INSTALLATION AND MAINTENANCE MANUAL

BELT CONVEYOR
MODEL BS100B

DO NOT OPERATE EQUIPMENT BEFORE READING

ATLANTIS TECHNOLOGIES LLC

Version 2014.1

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INTRODUCTION

This manual has been created to assist with the maintenance, operation and installation of the belt conveyor. It is important that all maintenance personnel are trained properly in operation and maintenance of the belt conveyor. Damage or injury caused by non-compliance with this manual is not the responsibility of Atlantis Technologies LLC.

RECEIVING, INSPECTION AND UNCRATING

1) Compare the bill of lading with what you have received.
2) Examine the equipment for damage during shipping.
3) Immediately report shortage or damages to the vendor and carrier.
4) If damage has occured, obtain signed damage report documentation from the carrier and send a copy to the vendor. **Contact your Atlantis Technologies LLC distributor prior to attempting to modify or repair damaged equipment.**
5) Move all crates to area of installation.
6) Remove crating and packaging.
7) Look for boxes, accessories, bags or components such as fasteners, manuals, guard rails, etc. that may be banded or fastened to the crating material to ensure you do not discard any loose parts (Guards, Fasteners or other components) that were packaged for loose shipping.

ORDERING REPLACEMENT PARTS

Assembly drawings with replacement parts listings have been provided in this manual.

Procedure for ordering replacement parts:

1) Contact your Atlantis Technologies LLC Distributor.
2) Give Conveyor Model Number and Serial Number.
3) Give Part Number and complete description from Parts Listing.
4) Give type of drive configuration. For instance: 8” End Drive, 8” Center Drive, etc.
5) Tell us if you are in a breakdown situation.

SAFETY INFORMATION - INSTALLATION

GUARDS AND GUARDING

Interfacing of Equipment

When two or more pieces of equipment are interfaced, special attention shall be given to the interfaced area to ensure the presence of adequate guarding and safety devices.

Guarding Exceptions

Wherever conditions prevail that would require guarding under this standard but such guarding would render the conveyor unusable, seek guidance from your safety professional.

Overhead conveyors for which guarding would render the conveyor unusable or would be impracticable, shall have prominent and legible warnings posted in the area or on the equipment and where feasible lines shall be painted on the floor delineating the danger area.

When a conveyor passes over a walkway, roadway or work station, it is considered guarded by location if all moving parts are at least 2.44 meters (8 feet) above the floor or walking surface or are otherwise located so that personnel cannot inadvertently come in contact with hazardous moving parts. Check your state and local laws and codes for overall compliance.

Although overhead conveyors may be guarded by location, spill guards, pan guard or equivalent shall be installed if material may fall off the conveyor and endanger personnel.

HEADROOM CLEARANCE

When conveyors are installed above exit passageways, aisles or corridors, there shall be provided a minimum clearance of 2.00 meters (6 feet 8 inches) measured vertically from the floor or walking surface to the lowest part of the conveyor or guards.

Where system function will be impaired by providing the minimum clearance of 2.00 meters (6 feet 8 inches) through an emergency exit, alternate passageways should be provided.

It is permissible to allow passage under conveyors with less than 2.00 meters (6 feet 8 inches) clearance from the floor for other than emergency exits if a suitable warning indicates low headroom. Check your state and local laws and codes for overall compliance.

SAFETY INFORMATION - OPERATION

Only trained, qualified personnel shall be permitted to operate a conveyor. Training shall include instruction in operation under normal conditions and emergency situations.

Where safety is dependent upon stopping / starting devices, they shall be kept free of obstructions to permit access.

The area around loading and unloading points shall be kept clear of obstructions that could endanger personnel.

Do not ride the load-carrying element of a conveyor under any circumstances. Warning labels reading **“DO NOT RIDE CONVEYOR”** shall be affixed by the owner of the conveyor.

Personnel working on or near a conveyor shall be instructed as to the location and operation of pertinent stopping devices.

A conveyor shall be used to transport only a load that it is designed to handle safely.

Under no circumstances shall the safety characteristics of the conveyor be altered.

SAFETY INFORMATION - OPERATION (Continued)

Routine inspections and preventative and corrective maintenance programs shall be conducted to ensure that all safety features and guards are retained and functioning properly. Inspect equipment for safety labels. Make sure personnel are aware of and follow safety label instructions.

Alert all personnel to the potential hazard of entanglement in conveyors caused by items such as long hair, loose clothing and jewelry.

SAFETY INFORMATION - MAINTENANCE

ATTENTION: ELECTRICAL POWER MUST BE TURNED OFF AND LOCKED / TAGGED OUT following your company's machine specific procedures when servicing the conveyor to prevent accidental restarting by other persons or interconnecting equipment.

Maintenance and service shall be performed by trained, qualified personnel only.

Where lack of maintenance and service would cause a hazardous condition, the user shall establish a maintenance program to ensure that conveyor components are maintained in a condition that does not constitute a hazard to personnel.

No maintenance or service shall be performed when a conveyor is in operation. See "Lubrication" and "Adjustments or Maintenance/Service During Operation" for exceptions.

When a conveyor is stopped for maintenance or service, the starting devices, prime mover, powered accessories or electrical must be locked / tagged out in accordance with your company machine specific formalized procedure designed to protect all persons or groups involved with the conveyor against an unexpected restart. Personnel should be alerted to the hazard of stored energy, which may exist after the power source is locked/tagged out. All safety devices and guards shall be replaced before starting equipment for normal operation.

ADJUSTMENTS OR MAINTENANCE/SERVICE DURING OPERATION

When adjustments or maintenance must be done while equipment is in operation, only trained, qualified personnel who are aware of the hazards of the conveyor in motion shall be allowed to make adjustments, perform maintenance or service.

Conveyors shall NOT be maintained or serviced while in operation unless proper maintenance or service requires the conveyor to be in motion. If conveyor operation is required, personnel shall be made aware of the hazards and how the task may be safely accomplished.

GUARDS AND SAFETY DEVICES

Guards and safety devices shall be maintained in a serviceable and operational condition. Warning signs are the responsibility of the owner of the conveyor and must be maintained in a legible / operational condition.

LUBRICATION

Conveyors shall **NOT** be lubricated while in operation unless it is impractical to shut them down for lubrication. Only trained and qualified personnel who are aware of the hazards of the conveyor in motion shall be allowed to lubricate a conveyor that is operating.

Where the drip of lubricants or process liquids on the floor constitutes a hazard, drip pans or other means of eliminating the hazard must be provided by purchaser(s).

SAFETY INFORMATION - ELECTRICAL

ELECTRICAL CODE

All electrical installations and wiring shall conform to federal, state and local codes.

When conveyor operation is not required for a maintenance procedure, electrical power must be turned off and locked / tagged out following your company's machine specific procedure.

CONTROL STATIONS

Control stations should be so arranged and located that the operation of the affected equipment is visible from them. Control stations shall be clearly marked or labeled to indicate the function controlled.

A conveyor that would cause injury when started shall not be started until personnel in the area are alerted by a signal or by a designated person that the conveyor is about to start.

Where system function would be seriously hindered or adversely affected by the required time delay, or where the intent of the warning may be misinterpreted (i.e., a work area with many different conveyors and allied devices), a clear, concise and legible warning sign needs to be provided. The warning sign shall indicate that conveyors and allied equipment may be started at any time, that danger exists and that personnel must keep clear. These warning signs shall be provided along the conveyor at areas not guarded by position or location.

Remotely and automatically controlled conveyors, and conveyors where operator stations are not manned or are beyond voice or visual contact from drive areas, loading areas, transfer points and other potentially hazardous locations on the conveyor path not guarded by location, position or guards shall be furnished with emergency stop buttons, pull cords, limit switches or similar emergency stop devices.

All such emergency stop devices shall be easily identifiable in the immediate vicinity of such locations unless guarded by location, position or guards. Where the design, function and operation of such conveyor clearly is not hazardous to personnel, an emergency stop device is not required.

The emergency stop device shall act directly on the control of the conveyor concerned and shall not depend on the stopping of any other equipment. The emergency stop devices shall be installed so that they cannot be overridden from other locations.

Inactive and unused actuators, controllers and wiring should be removed from control stations and panel board, together with obsolete diagrams, indicators, control labels and other material that might confuse the operator.

SAFETY DEVICES

All safety devices, including wiring of electrical safety devices, shall be arranged to operate such that a power failure or failure of the device itself will not result in a hazardous condition.

Conveyor controls shall be so arranged that, in case of emergency stop, manual reset or start at the location where the emergency stop was initiated shall be required for the conveyor(s) and associated equipment to resume operation.

Before restarting a conveyor that has been stopped because of an emergency, an inspection of the conveyor shall be made and the cause of the stoppage determined. The starting device and electrical power must be turned off and locked / tagged out according to your company's machine specific procedure before any attempt is made to remove the cause of the stoppage, unless operation is necessary to determine the cause or to safely remove the stoppage.

Replace all safety devices, guards and guarding prior to equipment start-up.

INSTALLATION

FLOOR SUPPORT INSTALLATION

Floor supports are tyically mounted at Drive, Tail and across splice locations. Fasten leg supports to conveyor sections with the provided fasteners as shown (Figure 7.1).

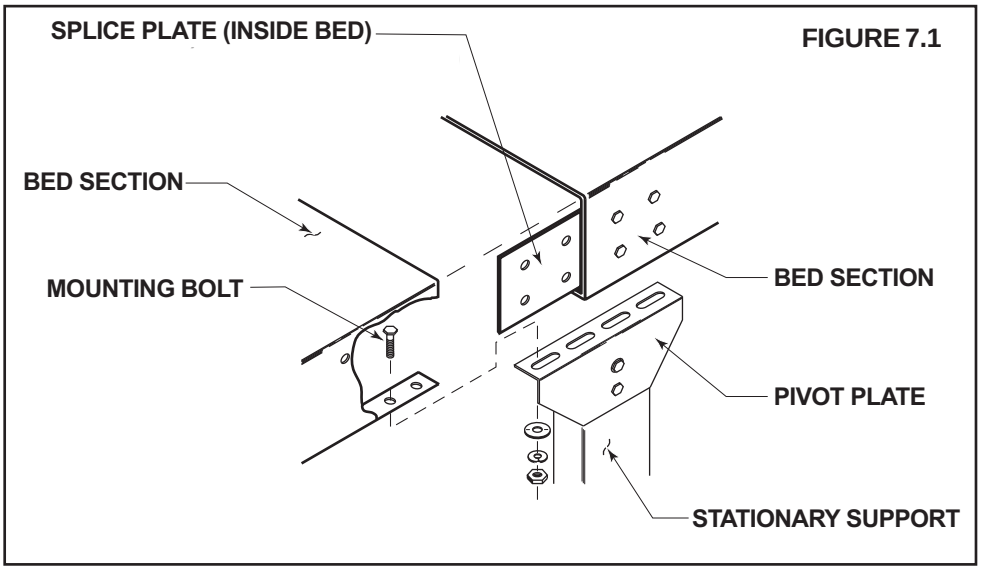


FIGURE 7.1

CEILING HANGERS INSTALLATION

Ceiling hangers may have been supplied in lieu of floor supports, if conveyors are to be used in an overhead application. Figure 7.2 illustrates how ceiling hangers mount to a conveyor section. Mount ceiling hangers on each section joint. See safety information regarding overhead mounted conveyors.

NOTE: When installing ceiling hangers, refer to local building codes to ensure that materials comply. Only experienced material handling installers should attempt to install conveyors.

