



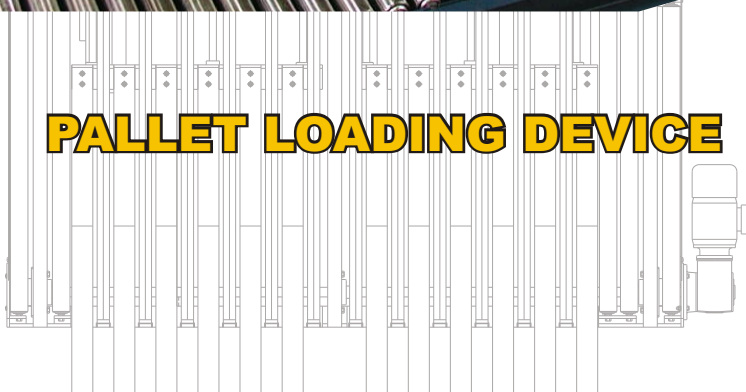
The Leader in Conveyor Innovation

10010 Conveyor Drive • Indianapolis, IN 46235 • Toll Free: 1.800.578.1755 • www.systecconveyors.com

SERVICE & MAINTENANCE MANUAL



PALLET LOADING DEVICE



TOLL FREE: 1.800.578.1755 or ONLINE: WWW.SYSTECCONVEYORS.COM

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Every effort has been made to insure the accuracy of this manual. However, Systec Corporation does reserve the right to make changes to this publication without public notification.

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The information contained within this manual is specific to **SYSTEC's** standard Pallet Loading Device. The Pallet Loading Device will be referred to as PLD from this point forward.

The PLD places corrugated loads onto pallets. Loads enter the system via an entry conveyor line. While the load is entering the system, a pallet is placed on the palletizing line either via manual operation or through the aid of an automatic pallet dispenser. After a load enters the PLD, the unit is raised. After the unit elevates, the pallet is brought flush with the front face of the PLD. Next, the head of the PLD sweeps across the roller bed pushing the load onto the forks that are extended above the pallet; as illustrated in the photo below. Once the load is centered above the pallet, the forks under the load retract while the pusher head remains stationary. In short, the load is being scraped off the forks and onto the pallet below. Now that the load is placed onto the pallet, the load is centered on the conveyor line and then conveyed out of the system. While the palletized load is being moved, the PLD prepares to accept another load by the head returning to the home position as the device lowers back to floor conveyor height.

ILLUSTRATION A



PALLET LOADING DEVICE

Where safety is concerned, conveyor is no different from any other form of machinery or processing equipment. In many cases, the conveyor and devices can start running without notice.

SYSTEC designs all of its equipment to be as safe as possible. **SYSTEC** provides safety labels on all of its equipment and installs guarding when appropriate. Safety labels are in place to warn personnel working on or around the conveyor system of the inherent dangers that exist with any conveyor or machinery.

SYSTEC Conveyors believes that conveyor safety presentations should be incorporated into your existing safety training program to educate all personnel that work on or around conveyor systems.

Below is Illustration B, showing the location and type of safety labels on the PLD. These labels should be prominently displayed alerting personnel of potential hazards caused by improper use of conveyor equipment. Where foot traffic exists, personnel should be discouraged from walking on any conveyor line. Furthermore, depending on your application and control features, the following labels may also need to be applied: Lockout, Motor Switch Location and Photoeye Location. Please consult your electrical schematics to indicate if and where these labels need to be applied.

Should you need additional labels, please contact **SYSTEC's** Parts Department at the toll free number listed at the bottom of this page. Please have part description as well as part number ready to ensure accurate replacement.

ILLUSTRATION B



Safety Label, Part Number: 000-0302-00.



Safety Label, Part Number: 000-0301-00.
Also located on opposite side.



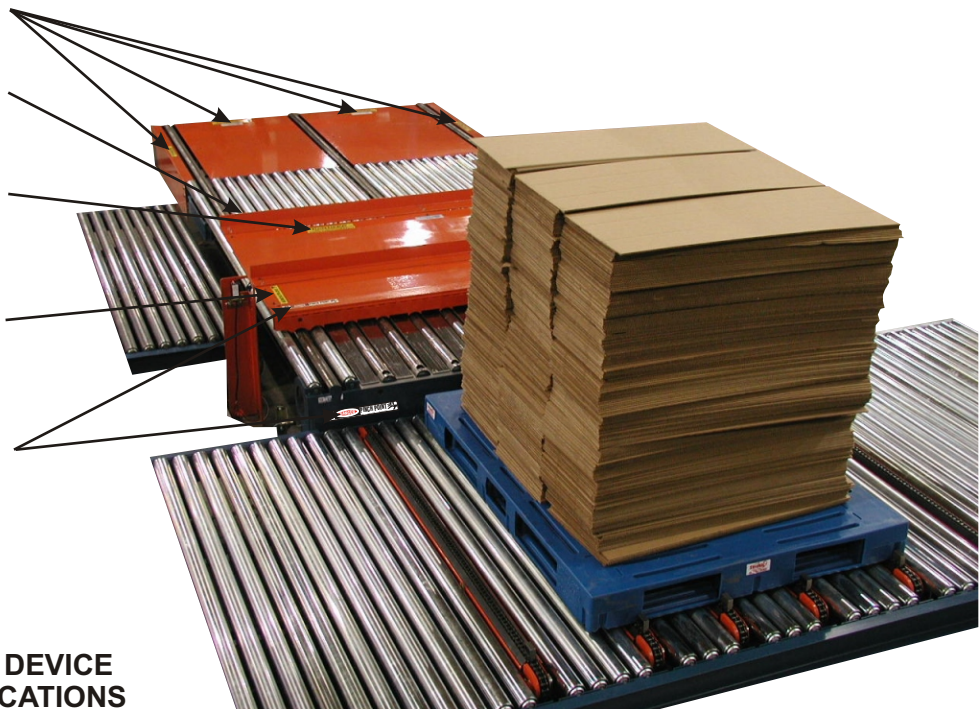
Safety Label, Part Number: 000-0302-00.
Also located on opposite side.



Safety Label, Part Number: 000-0300-00.
Also located on opposite side.



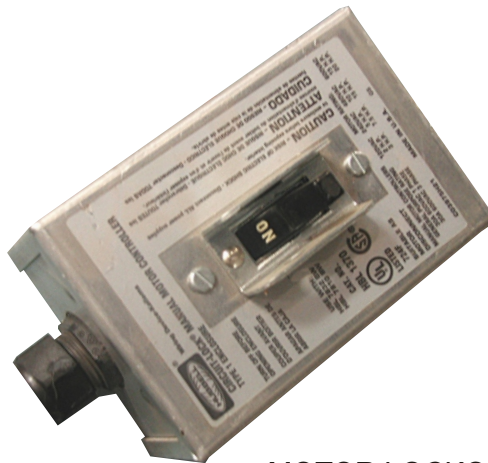
Safety Label, Part Number: 000-0301-00.
Also located on opposite side.



PALLET LOADING DEVICE SAFETY LABEL LOCATIONS

Prior to beginning any service or maintenance work on any conveyor or device, it is vital to lock-out. **SYSTEC** typically provides lockout switches, as displayed in Illustration C, for each drive motor provided on each conveyor line and device.

ILLUSTRATION C



MOTOR LOCKOUT SWITCH

Motor lockout switches are generally located in close proximity to the motor. Be certain that the motor switch is in the “off” position before any maintenance or service work is performed. Additional precautions should be taken if “internal” work is to be performed by disconnecting power to the unit at the circuit breaker in the corresponding service panel. Again, your lock-out, tag-out procedures should apply.

NOTE: Only authorized personnel should perform service and maintenance on any conveyor equipment and/or controls.

WHAT TO HAVE PRIOR TO CALLING:

Before placing your parts order, please have the following information readily available:

- *Part Information:* You will need the part number, any customer specified dimension(s), and the type of device the part is from.
- *Payment Information:* Systec accepts various payment options including: purchase orders, check, or Visa and Mastercard. If you select to pay by purchase order, you will need to supply Systec with the invoice mailing address if it is different than your shipping address.



- *Shipping Information:* If you have a preferred carrier to deliver your parts, please specify this information at time of order. Systec will make every reasonable effort to honor your shipping requests. If no carrier is specified or Systec is unable to fulfill your shipping request, the shipment will be sent to the customer the most affordable way possible. You will also need to supply Systec with your shipping address.

ACCEPTABLE WAYS TO PLACE AN ORDER:

You may place an order in one of the following ways:

- *Telephone:* Simply call 1.800.578.1755 and ask to speak to the Parts Department.
- *Fax:* Submit your parts order request to 317.890.9232, attention Parts Department
- *Email:* Send your order request electronically to parts@systecconveyors.com.
- *Postal Mail:* Systec Conveyors
Parts Department
10010 Conveyor Drive
Indianapolis, IN 46235

EMERGENCY PARTS ORDERS:

If you are in need of placing an emergency parts order after Systec's regular business hours, dial toll free 1.800.578.1755. When Systec's answering service picks up, dial 203. After the outgoing message, please leave the following information:

- Your first and last name
- Your company and location
- A telephone number where you can be immediately reached
- A brief description of the problem or the part you are in need of.

