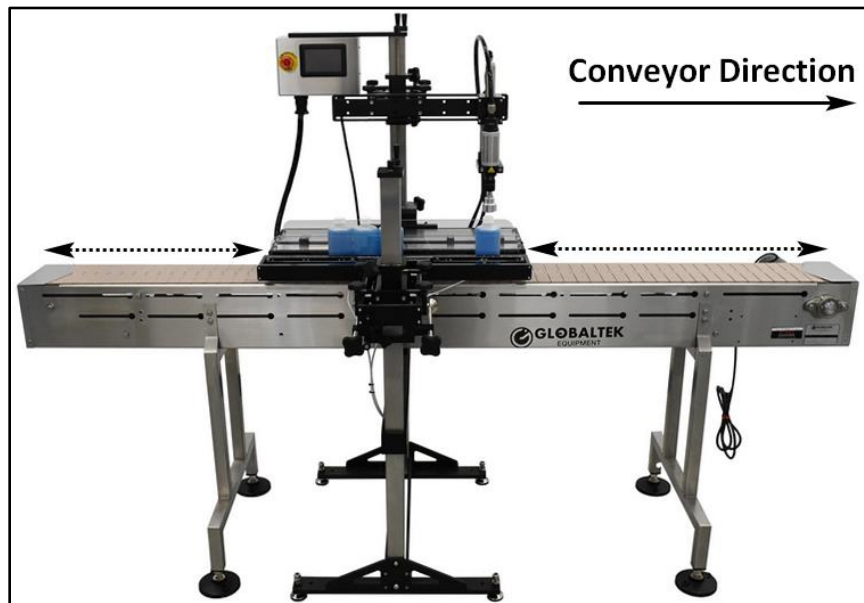
	<p>CAUTION: Keep all body parts clear of the conveyor when energizing the belt. The belt can move suddenly and cause injury.</p>
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Installing and Integrating Machinery Along a Conveyor

Many types of machines, such as the machine in our example, provide their own means to guide bottles or other objects that pass through them. This section will instruct you on how to install and setup the guiderails to allow the conveyor to work optimally with this type of machine.



Install the machine of your choice along the conveyor as prescribed by the manufacturer. In our example, we are installing a Kinex Cappers® automatic capping machine along the conveyor as shown in the image to the right. The direction of the conveyor is always toward the end with the motor as indicated in the picture to the right.



8. The dashed lines in the image above indicate the lengths of the conveyor where guide rails should be installed.

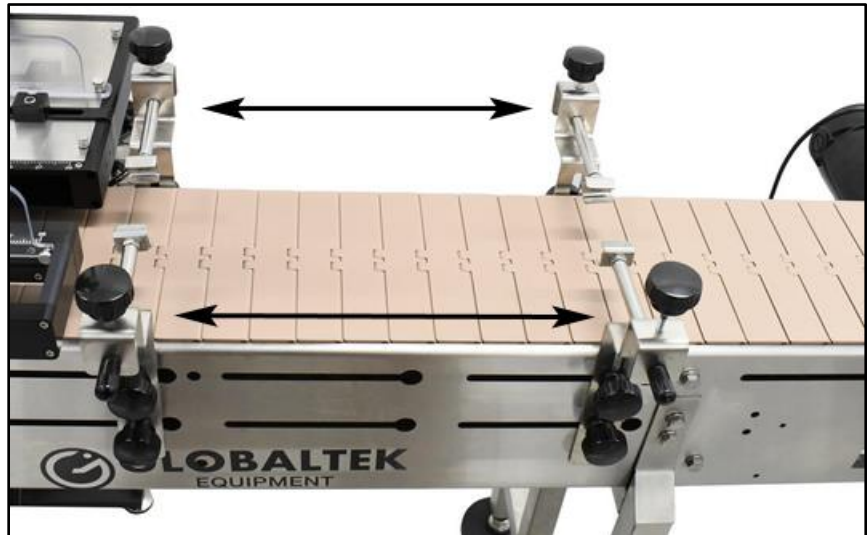
Measure these lengths as shown in the image to the right.



9. After taking measurements, mark the guide rails and then cut the guiderails to length with a hacksaw as shown in the image to the right.



10. Following the instruction found on page 24 of this manual, mount two guide rail brackets on each side of the conveyor as shown in the image to the right.



Repeat this step at the other end of the conveyor.

11. Following the instruction found on page 25 of this manual, insert guide rails through the mounting brackets and then slide the guide rails against the machine as shown in the image to the right. Fasten the guide rails in place with a 13mm wrench.



Repeat this step at the other end of the conveyor.

12. Adjust the width and height of the guide rails so they align with the bottle (or object) guiding system of the machine you are working with as shown in the image below. For more information on adjusting the height and width of the guide rails, see page 26 of this manual.

Repeat this step at the other end of the conveyor.



13. Setup is now complete. The guide rails have been installed on either side of the machine as shown in the image below.



Conveyor to Conveyor End Transfer (Standard Type)

A conveyor to conveyor end transfer, standard type, involves aligning two conveyors end to end, and then connecting the guide rails of the two conveyors to allow product to flow from one conveyor to the other.



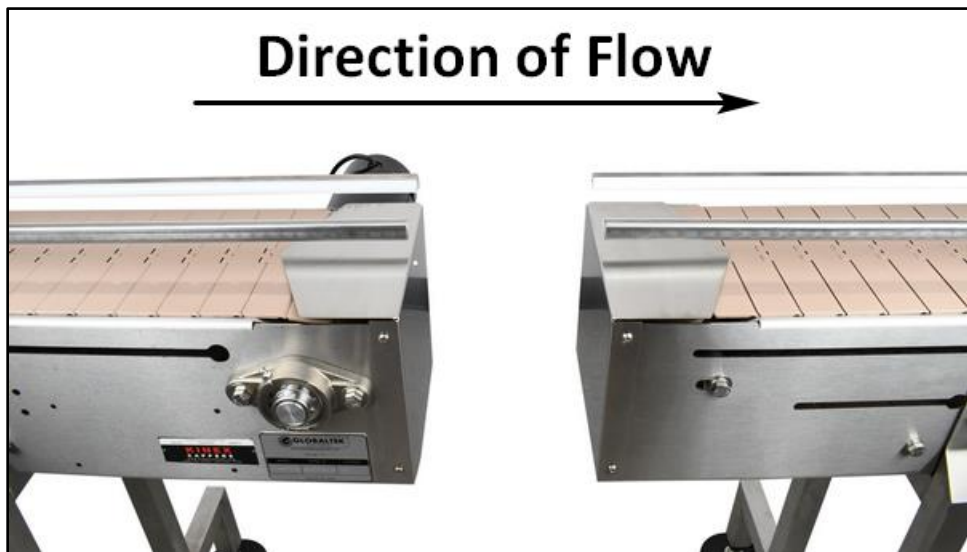
- 1. Before starting, gather the tools shown in the image to the right.



2. Assemble the conveyors you will be connecting following the instructions found on pages 35 – 38 of this manual.



3. Arrange the two conveyors you will be connecting end to end, about one foot apart, as shown in the image below. Be aware of the direction of flow of the conveyors. Remember that product always flows towards the motor end of the conveyor.



4. Place the bottle or other object you will be conveying onto the belt of the conveyor. Slide the object from the belt onto the end plate of the conveyor as is shown in the picture to the right.

If the height of the end plate is set correctly, the object should slide freely over the end plate.



If it object does not slide freely over the end plate, the end plate should be lowered. To lower the end plate, loosen the four screws that fasten the end plate to the conveyor with a 1/8 inch hex key as shown in the picture to the right.



Once the end plate is loose, slightly lower the end plate by hand. While it is important to lower the end plate you

must also ensure not to lower the end plate too far. If the end plate is set too low, it will rub against the belt of the conveyor when the belt of the conveyor is moving. Once the correct height of the end plate has been determined, tighten the four hex screws with a 1/8th inch hex key to fasten each end plate in place.

Test the adjustment you made by again sliding the bottle over the end plate to make sure that it slides freely. Continue to make adjustments until the object slides freely. Once the end plate is set correctly, retighten the 4 screws with the 1/8 inch hex key. Perform this step for the two endplates that will be joined together.

5. Move the two conveyors together as shown in the image to the right.

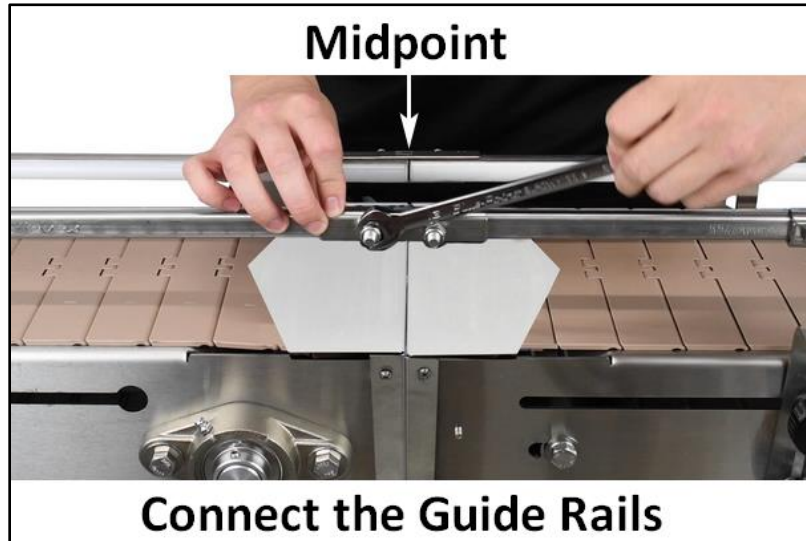


6. Following the instructions found on pages 24 – 26 of this manual, adjust the guide rails of the conveyors so they are aligned and joined together as shown in the image below.



