

INSTALLATION AND MAINTENANCE MANUAL

BELT DRIVEN LIVE ROLLER CONVEYOR



**DO NOT OPERATE
EQUIPMENT
BEFORE READING**

ATLANTIS
TECHNOLOGIES LLC

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INTRODUCTION

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

RECEIVING, INSPECTION AND UNCRATING

- 1) Compare the bill of lading with what you have received.
- 2) Examine the equipment for damage during shipping.
- 3) Immediately report shortage or damages to the carrier.
- 4) Move all crates to area of installation.
- 5) Remove crating and packaging.
- 6) Look for boxes, accessories, bags or components such as fasteners, manuals, guard rails, etc. that may be banded or fastened to the crating material to ensure you do not discard any loose parts (Guards, Fasteners or other components) that were packaged for loose shipping.

ORDERING REPLACEMENT PARTS

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

Procedure for ordering replacement parts:

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

SAFETY INFORMATION - INSTALLATION

GUARDS AND GUARDING

Interfacing of Equipment

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

Guarding Exceptions

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

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

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

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

HEADROOM CLEARANCE

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

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

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

SAFETY INFORMATION - OPERATION

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

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

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

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

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

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

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

SAFETY INFORMATION - OPERATION (Continued)

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

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

SAFETY INFORMATION - MAINTENANCE

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

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

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

ADJUSTMENTS OR MAINTENANCE/SERVICE DURING OPERATION

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

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

GUARDS AND SAFETY DEVICES

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

LUBRICATION

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

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

SAFETY INFORMATION - ELECTRICAL

ELECTRICAL CODE

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

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

CONTROL STATIONS

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

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

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

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

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

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

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

SAFETY DEVICES

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

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

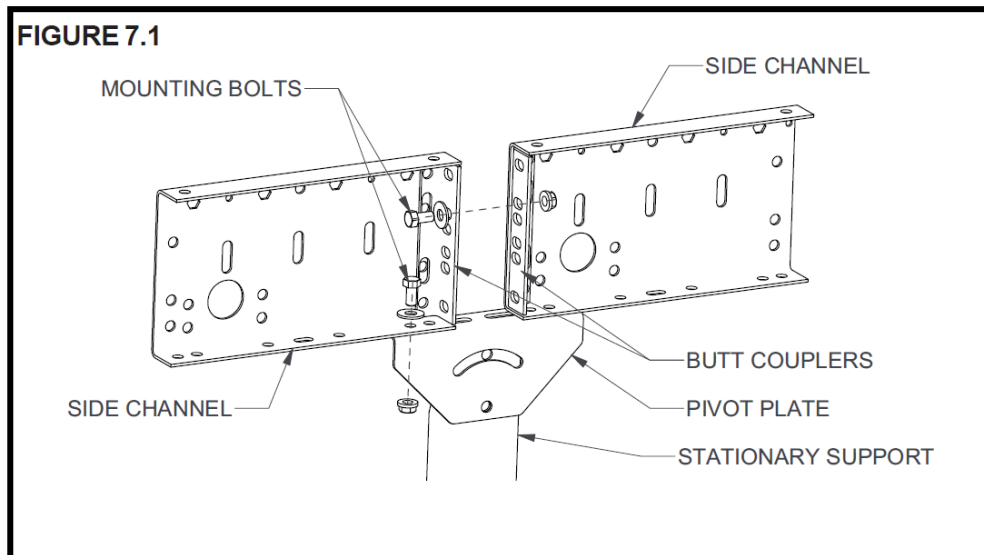
Before restarting a conveyor that has been stopped because of an emergency, an inspection of the conveyor should be made and the cause of the stoppage determined. The starting device and electrical power must be turned off and locked / tagged out according to your company's machine specific procedure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

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

INSTALLATION

FLOOR SUPPORT INSTALLATION

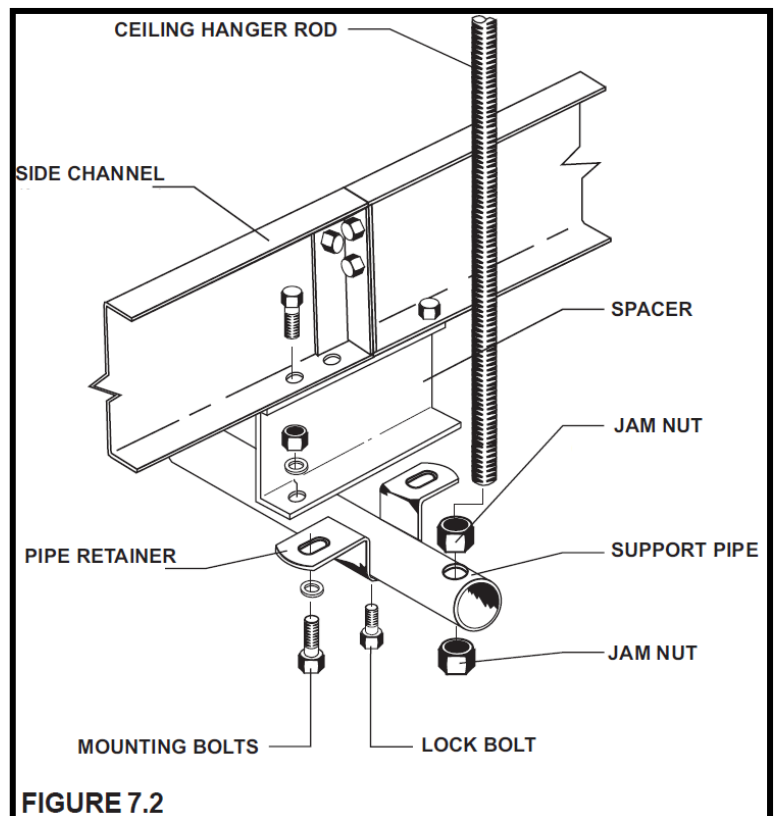
Floor supports are typically mounted at Drive, Tail and across splice locations. Fasten leg supports to conveyor sections with the provided fasteners as shown (Figure 7.1).



CEILING HANGERS INSTALLATION

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

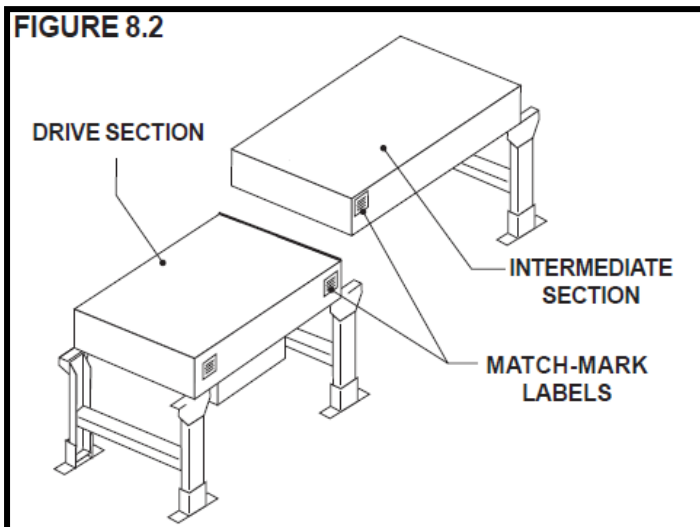
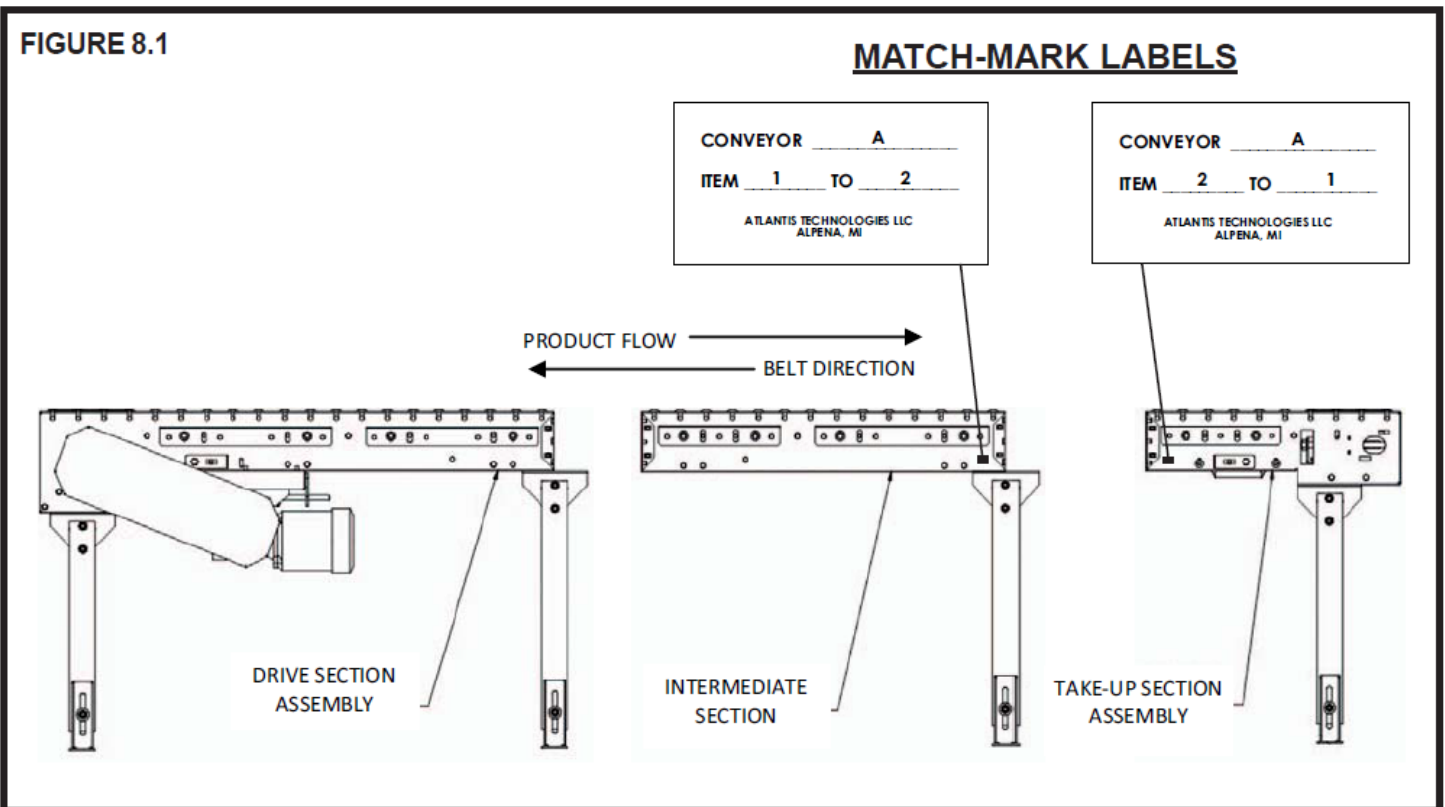
NOTE: When installing ceiling hangers, refer to local building codes to ensure that materials comply. Only experienced material handling installers should attempt to install conveyors.



