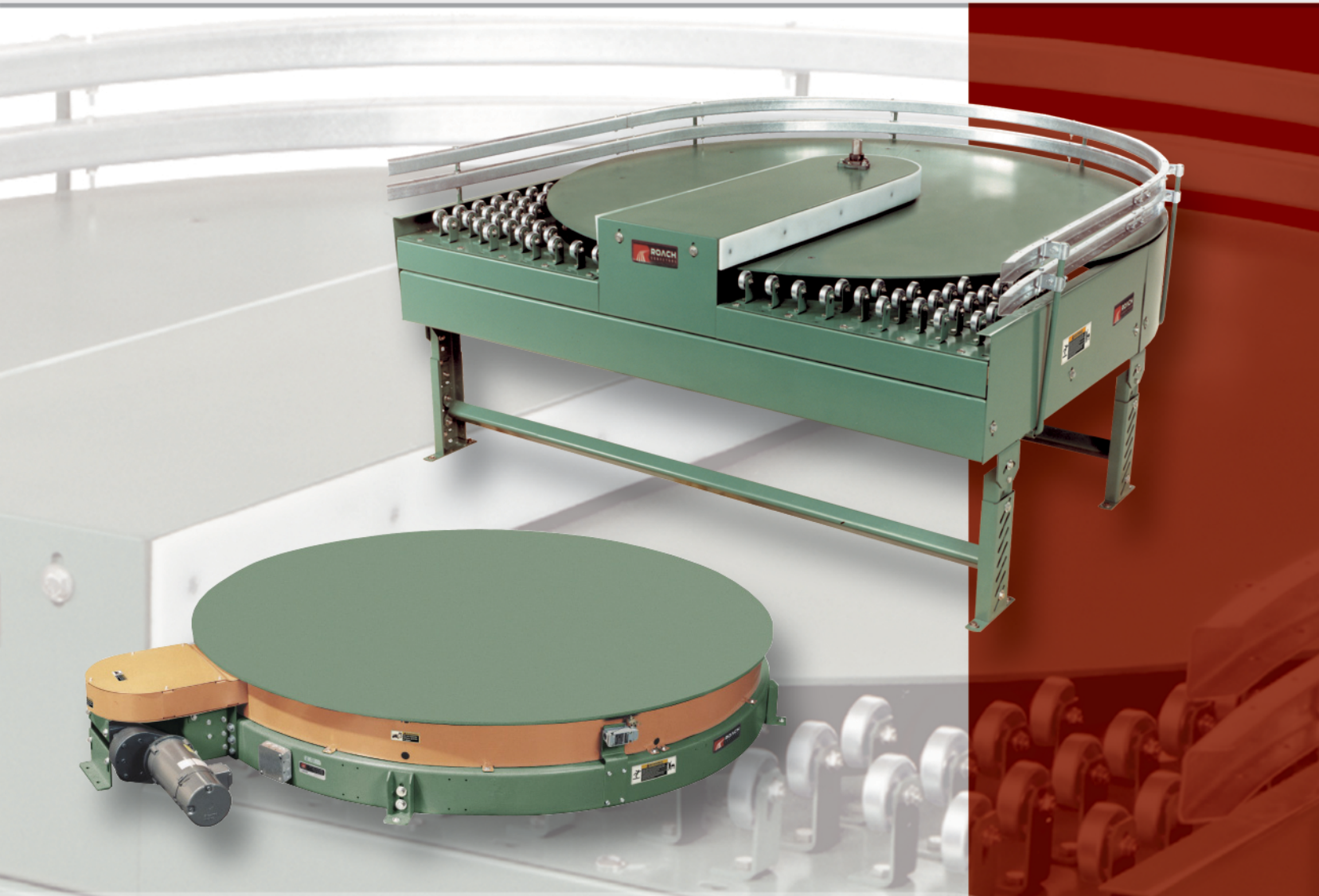




OWNER'S MANUAL



Turntables

Model CRT • IPT

DO NOT OPERATE BEFORE READING THIS HANDBOOK
KEEP IN A SAFE PLACE - DO NOT DISCARD

TECH HANDBOOK FOR CRT & IPT CONVEYORS

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All specifications are subject to change without notice - Drawings are intended for illustration ONLY and are not to scale

WARNING LABELS



ABOVE: Label attached to all protective guards (drives, roller guards, etc.)



ABOVE: Label placed near all pulleys (center drives, end drives, tail pulleys)

⚠ WARNING

1. DO NOT walk, ride, climb or touch moving parts on a conveyor in operation.
2. DO NOT wear loose clothing or uncovered hair around conveyor in operation.
3. DO NOT operate a conveyor with chain or other protective guards removed.
4. DO NOT work near a conveyor without knowing how & where to shut power "OFF".
5. DO NOT remove jammed product with conveyor running.
6. DO NOT replace parts or perform maintenance on conveyor, or moving conveyor parts, without first shutting "OFF" power to conveyor.
7. DO NOT connect gravity to powered conveyor without gravity connector brackets.
8. TO PREVENT electrical shock, conveyor must be grounded and have proper electrical connections in accordance with federal, state and local codes.
9. SAFETY pop-out rollers must be retained when elevation is 7'-0" or above, but free to pop out at lower elevations.

CAUTIONS, WARNINGS AND HAZARDS INTRODUCTION

This manual was prepared as a "how-to-guide" for installers, end-users and maintenance personnel. It is also intended to educate both owner (purchaser) and all individuals working around the unit, of potential hazards.

With proper installation and maintenance, turntables are essential for achieving a variety of functions essential in today's industrial marketplace. By following a simple, periodic maintenance schedule, the life of a typical turntable (or, most any type of machinery--including our automobiles!) will increase when compared to a similar

unit in an application receiving little or no maintenance. You may find that a turntable can become your best workplace friend by following simple safety guidelines. **Failure to follow even the most basic safety suggestions can result in serious personal injury.**

Turntables contain many moving parts--pulleys, belting, chains, sprockets, shafts, rollers, etc. Therefore, it is imperative to become familiar with basic unit operation and know all points of potential hazards.

Remember, when working around or near

turntables (and any industrial machinery) it is **your** responsibility to become familiar with the unit, to know potential hazards (many are noted with caution labels) and to operate unit in strict accordance with the safety guidelines in this manual.

Keep this manual in a safe place for future reference. It should be placed where appropriate personnel may maintain proper maintenance and records.

This manual must be read by all new users before operating or working near this unit.