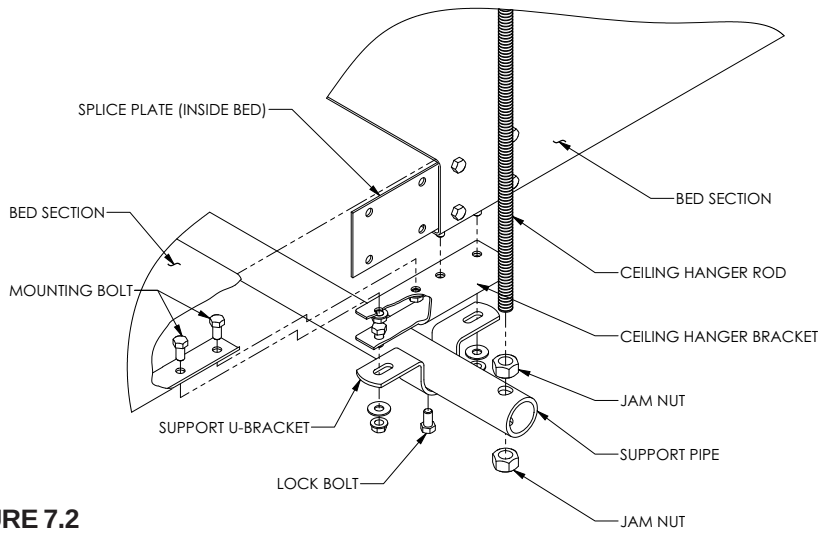


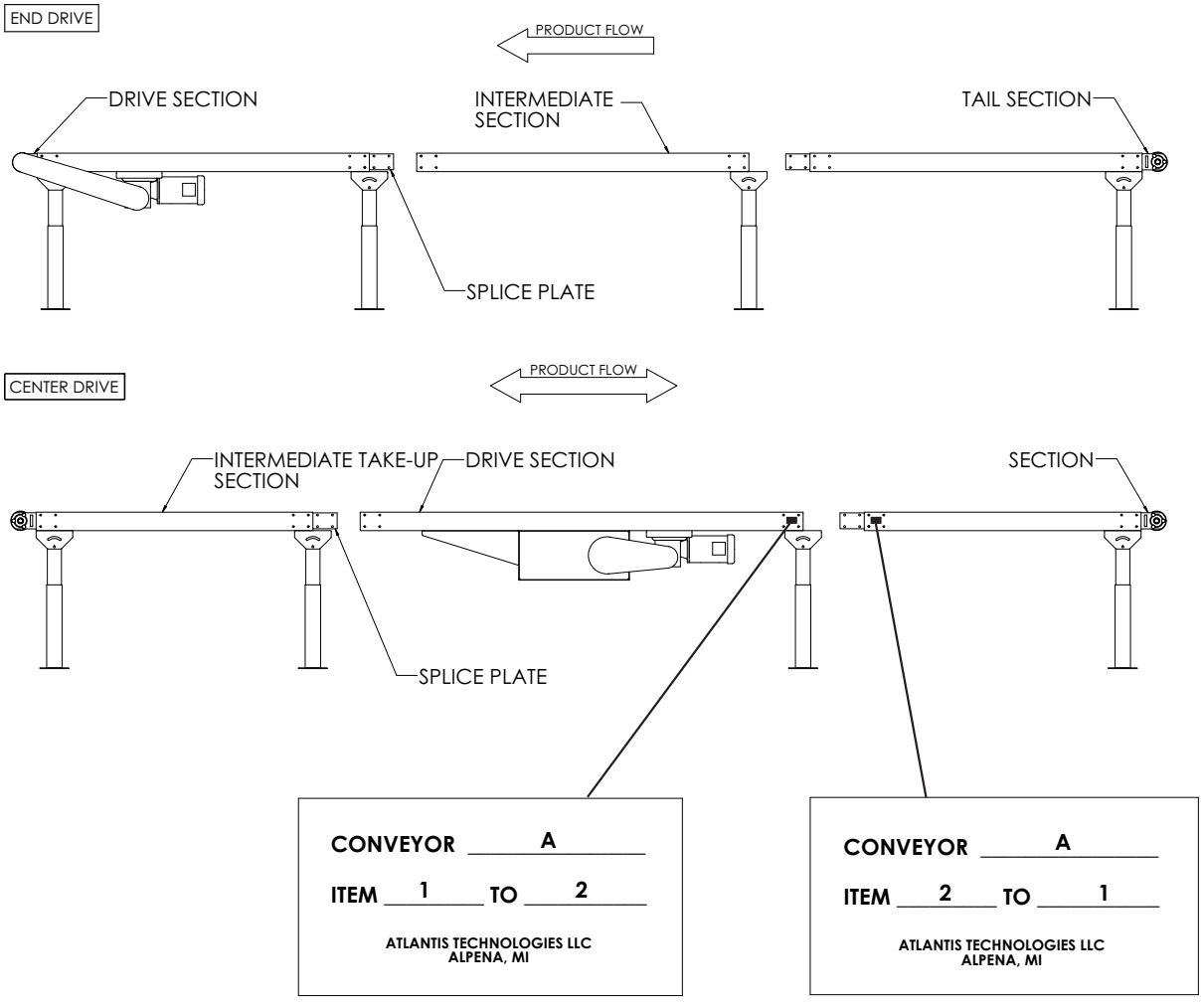
FIGURE 7.2

INSTALLATION

CONVEYOR SET-UP

1) Locate center line of the conveyor by marking a chalk line on floor.
2) Determine flow of conveyor related to drive.
3) Position the conveyor sections in the proper order (See Figure 8.1).
4) Fasten floor or ceiling supports to Drive, Intermediate and Tail sections.
5) Use splice and pivot plates to fasten conveyor sections together.
6) Check to ensure that the conveyor is square and level across the length. Adjust leg supports and/or ceiling hangers as necessary to acheive desired height.
7) Wire motor and install controls.
8) Install the belt and track belt per instructions on page 10-12.

FIGURE 8.1



MATCH-MARK LABELS

INSTALLATION

BELT INSTALLATION

The belt has been cut and laced to the proper length at the manufacturing facility and is ready for installation. To install follow these steps:

1) Loop belt over snub rollers, return rollers and end pulleys as shown in **Figure 9.1**. Bring laced ends together and thread lacing pin through loops.
2) Adjust the take-up or tail pulley to remove excess slack from the belt. Keep the pulley square by moving both tension bolts an equal amount. Maintain just enough tension so that the drive pulley will not slip when carrying the rated load. **Note: Overtightening the belt will make it difficult to track and may damage the belt.**
3) Check for squareness of all frame sections, end units, drive units, etc. All snubber rollers and pulleys must be squared with the frame before making any belt adjustments.
4) Use belt tracking instructions to properly track the belt.

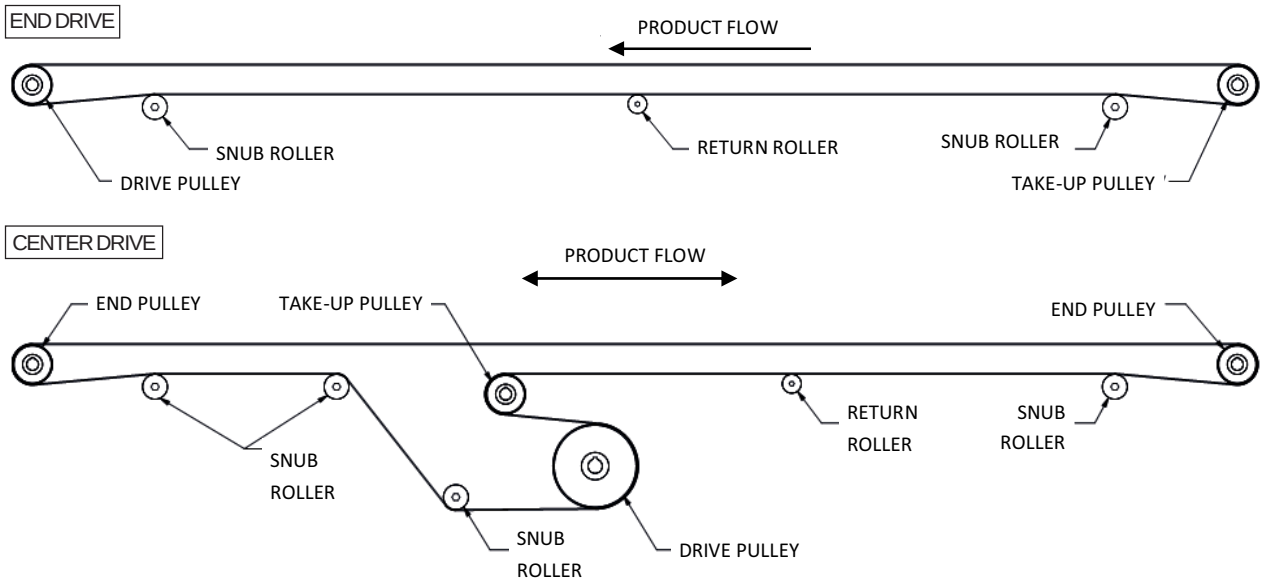


FIGURE 9.1

OPERATION

START-UP OVERVIEW

1) Ensure that conveyor sections, leg supports, etc. were installed properly.
2) Ensure that drive chains and sprockets are installed, aligned and tensioned properly.
3) Ensure set screws are tight in sprockets, bearings and pulleys.
4) Ensure that all drive, mounted bearings and fasteners are securely tighten.
5) Ensure that all motor and control wiring is connected properly.
6) Ensure that the conveyor is not loaded with product.
7) Ensure that gearboxes are properly filled with the correct amount of lubricant or that they were factory filled with lubricant.
8) Ensure that the gearbox has necessary vent plugs installed (if applicable).

BELT TRACKING

The belt is tracked by adjusting snub rollers, return rollers, tail pulley and drive pulley. The initial goal is to center the belt on pulley at infeed end of conveyor, then move to discharge end if needed. All adjustments should be made in small increments (1/16 in. at a time). Allow adequate time for the belt to react to each adjustment. It may take several complete belt revolutions to see the effect of each adjustment. **CONVEYOR POWER MUST BE TURNED OFF WHEN MAKE ANY ADJUSTMENTS.** The same tracking principles apply to conveyors supplied with end drives, center drives or underside take-ups.

PRIOR TO TRACKING

1. Make sure conveyor frame is cross square.
2. Confirm that conveyor is level across its width and length.
3. Make sure snubber rollers, return rollers, tail pulley and drive pulley are square with the frame. Reference dimension “A” in figures 12.1, 12.2 and 12.3.
4. Confirm belt has been properly threaded through the conveyor.