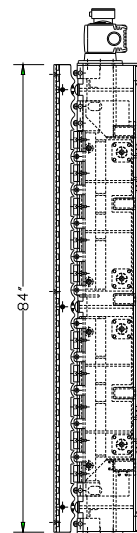
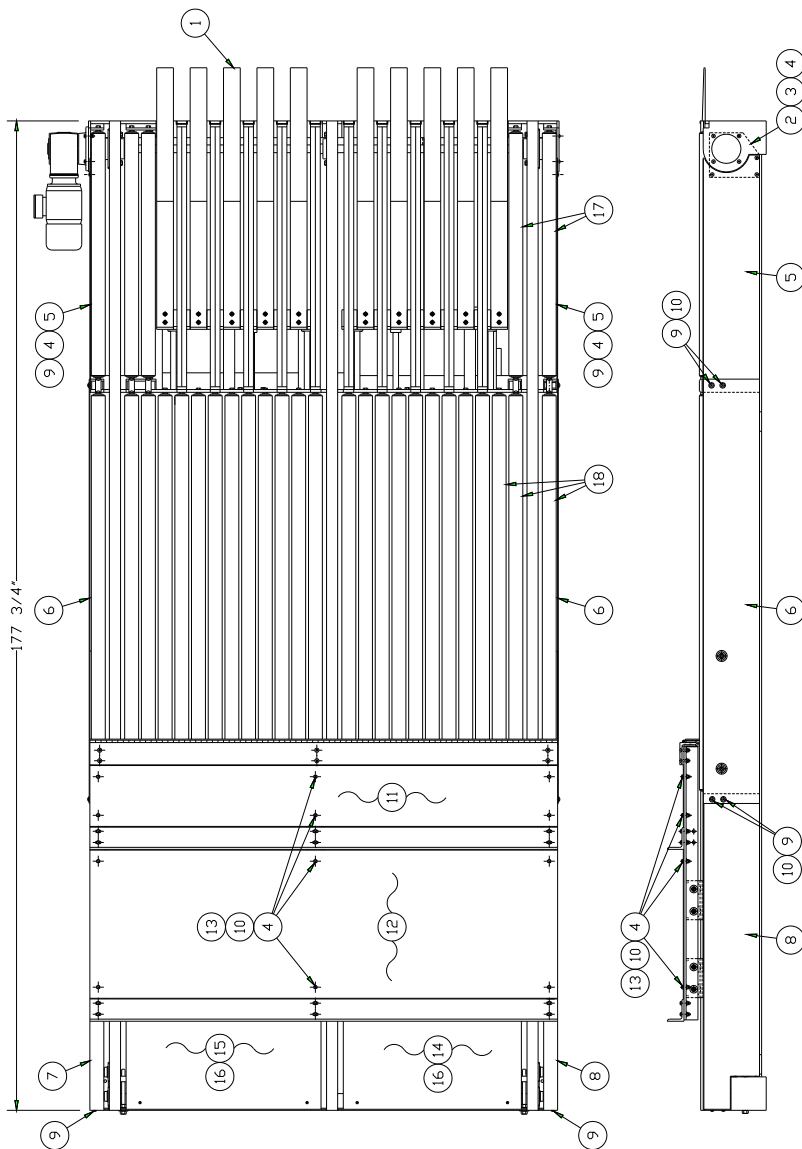
After your message is completed, the pager of the person on call at Systec will be activated. The person will then return your phone call.

NOTE: Emergency parts orders are subject to expedited service fees and special handling fees.

ORDER CONFIRMATION:

Systec provides every customer with an order confirmation. This confirmation is the customer's proof of order and opportunity to verify all parts and shipping information. All order confirmations are processed in order of receipt. Under most circumstances, an order confirmation is faxed to the customer within one business day. In many instances, the order confirmation is sent within a couple of hours. If you do not receive a confirmation, please call Systec's Parts Department to inquire on the status of the confirmation.

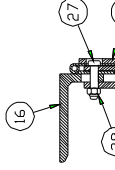
ITEM	QTY	DESCRIPTION	PART NUMBER	GR.
1	1	PLD HEAD AND FORKS ASSEMBLY X 84" W.	50D0090	
2	1	PLD NON-MOTOR SIDE GUARD MTG. PLATE	50B0051	
3	4	SCREW, BUTTON HEAD, SOC CAP 3/8-16 X 1" L.	740-3234	20
4	22	NUT, WYE INS LOCK 3/8-16	790-3234	00
5	2	PLD MOTOR END SIDE GUARD	50B0052	
6	2	PLD CONVR SIDE GUARD X 76-1/4" L.	50B0053	01
7	1	SHEET PUSHER SIDE GUARD WELDMENT - LH	21C6030	
8	1	SHEET PUSHER SIDE GUARD WELDMENT - RH	760-3234	15
9	18	SCREW, BUTTON HEAD, SOC CAP 3/8-16 X 3/4" L.	800-0326	00
10	20	WASHER, FLAT USS 3/8"	50C0075	01
11	1	PLD HEAD TOP GUARD PLATE X 10-15/16" W.	50C0075	02
12	1	PLD HEAD TOP GUARD PLATE X 26-3/8" W.	740-0234	24
13	12	SCREW, HEX HEAD CAP 3/8-16 X 1-1/4" L.	50C0080	01
14	1	PLD TOP GUARD PLATE X 32" W.	50C0080	02
15	1	PLD TOP GUARD PLATE X 35" W.	760-3226	15
16	12	SCREW, BUTTON HEAD, SOC CAP 1/4-20 X 3/4" L.	1000150	MU
17	5	ROLLER - 11/16" HEX S.L. 2-1/2" DIA. - 11 GA. X 44-3/4" L.	1000150	MU
18	25	ROLLER - 11/16" HEX S.L. 2-1/2" DIA. - 11 GA. X 72" L.	1000150	15



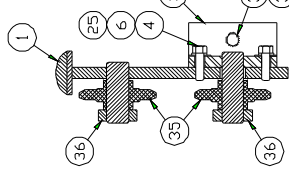
PROJECT NO.		QUANTITY PER ASS'Y:	1	SYSTEC CORPORATION
GROUP NO.		ENGINEER: ABR	DATE: 8-7-02	
QTY. OF ASS'Y		DRAWN BY: ABR	DATE: 8-7-02	
		CHECKED: ABR	DATE:	
		DE-BURR ALL SHARP EDGES		
		DWG. NO:	50D0095	
				PALLET LOADING DEVICE GUARDS ASSEMBLY 84" W. HEAD X 72" B.F.

ITEM	QTY	DESCRIPTION	PAGE	GR
1	1	PLD SECONDARY FRAME ASSEMBLY X 84" W	5000095	00
2	10	PLD LOAD SUPPORT BAR WELDMENT	5000045	00
3	2	SREW FLAT HEAD 3/8" CAP 3/8-16 X 3/4" L	700-2234	15
4	2	NUT NYL INS LOCK 3/8-16	800-1235	00
5	2	NUT NYL INS LOCK 3/8-16	800-1235	00
6	2	WASHER, FLAT LOCK 3/8"	5000001	00
7	10	PLD PALLET FORK CAP 3/8-16 X 1/2" L	5000001	00
8	2	PLD MAIN HEAD DRIVE SHAFT X 84-3/8" L	5000001	00
9	2	SPROCKET - 60LB TAPER LOCK W/KILL 20LB X 1-3/8" T.L. B51G	500-1200	01
10	2	BEARING, FLANGE BLOCK 2-BOLT 1-7/8" BORE W/SET SCREWS	500-2030	01
11	2	SREW HEX HEAD CAP 3/8-16 X 1-1/2" L	740-0234	00
12	2	NUT NYL INS LOCK 3/8-16	800-1235	00
13	2	GEAR MOTOR - SKID2634F-80L4BREHL 68.371 RATIO 1HP	500-1701	00
14	4	SREW HEX HEAD CAP 3/8-16 X 1-1/2" L	740-0234	12
15	1	PLD HEAD ANGLE WELDMENT X 84" L	5000003	01
16	2	PLD HEAD ANGLE WELDMENT X 84" L	5000003	01
17	2	PLD HEAD ANGLE WELDMENT X 84" L	5000003	01
18	2	PLD HEAD ANGLE WELDMENT X 84" L	5000003	01
19	2	PLD HEAD ANGLE WELDMENT X 84" L	5000003	01
20	1	PLD SCALLOPED HEAD AND HINGE WELDMENT X 84" W	5000066	00
21	2	SREW FLAT HEAD 3/8" CAP 3/8-16 X 3/4" L	700-2234	15
22	2	NUT NYL INS LOCK 3/8-16	800-1235	00
23	2	WASHER, FLAT LOCK 3/8"	5000001	00
24	2	SREW FLAT HEAD 3/8" CAP 3/8-16 X 3/4" L	700-2234	15
25	2	NUT NYL INS LOCK 3/8-16	800-1235	00
26	2	WASHER, FLAT LOCK 3/8"	5000001	00
27	2	SREW FLAT HEAD 3/8" CAP 3/8-16 X 3/4" L	700-2234	15
28	2	NUT NYL INS LOCK 3/8-16	800-1235	00
29	2	WASHER, FLAT LOCK 3/8"	5000001	00
30	2	SREW FLAT HEAD 3/8" CAP 3/8-16 X 3/4" L	700-2234	15
31	2	NUT NYL INS LOCK 3/8-16	800-1235	00
32	2	WASHER, FLAT LOCK 3/8"	5000001	00
33	2	SREW FLAT HEAD 3/8" CAP 3/8-16 X 3/4" L	700-2234	15
34	2	NUT NYL INS LOCK 3/8-16	800-1235	00
35	2	WASHER, FLAT LOCK 3/8"	5000001	00
36	2	SREW FLAT HEAD 3/8" CAP 3/8-16 X 3/4" L	700-2234	15
37	2	NUT NYL INS LOCK 3/8-16	800-1235	00
38	2	WASHER, FLAT LOCK 3/8"	5000001	00
39	2	SREW FLAT HEAD 3/8" CAP 3/8-16 X 3/4" L	700-2234	15

