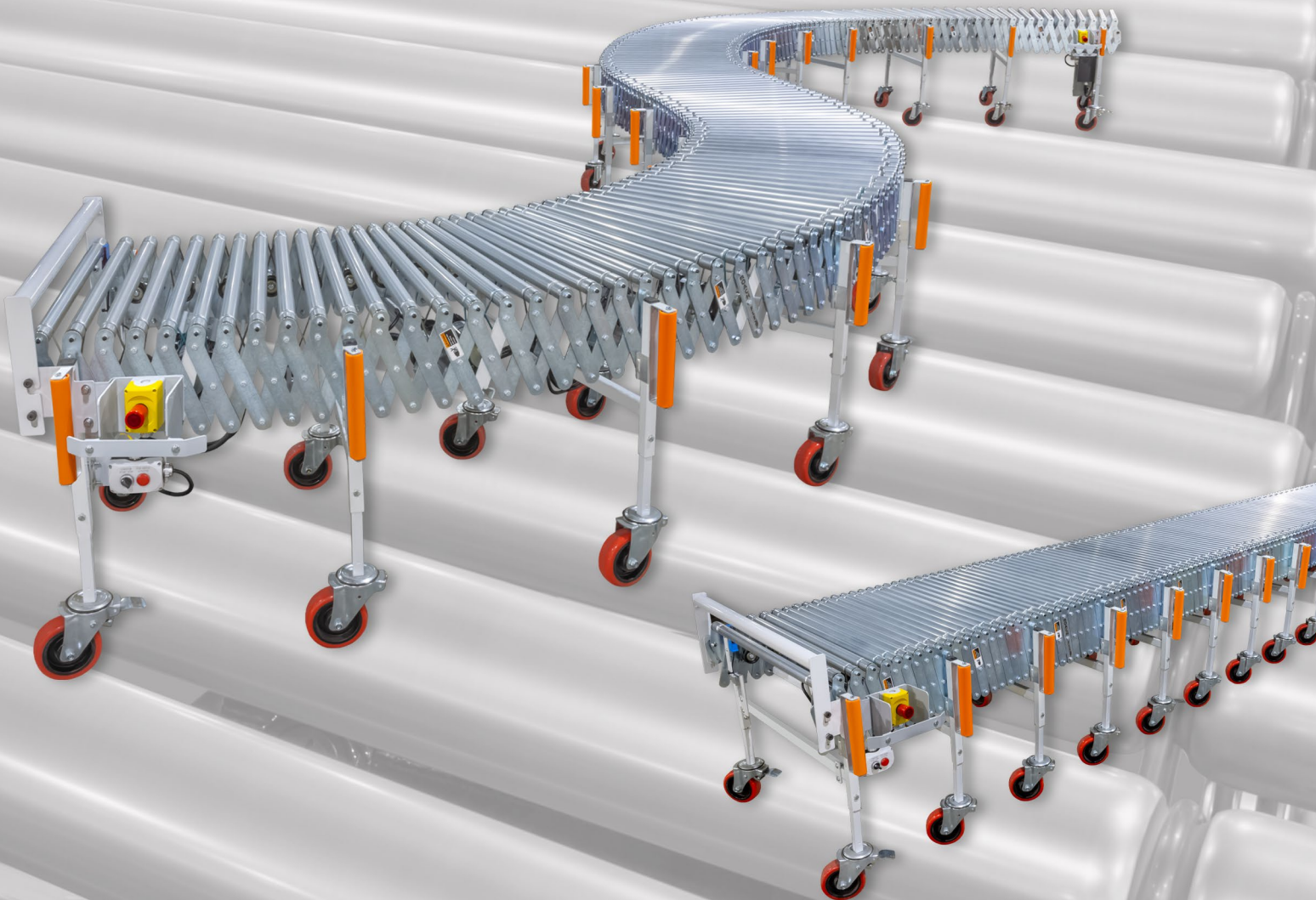




American Made Conveyor Solutions

OWNER'S MANUAL



PowerFlex SC

DO NOT OPERATE BEFORE READING THIS HANDBOOK

TECH HANDBOOK FOR POWERFLEX 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 is placed on conveyor between each set of floor supports on both sides of each flexible conveyor.

DO NOT OPERATE ANY FLEXIBLE CONVEYOR WITHOUT THIS WARNING LABEL PLACED BETWEEN EVERY SET OF LEGS ON BOTH SIDES OF EVERY FLEXIBLE CONVEYOR USED.

SERIOUS OPERATOR INJURY MAY OCCUR IF WARNING LABELS ARE NOT CLEARLY DISPLAYED ON EVERY FLEXIBLE CONVEYOR.

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, conveyors 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 conveyor (or, most any type of machinery-including our automobiles!) will increase when com-

pared to a similar unit in an application receiving little or no maintenance. You may find that a conveyor 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.

Conveyors 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 conveyors (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


-  Before conveyor is placed into operation, all operators and other personnel coming in contact with conveyor must be properly trained and must have read accompanying Tech Handbook.
-  Never move MCP conveyor by holding ANY part of conveyor other than handles. Handles are provided at both ends and both sides of MCP conveyors.
-  DO NOT wear loose clothing or unprotected long hair around MCP conveyors, powered conveyors or machinery with moving parts.
-  When MCP conveyor is being moved, set up or when conveyor is being adjusted by expanding or contracting overall unit length, keep hands, clothing, long hair or other objects clear of scissor grid framework on conveyor to avoid serious injury. Turn off power when moving the conveyor. Keep feet clear of casters when rolling. Only handles should be used when moving the conveyor.
-  Never connect belt conveyors directly to gravity conveyors, MCP conveyors, machinery or fixtures without using connector brackets & pop out roller.
-  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.
-  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.


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 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 walk, ride, climb, or touch moving parts on a conveyor in operation.


 Do not wear loose clothing or uncovered hair around conveyor.

 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.

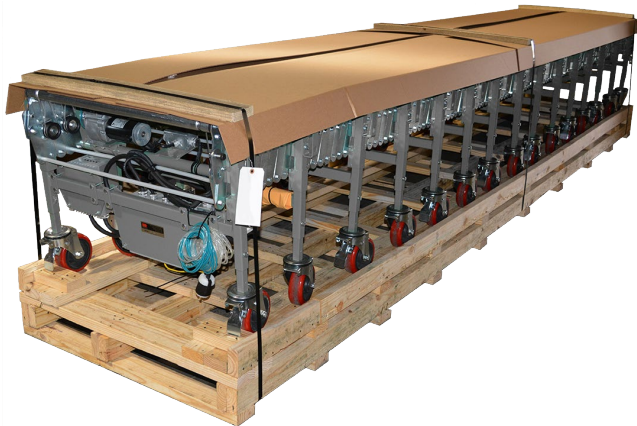
 Do not connect gravity to powered conveyor without safety gravity connector brackets.

 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

 Keep hands, hair, clothing, etc. clear of drive bands.

SHORTAGES, DAMAGES, RETURNS AND UNCRATING



NOTE: Do not return goods to factory without prior, written return authorization. Unauthorized returns are subject to refusal at factory.

Before uncrating, check quantity of items received against bill of lading to confirm that all material has been received. Examine the condition of equipment to determine if any damage has occurred.

Damage and/or shortage in shipment should be reported immediately to both vendor and carrier. Obtain a signed damage report from carrier agent and

send copy to vendor. Do not repair any damage before obtaining this report.

For damaged shipments, consult factory to determine if entire shipment must be returned to factory for repair or if an immediate order should enter production to produce a new, replacement shipment.

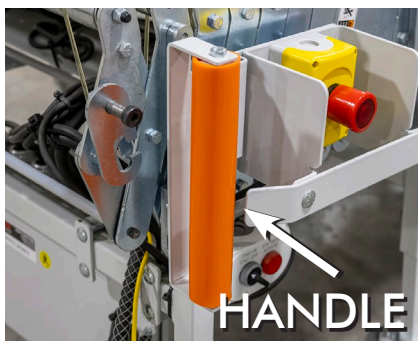
Carefully remove crating and look for essential components and specific

accessories that may have been boxed and attached (or 'banded') to crating material. Save all hardware for subsequent use by installation personnel.

It is possible that some items may become separated from original shipment. Check bill of lading (or, accompanying freight documentation) to ensure receipt of ALL units ordered including ALL accessories.

SET-UP / CONNECTION OF INTERMEDIATE SECTIONS

Once initial inspection and uncrating are completed, unlock casters and move conveyor into actual operational area. Use ONLY handles on each side of conveyor (located at each support of the conveyor) to move extendible conveyor to open or "expand" conveyor.



While moving, be sure to keep hands, clothing, hair and other objects clear of side frame grid on conveyor to avoid serious injury. Once relocated, lock casters to secure extendible conveyor. If two or more sections require connection, see coupling hooks illustration below to connect.



COUPLING HOOKS

⚠ DO NOT CONNECT MORE THAN 3 UNITS TO A SINGLE OUTLET!



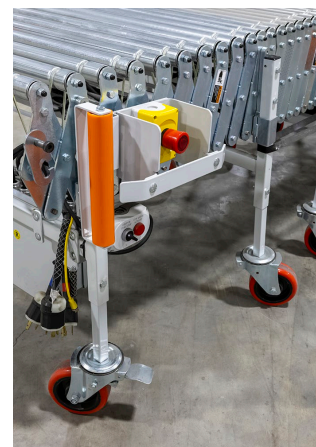
Intermediate sections may be connected by using coupling hooks as shown above. Move adjoining sections into position then rotate coupling hook from section 1 over the rod on section 2. Next, rotate coupling hook from section 2 over the rod on section 1.

FLOOR SUPPORTS



Extendible conveyors are supported by fixed elevation supports with 6" dia. casters. Every 3rd caster is supplied with a brake to curtail conveyor movement when placed into operation (see image at top right of page).

Keep feet clear of casters when rolling.



⚠ WARNING: While moving, keep hands, clothing, hair and other objects clear of conveyor side bars to avoid serious injury.

BEFORE PERFORMING MAINTENANCE

WARNING

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.

One of the most important guidelines for maximizing conveyor 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" (if applicable) 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 conveyor 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 conveyor following maintenance or other emergency shut-off.

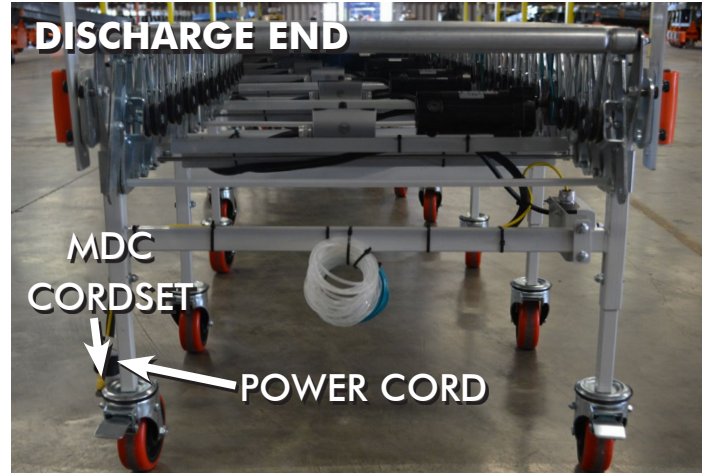
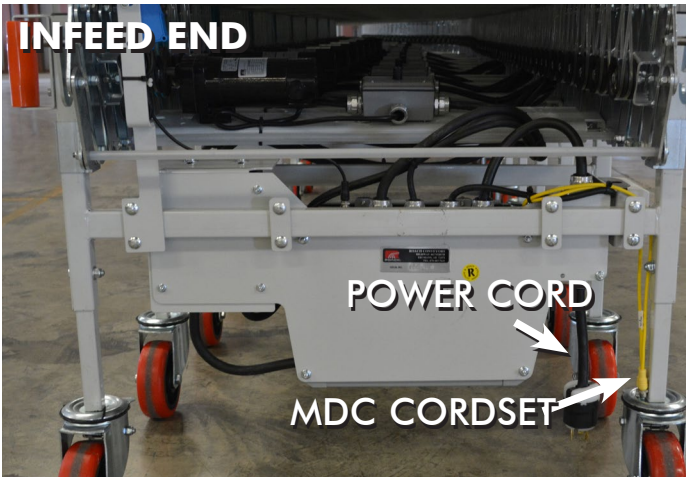
While performing maintenance do not wear loose clothing. Immediately report any hazardous conditions-sharp edges, pinch (or nip) points or other conditions that may result when several manufacturers supply machinery which may create operating hazards.