! WARNING

**DO NOT OPERATE BEFORE READING THIS MANUAL!
KEEP IN SAFE PLACE--DO NOT DISCARD!**

CAUTIONS, WARNINGS AND HAZARDS

! WARNING

- !** Always anchor permanent supports to floor (or mounting surface). Use 3/8" x 2-1/2" (or longer) wedge anchors for permanent installation in concrete flooring.
- !** It is the responsibility of the customer and installation personnel to supply and install net or mesh guarding on overhead mounted conveyors to prevent product and/or debris from falling to floor in areas where required.
- !** To check drive sprocket alignment, shut "OFF" and lock out power source before attempting any adjustments.
- !** To check drive sprocket tension, shut "OFF" and lock out power source before any adjustments are attempted.
- !** Electrical controls must be designed by a qualified electrical engineer to ensure that appropriate safety features (emergency stops, pull cords, switches, etc.) are installed on unit for safe operation. Before conveyor start-up, all operators and other personnel coming in contact with unit must be properly trained and must have read accompanying Tech Handbook.
- !** Only trained personnel shall perform maintenance functions. Before maintenance operations are performed, shut conveyor "OFF" and lock out power source to prevent unauthorized start-up. When maintenance is completed, only authorized personnel shall be permitted to start conveyor following maintenance or other emergency shut-off.

SAFETY INFORMATION

IMPORTANT SAFETY GUIDELINES

⚠️ WARNING

WARNING: All personnel coming in contact with this conveyor should be aware of the following safety guidelines **BEFORE USING OR WORKING AROUND CONVEYOR**. **NOTE:** ALWAYS notify Roach Manufacturing® whenever any conveyor is used in an application or condition other than was originally intended. Failure to notify Roach® may allow conveyor to be operated in a hazardous operating condition. Injuries resulting from negligence or violation of safety instructions hereby removes responsibility of product liability claims from Roach®.

⚠️ Do not operate conveyor with protective guards removed. This includes chain guards, belt guards, snub roller guards, center drive guards and any other safety guard.

⚠️ Do not walk, ride, climb, or touch moving parts on a conveyor in operation.

⚠️ Do not wear loose clothing or uncovered hair around conveyor.

⚠️ Do not work near conveyor without knowing how & where to shut power "OFF" and lock out power source.

⚠️ Do not remove jammed product with conveyor running.

⚠️ Do not replace parts or perform maintenance on conveyor, or moving conveyor parts, without first shutting "OFF" power to conveyor and locking out power source.

⚠️ Do not connect gravity to powered conveyor without safety gravity connector brackets.

⚠️ To prevent electrical shock, conveyor must be grounded, and have proper electrical connections in accordance with federal, state, and local codes.

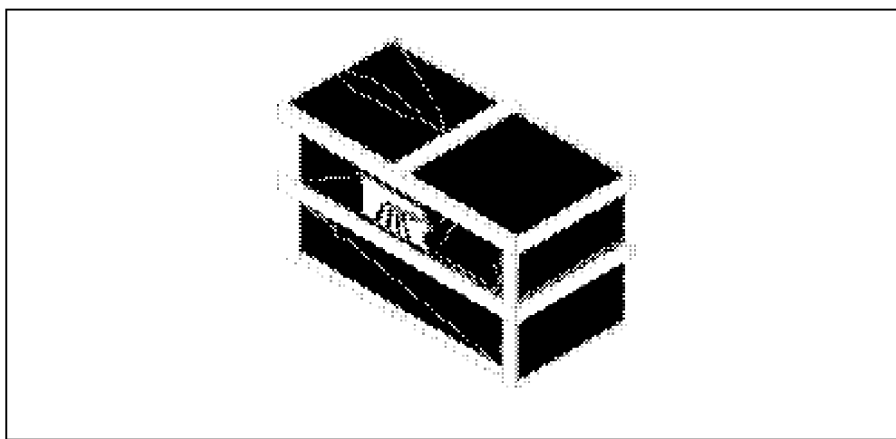
⚠️ Safety pop out rollers in conveyors installed above 7'-0" elevation must be retained by guard rail, clips, etc. Safety

pop out rollers must be allowed to pop out when conveyors are installed at or below 7'-0" elevation.

⚠️ It is the responsibility of conveyor end-user to comply with all safety standards including OSHA and other federal, state, and local codes or regulations. Install protective guarding and other related safety precautionary equipment to eliminate hazardous operating conditions which may exist when two or more vendors supply machinery for related use.

⚠️ Any violation of above safety instructions hereby removes all product liability claims from Roach Manufacturing Corporation®.

SHORTAGES, DAMAGES AND RETURN AUTHORIZATIONS



Before uncrating, check quantity of items received against bill of lading to confirm that all equipment has been received. Next, determine if any damage has occurred. Damage and/or shortage in shipment should be reported immediately to both Roach and carrier. Obtain signed damage report from carrier agent and send copy to Roach. **Do not repair any**

damage before obtaining this report.

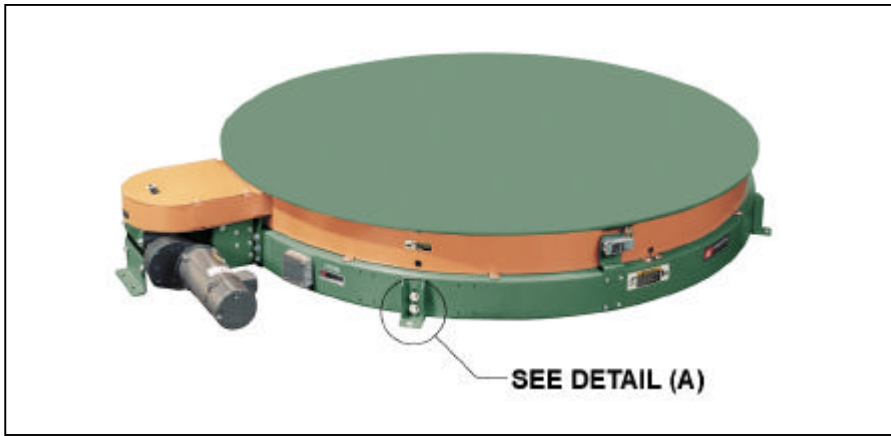
Finally, consult factory to determine if entire shipment must be returned to factory for repair *or* if a replacement order should be entered for replacement equipment.

Therefore, it is imperative that the bill of lading (or, accompanying freight documentation) be checked to ensure receipt of ALL units ordered including ALL accessories.

After receipt and initial inspection, carefully remove crating and look for essential components and specific accessories that may have been boxed and attached (or 'banded') to crating material such as guard rails and hardware which may be packaged and shipped in this manner. Save all hardware for subsequent use by installation personnel.

GENERAL INSTALLATION INFORMATION

INDEXING POWERED TURNTABLE SET UP



WARNING

Always anchor permanent supports to floor (or mounting surface). Use 3/8" x 2-1/2" (or longer) wedge anchors for permanent installation in concrete flooring.