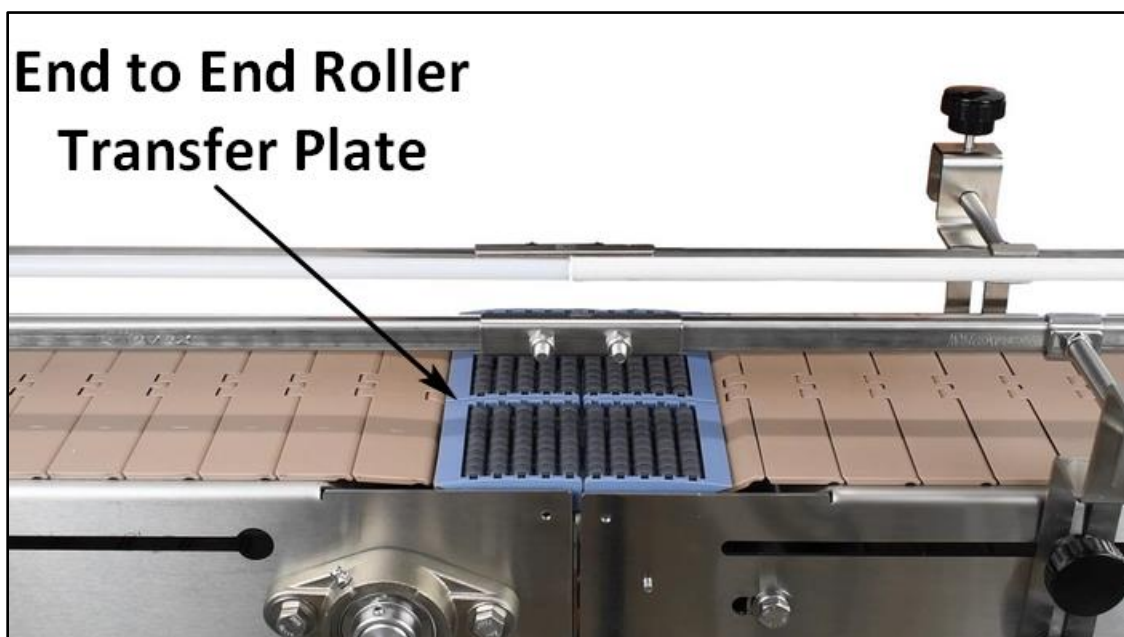
7. Following the instructions found on pages 27 of this manual, connect the guide rails of the two conveyors by installing two piece guide rail clamps as shown in the image to the right.

Set up is now complete.



Conveyor to Conveyor End Transfer (Roller Type)

A conveyor to conveyor end transfer, roller type, involves installing an end to end roller transfer plate to the end of one conveyor, and then joining two conveyors end to end as shown in the image below. Once the conveyors have been connected, merge the guide rails of the two conveyors to allow product to flow from one conveyor to the other.



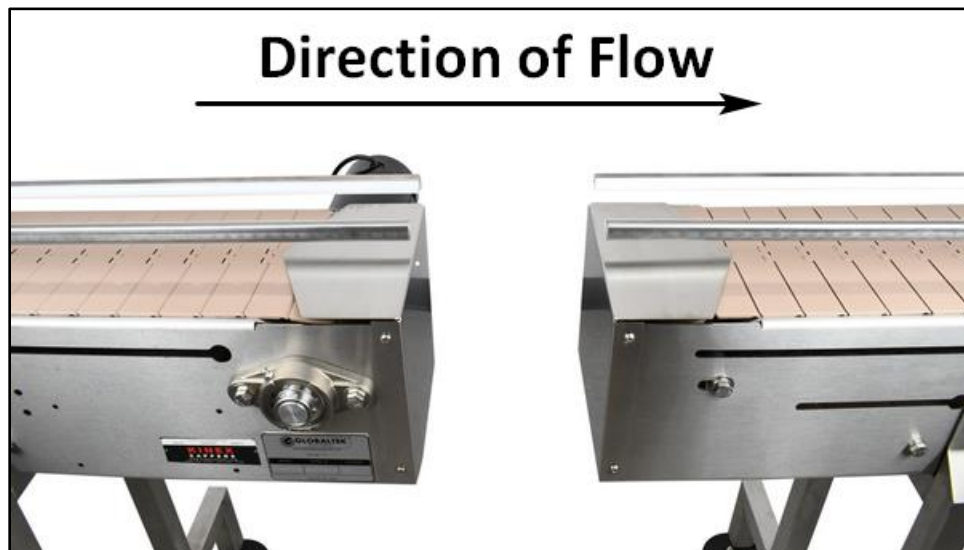
1. Before starting, gather the tools shown in the image to the right.



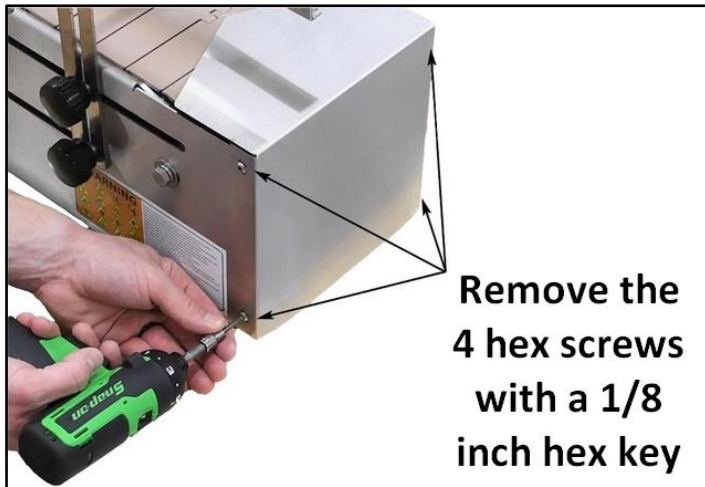
2. Assemble the conveyors you will be connecting following the instructions found on pages 35 – 38 of this manual.



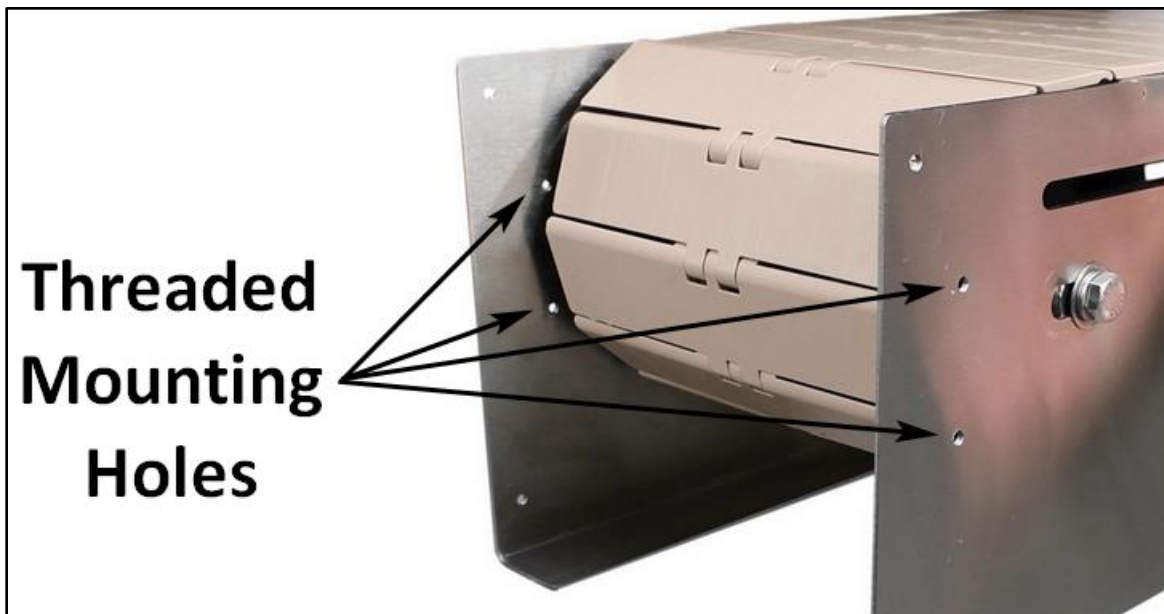
3. Arrange the two conveyors you will be connecting end to end, about one foot apart, as shown in the image below. Be aware of the direction of flow of the conveyors. Remember that product always flows towards the motor end of the conveyor.



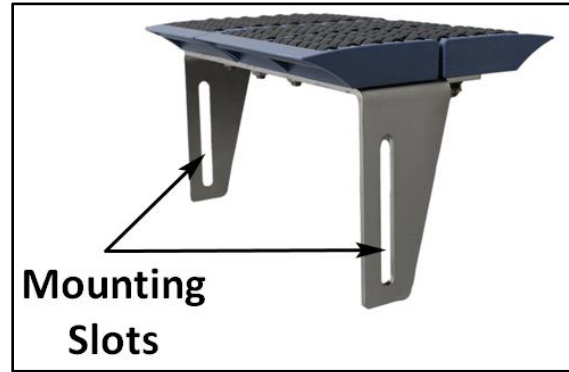
- Remove the end plates from the end of each conveyor that will be connected together by removing the 4 hex screws with a 1/8 inch hex key as shown in the image below and to the left.



- With the four hex screws removed, the end plate can be removed from the conveyor as shown in the image above and to the right.
- With the end plate removed, the four threaded mounting holes used to attach the roller transfer plate to the conveyor are exposed as indicated in the picture below.