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 flexible conveyor warning labels (see "WARNING LABELS" at front of handbook). If labels have been destroyed or are not clearly legible, contact Roach Corporation® 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.

SEQUENCE OF OPERATION



The power cord for the unit is at the infeed end of the conveyor. This input is a twist lock connector (see twist lock connector at bottom of the page) and should only be connected by authorized personnel. The power cord should be connected to a dedicated 120v power source.

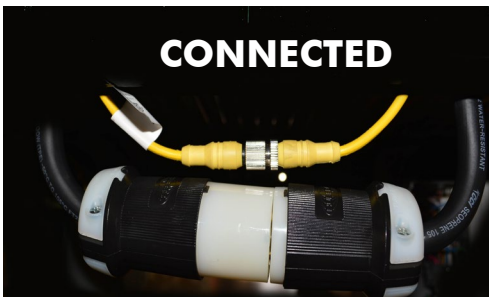
If multiple units are hooked together the power supply and the Yellow MDC

Cordset for each unit must be connected. The individual units have male twist lock connectors and female MDC cordset connectors at the infeed end. The discharge end has a female twist lock connector and male MDC cordset connectors. Connect these 2 sets of cable to provide power to the subsequent conveyor and interface all of the Start/Stop switches.

The MDC Cordset cables should be connected by aligning the tabs and screwing the two connector barrels together.



MDC CORDSET



⚠ DO NOT CONNECT MORE THAN 3 UNITS TO A SINGLE OUTLET!

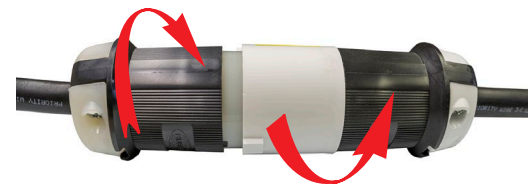
TWIST LOCK CONNECTOR W/ SHROUD



1) Align the connector blades with the plug inlets.



2) Insert blades into inlets

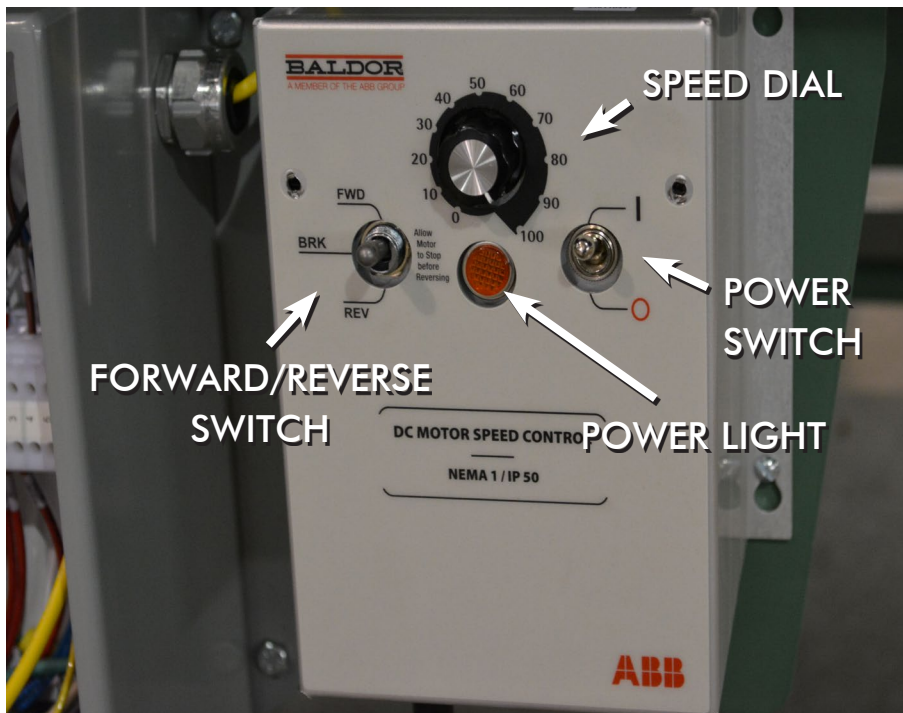


3) Twist connectors to lock in place

SEQUENCE OF OPERATION

Once the power cord is connected the unit is ready to power on. The controls are at the infeed end of the unit at the enclosure mount. The power switch is OFF in the down position and ON in the up position. Turning the switch ON the amber power light should illuminate, indicating the unit has been activated and is ready to run.

The conveyor speed can be adjusted by rotating the SPEED DIAL left to right from 0 - 100. 0 being the slowest speed and 100 the maximum. Speed should only be adjusted by trained personnel.



START / STOP SWITCH



A START/STOP switch is located on the right side of the conveyor at the infeed end and a second switch on the left side at the discharge end allowing operators to control the conveyor from either side. All switches need to be in the START position to run. The conveyor will not run if any of the switches are in the STOP position.

POWER ON BUTTON



Finally, the infeed end Power On button must also be pressed and illuminated for the conveyor to run.

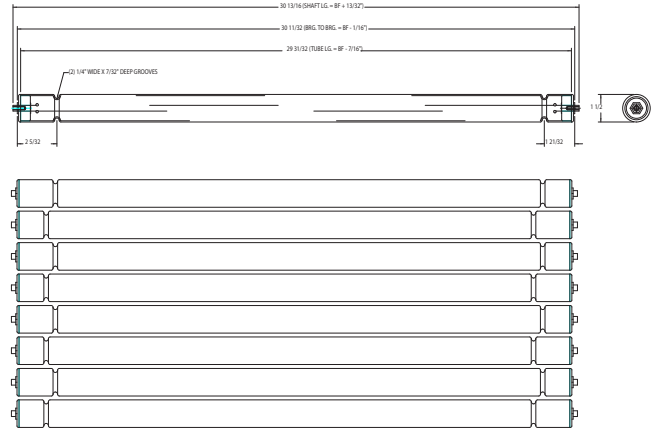


Be aware of potential for falling packages. Product guards are available for this conveyor.

ROLLERS

The rollers for the powered flexible are 156G double grooved rollers 30"BF. These rollers have 1/4" wide grooves at both ends. The grooves are located 2-5/32" from one end of the

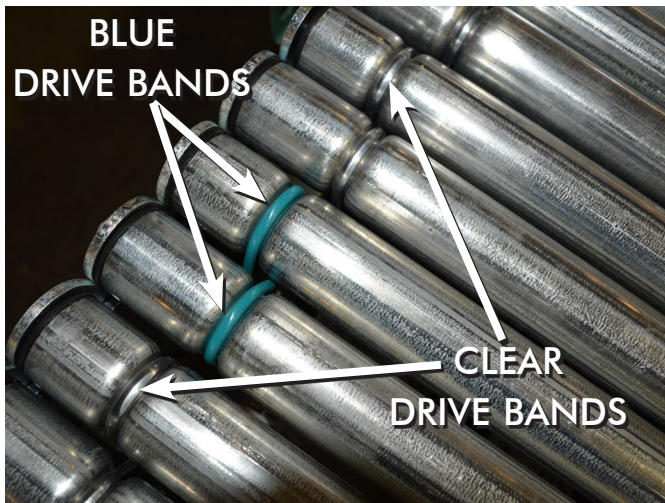
roller and 1-21/32" from the other end. This is so the rollers can be staggered in the conveyor frame.



DRIVE BANDS

There are 2 types of drive bands for the powered flexible conveyor. The first is a blue band for the rollers driven by the motor. The second is a clear band which is for the rollers that are slave driven.

Should one of these drive bands break, extra bands have been included with each conveyor. These bands are zip tied to the frame at the infeed end of the conveyor.



GEAR REDUCER ADJUSTMENTS

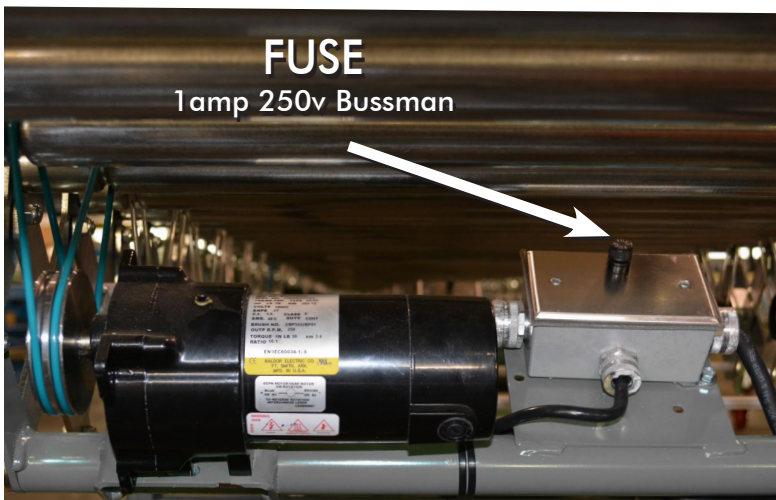
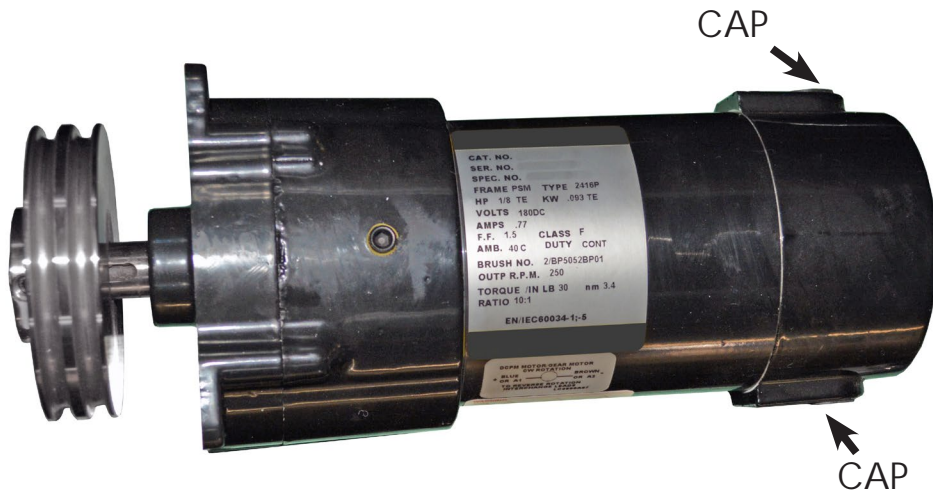
DC MAGNET MOTORS BRUSH MAINTENANCE

- Remove cap (shown at right) from both sides of motor to access the brushes.
- With cap removed, brush may be removed by pulling on the spring.
- Visually inspect brushes for chips or grooves.
- The shunt wire should not have any frays.
- Reinsert with the brass tabs facing the front and rear of the motor.

⚠ 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 Owners Manual.




A fuse has been included at each motor for protection. The fuse is a 1amp 250v Bussman fuse. If a fuse is blown a qualified technician should determine the cause of the surge before replacing the fuse.