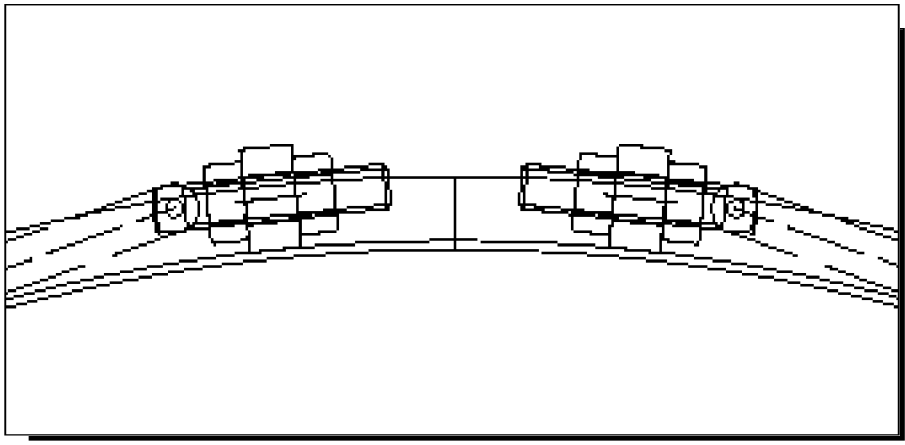
Once the IPT conveyor is uncrated, installation may begin. Locate unit in the actual installation area. Use mechanical hoist (fork truck or other available means) to raise turntable to approximate installed elevation. Adjust elevation to top of conveyor by loosening bolts in support uprights, rais-

ing or lowering conveyor and fully tightening bolts at desired elevation. Next, level the turntable across at 90 degree increments for proper unit operation. To level turntable, loosen bolts in upright floor supports and level as

required. Complete support installation by tightening bolts in ALL supports **before** unit operation and lag support attachment plates to floor with lag bolts in support foot plate mounting holes (see detail "A").

TECHNICAL

MAINTAINING PROPER CHAIN TENSION



WARNING

Before any adjustments are attempted it is imperative that conveyor is shut "OFF" and power source is locked out.

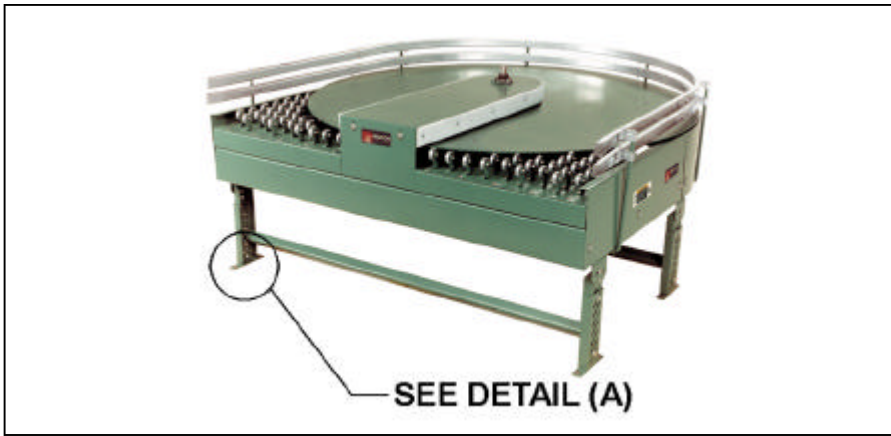
Maintaining proper chain tension is vital to conveyor operation. Enough tension should be maintained so that drive sprocket does not slip under fully loaded conditions. It is perfectly normal for chain to stretch in varying operating conditions under rated

loading. Therefore, tension on chain must be monitored and adjusted as necessary. To adjust IPT take-up, adjust position of take-up bolts as required. Do not operate with too much tension on chain, however.

Over-tensioning may increase operating noise to unacceptable levels. Adjust to decrease tension on chain if this occurs.

GENERAL INSTALLATION INFORMATION

CONTINUOUS ROTATION POWERED TURNTABLE SET-UP



WARNING
Always anchor permanent supports to floor (or mounting surface). Use 3/8" x 2-1/2" (or longer) wedge anchors for permanent installation in concrete flooring.

Once the CRT is uncrated, installation may begin. Locate unit in the actual installation area. Use mechanical hoist (fork truck or other available means) to raise turntable to approximate installed elevation. Adjust elevation to top of turntable by loosening bolts in support uprights, raising or lowering turntable and fully tightening bolts at

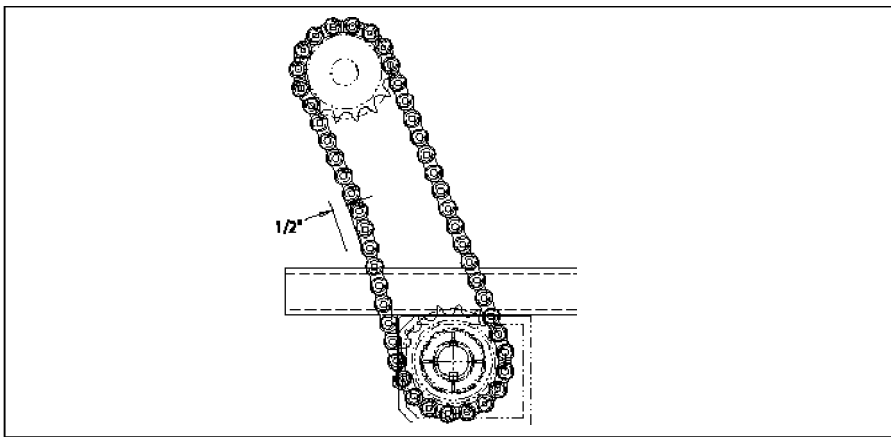
desired elevation.

Next, level CRT both across and lengthwise for proper unit operation. To level conveyor, loosen bolts in upright floor supports and level as required. Adjustments may be required at both sides of turntable supports and at each end of turntable.

Complete support installation by tightening bolts in ALL supports **before** unit operation and lag support attachment plates to floor with lag bolts in support foot plate mounting holes (see detail "A").

TECHNICAL

MAINTAINING PROPER CHAIN TENSION



WARNING
Before any adjustments are attempted it is imperative that conveyor is shut "OFF" and power source is locked out.

Maintaining proper chain tension is especially important. Again, a periodic visual inspection is recommended to ensure chain tension within a pre-determined operating range.

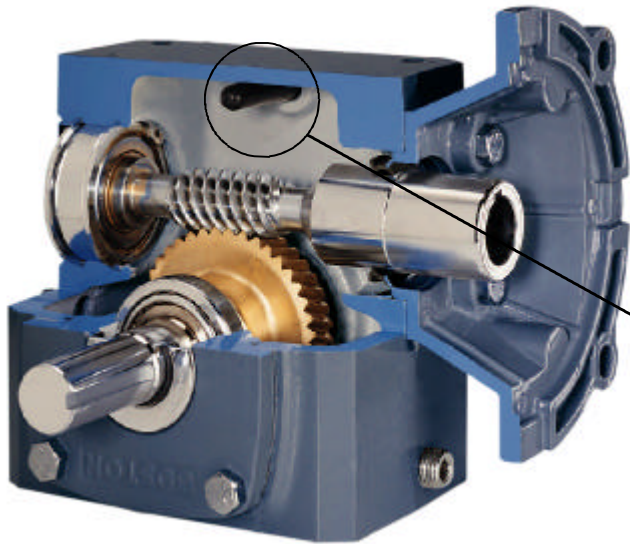
Remember, before any adjustments are attempted, conveyor must be shut "OFF" and power source locked out.