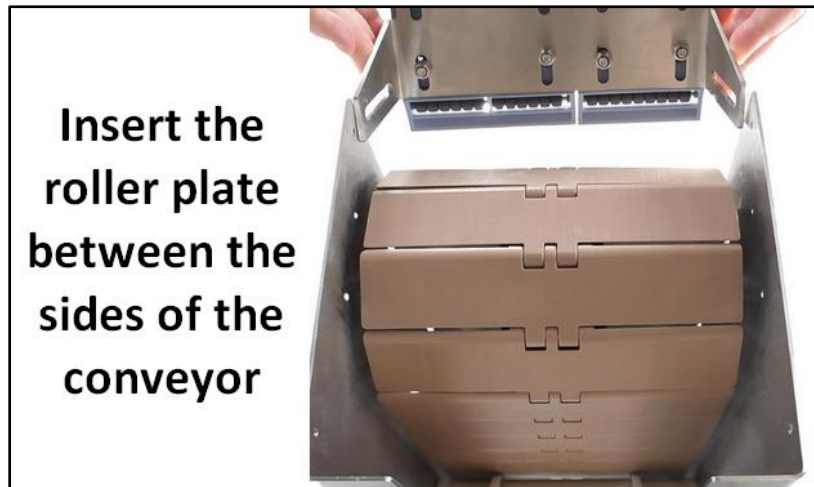


7. The roller transfer plate is shown to the right. The mounting slots are indicated.

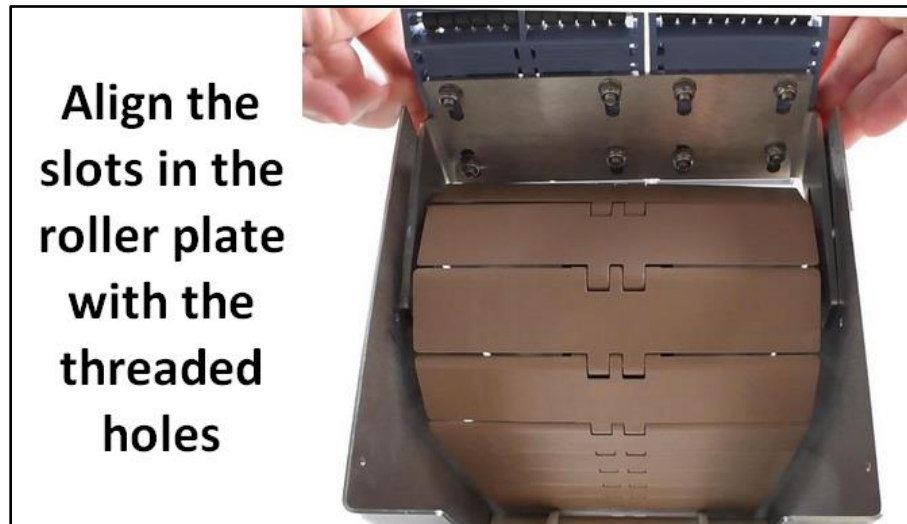


8. The roller transfer plate can be installed onto the end of either of the conveyors being connected. Choose the conveyor on which it will be installed.

Insert the roller transfer plate between the sides of the conveyor as shown in the image to the right.



9. Align the slots in the roller transfer plate with the pairs of threaded holes at each side of the conveyor as shown in the image to the right.



10. Level the rollers with the belt of the conveyor as is shown in the image to the right.



11. From the inside, tighten the 4 screws into the 4 threaded holes with a 1/8 inch hex key.



12. With the roller transfer plate attached to one of the conveyors, move the two conveyors together as is shown in the image to the right.



13. Continue to move the conveyors until they are fully brought together as is shown in the image to the right.

The roller transfer plate has now been installed.



14. Following the instructions found on pages 24-26 of this manual, install the guide rail brackets and guide rails onto the two conveyors as shown in the image below.



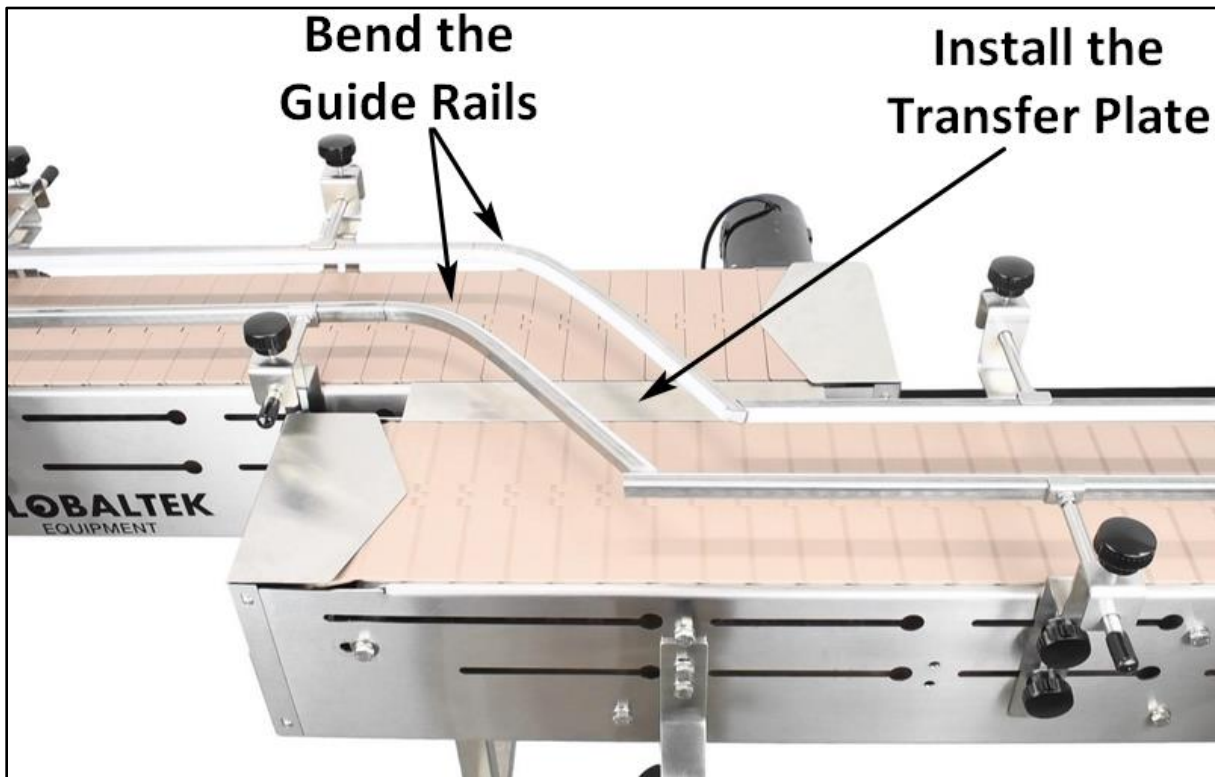
15. Following the instructions found on pages 27 of this manual, connect the guide rails of the two conveyors by installing two piece guide rail clamps as shown in the image to the right.

Set up is now complete.



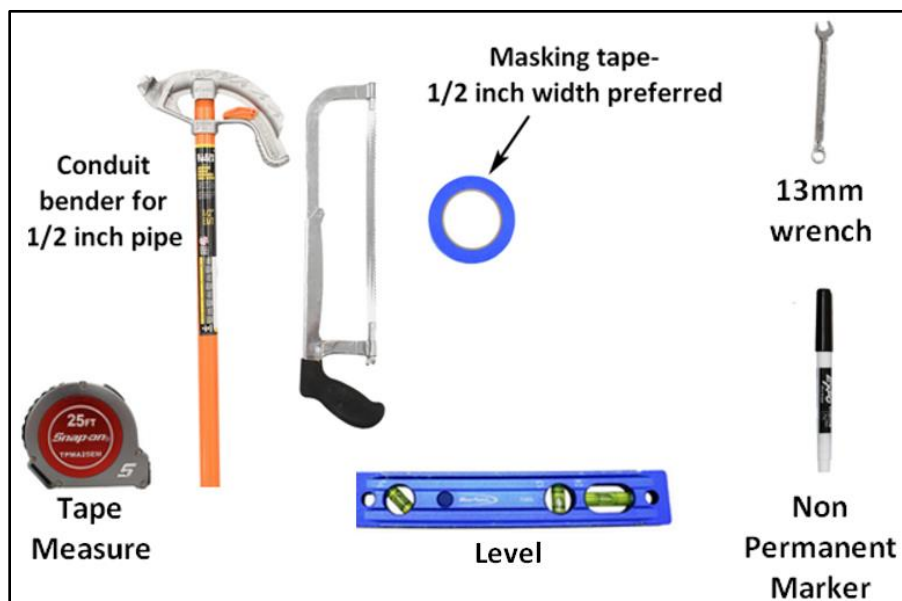
Conveyor to Conveyor Side Transfer (Standard Type)

A conveyor to conveyor side transfer involves connecting two conveyors, side by side, as shown in the image below, and then bending the guide rails to allow product to flow from one conveyor to the other.

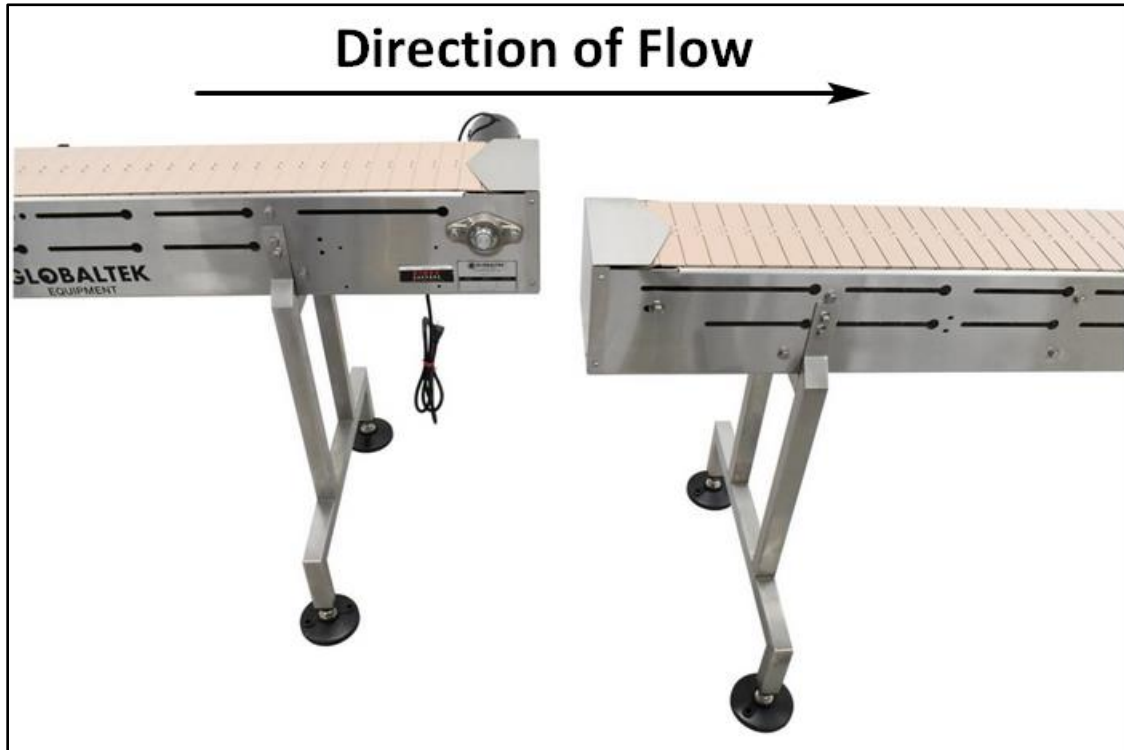


1. Before starting, gather the tools shown in the image to the right.

A ½ inch conduit bender can be purchased at your local hardware store.