INSTALLATION

CONVEYOR SET-UP

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

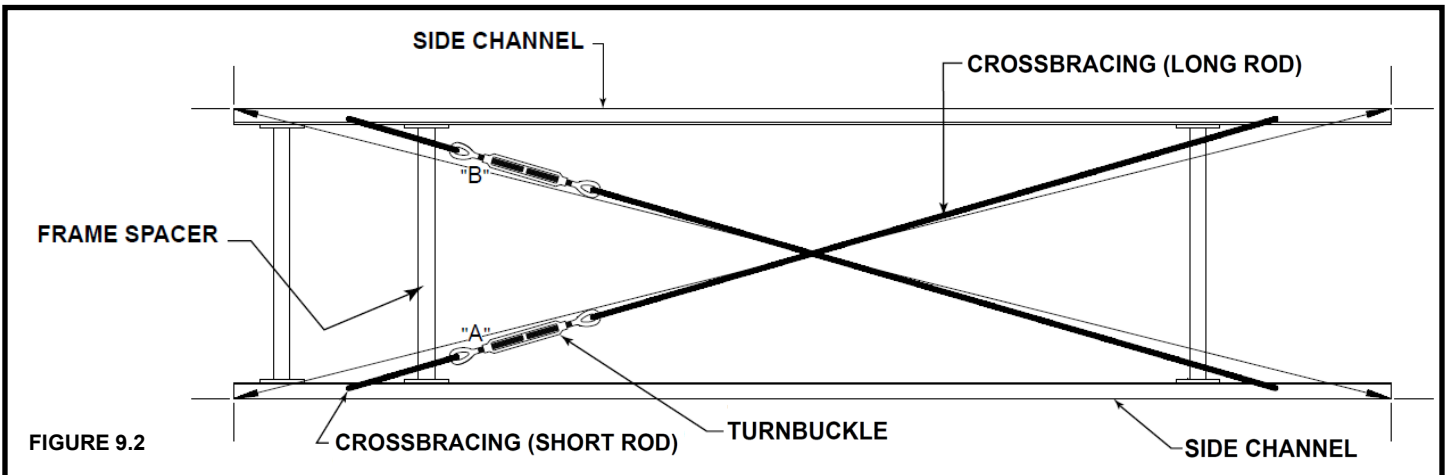
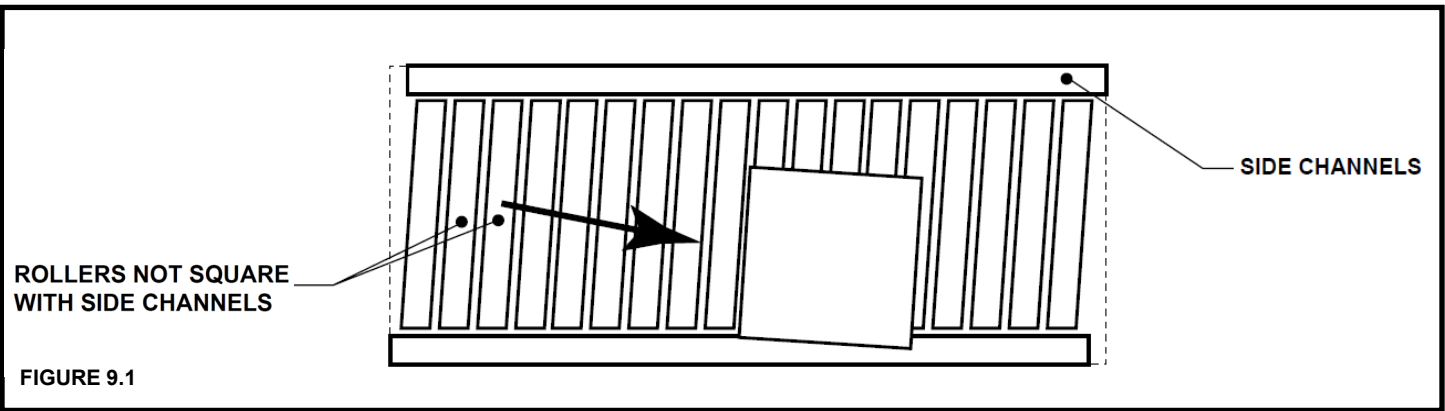


INSTALLATION

RACKED SECTIONS

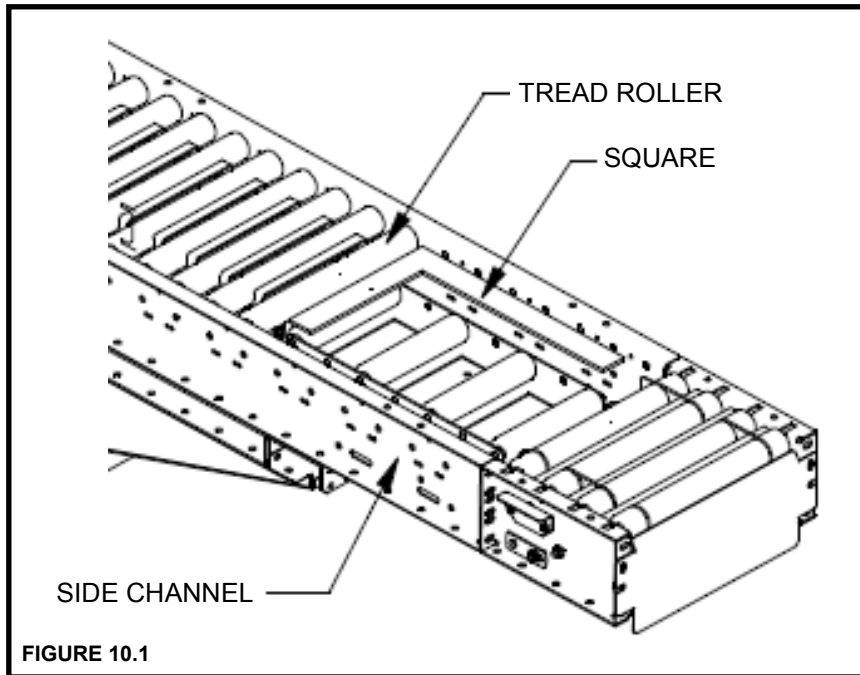
Important: Bed sections on the conveyor should be checked for a “racked” or un-squared position. Problems with tracking will occur if the conveyor is not square. Turnbuckles are supplied on conveyors 30’ or longer.