Before replacing chain guard cover, check to see if drive chain is operating within 1/2" range. If unit is out of tolerance, adjustment is necessary.

To adjust drive chain tension, tensioner bolt located on reducer push plate should be tightened (rotate clockwise) if chain tension is loose. Tighten until proper operating

range is achieved. If chain tension is too tight, loosen tensioner bolt (rotate counter-clockwise) as required. When adjustment is complete replace chain guard cover.

WARNING: Do not operate unit until chain guard cover is replaced. Serious operator or other personal injury could result if protective guarding is not replaced.



NOTE
The gear reducer is supplied with a "PosiVent". No vent plugs are required.

PosiVent Unique design incorporates a single seam construction. Factory filled with synthetic lubrication for universal mounting. Lubed for life, no oil changes are required.

To expedite the installation and start-up process, all gear reducers are shipped filled with oil. The reducers are sealed and lubed for life and require no oil changes.

PREPARING FOR INITIAL START-UP



⚠ DANGER
WARN ALL PERSONNEL TO KEEP CLEAR OF CONVEYOR DURING UNIT START-UP
Electrical controls must be designed by a qualified electrical engineer to ensure that appropriate safety features (emergency stops, pull cords, switches, etc.) are installed on unit for safe operation. Before conveyor start-up, all operators and other personnel coming in contact with unit must be properly trained and must have read accompanying Tech Handbook.

Before turntable start-up, all operators and other personnel coming in contact with unit must be properly trained and must have read accompanying Tech Handbook.

Provisions must be in order to instruct all personnel coming in contact with conveyor on the location of emergency stops, pull cords, etc.

A routine maintenance program should

be implemented before unit is placed into operation so that fundamental unit components are attended to. This maintenance program should include an inspection to ensure that any dangerous or hazardous operating conditions are noted and IMMEDIATELY corrected, as well as including electrical and mechanical unit inspections and corrections.

Finally, when conveyor is initially started, an immediate visual inspection should include motor, gear reducer, belt tracking (discussed in following section under "Belt Tracking") and related adjustments noted in handbook for unit/component corrections.

MAINTENANCE SAFETY PRECAUTIONS BEFORE PERFORMING MAINTENANCE

WARNING

Only trained personnel shall perform maintenance functions. Before maintenance operations are performed, turntable must be shut "OFF" and disconnects locked in the "OFF" position to prevent unit from unauthorized start-up.

One of the most important guidelines for maximizing turntable operation and personnel safety is to implement a regular maintenance schedule and train personnel on the appropriate needs of the specific unit.

Only trained personnel shall perform maintenance functions. Before maintenance operations are performed, conveyor must be shut "OFF" and disconnects locked in the "OFF" position to prevent unit from unauthorized start-up during maintenance. All personnel should be informed of the safety procedures associated with unit maintenance and performance.

Do not perform any work on conveyors or turntable system while in operation unless it is impossible to otherwise conduct adjustment, lubrication or other maintenance function. Only experienced, trained personnel possessing advanced hazards-training should attempt such critical operations.

MAINTENANCE AND FOLLOW-UP DETAILS

WARNING

Only trained personnel shall perform maintenance functions. When maintenance is completed, only authorized personnel shall be permitted to start turntable following maintenance or other emergency shut-off.

While performing maintenance do not wear loose clothing. Immediately report any hazardous conditions--sharp edges, pinch (or nip) points or other conditions that may result when several manufacturers supply machinery which may create operating hazards.

When using mechanical aids such as hoists, cables, or cranes exercise extreme caution to prevent damage to conveyors or other integrated machinery which may create a working hazard when maintenance is completed and units are in operation.

Clean up any spilled lubricants or other materials used in the maintenance process or those which may be deposited during unit operation. Eliminating poor housekeeping practices increases unit efficiency while creating safer personnel working conditions.

After maintenance, conduct visual inspection to ensure that all

safety devices and guards have been replaced. Confirm that all units are clear of tools, debris or other items. Before starting conveyor, check condition of conveyor warning labels (see "WARNING LABELS" at front of handbook). If labels have been destroyed or are not clearly legible, call 870.483.7631 to receive replacement labels. Placement of warning labels is critical to avoid unauthorized unit operation which may result in hazardous working conditions for all related personnel coming in contact with conveyor.

Warn personnel that conveyor is being prepared for start-up and to stay clear of unit. Do not start conveyor until all personnel are clear. When maintenance is completed, only authorized personnel shall be permitted to start conveyor following maintenance or other emergency shut-off.

MAINTENANCE AND LUBRICATION PERIODIC MAINTENANCE SCHEDULE

MODEL NO. _____

WEEKLY RECOMMENDED MAINTENANCE SCHEDULE*	
COMPONENT	DETAIL OF MAINTENANCE
BEARINGS	Lubricate in dirty, dusty or moist/wet conditions
UNIT SAFETY CHECK	Confirm placement of all guards, warning labels & check for loose bolts, nip points & other hazards

MONTHLY RECOMMENDED MAINTENANCE SCHEDULE*	
COMPONENT	DETAIL OF MAINTENANCE
GEAR REDUCER	Check for leaks
V-BELT DRIVE BELT	Check for proper operating tension & overall wear
DRIVE SHEAVES	Check & re-tighten set screws & check for overall wear
PILLOW BLOCK/ FLANGE BEARINGS	Lubricate (normal conditions)
DRIVE CHAIN	Check for proper operating tension & for overall wear & lubricate
DRIVE SPROCKETS	Check for overall wear & re-tighten set screws

PERIODIC RECOMMENDED MAINTENANCE SCHEDULE*	
COMPONENT	DETAIL OF MAINTENANCE
GEAR REDUCER	Check for leaks
DRIVE CHAIN	Clean (brush in solvent) & re-Lubricate by applying lubricant to inside of chain with brush or spout can at 2000 hour intervals
MOTOR	Check & clear motor ventilation openings at 500 hour intervals Check misc. operating conditions (normal heat & noise)

*All charts are for guidelines in normal operating or 'as noted' conditions. Severe applications may warrant additional maintenance.

