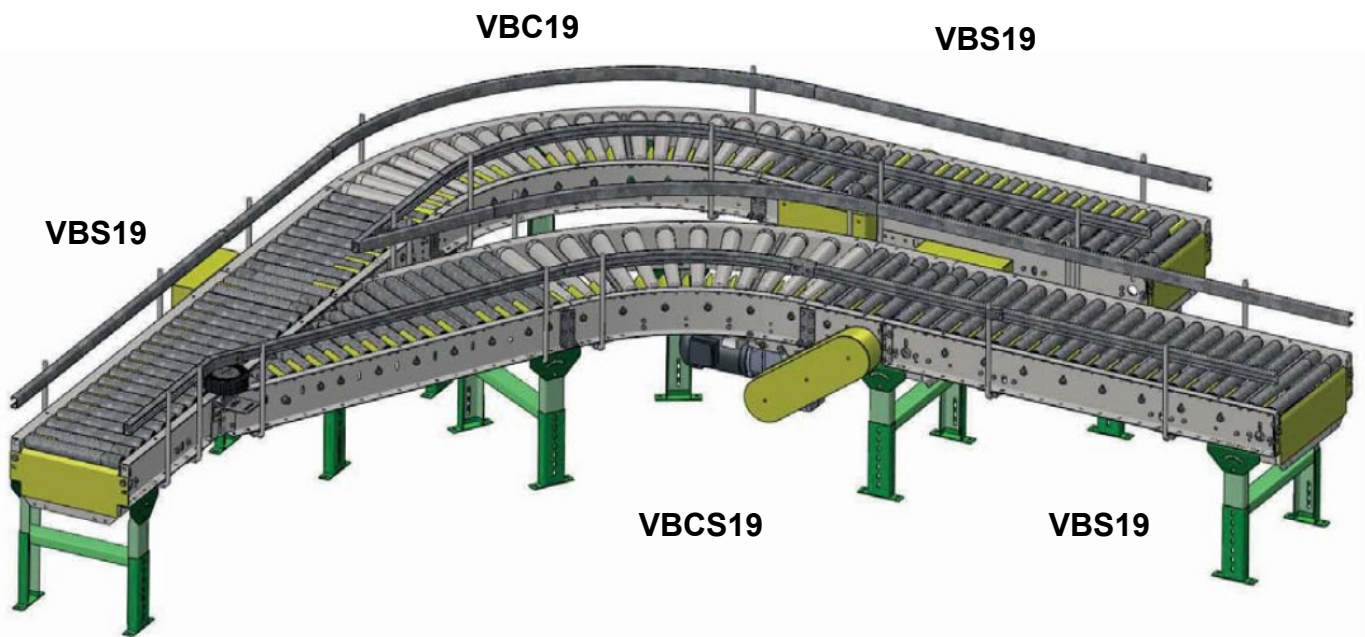


INSTALLATION AND MAINTENANCE MANUAL

V-BELT DRIVEN LIVE ROLLER CONVEYOR

MODEL VBS19, VBC19, VBCS19 AND VB SS19



**DO NOT OPERATE
EQUIPMENT
BEFORE READING**

ATLANTIS
TECHNOLOGIES LLC

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INTRODUCTION

This manual has been created to assist with the maintenance, operation and installation of the V-Belt BDLR conveyor. It is important that all maintenance personnel are trained properly in operation and maintenance of the 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 carrier.
- 4) Move all crates to area of installation.
- 5) Remove crating and packaging.
- 6) 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/or 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 should 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, should have prominent and legible warnings posted in the area or on the equipment and where feasible lines should 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 should 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 should 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 should be permitted to operate a conveyor. Training should include instruction in operation under normal conditions and emergency situations.

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

The area around loading and unloading points should 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”** should be affixed by the manufacturer of the conveyor.

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

A conveyor should be used to transport only a load that it is designed to be handled safely.

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

SAFETY INFORMATION - OPERATION (Continued)

Routine inspections and preventative and corrective maintenance programs should 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 should be performed by trained, qualified personnel only.

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

ADJUSTMENTS OR MAINTENANCE/SERVICE DURING OPERATION

Conveyors should **NOT** be maintained or serviced while in operation.

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 should be replaced before starting equipment for normal operation.

GUARDS AND SAFETY DEVICES

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

LUBRICATION

Conveyors should **NOT** be lubricated while in operation.

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 should 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 should be clearly marked or labeled to indicate the function controlled.

A conveyor that would cause injury when started should 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 associated devices), a clear, concise and legible warning sign needs to be provided. The warning sign should indicate that conveyors and associated equipment may be started at any time, that danger exists and that personnel must keep clear. These warning signs should 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 should be furnished with emergency stop buttons, pull cords, limit switches or similar emergency stop devices.

All such emergency stop devices should 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 should act directly on the control of the conveyor concerned and should not depend on the stopping of any other equipment. The emergency stop devices should 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, should be arranged to operate such that a power failure or failure of the device itself will not result in a hazardous condition.

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

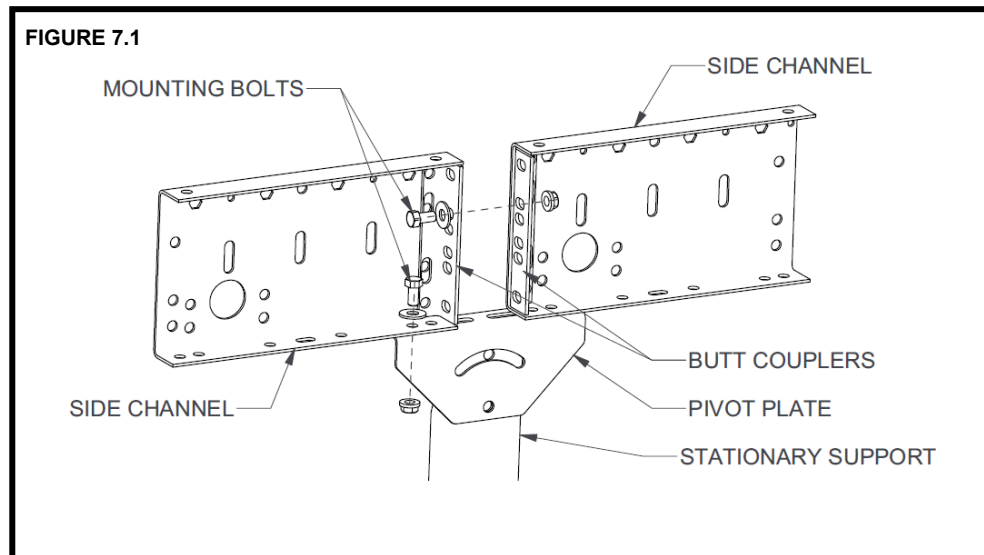
Before restarting a conveyor that has been stopped because of an emergency, an inspection of the conveyor should be made and the cause of the stoppage determined. The starting device and electrical power must be turned off and locked / tagged out according to your company's machine specific procedure 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 typically mounted at Drive, Tail and across splice locations. Fasten leg supports to conveyor sections with the provided fasteners as shown (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.

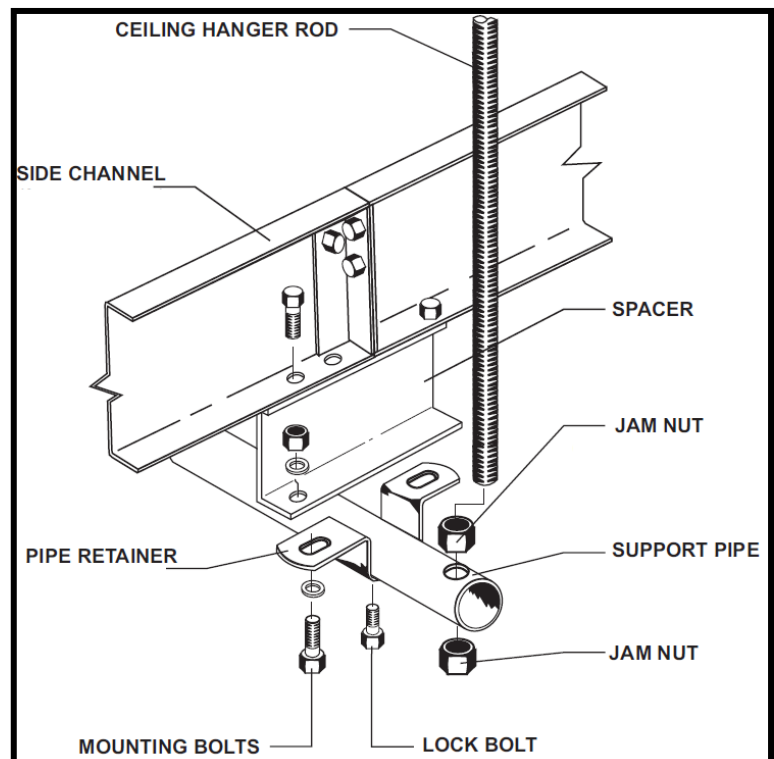


FIGURE 7.2

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 achieve desired height.
- 7) Wire motor and install controls.
- 8) Connect belt between driven and slaved units.

FIGURE 8.1

MATCH-MARK LABELS

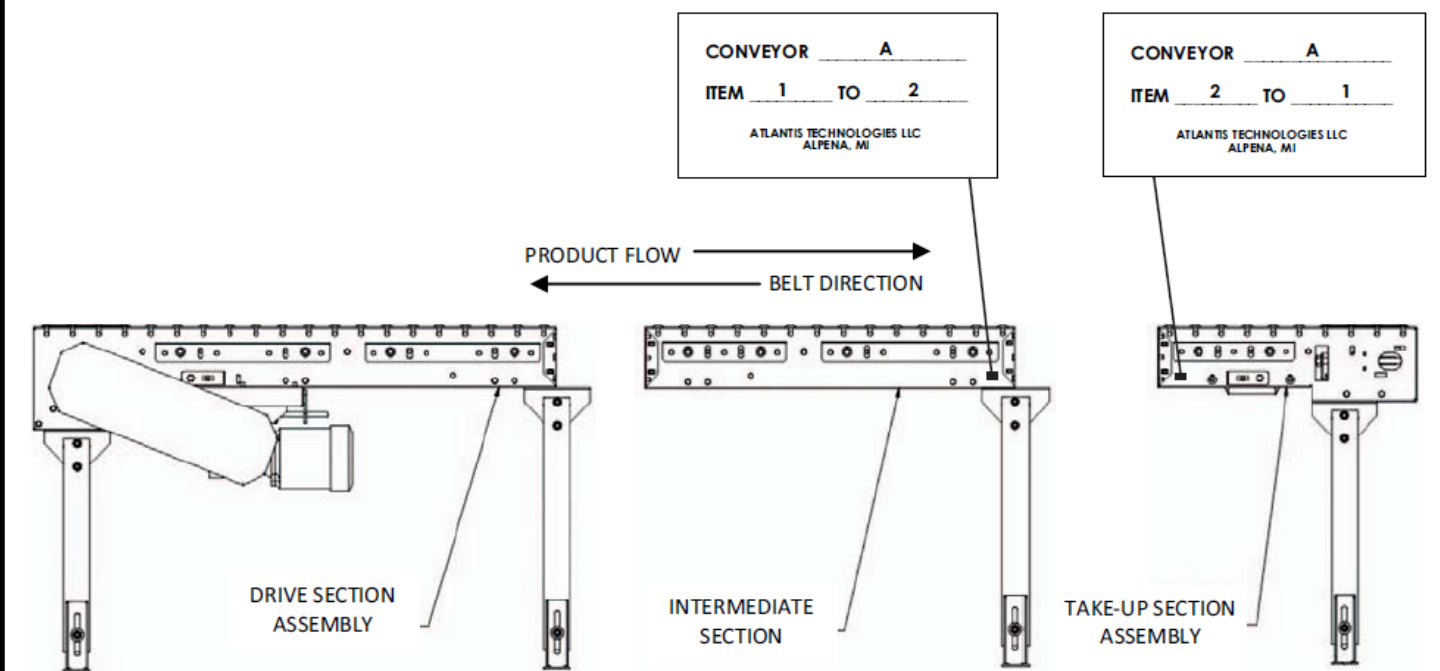
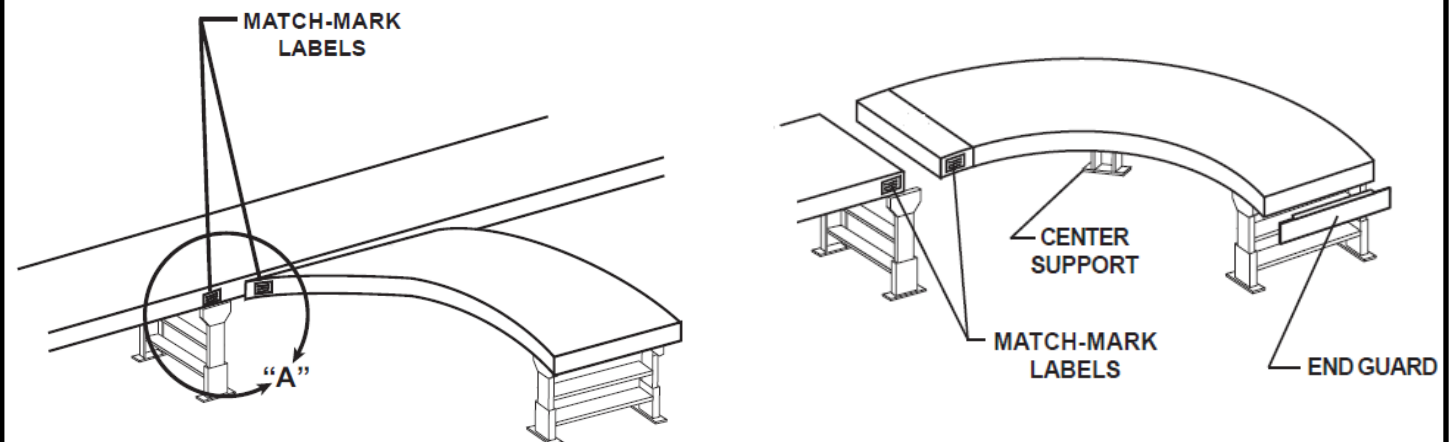


FIGURE 8.2



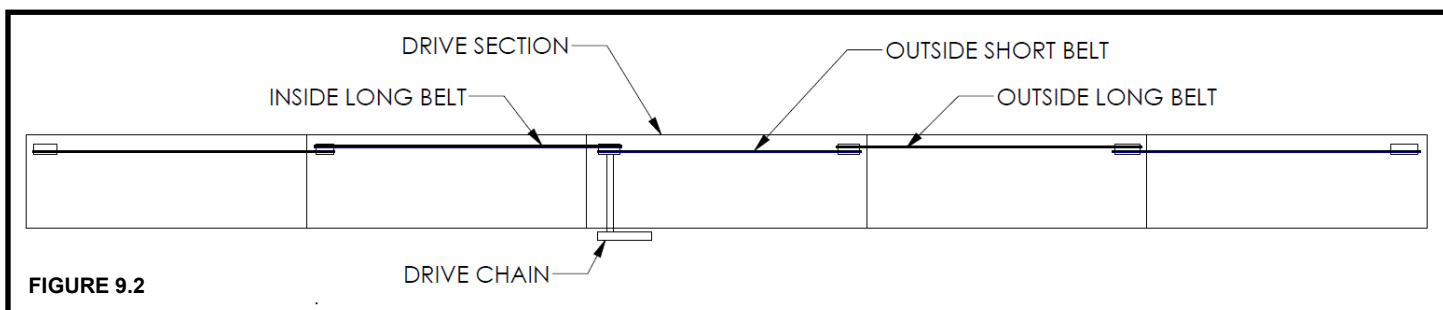
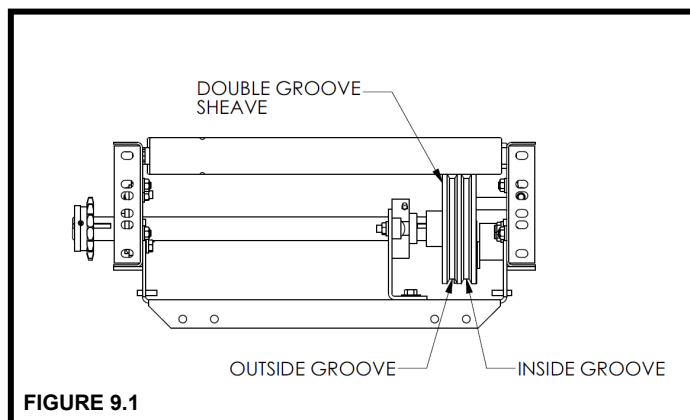
INSTALLATION

CONNECTING V-BELT CONVEYORS

Situated at one end of each slaved conveyor section is a double groove sheave. Drive section has a double groove sheave at each end. This sheave connects the conveyors driving V-Belts. Starting at the drive section, the V-Belt should ride in the sheave's outside groove (see figure 9.1. and 9.2). In both directions from this point on, the belts will have an alternating track from the inside to the outside groove. The groove in which belt will ride is predetermined by factory. Note that take-up sheaves are installed to keep V-Belts aligned in the proper groove when alternating, as well to adjust the V-Belt's tension.

WARNING

NEVER attempt to install a V-Belt while the conveyor is in operation. Personal injury may occur.