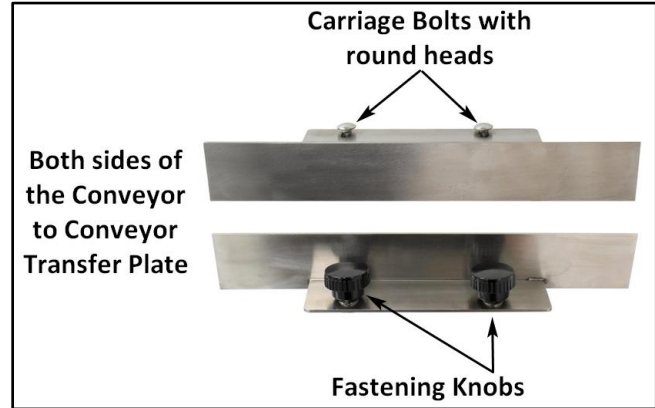
2. Arrange the two conveyors you will be connecting side to side as shown in the image below. Be aware of the direction of flow of the conveyors. Remember that product always flows towards the motor end of the conveyor.



3. Level both conveyors before connecting them.



4. Both sides of the conveyor to conveyor side transfer plate are shown in the image to the right. Note that the two fastening knobs are connected to carriage bolts with round heads.



Locate the slot in which you will be mounting the transfer plate. Note the round opening at one end of the slot. This is where the carriage bolts with the round heads are inserted into the slot.



Insert the carriage bolts of the transfer plate into the slot on the conveyor.

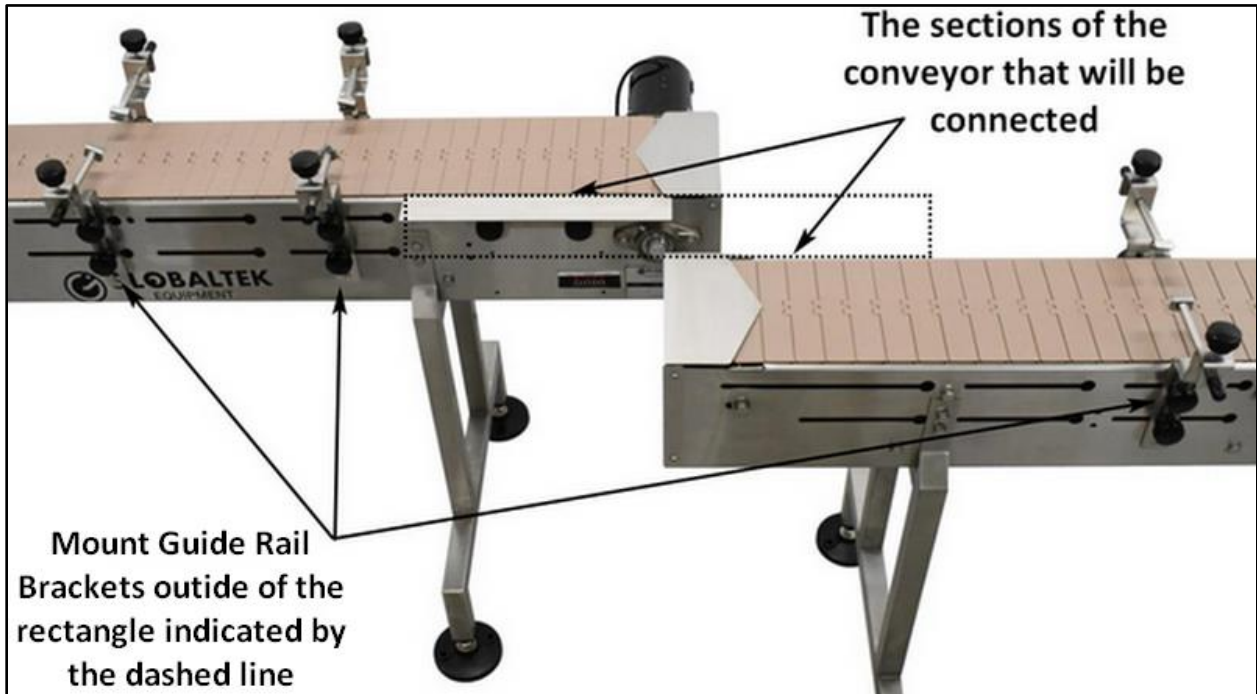


Position the transfer plate as shown in the picture to the right and tighten the fastening knobs to lock the transfer plate in place.



It is important to note that only one transfer plate is installed. You do not need to install another transfer plate to the connecting conveyor.

5. See the dashed rectangle in the picture below. This represents the two areas that will come together when the conveyors are connected. Mount guide rail brackets outside of this area as shown in the picture below. For instructions on how to mount guide rail brackets, please see page 24 of this manual.



6. Slide the conveyors together as shown in the picture below. The transfer plate now serves as a level floor connecting the two conveyors.

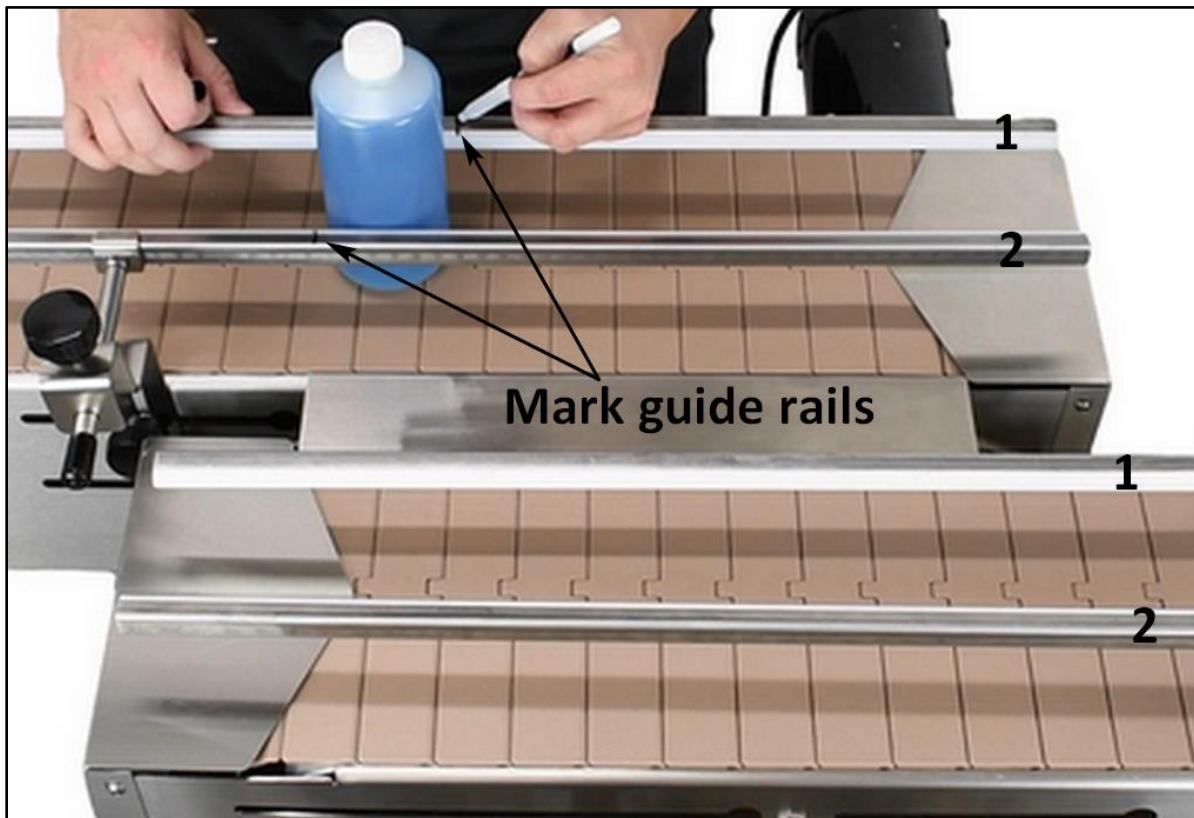


7. Choose the object you wish to move with the conveyors. Insert the guide rails and then adjust the guiderails to fit the object following the instructions found on pages 25 and 26 of this manual.

Do this for both conveyors.