TROUBLE SHOOTING AND REPLACEMENT PARTS

TROUBLE SHOOTING / SERIAL PLATE

TROUBLE SHOOTING		
TROUBLE	PROBABLE CAUSE	REMEDY
Motor & gear reducer running excessively hot, or hard to start	A. Lack of lubricant B. Frozen sprocket C. Overload D. Electrical	A. Check oil level in gear case. B. Check and inspect all sprockets and bearings. Replace sprockets failing to rotate or that are difficult to rotate. C. Reduce cause and/or increase motor horsepower. D. Check wiring and circuits, take ampere reading, replace motor if nec.
Motor & gear reducer makes excessive noise	A. Lack of Lubrication B. Damaged Gears C. Faulty Bearing	A. Check oil level in gear reducer. B. Replace Unit. C. Replace Bearing.
Drive chain, conveying chain or sprockets experience excessive wear	A. Excessive chain tension B. Sprockets misaligned C. Chain not lubricated D. Damaged sprocket or chain E. Misalignment of chain gd. F. Dirty Chain	A. Reduce chain tension. B. Realign with straight edge across sprocket faces. C. Lubricate chain with approved lubricant, wipe away excess lubricant. D. Replace damaged component E. Adjust chain guard assembly as necessary. F. Clean thoroughly and lubricate with approved lubricant.
Drive chain, conveying chain or sprockets make excessive noise	A. Insufficient chain tension B. Chain not adequately lubricated C. Sprockets misaligned	A. Adjust chain tension. B. Lubricate chain with approved lubricant, wipe away excess lubricant. C. Realign sprockets with straight edge across sprocket faces.
Pulsating chain	A. Insufficient chain tension B. Misalignment of chain gd. C. Overload	A. Adjust chain tension. B. Adjust chain guard assembly as necessary. C. Inspect for obstruction to or drag on conveyor.
Broken chain	A. Frozen bearing or sprocket shaft B. Worn or damaged chain C. Obstructed or jam	A. Inspect for damaged bearings, replace if necessary. Replace links as required. B. Replace chain as required. C. Remove obstruction to clear jam.
Tread roller(s) stalls or does not turn when loaded	A. Product overload B. Drive band broken C. Oily conditions D. Frozen roller bearing	A. Alter product loading to specified load rating. Consult factory. B. Replace drive band. C. Remove oil with recommended cleaner. D. Replace roller
Sprocket loose on shaft	A. Loose set screws B. Worn or damaged key	A. Realign sprockets with straight edge and tighten set screws. B. Replace with new key.
Excessive slack in chain	A. Normal Wear	A. Expect rapid chain growth in first two weeks of operation. Adjust chain tension as specified in this manual.

ORDERING REPLACEMENT PARTS

To order any replacement parts or when calling for assistance with any powered conveyor, **ALWAYS** provide the unit serial number. Shown at actual size, this is placed on the conveyor frame near the location of the drive assembly.



ROACH CONVEYORS
808 HIGHWAY 463
TRUMANN, AR 72472
TEL 870-483-7631

SERIAL NO. **123456**

To order replacement parts or add-on components, contact the Roach distributor who originally furnished the unit if possible. If this is not possible, contact the National Sales Office at 870-483-7631 for the name of the authorized Roach distributor in your area. Have unit model number and serial number **BEFORE** calling. Refer to unit drawings (in rear section of handbook) for part numbers if ordering replacement parts.