- 1) Measure diagonally from corner at one end to opposite corner on the other end. Repeat for other corner. The section will not be square if these dimensions are not equal. (See dimensions A & B in figure 9.2)
- 2) On the underside of the conveyor, where diagonal dimension was the longest, use the supplied cross-bracing to pull section in to square. Adjust the turnbuckle until both dimensions are equal.
- 3) Tighten all pivot plate bolts and butt couplings after bed sections have been checked and corrected for “racked condition”.
- 4) Make a final check to verify that all conveyor sections are level across width and length. Supports can be lagged to the floor once the entire conveyor is level.



TRACKING THE PACKAGE

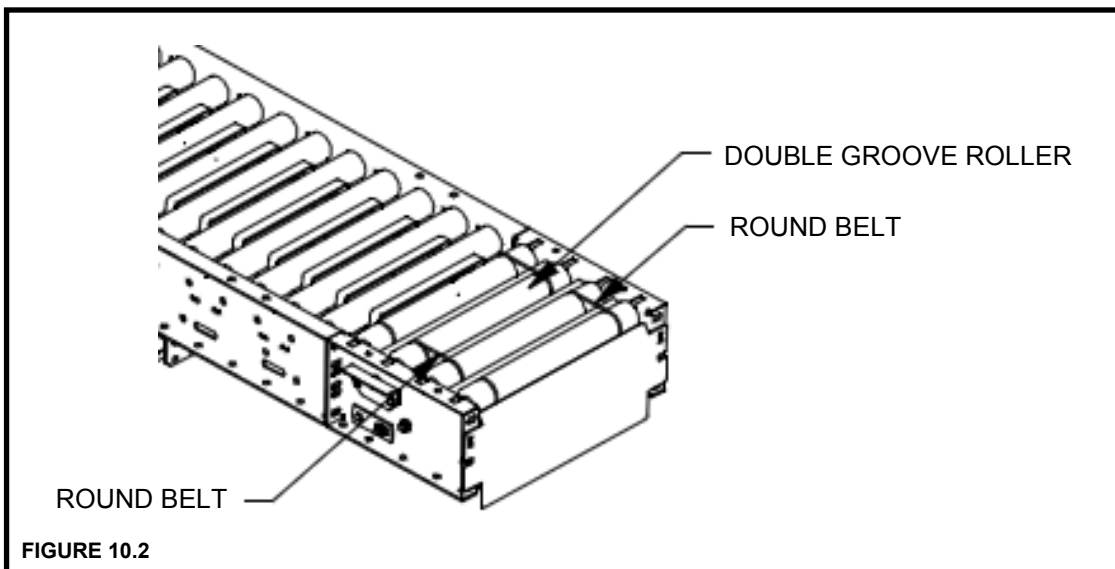
Unsquare Tread Roller can make a package track improperly. Ensure the Tread Rollers are square with the conveyor side frames. If the Tread Rollers are not square, reference the Racked Section installation on page 9.



TREAD ROLLER INSTALLATION

BDLR Conveyors have “pop-out” tread rollers that are removed before installation.

- 1) Re-install tread rollers after belt has been installed and tracked properly
- 2) All of the rollers are slide into the slots on the frame, except the 3 rollers at either end
- 3) “O” rings drive the end rollers, the center roller has two grooves and the others only have one. (See Figure 10.2.)



INSTALLATION

PRESSURE ADJUSTMENT

BDLR Conveyor utilize pressure rollers in order to force the belt into contact with the tread rollers. Slots in the frames allow the sheaves to be adjusted up and down to apply the correct amount of pressure to the tread rollers. Take-up sheaves are located near the double-groove sheave.

The belt must be properly tensioned to ensure the correct amount of drive pressure. A belt tensioned too much can cause the conveyor to stall out. Likewise, a belt not tensioned enough may be unable to drive the tread rollers.

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

TRANSPORATION:

Adjust belt pressure to tread rollers by raising pressure rollers. Loosen bolts in the pressure roller brackets. Raise brackets on both sides of conveyor until belt pressure to tread rollers is sufficient to drive largest product. Keep brackets equal and level from side to side. Retighten bolts. Note: Excess pressure is unnecessary and will cause premature belt and frame wear.

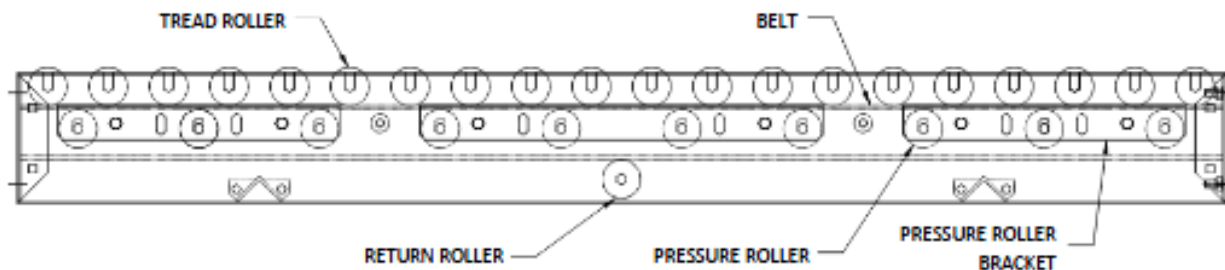


FIGURE 11.1

MINIMUM PRESSURE:

While the conveyor is running, reduce pressure on all tread rollers by loosening the knurled finger nuts until there is no belt pressure driving the tread rollers. Place the heaviest product to be conveyed on the infeed end of conveyor. Increase pressure by tightening knurled finger nuts until belt pressure to tread rollers is sufficient to drive product. Keep brackets equal and level from side to side. Continue process until product has traveled the entire length of conveyor. Note: Excess pressure is unnecessary and will cause premature belt and frame wear.