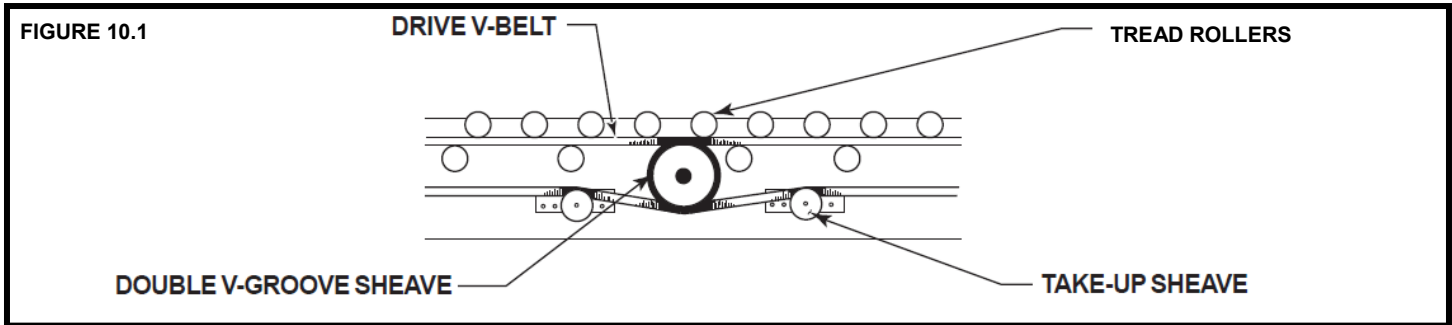


TO CONNECT THE V-BELT

Never use tools such as screw-drivers, pliers, wrenches, etc. during installation as damage to the V-Belts may occur.

- 1) Remove 5 rollers from both ends of each conveyor by depressing one end of spring retained rollers.
- 2) Identify conveyor sections where belt will be riding in the outside groove. (See figure 9.1 and 9.2). These belts need to be connected first and are located on every other section out from drive.
 - A. Place drive belt over take-up sheave located near double groove sheave (See figure 10.1).
 - B. Carefully roll the belt to the outside groove by rotating the double groove sheave.
- 3) Once all applicable belts are installed in the outside grooves, install the remaining belts on the inside groove.
- 4) Replace rollers.

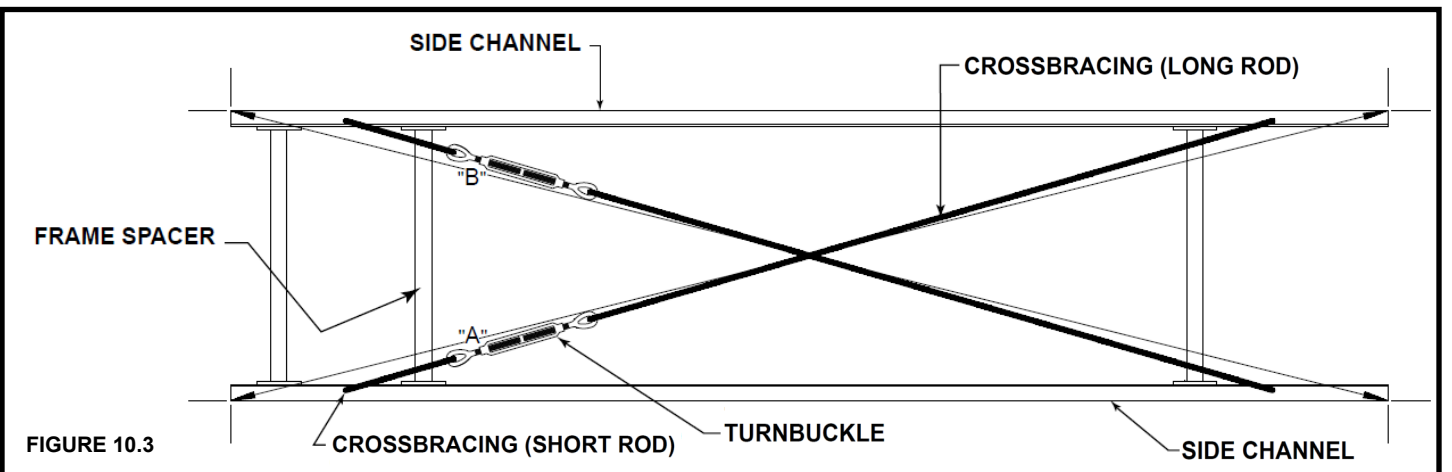
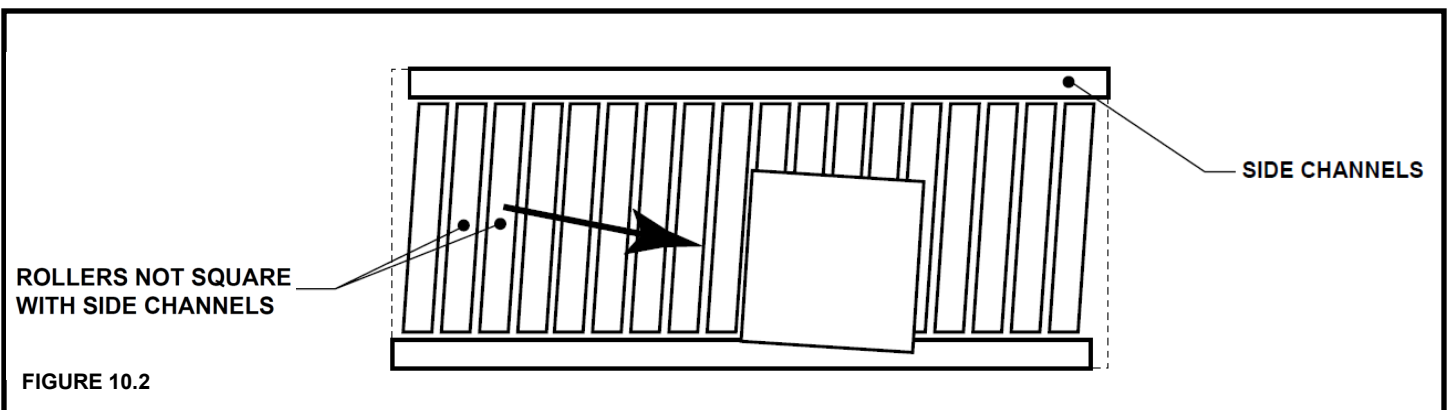
INSTALLATION



RACKED SECTIONS

Important: Bed sections on the conveyor should be checked for a “racked” or un-squared position. Problems with tracking will occur if the conveyor is not square. Turnbuckles are supplied on conveyors 30’ or longer.

- 1) Measure diagonally from corner at one end to opposite corner on the other end. Repeat for other corner. The section will not be square if these dimensions are not equal. (See dimensions A & B in figure 10.3)
- 2) On the underside of the conveyor, where diagonal dimension was the longest, use the supplied cross-bracing to pull section in to square. Adjust the turnbuckle until both dimensions are equal.
- 3) Tighten all pivot plate bolts and butt couplings after bed sections have been checked and corrected for “racked condition”.
- 4) Make a final check to verify that all conveyor sections are level across width and length. Supports can be lagged to the floor once the entire conveyor is level.



INSTALLATION

PRESSURE ADJUSTMENT AND BELT TENSIONING (STRAIGHTS)

Model VBS19

The VBS19 is equipped with suspension angles that support the pressure rollers and hold the drive V-Belt in contact with the tread rollers. Knurled nuts allow the conveyor to be finely adjusted for minimum pressure accumulation. To make this adjustment, follow the steps listed below.

- 1) With conveyor running, reduce pressure on all tread rollers to zero by loosening the knurled adjustment nuts.
- 2) Place heaviest item to be conveyed on infeed end of conveyor. Increase pressure under the item by tightening the knurled nuts. Apply only enough pressure to slightly move the item.
- 3) As the item moves, continue adjustment ahead of item until it moves the entire length of conveyor.
- 4) Return item to infeed end of unit. It should now travel the entire length of conveyor. If not, repeat the adjustment procedure in the problem area.

Apply only enough pressure to convey/drive the heaviest product.

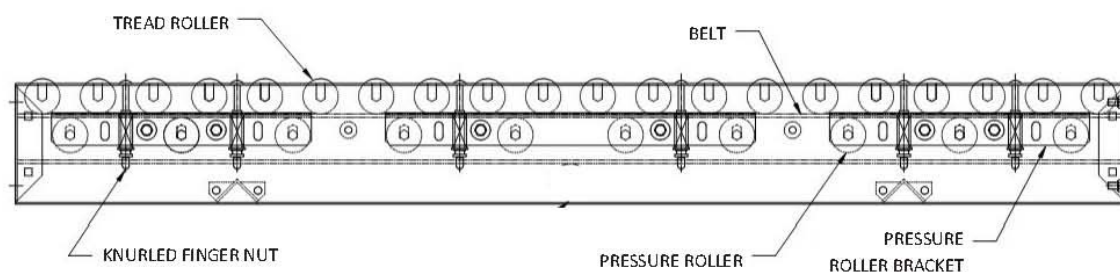


FIGURE 11.1

Take-up sheaves are located near the double-groove sheave to adjust belt tension. To tighten the belt, move take-up sheave closer to the double groove sheave. To loosen the belt, move take-up sheave further away from the double groove sheave. The V-Belt must be properly tensioned to ensure the correct amount of drive pressure. A belt tensioned too much can cause the conveyor to stall out. Likewise, a belt not tensioned enough may be unable to drive the tread rollers.

Model VBC19, VBCS19, VBSS19

These units utilize pressure sheaves in order to hold the drive V-Belt into contact with the tread rollers. Slots in the frames allow the sheaves to be adjusted up and down to apply the correct amount of pressure to the tread rollers.

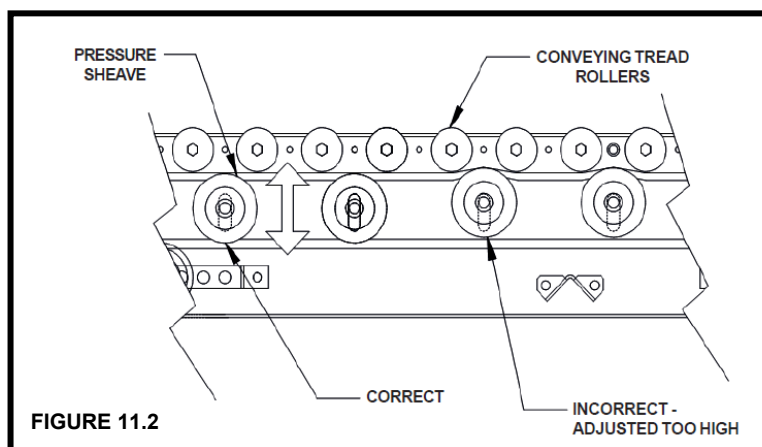
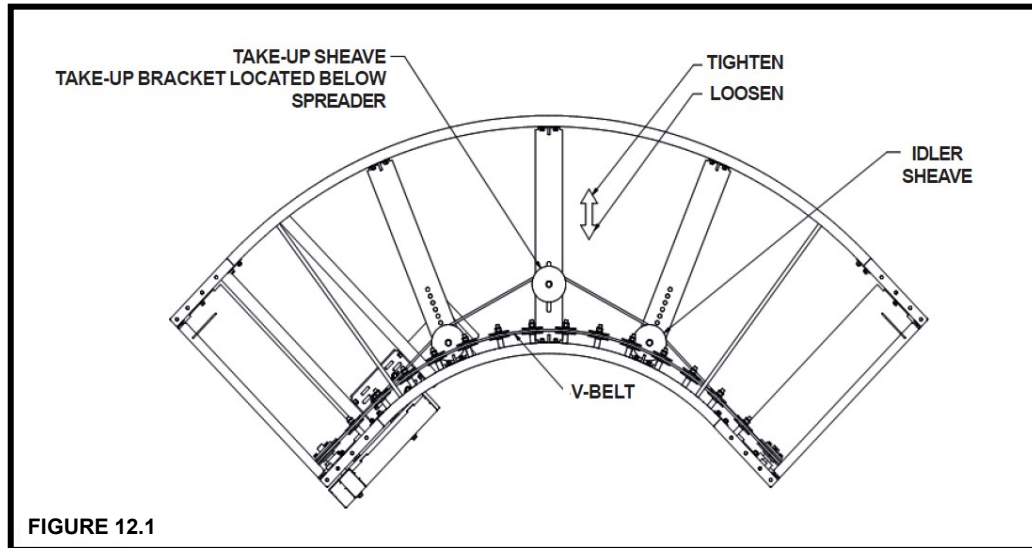


FIGURE 11.2

INSTALLATION

VBC19 and VBCS19 models have a take-up sheave centered in the curved sections of the conveyor which allows the belt to be tensioned. Loosen jam nuts on both ends of the take-up rod and adjust sheave as shown in Figure 12.1. If more belt take-up is required than what the take-up sheave allows, two (2) idler sheaves can also be moved accordingly.

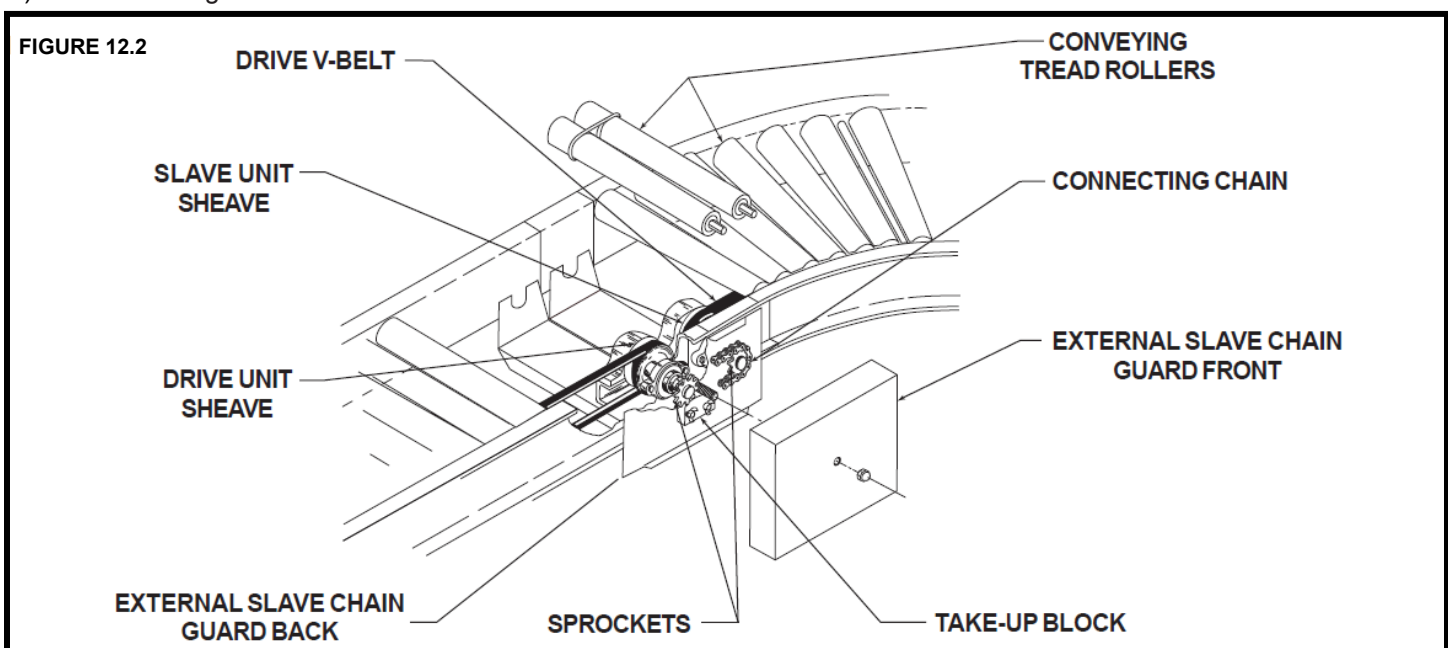
NOTE: Idler sheaves should be equally adjusted in their respective adjustment holes.



EXTERNAL SLAVE DRIVE

INSTALLING THE EXTERNAL SLAVE DRIVE/CONNECTING CHAIN

- 1) Remove sprockets and chain back guard to connect and fasten conveyor sections together.
- 2) Fasten chain guard back plate to the bottom flange of conveyor channel.
- 3) Install sprockets with keys on shafts and properly align using the diagrams on page 13.
- 4) Install slave chain. Tension chain by adjusting the take-up blocks. If conveyor is conveying in one direction, position take-up block on top side of chain. If conveyor is conveying in both directions, position take-up block on bottom side of chain. After proper tension is achieved, tighten wing nut to hold into place.
- 5) Install chain guard front. Fasten with acorn nut.



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 in an extended chain life. No general rule can be given for the frequency of inspection. The frequency should be influenced by conditions of operation.

Suggested Lubrication

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

Chain No.	Temperature		
	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 the drive component could occur due to improper chain tension and alignment. Check chain tension to be certain the slack span has an approximate 2% mid-span movement. (See Figure 13.1)

Drive Chain Tension Adjustment Procedure (See Figure 13.1)

- 1) Remove the 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 the set screws.
- 3) To adjust chain tension, loosen the bolts that fasten the motor base to the mounting angles. (Both sides of the conveyor)
- 4) Tighten take-up bolts until the desired chain tension is reached. Re-tighten the mounting bolts.
- 5) Reference lubrication instructions to lubricate chain properly.
- 6) Replace chain guard so that it does not interfere with the drive.