BELT TRACKING PROCEDURE FOR END DRIVE

1. Run conveyor for a few minutes so the belt can take its position. **Stop conveyor immediately if belt rubs against side of conveyor.** Re-check all items covered under “Prior to Tracking”.
2. If belt on infeed end shifts to one side as illustrated, adjust snubber roller (C) as shown to steer belt to center of take-up pulley (B). See Figure 10.1.
3. If belt is riding at the center of take-up pulley (B) on infeed but is not at the center of drive pulley (A) on discharge, adjust drive pulley (A) as shown.
4. Adjusting drive pulley (A) may throw off alignment of take-up pulley (B). Repeat steps 2 and 3 as necessary.
5. If belt continues to track improperly, re-check all items covered under “Prior to Tracking”

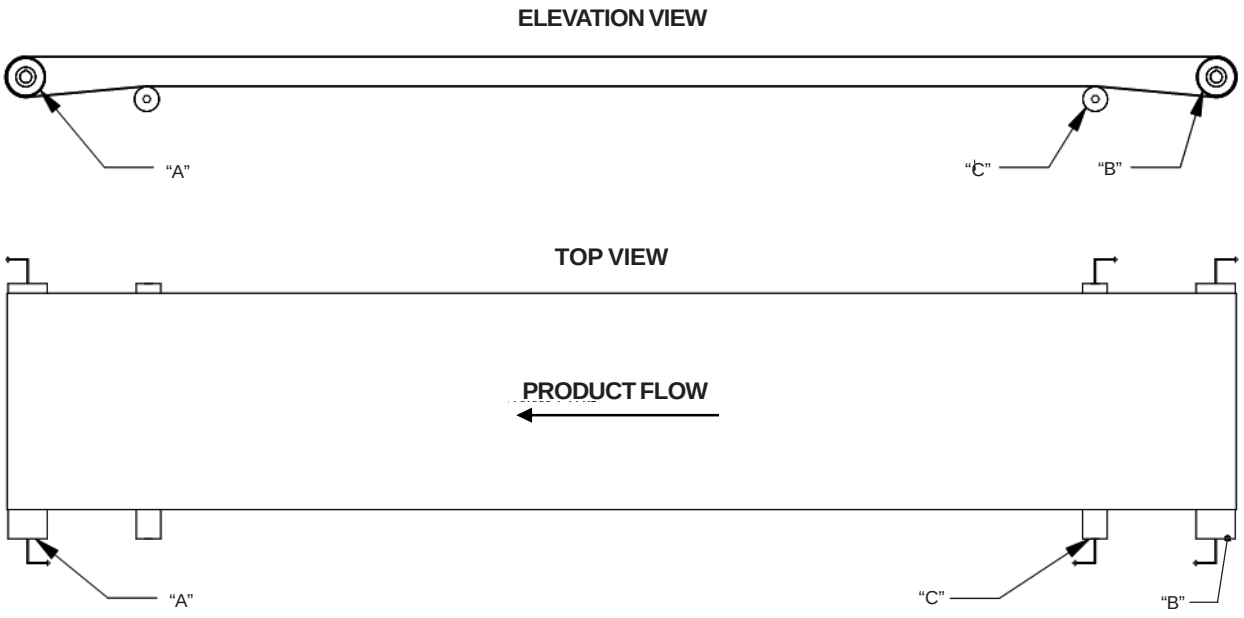


FIGURE 10.1

BELT TRACKING

BELT TRACKING PROCEDURE FOR CENTER DRIVE (FORWARD SERVICE)

1. Run conveyor in FORWARD direction for a few minutes so the belt can take its position. **Stop conveyor immediately if belt rubs against side of conveyor.** Re-check all items under “Prior to Tracking”.
2. If belt on infeed end shifts to one side as illustrated, adjust snubber rollers (D) as shown to steer belt to center of drive pulley (B) which then will center belt on end pulley (G). See Figure 12.1.
3. If belt is still not riding at center of end pulley (G), adjust snubber roller (C) as shown.
4. If belt is riding at center of end pulley (G) on infeed but not at the center of end pulley (F) on discharge, adjust end pulley (F) as shown. Note: Care is required as adjusting this pulley mat cause the belt to travel to the opposite side in REVERSE service.
5. Repeat steps 2 through 4 as necessary.
6. If belt continues to track improperly, re-check all items covered under “Prior to Tracking”

BELT TRACKING PROCEDURE FOR CENTER DRIVE (REVERSE SERVICE)

1. Run conveyor in REVERSE direction for a few minutes so the belt can take its position. **Stop conveyor immediately if belt rubs against side of conveyor.** Re-check all items under “Prior to Tracking”.
2. If belt on infeed end shifts to one side as illustrated, adjust take-up (A) as shown to steer belt to center of drive pulley (B) which then will center belt on end pulley (F). See Figure 12.1
3. If belt is still not riding at center of end pulley (F), adjust snubber roller (E) as shown.
4. If belt is riding at the center of end pulley (F) on infeed but not at the center of end pulley (G) on discharge, adjust end pulley (G) as shown. Note: Care is required as adjusting this pulley may cause the belt to travel to the opposite side in FORWARD service.
5. Repeat steps 2 through 4 as necessary.
6. If belt continues to track improperly, re-check all items covered under “Prior to Tracking”

Note: Reversing belts may require that the belt run slightly off center to one side in the forward direction and to the opposite side in the reverse direction. This is due to the nature of the belt.

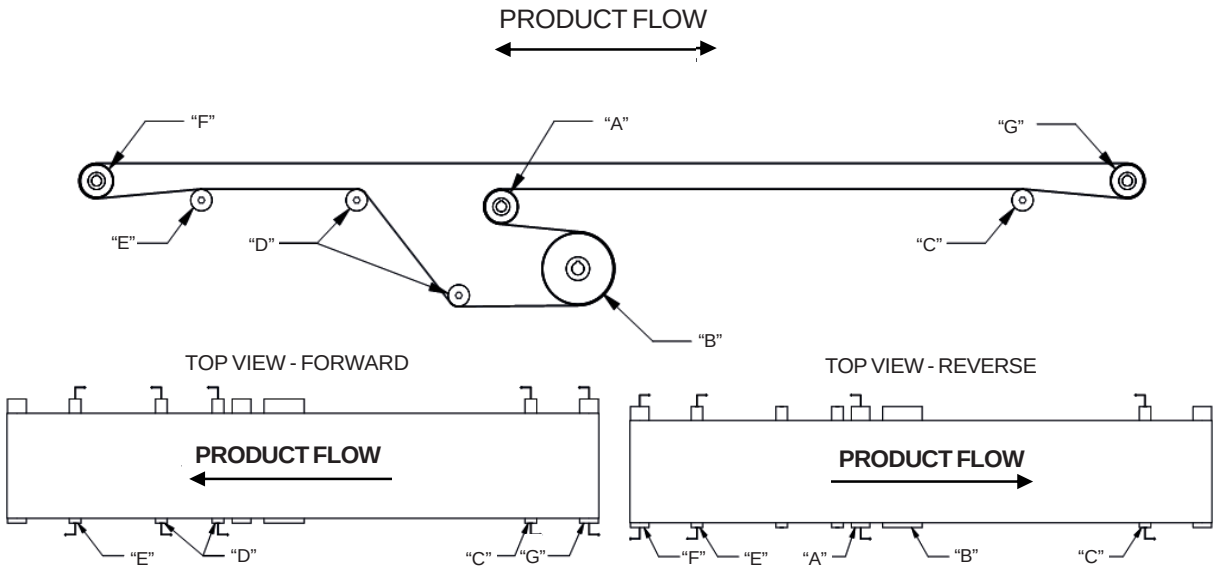


FIGURE 12.1

BELT TRACKING

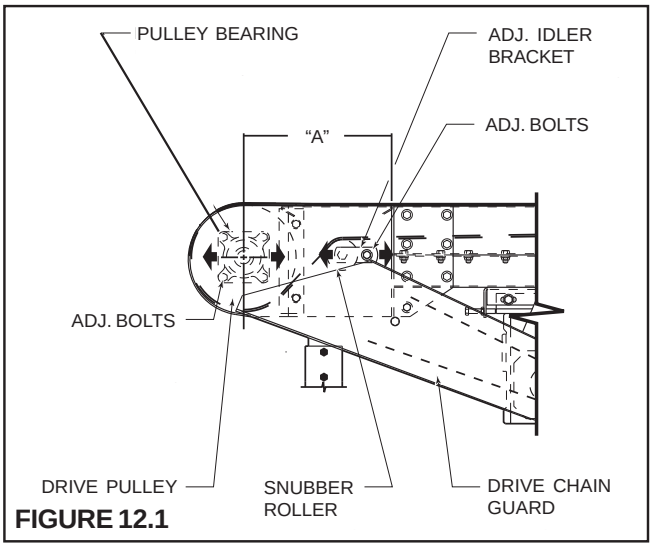
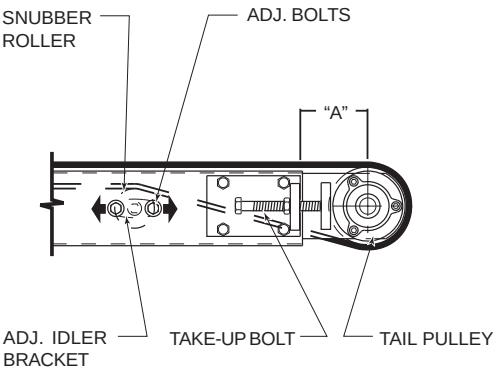


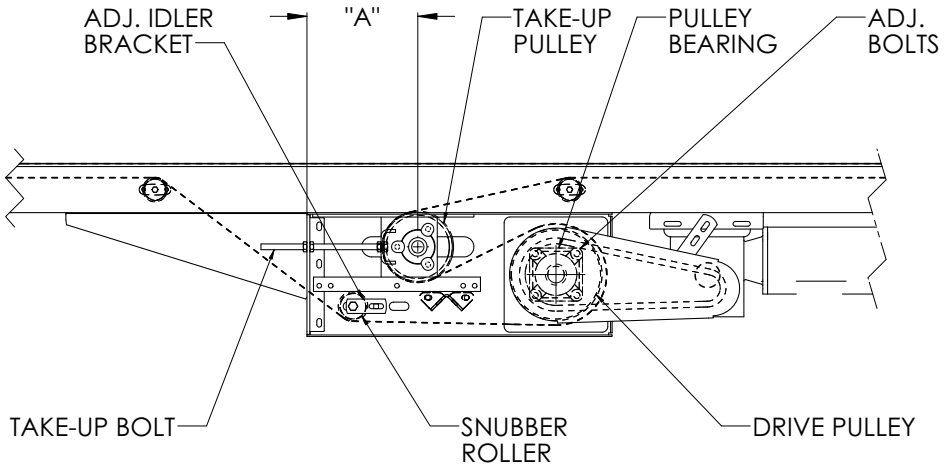
FIGURE 12.1

FIGURE 12.2



TAIL PULLEY SQUARING COMPONENTS

FIGURE 12.3



CENTER DRIVE OR UNDERSIDE PULLEY SQUARING COMPONENTS

MAINTENANCE

LUBRICATION

Chain Lubrication
Proper maintenance of any chain should include correct lubrication, periodic inspection, and proper adjustment for normal wear. Periodic inspection of the chain and sprockets is required to detect any deviation from normal wear before serious damage takes place. The cost of such inspection is repaid many times in extended chain life. No general rule can be given for the frequency of inspection. The frequency should be influenced by conditions of operation.

Suggested Lubrcation
Only high quality oil should be used to lubricate chain. Neither heavy oil nor grease is suitable. The lubricant should have a viscosity to enable it to reach internal surfaces under normal conditions. Lubricants suggested for specific ambient temperatures and chain ranges are given in the table below.

	Temperature		
Chain No.	15 - 35 Deg (F)	35 - 105 Deg (F)	105 - 120 Deg (F)
ANSI 25 - 50	SAE10W	SAE20	SAE30
ANSI 60 - 100	SAE20	SAE30	SAE40

CHAIN ALIGNMENT AND TENSIONING

Periodically check the drive chain and sprocket for proper tension and alignment. Extensive wear to drive component can be caused by improper chain tension and alignment. Check chain tension to be certain the slack span has an approximate 2% mid-span movement. (See Figure 14.5)

DRIVE CHAIN TENSION ADJUSTMENT PROCEDURE: (See Figure 13.1 and Figure 13.2)

1. Remove chain guard.
2. Place a straight edge across the face of both drive sprockets to check alignment. Loosen set screws and adjust as needed. Re-tighten set screws.
3. To adjust chain tension, loosen bolts that fasten motor base to mounting angles. (Both sides of the conveyor)
4. Tighten take-up bolts until desired chain tension is reached. Re-tighten mounting bolts.
5. Lubricate chain per lubrication instructions.
6. Replace chain guard so that it does not interfere with drive.