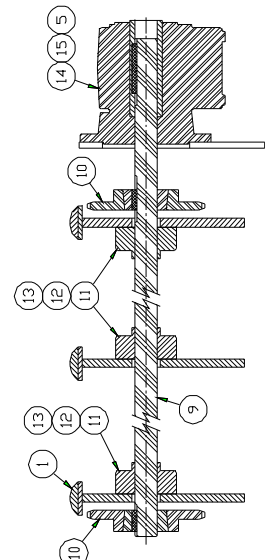
* ITEMS NOT SHOWN ON DRAWING



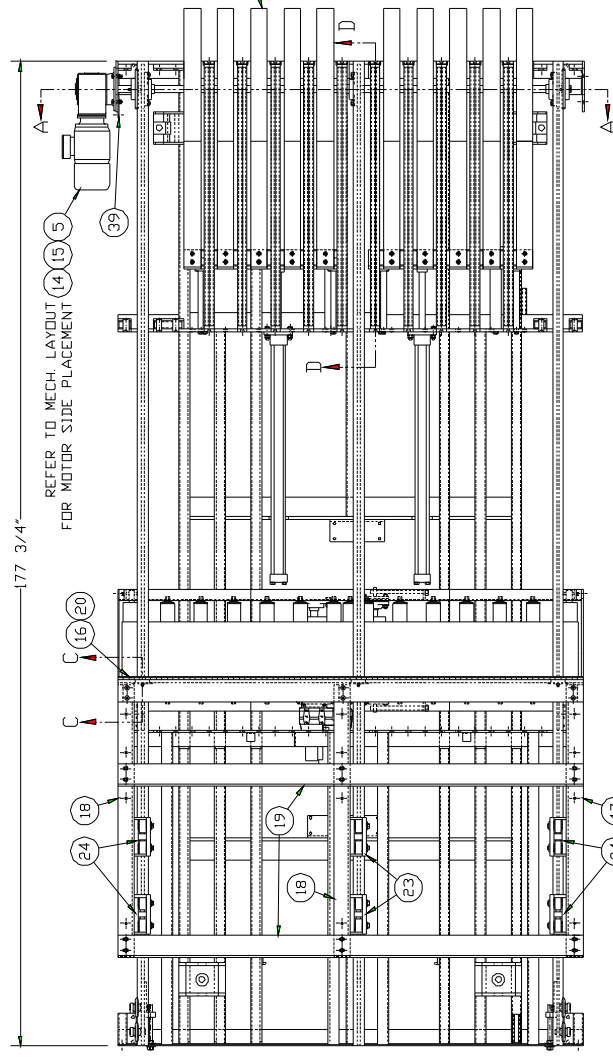
SECTION VIEW @ C-C



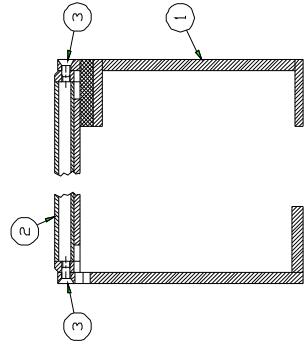
SECTION VIEW @ B-B
TYPICAL (2) PLACES



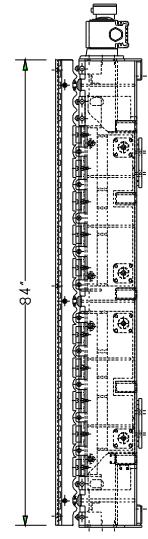
SECTION VIEW @ A-A



REFER TO MECH LAYOUT (14) (15) (5)
FOR MOTOR SIDE PLACEMENT



SECTION VIEW @ D-D

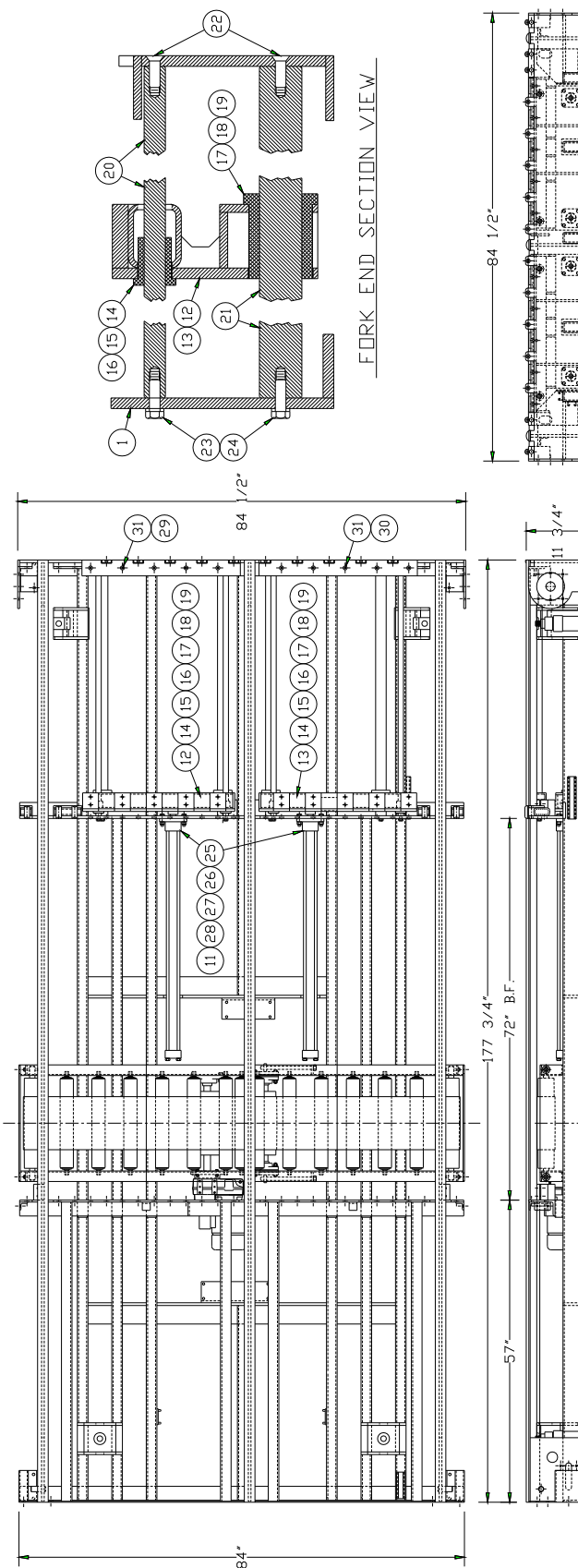


PROJECT NO.		QUANTITY PER ASS'Y	1
GROUP NO.		ENGINEER: ABR	DATE: 5-15-02
QTY. OF ASS'Y		DRAWN BY: ABR	DATE: 5-15-02
		CHECKED: DATE:	
		DWG. NO.: 50D0090	
		PALLET LOADING DEVICE	
		HEAD AND FORKS ASS'Y	
		84\" W HEAD X 72\" BF.	