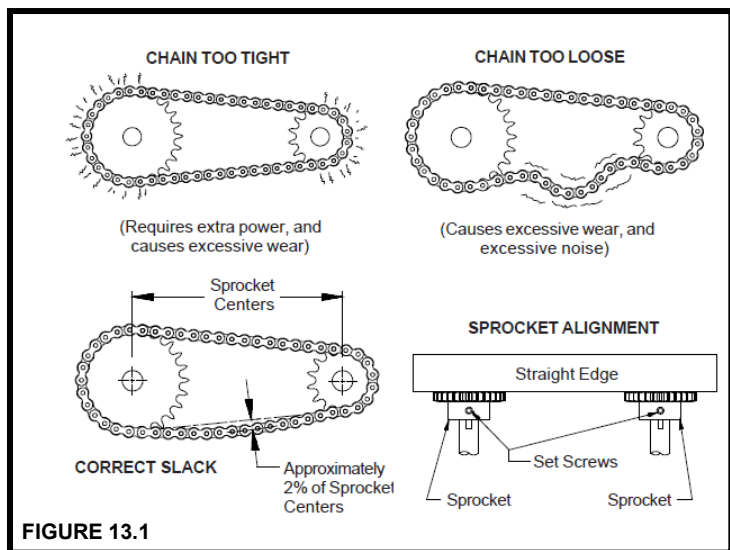


FIGURE 13.1

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.

REPLACING THE V-BELT

MODEL VBS19

Belt Identification

- 1) Check length of section in which belt is to be replaced.
- 2) Determine if long or short belt is required (See figure 9.2)
- 3) Contact factory.

Belt Replacement

- 1) Use knurled nuts to lower the belt away from the tread rollers in the section where the belt is being replaced.
- 2) Remove five (5) tread rollers from the section ends.
- 3) Remove all pressure rollers.
- 4) Replace belt and all rollers.
- 5) View instructions for adjusting belt pressure and tension.

MODEL VBC19, VBCS19

Belt Identification

- 1) Measure between frame width.
- 2) Determine the degree of curve or spur.
- 3) Contact factory.

Belt Replacement

- 1) Note how the existing belt is installed. Loosen take-up sheave to take tension of belt. Loosen/lower pressure sheaves to take further tension off belt if required.
- 2) Remove all tread rollers.
- 3) Replace all belt and rollers.
- 4) View instructions for adjusting belt pressure and tension.

MODEL VBSS19

Belt Identification

- 1) Measure between frame width.
- 2) Determine the degree of curve or spur.
- 3) Contact factory.

Belt Replacement

- 1) Note how the existing belt is installed. Loosen take-up sheave to take tension of belt. Loosen/lower pressure sheaves to take further tension off belt if required.
- 2) Remove all tread rollers.
- 3) Replace all belt and rollers.
- 4) View instructions for adjusting belt pressure and tension.

MAINTENANCE

DAILY MAINTENANCE

- Inspect all conveyors to ensure that all guarding is securely in place.

WEEKLY MAINTENANCE

- Inspect conveyor for loose bolts and set screws.
- Inspect bearings, gear reducers, motors and chains for excessive noise or heat.
- Inspect V-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.
- Inspect rollers to ensure that they rotate freely without excessive noise.

MONTHLY MAINTENANCE

- Inspect reducer for leaking seals.
- Inspect drive chains, jump chains and sprockets for wear, alignment and proper chain tension.

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

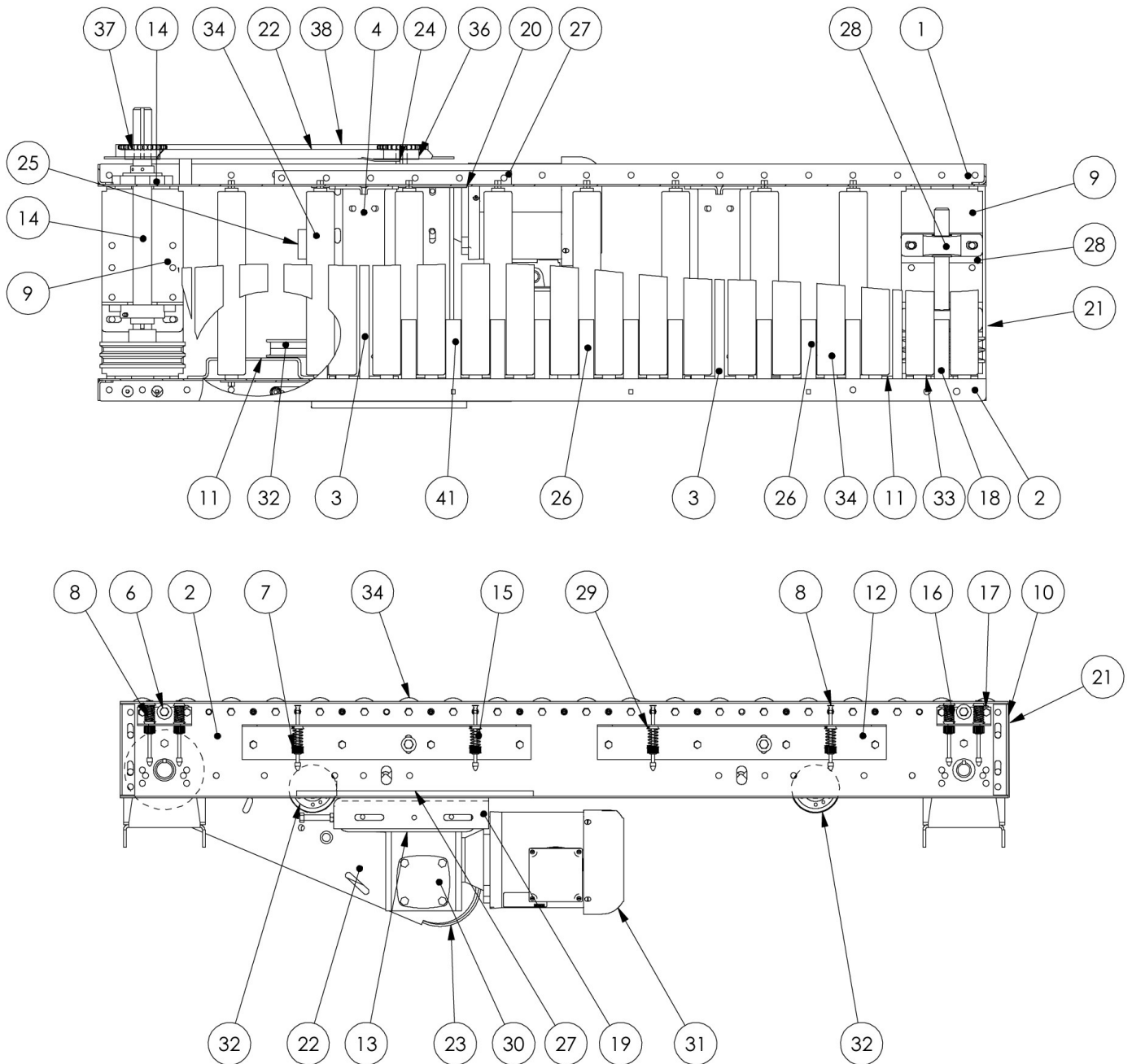
- Tighten all bearing set screws if not completely tight.

TROUBLE SHOOTING

TROUBLE	CAUSE	SOLUTION
Conveyor motor will not start or motor quits frequently	Motor is overloaded	Inspect conveyor for overloading and remove excessive load
	Motor is drawing excessive current	Check heater and/or circuit breaker and replace if necessary
Excessive wear on drive sprockets and drive chain	Inadequate amount of lubrication on drive chain	Replace chain and sprockets. Apply adequate amount of lubrication to chain.
	Misalignment of sprockets	Align sprockets
	Loose chain	Tighten chain
Loud popping or grinding noise	Defective bearing	Replace defective bearing
	Loose set screws in sprockets or bearing	Tighten loose set screws
	Improper drive chain tension	Properly tension drive chain
Motor or reducer is overheating	Overloaded conveyor	Check to ensure that the conveyor belt is not over capacity and reduce load
	Voltage to conveyor is too low	Have a qualified electrician test the voltage and correct if necessary
	Insufficient amount of lubricant in reducer	Add lubricant to reducers, manufacturer recommended level
	Accumulation pressure is too high	See "Pressure Adjustment" section
	One or more V-Belts are too tight	Reposition take-up sheaves further away from double groove sheave
Belt slips or will not move but drive runs	Overloaded conveyor	Check to ensure that the conveyor belt is not over capacity and reduce load
	Belt is too loose	Reposition take-up sheaves further away from double groove sheave
	Too much pressure against belt	Loosen tension on pressure sheaves
Belt is moving but conveyor tread rollers not turning	Not enough contact between V-Belt to conveying tread rollers	Adjust the pressure sheaves to allow for proper contact of the V-Belt to the conveying tread rollers

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

DRAWING AND PARTS LIST (STRAIGHT)



V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

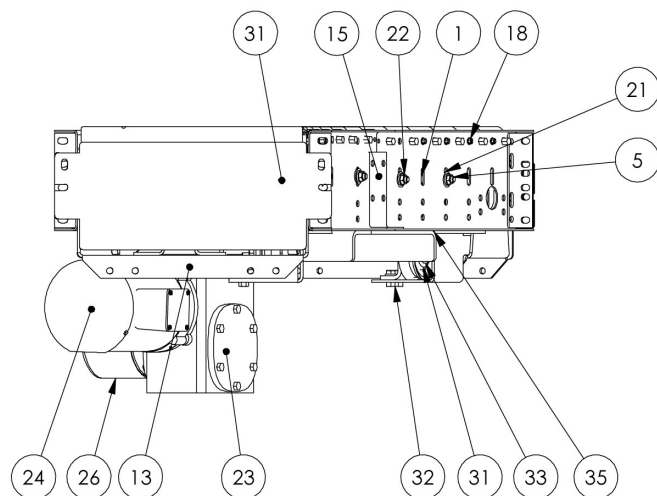
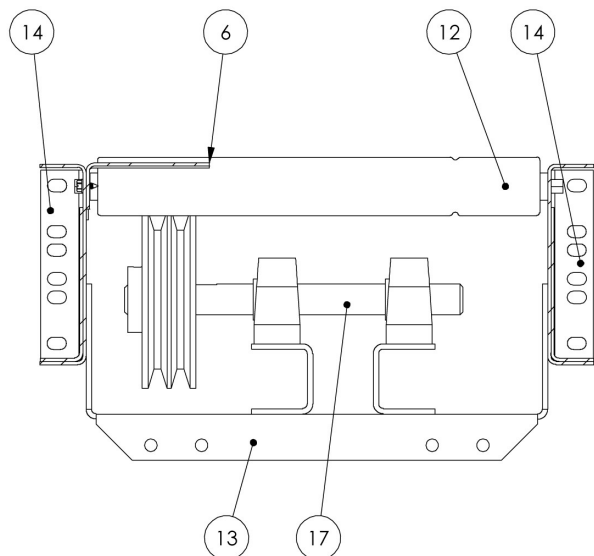
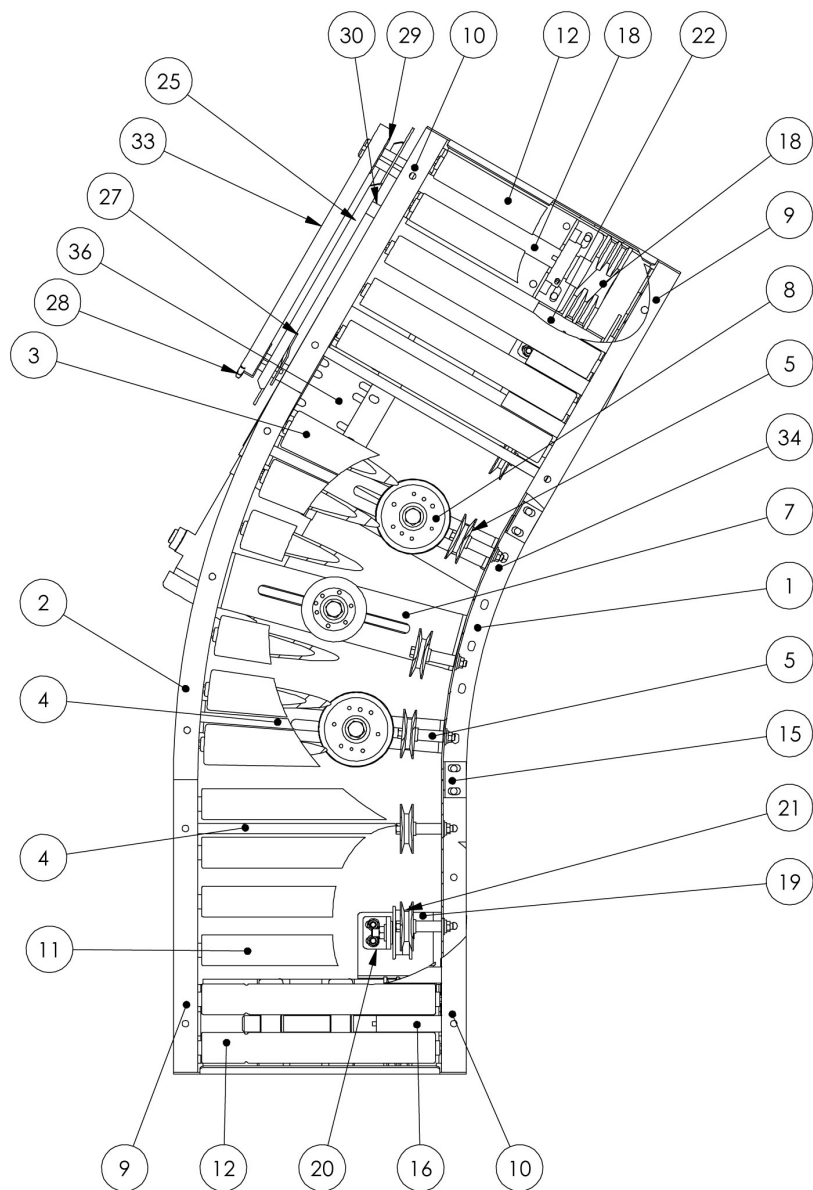
DRAWING AND PARTS LIST (STRAIGHT)

DET.	PART NO.	DESCRIPTION
1	SPECIFIC TO ORDER	FRAME NON-ADJUSTMENT SIDE
2	SPECIFIC TO ORDER	FRAME ADJUSTMENT SIDE
3	ATL-13432-BF	PIPE SPREADER, GALV. ROUND SPREADER (BF)
4	ATL-11695-BF	SPREADER (BF)
5	ATL-13209	CAP RED
6	ATL-13324	SHOULDER BOLT
7	ATL-13325	FINGER ADJUSTMENT NUT
8	ATL-13327	CARRIAGE BOLT
9	ATL-13430-BF	END BEARING SUPPORT (BF)
10	ATL-13431	BUTT COUPLER
11	ATL-13433	TAKE-UP SHEAVE BRACKET
12	SPECIFIC TO ORDER	PRESSURE ROLLER ADJUSTMENT PLATE
13	ATL-13469-BF	MOTOR / REDUCER MOUNT WELDMENT (BF)
14	ATL-13502-BF	DRIVE / SLAVE END ASSEMBLY
15	ATL-13451	SPRING: 1.200" FREE LENGTH
16	ATL-13452	SPRING: 2.250" FREE LENGTH
17	ATL-13453-3	PRESSURE ROLLER ADJUSTMENT PLATE, (2) ROLLER, END ROLLERS
18	ATL-13455	METALIC FINGER GUARD, 1 BOLT TYPE
19	ATL-13465	MOTOR / REDUCER MOUNT PLATE SLIDE, RIGHT
20	ATL-13466	MOTOR / REDUCER MOUNT PLATE SLIDE, LEFT
21	ATL-13471-BF-S	END GUARD (BF)
22	ATL-13653-S	CHAIN GUARD BACK PLATE
23	ATL-13656-S	CHAIN GUARD, STRAIGHT
24	ATL-13657-OAL	CHAIN GUARD, SUPPORT BAR, OVER ALL LENGTH
25	ATL-13658-OAL	CHAIN GUARD, SUPPORT PIPE, OVER ALL LENGTH
26	ATL-13965	METAL FINGER GUARDS (CONVEYOR SPECIFIC)
27	ATL-14103	MOTOR / REDUCER MOUNT REINFORCEMENT BAR
28	ATL-13500-N	IDLER ASSEMBLY
29	ATL-13784	1/4" FINISH WASHER
30	SPECIFIC TO ORDER	REDUCER
31	SPECIFIC TO ORDER	MOTOR
32	ATL-13483	3" FLAT IDLER
33	ATL-14208-BF-GP	DRIVE ROLLER: 1.9" OD, SINGLE GROOVE
34	ATL-13479-BF-GP	BED ROLLER: 1.9" OD
35	SPECIFIC TO ORDER	B-SECTION V-BELT (CONVEYOR SPECIFIC)
36	SPECIFIC TO ORDER	DRIVE SPROCKET: RC50 SERIES
37	SPECIFIC TO ORDER	DRIVEN SPROCKET: RC50 SERIES
38	SPECIFIC TO ORDER	DRIVE ROLLER CHAIN

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

DRAWING AND PARTS LIST (30° CURVE)

