

# ***INSTALLATION AND MAINTENANCE MANUAL***

## ***BELT CONVEYOR MODEL BS300B***



**DO NOT OPERATE  
EQUIPMENT  
BEFORE READING**

**ATLANTIS**  
TECHNOLOGIES LLC

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## **INTRODUCTION**

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This manual has been created to assist with the maintenance, operation and installation of the BS300B Belt 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**

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### **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**

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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 handle safely.

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

## **SAFETY INFORMATION - OPERATION (Continued)**

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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**

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**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**

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### **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.

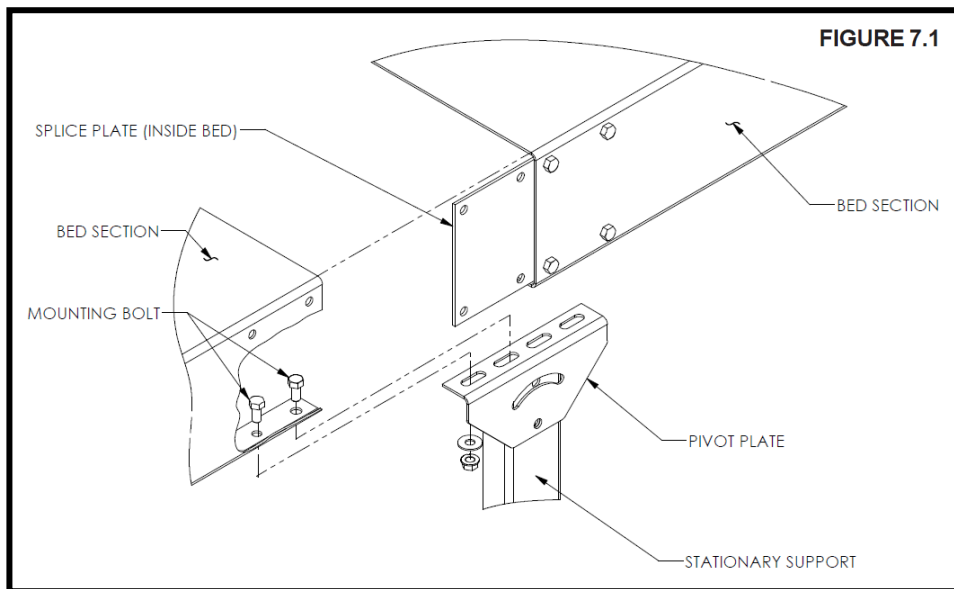
Before restarting a conveyor that has been stopped because of an emergency, an inspection of the conveyor should be made and the cause of the stoppage determined. The starting device and electrical power must be turned off and locked / tagged out according to your company's machine specific procedure 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

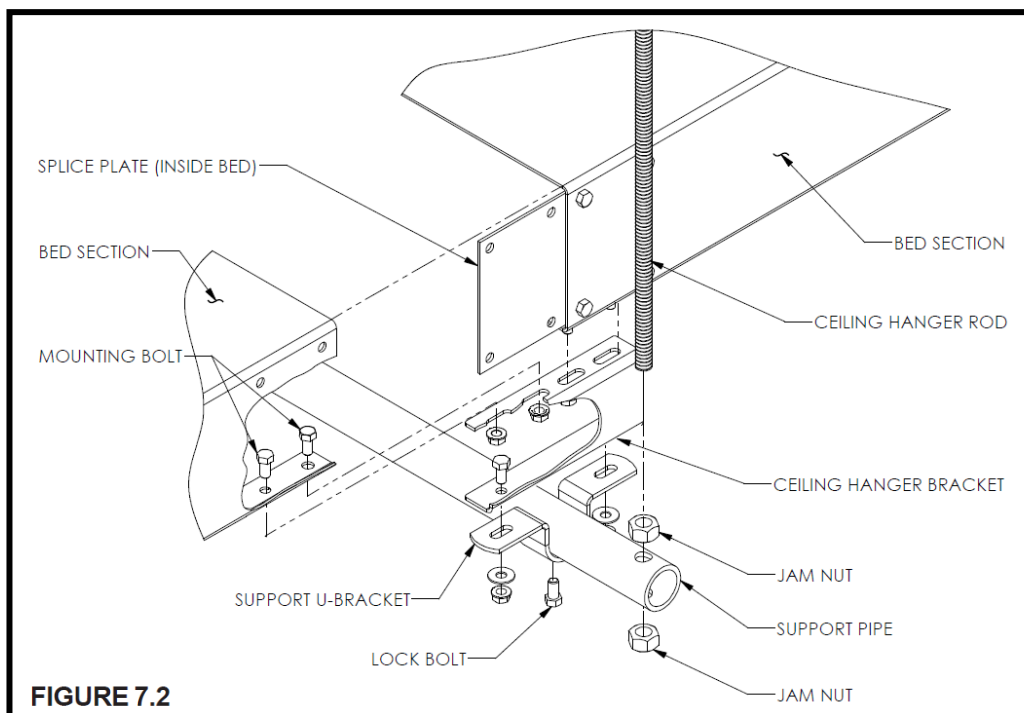
Floor supports are typically mounted at Drive, Tail and across splice locations. Fasten leg supports to conveyor sections with the provided fasteners as shown (Figure 7.1).