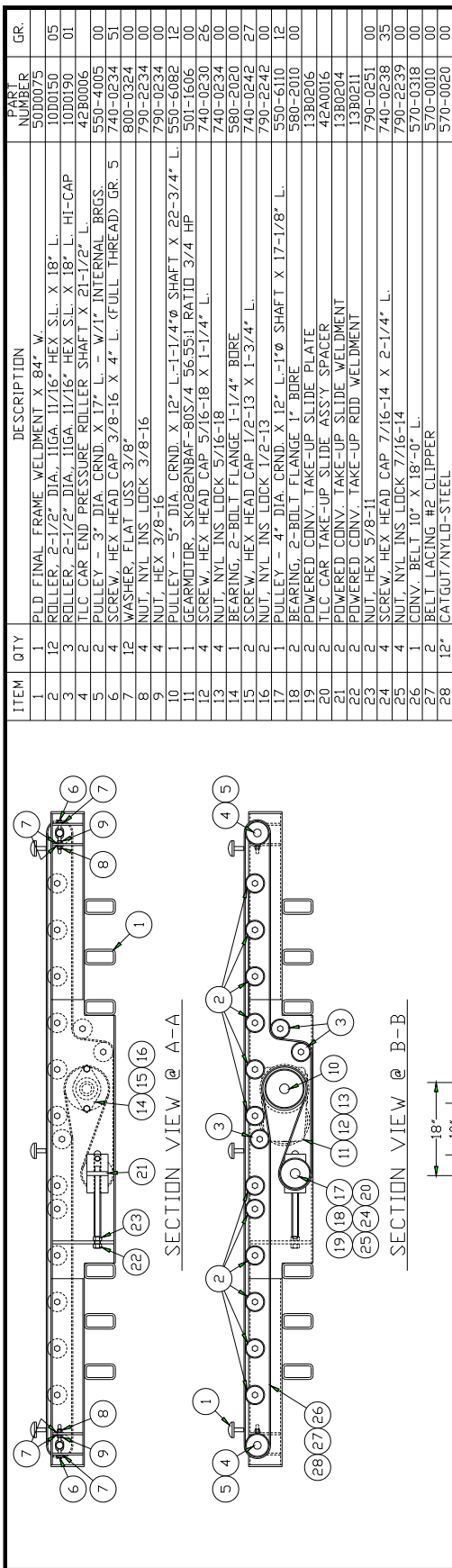


TOLERANCE	DECIMAL : ±.015"
FRACTION : ±1/32"	
ANGLE : ±1°	
CLEAN AND	
DE-BURR ALL	
SHARP EDGES	

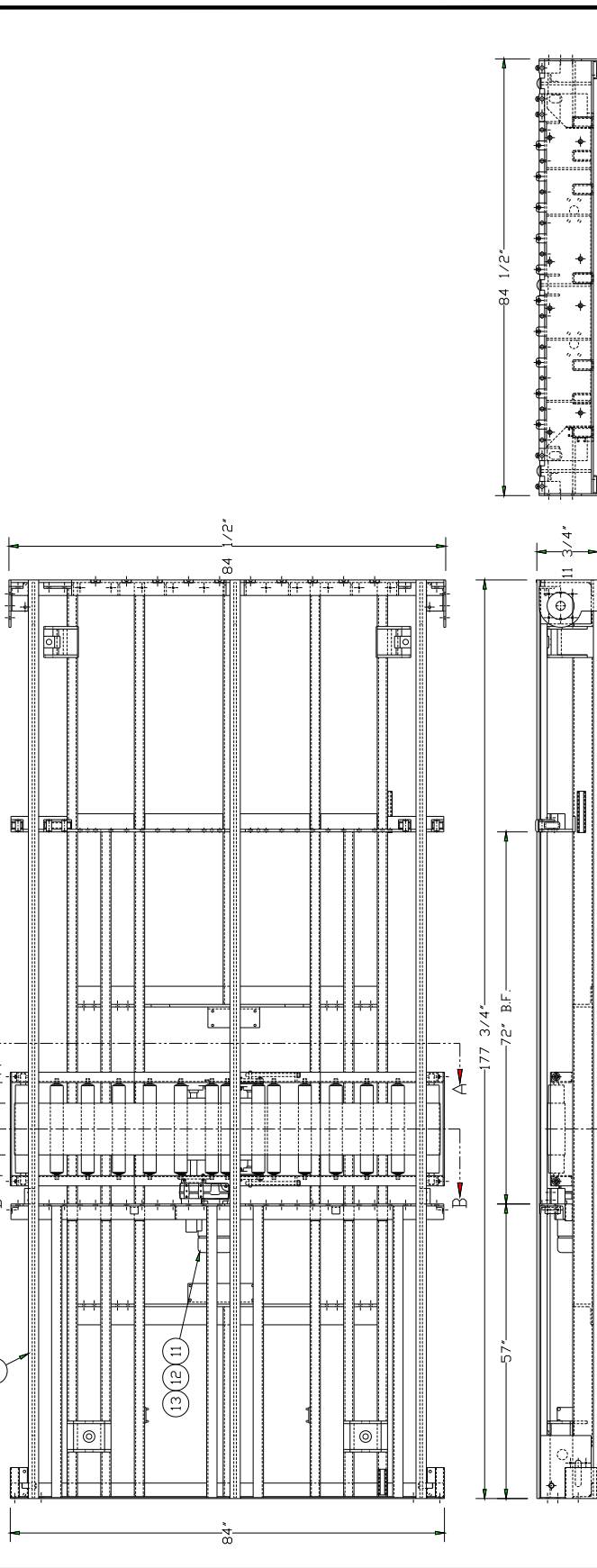
ITEM	QTY	DESCRIPTION	PART NUMBER	GR.
1	1	PLD PRIMARY FRAME ASSEMBLY X 84" W.	50D0080	-
2	4	CYL HYD TELE-- 7" STROKE,	-	-
3	4	NUT, JAM.	-	-
4	4	PLD LIFT CYLINDER BASE PLATE	50C0111	00
5	16	FCR-FMC, 5/16-18 X 2-1/2"	740-0234	00
6	16	NUT, NTL, 5/16-18	800-0231	00
7	16	WASHER, FLAT, SAE, 5/16"	-	-
8	16	WASHER, FLAT, SAE, 5/16"	-	-
9	16	WASHER, FLAT, SAE, 5/16"	-	-
10	16	WASHER, FLAT, SAE, 5/16"	-	-
11	40	INS LOCK 1/2-13	790-2242	08
12	1	PLD FORK TRANSFER WELDMENT - LH	50C0045	-
13	1	PLD FORK TRANSFER WELDMENT - RH	50C0046	-
14	4	LINEAR BEARING - SQUARE FLANGE 1" ID	580-6525	01
15	16	SCREW, SDC HEAD CAP #10-24 X 5/8" L.	750-3220	00
16	16	WASHER, SPLIT LOCK #10	800-1220	00
17	4	BEARING, LINEAR - 2" ID, SQUARE FLANGE	580-6525	02
18	16	SCREW, SDC HEAD CAP 5/16-18 X 1" L.	750-0516	18
19	16	WASHER, SPLIT LOCK 5/16"	800-1230	00
20	4	PLD FORK TRANSFER GUIDESHAFT X 1" DIA	50C0055	01
21	4	PLD FORK TRANSFER GUIDESHAFT X 2" DIA	50C0055	02
22	8	SCREW, FLAT HEAD SDC CAP 1/2-13 X 1-1/2" L.	770-3242	25
23	8	SCREW, HEX HEAD CAP 1/2-13 X 1-1/2" L.	800-1242	28
24	8	WASHER, SPLIT LOCK 1/2"	660-2003	40
25	2	CYL, HYD. - 40" STROKE, 2" BORE, 1" DIA ROD	660-2022	00
26	2	FEMALE ROD CLEVIS - 3/4-16 THREADS	845-2025	00
27	2	PIVOT PIN - 3/4" DIA	740-0242	31
28	8	SCREW, HEX HEAD CAP 1/2-13 X 2" L.	50C0061	01
29	1	PLD END FORK WEAR PAD - RH X 29-7/8" L.	50C0061	02
30	1	PLD END FORK WEAR PAD - LH X 29-7/8" L.	50C0061	02
31	10	SCREW, FLAT HEAD SDC CAP 3/8-16 X 1" L.	770-3234	20
32	1	OMITTED	-	-



PROJECT NO:	GROUP NO:	QTY. OF ASSY:
 SYSTEC CORPORATION QUANTITY PER ASSY: 1 ENGINEER: ABR DATE: 5-13-02 DRAWN BY: ABR DATE: 5-13-02 CHECKED: DATE: DWG. NO: 50D0085		
PALLET LOADING DEVICE SECONDARY FRAME ASSY 84" W. HEAD X 72" B.F.		



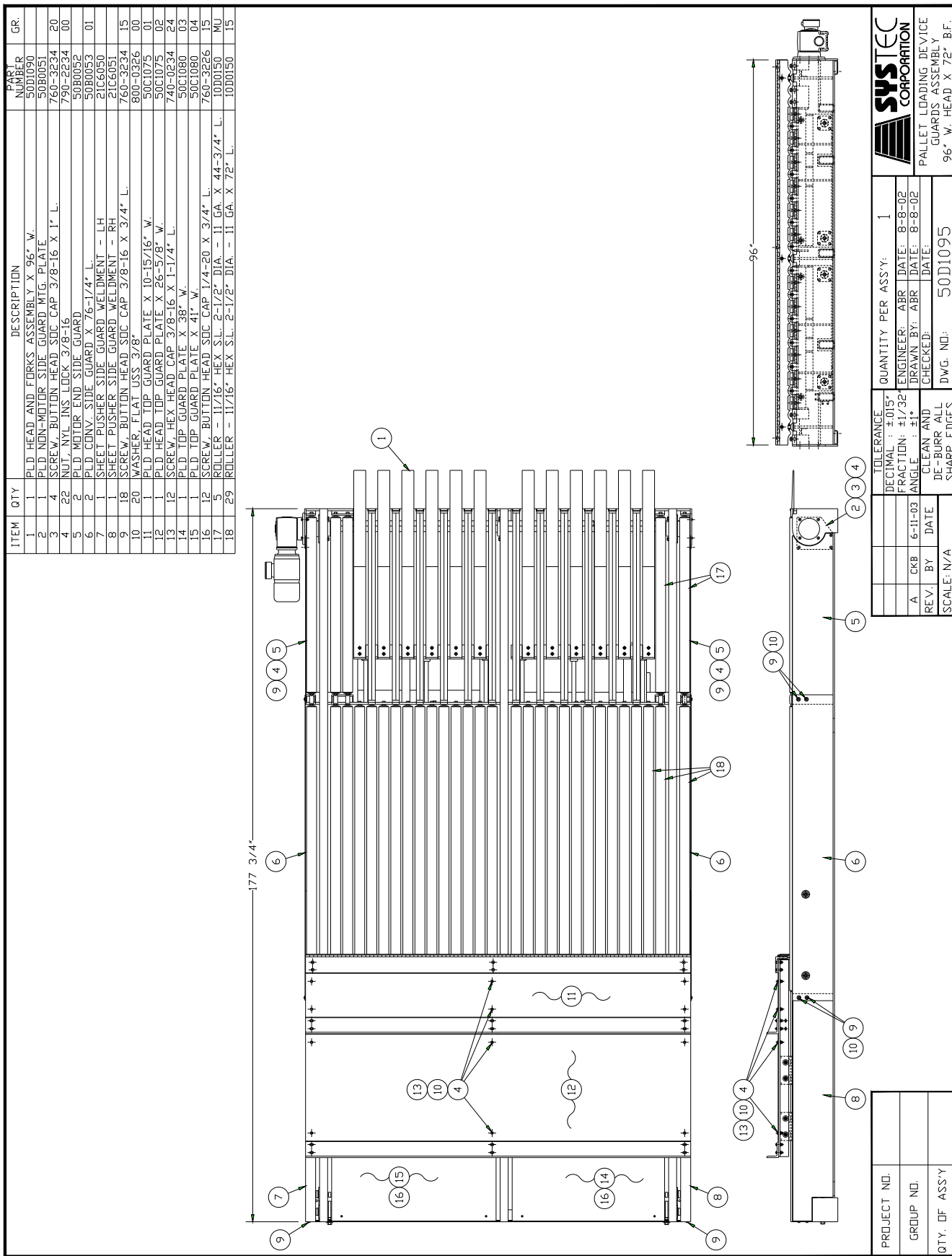
ITEM	QTY	DESCRIPTION	PART NUMBER	GR.
1	1	PLD. FINAL FRAME WELDMENT X 84" W.	5000075	05
2	12	ROLLER, 2-1/2" DIA., 11/16" HEX SL. X 18" L. HI-CAP	1000150	01
3	3	ROLLER, 2-1/2" DIA., 11/16" HEX SL. X 18" L. HI-CAP	1000150	01
4	2	TLC CAR END PRESSURE ROLLER SHAFT X 21-1/2" L.	4280006	00
5	2	PULLEY - 3" DIA. CRND. X 17" L. - W/1" INTERNAL BRGS.	550-4005	00
6	4	SCREW, HEX HEAD CAP 3/8-16 X 4" L. (FULL THREAD) GR. 5	740-0234	51
7	12	WASHER, FLAT USS 3/8"	800-0324	00
8	4	NUT, NYL INS LOCK 3/8-16	790-2234	00
9	4	NUT, HEX 3/8-16	790-0234	00
10	1	PULLEY - 5" DIA. CRND. X 12" L. 1-1/4" SHAFT X 22-3/4" L.	550-6082	12
11	1	GEAR MOTOR, SK0282NBAF-80S/4 56.551 RATIO 3/4 HP	501-1606	00
12	4	SCREW, HEX HEAD CAP 5/16-18 X 1-1/4" L.	740-0230	26
13	4	NUT, NYL INS LOCK 5/16-18	740-0234	00
14	1	BEARING, 2-BOLT FLANGE 1-1/4" BORE	580-2020	00
15	2	SCREW, HEX HEAD CAP 1/2-13 X 1-3/4" L.	740-0242	27
16	2	NUT, NYL INS LOCK 1/2-13	790-2242	00
17	1	PULLEY - 4" DIA. CRND. X 12" L. 1" SHAFT X 17-1/8" L.	550-6110	12
18	2	BEARING, 2-BOLT FLANGE 1" BORE	580-2010	00
19	2	POWERED CONV. TAKE-UP SLIDE PLATE	1380206	00
20	2	TLC CAR TAKE-UP SLIDE ASSY SPACER	4280016	00
21	2	POWERED CONV. TAKE-UP SLIDE WELDMENT	1380204	00
22	2	POWERED CONV. TAKE-UP ROD WELDMENT	1380211	00
23	2	NUT, HEX 5/8-11	790-0251	00
24	4	SCREW, HEX HEAD CAP 7/16-14 X 2-1/4" L.	740-0238	35
25	1	NUT, NYL INS LOCK 7/16-14	790-2239	00
26	2	CONV. BELT 10" X 18'-0" L.	570-0318	00
27	1	BELT LACING #2 CLIPPER	570-0010	00
28	12	CATGUT/NYLO-STEEL	570-0020	00



PROJECT NO.		QUANTITY PER ASSY:	1
GROUP NO.		ENGINEER: ABR	DATE: 5-10-02
QTY. OF ASSY		DRAWN BY: ABR	DATE: 5-10-02
		CHECKED: DATE:	
		DWG. NO:	50D0080
		DE-BURR ALL SHARP EDGES	
		CLEAN AND	
		ANGLE: ±1°	
		FRACTION: ±1/32"	
		DECIMAL: ±0.015"	
		TOLERANCE	

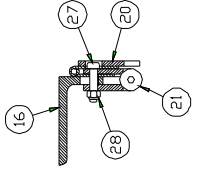


SYSTEC CORPORATION
PALLET LOADING DEVICE
PRIMARY FRAME ASSEMBLY
84" W. HEAD X 72" B.F.