MODEL IPT PARTS LIST

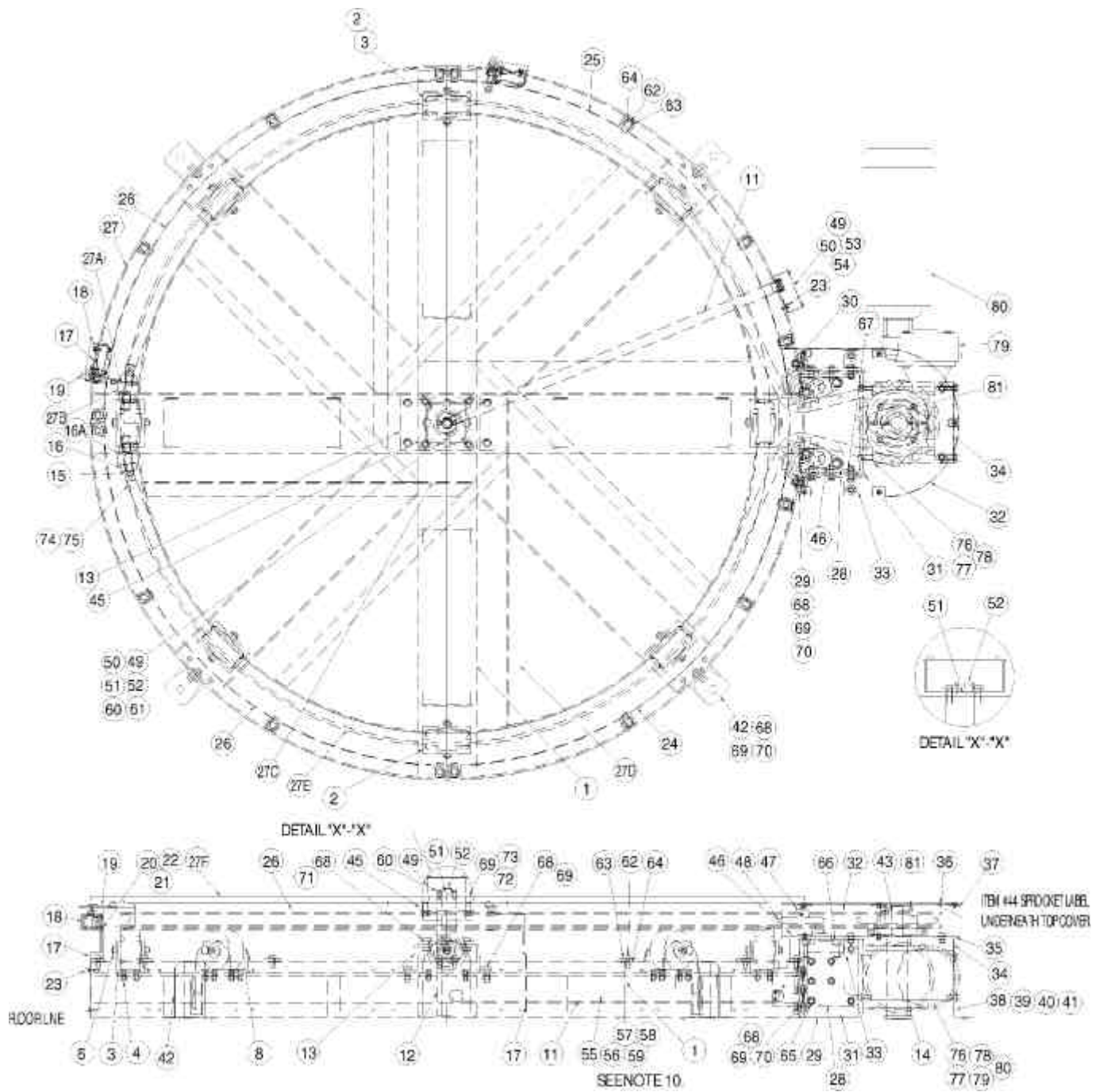
ITEM NO.	DESCRIPTION	ITEM NO.	DESCRIPTION	ITEM NO.	DESCRIPTION
1	BASE WELD ASSEMBLY	28	SPROCKET MOUNT WELD ASSY	61	1/4" LOCK WASHER
2	4" CASTER ASSEMBLY INSTRUCTIONS	29	MOTORBASE MOUNTING ANG. L.H	62	3/8"-16 X 1"LG. HHCS
3	CASTER MOUNTING ANGLE	30	MOTORBASE MOUNTING ANG. R.H	63	3/8" FLAT WASHER
4	3/8" X 1"LG. HHCS	31	MOTORBASE 730	64	3/8"-16 SPRING NUT U-TAPPED
5	3/8" LOCK WASHERS	32	CHAIN GUARD ASSY 730	65	3/8"-16 X 1 1/4"LG. HHCS
6	AXEL KIT (#5953 X 76)	33	GUARD MOUNTING ANGLE		3/8" LOCK WASHER
7	THRUST WASHER (TB1225)	34	GUARD MOUTING BRACKET 730	66	7/16"-14 X 1 1/2"LG. HHCS
8	4" DIA. DURALAST WHEEL	35	GUARD BOTTOM PLATE 730		7/16" LOCK WASHER
9	SPANNER BUSHING (#SB-2D)	36	GUARD TOP PLATE 730		3/8" FLAT WASHER
10	CASTER SHIM	37	GUARD SIDE PLATE 730	67	3/8" NYLON INSERT FLANGE NUT
11	3/4" CONDUIT PIPE	38	REDUCER SUPPORT ANGLE 730	68	1/2"-13 X 1 1/4"LG. HHCS
12	PIVOT SHAFT WELD ASSY	39	7/16"-14 X 1"LG. HHCS 730	69	1/2" LOCK WASHER
13	PIVOT SHAFT MOUNT	40	7/16" LOCK WASHER 730	70	1/2" FLAT WASHER
14	REDUCER SHAFT 730	41	3/8" FLAT WASHER 730	71	1/2" FLANGE NUT
15	TAKE-UP BOLT	42	SUPPORT CHANNEL WELD ASSY.	72	1/2"-13 X 2"LG. SHCS
16	7/8"-9UNC HEX NUT	43	1/4" X 2 7/8"LG. KEYSTOCK	73	1/2" HEX NUT
16A	7/8" LOCK WASHER	44	SHEAR PIN SPROCKET LABEL	74	#80 RIVETED CHAIN
17	LIMIT SWITCH MOUNT	45	FB-250 4 HOLE 1 15/16" BORE	75	#80 CONNECTING LINK
18	LIMIT SWITCH #802T-HP	46	ADJUSTABLE FLANGE TIGHTENER	76	7/16"-14 X 1"LG. HHCS (730)
19	ADJUSTABLE LEVER #802T-W2	49	JUNCTION BOX 4" X 4" X 1.5"	77	7/16" LOCK WASHER (730)
20	10-32NF X 1/2"LG IND.HHMS	50	JUNCTION BOX COVER 4" X 4"	78	IPT DRIVE KIT (3/4 HP)
21	#10 LOCK WASHER	51	1/2" CONDUIT CHASE NIPPLE	79	HMHF730-100-SPV-B5-H2-P31B
22	#10 FLAT WASHER	52	1/2" INSULATING BUSHING		1 15/16" BORE, 2"LG KEY.
23	1/4"-20 X 1/2"LG SELF TAP	53	3/4" LOCK NUT FOR CONDUIT	80	BRAKE MOTOR 3/4 HP 230/460-
24	DRIVE SIDE GUARD L.H.	54	3/4" INSULATING BUSHING		3PH/60H/TENV/56C (VBM3542)
25	DRIVE SIDE GUARD R.H.	55	#12 THHN BLACK STRANDED WIRE	81	SHEAR PIN SPROCKET ASSY.
26	INTERMEDIATE SIDE GUARD		(SEE CHART FOR CUT LENGTHS)		W/80A24 SPROCKET
27	PLATFORM WELD ASSEMBLY	56	#12 THHN GREEN STRANDED WIRE	82	1/4" X 1 1/8"LG. SHEAR PIN
27A	STRIKER TAB		(SEE CHART FOR CUT LENGTHS)	78	IPT DRIVE KIT (1 HP)
27B	CHAIN TAKE-UP BLOCK	57	#16 TFFN RED STRANDED WIRE	79	HMHF730-100-SPV-B7-H2-P31B
27C	BEARING MOUNTING PLATE		(SEE CHART FOR CUT LENGTHS)		1 15/16" BORE, 2"LG KEY.
27D	CENTER BRACE CHANNEL	58	#16 TFFN WHITE STRANDED WIRE	80	BRAKE MOTOR 1 HP 230/460-3PH
27E	CURVE BRACE CHANNEL 180 ³		(SEE CHART FOR CUT LENGTHS)		/60H/TEFC/143TC (VBM-3546T)
	CURVE BRACE CHANNEL 360 ³	59	#16 TFFN GREEN STRANDED WIRE	81	SHEAR PIN SPROCKET ASSY.
27F	PLATFORM TOP PLATE 36-48		(SEE CHART FOR CUT LENGTHS)		W/80A24 SPROCKET
	PLATFORM TOP PLATE 54-96	60	1/4"-20 X 3/4"LG. HHCS	82	1/4" X 1 1/8"LG. SHEAR PIN

Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components.

LIGHT SWITCH CHART			
QTY PER NUMBER OF STOP POSITIONS			
ITEM	2 POS	3 POS	4 POS
#17	2	3	4
#18	2	3	4
#19	2	3	4
#20	4	6	8
#21	4	6	8
#22	4	6	8
#23	9	13	17

ITEMS # 55, 56, 57											
LENGTH OF WIRE PER DIAMETER											
TURNTABLE DIA	36"	42"	48"	54"	60"	66"	72"	78"	84"	90"	96"
LENGTH OF WIRE	54"	57"	60"	63"	66"	69"	72"	75"	78"	81"	84"
FOR ONE STRAND	4'6"	4'9"	5'	5'3"	5'6"	5'9"	6'	6'3"	6'6"	6'9"	7'