## 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.

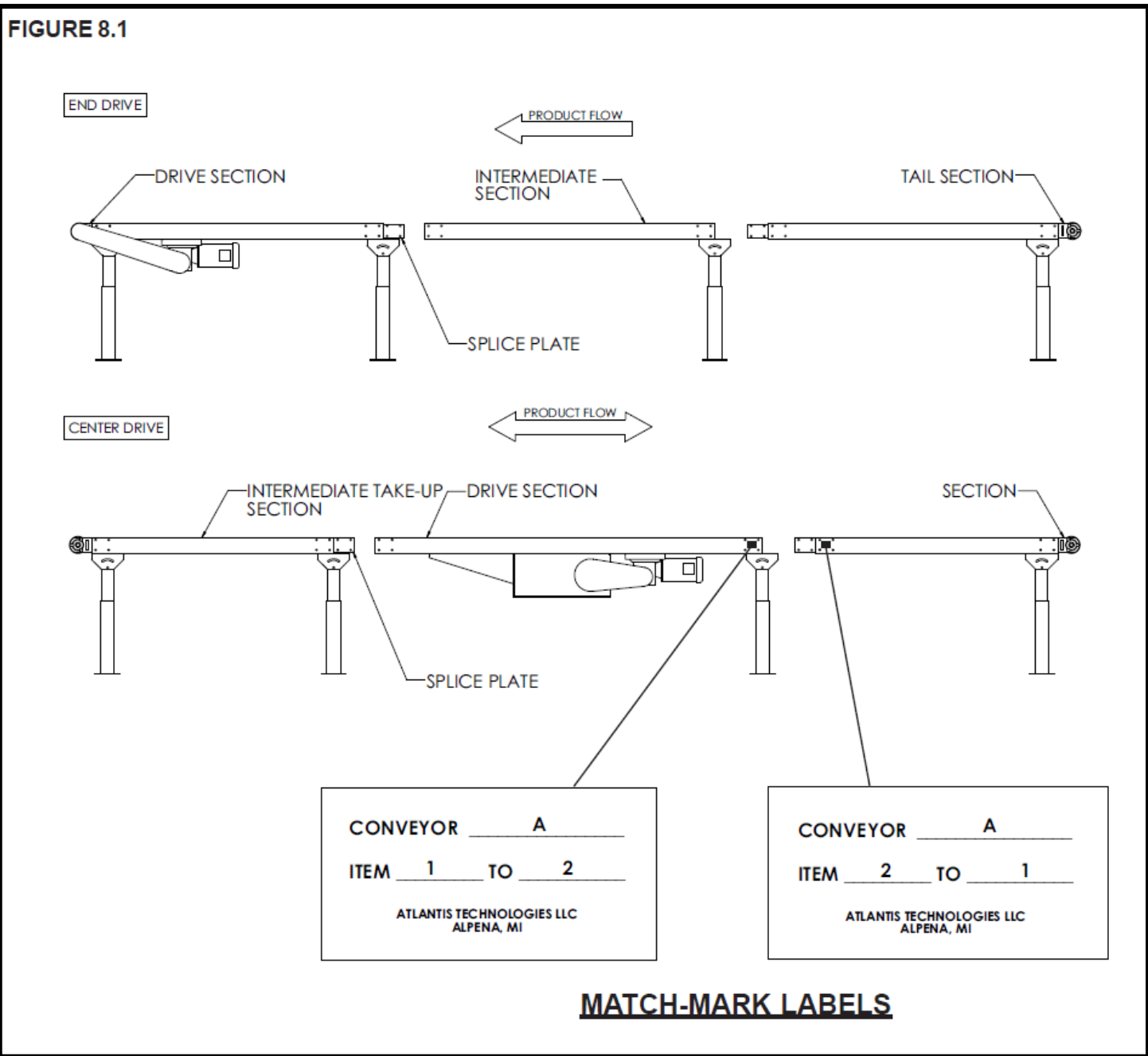
**NOTE:** When installing ceiling hangers, refer to local building codes to ensure that materials comply. Only experienced material handling installers should attempt to install conveyors.



# 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) Install the belt and track belt per instructions on page 10-12.



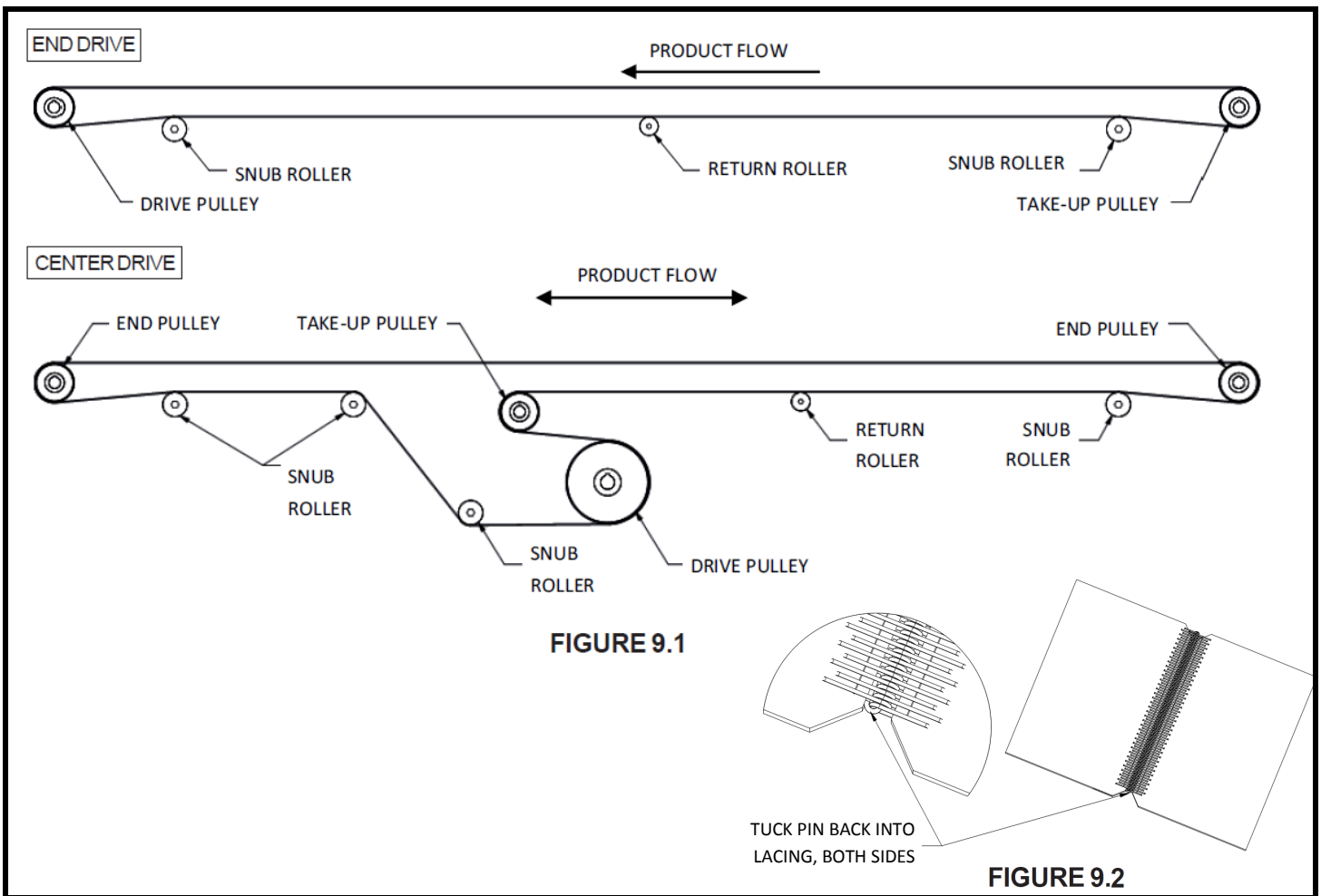


## INSTALLATION

### 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 as shown in Figure 9.2.
- 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: Over tightening 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.