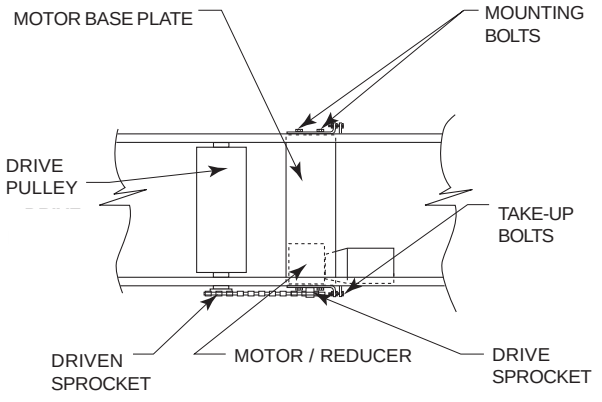


FIGURE 13.1

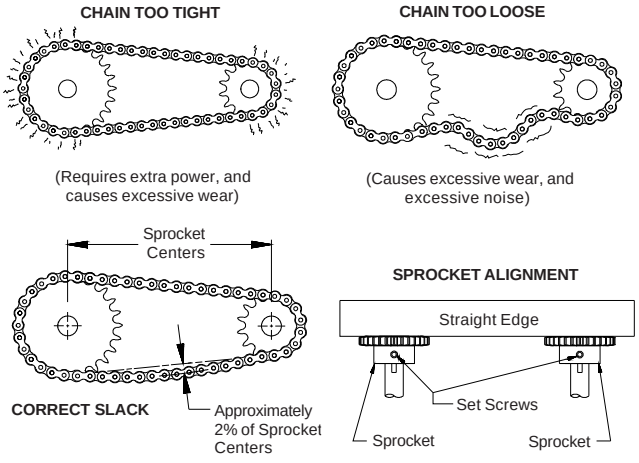


FIGURE 13.2

TROUBLE SHOOTING

TROUBLE	CAUSE	SOLUTION
Conveyor motor will not start or motor quits frequently	1. Motor is overloaded 2. Motor is drawing excessive current	1. Inspect conveyor for overloading and remove excessive load.
Excessive wear on drive sprockets and drive chain	1. Inadequate amount of lubrication on drive chain. 2. Misalignment of sprockets. 3. Loose Chain	1. Replace chain and sprockets. Apply adequate amount of lubrication to chain. 2. Align Sprockets 3. Tighten Chain
Loud popping or grinding noise.	1. Defective bearing. 2. Loose set screws in spockets or bearing. 3. Improper drive chain tension.	1. Replace defective bearing. 2. Tighten loose set screws. 3. Properly tension drive chain.
Motor or Reducer is overheating	1. Overloaded conveyor. 2. Voltage to conveyor is too low. 3. Insufficient amount of lubricant in reducer.	1. Check to ensure that the conveyor belt is not over capacity and reduce load. 2. Have a qualified electrian test the voltage and correct if necessary. 3. Add lubricant to reducers manufacturer recommended level.
Belt does not move, but drive is running.	1) Overloaded conveyor. 2) Belt is too loose. 3) Lagging on drive pulley is worn.	1) Check to ensure that the conveyor belt is not over capacity and reduce load. 2) Tighen belt using belt take-ups. 3) Replace drive pulley lagging and tighten belt.
Belt tracks off at one point along conveyor length	1) One or more idlers near trouble point are out of line. 2) Conveyor sections might be out of square or level. 3) Residue/debris build up on pulleys or idlers.	1) Adjust the idlers near the trouble point. 2) Make necessary adjustments to square the conveyor sections. 3) Remove residue/debris from pulleys and idlers.
Belt tracks to one side at drive or tail pulleys	1) Drive pulley, tail pulley or idlers located near the pulley are not aligned properly or square with the conveyor bed.	1) Adjust pulleys and idlers as necessary.
Belt tracks to one side.	1) Conveyor not level or straight. 2) Residue/debris build up on pulleys or idlers.	1) Ensure that belt sections are aligned and leveled properly. 2) Remove residue/debris from pulleys and idlers.

MAINTENANCE SCHEDULE

DAILY MAINTENANCE

- Inspect all conveyors to ensure that all guarding is securely in place.
- Inspect belt tracking for a minimum of (3) full belt revolutions.

WEEKLY MAINTENANCE

- Inspect conveyor for loose bolts and set screws.
- Inspect bearings, gear reducers, motors and chains for excessive noise or heat.
- Inspect belt to ensure that there is not excessive wear and that all splices are intact.
- Inspect belt tension. The tension should be enough to:
  - Prevent slippage between drive pulley (sheaves for spurs) and belt under a full load.
  - Force belt to conform to the crown on crowned pulleys.
- Inspect rollers to ensure that they rotate freely without excessive noise.

MONTHLY MAINTENANCE

- Inspect oil level in reducer. Fill if necessary.
- Inspect reducer for leaking seals.
- Inspect conveyor for loose bolts.
- Inspect drive chains, jump chains and sprockets for wear, alignment and proper chain tension.
- Lubricate pulley shaft bearings. Use No. 2 lithium base grease or equivalent.

QUARTERLY MAINTENANCE

- Grease all pulley shaft bearings.
- Inspect conveyors for worn or broken drive belts. Replace as necessary. If belt shows signs of abrasion, check for hindrance with the belt or foreign object in the roller groove.

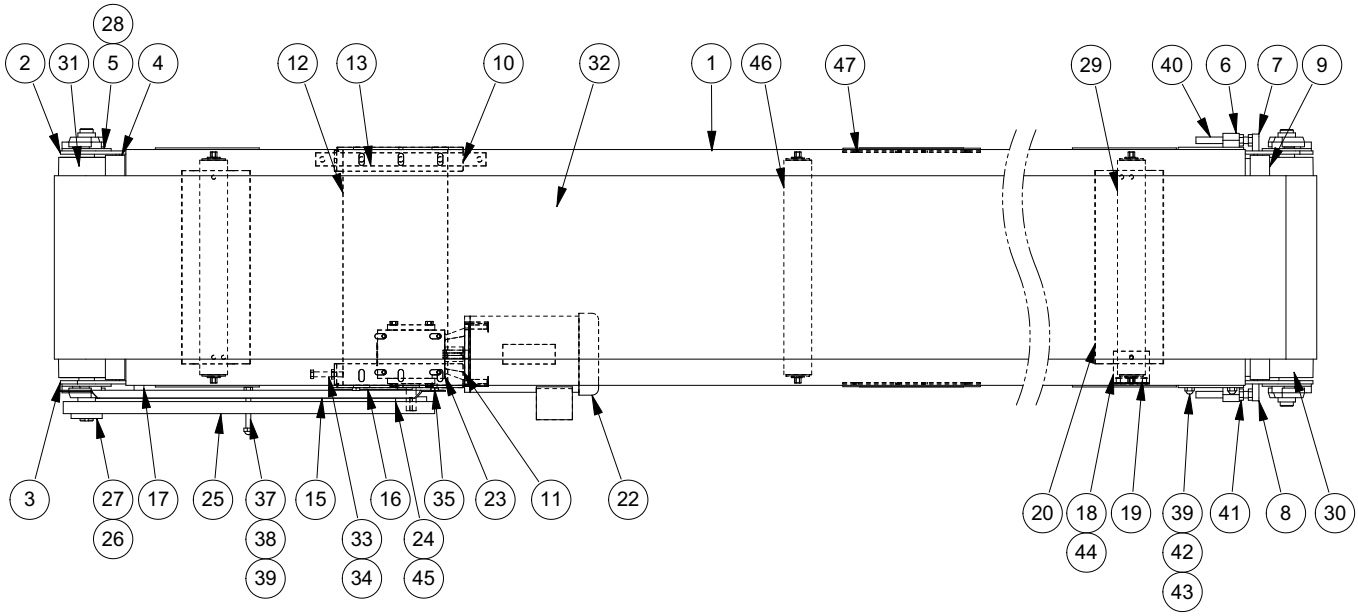
SEMI-ANNUAL MAINTENANCE

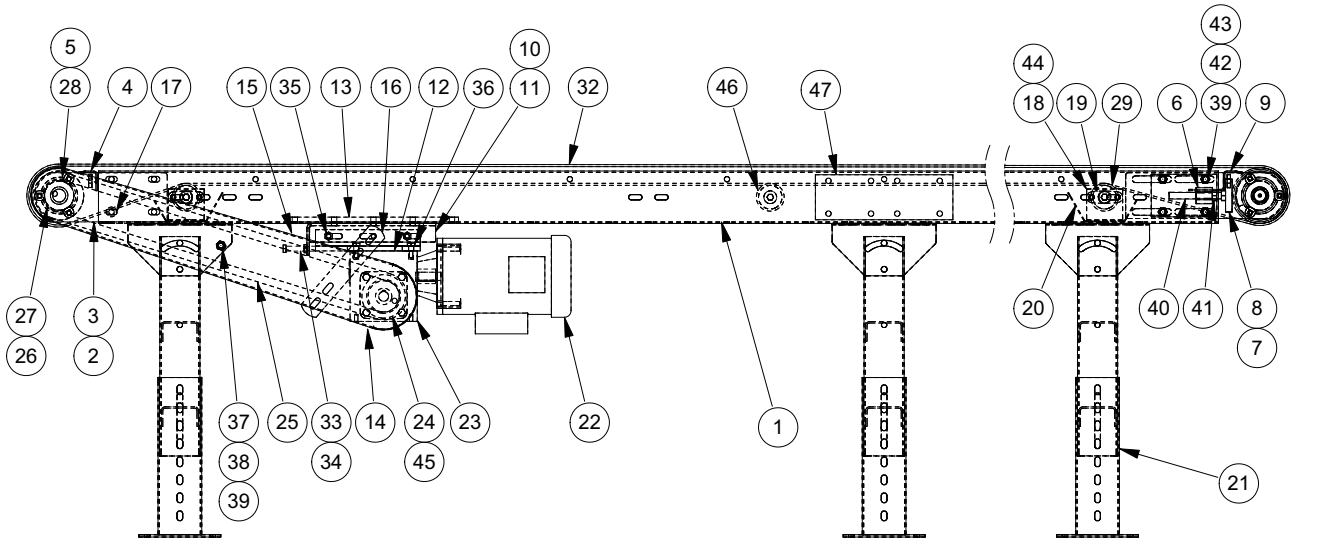
- Tighten all bearing set screws if not completely tight.