TROUBLESHOOTING

TROUBLESHOOTING		
TROUBLE	PROBABLE CAUSE	REMEDY
Product stops on conveyor or will not flow smoothly	<ul style="list-style-type: none"> A. Floor supports out of adjustment B. Wheels are locked C. Conveyor damaged 	<ul style="list-style-type: none"> A. Adjust supports as previously outlined in the Owners Manual. B. Remove debris from wheels and/or replace wheels as necessary. C. Visual inspection required to identify worn or damaged parts. Replace worn or damaged parts as necessary.
Conveyor will not open or roll smoothly	<ul style="list-style-type: none"> A. Casters are locked B. Casters are frozen due to debris or dirty environment C. Bolts and nuts are over tightened D. Conveyor is damaged 	<ul style="list-style-type: none"> A. Unlock casters before moving conveyor. B. Clear debris from casters until casters are readily mobile. Replace damaged or worn casters as necessary C. Loosen bolts and nuts that may have been over tightened during maintenance procedures. D. Replace ALL components damaged to return unit to proper operating condition. <p>NOTE: All damaged parts should be replaced immediately to promote safe work environment</p>

ORDERING REPLACEMENT PARTS



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

SERIAL NO.

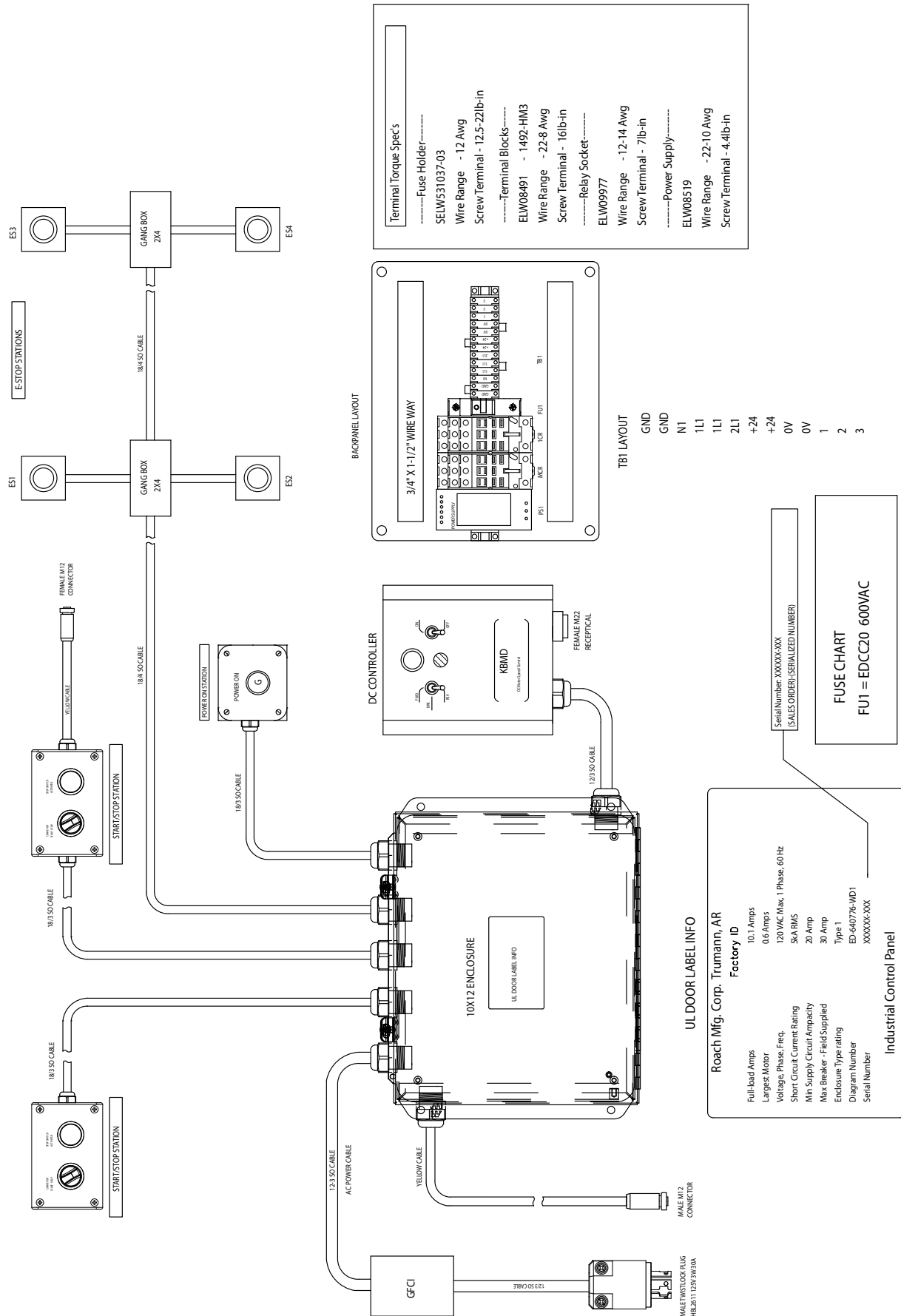
123456



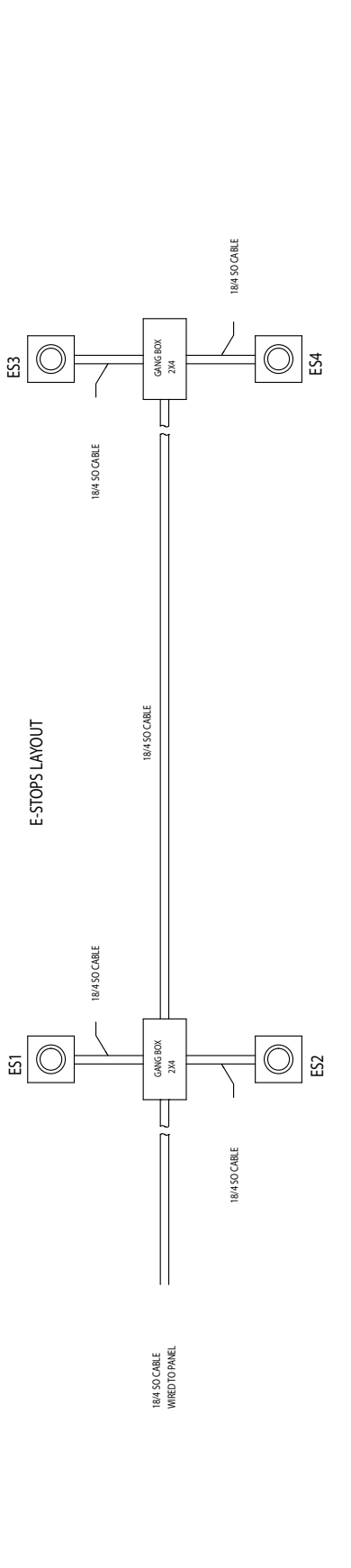
To order any replacement parts or when calling for assistance with any powered conveyor, ALWAYS provide the unit serial number. Shown at actual size, this aluminum plate is placed on enclosure mount at the infeed end of the conveyor.

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.

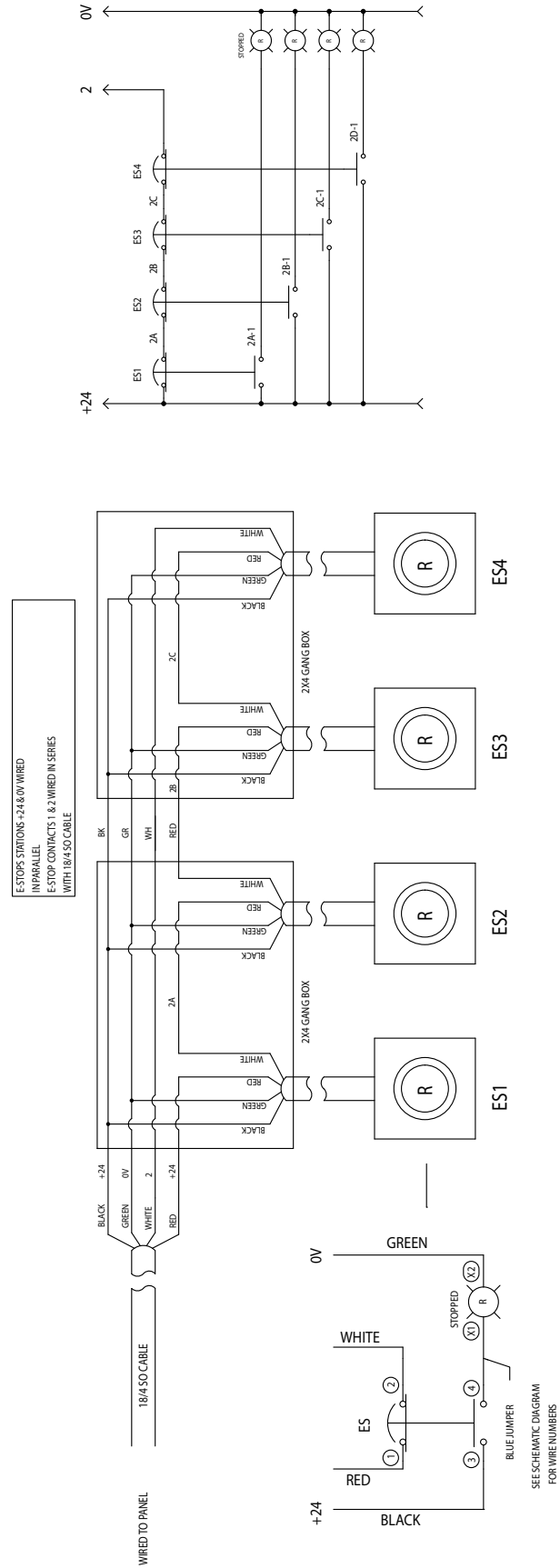
40' SC CONTROL SYSTEM PANEL LAYOUT WITH E-STOPS