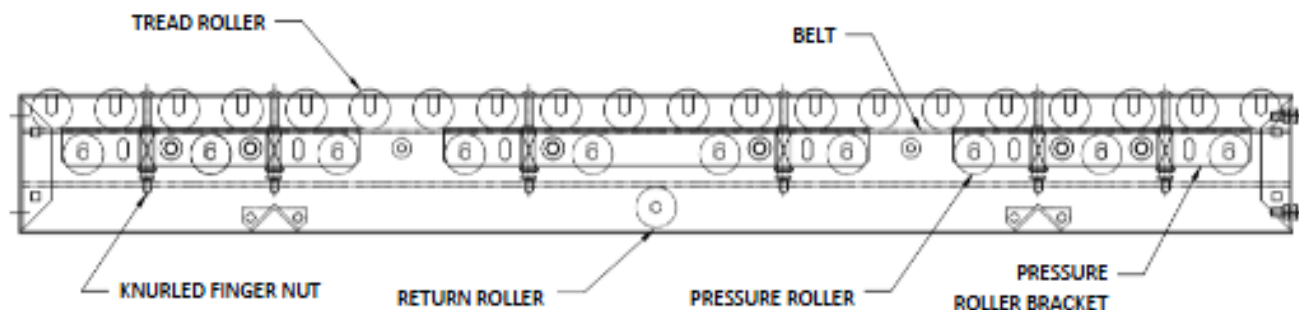


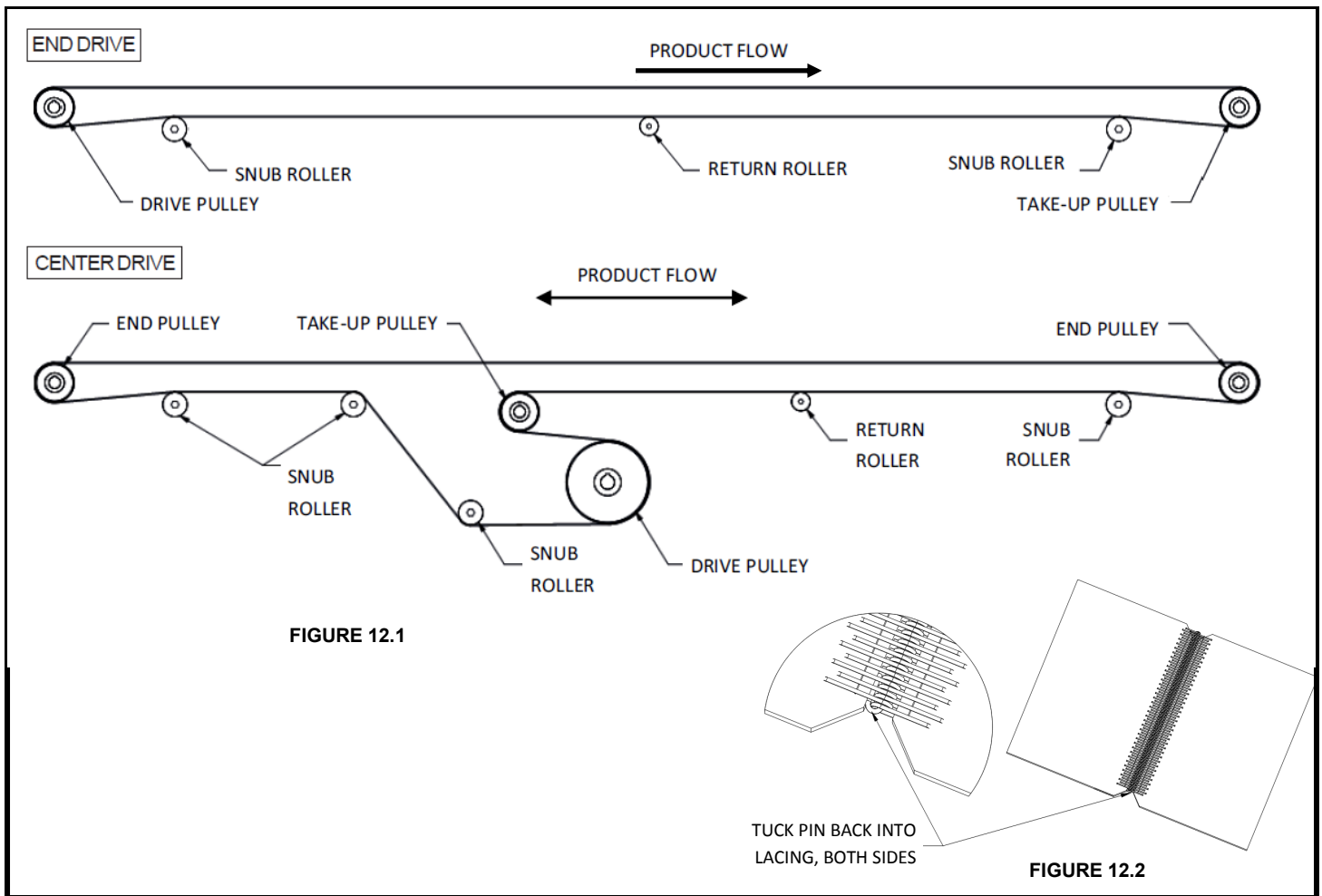
FIGURE 11.2

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 12.1. Bring laced ends together and thread lacing pin through loops as shown in Figure 12.2.
- 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

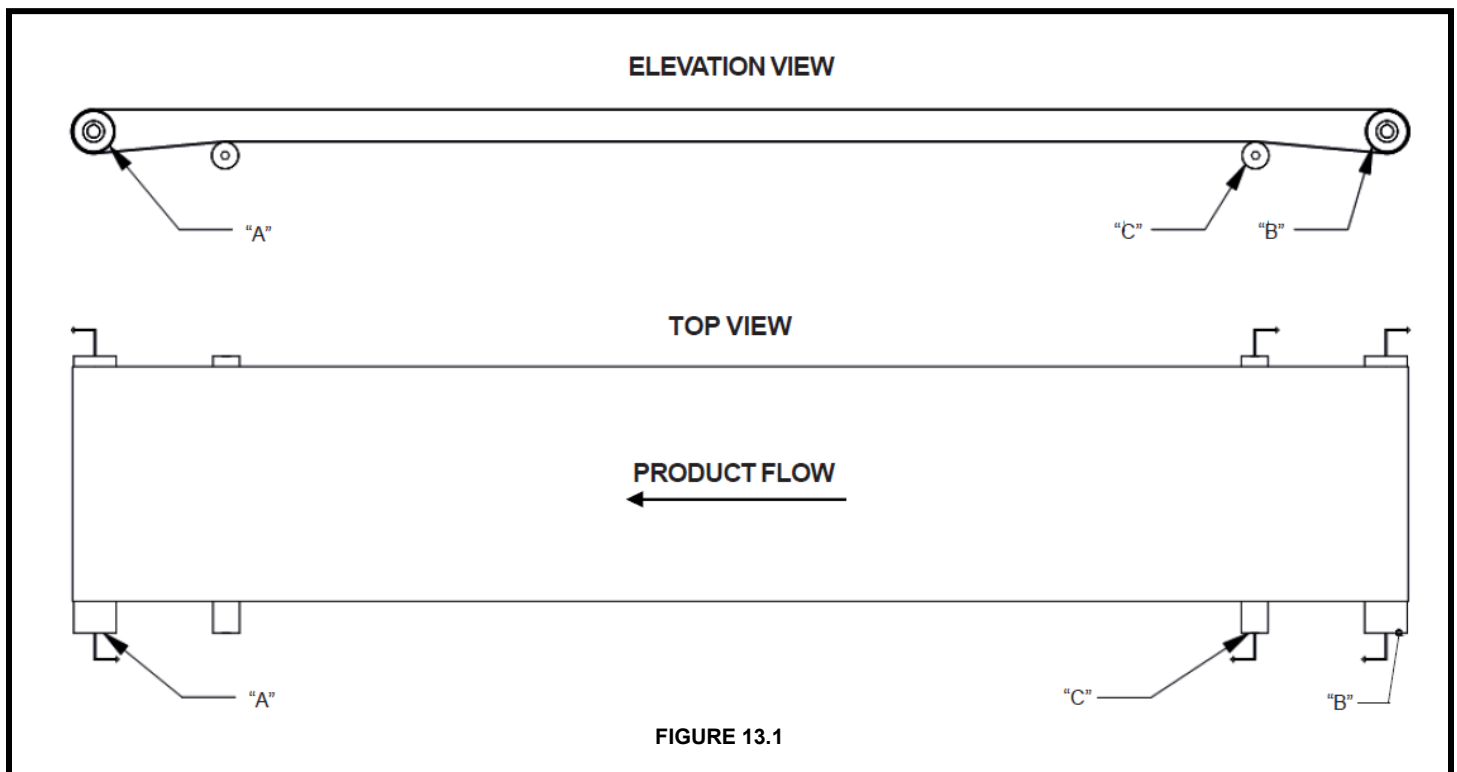
The belt is tracked by adjusting snub rollers, return rollers, tail pulley and drive pulley. The initial goal is to center the belt on pulley at infeed end of conveyor, then move to discharge end if needed. All adjustments should be made in small increments (1/16 in. at a time). Allow adequate time for 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