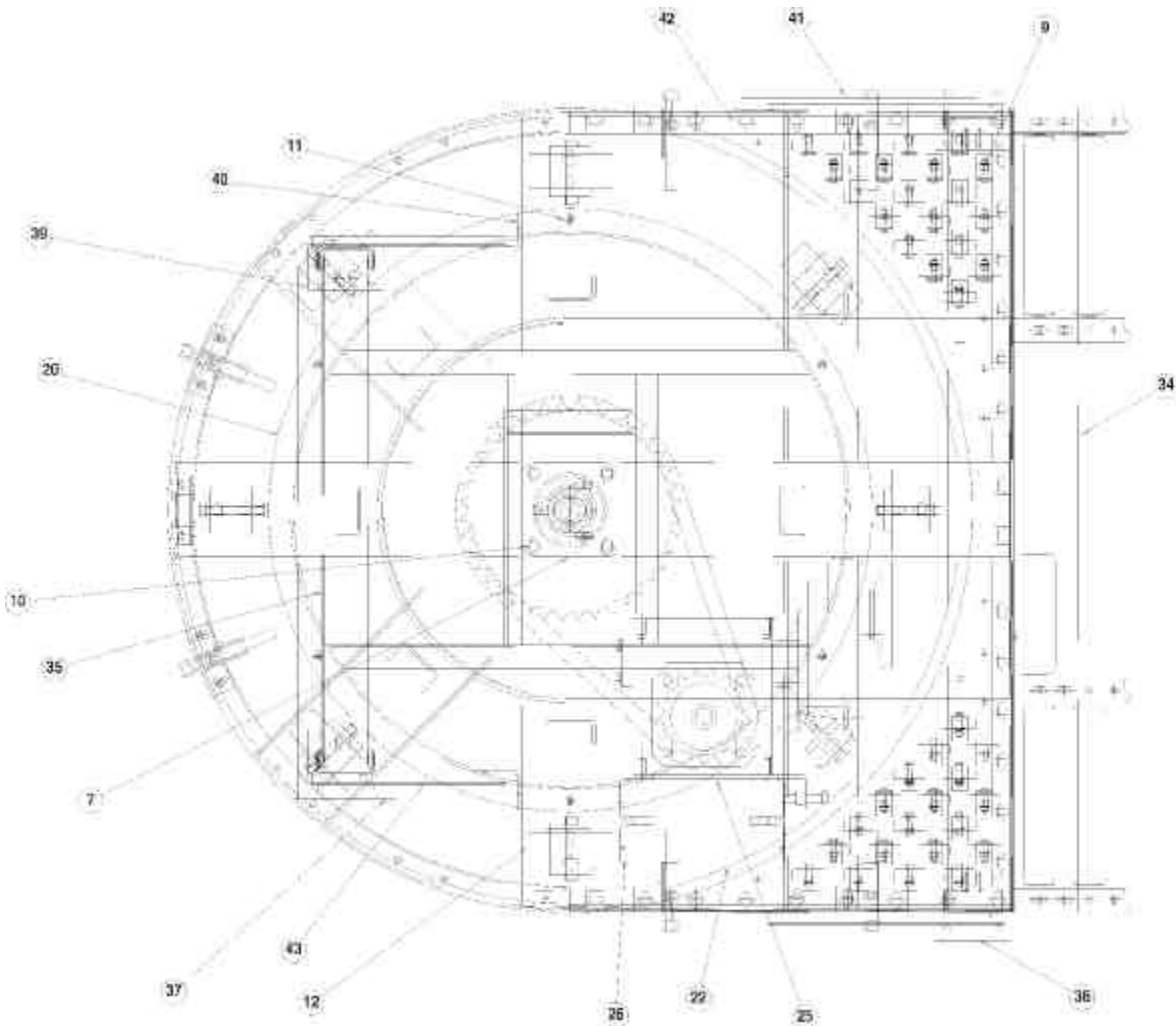
DRIVE CHAIN & CONNECTOR LINK											
TURNTABLE DIA.	36"	42"	48"	54"	60"	66"	72"	78"	84"	90"	96"
ITEM # 72	9'2"	10'9"	12'4"	13'10"	15'5"	17'	18'7"	20'2"	21'8"	23'3"	24'10"

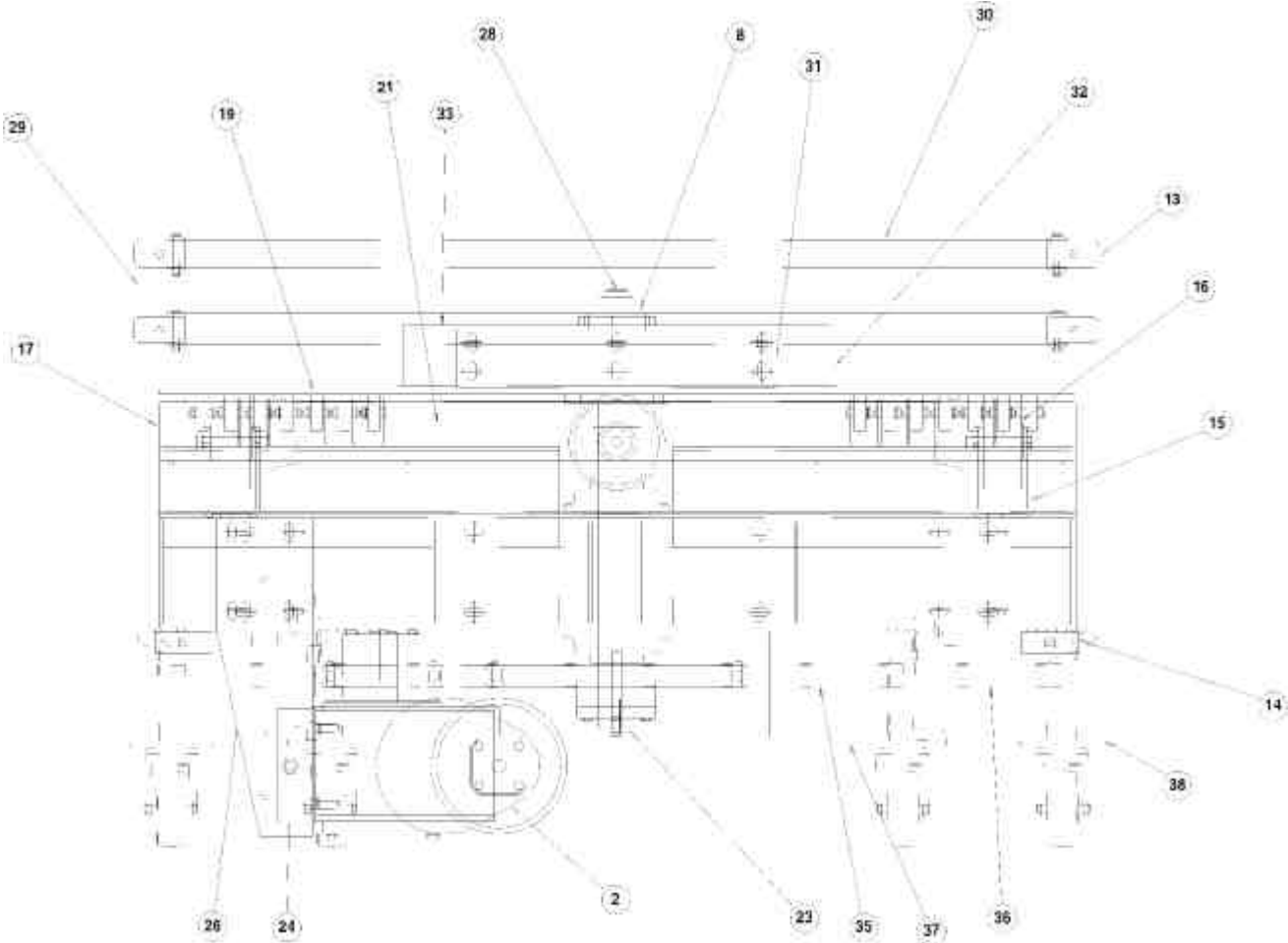
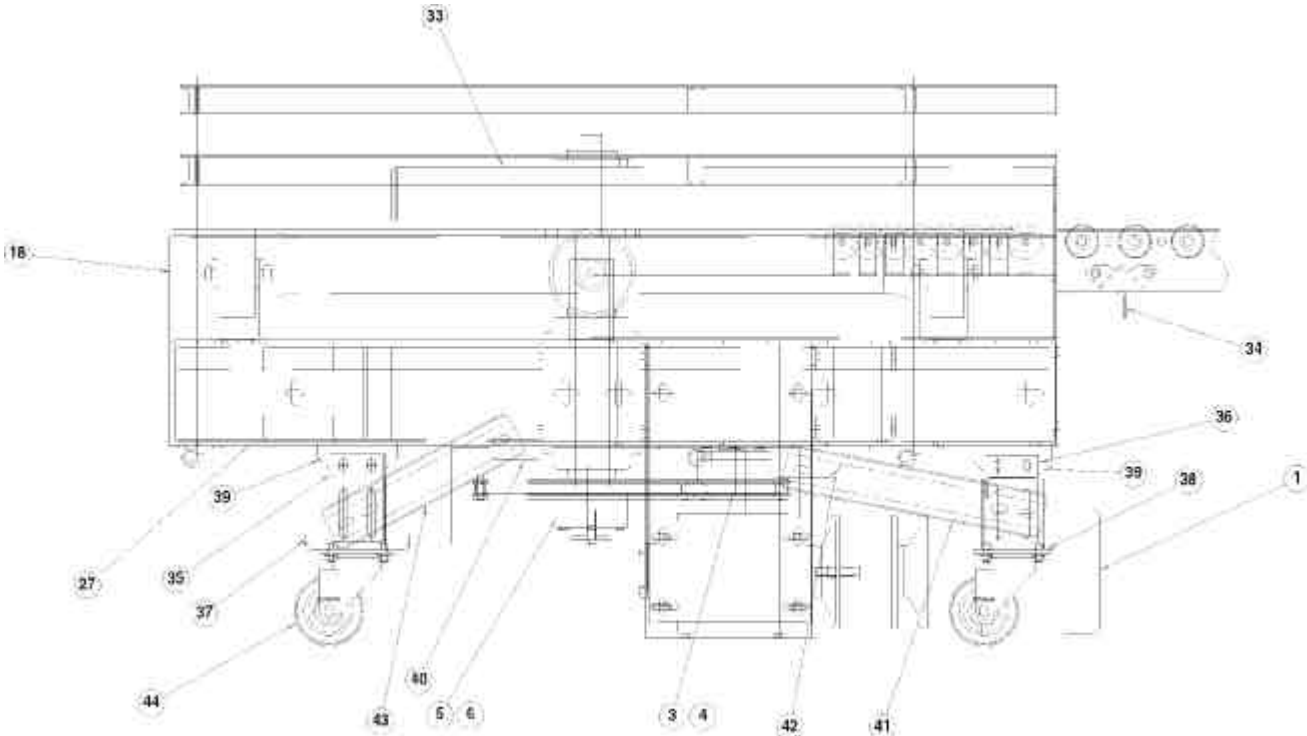