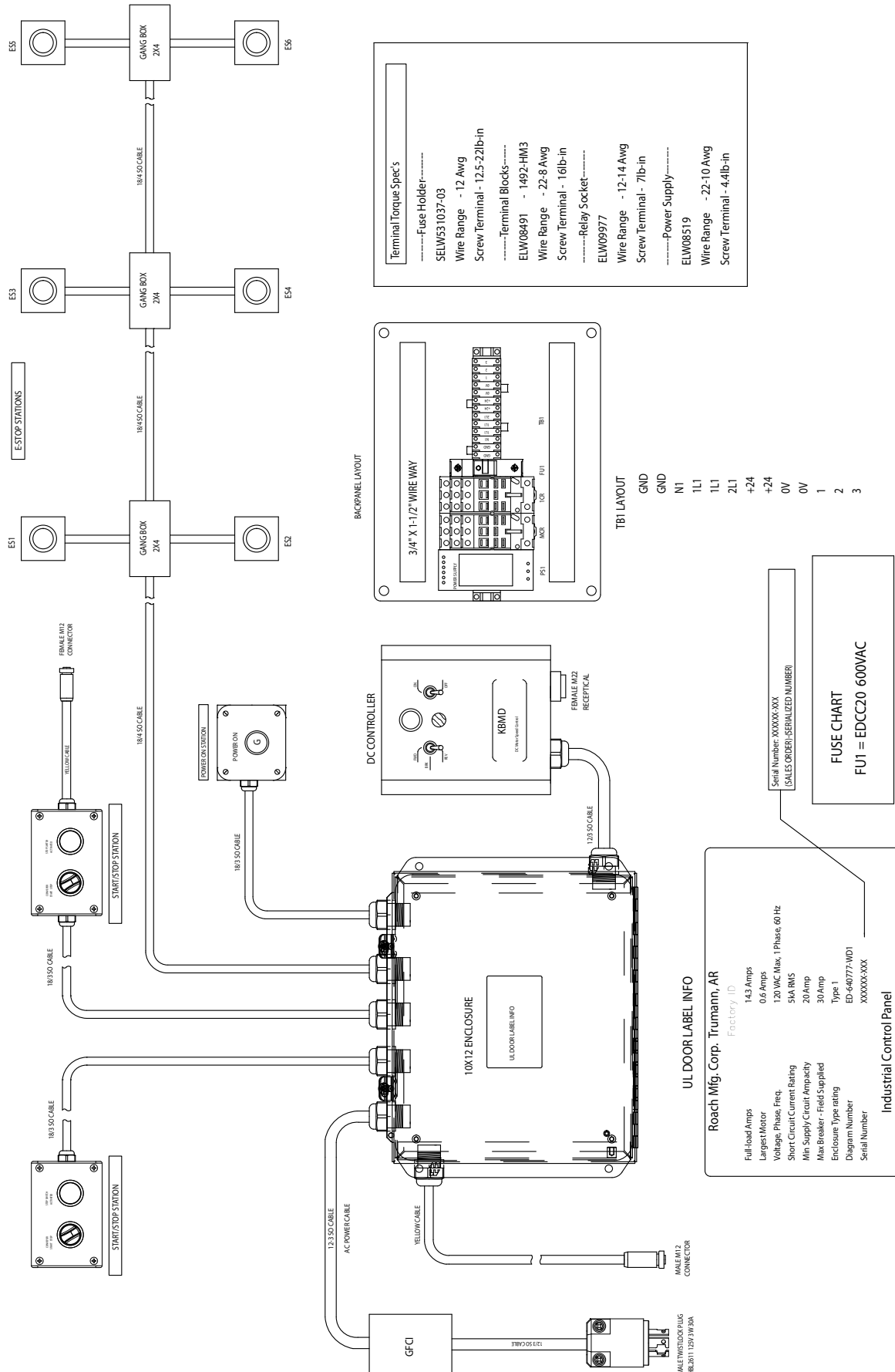
40' SC CONTROL SYSTEM E-STOP WIRING



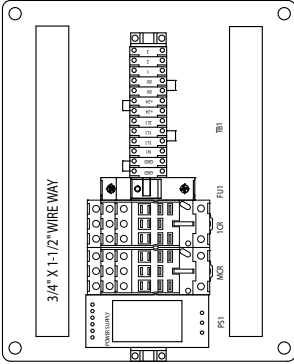
E-STOPS WIRING



60' SC CONTROL SYSTEM PANEL LAYOUT WITH E-STOP



- Terminal Torque Specs**
- SELW531037-03 - Fuse Holder
 - Wire Range - 12 Awg
 - Screw Terminal - 12.5-22lb-in
 - Terminal Blocks
 - ELW08491 - 1492-HM3
 - Wire Range - 22-8 Awg
 - Screw Terminal - 16lb-in
 - ELW09977 - Relay Socket
 - Wire Range - 12-14 Awg
 - Screw Terminal - 7lb-in
 - Power Supply
 - ELW08519
 - Wire Range - 22-10 Awg
 - Screw Terminal - 4.4lb-in



- TB1 LAYOUT**
- GND
 - NI
 - 1L1
 - 2L1
 - +24
 - +24
 - 0V
 - 0V
 - 1
 - 2
 - 3

UL DOOR LABEL INFO

Roach Mfg. Corp. Trumann, AR
Factory ID

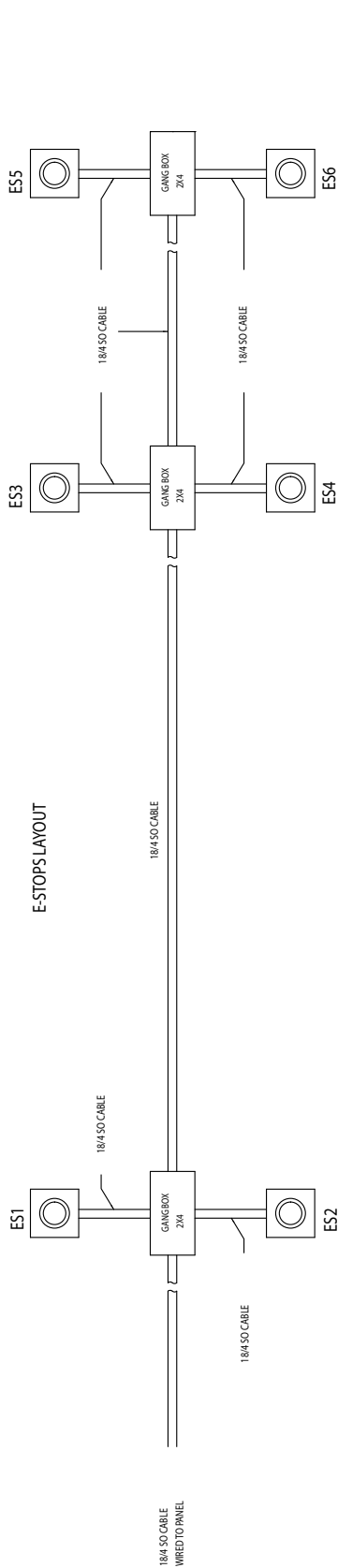
Full-load Amps	14.3 Amps
Largest Motor	0.6 Amps
Voltage Phase Freq.	120 VAC Max, 1 Phase, 60 Hz
Short Circuit Current Rating	5KA RMS
Min Supply Circuit Ampacity	20 Amp
Max Breaker - Field Supplied	30 Amp
Enclosure Type rating	Type 1
Diagram Number	ED-64077-W01
Serial Number	XXXXXXXXXX

Industrial Control Panel

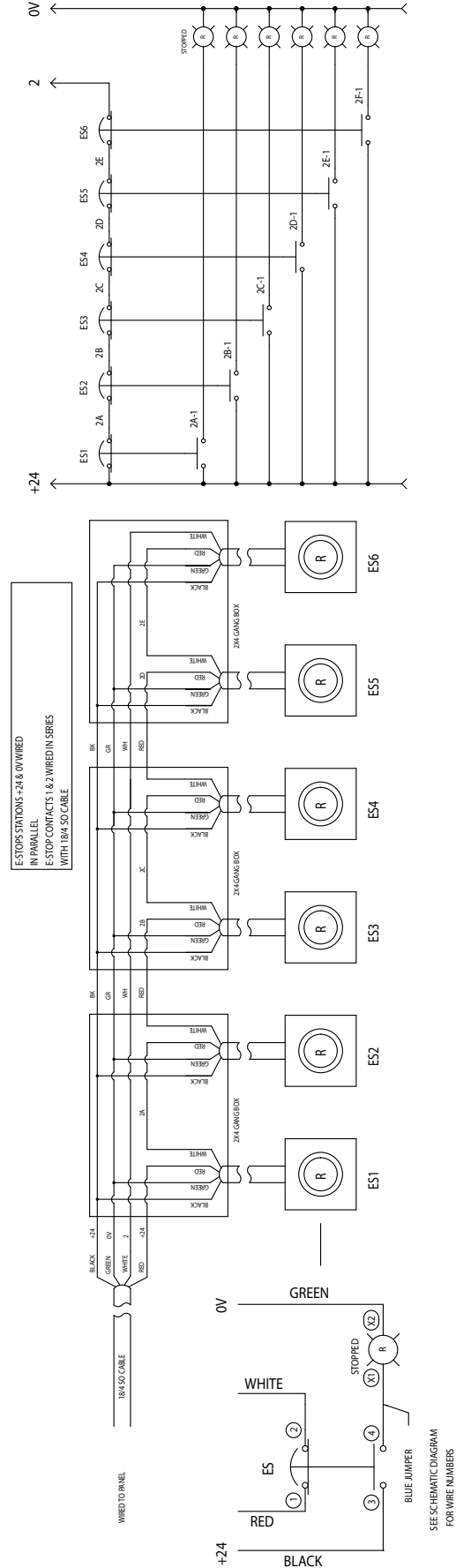
Serial Number: XXXXX-XXX
SALES ORDER/SERIALIZED NUMBER

FUSE CHART
FUI = EDCC20 600VAC

60' SC CONTROL SYSTEM E-STOP WIRING

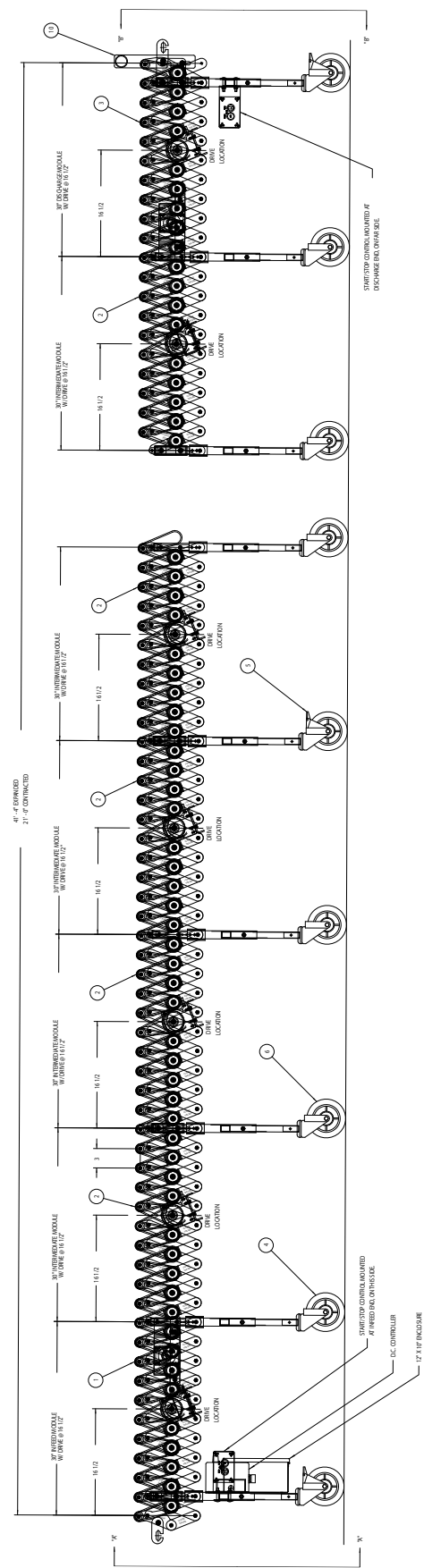
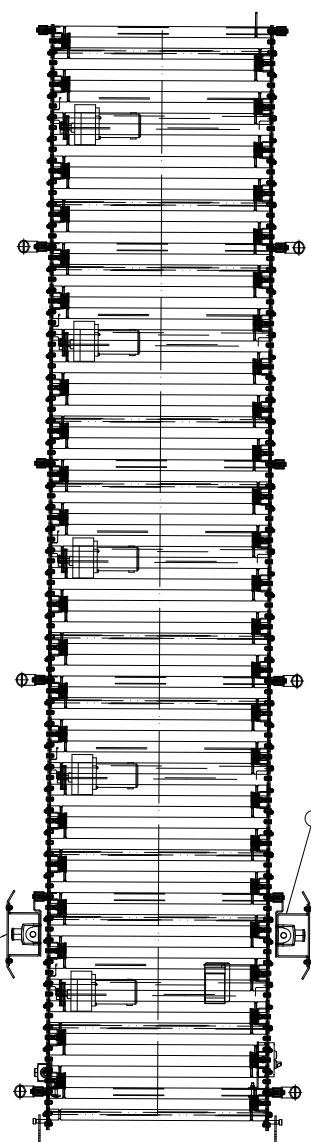
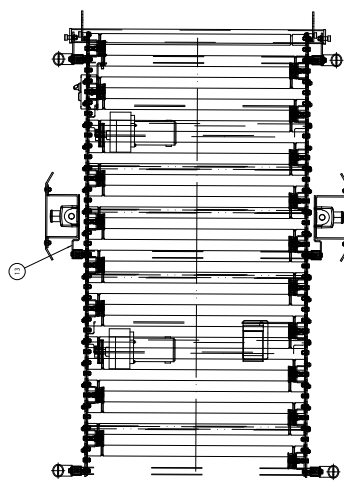
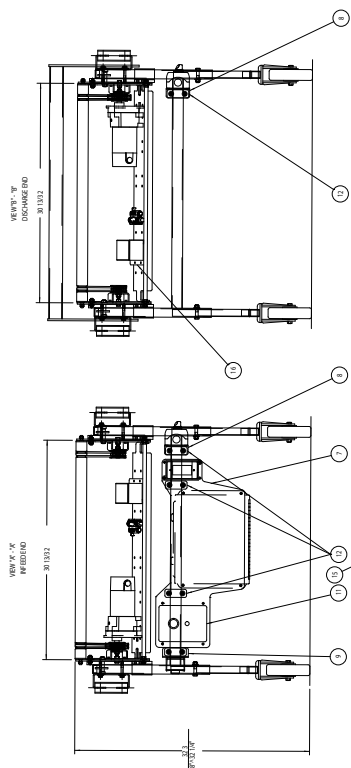