### 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

### 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"

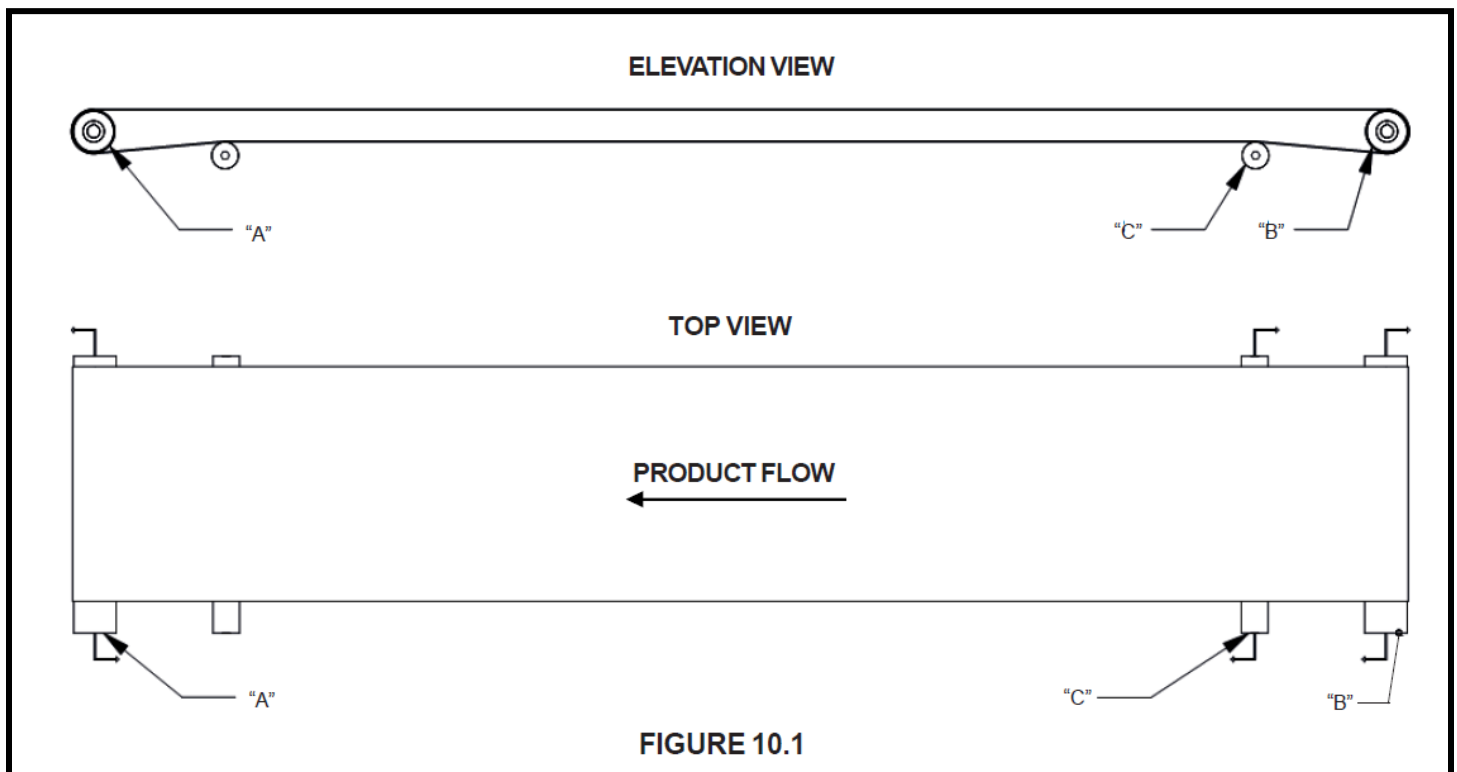


FIGURE 10.1

## 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 11.1.
- 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 may 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 11.1
- 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.