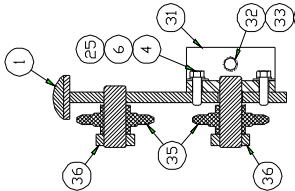


ITEM	QTY	DESCRIPTION	NUMBER	CR
1	1	PLD SECONDARY FRAME ASSEMBLY X 96" W.	5001055	
2	12	PLD LOAD SUPPORT BAR WELDMENT	5000045	
3	2	WASHER, FLAT LSS 3/8"	5000045	
4	22	NUT, NYL INS LOCK 3/8-16	800-0234	
5	24	WASHER, SPLIT LOCK 3/8"	790-0234	
6	24	WASHER, SPLIT LOCK 3/8"	800-1235	
7	12	PLD PALLET FORK	5000001	
8	24	PLD MAIN HEAD DRIVE SHAFT X 100-2/8" L.	5000074	
9	1	SPRINGER - 601.28 TAPER LOCK W/4 KL 2012 X 1-3/8" TL BSHG	500-1200	
10	3	BEARING, FLANGE BLOCK 2-BOLT 1-3/8" BORE W/SETSCREWS	580-2030	
11	6	WASHER, FLAT LSS 1/2"	500-1245	
12	6	NUT, NYL INS LOCK 1/2-13 X 1-1/2" L.	800-0234	
13	4	GEAR MOTOR - SKLE065AK-601.4BREHL 68.371 RATIO 1HP	501-0701	
14	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	
15	1	PLD HEAD ANGLE WELDMENT X 96" L.	5001003	
16	1	SHEET PUSHER TROLLEY ATT ANGLE - LH X MID X 45-1/16" L.	5001003	
17	1	PLD HEAD TIEBRACE ANGLE X 96" L.	5001005	
18	2	PLD SCALLOPED HEAD AND HINGE WELDMENT X 96" W	5001005	
19	3	SHEET PUSHER SCALLOPED HEAD AND HINGE WELDMENT X 96" W	5001005	
20	2	SHEET PUSHER MIDDLE TROLLEY ASSEMBLY	21C6034	
21	2	SHEET PUSHER OUTSIDE TROLLEY ASSEMBLY	21C6035	
22	4	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	
23	4	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	
24	4	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	
25	4	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	
26	4	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	
27	4	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	
28	4	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	
29	4	PUSHER CHAIN SUPPLIER BLOCK X 3" L.	21A0008	
30	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
31	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
32	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
33	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
34	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
35	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
36	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
37	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
38	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
39	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
40	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
41	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
42	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
43	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
44	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
45	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
46	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
47	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
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50	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
51	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
52	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
53	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
54	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
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56	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
57	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
58	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
59	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
60	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
61	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
62	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
63	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
64	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
65	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
66	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
67	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
68	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
69	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
70	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
71	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
72	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
73	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
74	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
75	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
76	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
77	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
78	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
79	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
80	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
81	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
82	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
83	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
84	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
85	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
86	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
87	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
88	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
89	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
90	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
91	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
92	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
93	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
94	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
95	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
96	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
97	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
98	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
99	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	
100	4	SPROCKET PULLEY - 60A13 1" ID W/EXTENDED INNER RING	790-0251	

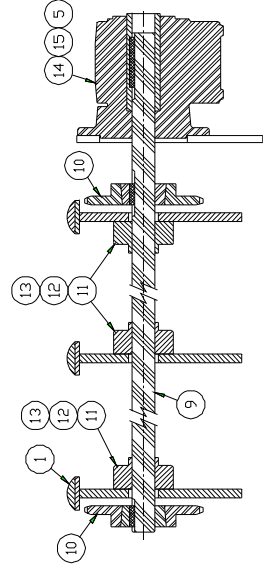
*ITEMS NOT SHOWN ON DRAWING



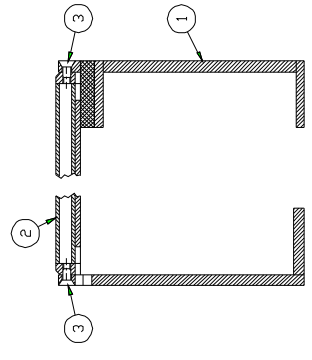
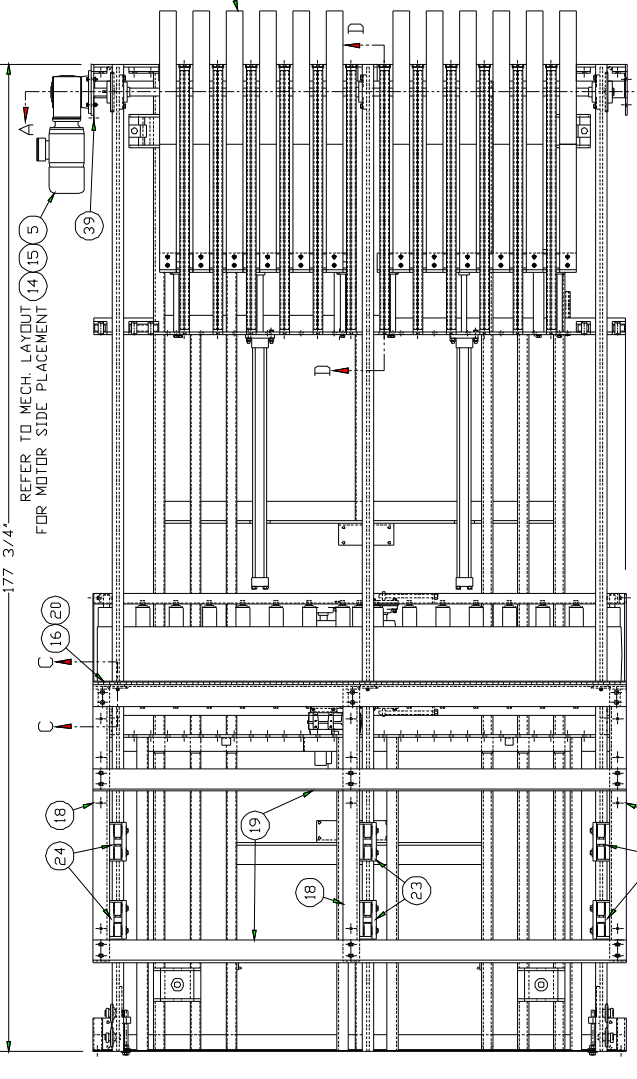
SECTION VIEW @ C-C.



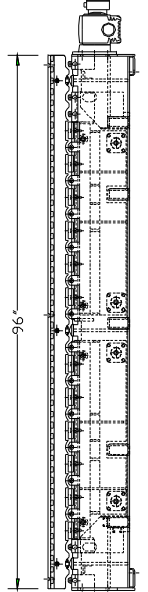
SECTION VIEW @ B-B.



SECTION VIEW @ A-A.

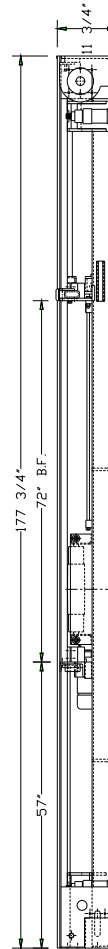
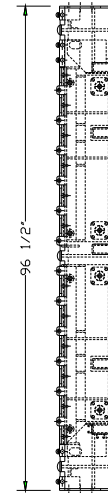
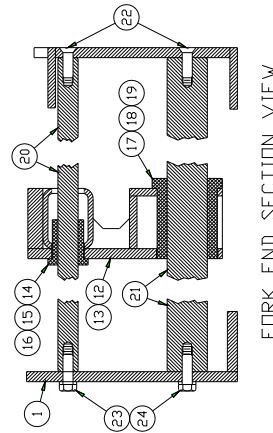
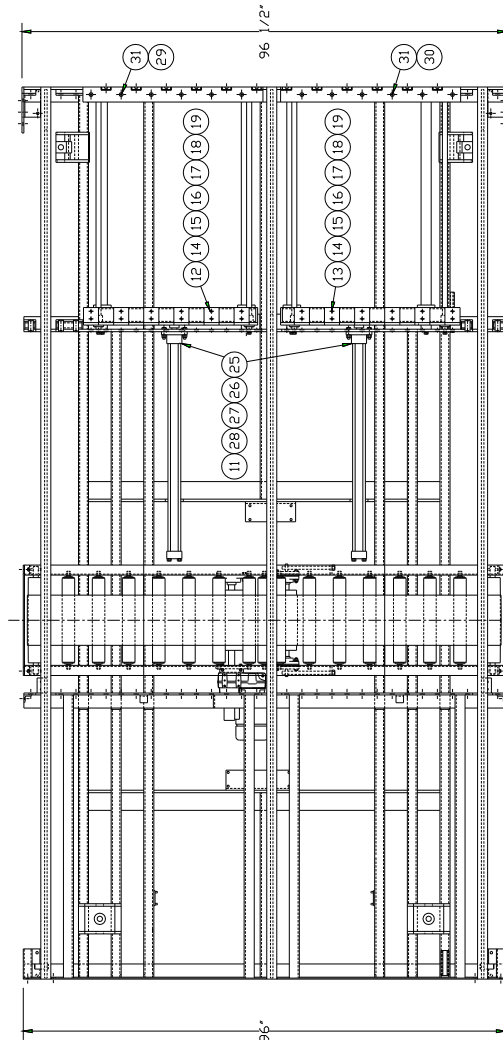


SECTION VIEW @ D-D.