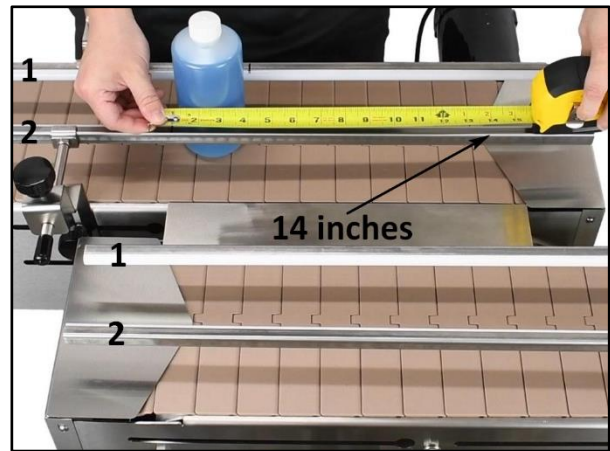
8. It is now time to bend the guide rails. The guide rails must be bent to redirect the flow of product from the upstream conveyor to the downstream conveyor. See the image below. Guide rail 1 of the upstream conveyor must be bent so it can extend to guide rail 1 of the downstream conveyor, guide rail 2 must be bent to extend to guide rail 2. Place your product within the guide rails of the upstream conveyor as shown in the image below. Mark guide rail 1 at the downstream edge of the bottle as shown in the image below. Mark guide rail 2 at the upstream edge of the bottle.



9. Extend a tape measure at a 45° angle from the marks made in step 8 to their corresponding guide rails on the downstream conveyor as shown in the image below and to the left. Measure the distance. In our example below, we are measuring the distance from guide rail 2 to guide rail 2. The distance is about 14 inches.

Guide rail 2 must be long enough such that after it is bent it has enough length to meet guide rail 2 of the downstream conveyor. To ensure there is enough length, measure the distance from the same mark on guide rail 2 to the end of the guide rail as shown in the image below and to the right. As can be seen in the picture, there is plenty of guide rail length.

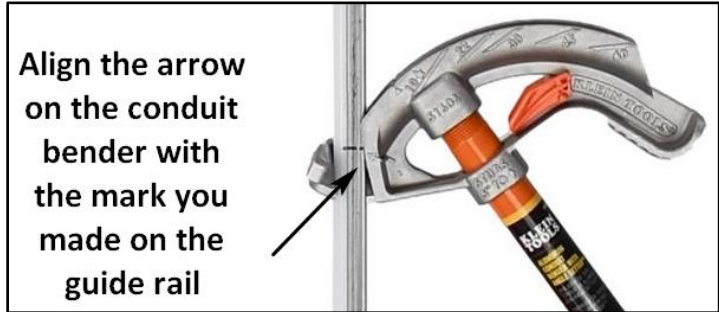
Repeat this step for guide rail 1. If you discover there is not enough length, move the object (bottle) further upstream on the conveyor and make new marks by repeating step 8.



10. From the marks you created on guide rails 1 and 2 in step 8, trace out 45 degree angles using ½ inch masking tape as shown in the image to the right. This will help you envision what the guide rails should look like after you bend them. Place your bottle between the masking tape guide rails to ensure that there will be enough width between the newly bent guide rails.



11. Conduit benders typically include a mark or arrow that indicates where the bend will start (shown in the picture below and to the left). Align the arrow on the conduit bender with the mark you made on the guide rail as shown in the image below and to the right.



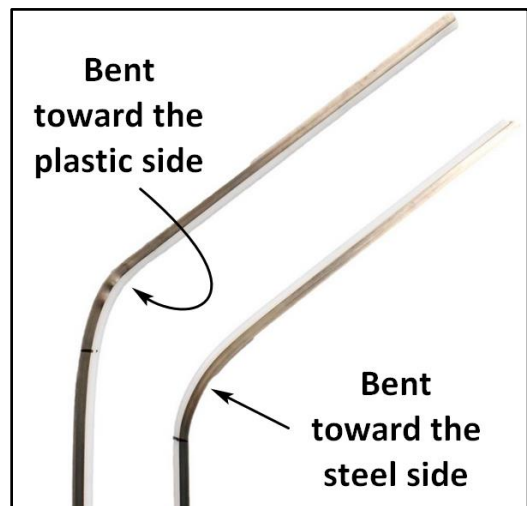
12. Conduit benders include lines that represent common angles. They also include a step so you can push down with your foot to provide more leverage during the bending process.



Bend the guide rail as shown in the image to the right. Bend the guide rail a little past the 45° indication mark, as the bend will naturally want to bounce back a bit when you release the conduit bender from the guide rail.



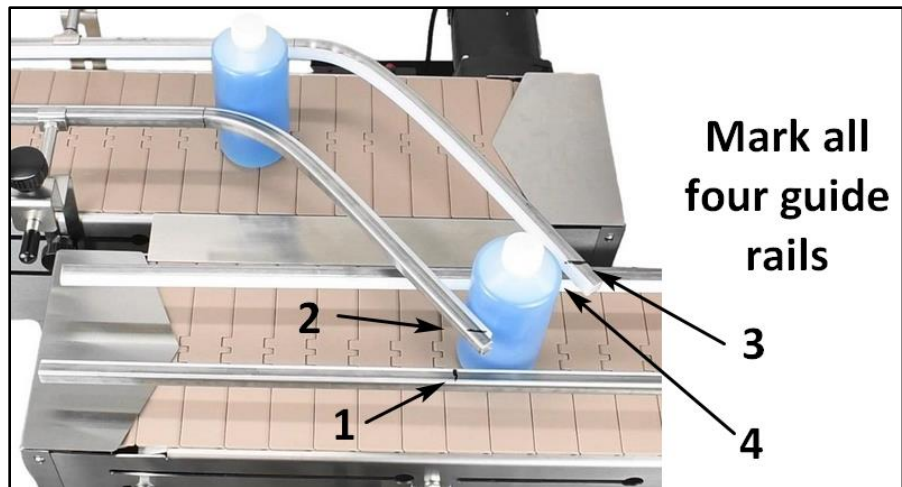
Note that one guide rail will need to be bent toward the plastic side while the other guide rail will need to be bent toward the metal side as shown in the image to the right.



13. Before installing the bent guide rails, adjust the height of the guide rail brackets so that when the bent guide rails are attached, they will be about one inch higher than the guide rails on the other conveyor.



14. Attach the bent guide rails to the conveyor. The bent guide rails will now overlap the guide rails of the other conveyor as is shown in the image to the right.



Mark the guide rails where they overlap as shown in the image to the right. Note that all four guide rails will need to be cut, and some may need to be cut at an angle.

15. Cut the guide rails you marked in step 14 to the appropriate length and angle as shown in the image to the right.

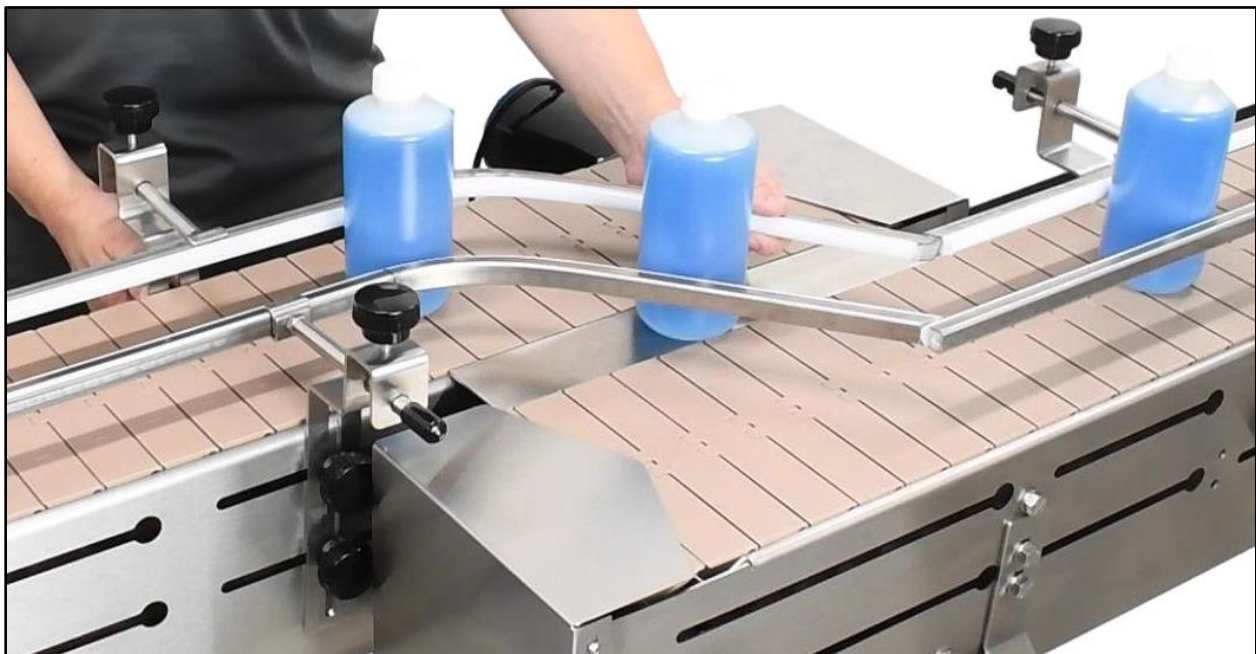


16. Reinstall the guide rails on both conveyors.

Lower the bent guide rails that you raised in step 13, so they are now level with the straight guide rails on the other conveyor as shown in the image to the right.