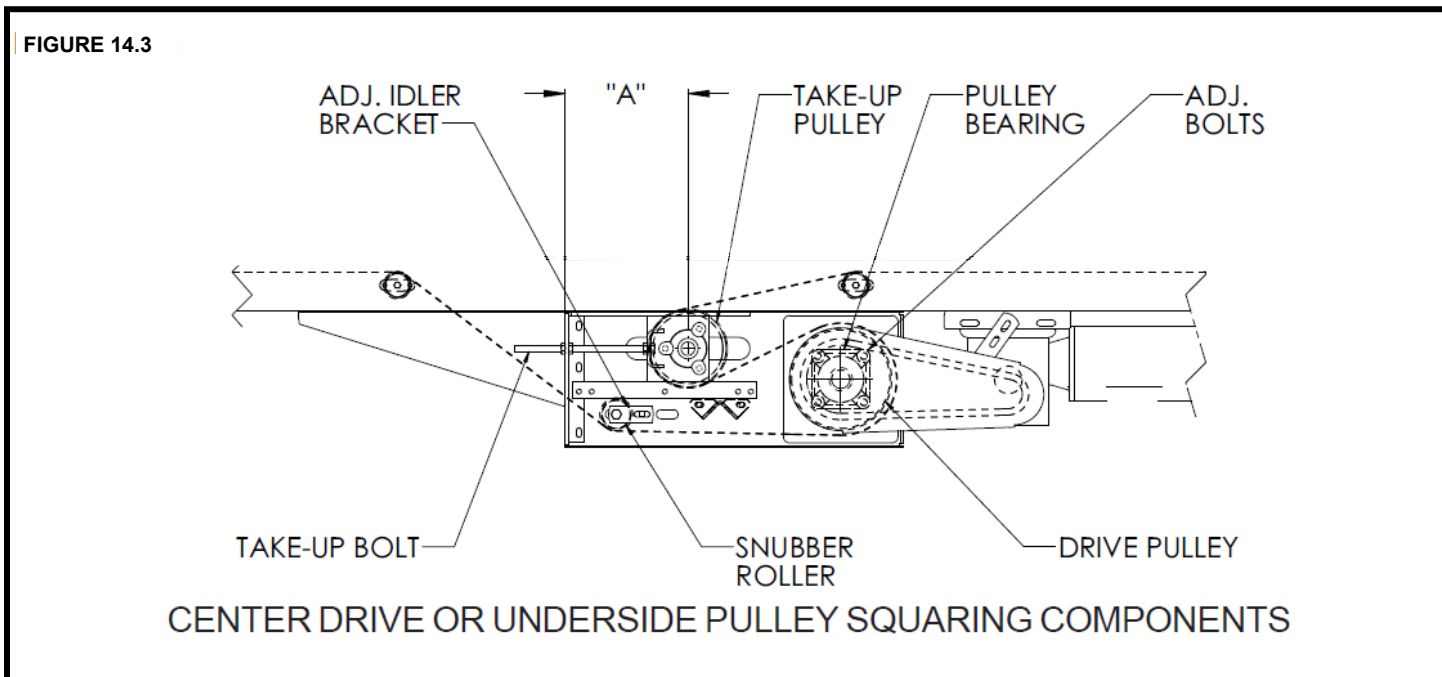
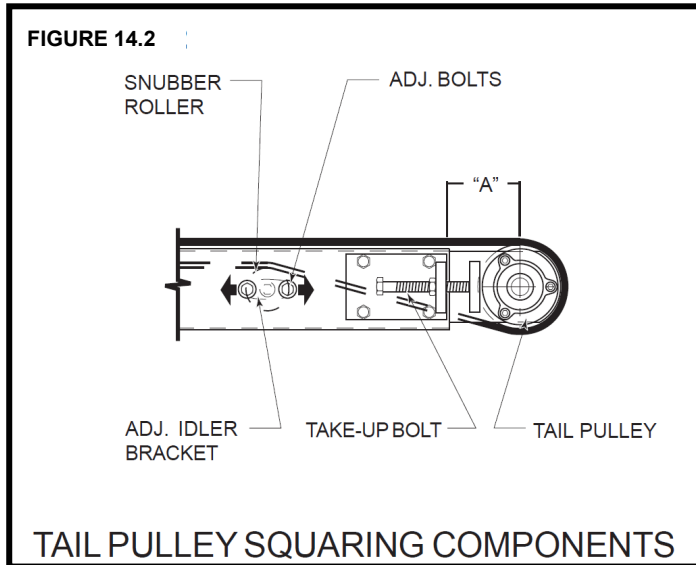
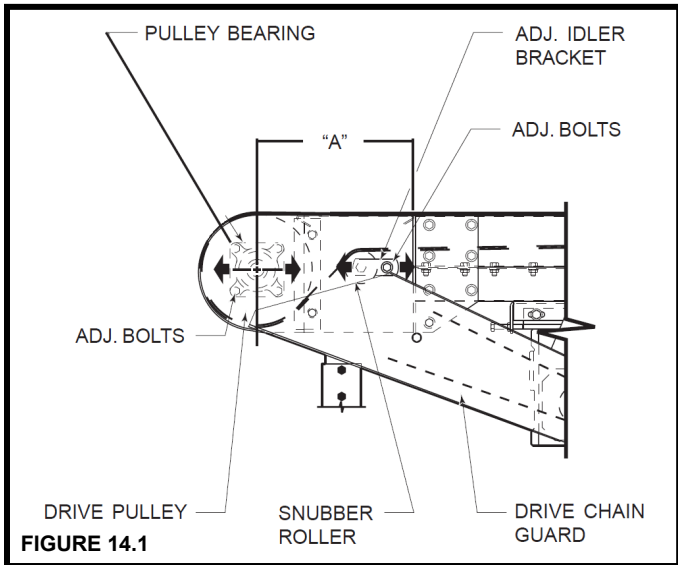
- 1) Make sure conveyor frame is cross square.
- 2) Confirm that conveyor is level across its width and length.
- 3) Make sure snubber rollers, return rollers, tail pulley and drive pulley are square with the frame.
Reference dimension "A" in figures 14.1, 14.2 and 14.3.
- 4) Confirm belt has been properly 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 13.1.
- 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"



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 13.1)

Drive Chain Tension Adjustment Procedure (See Figure 13.1)

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

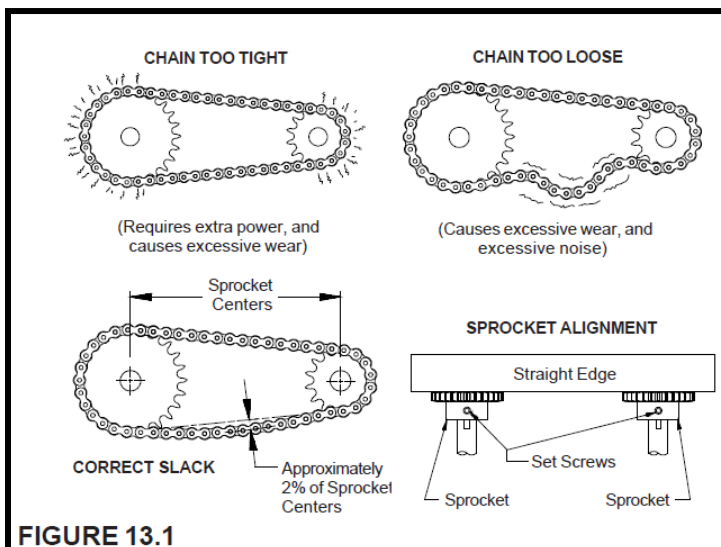


FIGURE 13.1

MAINTENANCE

DAILY MAINTENANCE

- Inspect all conveyors to ensure that all guarding is securely in place.
- Inspect belt tracking for at least (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 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 reducer for leaking seals.
- Inspect oil level in reducer. Fill to proper level if necessary.
- Inspect drive chains, jump chains and sprockets for wear, alignment and proper chain tension.

QUARTERLY MAINTENANCE

- Grease all pulley shaft bearings.
- Inspect all bearing set screws to ensure they are completely tightened.

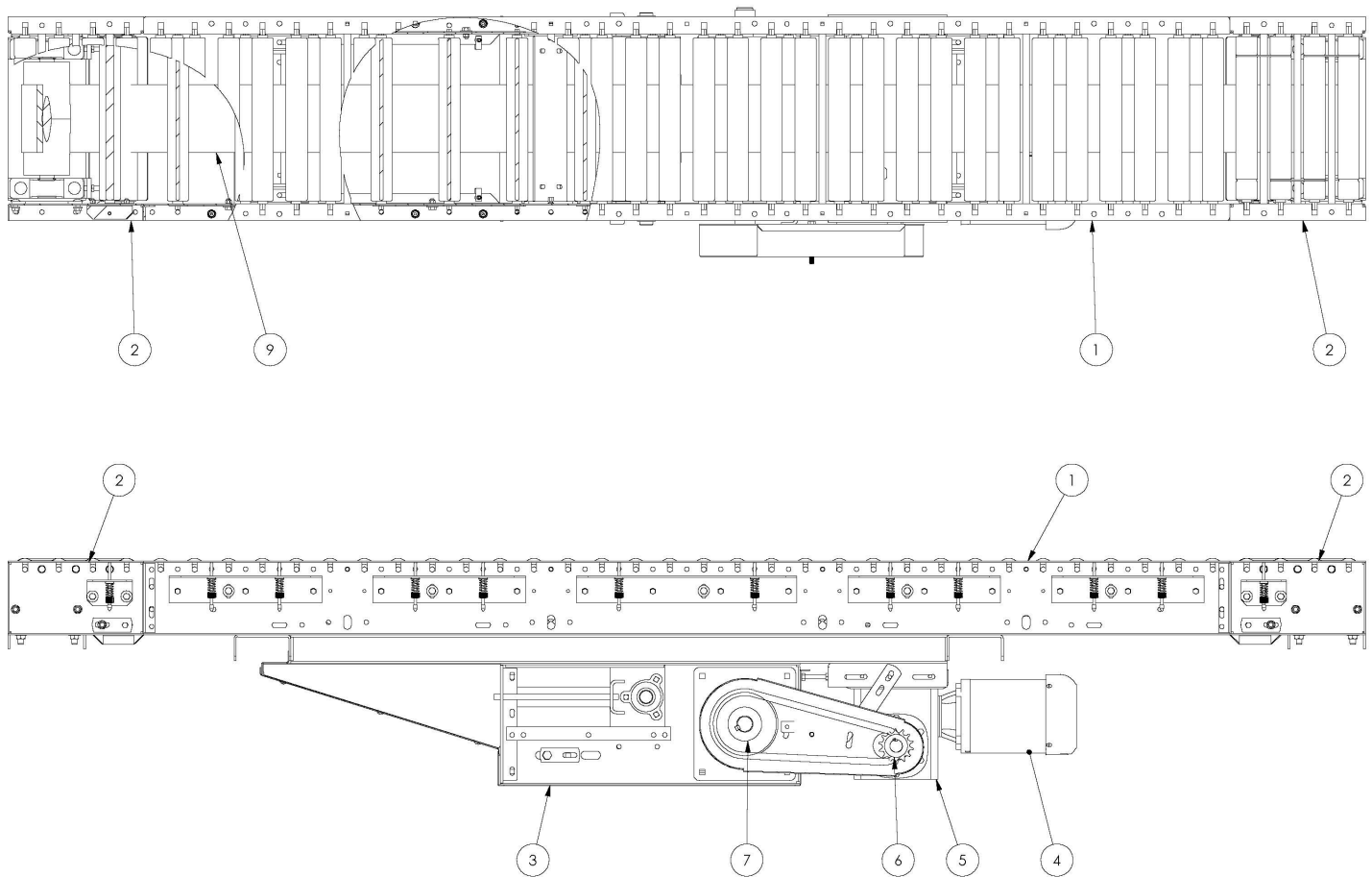
ANNUAL MAINTENANCE

- Change oil in reducers. (If your conveyor is equipped with a Boston 700 Series Reducer, it is filled with oil, sealed and lubed for life and requires no oil changes. See manufacturer's information for recommended lubricant at specific temperatures. Reducer information is shipped with every reducer.)