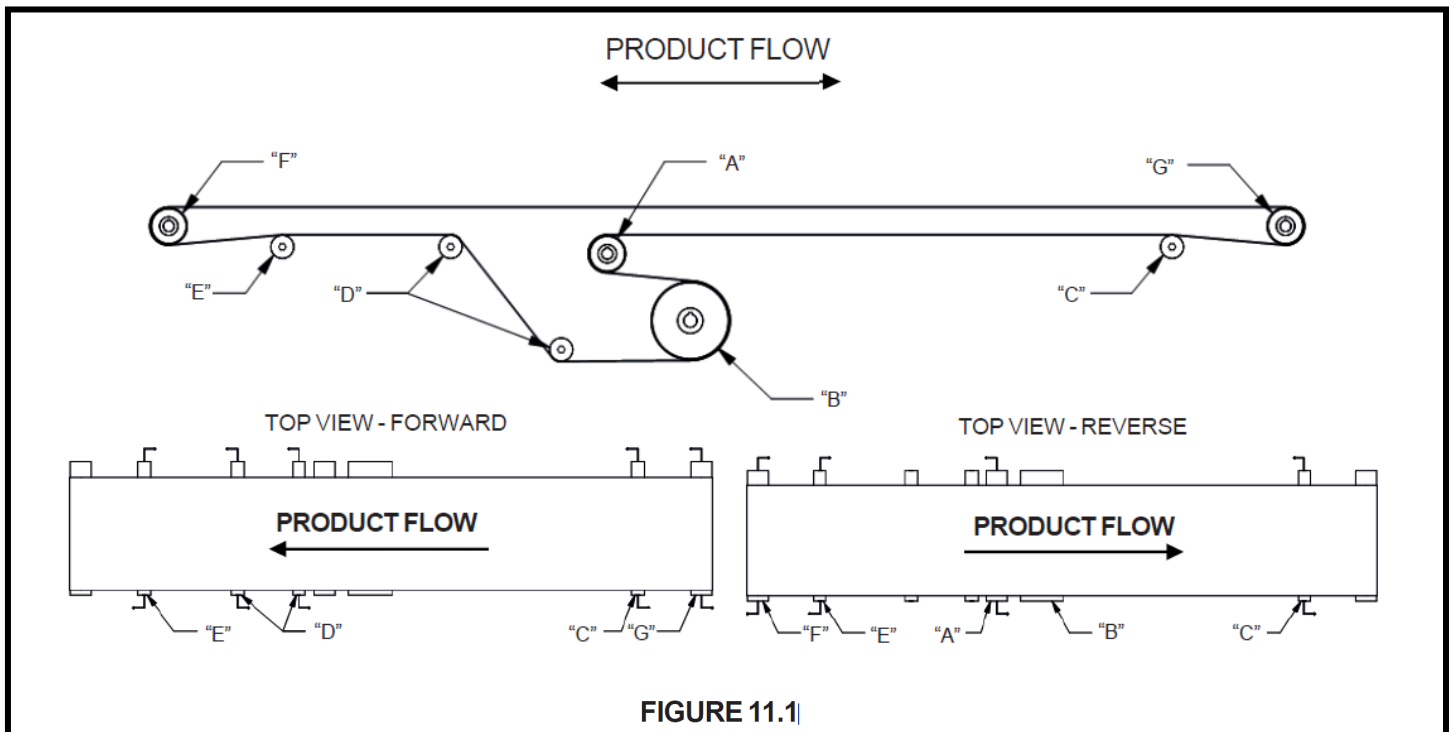
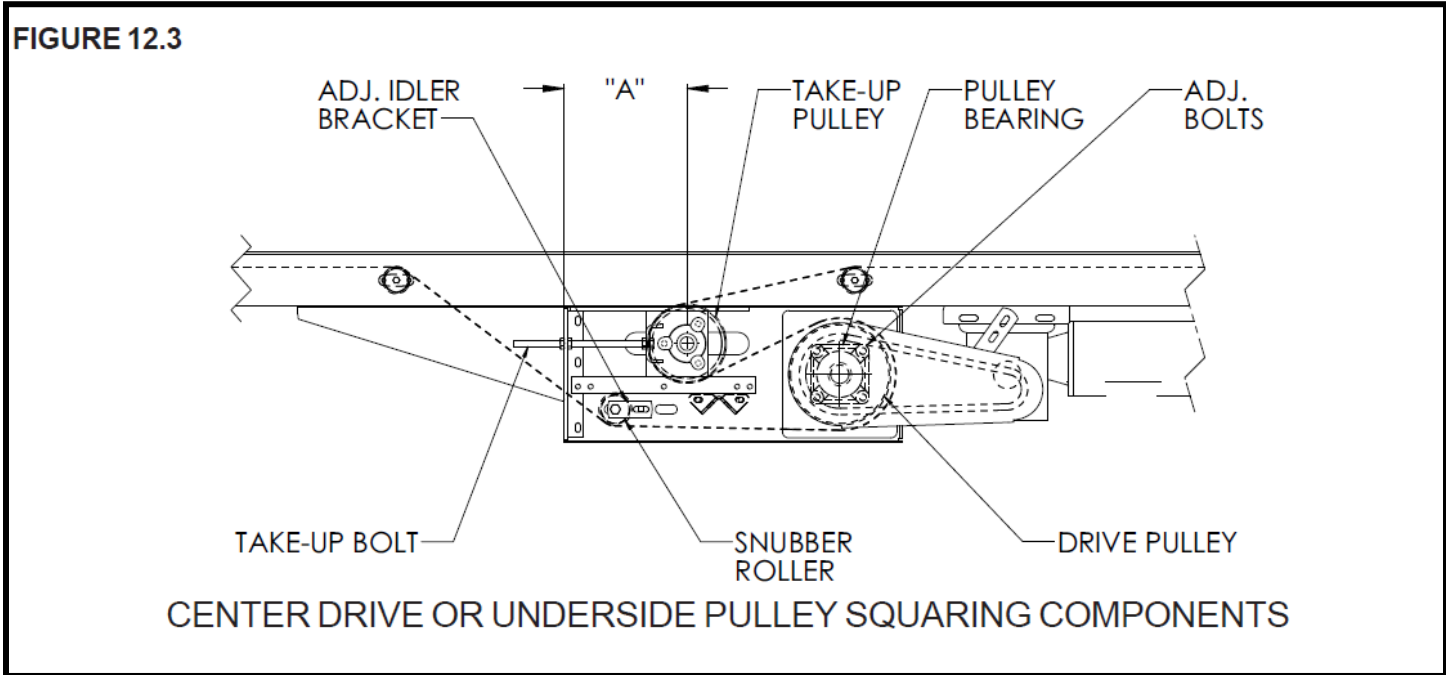
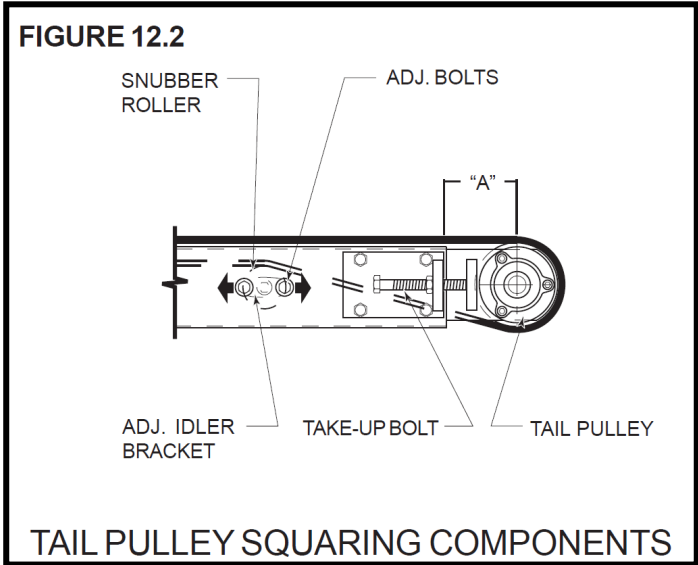
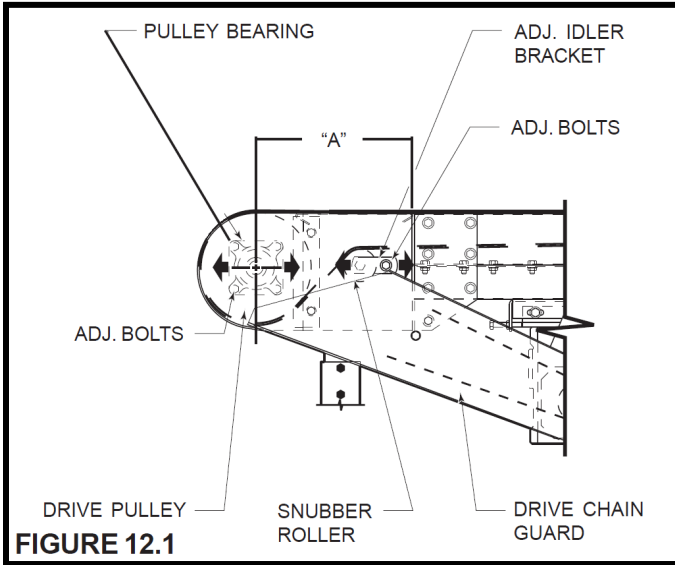