ITEM NO.	DESCRIPTION
19	ADJ LEVER # 802T-TW2
45	4 HOLE BEARING 15/16" BORE
48	HN80B-13 IDLER SPROCKET
72	#80 RIVETED CHAIN
50	MOTOR
51	REDUCER

MODEL CRT PARTS LIST

ITEM NO.	DESCRIPTION	ITEM NO.	DESCRIPTION
1	MOTOR	22	TRANSITION PLATE
2	REDUCER	23	PIVOT SHAFT END CAP
3	80Q-17 FOR / 1 1/2" BORE	24	232 (1325) RED. PUSH PLATE
4	Q1 BUSHING W/1 1/2" BORE	25	232 (1325) MOTOR BASE
5	80Q-40 FOR/ 1 15/16"BORE	26	MOTOR BASE STIFFENER ANGLE
6	Q1 BUSHING W/1 15/16" BORE	27	TURNTABLE BASE ASSY.
7	FB-220 4-HOLE BRG. 1 15/16"	28	PIVOT SHAFT ASSY.
8	GVFTD-1 3/16" BORE BRG.	29	22" L-ROD SPECIAL
9	35Z STEEL SKATEWHEEL	30	90° ADJ. CHAN GUARD SYSTEM
10	1/2-13 x 1" F.S.H.M.S.	31	DIVERTER MOUNTING ANGLE
11	3/8-16 x 1" F.S.H.M.S.	32	DIVERTER WEARSTRIP
12	W-520D-S HAMILTON CASTER	33	DIVERTER ASSY.
	W/ 1/2"x 3 1/2" AXLE	34	END SUPPORT BRACE
	W/ SB-2 SPANER BUSHING	35	I/S CHANNEL WELD ASSY
	W/ TB1225 THRUST WASHER	36	I/S CHANNEL WELD ASSY
13	L-ROD CLIP	37	CASTER CHANNEL WELD ASSY
14	3" GUARD RAIL BRKT.	38	O/S CHANNEL WELD ASSY
15	CASTER MTG. BRKT.	39	SUPPORT TOP CAP
16	SKATEWHEEL MTG. ANGLE	40	KNEE BRACE TOP CAP
17	BASE SIDE GUARD	41	KNEE BRACE SPECIAL 15"LG.
18	180° BASE GUARD	42	KNEE BRACE TOP CAP STD.
19	TURNTABLE TOP PLATE	43	KNEE BRACE KB-2 STD.
20	STIFFINER RING ASSY.	44	4" DIA. (SWIVEL W/BRAKE)
21	SPUR FRAME ASSY.		





- Materials used by Roach Conveyors are of good quality.
- Any part proving to be defective in materials or workmanship upon Roach inspection, will be replaced at NO cost, FOB, Trumann, Arkansas, for one year. Installation expense will be paid by others.
- Roach liability includes furnishing said part or parts; Roach is not liable for consequential damages, such as loss of profit, delays or expenses incurred by failure of said part or parts.
- Failure due to abuse, incorrect adjustments, exposure to corrosive or abrasive environment or operation under damp conditions does not constitute failure due to defects in workmanship or materials.
- Component parts not manufactured by Roach (motors, gear reducers, etc.) will be repaired or replaced at the option of their manufacturer. Contact nearest authorized service center for all warranty claims.

NOTE: MOTORS OR GEAR REDUCERS TAMPERED WITH BEFORE INSPECTION SHALL BE CONSIDERED FREE OF ALL WARRANTY CLAIMS.



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