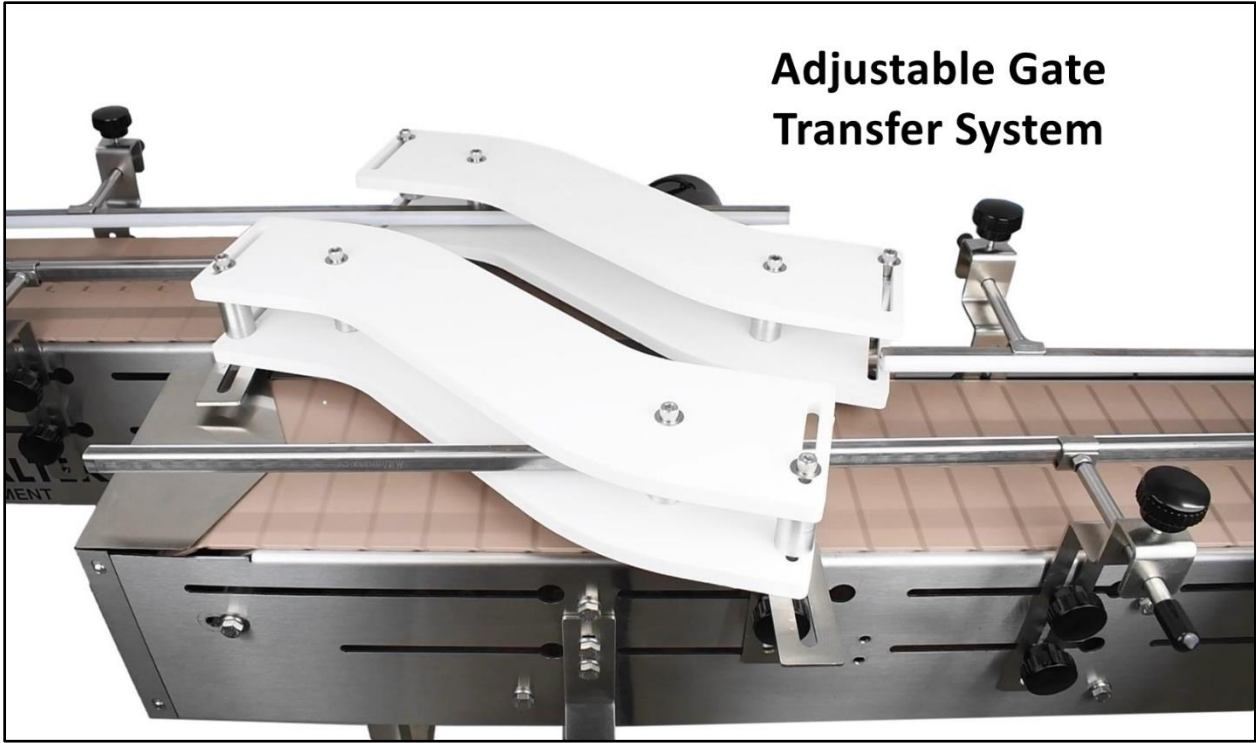


17. Make final adjustments. The guide rails of both conveyors should come together as shown in the image below. The conveyor to conveyor side transfer is now complete.

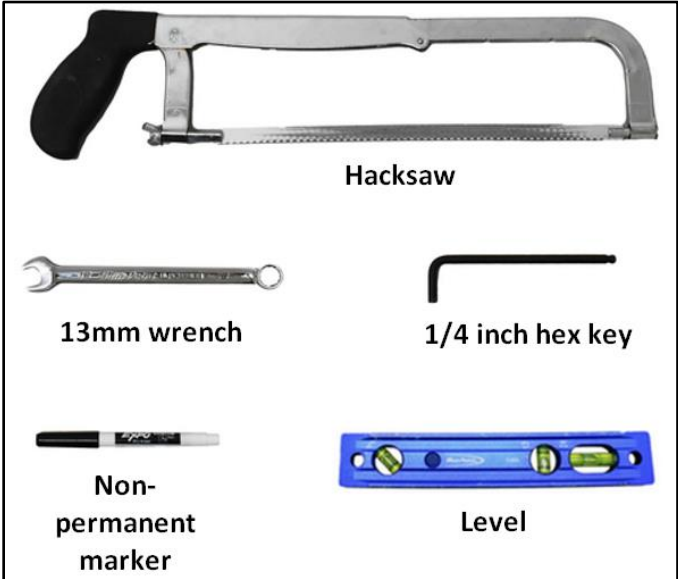


Conveyor to Conveyor Side Transfer (Adjustable Gate System)

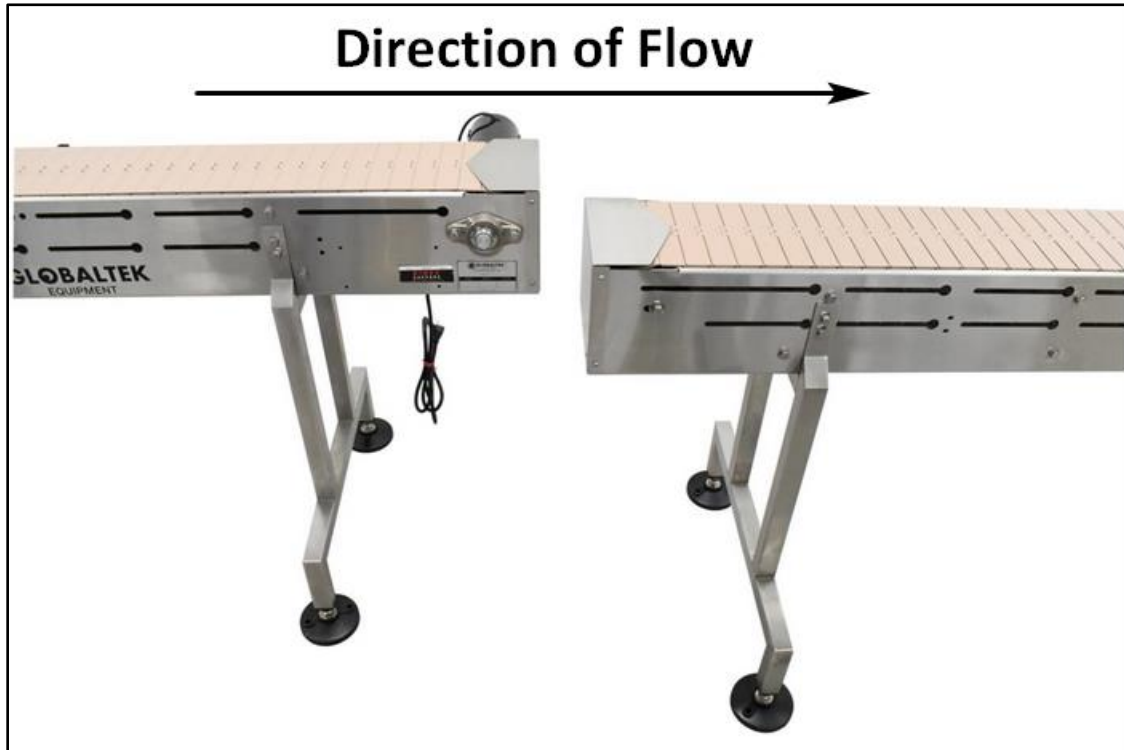
A conveyor to conveyor side transfer can also be achieved using the adjustable gate transfer system, an accessory you can purchase that helps product flow from one conveyor to the other.



- 1. Before starting, gather the tools shown in the image to the right.



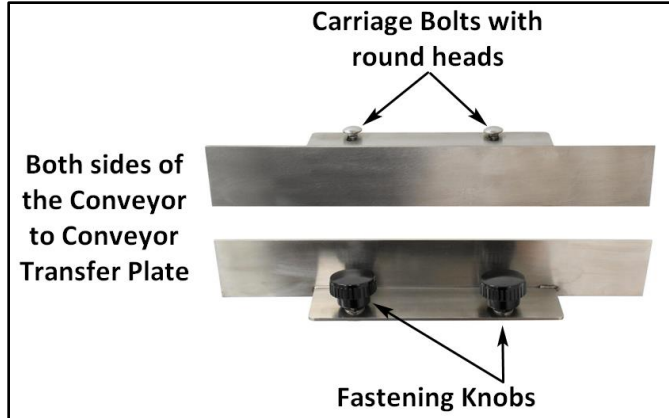
2. Arrange the two conveyors you will be connecting side to side as shown in the image below. Be aware of the direction of flow of the conveyors. Remember that product always flows towards the motor end of the conveyor.



3. Level both conveyors before connecting them.



4. Both sides of the conveyor-to-conveyor side transfer plate are shown in the image to the right. Note that the two fastening knobs are connected to carriage bolts with round heads.



Locate the slot in which you will be mounting the transfer plate. Note the round opening at one end of the slot. This is where the carriage bolts with the round heads are inserted into the slot.



Insert the carriage bolts of the transfer plate into the slot on the conveyor.

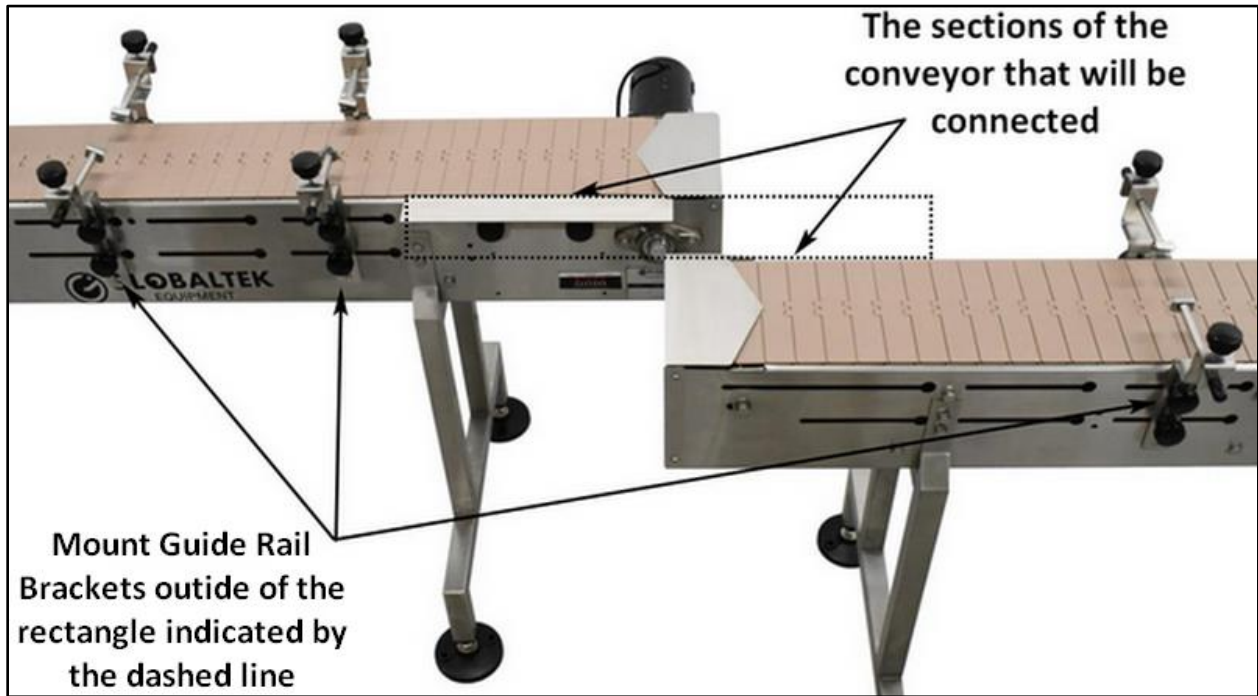


Position the transfer plate as shown in the picture to the right and tighten the fastening knobs to lock the transfer plate in place.