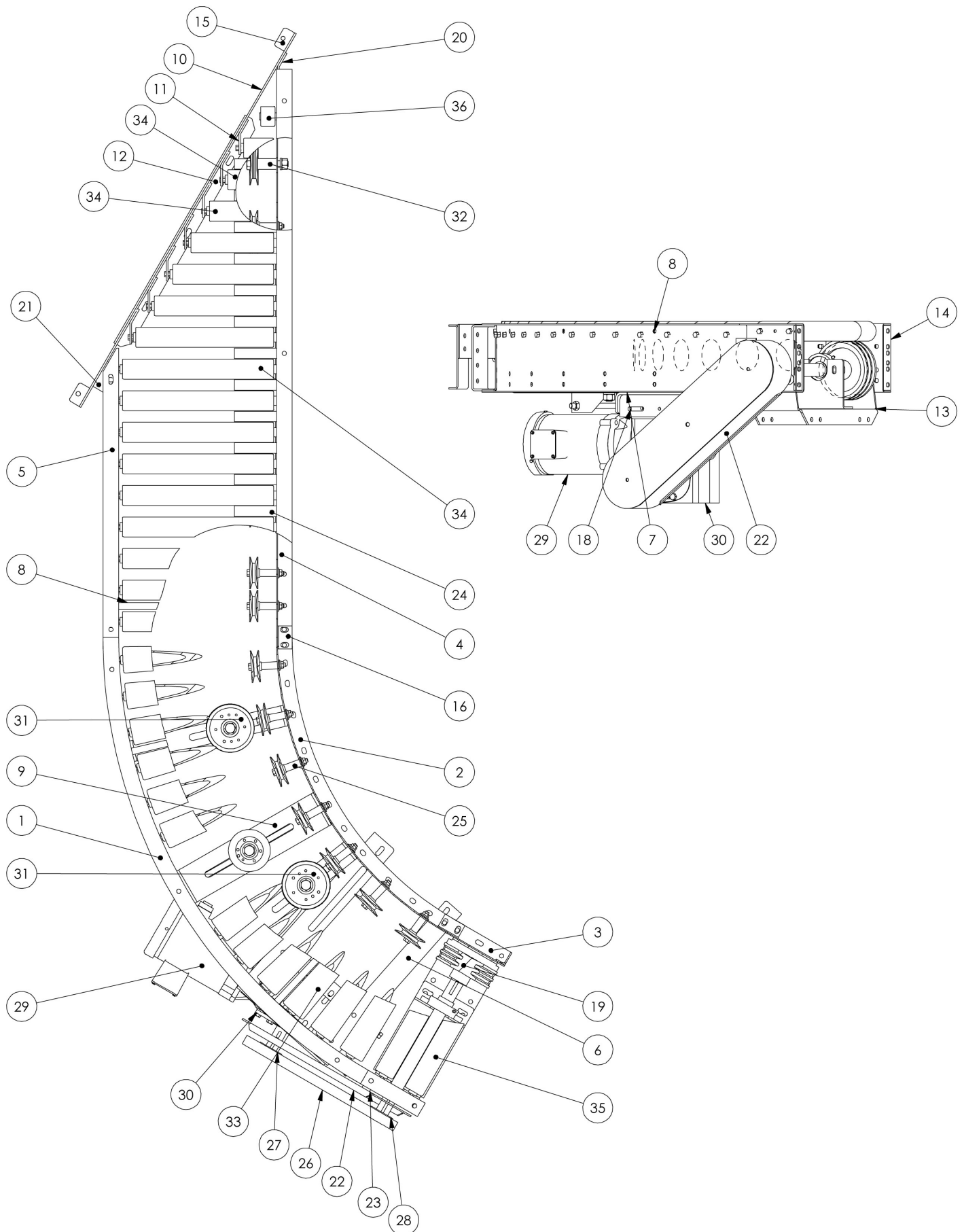


DRAWING AND PARTS LIST (30° CURVE)

DET.	PART NO.	DESCRIPTION
1	ATL-13521-30	CURVE INSIDE FRAME, 32.5" RADIUS, 30 DEG
2	ATL-13526-BF	CURVE OUTSIDE FRAME, 30 DEG, BF
3	ATL-14210-BF-GP	GRAVITY TAPER ROLLER: 2 1/2" OD - 1 11/16" OD
4	ATL-13432-BF	PIPE SPREADER, GALV ROUND SPREADER - BF
5	ATL-13969	2.5" V-SHEAVE WITH SPACER
6	ATL-13455	V-BELT, METALLIC FINGER GUARD, 1 BOLT TYPE
7	ATL-14211	V BELT TAKE UP V SHEAVE WELDED SPREADER ASSEMBLY
8	ATL-14206	FLAT IDLER TAKE UP ASSEMBLY
9	ATL-13517-OAL-L	CURVE TANGENT FRAME, OVER ALL LENGTH, LEFT
10	ATL-13517-OAL-R	CURVE TANGENT FRAME, OVER ALL LENGTH, RIGHT
11	ATL-13479-BF-GP	GRAVITY ROLLER: 1.9" OD
12	ATL-14208-BF-GP	DRIVE ROLLER: 1.9" OD, SINGLE GROOVE
13	ATL-13430-BF	V-BELT END BEARING SUPPORT - BF
14	ATL-13431	BUTT COUPLER
15	ATL-13448	SPLICE PLATE
16	ATL-13965-4	V-BELT, METAL FINGER GUARDS, 4 GUARDS
17	ATL-13500-N	IDLER ASSEMBLY SHEAVE ASSEMBLY: 1" DIA. SHAFT, NON-ADJUSTABLE
18	ATL-13502-BF	DRIVE / SLAVE END SHEAVE ASSEMBLY: 1 1/4" DIA. SHAFT, OPPOSITE SIDE SLAVE / DRIVEN BF
19	ATL-13534-R	RETURN SHEAVE BRACKET / GUARD
20	ATL-13535	RETURN FLAT IDLER SUPPORT
21	ATL-13483	3" FLAT IDLER WHEEL
22	ATL-13534-L	RETURN SHEAVE BRACKET / GUARD
23	SPECIFIC TO ORDER	REDUCER
24	SPECIFIC TO ORDER	MOTOR
25	ATL-13653-C	CHAIN GUARD BACK PLATE, CURVE
26	ATL-13656-C	CHAIN GUARD WELDMENT, CURVE
27	ATL-13657-OAL	CHAIN GUARD, SUPPORT BAR
28	SPECIFIC TO ORDER	DRIVE SPROCKET: RC50 SERIES
29	SPECIFIC TO ORDER	DRIVEN SPROCKET: RC50 SERIES
30	ATL-13658-OAL	CHAIN GUARD, SUPPORT PIPE
31	ATL-13471-BF-S	V-BELT END GUARD: (BF) STANDARD
32	SPECIFIC TO ORDER	B-SECTION V-BELT (CONVEYOR SPECIFIC)
33	SPECIFIC TO ORDER	DRIVE CHAIN: RC50 SERIES
34	ATL-13687-BF-R(L)	CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 60-40 DEG CURVE, LONG, BF, RIGHT(LEFT)
35	ATL-13686-BF-R(L)	CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 60-45-30 DEG CURVE, SHORT, BF, RIGHT(LEFT)
36	ATL-13470-BF-R(L)	V-BELT, MOTOR / REDUCER MOUNT ASSEMBLY, BF, RIGHT(LEFT)

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL
DRAWING AND PARTS LIST (30° SPUR)



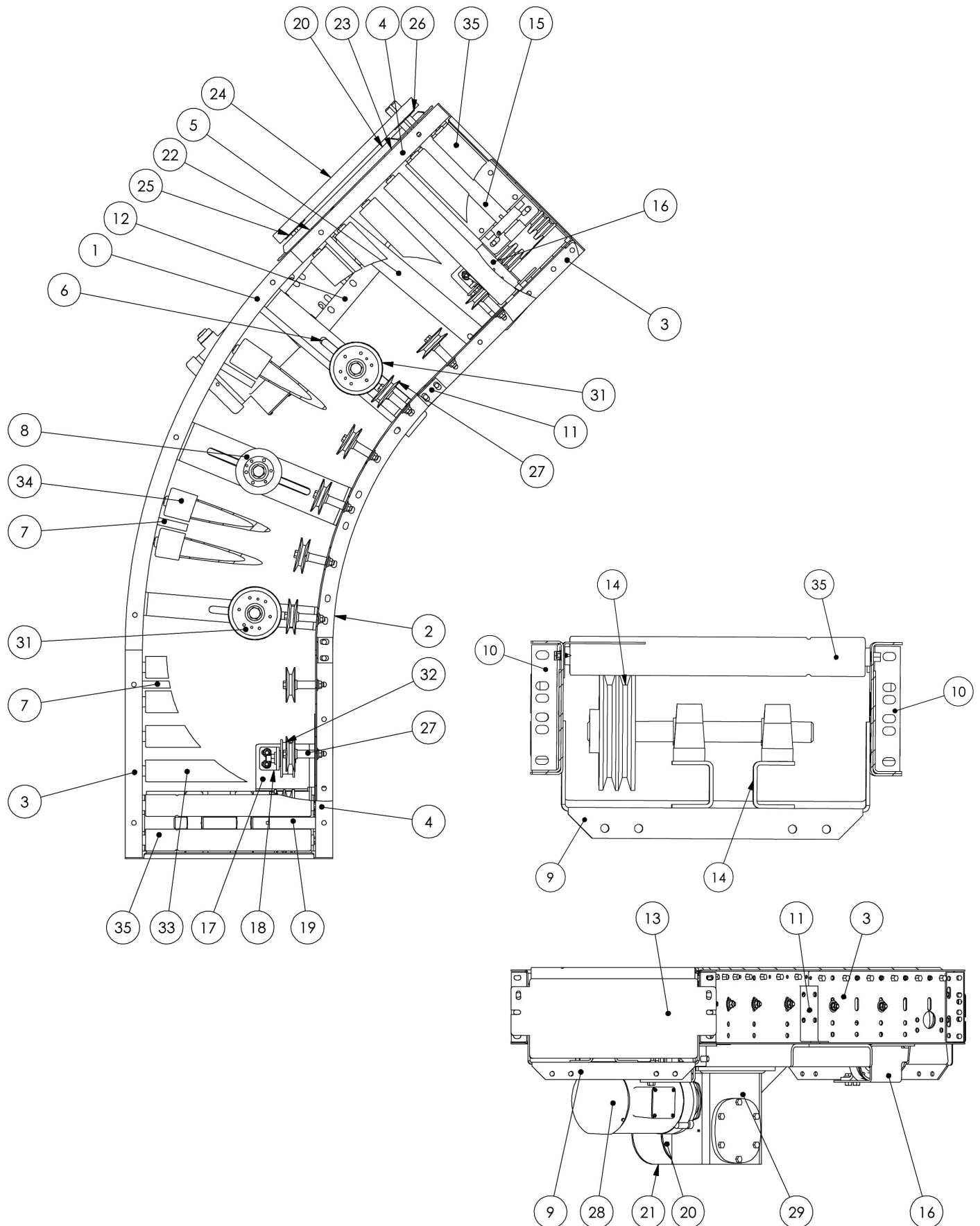
DRAWING AND PARTS LIST (30° SPUR)

DET.	PART NO.	DESCRIPTION
1	ATL-13524-BF	CURVE OUTSIDE FRAME, 60 DEG, (BF)
2	ATL-13521-60	CURVE INSIDE FRAME, 32.5" RADIUS, 60 DEG
3	ATL-13516-OAL	CURVE TANGENT FRAME,OAL REVERSABLE
4	ATL-13544-OAL	30 DEG CURVE SPUR LONG TANGENT FRAME
5	ATL-13545-BF-R(L)	30 DEG CURVE SPUR SHORT TANGENT FRAME
6	ATL-13686-BF-L(R)	CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 60-45-30 DEG CURVE,SHORT, (BF), LEFT(RIGHT)
7	ATL-13687-BF-L(R)	CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 60-40 DEG CURVE, LONG, (BF), LEFT(RIGHT)
8	ATL-13432-BF	PIPE SPREADER, GALV ROUND SPREADER BF
9	ATL-14211	V BELT TAKE UP V SHEAVE WELDED SPREADER ASSEMBLY
10	ATL-11735-BF	ROLLER CONVEYOR SPUR SHELF, (BF), 30 DEG
11	ATL-11743	SPUR AXLE SUPPORT, 30 DEG
12	ATL-11746-OAL	SHELF REINFORCEMENT OAL
13	ATL-13430-BF	END BEARING SUPPORT (BF)
14	ATL-13431	BUTT COUPLER
15	ATL-13447	SPUR SHELF MOUNT BRACKET
16	ATL-13448	SPLICE PLATE
17	ATL-13455	METALIC FINGER GUARD, (1) BOLT TYPE
18	ATL-13468-BF	MOTOR / REDUCER MOUNT PLATE (BF)
19	ATL-13502-BF	DRIVE / SLAVE END ASSEMBLY
20	ATL-13540-DEG	SPUR SHELF BRACKET MOUNT, OPEN END
21	ATL-13541-30	SPUR 30 DEG SHELF MOUNT, ANGLE
22	ATL-13656-C	CHAIN GUARD CURVE
23	ATL-13658	CHAIN GUARD, SUPPORT PIPE
24	ATL-13965	METAL FINGER GUARDS (CONVEYOR SPECIFIC)
25	ATL-13969	2.5" V-SHEAVE WITH SPACER
26	SPECIFIC TO ORDER	DRIVE CHAIN: RC50 SERIES
27	SPECIFIC TO ORDER	DRIVE SPROCKET: RC50 SERIES
28	SPECIFIC TO ORDER	DRIVEN SPROCKET: RC50 SERIES
29	SPECIFIC TO ORDER	MOTOR
30	SPECIFIC TO ORDER	REDUCER
31	ATL-14206	FLAT IDLER TAKE UP ASSEMBLY
32	ATL-13732	4" V-SPACER
33	ATL-14210-BF	GRAVITY TAPER ROLLER: 2 1/2" OD - 1 11/16" OD
34	ATL-13479-BF-GP	BED ROLLER: 1.9" OD
35	ATL-14208-BF-GP	DRIVE ROLLER: 1.9" OD, SINGLE GROOVE
36	SPECIFIC TO ORDER	BED ROLLER: 1.9" OD, LESS AXLE
37	SPECIFIC TO ORDER	B-SECTION V-BELT (CONVEYOR SPECIFIC)

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

DRAWING AND PARTS LIST (45° CURVE)



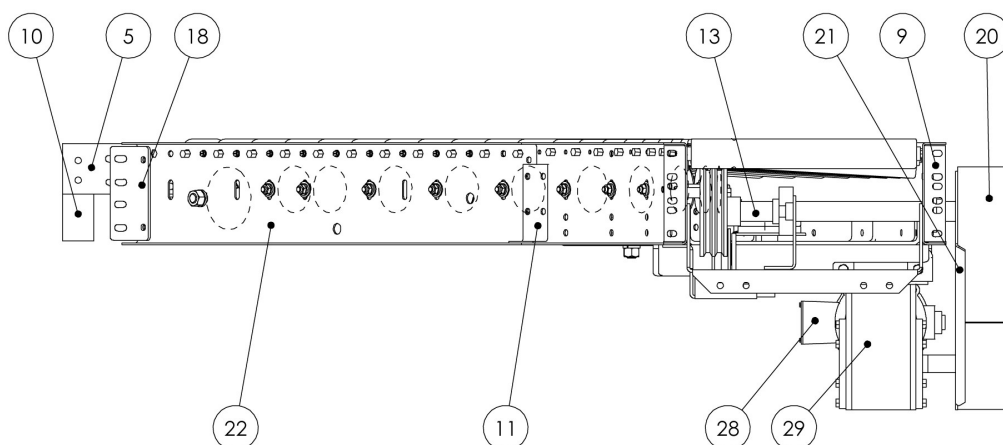
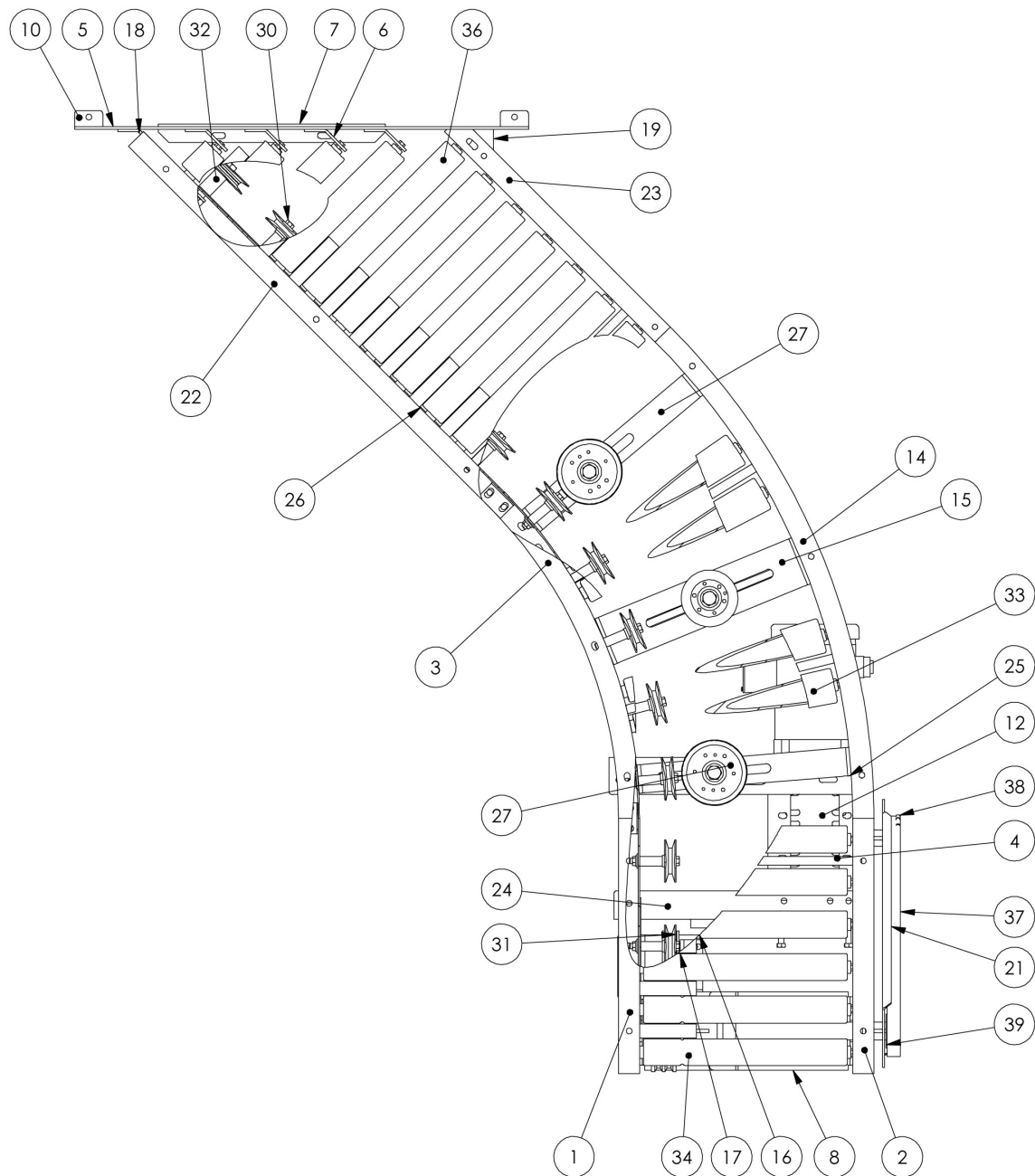
DRAWING AND PARTS LIST (45° CURVE)