ANNUAL MAINTENANCE

- Change oil in reducers

REPLACEMENT PARTS - PARTS DRAWING AND LIST (4” END DRIVE)

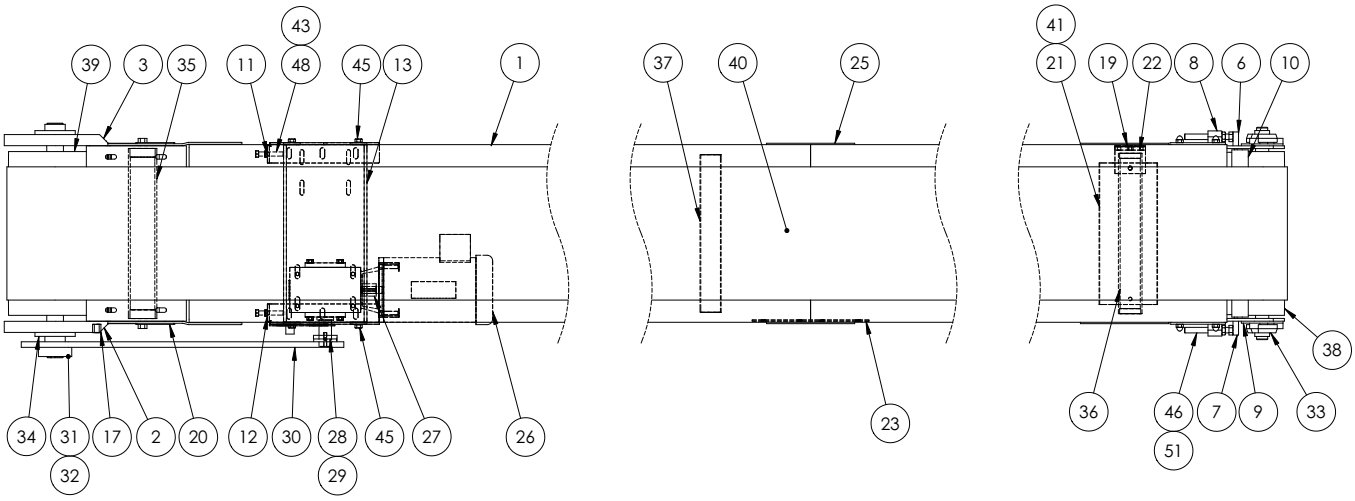


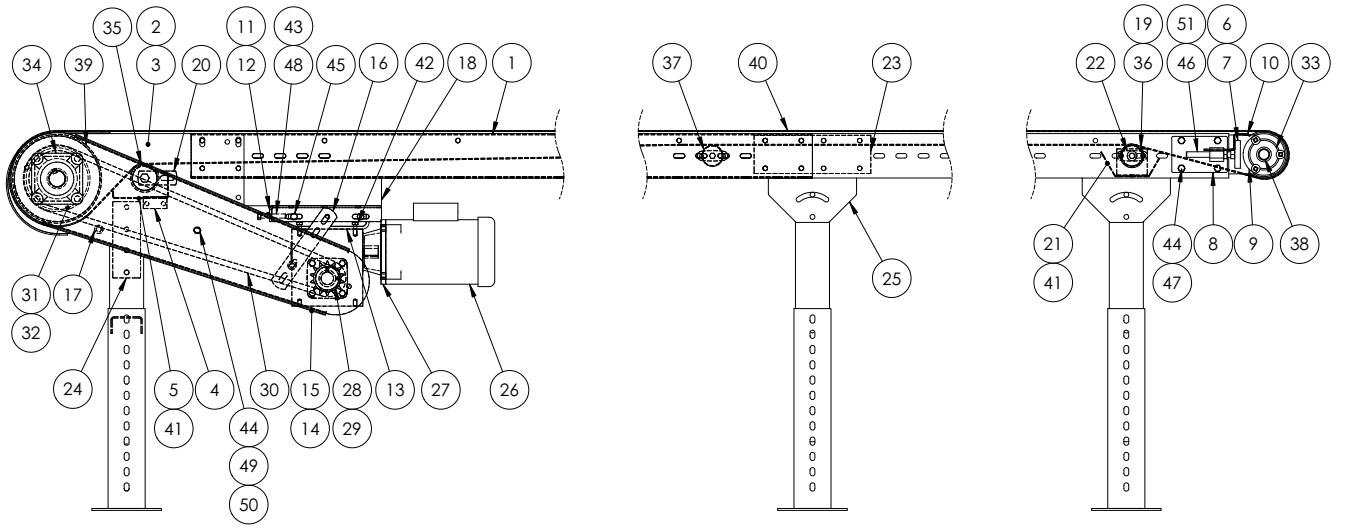


DET.	PART NO.	DESCRIPTION
1	SPECIFIC TO ORDER	SLIDER BED
2	ATL-10760-RH	DRIVE PLATE WELDMENT - RIGHT HAND
3	ATL-10760-LH	DRIVE PLATE WELDMENT - LEFT HAND
4	ATL-11085-OAW	NIP POINT GUARD - DRIVE END
5	ATL-10025	BEARING SPACER
6	ATL-10729	ATTACHMENT PLATE WELDMENT
7	ATL-10775-RH	TAKE-UP WELDMENT - RIGHT HAND
8	ATL-10775-LH	TAKE-UP WELDMENT - LEFT HAND
9	ATL-10086-OAW	NIP POINT GUARD - TAIL END
10	ATL-12850-RH	MOTOR BASE SUPPORT ANGLE - RIGHT HAND
11	ATL-12850-LH	MOTOR BASE SUPPORT ANGLE - LEFT HAND
12	SPECIFIC TO ORDER	MOTOR BASE WELDMENT
13	ATL-10781	REDUCER BASE REINFORCEMENT BAR
14	ATL-10769	CHAIN GUARD FRONT WELDMENT
15	ATL-10773	CHAIN GUARD BACK PLATE - LH
16	ATL-10780	CHAIN GUARD MOUNTING BAR
17	ATL-10774	SPACER - 3/4" OD X 7/16" ID X 3/8" L.
18	ATL-10011	SNUB ROLLER GUARD MOUNTING BRACKET
19	ATL-10024	RETURN ROLLER BRACKET
20	ATL-11096-OAW	SNUB ROLLER GUARD
21	SPECIFIC TO ORDER	SMS FLOOR SUPPORT
22	SPECIFIC TO ORDER	MOTOR
23	SPECIFIC TO ORDER	REDUCER
24	SPECIFIC TO ORDER	DRIVE SPROCKET (REDUCER)

DET.	PART NO.	DESCRIPTION
25	SPECIFIC TO ORDER	DRIVE CHAIN - RC50 WITH CONNECING LINK
26	ATL-10743	SHAFT KEY - 1/4" SQ X 1 1/4" LG
27	SPECIFIC TO ORDER	DRIVEN SPROCKET (DRIVE PULLEY)
28	ATL-10005	BEARING: 3-BOLT FLANGE, 1" BORE
29	ATL-10727-BF	SNUBBER ROLLER: 2 1/8" OD
30	ATL-12910-FL	4" TAIL PULLEY
31	ATL-12912-FL	4" DIA. DRIVE PULLEY (LAGGED - 4-1/2" DIA. FINISHED)
32	SPECIFIC TO ORDER	BELT WITH LACING
33	ATL-10787	TAKE-UP BOLT: 3/8-16 X 2-1/4" L
34	ATL-10742	HEX JAM NUT: HEAVY, 3/8-16
35	ATL-10749	HEX HEAD BOLT: 3/8-16 X 1" L. (GRADE 8)
36	ATL-10789	HEX HEAD BOLT: 5/16-18 X 1" L. (GRADE 8)
37	ATL-10788	HEX HEAD BOLT: 3/8-16 X 3-1/4" L.
38	ATL-10790	HEX JAM NUT: 3/8-16
39	ATL-10748	ACORN NUT: 3/8-16
40	ATL-10750	TAKE-UP BOLT: 1/2-13 - 4" LONG
41	ATL-10791	HEX JAM NUT: 1/2-13
42	ATL-10751	SHOULDER BOLT: 1/2" DIA. X .312" L
43	ATL-10783	SPACER: TAKE UP, 1/2" OD X 5/16" L
44	ATL-10747	U-TYPE SPEED NUT: 1/4-20
45	SPECIFIC TO ORDER	SHAFT KEY - 3/16" SQ X 1" LG
46	ATL-10728-BF	RETURN ROLLER: 1.9" OD
47	ATL-10023	SPLICE PLATE

REPLACEMENT PARTS - PARTS DRAWING AND LIST (8” END DRIVE)