TROUBLE SHOOTING

TROUBLE	CAUSE	SOLUTION
Conveyor motor will not start or motor quits frequently	Motor is overloaded	Inspect conveyor for overloading and remove excessive load
	Motor is drawing excessive current	Check heater and/or circuit breaker and replace if necessary
Excessive wear on drive sprockets and drive chain	Inadequate amount of lubrication on drive chain	Replace chain and sprockets. Apply adequate amount of lubrication to chain.
	Misalignment of sprockets	Align sprockets
	Loose chain	Tighten chain
Loud popping or grinding noise	Defective bearing	Replace defective bearing
	Loose set screws in sprockets or bearing	Tighten loose set screws
	Improper drive chain tension	Properly tension drive chain
Motor or reducer is overheating	Overloaded conveyor	Check to ensure that the conveyor belt is not over capacity and reduce load
	Voltage to conveyor is too low	Have a qualified electrician test the voltage and correct if necessary
	Insufficient amount of lubricant in reducer	Add lubricant to reducers, manufacturer recommended level
	Accumulation pressure is too high	See "Pressure Adjustment" section
	One or more V-Belts are too tight	Reposition take-up sheaves further away from double groove sheave
Belt slips or will not move but drive runs	Overloaded conveyor	Check to ensure that the conveyor belt is not over capacity and reduce load
	Belt is too loose	Adjust belt take-up to tighten belt.
	Drive pulley lagging is worn.	Replace drive pulley lagging and tighten belt.
Belt is moving but conveyor tread rollers not turning	Not enough contact between drive belt and conveying tread rollers.	Adjust the pressure rollers.
Belt tracks to one side of drive or tail pulleys	Drive pulley, tail pulley or idlers located near the pulley are not aligned properly or square with the conveyor bed	Adjust pulleys and idlers as necessary
Belt tracks to one side	Conveyor not level or straight	Ensure that belt sections are aligned and leveled properly
	Residue/debris build up on pulleys or idlers	Remove residue/debris from pulleys and idlers
Product does not accumulate with minimum pressure	Tension on springs is adjusted too lightly	Loosen spring tension on rollers by adjusting knurled nuts on both sides of conveyor.
Product does not move on conveyor.	Not enough pressure or tension on drive belt.	Increase the spring tension on pressure rollers.
	Drive belt is too loose.	Use belt take-up to tighten belt.

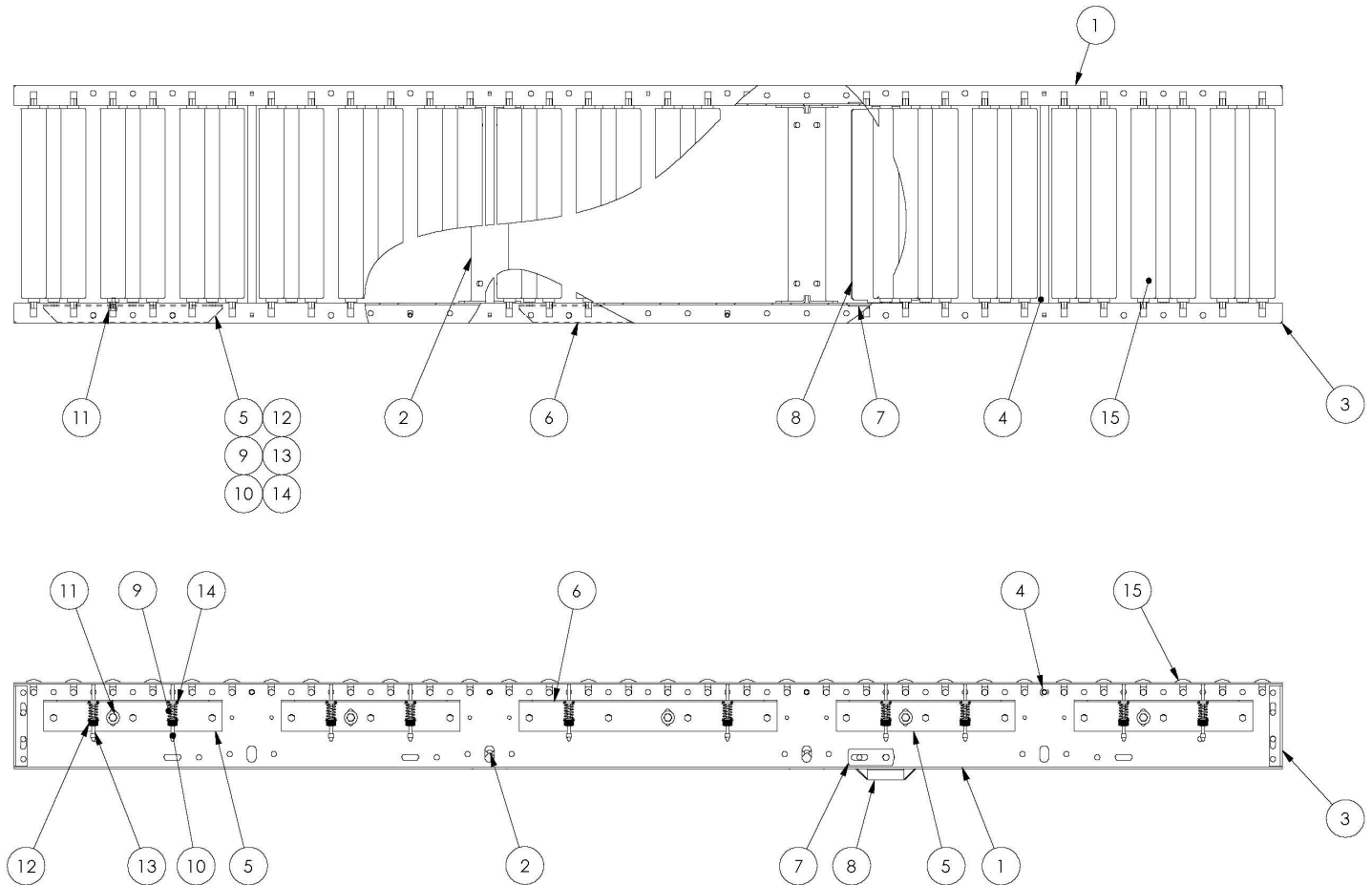
REPLACEMENT PARTS - DRAWING AND LIST (MINIMUM PRESSURE ASSEMBLY)



DET.	PART NO.	DESCRIPTION
1	ATL-13821	BED SECTION SUB-ASSEMBLY
2	ATL-13837	HEAD SUB-ASSEMBLY
3	ATL-13794	CENTER DRIVE SUB-ASSEMBLY
4	SPECIFIC TO ORDER	MOTOR
5	SPECIFIC TO ORDER	REDUCER
6	SPECIFIC TO ORDER	DRIVE SPROCKET: RC50 SERIES
7	SPECIFIC TO ORDER	DRIVEN SPROCKET: RC50 SERIES
8	SPECIFIC TO ORDER	DRIVE ROLLER CHAIN
9	SPECIFIC TO ORDER	BELT WITH LACING