It is important to note that only one transfer plate is installed. You do not need to install another on the connecting conveyor.

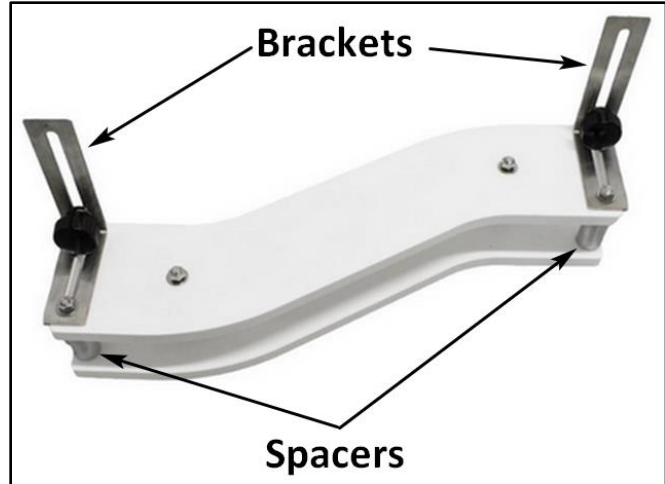
5. See the dashed rectangle in the picture below. This represents the two areas that will come together when the conveyors are connected. Mount guide rail brackets outside of this area as shown in the picture below. For instructions on how to mount guide rail brackets, please see page 24 of this manual.



6. Lift either of the conveyors to bring them together as shown in the picture below. The transfer plate now serves as a level floor connecting the two conveyors.



7. A close up view of a gate is shown to the right. The mounting brackets and spacers are indicated.



8. Remove the brackets from the gates by removing the nut and washer holding them in place with a 13mm wrench as shown in the image below and to the left. Then, refasten the nut and washer onto the bolt as shown in the image below and to the right.



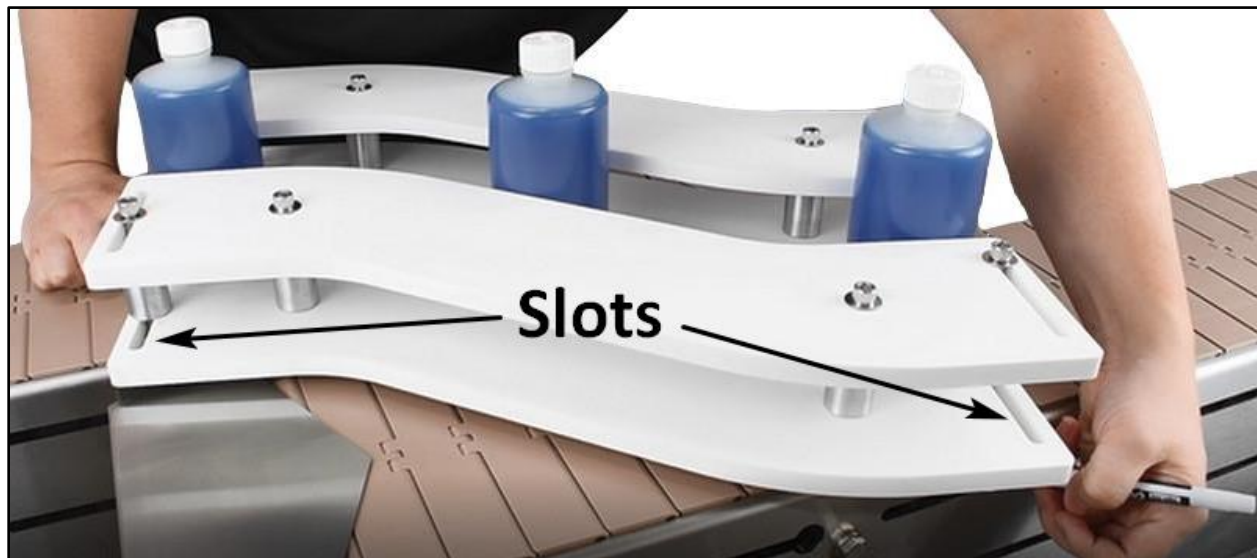
13. Envision the transfer you will be creating by placing your product onto the conveyors and side transfer plate as shown in the image to the right.



14. Using your product as a guide, pre-position the gates along the product as shown in the image to the right.

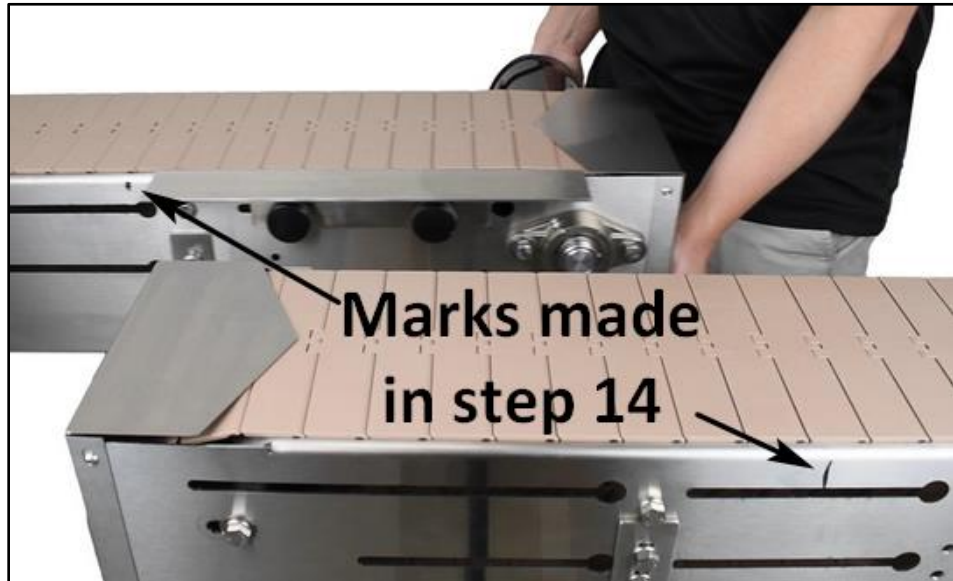


15. Now that the approximate mounting position of the gates has been determined, mark the conveyor where the slots on the transfer gates line up with the slots on the conveyor as shown in the image below. Mark these spots on the conveyor with tape or a non-permanent marker.



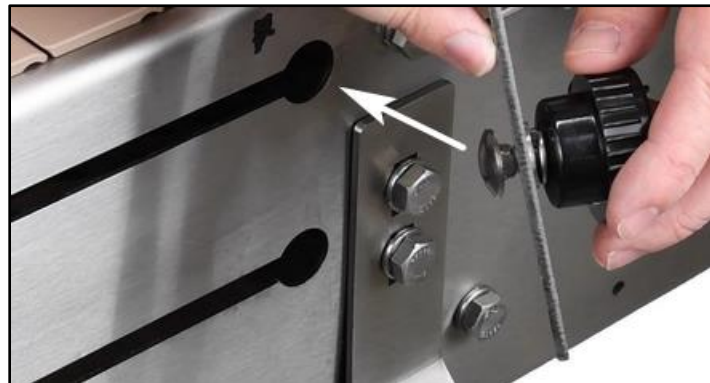
Mark the conveyor where the slots on the transfer gates line up with the slots of the conveyor

16. To allow for easy installation of the gate mounting brackets, lift either of the conveyors to separate the conveyors as shown in the image below. Note that two of the four marks we created in step 15 are visible in the image below.



17. Install the gate mounting brackets at the locations on the conveyor that you marked in step 15.

Align the round heads of the carriage bolt with the round opening at the end of the top mounting slot as shown in the picture to the right.



Insert the round head of the carriage bolt through the round opening in the top conveyor slot and then slide the bracket along the slot to where you marked it in step 15 as is shown in the image below.



Bracket should face out - away from the conveyor

When it is in place, tighten the mounting knob to fasten the bracket in place. Repeat this procedure for all four brackets.

18. With all four mounting brackets now in place, lift either of the conveyors to bring them back together as shown in the image to the right.



18. Reattach the gates to the brackets by first removing the nut and washer shown in the image below and to the left with a 13mm wrench. This exposes the threaded bolt at the bottom of each gate as is shown in the image below and to the right. Complete this step for all four brackets.



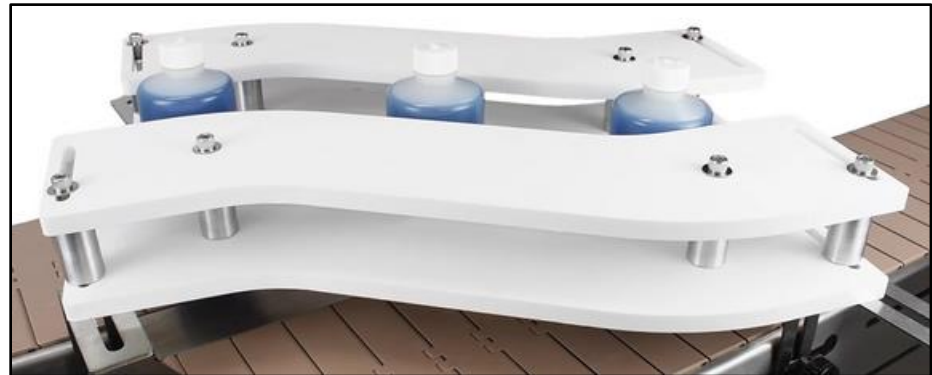
19. Slide the bolt shown in the image to the right into the slot of the gate mounting bracket as shown in the image to the right.