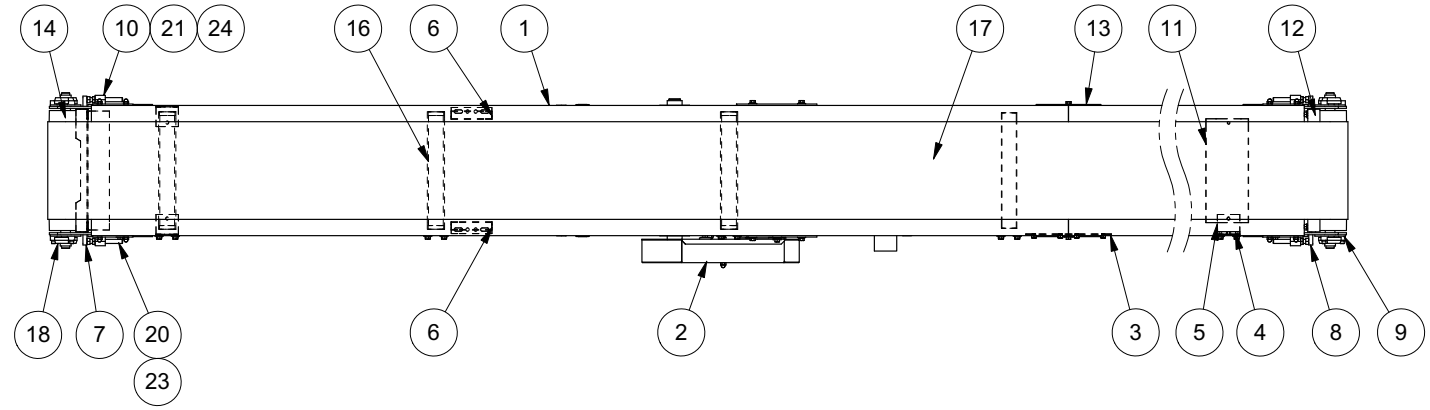


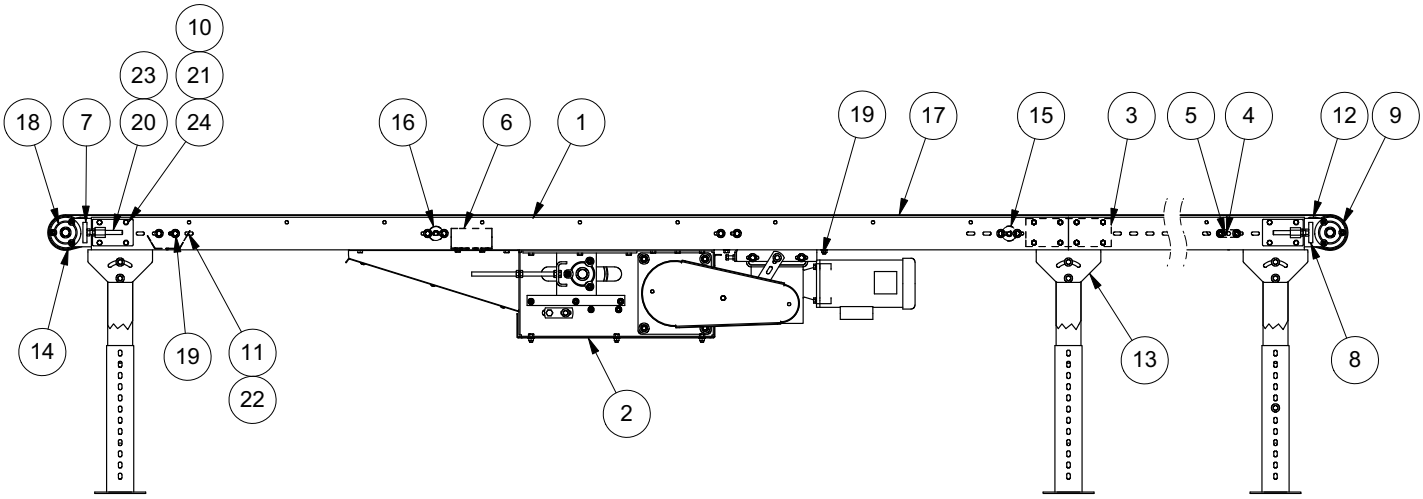


DET.	PART NUMBER	DESCRIPTION
1	SPECIFIC TO ORDER	BED SECTION
2	ATL-11110-BW	DRIVE SHELL WELDMENT - L.H. DRIVE
3	ATL-11077-LH	REMOVABLE DRIVE PLATE WELDMENT - L.H. DRIVE
4	ATL-11083	SNUB ROLLER GUARD MOUNTING BRACKET
5	ATL-11111-BW	SNUB ROLLER GUARD - DRIVE END
6	ATL-10775-RH	TAKE-UP WELDMENT - R.H.
7	ATL-10775-LH	TAKE-UP WELDMENT - L.H.
8	ATL-10729	ATTACHMENT PLATE WELDMENT
9	ATL-10025	BEARING SPACER (1" SHAFT)
10	ATL-11086-OAW	NIP POINT GUARD - TAIL END
11	ATL-12850-RH	MOTOR BASE SUPPORT ANGLE - R.H.
12	ATL-12850-LH	MOTOR BASE SUPPORT ANGLE - L.H.
13	SEE CHART	MOTOR BASE WELDMENT
14	ATL-11090	CHAIN GUARD FRONT WELDMENT
15	ATL-11091	CHAIN GUARD BACK PLATE
16	ATL-10780	CHAIN GUARD MOUNTING BAR
17	ATL-11280	SPACER - CHAIN GUARD
18	ATL-11104	SPACER - REDUCER BASE
19	ATL-10011	SNUBBER ROLLER GUARD MOUNTING BRACKET
20	ATL-10019	SNUBBER ROLLER BRACKET - 11/16" HEX
21	ATL-11096-OAW	SNUB ROLLER GUARD - TAIL END
22	ATL-10024	RETURN ROLLER BRACKET
23	ATL-10023	SPLICE PLATE
24	ATL-11268	ATTACHMENT BAR - DRIVE SUPPORT
25	SPECIFIC TO ORDER	SMS FLOOR SUPPORT

DET.	PART NUMBER	DESCRIPTION
26	SPECIFIC TO ORDER	MOTOR
27	SPECIFIC TO ORDER	REDUCER
28	SPECIFIC TO ORDER	DRIVE SPROCKET (REDUCER)
29	ATL-10743	SHAFT KEY: 1/4" SQ. X 1 1/4" L (REDUCER)
30	SPECIFIC TO ORDER	DRIVE CHAIN - RC60 WITH CONNECTING LINK
31	SPECIFIC TO ORDER	DRIVEN SPROCKET (DRIVE PULLEY)
32	ATL-10744	SHAFT KEY: 3/8" SQ. X 1" L. (PULLEY)
33	ATL-10005	BEARING: 3-BOLT FLANGE - 1" BORE
34	ATL-10004	BEARING: 4-BOLT FLANGE - 1 7/16" BORE
35	ATL-13028-BF	SNUBBER ROLLER: 2 9/16" DIA.
36	ATL-10727-BF	SNUBBER ROLLER: 2 1/8" DIA.
37	ATL-10728-BF	RETURN ROLLER: 1.9" DIA.
38	ATL-12910-FL	4" DIA. TAIL PULLEY
39	ATL-10758-FL	8" DIA. DRIVE PULLEY WITH LAGGING
40	SPECIFIC TO ORDER	BELT WITH LACING
41	ATL-10747	U-TYPE SPEED NUT: 1/4-20
42	ATL-10789	HEX HEAD BOLT: 5/16-18 X 1" L. (GRADE 8)
43	ATL-10742	HEX JAM NUT: HEAVY, 3/8-16
44	ATL-10748	ACORN NUT: 3/8-16
45	ATL-10749	HEX HEAD BOLT: 3/8-16 x 1" L. (GRADE 8)
46	ATL-10750	TAKE-UP BOLT: 1/2-13 X 4" L. (GRADE 8)
47	ATL-10751	SHOULDER BOLT: 1/2" DIA. X .312" L.
48	ATL-10787	TAKE-UP BOLT: 3/8-16 x 2 1/4" L.
49	ATL-10788	HEX HEAD BOLT: 3/8-16 x 3 1/4" L.
50	ATL-10790	HEX JAM NUT: 3/8-16
51	ATL-10791	HEX JAM NUT: 1/2-13

REPLACEMENT PARTS - PARTS DRAWING AND LIST (4” & 8” CENTER DRIVE)

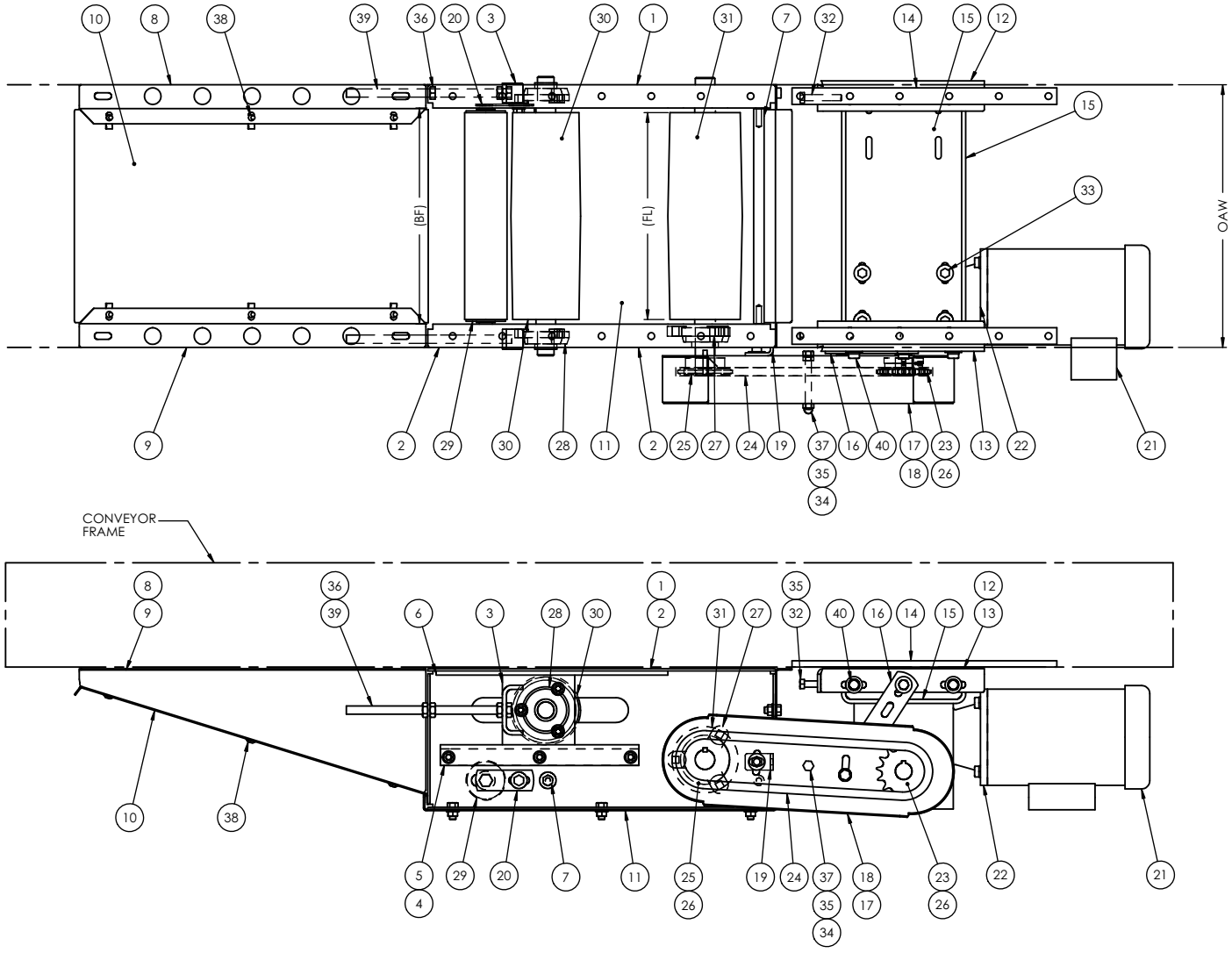




NOTE: FOR 4” CENTER DRIVE SEE PAGE #19 AND FOR 8” CENTER DRIVE SEE PAGE #20

DET.	PART NO.	DESCRIPTION
1	SPECIFIC TO ORDER	BED SECTION
2	SPECIFIC TO ORDER	CENTER DRIVE SUB ASSEMBLY
3	ATL-10023	SPLICE PLATE
4	ATL-10024	RETURN ROLLER BRACKET
5	ATL-10011	SNUB ROLLER GUARD MOUNTING BRACKET
6	ATL-10022	BELT PROTECTOR
7	ATL-10775-RH	TAKE-UP WELDMENT - RIGHT HAND
8	ATL-10775-LH	TAKE-UP WELDMENT - LEFT HAND
9	ATL-10025	BEARING SPACER (1" SHAFT)
10	ATL-10729	ATTACHMENT PLATE WELDMENT
11	ATL-11096-BW	SNUB ROLLER GUARD
12	ATL-11086-BW	NIP POINT GUARD - TAIL END
13	SPECIFIC TO ORDER	SMS LEG ASSEMBLY
14	ATL-12910-FL	4" DIA. TAIL PULLEY
15	ATL-10728-BF	RETURN ROLLER: 1.9" DIA.
16	ATL-10727-BF	SNUBBER ROLLER: 2 1/8" DIA.
17	SPECIFIC TO ORDER	BELT WITH LACING
18	ATL-10005	BEARING: 3-BOLT FLANGE, 1" BORE
19	ATL-12906	HEX HEAD BOLT: 3/8-16 x 1" L.
20	ATL-10750	HEX HEAD BOLT: 1/2-13 x 4" L.
21	ATL-10751	SHOULDER BOLT - 1/2" DIA. X .312 L.
22	ATL-10747	U-TYPE SPEED NUT: 1/4-20
23	ATL-10791	HEX JAM NUT: 1/2-13
24	ATL-10748	ACORN NUT: 3/8-16