E-STOPS WIRING



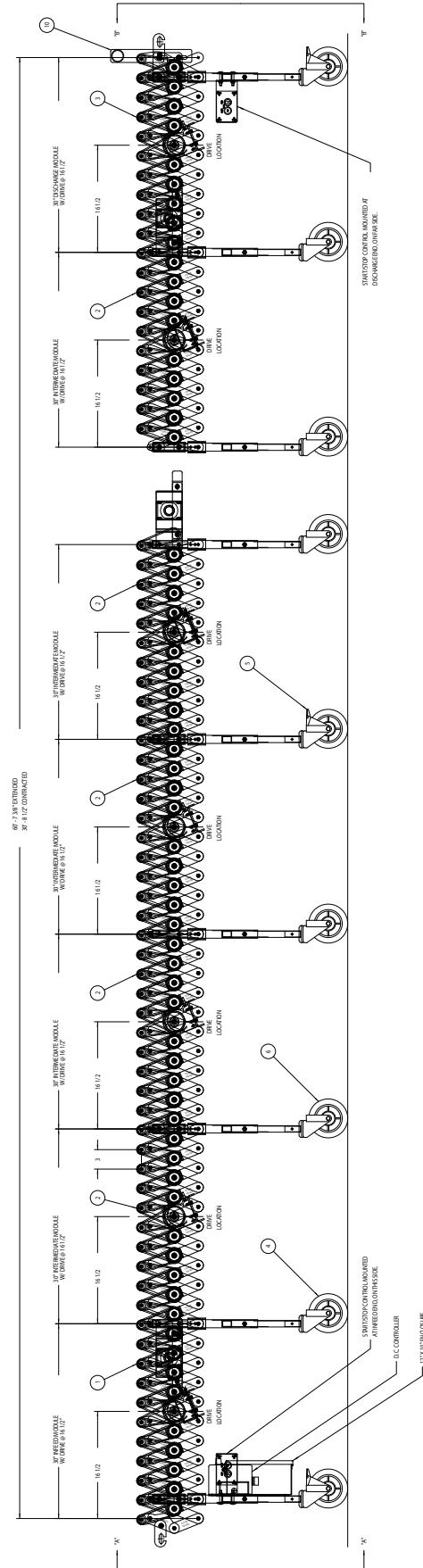
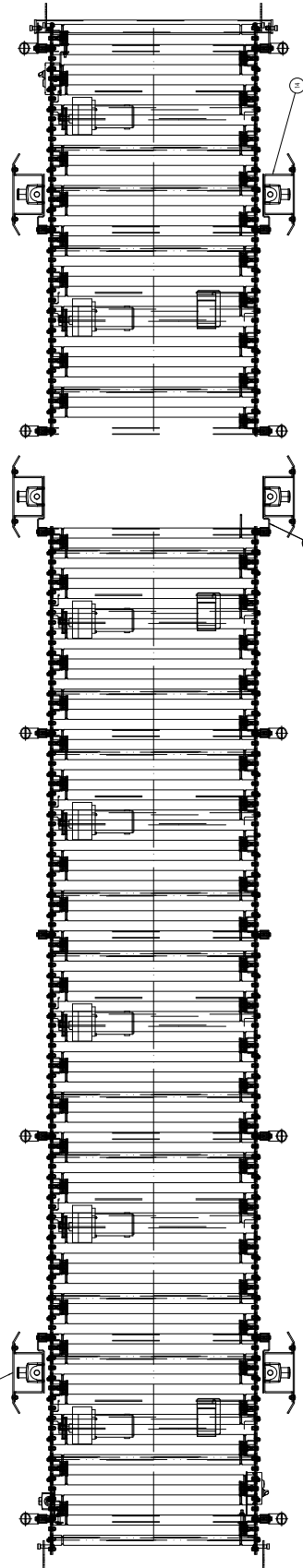
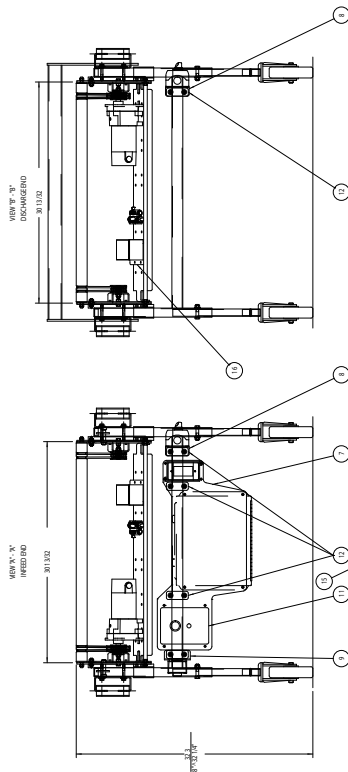
40' POWERED FLEXIBLE CONVEYOR W/ E-STOPS

ITEM	QTY	DESCRIPTION	PART NO.
1	1	30" INFEED MODULE W/ DRIVE @ 16 1/2"	551536-30IFMD16.5
2	13	30" INTERMEDIATE MODULE W/ DRIVE @ 16 1/2"	551536-30IMD16.5
3	1	30" DISCHARGE MOUDLE W/ DRIVE @ 16 1/2"	566912-30DMD16.5
4	8	CASTER SUPPORT ASSEMBLY	566912-S
5	5	CASTER SUPPORT WITH BRAKE ASSEMBLY	566912-BS
6	3	CASTER SUPPORT WITH HANDLE	566912-HS
7	1	POWER FLEXIBLE ENCLOSURE MOUNT	535013-7
8	2	START/STOP MOUNTING BRACKET (2-HOLE)	535013-6
9	1	START/STOP MOUNTING BRACKET (1-HOLE)	535013-2
10	1	RETRACTABLE HANDLE ASSEMBLY	566912-FPRCRH-30
11	1	DC CONTROLLER MOUNT AND COVER ASSEMBLY	568976-13
12	5	CLAMP PLATE	413224-5
	10	5/16" X 2" CARRIAGE BOLT	SFSW423549-01
	10	5/16"-18 FLANGED NUT	FSW09204
13	4	E-STOP MOUNTING BRACKET	531037-29
14	4	E-STOP GUARD	531037-28
15	4	E-STOP GUARD DEFLECTOR	531037-30
	8	5/16"-18 X 3/4" CARRIAGE BOLT	FSW04259
	8	5/16"-18 FLANGED NUT	FSW09204
16	2	GANG BOX MOUNTING PLATE	640776-2



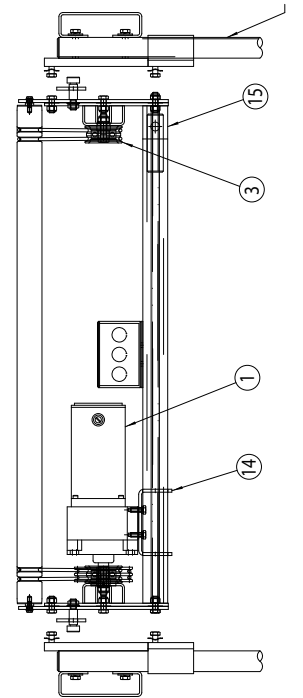
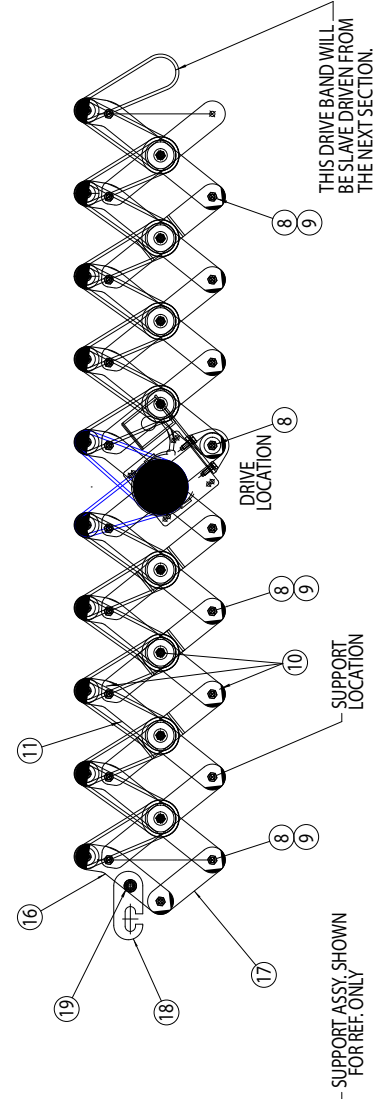
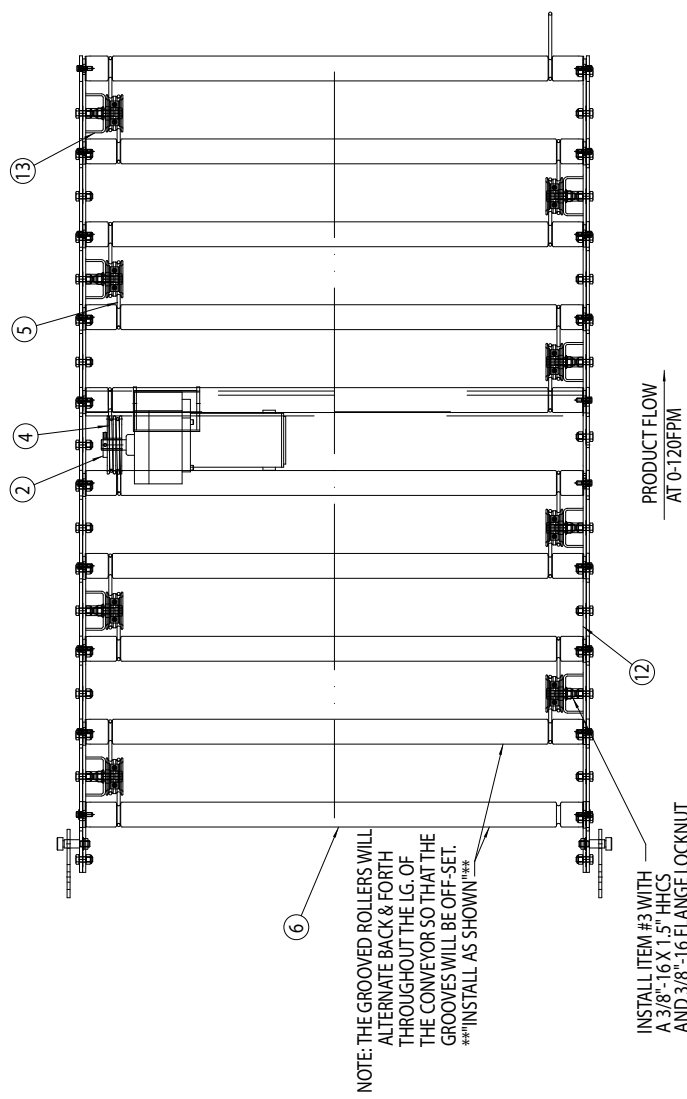
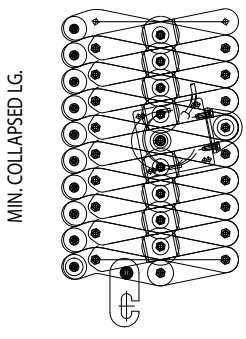
60' POWERED FLEXIBLE CONVEYOR W/ E-STOPS

ITEM	QTY	DESCRIPTION	PART NO.
1	1	30" INFEED MODULE W/ DRIVE @ 16 1/2"	551536-30IFMD16.5
2	20	30" INTERMEDIATE MODULE W/ DRIVE @ 16 1/2"	551536-30IMD16.5
3	1	30" DISCHARGE MODULE W/ DRIVE @ 16 1/2"	566912-30DMD16.5
4	10	CASTER SUPPORT ASSEMBLY	566912-S
5	7	CASTER SUPPORT WITH BRAKE ASSEMBLY	566912-BS
6	6	CASTER SUPPORT WITH HANDLE	566912-HS
7	1	POWER FLEXIBLE ENCLOSURE MOUNT	535013-7
8	2	START/STOP MOUNTING BRACKET (2-HOLE)	535013-6
9	1	START/STOP MOUNTING BRACKET (1-HOLE)	535013-2
10	1	RETRACTABLE HANDLE ASSEMBLY	566912-FPRCRH-30
11	1	DC CONTROLLER MOUNT AND COVER ASSEMBLY	568976-13
12	5	CLAMP PLATE	413224-5
	10	5/16" X 2" CARRIAGE BOLT	SFSW423549-01
	10	5/16"-18 FLANGED NUT	FSW09204
13	6	E-STOP MOUNTING BRACKET	531037-29
14	6	E-STOP GUARD	531037-28
15	6	E-STOP GUARD DEFLECTOR	531037-30
	12	5/16"-18 X 3/4" CARRIAGE BOLT	FSW04259
	12	5/16"-18 FLANGED NUT	FSW09204
16	3	GANG BOX MOUNTING PLATE	640776-2



45" INFEED MODULE WITH DRIVE AT 22-1/2"

WARNING
 When flexible conveyor is being moved, set up or when conveyor is being adjusted by expanding or contracting overall unit length, keep hands, clothing, long hair or other objects clear of conveyor side bars to avoid serious injury.