FIGURE 11.1

# BELT TRACKING



# 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.

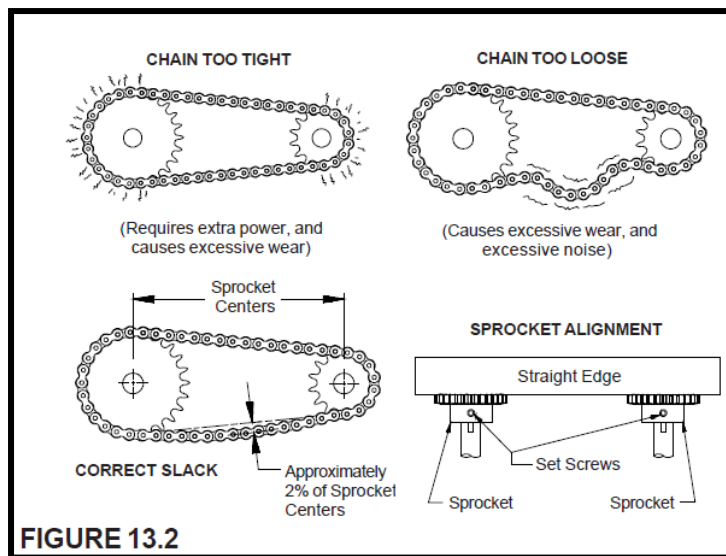
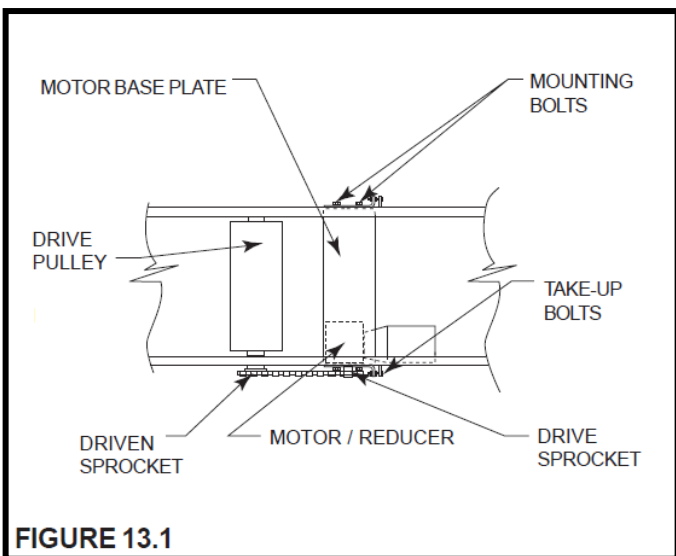
Chain No.	Temperature		
	15 - 35 Deg (F)	35 - 105 Deg (F)	105 - 120 Deg (F)
ANSI 25 - 50	SAE10W	SAE20	SAE30
ANSI 60 - 100	SAE20	SAE30	SAE40

## 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 13.2)

Drive Chain Tension Adjustment Procedure (See Figure 13.1 and Figure 13.2)

- 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.



## **MAINTENANCE SCHEDULE**

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### **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.

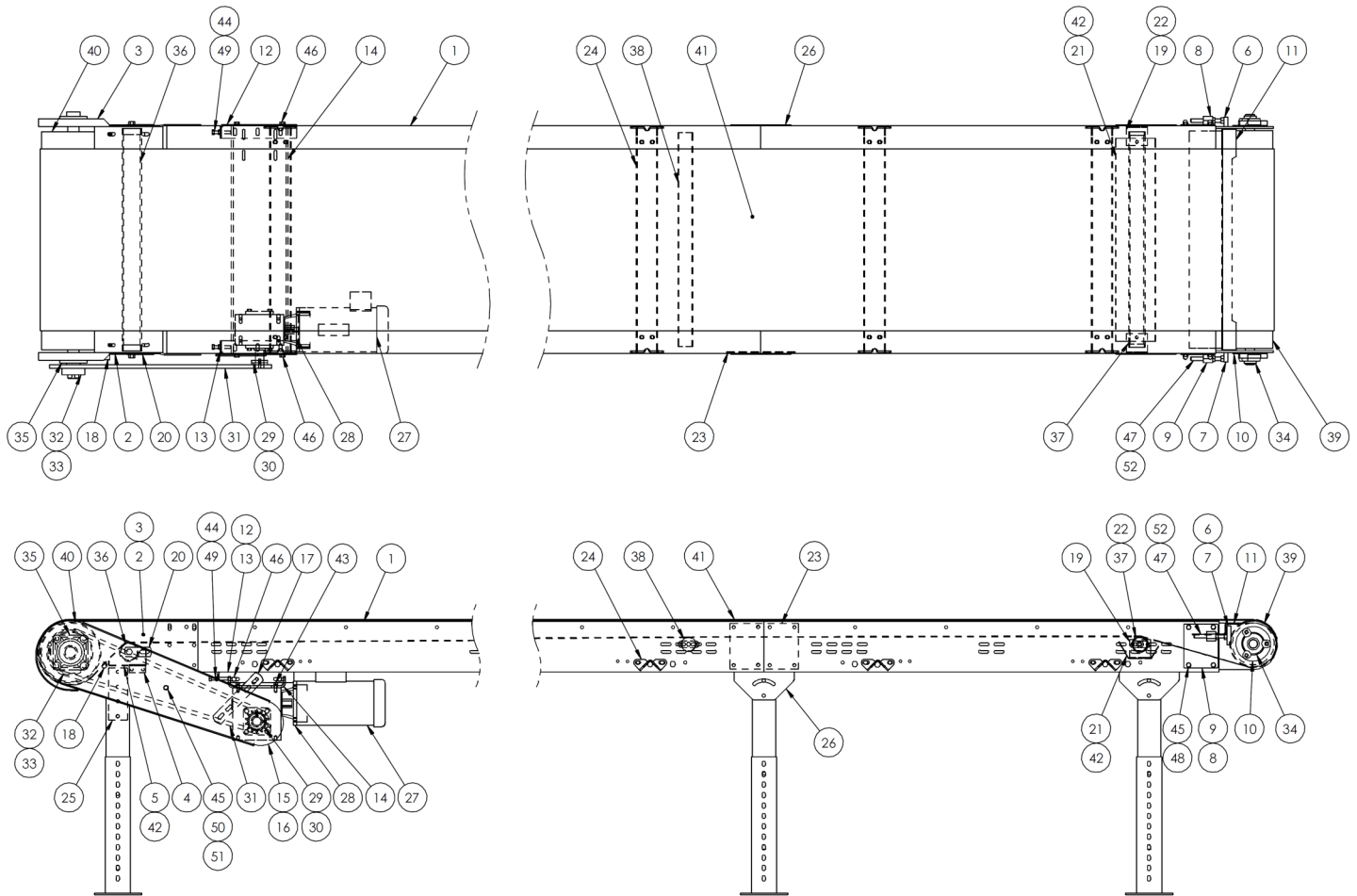
### **ANNUAL MAINTENANCE**

- Change oil in reducers.