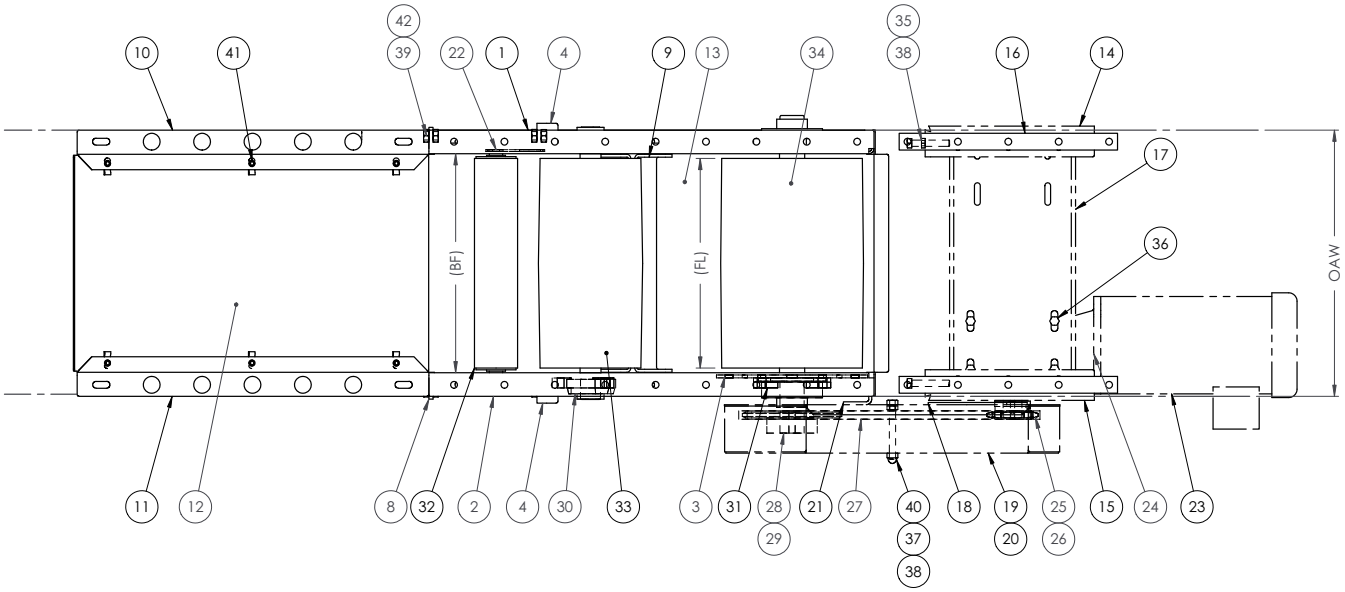
REPLACEMENT PARTS - PARTS DRAWING AND LIST (4” CENTER DRIVE)

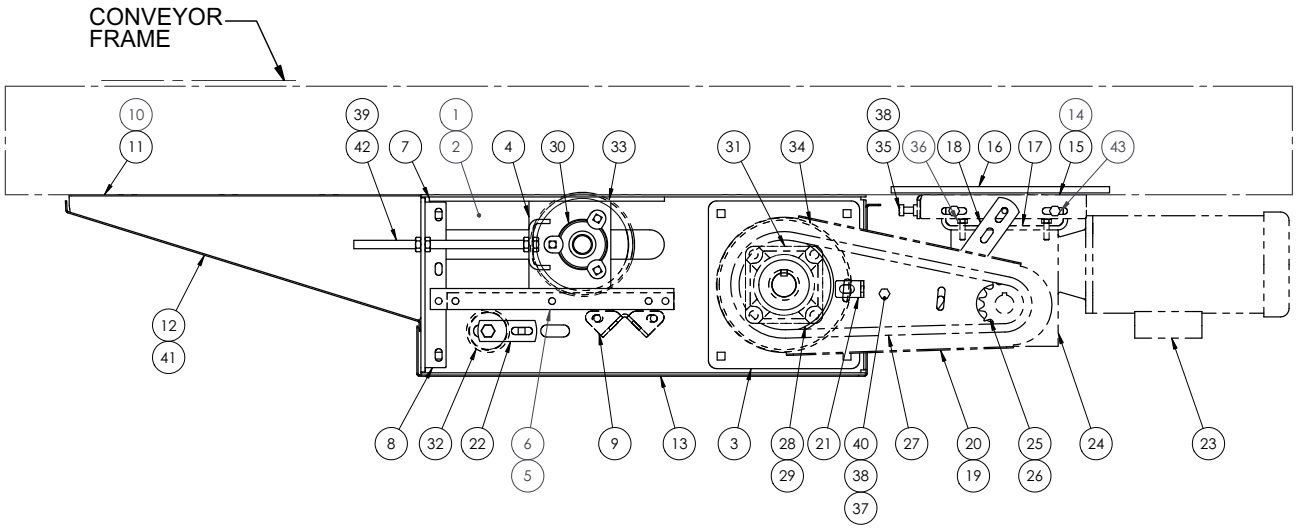


DET.	PART NUMBER	DESCRIPTION
1	ATL-10796-RH	DRIVE PLATE WELDMENT - RIGHT HAND
2	ATL-10796-LH	DRIVE PLATE WELDMENT - LEFT HAND
3	ATL-10799	TAKE-UP PLATE WELDMENT
4	ATL-10800	BEARING GUIDE SPACER
5	ATL-10801	BEARING GUIDE
6	ATL-10719	UPPER BEARING GUIDE
7	ATL-10828-BF	THREADED SECTION SPACER
8	ATL-10724-RH	SIDE GUARD - RIGHT HAND
9	ATL-10724-LH	SIDE GUARD - LEFT HAND
10	ATL-10021-OAW	BOTTOM ANGLE GUARD - CENTER DRIVE
11	ATL-10821-OAW	BOTTOM GUARD - CENTER DRIVE
12	ATL-12850-RH	MOTOR BASE SUPPORT ANGLE - RIGHT HAND
13	ATL-12850-LH	MOTOR BASE SUPPORT ANGLE - LEFT HAND
14	ATL-10819	REDUCER BASE REINFORCEMENT BAR
15	ATL-10710-OAW	MOTOR BASE WELDMENT
16	ATL-10780	CHAIN GUARD MOUNTING BAR
17	ATL-10827	CHAIN GUARD FRONT WELDMENT
18	ATL-10825	CHAIN GUARD BACK PLATE
19	ATL-12856	BRACKET - GUARD SUPPORT
20	ATL-10019	RETURN ROLLER BRACKET - 11/16" HEX

DET.	PART NUMBER	DESCRIPTION
21	SPECIFIC TO ORDER	MOTOR
22	SPECIFIC TO ORDER	REDUCER
23	SPECIFIC TO ORDER	DRIVE SPROCKET (REDUCER)
24	SPECIFIC TO ORDER	DRIVE CHAIN - RC50 WITH CONNECTING LINK
25	ATL-12832	DRIVE SPROCKET (DRIVE PULLEY)
26	ATL-10743	SHAFT KEY: 1/4" SQ X 1 1/4" L
27	ATL-10003	BEARING: 3-BOLT FLANGE, 1 3/16" BORE
28	ATL-10005	BEARING: 3-BOLT FLANGE, 1" BORE
29	ATL-13028-BF	SNUBBER ROLLER: 29/16" OD
30	ATL-12910-FL	4" DIA. TAKE-UP PULLEY
31	ATL-10802-FL	4" DIA. DRIVE PULLEY (LAGGED 4 1/2" DIA. FINISHED)
32	ATL-10787	TAKE-UP BOLT: 3/8-16 x 2 1/4" L (FULL THREAD)
33	ATL-10789	HEX HEAD BOLT: 5/16-18 X 1" L. (GRADE 8)
34	ATL-10788	HEX HEAD BOLT: 3/8-16 x 3 1/4" L (FULL THREAD)
35	ATL-10790	HEX JAM NUT: 3/8-16
36	ATL-10791	HEX JAM NUT: 1/2-13
37	ATL-10748	ACORN NUT: 3/8-16
38	ATL-10747	U-TYPE SPEED NUT: 1/4-20
39	ATL-11279	THREADED ROD: 1/2-13 X 10" L
40	ATL-10749	HEX HEAD BOLT: 3/8-16 x 1" L (GRADE 8)

REPLACEMENT PARTS - PARTS DRAWING AND LIST (8” CENTER DRIVE)

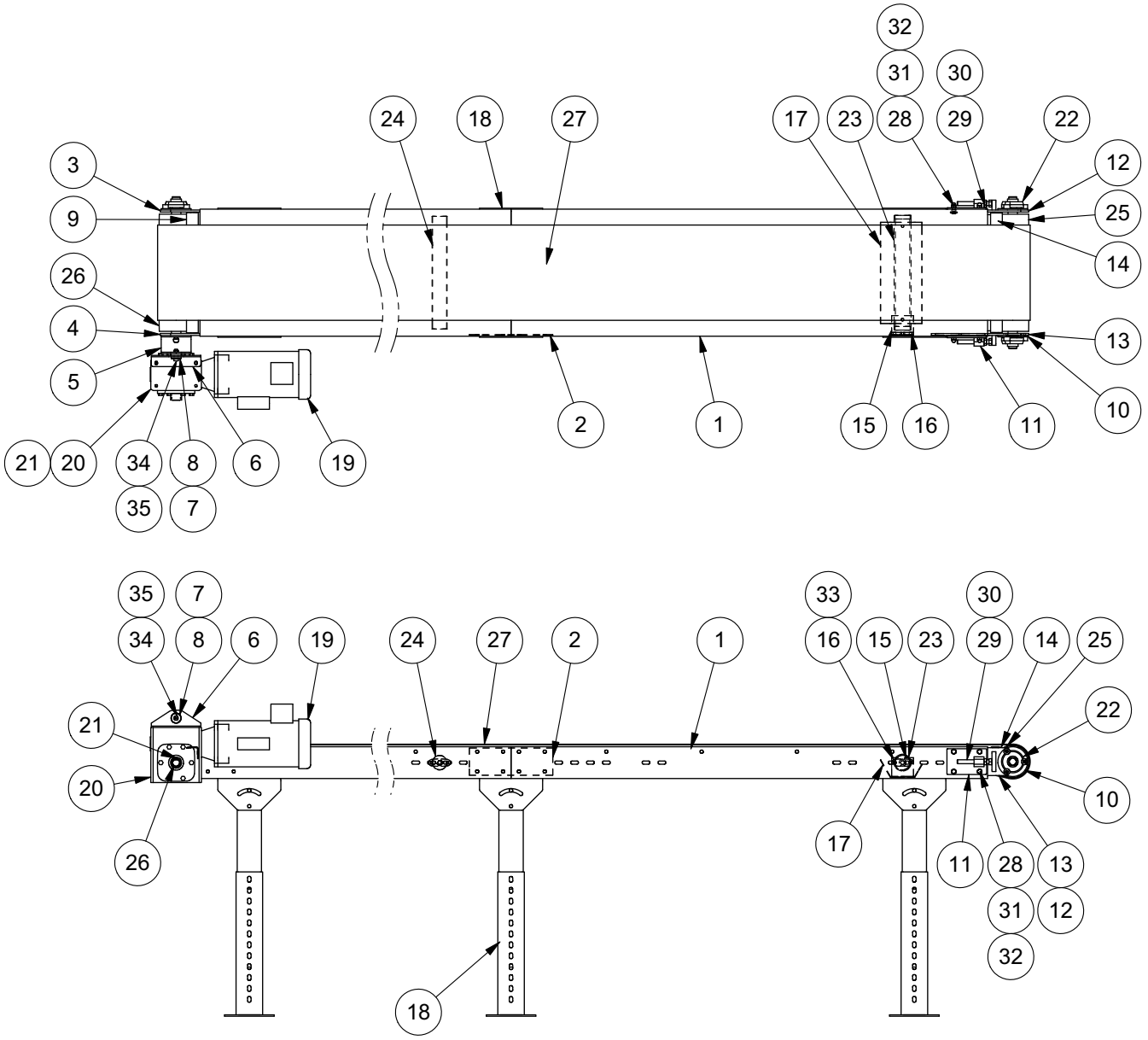




DET.	PART NUMBER	DESCRIPTION
1	ATL-10708-RH	DRIVE PLATE WELDMENT - RIGHT HAND
2	ATL-10708-LH	DRIVE PLATE WELDMENT - LEFT HAND
3	ATL-10713	BEARING PLATE - CENTER DRIVE
4	ATL-10714	TAKE-UP PLATE WELDMENT
5	ATL-10717	BEARING GUIDE SPACER
6	ATL-10718	BEARING GUIDE
7	ATL-10719	UPPER BEARING GUIDE
8	ATL-10720	TAKE UP ANGLE - CENTER DRIVE
9	ATL-11695-BF	BED SPREADER
10	ATL-10724-RH	SIDE GUARD - RIGHT HAND
11	ATL-10724-LH	SIDE GUARD - LEFT HAND
12	ATL-10021-OAW	BOTTOM ANGLE GUARD - CENTER DRIVE
13	ATL-10020-OAW	BOTTOM GUARD - CENTER DRIVE
14	ATL-12850-RH	MOTOR BASE SUPPORT ANGLE - RIGHT HAND
15	ATL-12850-LH	MOTOR BASE SUPPORT ANGLE - LEFT HAND
16	ATL-10781	REDUCER BASE REINFORCEMENT BAR
17	ATL-10710-OAW	MOTOR BASE WELDMENT
18	ATL-10780	CHAIN GUARD MOUNTING BAR
19	ATL-12854	CHAIN GUARD FRONT WELDMENT
20	ATL-12855	CHAIN GUARD BACK PLATE
21	ATL-12856	BRACKET - GUARD SUPPORT
22	ATL-10019	RETURN ROLLER BRACKET - 11/16" HEX