ITEM	QTY	DESCRIPTION	DWG. NO.	PART NO.
1	1	1/8HP/180VDC GEARMOTOR (RUNNING 125RPM @ 90VDC)	PP	RDW28100
	4	1/4" 20 X 3/4" HHCS	PP	FSW00155
	8	1/4" FLAT WASHER	PP	FSW09105
	4	1/4" LOCK WASHER	PP	FSW09107
2	1	DBL. GROOVE DRIVE SHEAVE	404830-2	404830-2
	2	1/4"-20 X 1/4" SET SCREW	PP	FSW05362-01
3	8	DBL. GROOVED IDLER SHEAVE	PP	SHW76238
	8	3/8"-16 X 1 1/2" HHCS	PP	FSW00359
	8	3/8"-16 NYLON INSERT FLANGE NUT	PP	FSW09304-02
4	3	3/16" X 14.5" BLUE DRIVE BAND	PP	SVB227955-01
5	19	3/16" X 12.5" CLEAR DRIVE BAND	PP	VBW71364
6	10	1.56G GROOVED ROLLER ASSY. (30"BF)	PP	551536-2
7				
8	4	5/16"-18 X 31.3/16" HHCS (30"BF)	PP	FSW00199
9	4	5/16"-18 NYLON INSERT CAPNUT	PP	FSW09203
10	3	1/2" O.D. SPACER TUBE 30" LG.	PP	MCW06134
	48	5/16"-18 X 13/16" HHCS	PP	FSW00253
	48	SPRING WASHER	PP	FSW09306
	48	5/16"-18 NYLON INSERT LOCKNUT	PP	FSW09211
11	18	ROLLER SIDE PLATE	383240-7	383240-7
12	8	I/S SIDE PLATE	383240-8	383240-8
13	8	I/S SIDE PLATE ASSY.	383240-9	383240-9
14	1	DRIVE MOUNT ASSY. (30"BF UNIT)	404830-6	404830-6
15	1	DRIVE PIVOT PLATE ASSY.	404830-9	404830-9
16	2	INFEED ROLLER SIDE PLATE	404830-12	404830-12
17	2	END INSIDE PLATE	383240-15	383240-15
18	2	CONNECTOR HOOK	M09012	M09012
19	2	3/8"-16 X 1/2" X 1 1/2" SHOULDER BOLT	GA-055	GA-055
	2	3/8"-16 NYLON INSERT FLANGE NUT	PP	FSW09351
	2		PP	FSW09304-02

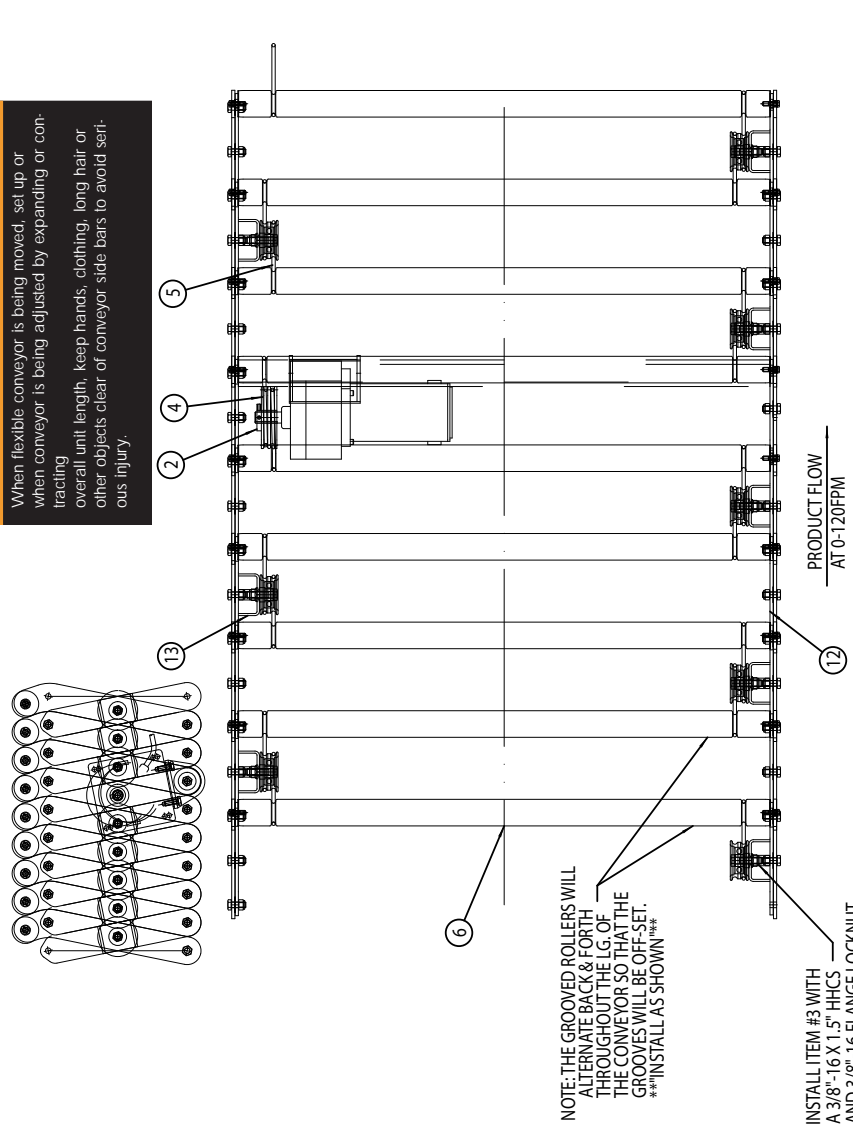
Specify Unit Serial Number ensure proper allocation of components.
 Recommended Spare Parts are shown in red.

NOTE: QTY FOR ITEM #4 INCLUDES (1) EXTRA & QTY FOR ITEM #5 INCLUDES (2) EXTRA.

45" INTERMEDIATE MODULE WITH DRIVE AT 27-1/2"

WARNING
 When flexible conveyor is being moved, set up or when conveyor is being adjusted by expanding or contracting tracing
 overall unit length, keep hands, clothing, long hair or other objects clear of conveyor side bars to avoid serious injury.

MIN. COLLAPSED LG.



NOTE: THE GROOVED ROLLERS WILL ALTERNATE BACK & FORTH THROUGHOUT THE LG. OF THE CONVEYOR SO THAT THE GROOVES WILL BE OFF-SET. ***INSTALL AS SHOWN***

INSTALL ITEM #3 WITH A 3/8"-16 X 1.5" HHCS AND 3/8"-16 FLANGE LOCKNUT

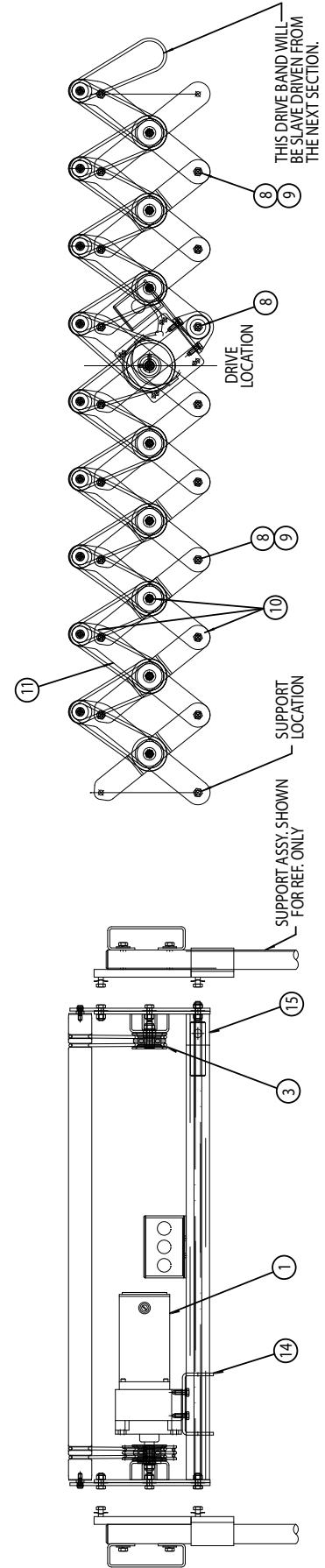
ITEM	QTY	DESCRIPTION	DWG. NO.	PART NO.
1	1	1/8HP/180VDC GEARMOTOR (RUNNING 125RPM @ 90VDC)	PP.	RDW28100
	4	1/4"-20 X 3/4" HHCS	PP.	FSW00155
	8	1/4" FLAT WASHER	PP.	FSW09105
	4	1/4" LOCK WASHER	PP.	FSW09107
2	1	DBL. GROOVE DRIVE SHEAVE	404830-2	404830-2
	2	1/4"-20 X 1/4" SET SCREW	PP.	FSW05362-01
3	8	DBL. GROOVED IDLER SHEAVE	PP.	SHW76238
	8	3/8"-16 X 1 1/2" HHCS	PP.	FSW00359
	8	3/8"-16 NYLON INSERT FLANGE NUT	PP.	FSW09304-02
4	3	3/16" X 14.5" BLUE DRIVE BAND	PP.	SVBW227955-0
5	18	3/16" X 12.5" CLEAR DRIVE BAND	PP.	VBW71364
6	9	156G GROOVED ROLLER ASSY. (30"BF)	PP.	551536-2
7				
8	3	5/16"-18 X 3/16" HHCS (30"BF)	PP.	FSW00199
	3	5/16"-18 NYLON INSERT CAPNUT	PP.	FSW09203
9	2	1/2" O.D. SPACER TUBE 30" LG.	PP.	MCW06134
10	46	5/16"-18 X 13/16" HHCS	PP.	FSW00253
	46	SPRING WASHER	PP.	FSW09306
	46	5/16"-18 NYLON INSERT LOCKNUT	PP.	FSW09211
11	18	ROLLER SIDE PLATE	383240-7	383240-7
12	8	I/S SIDE PLATE	383240-8	383240-8
13	8	I/S SIDE PLATE ASSY.	383240-9	383240-9
14	1	DRIVE MOUNT ASSY. (30"BF UNIT)	404830-6	404830-6
15	1	DRIVE PIVOT PLATE ASSY.	404830-9	404830-9

Specify Unit: Serial Number ensure proper allocation of components.