## TROUBLE SHOOTING

TROUBLE	CAUSE	SOLUTION
Conveyor motor will not start or motor quits frequently	<ol style="list-style-type: none"> <li>1. Motor is overloaded</li> <li>2. Motor is drawing excessive current</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect conveyor for overloading and remove excessive load.</li> </ol>
Excessive wear on drive sprockets and drive chain	<ol style="list-style-type: none"> <li>1. Inadequate amount of lubrication on drive chain.</li> <li>2. Misalignment of sprockets.</li> <li>3. Loose Chain</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace chain and sprockets. Apply adequate amount of lubrication to chain.</li> <li>2. Align Sprockets</li> <li>3. Tighten Chain</li> </ol>
Loud popping or grinding noise.	<ol style="list-style-type: none"> <li>1. Defective bearing.</li> <li>2. Loose set screws in sprockets or bearing.</li> <li>3. Improper drive chain tension.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace defective bearing.</li> <li>2. Tighten loose set screws.</li> <li>3. Properly tension drive chain.</li> </ol>
Motor or Reducer is overheating	<ol style="list-style-type: none"> <li>1. Overloaded conveyor.</li> <li>2. Voltage to conveyor is too low.</li> <li>3. Insufficient amount of lubricant in reducer.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check to ensure that the conveyor belt is not over capacity and reduce load.</li> <li>2. Have a qualified electrician test the voltage and correct if necessary.</li> <li>3. Add lubricant to reducers manufacturer recommended level.</li> </ol>
Belt does not move, but drive is running.	<ol style="list-style-type: none"> <li>1) Overloaded conveyor.</li> <li>2) Belt is too loose.</li> <li>3) Lagging on drive pulley is worn.</li> </ol>	<ol style="list-style-type: none"> <li>1) Check to ensure that the conveyor belt is not over capacity and reduce load.</li> <li>2) Tighten belt using belt take-ups.</li> <li>3) Replace drive pulley lagging and tighten belt.</li> </ol>
Belt tracks off at one point along conveyor length	<ol style="list-style-type: none"> <li>1) One or more idlers near trouble point are out of line.</li> <li>2) Conveyor sections might be out of square or level.</li> <li>3) Residue/debris build up on pulleys or idlers.</li> </ol>	<ol style="list-style-type: none"> <li>1) Adjust the idlers near the trouble point.</li> <li>2) Make necessary adjustments to square the conveyor sections.</li> <li>3) Remove residue/debris from pulleys and idlers.</li> </ol>
Belt tracks to one side at drive or tail pulleys	<ol style="list-style-type: none"> <li>1) Drive pulley, tail pulley or idlers located near the pulley are not aligned properly or square with the conveyor bed.</li> </ol>	<ol style="list-style-type: none"> <li>1) Adjust pulleys and idlers as necessary.</li> </ol>
Belt tracks to one side.	<ol style="list-style-type: none"> <li>1) Conveyor not level or straight.</li> <li>2) Residue/debris build up on pulleys or idlers.</li> </ol>	<ol style="list-style-type: none"> <li>1) Ensure that belt sections are aligned and leveled properly.</li> <li>2) Remove residue/debris from pulleys and idlers.</li> </ol>