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

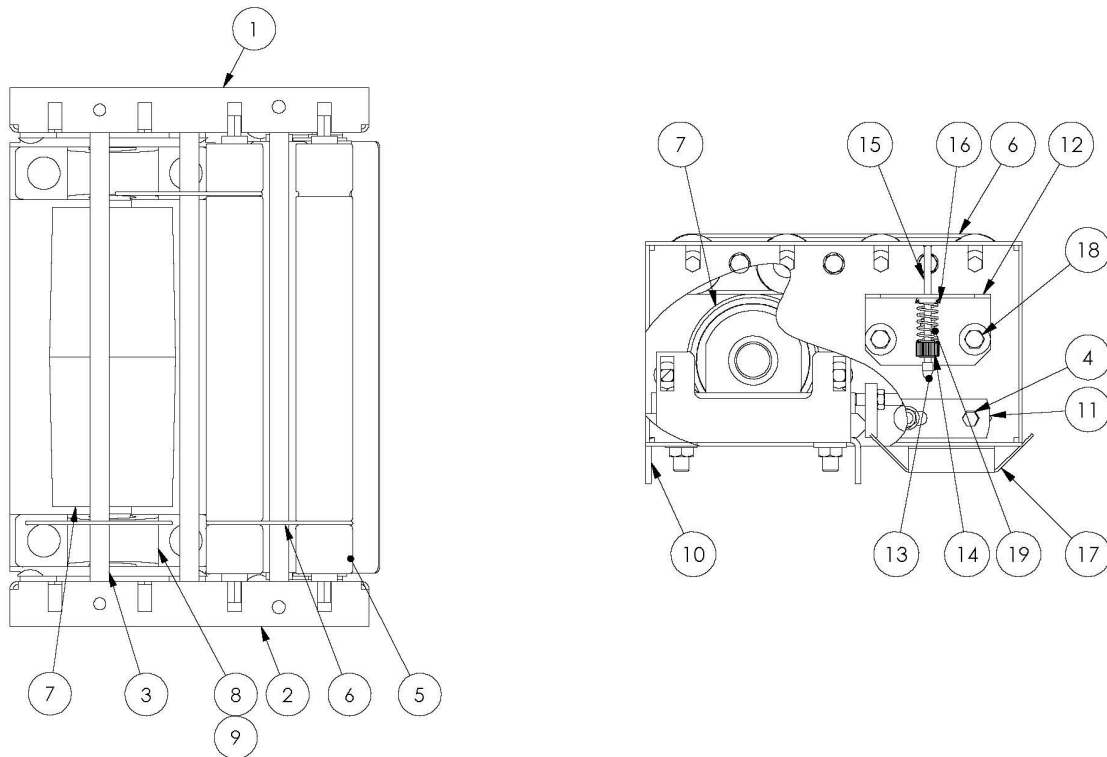
REPLACEMENT PARTS - DRAWING AND LIST (MINIMUM PRESSURE INTERMEDIATE)



DET.	PART NO.	DESCRIPTION
1	SPECIFIC TO ORDER	SIDE FRAME
2	ATL-11695-BF	SPREADER (BF)
3	ATL-13431	BUTT COUPLER
4	37690-BF	PIPE SPREADER, GALV. ROUND SPREADER (BF)
5	SPECIFIC TO ORDER	PRESSURE ROLLER ADJUSTMENT PLATE, (3) ROLLERS
6	SPECIFIC TO ORDER	PRESSURE ROLLER ADJUSTMENT PLATE, (4) ROLLERS
7	ATL-13819	SNUBBER ROLLER BRACKET - 7/16" HEX
8	ATL-13814-BF	SNUBBER ROLLER FINGER GUARD, (BF)
9	ATL-13451	SPRING
10	ATL-13209	CAP (VINYL): CAPPLUGS #VC-218-8, .218" I.D. X .5" HIGH, RED COLOR
11	ATL-13324	HEX HEAD SHOULDER SCREW, 3/8" X 1/4", 1/4-20 X 1/2" THREAD, (SPECIAL HARDWARE)
12	ATL-13325	FINGER ADJUSTMENT NUT
13	ATL-13327	CARRIAGE BOLT: 1/4-20 x 4 1/8" LONG
14	ATL-13784	FINISH WASHER: 1/4"
15	42072-BF-GP	BED ROLLER: 1.9" OD

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

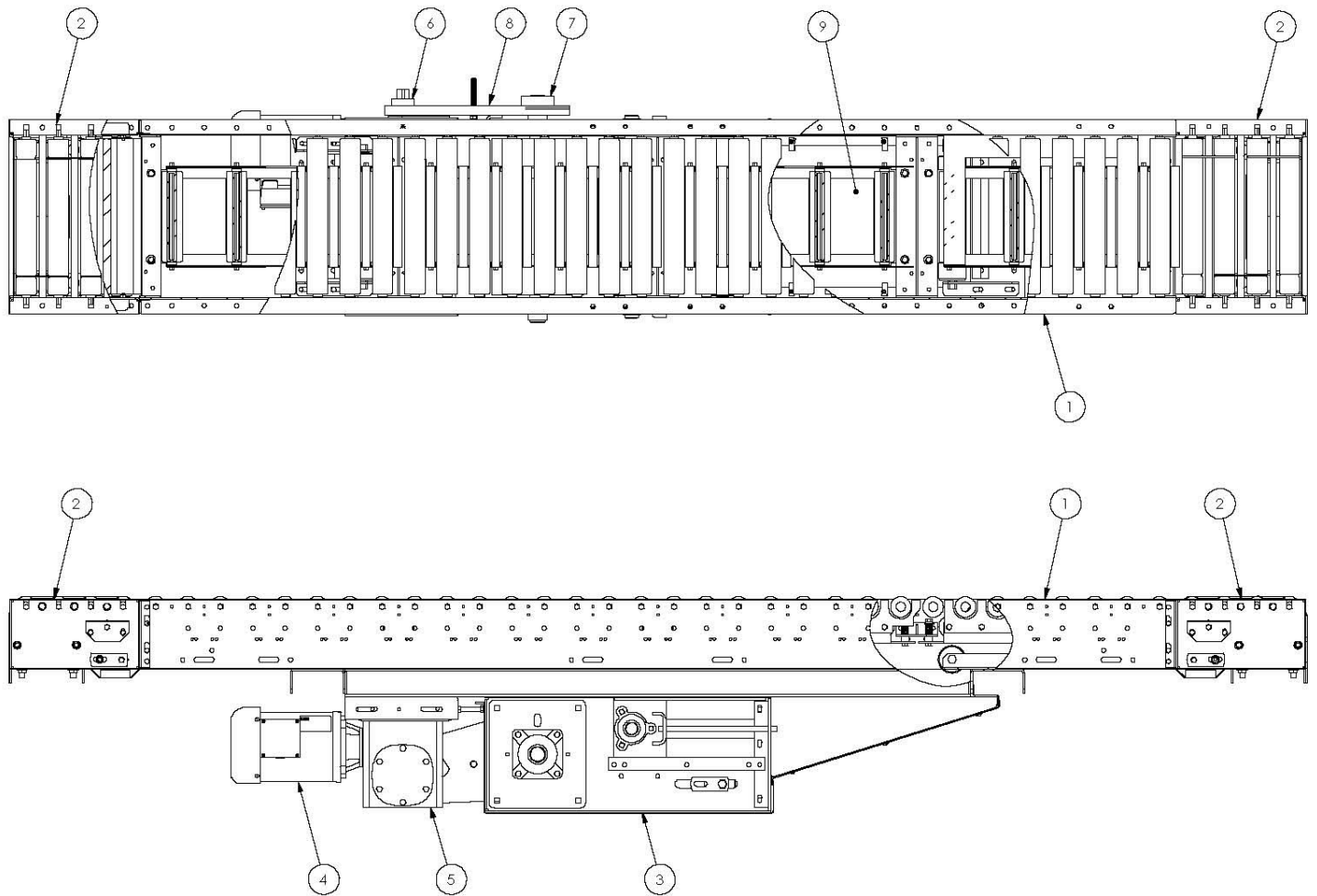
REPLACEMENT PARTS - DRAWING AND LIST (MINIMUM PRESSURE ENDS)



DET.	PART NO.	DESCRIPTION
1	ATL-13857-L	FRAME (LEFT)
2	ATL-13857-R	FRAME (RIGHT)
3	ATL-13432-BF	PIPE SPREADER (BF)
4	ATL-13479-BF-GP	GRAVITY ROLLER: 1.9" DIA.
5	ATL-14699-BF	DRIVE ROLLER: 1.9" DIA., DOUBLE GROOVE
6	ATL-13665	URETHANE BELT
7	ATL-13805-FL	4" DIA. TAIL PULLEY
8	ATL-14925	BEARING: PILLOW BLOCK, 1 3/16" BORE
9	ATL-13809	BEARING RISER
10	ATL-13813-BF	END BEARING MOUNT(BF)
11	ATL-13819	SNUB ROLLER BRACKET
12	ATL-13858-M	ADJUSTMENT PLATE
13	ATL-13209	CAP, VINYL
14	ATL-13325	FINGER ADJUSTMENT NUT: 1/4-20
15	ATL-13327	CARRIAGE BOLT: 1/4-20 x 4 1/8" LONG
16	ATL-13784	WASHER
17	ATL-13814-BF	SNUB ROLLER GUARD (BF)
18	ATL-13324	HEX HEAD SHOULDER SCREW, 3/8" X 1/4", 1/4-20 X 1/2" THREAD
19	ATL-13451	SPRING