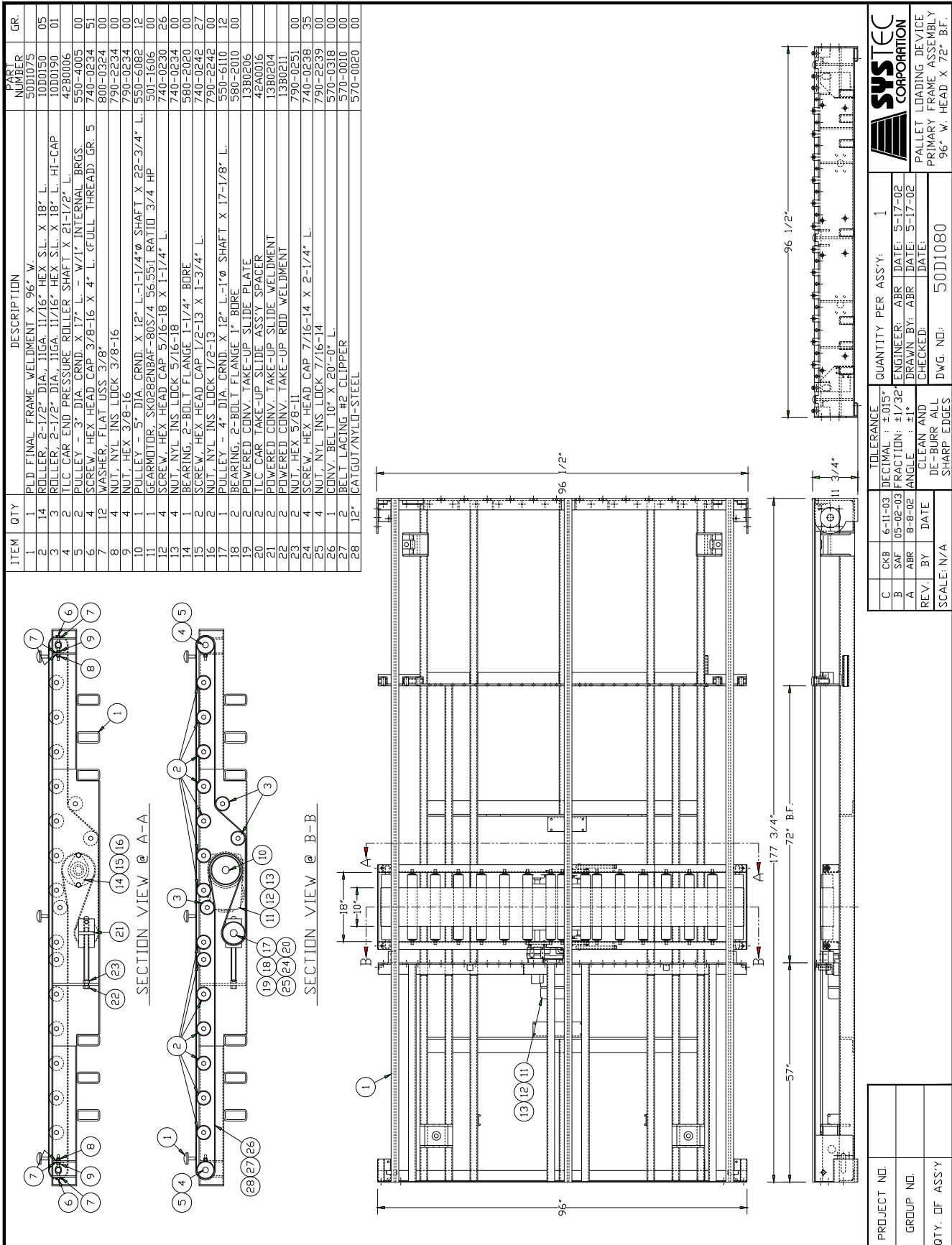


PROJECT NO.	GROUP NO.	QTY. OF ASSY
SYSTEC CORPORATION		
PALLET LOADING DEVICE		
HEAD AND FORKS ASSY		
96" W. HEAD X 72" BF.		
TOLERANCE		
DECIMAL : ±0.015"	ENGINEER: ABR	DATE: 5-20-02
FRACTION: ±1/32"	DRAWN BY: ABR	DATE: 5-20-02
ANGLE : ±1°	CHECKED:	DATE:
CLEAN AND	DWG. NO:	50D1090
DE-BURR ALL		
SHARP EDGES		
SCALE: N/A		

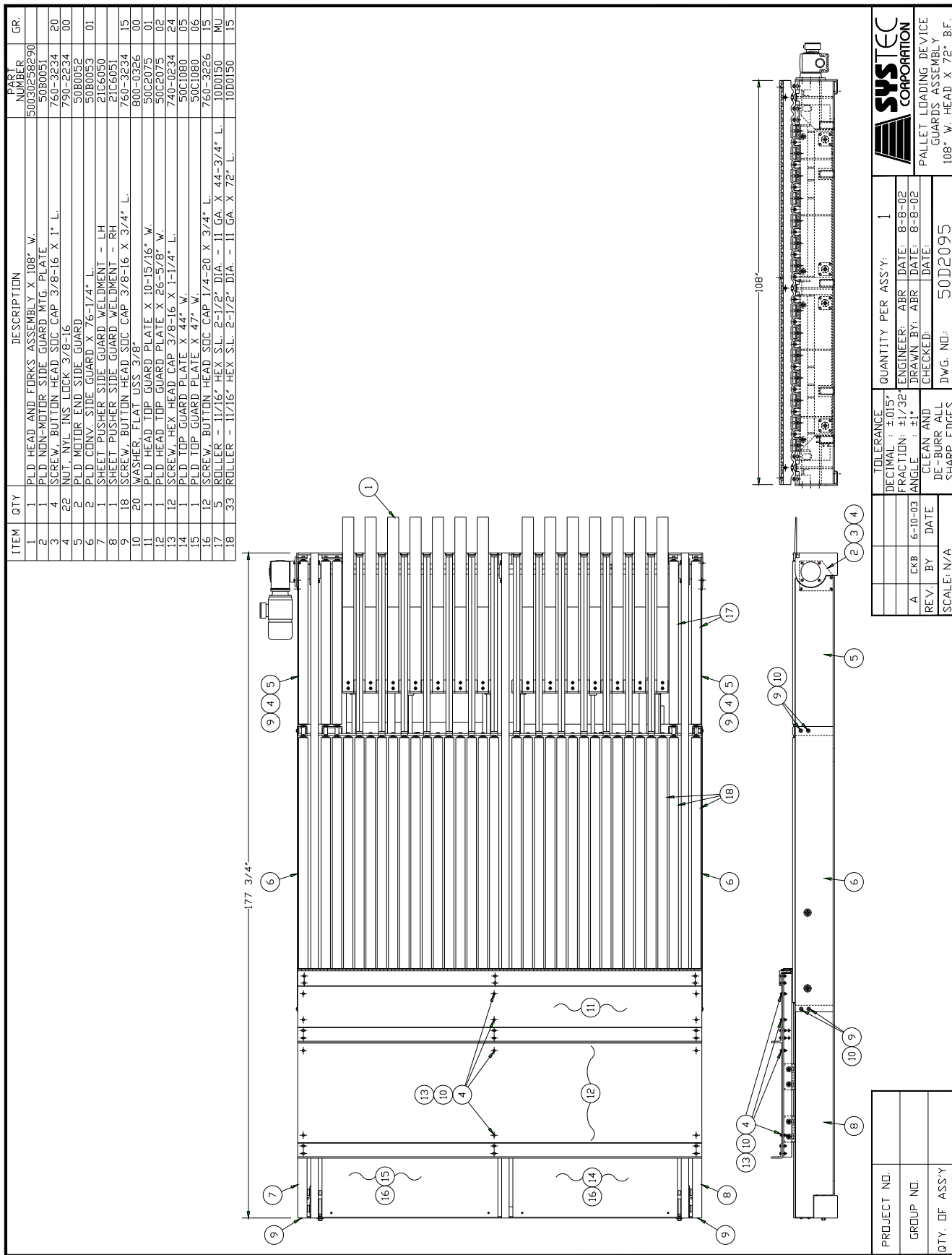
ITEM	QTY	DESCRIPTION	PART NUMBER	GR.
1	1	PLD PRIMARY FRAME ASSEMBLY X 96" W.	50D1080	
2	4	CYL. HYD. TELE-- 7" STROKE,		
3	4	NUT, JAM.		
4	4	PLD. LIFT CYLINDER BASE PLATE	50C0111	00
5	16	FOR. FLNG, 5/16-18 X 2-1/2"	740-0234	00
6	16	NUT, NTL, 5/16-18	800-0231	00
7	16	WASHER, FLAT, SAE, 5/16"		
8		OMITTED		
9		OMITTED		
10		OMITTED		
11	40	NUT, NTL, INS LOCK 1/2-13	790-2242	08
12	1	PLD FORK TRANSFER WELDMENT - LH	50C1045	
13	1	PLD FORK TRANSFER WELDMENT - RH	50C1046	
14	4	LINEAR BEARING - SQUARE FLANGE 1" ID	580-6525	01
15	16	SCREW, SDC HEAD CAP #10-24 X 5/8" L.	750-3220	00
16	16	WASHER, SPLIT LOCK #10	800-1220	00
17	4	BEARING, LINEAR - 2" ID, SQUARE FLANGE	580-6525	02
18	16	SCREW, SDC HEAD CAP 5/16-18 X 1" L.	750-0516	18
19	16	WASHER, SPLIT LOCK 5/16"	800-1230	00
20	4	PLD FORK TRANSFER GUIDESHAFT X 1" DIA.	50C0055	01
21	4	PLD FORK TRANSFER GUIDESHAFT X 2" DIA.	50C0055	02
22	8	SCREW, FLAT HEAD SDC CAP 1/2-13 X 1-1/2" L.	770-3242	25
23	8	SCREW, HEX HEAD CAP 1/2-13 X 1-1/2" L.	740-0242	00
24	8	WASHER, SPLIT LOCK 1/2"	800-1242	00
25	2	CYL. HYD. - 40" STROKE, 2" BORE, 1" DIA. ROD	660-2003	40
26	2	FEMALE ROD CLEVIS - 3/4-16 THREADS	660-2022	00
27	2	PIVOT PIN - 3/4" DIA.	845-2025	00
28	8	SCREW, HEX HEAD CAP 1/2-13 X 2" L.	740-0242	31
29	1	PLD END FORK WEAR PAD - RH X 35-7/8" L.	50C1061	01
30	1	PLD END FORK WEAR PAD - LH X 35-7/8" L.	50C1061	02
31	12	SCREW, FLAT HEAD SDC CAP 3/8-16 X 1" L.	770-3234	20
32				