**BELT CONVEYOR INSTALLATION AND MAINTENANCE MANUAL**  
**DRAWING AND PARTS LIST (8" END DRIVE)**

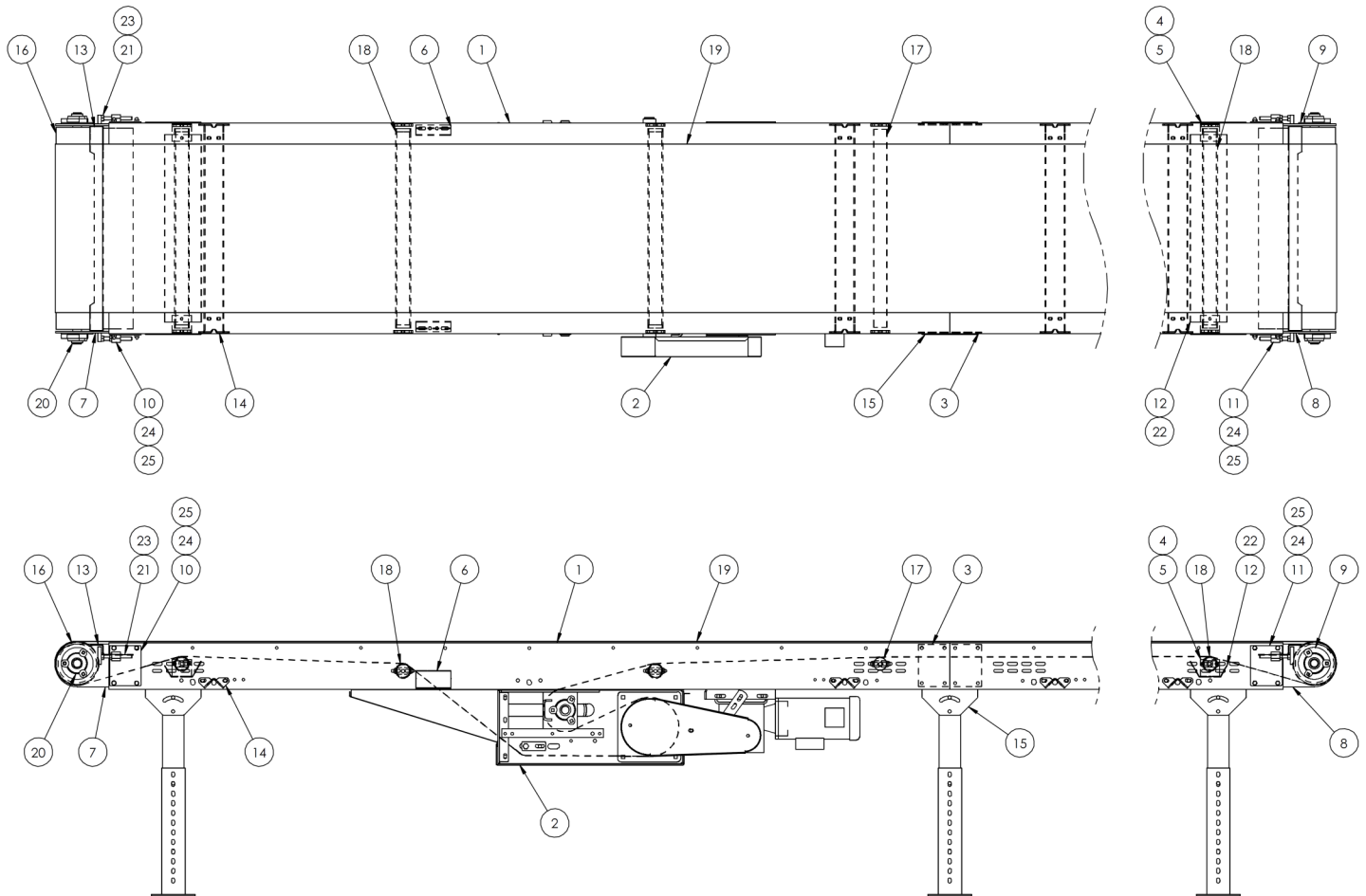


DET.	PART NUMBER	DESCRIPTION	DET.	PART NUMBER	DESCRIPTION
1	SPECIFIC TO ORDER	BED SECTION	27	SPECIFIC TO ORDER	MOTOR
2	ATL-11073-BW	DRIVE SHELL WELDMENT - L.H. DRIVE	28	SPECIFIC TO ORDER	REDUCER
3	ATL-11077-LH	REMOVABLE DRIVE PLATE WELDMENT - L.H. DRIVE	29	SPECIFIC TO ORDER	DRIVE SPROCKET (REDUCER)
4	ATL-11083	SNUB ROLLER GUARD MOUNTING BRACKET	30	SPECIFIC TO ORDER	SHAFT KEY: 1/4" SQ. X 1 1/4" L. (REDUCER)
5	ATL-11082-BW	SNUB ROLLER GUARD - DRIVE END	31	SPECIFIC TO ORDER	DRIVE CHAIN - RC60 WITH CONNECTING LINK
6	ATL-11098-RH	TAKE-UP PLATE WELDMENT - R.H.	32	SPECIFIC TO ORDER	DRIVEN SPROCKET (DRIVE PULLEY)
7	ATL-11098-LH	TAKE-UP PLATE WELDMENT - L.H.	33	ATL-10744	SHAFT KEY: 3/8" SQ. X 1" L. (PULLEY)
8	ATL-11101-RH	ATTACHMENT PLATE WELDMENT - R.H.	34	ATL-10003	BEARING: 3-BOLT FLANGE - 1 3/16" BORE
9	ATL-11101-LH	ATTACHMENT PLATE WELDMENT - L.H.	35	ATL-10004	BEARING: 4-BOLT FLANGE - 1 7/16" BORE
10	ATL-11099	BEARING SPACER (1 3/16" SHAFT)	36	ATL-13028-BF	SNUBBER ROLLER: 2 9/16" DIA.
11	ATL-11094-BW	NIP POINT GUARD - TAIL END	37	ATL-10727-BF	SNUBBER ROLLER: 2 1/8" DIA.
12	ATL-12850-RH	MOTOR BASE SUPPORT ANGLE - R.H.	38	ATL-10728-BF	RETURN ROLLER: 1.9" DIA.
13	ATL-12850-LH	MOTOR BASE SUPPORT ANGLE - L.H.	39	ATL-10756-FL	6" DIA. TAIL PULLEY
14	SPECIFIC TO ORDER	MOTOR BASE WELDMENT	40	ATL-10758-FL	8" DIA. DRIVE PULLEY WITH LAGGING
15	ATL-11090	CHAIN GUARD FRONT WELDMENT	41	SPECIFIC TO ORDER	BELT WITH LACING
16	ATL-11091	CHAIN GUARD BACK PLATE	42	ATL-10747	U-TYPE SPEED NUT: 1/4-20
17	ATL-10780	CHAIN GUARD MOUNTING BAR	43	SPECIFIC TO ORDER	REDUCER BOLT (GRADE 8)
18	ATL-11280	SPACER - CHAIN GUARD	44	ATL-10742	HEX JAM NUT: HEAVY, 3/8-16
19	ATL-10011	SNUB ROLLER GUARD MOUNTING BRACKET	45	ATL-10748	ACORN NUT: 3/8-16
20	ATL-10019	SNUB ROLLER BRACKET - 11/16" HEX	46	ATL-10749	HEX HEAD BOLT: 3/8-16 x 1" L. (GRADE 8)
21	ATL-11096-OAW	SNUB ROLLER GUARD - TAIL END	47	ATL-10750	TAKE-UP BOLT: 1/2-13 x 4" L. (FULL THREAD)
22	ATL-10024	RETURN ROLLER BRACKET	48	ATL-10751	SHOULDER BOLT: 1/2" DIA. X .312" L. - 3/8-16
23	ATL-11064	SPLICE PLATE	49	ATL-10787	TAKE-UP BOLT: 3/8-16 x 2 1/4" L.
24	ATL-10018-BW	BED SPACER	50	ATL-10788	HEAD HEX BOLT: 3/8-16 x 3 1/4" L.
25	ATL-11268	ATTACHMENT BAR - DRIVE SUPPORT	51	ATL-10790	HEX JAM NUT: 3/8-16
26	SPECIFIC TO ORDER	SMS FLOOR SUPPORT	52	ATL-10791	HEX JAM NUT: 1/2-13

HIGHLIGHTED ITEMS ARE REPLACEMENT PARTS



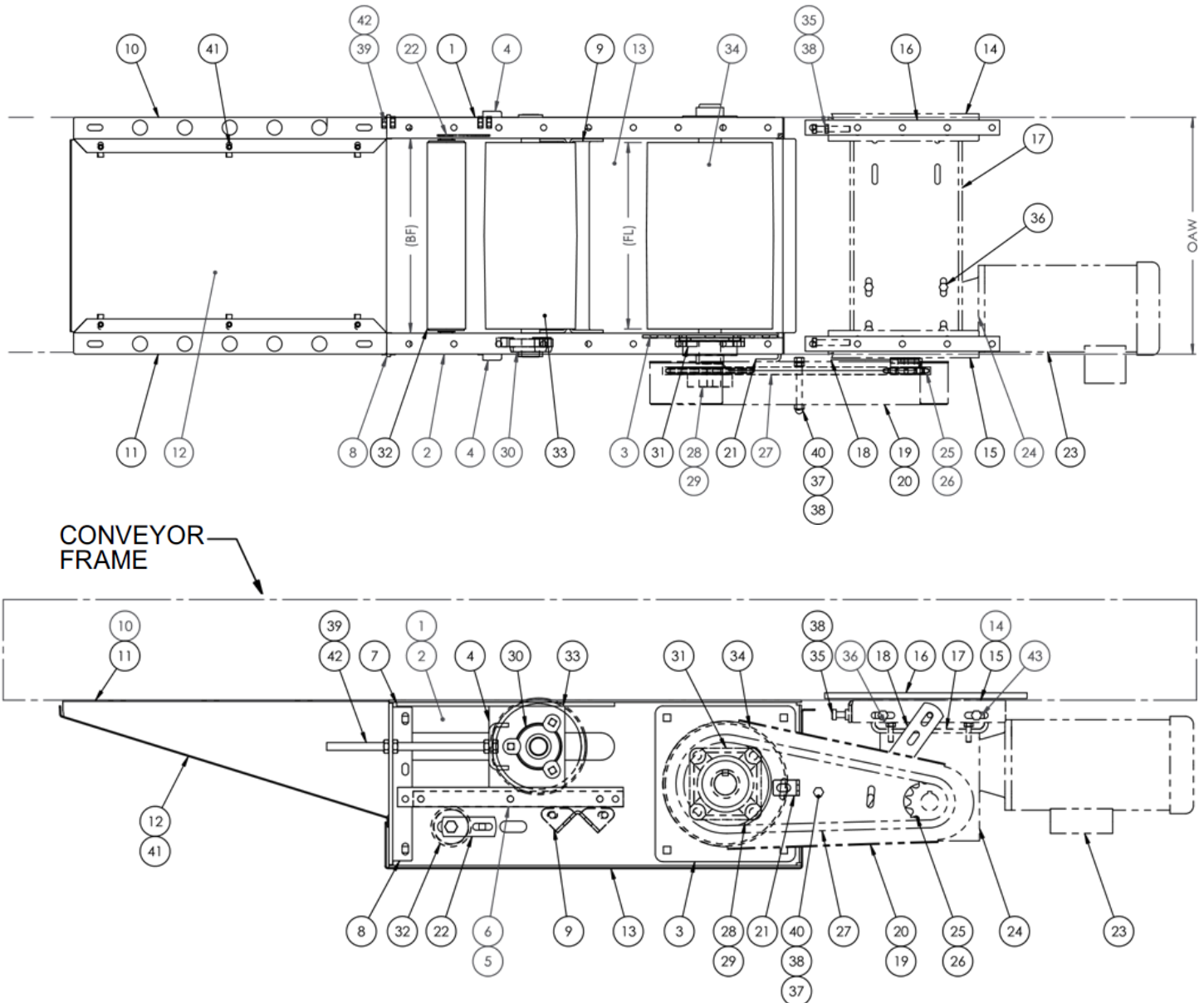
**BELT CONVEYOR INSTALLATION AND MAINTENANCE MANUAL**  
**DRAWING AND PARTS LIST (8" CENTER DRIVE)**