DET.	PART NUMBER	DESCRIPTION
23	SPECIFIC TO ORDER	MOTOR
24	SPECIFIC TO ORDER	REDUCER
25	SPECIFIC TO ORDER	DRIVE SPROCKET (REDUCER)
26	ATL-10743	PULLEY SHAFT KEY 1/4" SQ X 1 1/4" L.
27	SPECIFIC TO ORDER	DRIVE CHAIN: RC50 WITH CONNECTING LINK
28	ATL-11252	DRIVE SPROCKET (DRIVE PULLEY)
29	ATL-10744	SHAFT KEY: 3/8" SQ. X 1" L.
30	ATL-10003	BEARING: 3-BOLT FLANGE, 1 3/16" BORE
31	ATL-10004	BEARING: 4-BOLT FLANGE, 1 7/16" BORE
32	ATL-13028-BF	SNUBBER ROLLER: 2 9/16" OD
33	ATL-10756-FL	6" DIA. TAKE-UP PULLEY
34	ATL-10785-FL	8" DIA. DRIVE PULLEY (LAGGED - 8 1/2" DIA. FINISHED)
35	ATL-10787	TAKE-UP BOLT: 3/8-16 x 2 1/4" L. (FULL THREAD)
36	ATL-10789	HEX HEAD BOLT: 5/16-18 x 1" L. (GRADE 8)
37	ATL-10788	HEX HEAD BOLT: 3/8-16 x 3 1/4" L. (FULL THREAD)
38	ATL-10790	HEX JAM NUT: 3/8-16
39	ATL-10791	HEX JAM NUT: 1/2-13
40	ATL-10748	ACORN NUT: 3/8-16
41	ATL-10747	U-TYPE SPEED NUT: 1/4-20
42	ATL-11278	THREADED ROD: 1/2-13 x 11" L.
43	ATL-10749	HEX HEAD BOLT: 3/8-16 x 1" L. (GRADE 8)

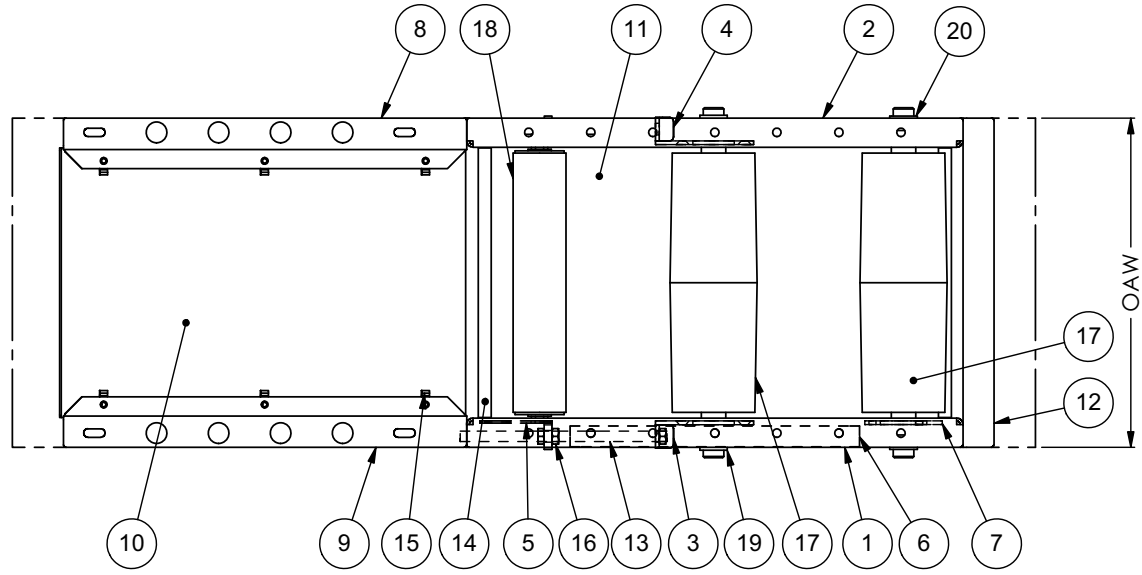
REPLACEMENT PARTS - PARTS DRAWING AND LIST (4” SHAFT MOUNT)

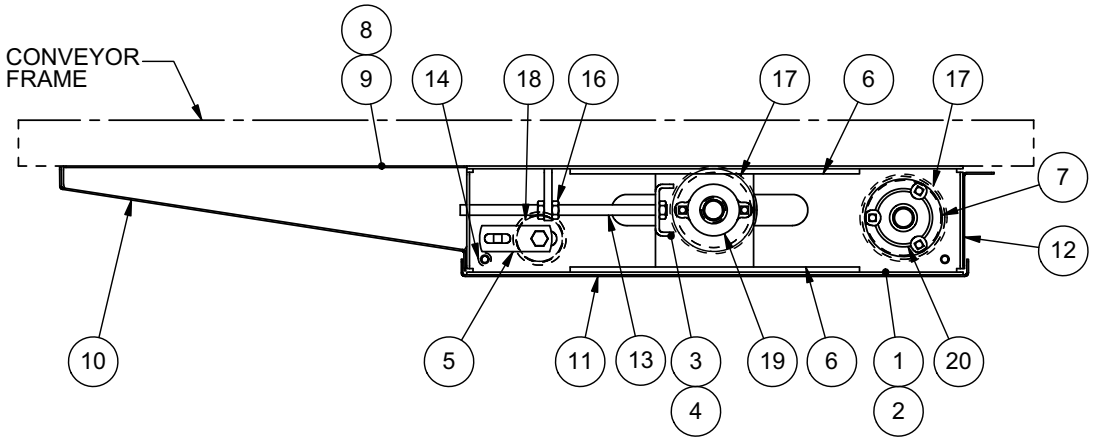


DET.	PART NO.	DESCRIPTION
1	SPECIFIC TO ORDER	SLIDER BED
2	ATL-10023	SPLICE PLATE
3	ATL-10760-RH	DRIVE PLATE WELDMENT - RIGHT HAND
4	ATL-10760-LH	DRIVE PLATE WELDMENT - LEFT HAND
5	ATL-11116	BRACKET - DRIVE PLATE
6	ATL-11194	REDUCER BRACKET WELDMENT
7	ATL-11120	SHOCK ABSORBER
8	ATL-11195	WASHER
9	ATL-10763-BW	NIP POINT GUARD - DRIVE END
10	ATL-10025	BEARING SPACER
11	ATL-10729	ATTACHMENT PLATE WELDMENT
12	ATL-10775-RH	TAKE-UP WELDMENT - RIGHT HAND
13	ATL-10775-LH	TAKE-UP WELDMENT - LEFT HAND
14	ATL-10779-BW	NIP POINT GUARD - TAIL END
15	ATL-10011	SNUB ROLLER GUARD MOUNTING BRACKET
16	ATL-10024	RETURN ROLLER BRACKET
17	ATL-10741-BW	SNUB ROLLER GUARD
18	SPECIFIC TO ORDER	FLOOR SUPPORT - SMS
19	SPECIFIC TO ORDER	MOTOR
20	SPECIFIC TO ORDER	REDUCER

DET.	PART NO.	DESCRIPTION
21	ATL-10743	SHAFT KEY: 1/4" SQ X 1-1/4" LONG
22	ATL-10005	BEARING: 3-BOLT FLANGE, 1" BORE
23	ATL-10727-BF	SNUBBER ROLLER: 2 1/8" OD
24	ATL-10728-BF	RETURN ROLLER: 1.9" OD
25	ATL-12910-FL	4" DIA. TAIL PULLEY
26	ATL-11114-FL	4" DIA. DRIVE PULLEY (LAGGED)
27	ATL-10785-BW	BELT WITH LACING
28	ATL-10748	ACORN NUT 3/8-16
29	ATL-10750	1/2-13 HHCS x 4" LONG (GRADE 8)
30	ATL-10791	HEX JAM NUT (SS 18-8): 1/2-13
31	ATL-10751	SHOULDER BOLT 1/2" DIA. X .312" L.
32	ATL-10783	SPACER - TAKE UP - 1/2" OD X 5/16" L
33	ATL-10747	U-TYPE SPEED NUT: 1/4-20
34	ATL-11121	SHOULDER BOLT - 3/8" DIA. BODY - 5/16-18 X 1-125" L., ZINC PLATED
35	ATL-11122	5/16-18 TOP LOCK NUT - 18-8 STAINLESS

REPLACEMENT PARTS - PARTS DRAWING AND LIST (UNDERSIDE TAKE-UP)





DET.	PART NO.	DESCRIPTION
1	ATL-10838-LH	SIDE CHANNEL WELDMENT - LEFT HAND
2	ATL-10838-RH	SIDE CHANNEL WELDMENT - RIGHT HAND
3	ATL-10842-LH	TAKE-UP PLATE WELDMENT - LEFT HAND
4	ATL-10842-RH	TAKE UP PLATE WELDMENT - RIGHT HAND
5	ATL-10019	RETURN ROLLER BRACKET - 11/16" HEX
6	ATL-10719	UPPER BEARING GUIDE
7	ATL-10025	BEARING SPACER (1" SHAFT)
8	ATL-10844-RH	SIDE GUARD - RIGHT HAND
9	ATL-10844-LH	SIDE GUARD - LEFT HAND
10	ATL-10846-OAW	BOTTOM ANGLE GUARD
11	ATL-10847-OAW	BOTTOM GUARD
12	ATL-10848-OAW	REAR GUARD - UNDERSIDE TAKE-UP
13	ATL-11279	THREADED ROD: 1/2-13 X 10" L.
14	ATL-10828-OAW	THREADED SECTION SPACER
15	ATL-10747	U-TYPE SPEED NUT: 1/4-20
16	ATL-10791	HEX JAM NUT: 1/2-13
17	ATL-12910-FL	4" DIA. TAIL PULLEY
18	ATL-13028-BF	SNUBBER ROLLER: 2 9/16" OD
19	ATL-12937	BEARING: 2-BOLT FLANGE, 1" BORE
20	ATL-10005	BEARING: 3-BOLT FLANGE, 1" BORE