DET.	PART NO.	DESCRIPTION
1	ATL-13525-15	CURVE OUTSIDE FRAME, 45 DEG, BF
2	ATL-13521-45	CURVE INSIDE FRAME, 32.5" RADIUS, 45 DEG
3	ATL-13517-OAL-L	CURVE TANGENT FRAME, OVER ALL LENGTH, LEFT
4	ATL-13517-OAL-R	CURVE TANGENT FRAME, OVER ALL LENGTH, RIGHT
5	ATL-13686-BF-R	CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 60-45-30 DEG CURVE, SHORT, (BF), RIGHT
6	ATL-13687-BF-R	CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 60-40 DEG CURVE, LONG, (BF), RIGHT
7	ATL-13432-BF	PIPE SPREADER, GALV ROUND SPREADER BF
8	ATL-14211	V BELT TAKE UP V SHEAVE WELDED SPREADER ASSEMBLY
9	ATL-13430-BF	V-BELT END BEARING SUPPORT BF
10	ATL-13431	BUTT COUPLER
11	ATL-13448	SPLICE PLATE
12	ATL-13470-6-R(L)	MOTOR / REDUCER MOUNT ASSEMBLY, (BF), RIGHT(LEFT)
13	ATL-13471-BF-S	END GUARD- BF STANDARD
14	ATL-13500-N	IDLER ASSEMBLY, 1" SHAFT, NON-ADJUSTABLE
15	ATL-13502-15	DRIVE / SLAVE END, 1-1/4 SHAFT, OPPOSITE SIDE SLAVE / DRIVEN BF
16	ATL-13534-L	RETURN SHEAVE BRACKET / GUARD - LEFT
17	ATL-13534-R	RETURN SHEAVE BRACKET / GUARD - RIGHT
18	ATL-13535	RETURN FLAT IDLER SUPPORT
19	ATL-13965	V-BELT, METAL FINGER GUARDS (CONVEYOR SPECIFIC)
20	ATL-13653-C	CHAIN GUARD BACK PLATE, CURVE
21	ATL-13656-C	CHAIN GUARD WELDMENT, CURVE
22	ATL-13657	CHAIN GUARD, SUPPORT BAR
23	ATL-13658-OAL	CHAIN GUARD, SUPPORT PIPE
24	SPECIFIC TO ORDER	DRIVE CHAIN: RC50 SERIES
25	SPECIFIC TO ORDER	DRIVE SPROCKET: RC50 SERIES
26	SPECIFIC TO ORDER	DRIVEN SPROCKET: RC50 SERIES
27	ATL-13969	3" V-SHEAVE WITH SPACER
28	SPECIFIC TO ORDER	MOTOR
29	SPECIFIC TO ORDER	REDUCER
30	SPECIFIC TO ORDER	B-SECTION V-BELT (CONVEYOR SPECIFIC)
31	ATL-14206	FLAT IDLER TAKE UP ASSEMBLY
32	ATL-13483	3" FLAT IDLER
33	ATL-13479-BF-GP	BED ROLLER: 1.9" OD
34	ATL-14210-BF	GRAVITY TAPER ROLLER: 2 1/2" OD - 1 11/16" OD
35	ATL-14208-BF-GP	DRIVE ROLLER: 1.9" OD, SINGLE GROOVE

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

DRAWING AND PARTS LIST (45° SPUR)



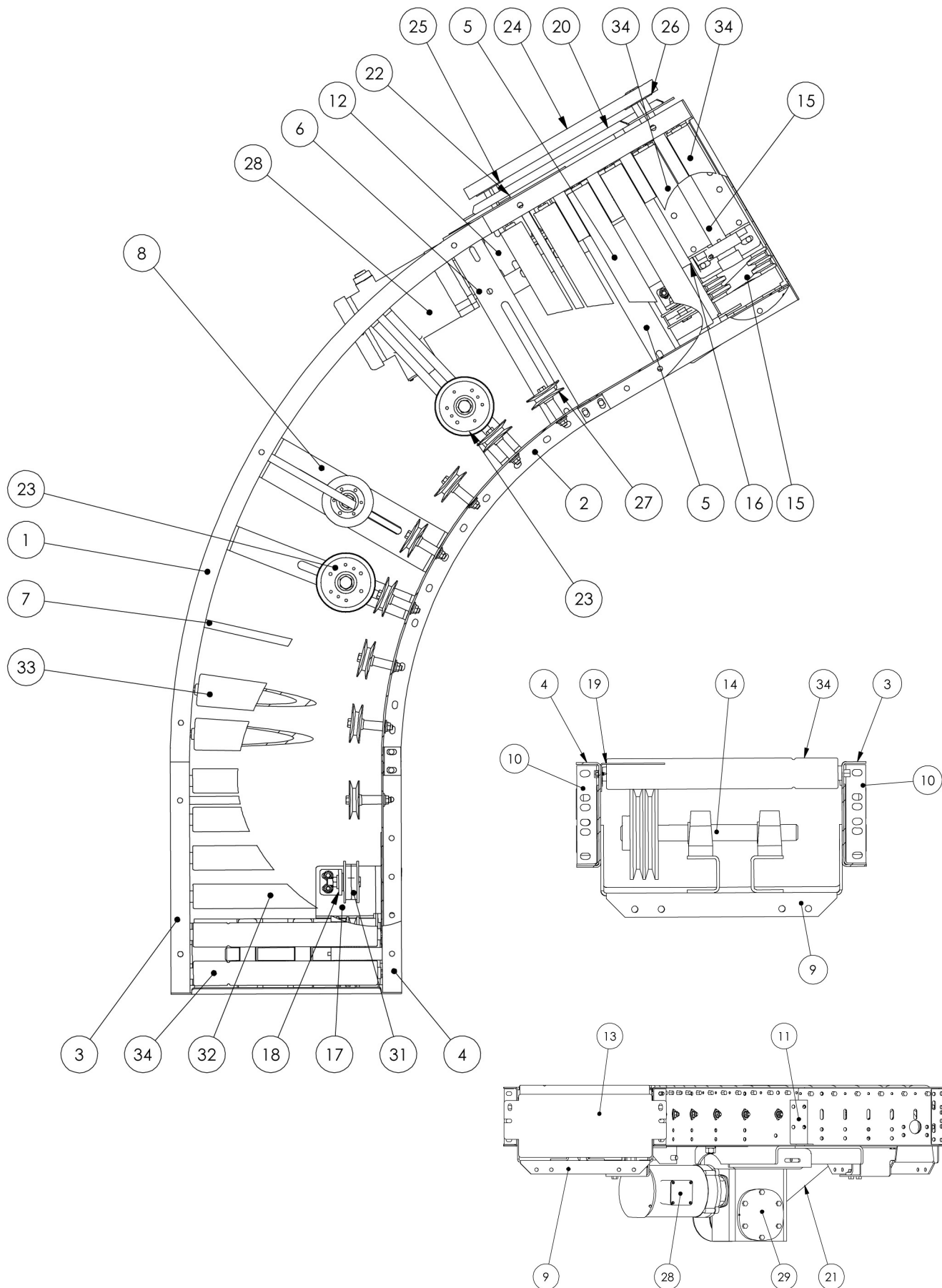
DRAWING AND PARTS LIST (45° SPUR)

DET.	PART NO.	DESCRIPTION
1	ATL-13517-OAL-L	V-BELT, 1.9 CURVE TANGENT FRAME, OVER ALL LENGTH, LEFT
2	ATL-13517-OAL-R	V-BELT, 1.9 CURVE TANGENT FRAME, OVER ALL LENGTH, RIGHT
3	ATL-13521-45	V-BELT, 1.9 CURVE INSIDE FRAME, 32.5" RADIUS, 45 DEG
4	ATL-13432-BF	PIPE SPREADER, GALV ROUND SPREADER BF
5	ATL-11736-OAL	ROLLER CONVEYOR SPUR SHELF, OAL, 45 DEG
6	ATL-11744	SPUR AXLE SUPPORT, 45 DEG
7	ATL-11746-OAL	SHELF REINFORCEMENT OAL
8	ATL-13430-BF	V-BELT END BEARING SUPPORT (BF)
9	ATL-13431	BUTT COUPLER
10	ATL-13447	SPUR SHELF MOUNT BRACKET
11	ATL-13448	SPLICE PLATE
12	ATL-13470-BF-R(L)	V-BELT, MOTOR / REDUCER MOUNT ASSEMBLY, RIGHT(LEFT)
13	ATL-13502-BF	DRIVE / SLAVE END, 1-1/4 SHAFT, OPPOSITE SIDE SLAVE / DRIVEN, (BF)
14	ATL-13525-15	V-BELT, 1.9 CURVE OUTSIDE FRAME, 45 DEG, (BF)
15	ATL-14211	V BELT TAKE UP V SHEAVE WELDED SPREADER
16	ATL-13533-L	RETURN SHEAVE BRACKET / GUARD
17	ATL-13535	RETURN FLAT IDLER SUPPORT
18	ATL-13540-DEG	V-BELT, 1.9 SPUR SHELF BRACKET MOUNT, OPEN END
19	ATL-13541-45	SPUR 30 DEG SHELF MOUNT, ANGLE
20	ATL-13656-C	V-BELT, 1.9 CHAIN GUARD WELDMENT, CURVE
21	ATL-13653-C	V-BELT, 1.9 CHAIN GUARD BACK PLATE, CURVE
22	ATL-13542-OAL	V-BELT, 1.9 45 DEG CURVE SPUR LONG TANGENT FRAME
23	ATL-13543-BF-L	V-BELT, 1.9 45 DEG CURVE SPUR SHORT TANGENT FRAME
24	ATL-13686-BF-R(L)	V-BELT, 1.9 CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 60-45-30 DEG CURVE, SHORT, (BF), RIGHT(LEFT)
25	ATL-13687-BF-R(L)	V-BELT, 1.9 CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 60-40 DEG CURVE, LONG, (BF), RIGHT(LEFT)
26	ATL-13965	V-BELT, METAL FINGER GUARDS (CONVEYOR SPECIFIC)
27	ATL-14206	FLAT IDLER TAKE UP ASSEMBLY
28	SPECIFIC TO ORDER	MOTOR
29	SPECIFIC TO ORDER	REDUCER
30	ATL-13969	3" V SHEAVE WITH SPACER
31	ATL-13483	3" FLAT IDLER
32	ATL-13732	4" V-SHEAVE WITH SPACER
33	ATL-14210-BF	GRAVITY TAPER ROLLER: 2 1/2" OD - 1 11/16" OD
34	ATL-14208-BF-GP	DRIVE ROLLER: 1.9" OD, SINGLE GROOVE
35	SPECIFIC TO ORDER	B-SECTION V-BELT (CONVEYOR SPECIFIC)
36	ATL-13479-BF-GP	BED ROLLER: 1.9" OD
37	SPECIFIC TO ORDER	DRIVE CHAIN: RC50 SERIES
38	SPECIFIC TO ORDER	DRIVE SPROCKET: RC50 SERIES
39	SPECIFIC TO ORDER	DRIVEN SPROCKET: RC50 SERIES

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

DRAWING AND PARTS LIST (60° CURVE)



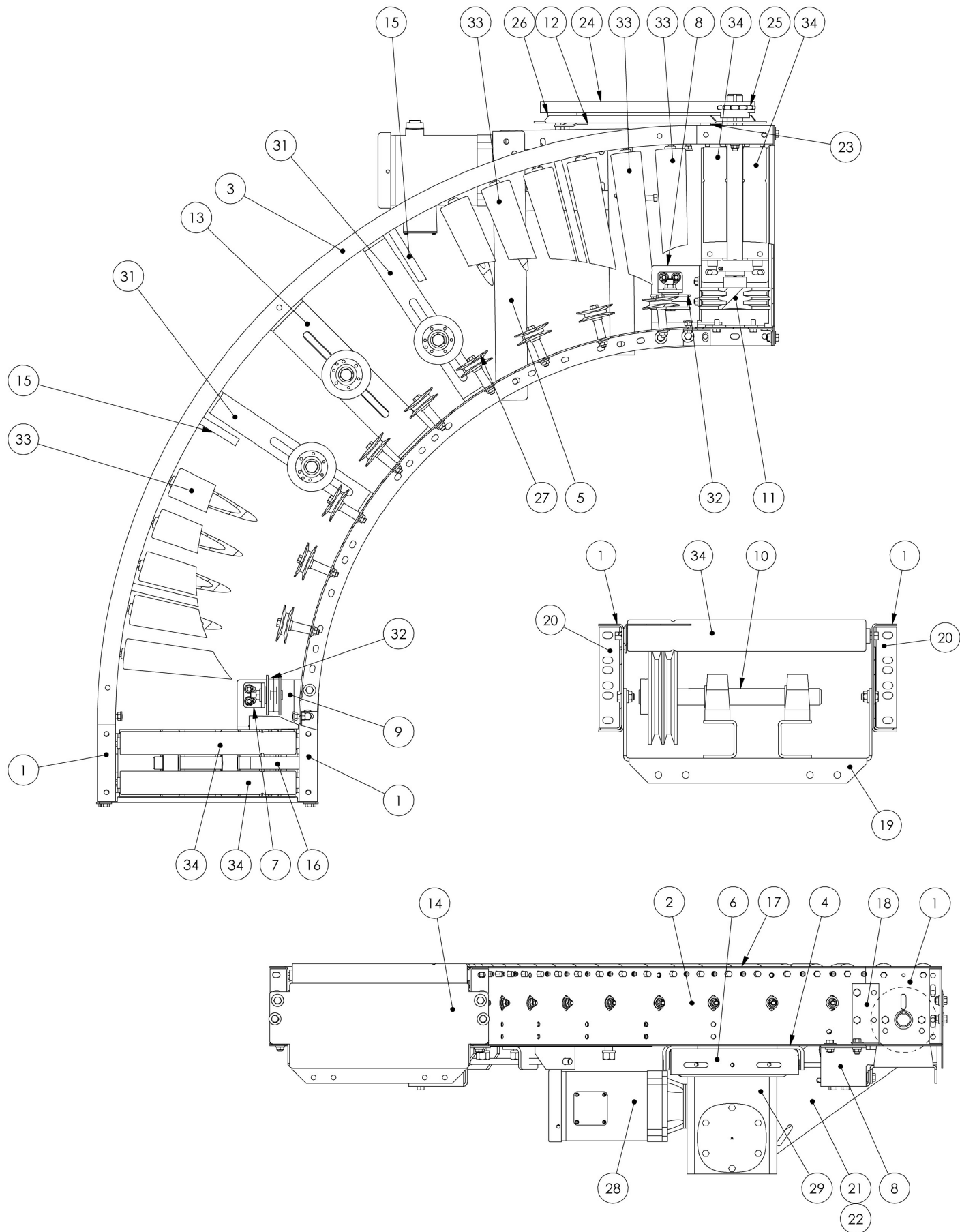
DRAWING AND PARTS LIST (60° CURVE)