DET.	PART NO.	DESCRIPTION
1	SPECIFIC TO ORDER	BED SECTION
2	SPECIFIC TO ORDER	CENTER DRIVE SUB ASSEMBLY
3	ATL-11064	SPLICE PLATE
4	ATL-10024	RETURN ROLLER BRACKET
5	ATL-10011	SNUB ROLLER GUARD MOUNTING BRACKET
6	ATL-10022	BELT PROTECTOR
7	ATL-11098-RH	TAKE-UP PLATE WELDMENT - R.H.
8	ATL-11098-LH	TAKE-UP PLATE WELDMENT - L.H.
9	ATL-11099	BEARING SPACER (1 3/16" SHAFT)
10	ATL-11101-RH	ATTACHMENT PLATE WELDMENT - R.H.
11	ATL-11101-LH	ATTACHMENT PLATE WELDMENT - L.H.
12	ATL-11096-OAW	SNUB ROLLER GUARD
13	ATL-11094-BW	NIP POINT GUARD - TAIL END
14	ATL-10018-BW	BED SPACER
15	SPECIFIC TO ORDER	SMS LEG ASSEMBLY
16	ATL-10756-FL	6" DIA. TAIL PULLEY
17	ATL-10728-BF	RETURN ROLLER: 1.9" DIA.
18	ATL-10727-BF	SNUBBER ROLLER: 2-1/8" DIA.
19	SPECIFIC TO ORDER	BELT WITH LACING
20	ATL-10003	BEARING: 3-BOLT FLANGE - 1 3/16" BORE
21	ATL-10750	HEX HEAD BOLT: 1/2-13 x 4" 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
25	ATL-10751	SHOULDER BOLT - 1/2" DIA. X .312 L.

HIGHLIGHTED ITEMS ARE REPLACEMENT PARTS

# DRAWING AND PARTS LIST (8" CENTER DRIVE ASSEMBLY)



DET.	PART NO.	DESCRIPTION	DET.	PART NO.	DESCRIPTION
1	ATL-10708-RH	DRIVE PLATE WELDMENT - RIGHT HAND	23	SPECIFIC TO ORDER	MOTOR
2	ATL-10708-LH	DRIVE PLATE WELDMENT - LEFT HAND	24	SPECIFIC TO ORDER	REDUCER
3	ATL-10713	BEARING PLATE - CENTER DRIVE	25	SPECIFIC TO ORDER	DRIVE SPROCKET (REDUCER)
4	ATL-10714	TAKE-UP PLATE WELDMENT	26	ATL-10743	PULLEY SHAFT KEY 1/4" SQ X 1 1/4" L.
5	ATL-10717	BEARING GUIDE SPACER	27	SPECIFIC TO ORDER	DRIVE CHAIN: RC50 WITH CONNECTING LINK
6	ATL-10718	BEARING GUIDE	28	ATL-11252	DRIVE SPROCKET (DRIVE PULLEY)
7	ATL-10719	UPPER BEARING GUIDE	29	ATL-10744	SHAFT KEY: 3/8" SQ. X 1" L.
8	ATL-10720	TAKE UP ANGLE - CENTER DRIVE	30	ATL-10003	BEARING: 3-BOLT FLANGE, 1 3/16" BORE
9	ATL-11695-BF	BED SPREADER	31	ATL-10004	BEARING: 3-BOLT FLANGE, 1 7/16" BORE
10	ATL-10724-RH	SIDE GUARD - RIGHT HAND	32	ATL-13028-BF	SNUBBER ROLLER: 2 9/16" OD
11	ATL-10724-LH	SIDE GUARD - LEFT HAND	33	ATL-10756-FL	6" DIA. TAKE-UP PULLEY
12	ATL-10021-OAW	BOTTOM ANGLE GUARD - CENTER DRIVE	34	ATL-10758-FL	8" DIA. DRIVE PULLEY (LAGGED - 8 1/2" DIA. FINISHED)
13	ATL-10020-OAW	BOTTOM GUARD - CENTER DRIVE	35	ATL-10787	TAKE-UP BOLT: 3/8-16 x 2 1/4" L. (FULL THREAD)
14	ATL-12850-RH	MOTOR BASE SUPPORT ANGLE - RIGHT HAND	36	ATL-10789	HEX HEAD BOLT: 5/16-18 x 1" L. (GRADE 8)
15	ATL-12850-LH	MOTOR BASE SUPPORT ANGLE - LEFT HAND	37	ATL-10788	HEX HEAD BOLT: 3/8-16 x 3 1/4" L. (FULL THREAD)
16	ATL-10781	REDUCER BASE REINFORCEMENT BAR	38	ATL-10790	HEX JAM NUT: 3/8-16
17	ATL-10710-OAW	MOTOR BASE WELDMENT	39	ATL-10791	HEX JAM NUT: 1/2-13
18	ATL-10780	CHAIN GUARD MOUNTING BAR	40	ATL-10748	ACORN NUT: 3/8-16
19	ATL-12854	CHAIN GUARD FRONT WELDMENT	41	ATL-10747	U-TYPE SPEED NUT: 1/4-20
20	ATL-12855	CHAIN GUARD BACK PLATE	42	ATL-11278	THREADED ROD: 1/2-13 x 11" L.
21	ATL-12856	BRACKET - GUARD SUPPORT	43	ATL-10749	HEX HEAD BOLT: 3/8-16 x 1" L. (GRADE 8)
22	ATL-10019	RETURN ROLLER BRACKET - 11/16" HEX			

HIGHLIGHTED ITEMS ARE REPLACEMENT PARTS

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