Recommended Spare Parts are shown in red.

NOTE: QTY FOR ITEM #4 INCLUDES (1) EXTRA & QTY FOR ITEM #5 INCLUDES (2) EXTRA.

"INFEED END VIEW"



THIS DRIVE BAND WILL BE SLAVE DRIVEN FROM THE NEXT SECTION.

SUPPORT ASSY. SHOWN FOR REF. ONLY

40" INTERMEDIATE MODULE WITH DRIVE AT 22-1/2"

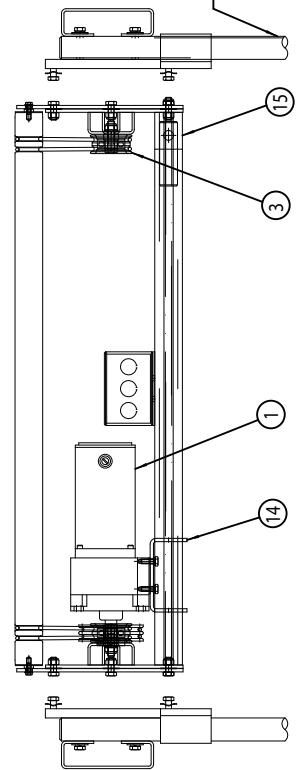
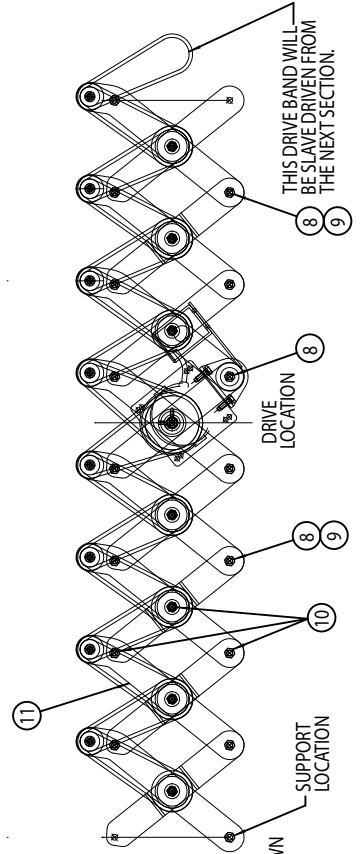
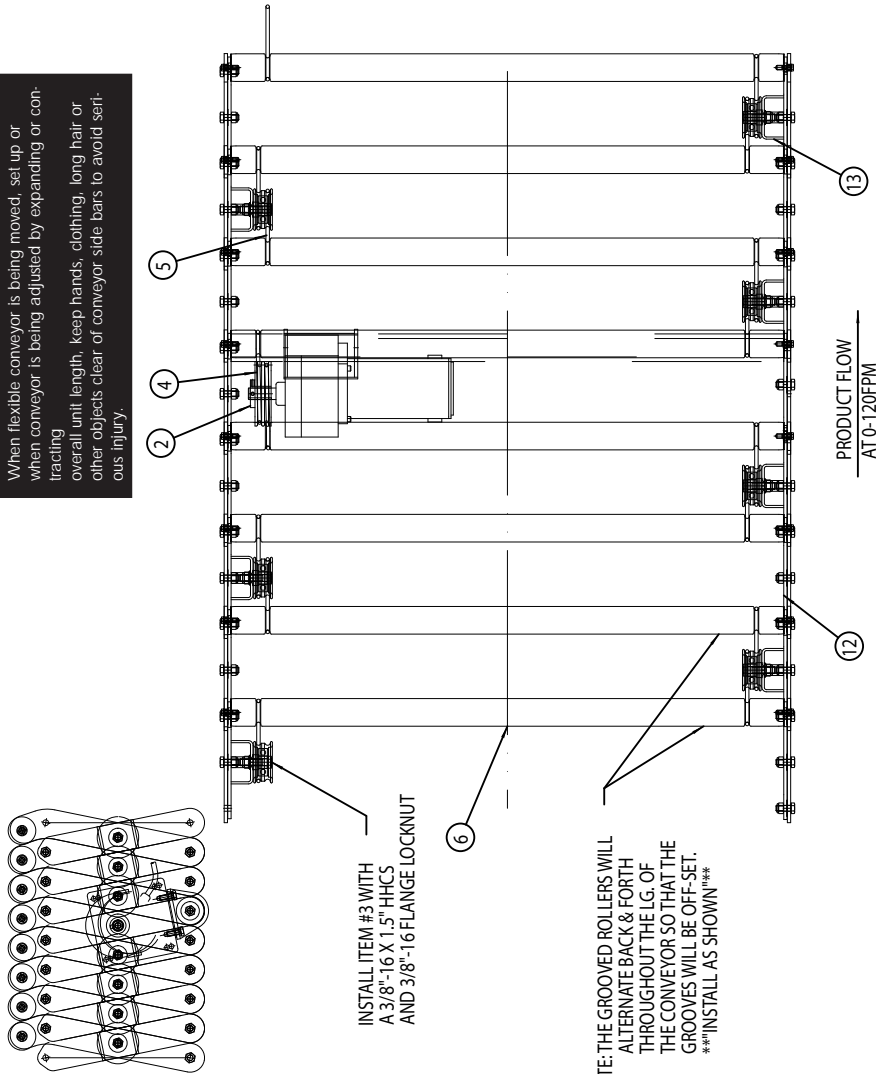
WARNING
 When flexible conveyor is being moved, set up or when conveyor is being adjusted by expanding or contracting tracing overall unit length, keep hands, clothing, long hair or other objects clear of conveyor side bars to avoid serious injury.

ITEM	QTY	DESCRIPTION	DWG. NO.	PART NO.
1	1	1/8HP/180VDC GEARMOTOR (RUNNING 125RPM @ 90VDC)	PP.	RDW28100
4	4	1/4"-20 X 3/4" HHCS	PP.	FSW00155
8	8	1/4" FLAT WASHER	PP.	FSW09105
4	4	1/4" LOCK WASHER	PP.	FSW09107
2	1	DBL. GROOVE DRIVE SHEAVE	404830-2	404830-2
1	2	1/4"-20 X 1/4" SET SCREW	PP.	FSW05362-01
7	2	DBL. GROOVED IDLER SHEAVE	PP.	SHW76238
7	7	3/8"-16 X 1 1/2" HHCS	PP.	FSW00359
7	7	3/8"-16 NYLON INSERT FLANGE NUT	PP.	FSW09304-02
4	3	3/16" X 14.5" BLUE DRIVE BAND	PP.	SVBW227955-01
5	16	3/16" X 12.5" CLEAR DRIVE BAND	PP.	VBW71364
6	8	156G GROOVED ROLLER ASSY. (30"BF)	PP.	551536-2
7				
8	3	5/16"-18 X 31 3/16" HHCS (30"BF)	PP.	FSW00199
9	3	5/16"-18 NYLON INSERT CAPNUT	PP.	FSW09203
10	2	1/2" O.D. SPACER TUBE 30" LG.	PP.	MCW06134
40	40	5/16"-18 X 13/16" HHCS	PP.	FSW00253
40	40	SPRING WASHER	PP.	FSW09306
40	40	5/16"-18 NYLON INSERT LOCKNUT	PP.	FSW09211
11	16	ROLLER SIDE PLATE	383240-7	383240-7
12	7	I/S SIDE PLATE	383240-8	383240-8
13	7	I/S SIDE PLATE ASSY.	383240-9	383240-9
14	1	DRIVE MOUNT ASSY. (30"BF UNIT)	404830-6	404830-6
15	1	DRIVE PIVOT PLATE ASSY.	404830-9	404830-9

Specify Unit Serial Number ensure proper allocation of components.

Recommended Spare Parts are shown in red.

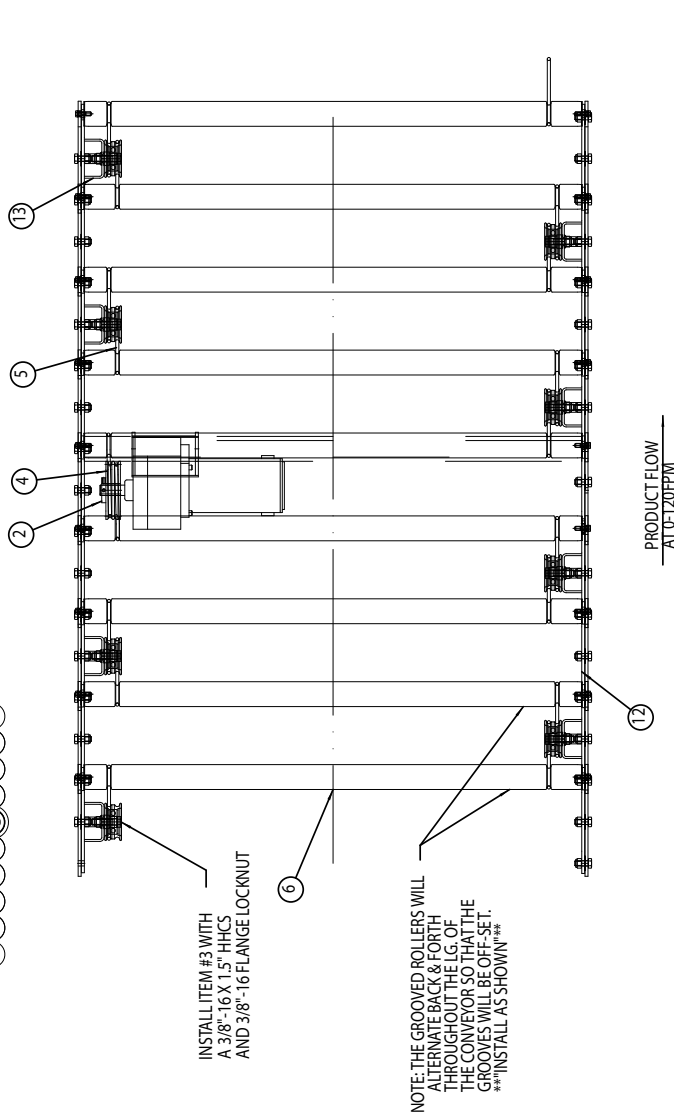
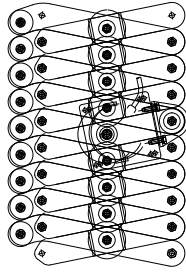
NOTE: QTY FOR ITEM #4 INCLUDES (1) EXTRA & QTY FOR ITEM #5 INCLUDES (2) EXTRA.



45" INTERMEDIATE MODULE WITH DRIVE AT 22-1/2"

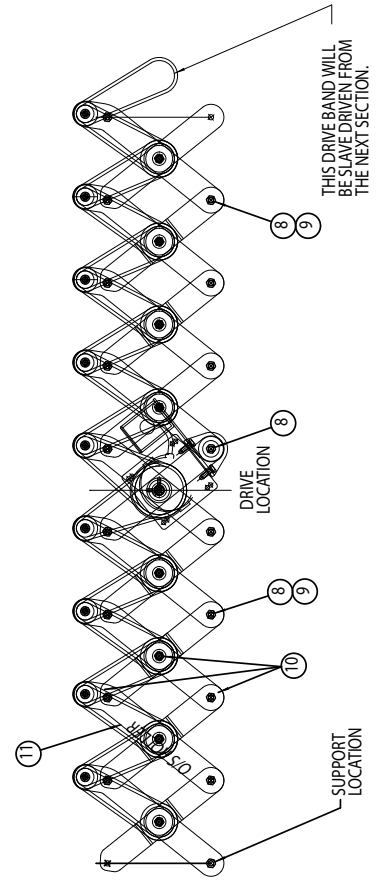
WARNING
 When flexible conveyor is being moved, set up or when conveyor is being adjusted by expanding or contracting overall unit length, keep hands, clothing, long hair or other objects clear of conveyor side bars to avoid serious injury.