DET.	PART NO.	DESCRIPTION
1	ATL-13524-BF	CURVE OUTSIDE FRAME, 60 DEG, (BF)
2	ATL-13521-60	CURVE INSIDE FRAME, 32.5" RADIUS, 60 DEG
3	ATL-13517-OAL-L	CURVE TANGENT FRAME, OVER ALL LENGTH, LEFT
4	ATL-13517-OAL-R	CURVE TANGENT FRAME, OVER ALL LENGTH, RIGHT
5	ATL-13686-BF-R(L)	V-BELT, 1.9 CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 60-45-30 DEG CURVE, SHORT, (BF), RIGHT(LEFT)
6	ATL-13687-BF-R	V-BELT, 1.9 CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 60-40 DEG CURVE, LONG, (BF), RIGHT(LEFT)
7	ATL-13432-BF	PIPE SPREADER, GALV ROUND SPREADER BF
8	ATL-14211	V-BELT TAKE UP V-SHEAVE WELDED SPREADER
9	ATL-13430-BF	END BEARING SUPPORT (BF)
10	ATL-13431	BUTT COUPLER
11	ATL-13448	SPLICE PLATE
12	ATL-13470-BF-R(L)	MOTOR / REDUCER MOUNT ASSEMBLY, (BF), RIGHT(LEFT)
13	ATL-13471-BF-S	END GUARD-BF STANDARD
14	ATL-13500-N	IDLER ASSEMBLY, 1" SHAFT, NON-ADJUSTABLE
15	ATL-13502-15	V-BELT, 1.9 DRIVE / SLAVE END, 1-1/4 SHAFT, OPPOSITE SIDE SLAVE / DRIVEN, (BF)
16	ATL-13534-L	RETURN SHEAVE BRACKET / GUARD
17	ATL-13534-R	RETURN SHEAVE BRACKET / GUARD
18	ATL-13535	RETURN FLAT IDLER SUPPORT
19	ATL-13965	V-BELT, METAL FINGER GUARDS CONVEYOR SPECIFIC
20	ATL-13653-C	CHAIN GUARD BACK PLATE, CURVE
21	ATL-13656-C	CHAIN GUARD WELDMENT, CURVE
22	ATL-13657	CHAIN GUARD, SUPPORT BAR
23	ATL-14206	FLAT IDLER TAKE UP ASSEMBLY
24	SPECIFIC TO ORDER	DRIVE CHAIN: RC50 SERIES
25	SPECIFIC TO ORDER	DRIVE SPROCKET: RC50 SERIES
26	SPECIFIC TO ORDER	DRIVEN SPROCKET: RC50 SERIES
27	ATL-13969	3" V-SHEAVE WITH SPACER
28	SPECIFIC TO ORDER	MOTOR
29	SPECIFIC TO ORDER	REDUCER
30	SPECIFIC TO ORDER	B-SECTION V-BELT (CONVEYOR SPECIFIC)
31	ATL-13483	3" FLAT IDLER
32	ATL-13479-BF-GP	BED ROLLER: 1.9" OD
33	ATL-14210-BF	GRAVITY TAPER ROLLER: 2 1/2" OD - 1 11/16" OD
34	ATL-14208-BF-GP	DRIVE ROLLER: 1.9" OD, SINGLE GROOVE

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

DRAWING AND PARTS LIST (90° CURVE)



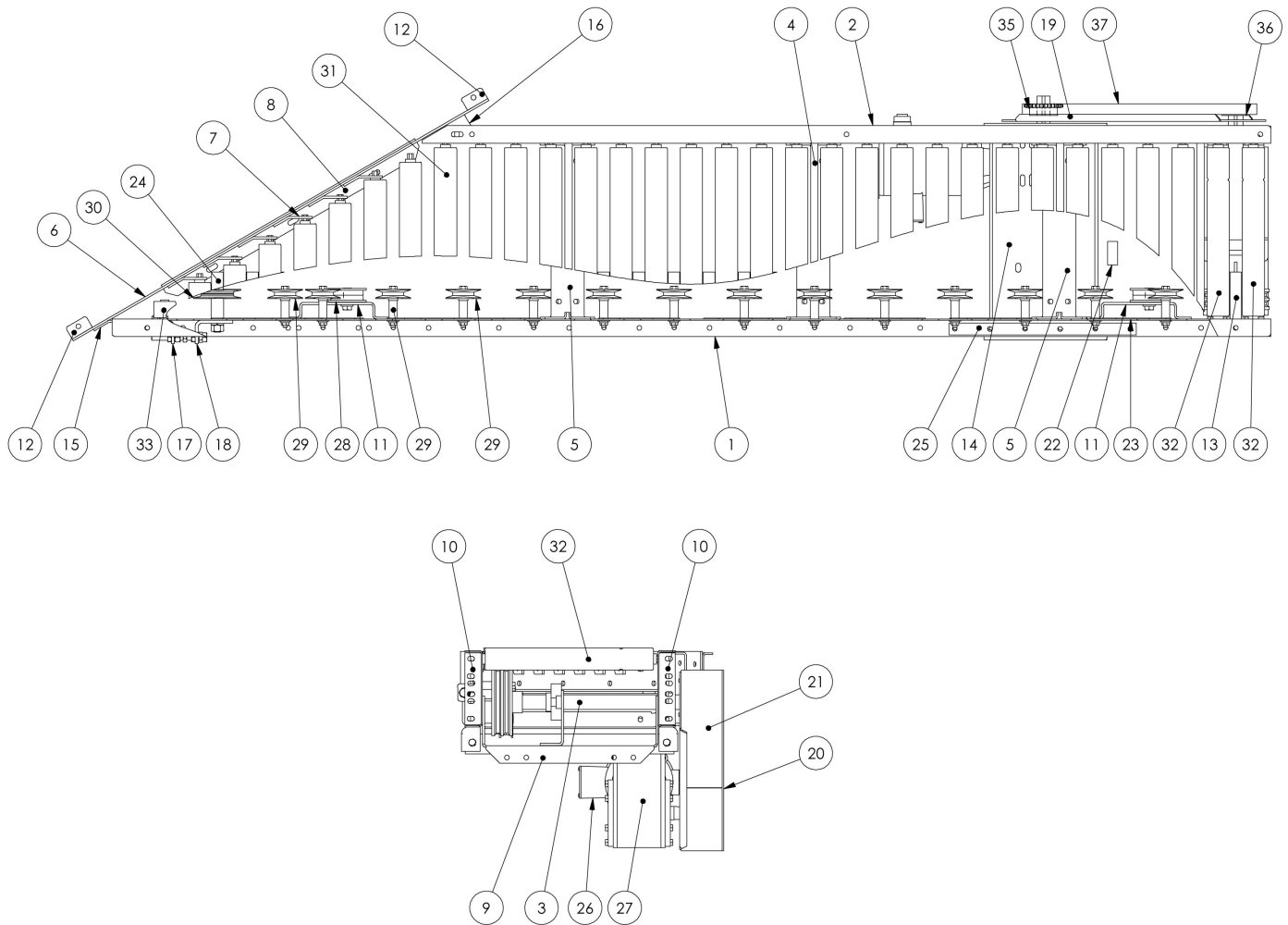
DRAWING AND PARTS LIST (90° CURVE)

DET.	PART NO.	DESCRIPTION
1	ATL-13516-OAL	CURVE TANGENT FRAME, OAL REVERSABLE
2	ATL-13521-90	CURVE INSIDE FRAME, 32.5" RADIUS, 90 DEG
3	ATL-13523-BF	CURVE OUTSIDE FRAME, 90 DEG, BF
4	ATL-13564-BF-R	V-BELT, 1.9 CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 90 DEG CURVE, SHORT, (BF), RIGHT
5	ATL-13565-BF-R	V-BELT, 1.9 CURVE UNDERHUNG MOTOR MOUNT FORMED ANGLE, 90 DEG CURVE, LONG, (BF), RIGHT
6	ATL-13470-BF-R(L)	MOTOR / REDUCER MOUNT ASSEMBLY, (BF), RIGHT(LEFT)
7	ATL-13535	RETURN FLAT IDLER SUPPORT
8	ATL-13534-L	RETURN SHEAVE BRACKET / GUARD - LEFT
9	ATL-13534-R	RETURN SHEAVE BRACKET / GUARD - RIGHT
10	ATL-13500-N	IDLER ASSEMBLY, 1" SHAFT, NON-ADJUSTABLE
11	ATL-13502-BF	DRIVE / SLAVE END, 1 1/4" SHAFT, OPPOSITE SIDE SLAVE / DRIVEN (BF)
12	ATL-13657	CHAIN GUARD, SUPPORT BAR
13	ATL-14211	V BELT TAKE UP V SHEAVE WELDED SPREADER ASSEMBLY
14	ATL-13471-BF-S	END GUARD-BF STANDARD
15	ATL-13432-BF	PIPE SPREADER, GALV. ROUND SPREADER (BF)
16	ATL-13455	METALLIC FINGER GUARD, 1 BOLT TYPE
17	ATL-13966	METAL FINGER GUARDS (CONVEYOR SPECIFIC)
18	ATL-13448	SPLICE PLATE
19	ATL-13430-BF	END BEARING SUPPORT BF
20	ATL-13431	BUTT COUPLER
21	ATL-13653-C	CHAIN GUARD BACK PLATE, CURVE
22	ATL-13656-C	CHAIN GUARD WELDMENT, CURVE
23	ATL-13658-OAL	CHAIN GUARD, SUPPORT PIPE
24	SPECIFIC TO ORDER	DRIVE CHAIN: RC50 SERIES
25	SPECIFIC TO ORDER	DRIVEN SPROCKET: RC50 SERIES
26	SPECIFIC TO ORDER	DRIVE SPROCKET: RC50 SERIES
27	ATL-13969	2.5" V-SHEAVE WITH SPACER
28	SPECIFIC TO ORDER	MOTOR
29	SPECIFIC TO ORDER	REDUCER
30	SPECIFIC TO ORDER	B-SECTION V-BELT (CONVEYOR SPECIFIC)
31	ATL-14207	V-IDLER TAKE UP ASSEMBLY
32	ATL-13483	FLAT IDLER WHEEL
33	ATL-14210-BF-GP	GRAVITY TAPER ROLLER: 2 1/2" OD - 1 11/16" OD
34	ATL-14208-BF-GP	DRIVE ROLLER: 1.9" OD, SINGLE GROOVE

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

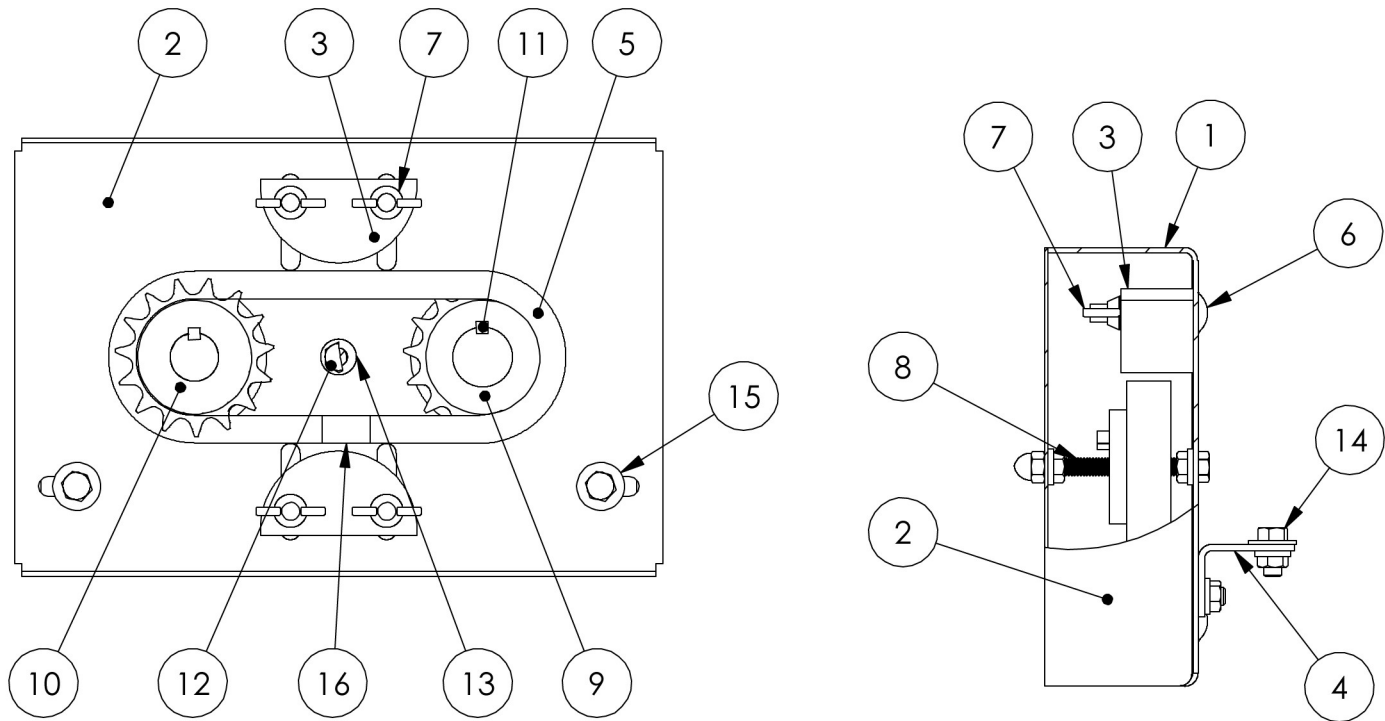
DRAWING AND PARTS LIST (STRAIGHT SPUR)



DRAWING AND PARTS LIST (30° STRAIGHT SPUR)

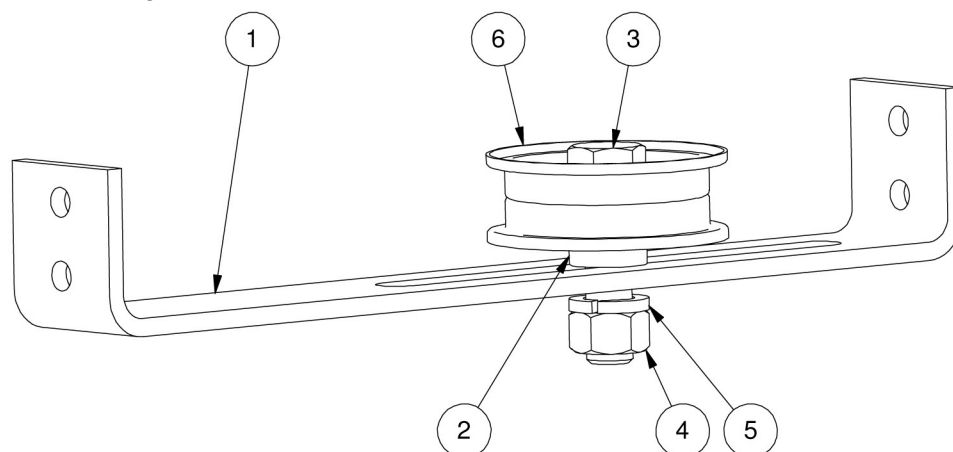
DET.	PART NO.	DESCRIPTION
1	ATL-13550-OAL-L	STRAIGHT SPUR FRAME, LONG FRAME
2	ATL-13552-BF-L	30 DEG STRAIGHT SPUR FRAME, SHORT FRAME
3	ATL-13502-BF	DRIVE / SLAVE END, 1-1/4 SHAFT, OPPOSITE SIDE SLAVE / DRIVEN, (BF)
4	ATL-13432-BF	PIPE SPREADER, GALV. ROUND SPREADER, (BF)
5	ATL-11695-BF	SPREADER (BF)
6	ATL-11735	ROLLER CONVEYOR SPUR SHELF, 30 DEG
7	ATL-11743	SPUR AXLE SUPPORT, 30 DEG
8	ATL-11746-OAL	SHELF REINFORCEMENT (OAL)
9	ATL-13430-BF	END BEARING SUPPORT (BF)
10	ATL-13431	BUTT COUPLER
11	ATL-13433	RETURN ROLLER SUPPORT
12	ATL-13447	SPUR SHELF MOUNT BRACKET
13	ATL-13455	METALLIC FINGER GUARD, (1) BOLT TYPE
14	ATL-13468-BF	MOTOR / REDUCER MOUNT PLATE (BF)
15	ATL-13540-DEG	SPUR SHELF BRACKET MOUNT, OPEN END, (DEGREE DEPENDENT)
16	ATL-13541-30	SPUR 30 DEG SHELF MOUNT, ANGLE
17	ATL-13555	STRAIGHT SPUR TAKEUP STATIONARY BRACKET
18	ATL-13556	STRAIGHT SPUR TAKEUP ADJUSTABLE BRACKET
19	ATL-13653-S	CHAIN GUARD BACK PLATE
20	ATL-13654-S	CHAIN GUARD FRONT PLATE, STRAIGHT
21	ATL-13656-S	CHAIN GUARD SIDE PLATE, STRAIGHT
22	ATL-13658-OAL	CHAIN GUARD, SUPPORT PIPE, 2" LONG
23	ATL-13965-3	METAL FINGER GUARDS, 3 GUARDS
24	ATL-13965-5	METAL FINGER GUARDS, 5 GUARDS
25	ATL-14103	V-BELT MOTOR / REDUCER MOUNT REINFORCEMENT BAR
26	SPECIFIC TO ORDER	MOTOR
27	SPECIFIC TO ORDER	REDUCER
28	ATL-13483	3" FLAT IDLER
29	ATL-13969	3" V-SHEAVE WITH SPACER
30	ATL-13485	4" V-IDLER
31	ATL-13479-BF-GP	BED ROLLER: 1.9" OD
32	ATL-14208-BF-GP	DRIVE ROLLER: 1.9" OD, SINGLE GROOVE
33	SPECIFIC TO ORDER	BED ROLLER: 1.9" OD, LESS AXLE
34	SPECIFIC TO ORDER	B-SECTION V-BELT (CONVEYOR SPECIFIC)
35	SPECIFIC TO ORDER	DRIVEN SPROCKET: RC50 SERIES
36	SPECIFIC TO ORDER	DRIVE SPROCKET: RC50 SERIES
37	SPECIFIC TO ORDER	DRIVE CHAIN: RC50 SERIES