PROJECT NO.		QUANTITY PER ASSY:	1	SYSTEC CORPORATION
GROUP NO.		ENGINEER: ABR	DATE: 5-20-02	PALLET LOADING DEVICE
QTY. OF ASSY		DRAWN BY: ABR	DATE: 5-20-02	SECONDARY FRAME ASSY
		CHECKED: DATE:		96" W. HEAD X 72" BF.
		DE-BURR ALL	DWG. NO: 50D1085	
		SHARP EDGES		
		TOLERANCE		
		DECIMAL : ±.015"		
		FRACTION: ±1/32"		
		ANGLE : ±1°		
		CLEAN AND		
		SCALE: N/A		

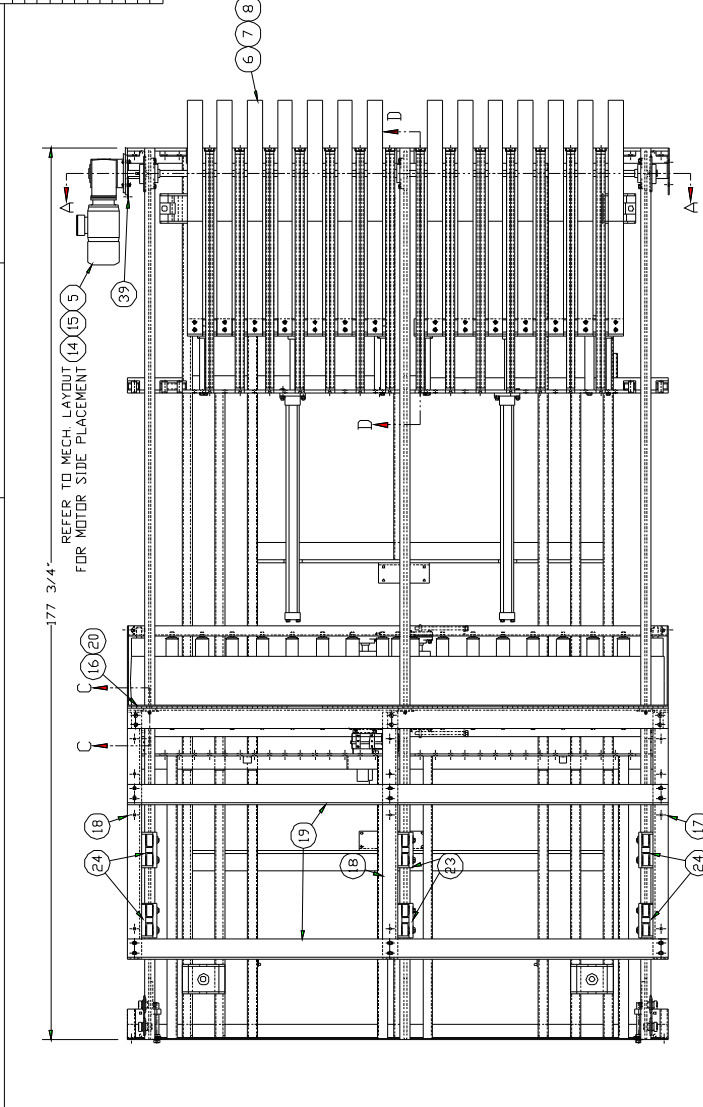
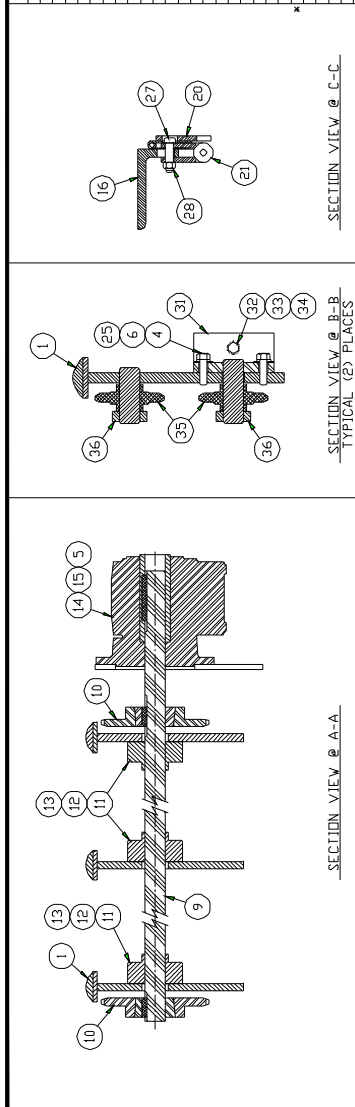


PROJECT NO.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																		</	
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ITEM	QTY	DESCRIPTION	PART NUMBER	GR.
1	1	PLD SECONDARY FRAME ASSEMBLY X 108" W.	50000250285	00
2	1	PLD LADY SUPPORT BAR WELDMENT	5000045	00
3	1	WASHER FLAT USS 3/8"	800-0362	00
4	2	WASHER FLAT USS 3/8"	800-0362	00
5	2	NUT NL INS LOCK 3/8-16	790-2234	00
6	2	WASHER SPLIT LOCK 3/8-16	800-1235	00
7	2	WASHER SPLIT LOCK 3/8-16	800-1235	00
8	2	WASHER SPLIT LOCK 3/8-16	800-1235	00
9	1	PLD MAIN HEAD DRIVESHAFT X 112-3/8" L.	5000071	03
10	2	SPURGEON - 60112-8 TAPER LOCK W/6311, 2012 X 1-3/8" I.D. BSHG	590-1200	01
11	2	BEARING PLATE BLOCK 2-BOLT 1-3/8" BORE W/8 SCREWS	590-2000	00
12	2	WASHER SPLIT LOCK 1/2"	800-1235	00
13	2	WASHER SPLIT LOCK 1/2"	800-1235	00
14	1	ARMATURE - SK1000-94-80.4 BSHG, 683/71 RATIO 1HP	500-1701	00
15	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
16	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
17	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
18	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
19	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
20	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
21	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
22	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
23	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
24	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
25	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
26	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
27	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
28	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
29	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
30	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
31	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
32	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
33	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
34	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
35	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
36	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
37	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
38	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12
39	1	SCREW, HEX HEAD CAP 3/8-16 X 1-1/2" L.	740-0234	12

*ITEMS NOT SHOWN ON DRAWING



PROJECT NO.

GROUP NO.

QTY. OF ASSY

TOLERANCE
DECIMAL : ±.015"
FRACTION : ±1/32"
ANGLE : ±1°

CLEAN AND
DE-BURR ALL
SHARP EDGES

SYSTEC CORPORATION

PALLET LOADING DEVICE
HEAD AND FORKS ASSY
108" W HEAD X 72" BF.

QUANTITY PER ASSY: 1

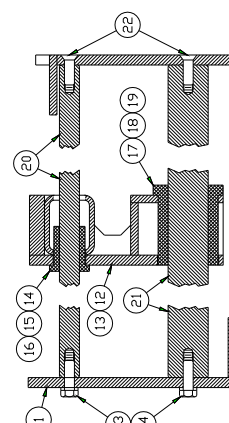
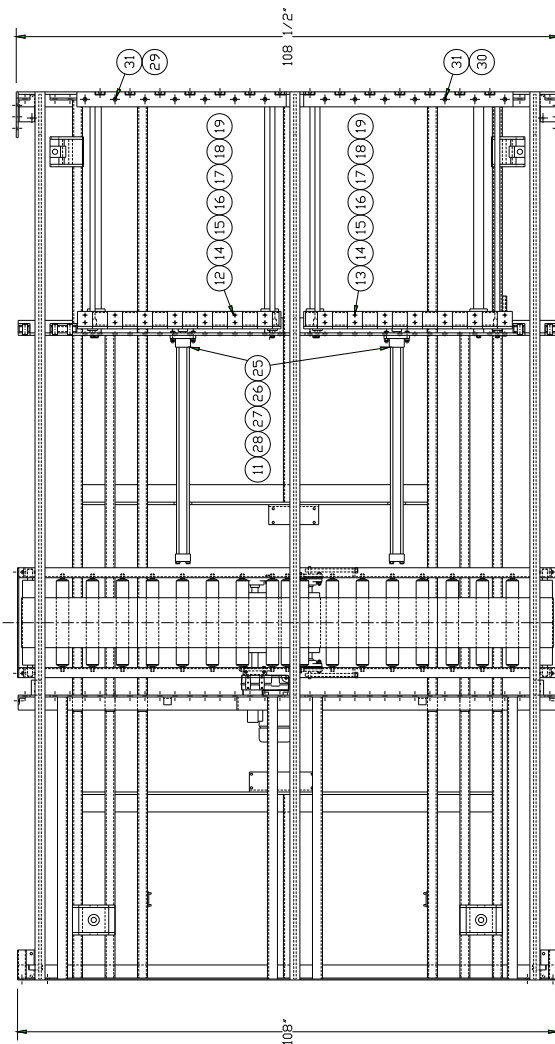
ENGINEER: ABR **DATE:** 5-21-02