20. From below, slide the lock washer onto the bolt and then thread the 13mm nut onto the bolt as shown in the image below. Tighten by hand at this time. Complete this step for all for four mounting brackets.



21. The gates are now attached to the brackets and mounted to the conveyor. Place your product between the gates as shown in the image to the right to check the fit.



22. Check the width of the opening between the gates. If the plates need to be moved closer together, or brought further apart, loosen the ¼ inch hex screw as shown in the image to the right.



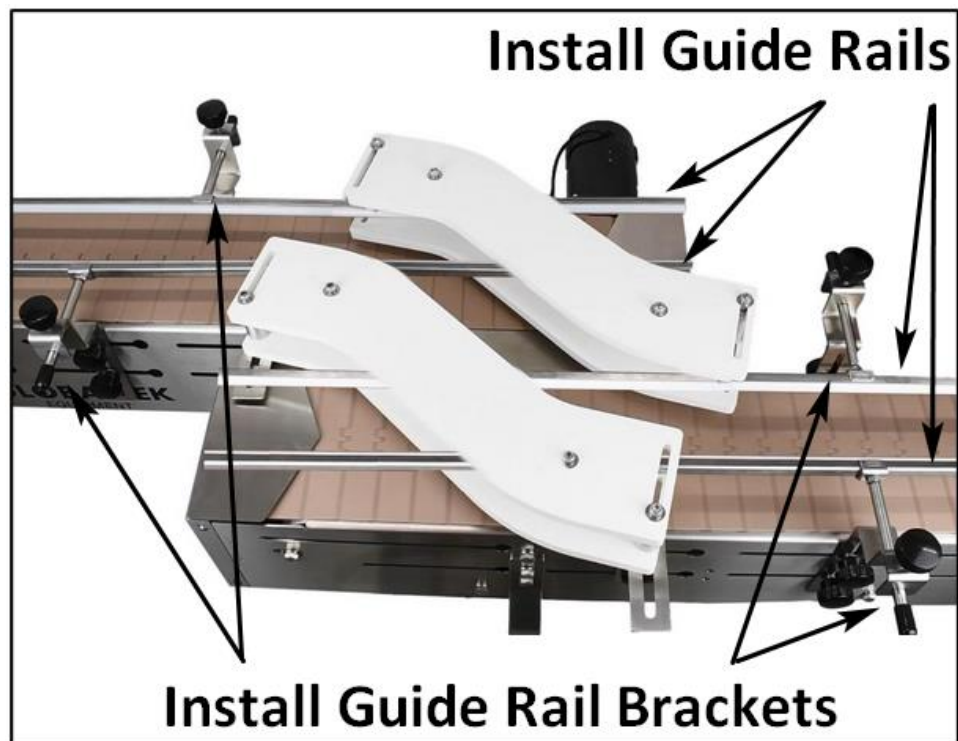
With the screw loose, the gates can slide in and out. Adjust the width of the gates and then tighten the hex screw to lock the new position in place.

23. Check the height of the gates in relation to your product. In our example, the gates should be lowered so that the height of the upper plate of the gate is just about half of the height of the product.

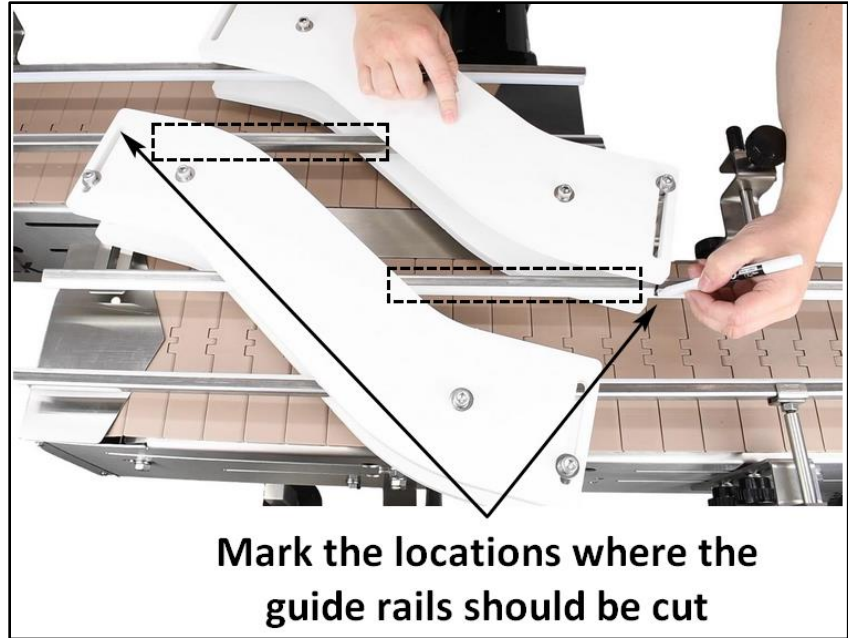


To adjust the height, loosen the fastening knobs on the gate mounting bracket as shown in the image to the right. With the knob loose, the gate can be raised or lowered. Set the height of that gate as desired and then tighten the fastening knob to lock the gate in place.

24. Following the instructions found on pages 24-26 of this manual, install the guide rail brackets and guide rails onto the two conveyors as shown in the image to the right.



25. As can be seen in the image to the right, the two interior guide rails, indicated by the two rectangles, must be cut so that product can flow from one conveyor to the other. Mark the guide rails as shown in the image.



26. Cut the guide rails you marked in step 25 to the appropriate length and angle as shown in the image to the right.



27. After reinstalling the guide rails you cut in step 26, the adjustable transfer system should now look similar to the image below. Installation is now complete.



Troubleshooting:

PROBLEM	POSSIBLE CAUSE	REMEDY
Motor won't run	<ol style="list-style-type: none"> 1. Power off 2. Limit switch activated 3. Blown fuse 	<ol style="list-style-type: none"> 1. Restore power 2. Remove object & adjacent linkage 3. Replace fuse
Motor runs; Belt does not	<ol style="list-style-type: none"> 1. Set screw on drive pulley loose 2. Gear box oil 3. Set screws thru bearing to drive shaft loose 	<ol style="list-style-type: none"> 1. Tighten screw 2. Check oil & refill if required - Repair leak & inspect gears 3. Tighten set screws
Motor runs intermittently	<ol style="list-style-type: none"> 1. Loose wire connection 	<ol style="list-style-type: none"> 1. Check wires
Belts do not run smoothly	<ol style="list-style-type: none"> 1. Excessive slack 2. Drive chain has excessive slack 3. Object under belt 	<ol style="list-style-type: none"> 1. Remove slack by adjusting 2. Remove slack 3. Remove object
Belt squeals while running	<ol style="list-style-type: none"> 1. Slider pan surface dirty 	<ol style="list-style-type: none"> 1. Clean with shela shine polish
Belt does not move	<ol style="list-style-type: none"> 1. Speed control knob loose 	<ol style="list-style-type: none"> 1. Tighten knob

Maintenance Guidelines:

Keeping the conveyor clean, and clear of accumulated debris, is essential to maintain proper operation of the conveyor.

Cleaning Instructions

- Clean stainless steel surfaces with a soft cloth and a mild detergent intended for use with stainless steel.
- Flush with clean water or wipe down with a clean wet cloth, and then wipe dry to avoid streaking and spotting.
- Chlorinated detergents and sanitizing agents will damage stainless steel unless thoroughly flushed or wiped away.

Strong solutions used during the washing or cleaning process should be checked before use to determine their pH levels. Any pH value below 4.5 or above 9.0 will damage the stainless steel and plastic parts of the conveyor. If it is necessary to use a strong solution to clean the conveyor or any of its components, all residues of the cleaning agent should be thoroughly removed by flushing or wiping down with a soft cloth.

To avoid risk of electric shock or fire, or damage to the conveyor, never spray the motor, speed control or any of the electrical connections on the conveyor with water or any other liquid.



WARNING:

To avoid risk of electric shock or fire, or damage to the conveyor, never spray the motor, speed control or any of the electrical connections on the conveyor with water or any other liquid.

Do not spray water onto the flange bearing as this may cause damage to the conveyor.



CAUTION:

Do not spray water onto the flange bearing as this may cause damage to the conveyor.



CAUTION:

This product is not intended for use in washdown environments.

Contact Technical Support:

Globaltek® Equipment

Attn: Repair Dept.

7354 NW 35th Street

Miami, FL 33122

USA

Telephone: (305) 418-9632 / (305) 418-9633

Warranty:

Globaltek® Equipment Inc., dba GlobalTek®, warrants all new machines against defects in material and workmanship from the manufacturer for a period of one (1) year from the date of purchase stated on the invoice.

The company will replace at no cost F.O.B. Miami, Florida, any part proving defective in materials or workmanship. Consumables and wear and tear items such as, but not limited to: Belts, Chains, Bearing, Wheels, Heating Elements, Mechanical Switches, Sealing Belts, Seals, Load cells, Blades, Fuses, etc., are not covered under warranty.

Defectiveness shall be verified by Globaltek® Equipment inspection and at the sole discretion of Globaltek® Equipment. Removal and installation expense shall be the responsibility of the purchaser. Globaltek® Equipment is liable solely for the furnishing of the defective part(s).

Globaltek® Equipment is not liable for consequential damages, such as loss of profit, delays or expenses incurred by failure of said part(s). Failure due to abuse, improper handling, installation, adjustments, operation and/or maintenance, as well as exposure to vibration, and/or exposure to the elements (including dust, sunlight, corrosion, high humidity conditions and temperature extremes) does not constitute failure due to materials or workmanship.

Globaltek® Equipment is not liable or responsible for repair, service, or installation charges, fees, or damages for correcting any defects.

During the applicable limited product warranty period, if a covered product is proven to be defective in workmanship or materials, Globaltek® Equipment will, at its option:

- (1) replace or repair the defective component; or
- (2) replace the product with a comparable product.