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

DRAWING AND PARTS LIST (SLAVE KIT)

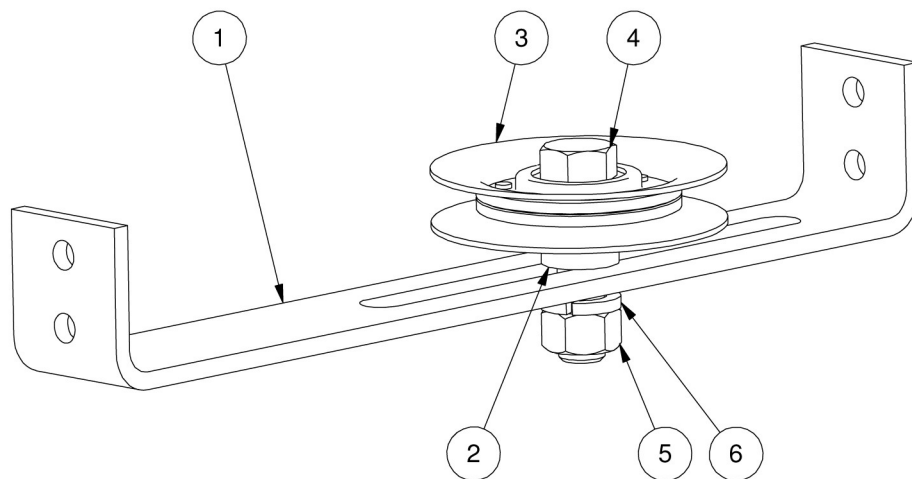
DET.	PART NO.	DESCRIPTION
1	ATL-13677	V-BELT, SLAVE KIT BACK
2	ATL-13676	SLAVE KIT FRONT COVER
3	ATL-13678	V-BELT, SLAVE KIT UHMW GUIDE
4	ATL-13679	V-BELT, SLAVE KIT MOUNT ANGLE FOOT
5	ATL-13680	CHAIN LOOP: RC50, 34 PITCHES, RIVETED WITH MASTER LINK, ASSEMBLED
6	ATL-13682-2.25	CARRIAGE BOLT: 3/8-16 x 2 1/4" LONG, GRADE 5, ZINC PLATED
7	ATL-13683	WING NUT, 3/8-16, ZINC PLATED
8	ATL-13684	TAP BOLT, 3/8-16 x 3-1/2 FULLY THREADED
9	SPECIFIC TO ORDER	SPROCKET: 50B15, KEYWAY, (2) SET SCREWS
10	SPECIFIC TO ORDER	SPROCKET: 50B15, KEYWAY, (2) SET SCREWS
11	ATL-10743	1/4" SQ. KEYSTOCK - 1 1/4" LG
12	ATL-10748	ACORN NUT, 3/8-16
13	ATL-101154	WHIZ NUT (FLANGE) : 3/8-16, ZINC PLATED
14	ATL-12905-0.75	3/8-16 HHCS x 3/4" LONG (GRADE 5)
15	ATL-12903-.75	3/8" FLAT WASHER
16	ATL-13681	50 RC HALF LINK

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

SUB-ASSEMBLIES AND PARTS LIST**FLAT SHEAVE TAKE-UP**

DET.	PART NO.	DESCRIPTION
1	ATL-13472-BF	V-BELT, TAKE UP SHEAVE, SLOTTED (BF DEPENDENT)
2	ATL-13971	3/4" SHORT SPACER
3	ATL-14675	HEX HEAD BOLT: 5/8-11 X 2 1/2" (GRADE 5)
4	ATL-12901-.625	HEX NUT: 5/8-11 (GRADE 5)
5	ATL-14003	LOCK WASHER: 5/8"
6	ATL-13484	5" FLAT IDLER WHEEL

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-SHEAVE TAKE-UP

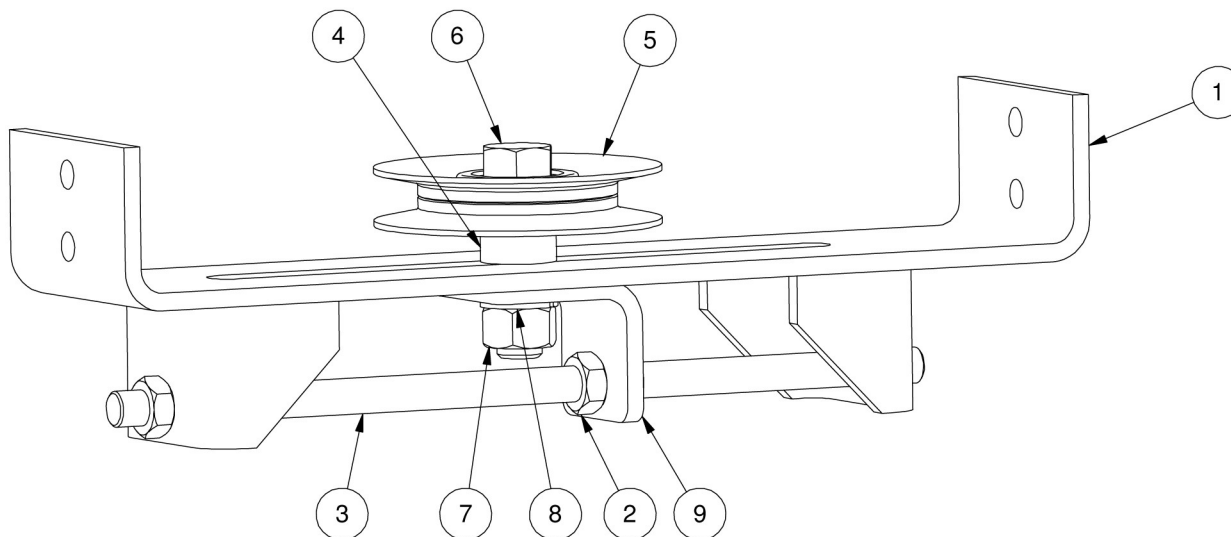
DET.	PART NO.	DESCRIPTION
1	ATL-13472-BF	V-BELT, TAKE UP SHEAVE, SLOTTED (BF DEPENDENT)
2	ATL-13971	3/4 SHORT SPACER
3	ATL-13485	4" V-IDLER WHEEL
4	ATL-14675	HEX HEAD BOLT: 5/8-11 X 2 1/2" LONG (GRADE 5)
5	ATL-12901-.625	HEX NUT: 5/8-11 (GRADE 5)
6	ATL-14003	LOCK WASHER: 5/8"

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

SUB-ASSEMBLIES AND PARTS LIST

MAIN TAKE-UP ASSEMBLY



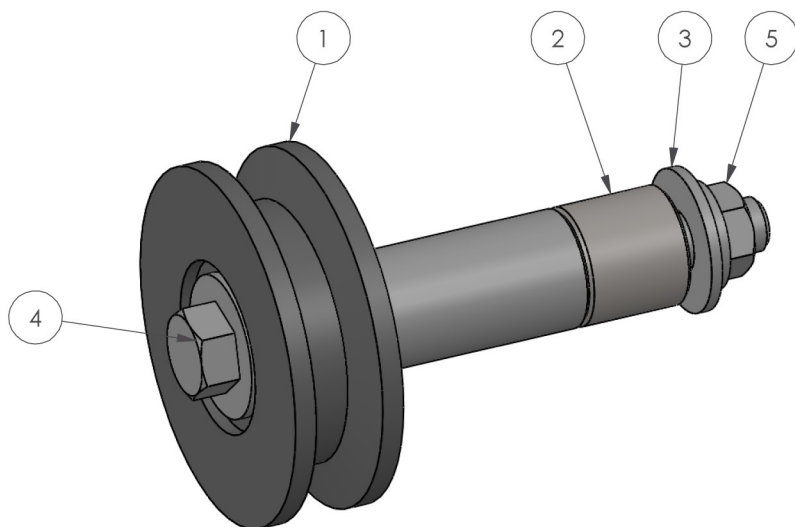
DET.	PART NO.	DESCRIPTION
1	ATL-13474-BF	V-BELT, TAKE UP CENTER SHEAVE BRACKET, SLOTTED FOR WELDEMNT, BF
2	101120	HEX JAM NUT: 1/2-13 (GRADE 5)
3	ATL-13528	THREADED ROD: 1/2-13 X 12 1/2" LONG
4	ATL-13971	3/4 SCH 80 PIPE - .68
5	ATL-13485	4" V-IDLER WHEEL
6	ATL-14675	HEX HEAD BOLT: 5/8-11 X 2 1/2" LONG, (GRADE 5)
7	ATL-12901-.625	HEX NUT: 5/8-11 (GRADE 5)
8	ATL-14003	LOCK WASHER: 5/8"
9	ATL-13476	V-BELT, TAKEUP SHEAVE SLIDE BRACKET

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

SUB-ASSEMBLIES AND PARTS LIST

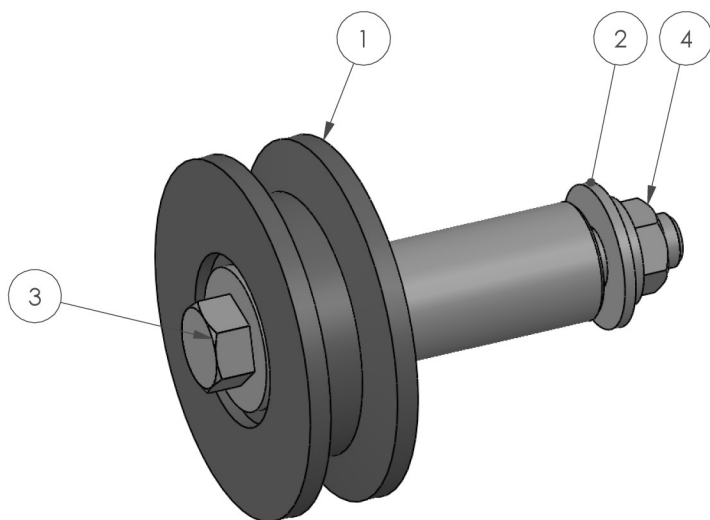
ATL-13970 LONG



DET.	PART NO.	DESCRIPTION
1	ATL-14104	SHEAVE: 2 1/2" OD, B-SECTION V-BELT, WITH NON-REMOVEABLE SHOULDER ADAPTER
2	ATL-14105	SPACER, 3/4" LONG
3	ATL-12903-.375	FLAT WASHER: 3/8"
4	ATL-14676	HEX HEAD BOLT: 3/8-16 X 4" LONG (GRADE 5)
5	ATL-12904	WHIZ NUT (FLANGE) : 3/8-16, ZINC PLATED

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

ATL-13969 SHORT

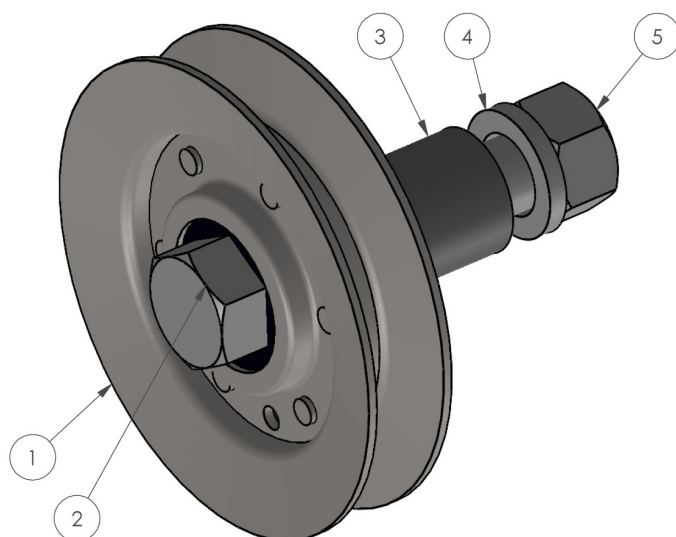


DET.	PART NO.	DESCRIPTION
1	ATL-14104	SHEAVE: 2 1/2" OD, B-SECTION V-BELT, WITH NON-REMOVEABLE SHOULDER ADAPTER
2	ATL-12903-.375	FLAT WASHER: 3/8"
3	ATL-12905-3.25	HEX HEAD BOLT: 3/8-16 X 3 1/4" LONG (GRADE 5)
4	ATL-12904	WHIZ NUT (FLANGE) : 3/8-16, ZINC PLATED

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

SUB-ASSEMBLIES AND PARTS LIST

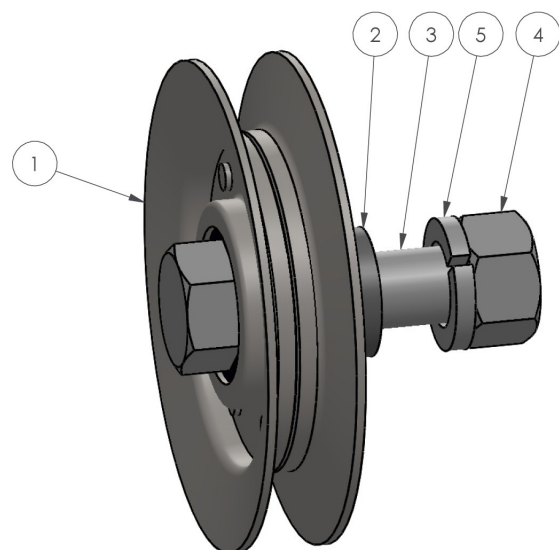
ATL-14244 LONG



DET.	PART NO.	DESCRIPTION
1	ATL-13485	4" V-IDLER WHEEL
2	ATL-14677	HEX HEAD BOLT: 5/8-11 X 3 1/2", (GRADE 5), ZINC PLATED
3	ATL-14245	SPACER, 3/4" LONG
4	ATL-14003	LOCK WASHER: 5/8"
5	ATL-12901-.625	HEX NUT: 5/8-11 (GRADE 5)

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

ATL-13972 SHORT



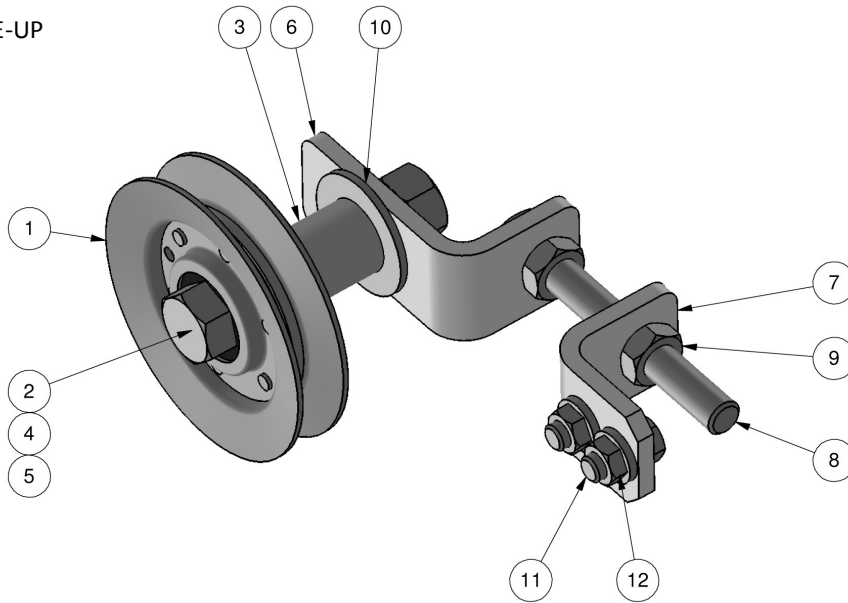
DET.	PART NO.	DESCRIPTION
1	ATL-13485	4" V-IDLER WHEEL
2	ATL-13971	SPACER, 3/4" LONG
3	ATL-14675	HEX HEAD BOLT: 5/8-11 X 2 1/2", (GRADE 5)
4	ATL-12901-.625	HEX NUT: 5/8-11 (GRADE 5)
5	ATL-14003	LOCK WASHER: 5/8"

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

SUB-ASSEMBLIES AND PARTS LIST

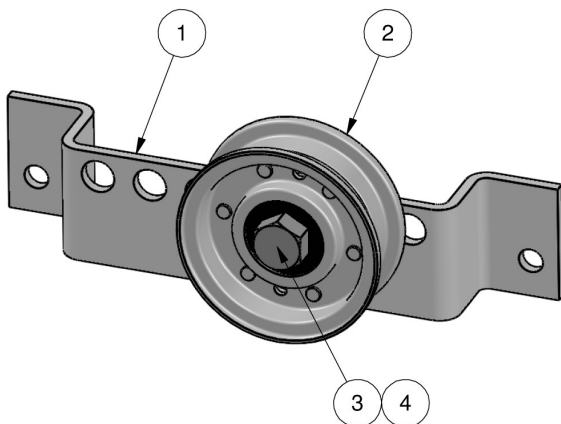
SPUR TAKE-UP



DET.	PART NO.	DESCRIPTION
1	PHO-35400063	4" V-IDLER WHEEL
2	ATL-14677	HEX HEAD CAP SCREW: 5/8-11 X 3 1/2", GRADE 5, ZINC PLATED
3	ATL-14245	3/4 SCH 80 PIPE - 1.90
4	ATL-14003	5/8" LOCK WASHER
5	ATL-12901-.625	5/8-11 HEX NUT (GRADE 5) - ZINC PLATED
6	ATL-13556	V-BELT, 1.9 STRAIGHT SPUR TAKEUP ADJUSTABLE BRACKET
7	ATL-13555	V-BELT, 1.9 STRAIGHT SPUR TAKEUP STATIONARY BRACKET
8	ATL-10750	1/2-13 HHCS x 4" LONG (GRADE 5) (ALL THREAD)
9	ATL-10751	1/2-13 HEX JAM NUT (GRD 5) (ZINC PLATED)
10	ATL-12903-.625	5/8" FLAT WASHER
11	ATL-12905-.075	3/8-16 HHCS x 3/4" LONG (GRADE 5)
12	ATL-12904	WHIZ NUT (FLANGE) : 3/8-16, ZINC PLATED