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

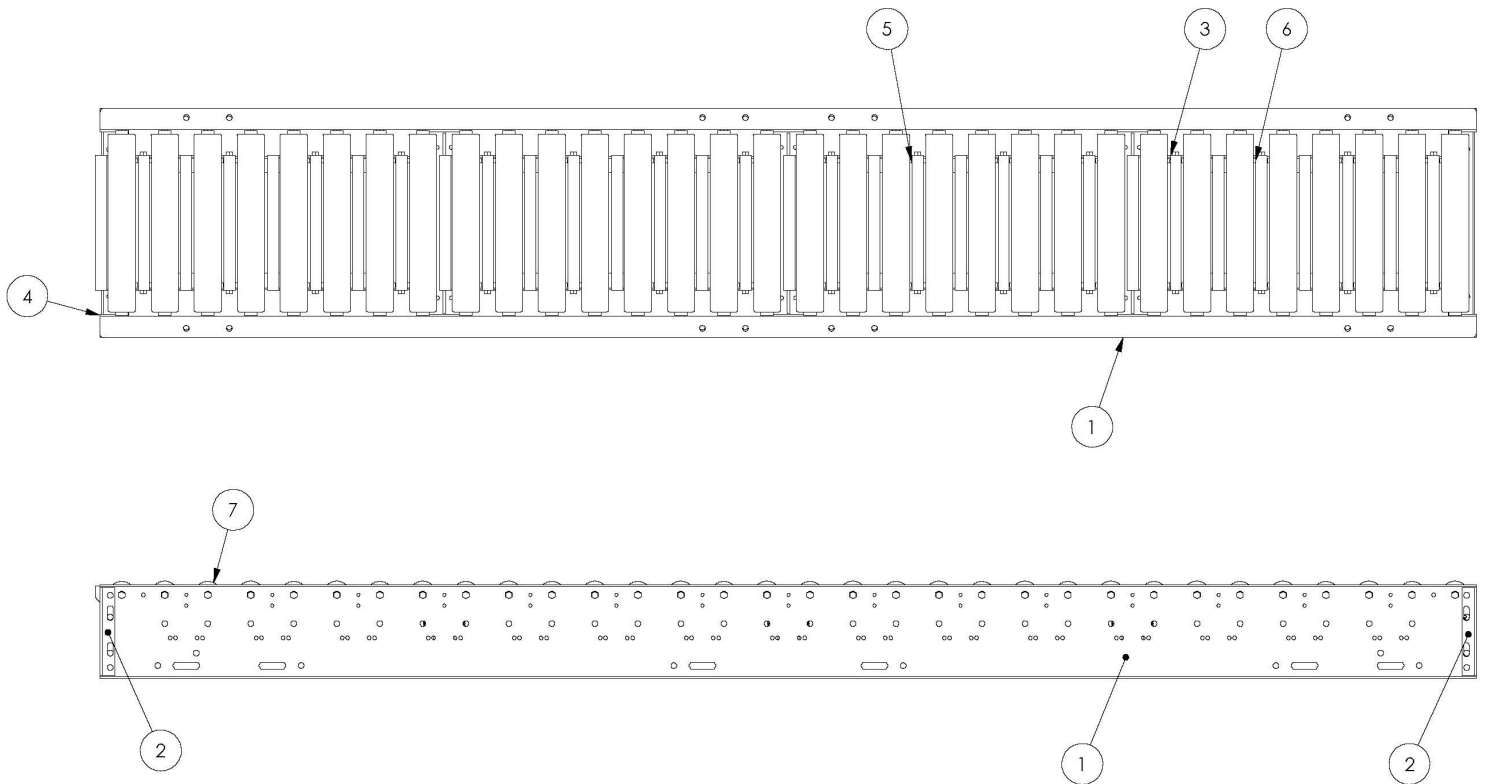
REPLACEMENT PARTS - DRAWING AND LIST (TRANSPORTATION ASSEMBLY)



DET.	PART NO.	DESCRIPTION
1	ATL-13867	BED SECTION SUB-ASSEMBLY
2	ATL-13837-15-T	HEAD SUB-ASSEMBLY
3	ATL-13794	CENTER DRIVE SUB-ASSEMBLY
4	SPECIFIC TO ORDER	MOTOR
5	SPECIFIC TO ORDER	REDUCER
6	SPECIFIC TO ORDER	DRIVE SPROCKET: RC50 SERIES
7	SPECIFIC TO ORDER	DRIVEN SPROCKET: RC50 SERIES
8	SPECIFIC TO ORDER	DRIVE ROLLER CHAIN
9	SPECIFIC TO ORDER	BELT WITH LACING

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

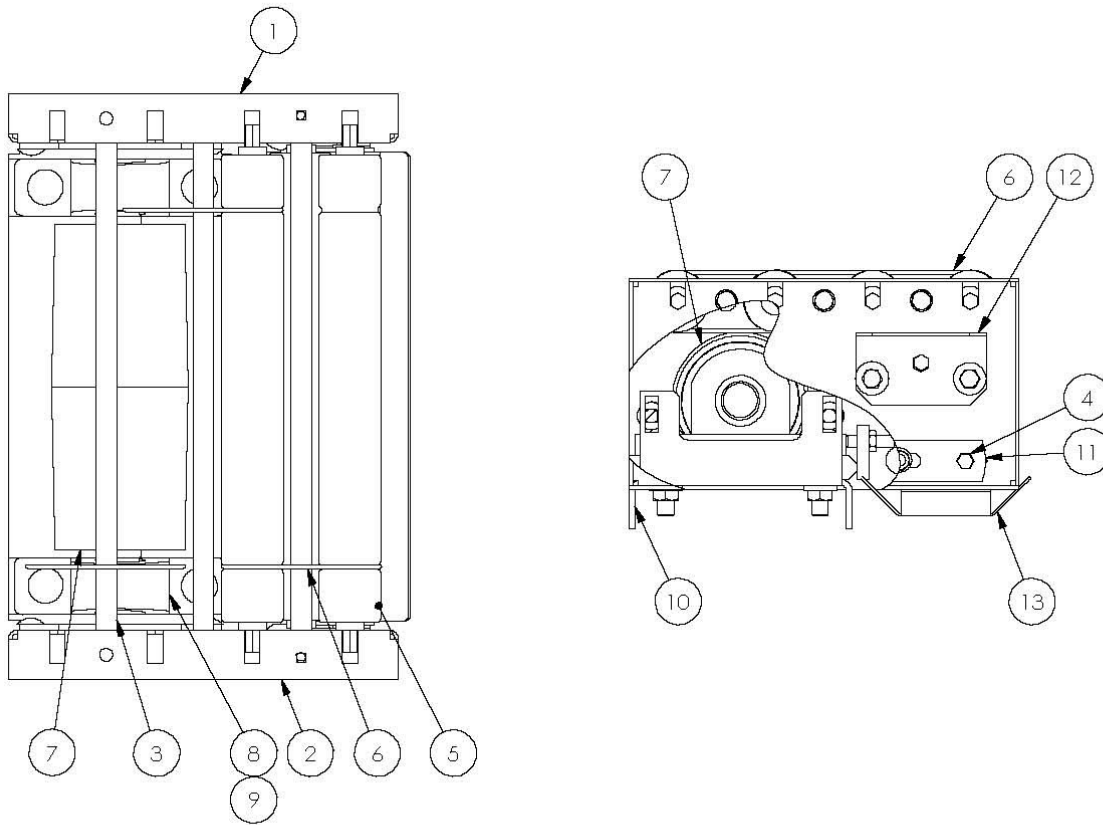
REPLACEMENT PARTS - DRAWING AND LIST (TRANSPORTATION INTERMEDIATE)



DET.	PART NO.	DESCRIPTION
1	ATL-13829-8.3	SIDEFRA
2	ATL-13431	BUTT COUPLER
3	ATL-13854-3.4	FINGER GUARD: 3 AXLE MOUNT, 4 GUARDS
4	SPECIFIC TO ORDER	END ZONE SPREADER/CARRIAGE SUPPORT CENTER WELDMENT (BF)
5	SPECIFIC TO ORDER	CARRIAGE SUB-ASSEMBLY: 18" ZONE LENGTH, 3" CENTERS (BF)
6	ATL-13820-18.3.NS	CARRIAGE SUB-ASSEMBLY: 18" ZONE LENGTH, 3" CENTERS, NO SPREADER
7	ATL-13479-BF-GP	GRAVITY ROLLER: 1.9" DIA.

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

REPLACEMENT PARTS - DRAWING AND LIST (TRANSPORTATION ENDS)



DET.	PART NO.	DESCRIPTION
1	ATL-13857-L	FRAME (LEFT)
2	ATL-13857-R	FRAME (RIGHT)
3	ATL-13432-BF	PIPE SPREADER (BF)
4	ATL-13479-BF-GP	GRAVITY ROLLER: 1.9" DIA.
5	ATL-14699-BF	DRIVE ROLLER: 1.9" DIA., DOUBLE GROOVE
6	ATL-13665	URETHANE BELT
7	ATL-13805-FL	4" DIA. TAIL PULLEY
8	ATL-14925	BEARING: PILLOW BLOCK, 1 3/16" BORE
9	ATL-13809	BEARING RISER
10	ATL-13813-BF	END BEARING MOUNT(BF)
11	ATL-13819	SNUB ROLLER BRACKET
12	ATL-13858-M	ADJUSTMENT PLATE
13	ATL-13814-BF	SNUB ROLLER GUARD (BF)

HIGHLIGHTED ITEMS ARE RECOMMENDED REPLACEMENT PARTS

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