MIN. COLLAPSED LG.



INSTALL ITEM #3 WITH A 3/8"-16 X 1.5" HHCS AND 3/8"-16 FLANGE LOCKNUT

NOTE: THE GROOVED ROLLERS WILL ALTERNATE BACK & FORTH THROUGHOUT THE LG. OF THE CONVEYOR SO THAT THE GROOVES WILL BE OFF-SET. ***INSTALL AS SHOWN***



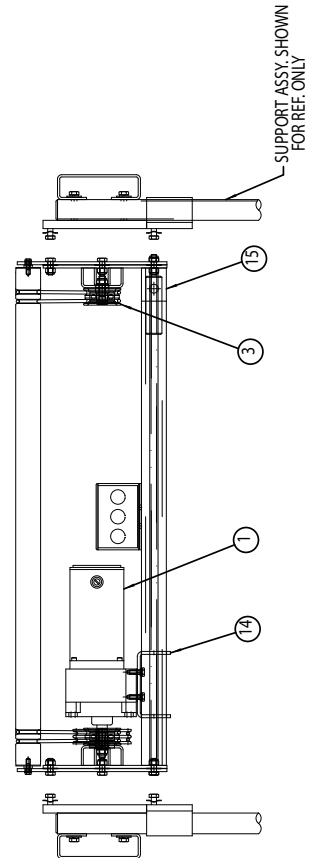
ITEM	QTY	DESCRIPTION	DWG. NO.	PART NO.
1	1	1/8HP/180VDC GEARMOTOR (RUNNING 125RPM @ 90VDC)	PP.	RDW28100
	4	1/4"-20 X 3/4" HHCS	PP.	FSW00155
	8	1/4" FLAT WASHER	PP.	FSW09105
	4	1/4" LOCK WASHER	PP.	FSW09107
2	1	DBL GROOVE DRIVE SHEAVE	404830-2	404830-2
	2	1/4"-20 X 1/4" SET SCREW	PP.	FSW05362-01
3	8	DBL GROOVED IDLER SHEAVE	SHW76238	SHW76238
	8	3/8"-16 X 1 1/2" HHCS	PP.	FSW00359
	8	3/8"-16 NYLON INSERT FLANGE NUT	PP.	FSW09304-02
4	3	3/16" X 14.5" BLUE DRIVE BAND	PP.	SVBW227955-01
5	18	3/16" X 12.5" CLEAR DRIVE BAND	PP.	VBW71364
6	9	156G GROOVED ROLLER ASSY. (30"BF)	551536-2	551536-2
7				
8	3	5/16"-18 X 31.3/16" HHCS (30"BF)	PP.	FSW00199
9	3	5/16"-18 NYLON INSERT CAPNUT	PP.	FSW09203
10	2	1/2" O.D. SPACER TUBE 30" LG.	PP.	MCW06134
10	46	5/16"-18 X 13/16" HHCS	PP.	FSW00253
10	46	SPRING WASHER	PP.	FSW09306
10	46	5/16"-18 NYLON INSERT LOCKNUT	PP.	FSW09211
11	18	ROLLER SIDE PLATE	383240-7	383240-7
12	8	I/S SIDE PLATE	383240-8	383240-8
13	8	I/S SIDE PLATE ASSY	383240-9	383240-9
14	1	DRIVE MOUNT ASSY. (30"BF UNIT)	404830-6	404830-6
15	1	DRIVE PIVOT PLATE ASSY.	404830-9	404830-9

Specify Unit Serial Number ensure proper allocation of components.

Recommended Spare Parts are shown in red.

NOTE: QTY FOR ITEM #4 INCLUDES (1) EXTRA & QTY FOR ITEM #5 INCLUDES (2) EXTRA.

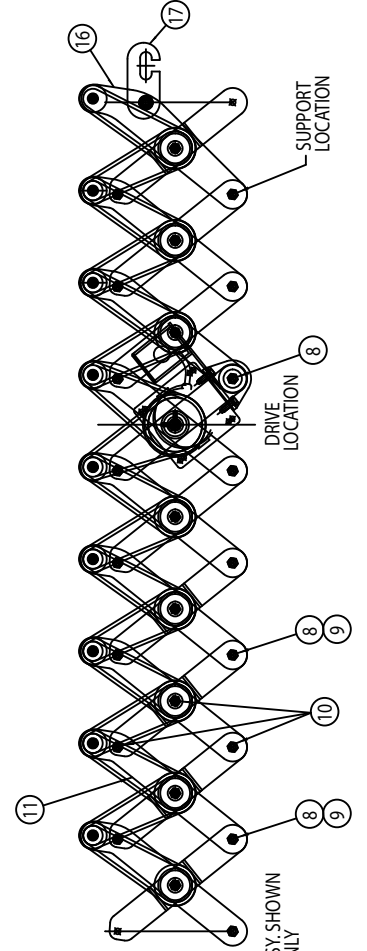
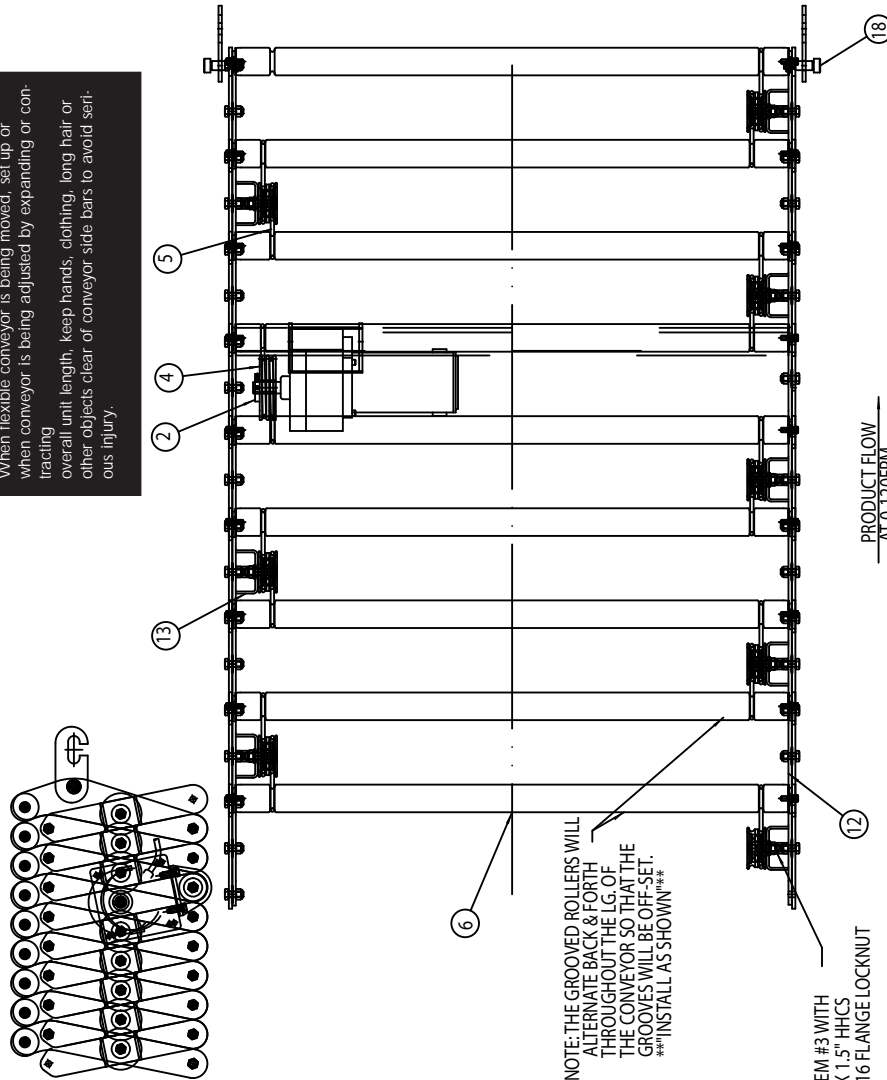
"INFEED END VIEW"



40" DISCHARGE MODULE WITH DRIVE AT 27-1/2"

WARNING
 When flexible conveyor is being moved, set up or tracing
 when conveyor is being adjusted by expanding or contracting overall unit length, keep hands, clothing, long hair or other objects clear of conveyor side bars to avoid serious injury.

MIN. COLLAPSED LG.



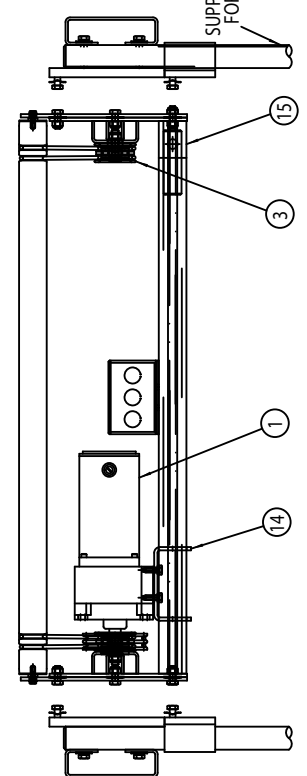
ITEM	QTY	DESCRIPTION	DWG. NO.	PART NO.
1	1	1/8HP/180VDC GEAR MOTOR (RUNNING 125RPM @ 90VDC)	P.P.	RDW28100
4	4	1/4"-20 X 3/4" HHCS	P.P.	FSW00155
8	8	1/4" FLAT WASHER	P.P.	FSW09105
4	4	1/4" LOCK WASHER	P.P.	FSW09107
2	1	DBL GROOVE DRIVE SHEAVE	404830-2	404830-2
1	2	1/4"-20 X 1/4" SET SCREW	FSW05362-01	FSW05362-01
3	8	DBL GROOVED IDLER SHEAVE	SHW76238	SHW76238
8	8	3/8"-16 X 1 1/2" HHCS	FSW00359	FSW00359
8	8	3/8"-16 NYLON INSERT FLANGE NUT	FSW09304-02	FSW09304-02
4	3	3/16" X 14.5" BLUE DRIVE BAND	SVBW227955-01	SVBW227955-01
5	17	3/16" X 12.5" CLEAR DRIVE BAND	VBW71364	VBW71364
6	9	156G GROOVED ROLLER ASSY. (30"BF)	551536-2	551536-2
7				
8	3	5/16"-18 X 31.3/16" HHCS (30"BF)	FSW00199	FSW00199
3	3	5/16"-18 NYLON INSERT CAPNUT	FSW09203	FSW09203
2	2	1/2" O.D. SPACER TUBE 30" LG.	MCW06134	MCW06134
42	42	5/16"-18 X 13/16" HHCS	FSW00253	FSW00253
42	42	SPRING WASHER	FSW09306	FSW09306
42	42	5/16"-18 NYLON INSERT LOCKNUT	FSW09211	FSW09211
11	18	ROLLER SIDE PLATE	383240-7	383240-7
12	8	I/S SIDE PLATE	383240-8	383240-8
13	8	I/S SIDE PLATE ASSY.	383240-9	383240-9
14	1	DRIVE MOUNT ASSY. (30"BF UNIT)	404830-6	404830-6
15	1	DRIVE PIVOT PLATE ASSY.	404830-9	404830-9
16	2	DISCH. ROLLER SIDE PLATE	404830-13	404830-13
17	2	CONNECTOR HOOK	M09012	M09012
18	2	3/8"-16 X 1/2" X 1 1/2" SHOULDER BOLT	GA-055	GA-055
2	2	3/8"-16 NYLON INSERT FLANGE NUT	FSW09351	FSW09351
2	2		FSW09304-02	FSW09304-02

Specify Unit Serial Number ensure proper allocation of components.

Recommended Spare Parts are shown in red.

NOTE: QTY FOR ITEM #4 INCLUDES (1) EXTRA & QTY FOR ITEM #5 INCLUDES (2) EXTRA.

"INFEED END VIEW"





ROACH CONVEYORS

WARRANTY

- 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.

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

Roach Conveyors
808 Highway 463 North
Trumann, AR 72472-1310