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

TAKE-UP SHEAVE BRACKET



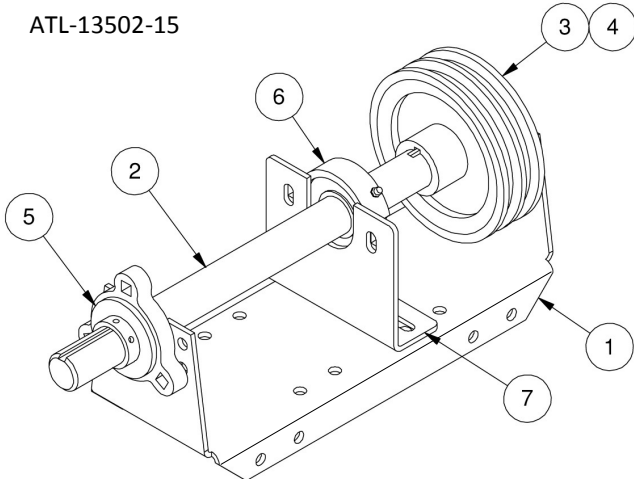
DET.	PART NO.	DESCRIPTION
1	ATL-13433	V-BELT, Return Roller Support
2	ATL-13483-S	3" FLAT IDLER, SHOULDER ADAPTER SHORT
3	ATL-13999	1/2-13 HHCS x 1 1/2" LONG (GRADE 5)
4	ATL-14678	WHIZ NUT (FLANGE) : 1/2-13, ZINC PLATED

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

SUB-ASSEMBLIES AND PARTS LIST

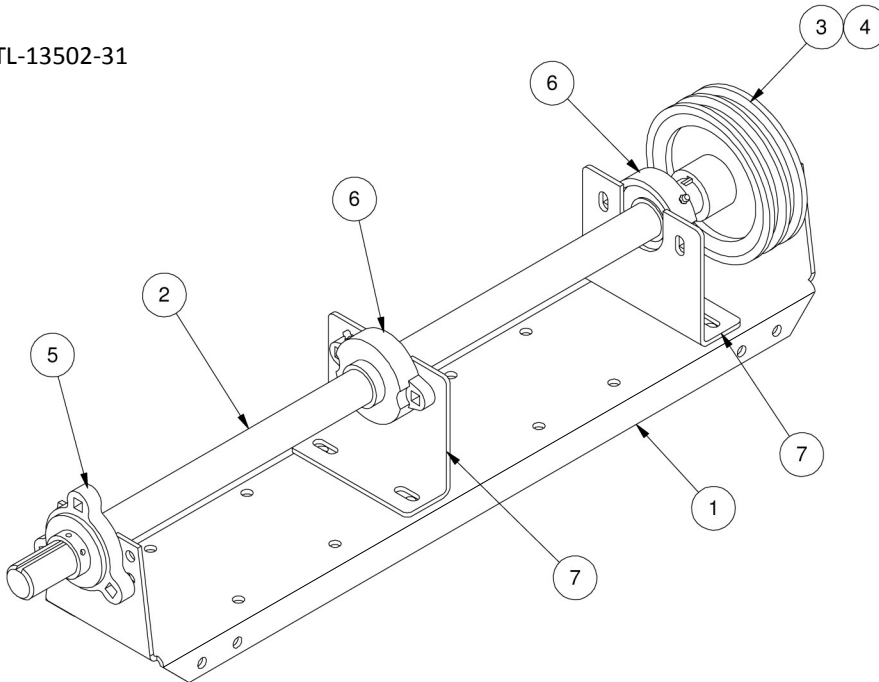
ATL-13502-15



DET.	PART NO.	DESCRIPTION
1	ATL-13430-BF	V-BELT END BEARING SUPPORT (BF DEPENDANT)
2	ATL-13493-BF	V-BELT, 1.9 DRIVE SHAFT, DRIVE END, 1-1/4 DIA, 1/4 KEYED BOTH ENDS (BF DEPENDANT)
3	ATL-13495	SHEAVE: V-BELT, 5.75" OD, 1 1/4" BORE, (2) GROOVES
4	ATL-14366	KEYSTOCK: 1/4" SQ., 1 1/2" LONG
5	ATL-14679	BEARING: 3-BOLT FLANGE, 1 1/4" BORE
6	ATL-14097	BEARING: 2-BOLT FLANGE, 1 1/4" BORE
7	ATL-13478	V-BELT, END BEARING MOUNT FOR 2-BOLT FLANGE BEARING

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

ATL-13502-31



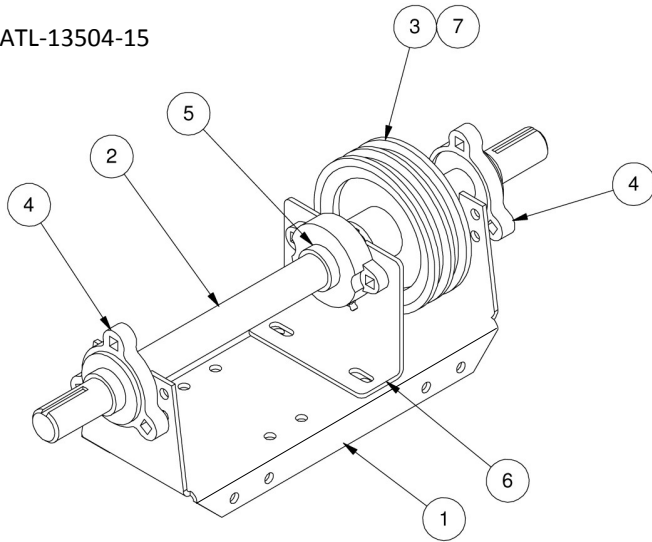
DET.	PART NO.	DESCRIPTION
1	ATL-13430-BF	V-BELT END BEARING SUPPORT (BF DEPENDANT)
2	ATL-13493-BF	V-BELT, 1.9 DRIVE SHAFT, DRIVE END, 1-1/4 DIA, 1/4 KEYED BOTH ENDS (BF DEPENDANT)
3	ATL-13495	SHEAVE: V-BELT, 5.75" OD, 1 1/4" BORE, (2) GROOVES
4	ATL-14366	KEYSTOCK: 1/4" SQ., 1 1/2" LONG
5	ATL-14679	BEARING: 3-BOLT FLANGE, 1 1/4" BORE
6	ATL-14097	BEARING: 2-BOLT FLANGE, 1 1/4" BORE
7	ATL-13478	V-BELT, END BEARING MOUNT FOR 2-BOLT FLANGE BEARING

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

SUB-ASSEMBLIES AND PARTS LIST

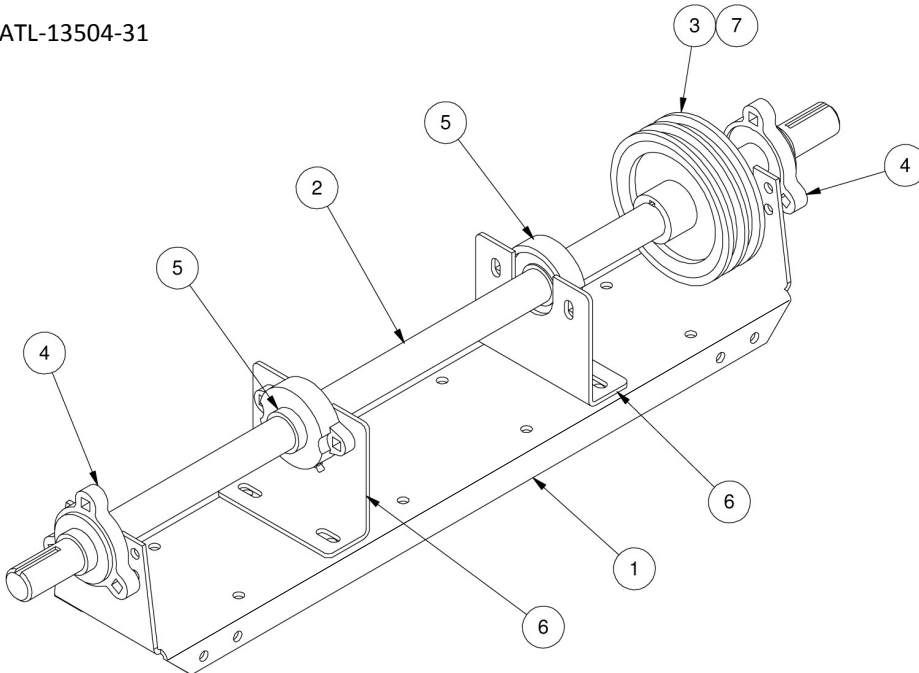
ATL-13504-15



DET.	PART NO.	DESCRIPTION
1	ATL-13430-BF	V-BELT END BEARING SUPPORT (BF DEPENDANT)
2	ATL-13494-BF	V-BELT, 1.9 DRIVE SHAFT, DRIVE AND SLAVE ENDS, 1 1/4" DIA., 1/4" KEYED BOTH ENDS AND CENTER (BF DEPENDANT)
3	ATL-13495	SHEAVE: V-BELT, 5.75" OD, 1 1/4" BORE, (2) GROOVES
4	ATL-14679	BEARING: 3-BOLT FLANGE, 1 1/4" BORE
5	ATL-14097	BEARING: 2-BOLT FLANGE, 1 1/4" BORE
6	ATL-13478	V-BELT, END BEARING MOUNT FOR 2-BOLT FLANGE BEARING
7	ATL-14366	KEYSTOCK: 1/4" SQ., 1 1/4" LONG

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

ATL-13504-31



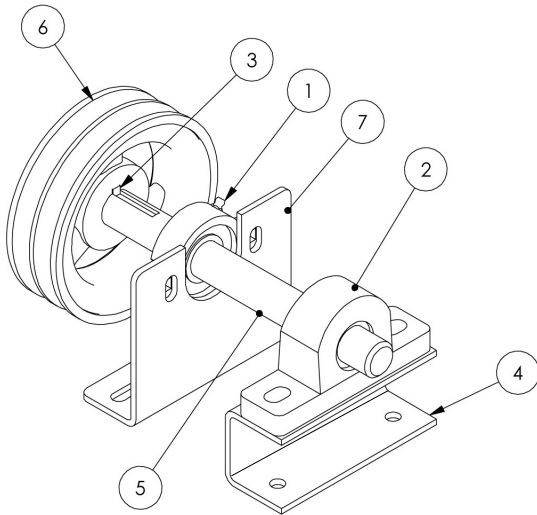
DET.	PART NO.	DESCRIPTION
1	ATL-13430-BF	V-BELT END BEARING SUPPORT (BF DEPENDANT)
2	ATL-13494-BF	V-BELT, 1.9 DRIVE SHAFT, DRIVE AND SLAVE ENDS, 1 1/4" DIA., 1/4" KEYED BOTH ENDS AND CENTER (BF DEPENDANT)
3	ATL-13495	SHEAVE: V-BELT, 5.75" OD, 1 1/4" BORE, (2) GROOVES
4	ATL-14679	BEARING: 3-BOLT FLANGE, 1 1/4" BORE
5	ATL-14097	BEARING: 2-BOLT FLANGE, 1 1/4" BORE
6	ATL-13478	V-BELT, END BEARING MOUNT FOR 2-BOLT FLANGE BEARING MOUNT
7	ATL-14366	KEYSTOCK: 1/4" SQ., 1 1/4" LONG

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

V-BELT DRIVEN LIVE ROLLER CONVEYOR INSTALLATION AND MAINTENANCE MANUAL

SUB-ASSEMBLIES AND PARTS LIST

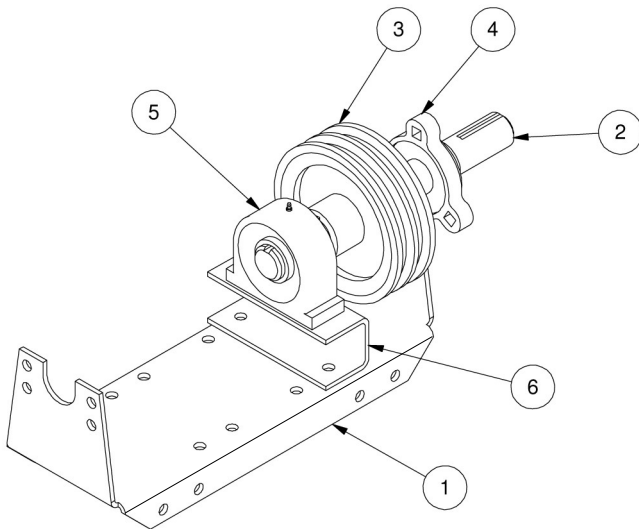
ATL-13500-A



DET.	PART NO.	DESCRIPTION
1	ATL-12937	BEARING: 2-BOLT FLANGE, 1" BORE
2	ATL-14680	BEARING: PILLOW BLOCK, 1" BORE
3	ATL-14366	KEYSTOCK: 1/4" SQ., 1 1/2" LG
4	ATL-13477-UCP	V-BELT, END BEARING ELEVATING BRACKET FOR PILLOW BLOCK BEARING
5	ATL-13492-1	V-BELT, 1.9 DRIVE SHAFT, IDLER END, 1" DIA, 1/4" KEYED ONE END
6	ATL-13497	SHEAVE: 5 3/4" OD, DOUBLE GROOVE, 1" BORE
7	ATL-13501	V-BELT, END BEARING 2-BOLT FLANGE BEARING MOUNT, 1" SHAFT

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

ATL-13515

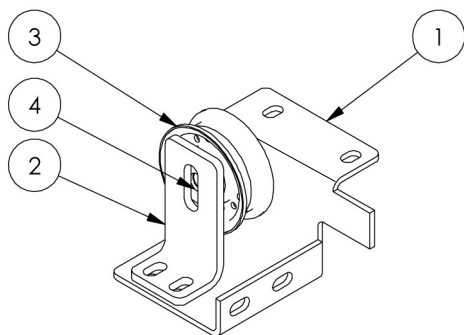


DET.	PART NO.	DESCRIPTION
1	ATL-13430-BF	V-BELT END BEARING SUPPORT (BF DEPENDANT)
2	ATL-13507-8	V-BELT, 1.9 DRIVE SHAFT, DRIVE AND SLAVE ENDS, 1-1/4 DIA, 1/4 KEYED BOTH ENDS AND INTERIOR
3	ATL-13495	SHEAVE: V-BELT, 5.75" OD, 1 1/4" BORE, (2) GROOVES
4	ATL-14679	BEARING: 3-BOLT FLANGE, 1 1/4" BORE
5	ATL-14099	BEARING: PILLOW BLOCK, 1 1/4" BORE
6	ATL-13477-UCPAS	V-BELT, END BEARING ELEVATING BRACKET FOR PILLOW BLOCK BEARING

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

SUB-ASSEMBLIES AND PARTS LIST

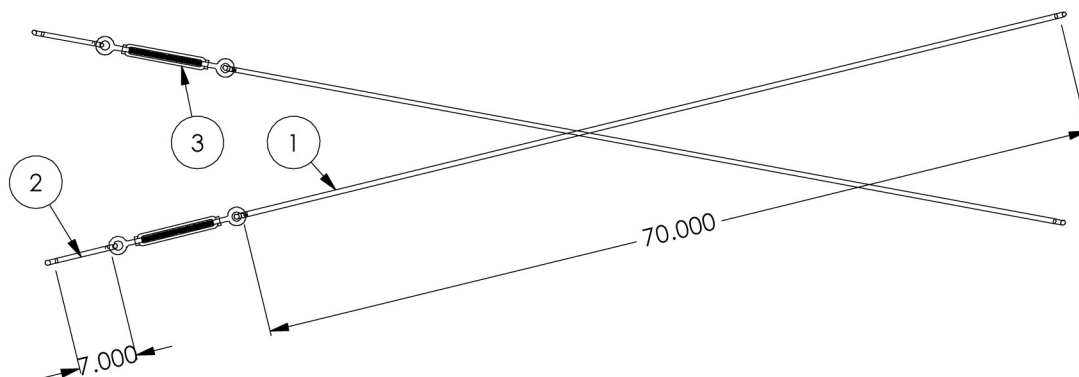
ATL-13536-R/L



DET.	PART NO.	DESCRIPTION
1	ATL-13532-R/L	RETURN SHEAVE BRACKET/GUARD
2	ATL-13535	RETURN FLAT IDLER SUPPORT
3	ATL-13483-S	SHEAVE: 3" FLAT IDLER, SHOULDER ADAPTER SHORT
4	ATL-12903.500	FLAT WASHER: 1/2"

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

ATL-14106



DET.	PART NO.	DESCRIPTION
1	ATL-13173	CROSS BRACE ROD - 70" L.
2	ATL-13174	CROSS BRACE ROD - 6" L.
3	ATL-13175	EYE AND EYE TURNBUCKLE

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