DRAWN BY: ABR **DATE:** 5-21-02

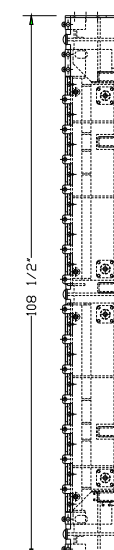
CHECKED: **DATE:**

DWG. NO.: 50D2090

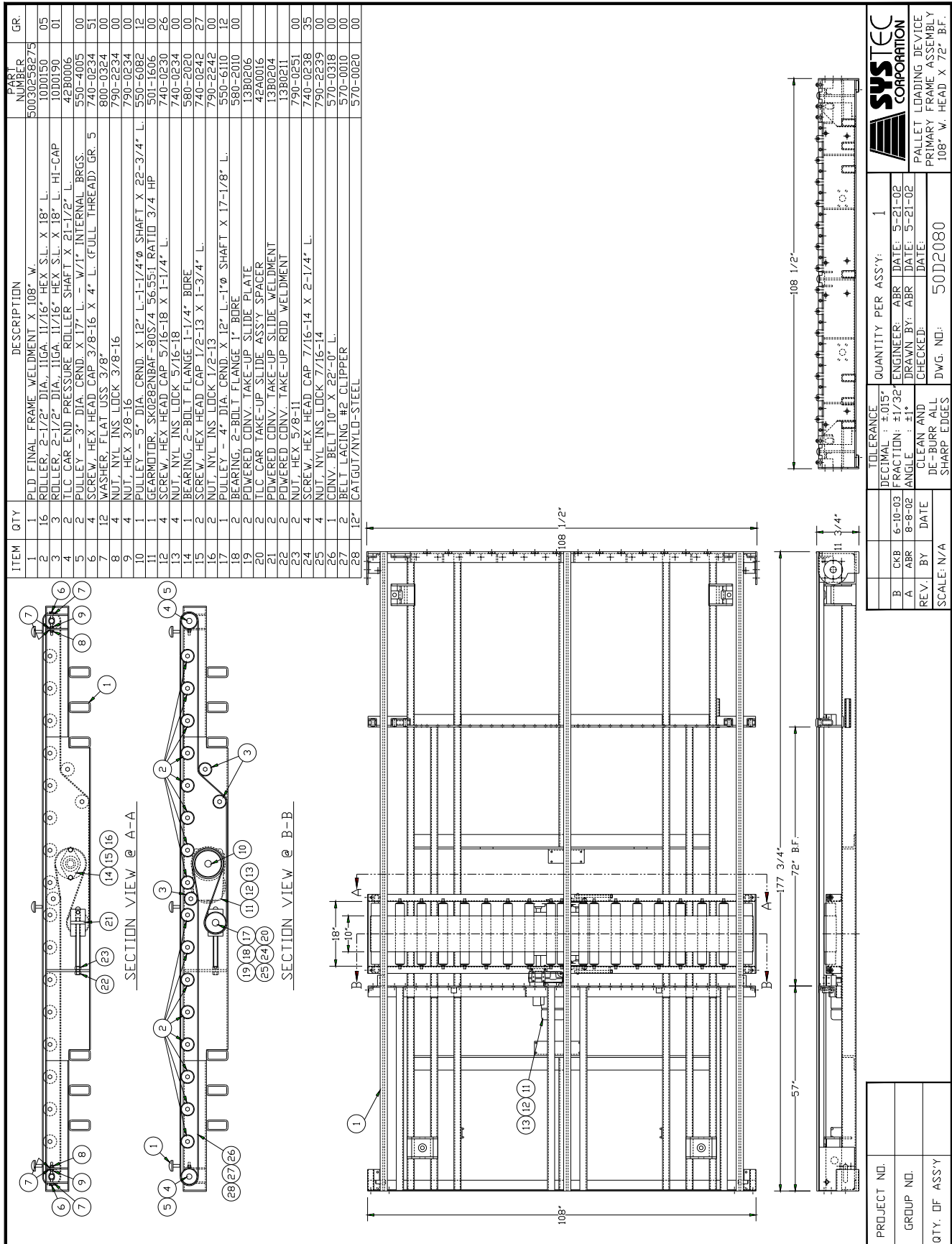
ITEM	QTY	DESCRIPTION	PART NUMBER	GR.
1	1	PLD PRIMARY FRAME ASSEMBLY X 96" W	50D060	-
2	4	CYL HYD TELE- 7" STROKE	-	-
3	4	NUT JAM	50C011	00
4	4	PLD LIFT CYLINDER BASE PLATE	740-0234	00
5	16	FCR-FHMC 5/16-18 X 2-1/2"	800-0231	00
6	16	NUT, NYL, 5/16-18	-	-
7	16	WASHER, FLAT, SAE, 5/16"	-	-
8	8	OMITTED	-	-
9	8	OMITTED	-	-
10	8	OMITTED	-	-
11	8	NUT, NYL, INS LOCK 1/2-13	790-2242	08
12	1	PLD FORK TRANSFER WELDMENT - LH	50C2045	-
13	1	PLD FORK TRANSFER WELDMENT - RH	50C2046	-
14	1	LINEAR BEARING - SQUARE FLANGE 1" ID	590-6525	01
15	16	SCREW, SOC HEAD CAP #10-24 X 5/8" L	750-3220	00
16	16	WASHER, SPLIT LOCK #10	800-1220	00
17	16	SCREW, LINEAR - 2" DIA, 5/16-18 X 1" L	790-6525	02
18	16	WASHER, SPLIT LOCK 5/16"	800-1236	00
19	16	SCREW, LINEAR - 2" DIA, 5/16-18 X 1" L	790-6525	02
20	4	PLD FORK TRANSFER GUIDE SHAFT X 1" DIA	50C0055	01
21	4	PLD FORK TRANSFER GUIDE SHAFT X 1" DIA	50C0055	02
22	8	SCREW, FLAT HEAD SOC CAP 1/2-13 X 1-1/2" L	770-3242	25
23	8	SCREW, FLAT HEAD SOC CAP 1/2-13 X 1-1/2" L	770-3242	28
24	8	WASHER, SPLIT LOCK 1/2"	800-1242	00
25	2	CYL, HYD - 40" STROKE, 2" BORE, 1" DIA, RDD	660-2003	40
26	2	PLD END GUARD CAP 3/4" DIA, 3/4-16 THREADS	840-2056	00
27	2	PLD END GUARD CAP 3/4" DIA, 3/4-16 THREADS	840-2056	00
28	8	SCREW, HEX HEAD CAP 1/2-13 X 2" L	740-0242	31
29	1	PLD END FORK WEAR PAD - RH X 41-7/8" L	50C2061	01
30	1	PLD END FORK WEAR PAD - LH X 41-7/8" L	50C2061	02
31	14	SCREW, FLAT HEAD SOC CAP 3/8-16 X 1" L	770-3234	20
32				



FORK END SECTION VIEW



PROJECT NO.		QUANTITY PER ASSY:	1	SYSTEC CORPORATION
GROUP NO.		ENGINEER: ABR	DATE: 5-21-02	PALLET LOADING DEVICE
QTY. OF ASSY		DRAWN BY: ABR	DATE: 5-21-02	SECONDARY FRAME ASSY
		CHECKED: DATE:		108" W. HEAD X 72" BF.
		DWG. NO:	50D2085	
		SCALE: N/A		
		REV. BY	DATE	
		CLEAN AND		
		DE-BURR ALL		
		SHARP EDGES		
		TOLERANCE		
		DECIMAL : ±0.015"		
		FRACTION : 1/32"		
		ANGLE : ±1°		
		REV. BY	DATE	
		CLEAN AND		
		DE-BURR ALL		
		SHARP EDGES		



PROJECT NO.		QUANTITY PER ASSY: 1	
GROUP NO.		ENGINEER: ABR DATE: 5-21-02	
QTY. OF ASS'Y		DRAWN BY: ABR DATE: 5-21-02	
		CLEAN AND CHECKED: DATE:	
		DWG. NO: 50D2080	
		TOLERANCE: DECIMAL: ±.015"	
		FRACTION: ±1/32"	
		ANGLE: ±1°	
		DE-BURR ALL SHARP EDGES	

SYSTEC CORPORATION	
PALLET LOADING DEVICE	
PRIMARY FRAME ASSEMBLY	
108" W. HEAD X 72" BF.	

This maintenance schedule is intended to cover all basic types of conveyor and related devices and components. Although your system may not have all the parts listed below, this schedule should help in identifying those components or parts that may require service or inspection. Should you need assistance in identifying the location of some of these components or inquire about how to perform a type of system check, contact **SYSTEC's** Customer Service Department at the number provided below.

ROUTINE MAINTENANCE SCHEDULE						
ITEM	INSPECTION OR SERVICE REQUIRED	500 HRS.	1,000 HRS.	2,500 HRS.	5,000 HRS.	10,000 HRS.
Gearmotor	Clean, Check for Noise, Leaks and Mounting					
	Check Oil Level					
	Change Oil					
Bearings	Check Roller Bearings for Noise					
	Check Pillow Block and Flange Block bearings for Noise, Mounting and Lubrication					
Belt	Check for Belt Wear, Tracking and Tension					
Chains	Check Tension, Wear, Lubrication and Adjustment					
Wire Cables	Check Tension, Wear and Adjustment					
Springs	Check Tension, Wear and Adjustment					
Sprockets	Check Alignment, Wear and Mounting					
Pulleys	Check Alignment, Wear and Mounting					
UHMW Blocks & Pads	Check for Wear and Fit					
Cams & Rollers	Check for Wear and Alignment					
Transfer Rails	Clean with Degreaser					
Photoeyes	Clean with Soft Cloth or Dry High Pressure Air					
Limitswitches	Clean Debris and Check Arm for Free Movement					
Proximity Switch	Clean Debris and Check for Proper Operation					
Pendant Switch	Check for Proper Operation					
Lockout Switch	Check for Proper Operation and Safety Labels					
Foot Switch	Check for Proper Operation					
Foot Valve	Check for Proper Operation					
Strobe Light	Check for Proper Operation					
Sound Alert	Check for Proper Operation					
Motion Detector	Check for Proper Operation					
Load Measuring Device	Check for Proper Operation					
Air Filter/Regulator	Check and Clean Trap and Adjust Pressure					
Solenoid Valve	Check for Air Leaks					
Airmount	Check for Air Leaks					
Air Supply Line	Check for Air Leaks					