

PERFORMANCE LINE SHAFT CONVEYOR



SERVICE AND MAINTENANCE MANUAL

TABLE OF CONTENTS

DESCRIPTION	PAGE NO.
Performance Line Shaft Conveyor	2
Conveyor Safety	3
Service and Parts	5
Service and Parts, Component Information	9
Parts Information	15
Maintenance Schedule	18

LIST OF ILLUSTRATIONS

A Performance Line Shaft Conveyor (PLSC)	2
B Performance Line Shaft Conveyor (PLSC)	3
C Safety Label Locations	3
D Lockout Switch for Safety	4
E PLSC Splice with Multi-section Drive	5
F PLSC Drive Shaft Assembly	6
G. PLSC Leg Assembly	7

LIST OF ASSEMBLY DRAWINGS

1 PLSC Leg Assembly	9
2 PLSC Drive Assembly	10
3 PLSC 120" Section Assembly	11
4 PLSC 60" Section Assembly	12
5 PLSC Final 4-Bar BTB Assembly	13
6 PLSC 90° Curve Assembly	14

When order parts, please call, fax or e-mail Systec at the address and/or the numbers shown below.

SYSTEC Conveyors Parts Department
10010 Conveyor Drive
Indianapolis, IN 46236

Tel 317.890.9230
1.800.578.1755
Fax 317.890.9232

On The Net @ <http://www.systecconveyors.com/>

PERFORMANCE LINE SHAFT CONVEYOR

The information within this manual covers **SYSTEC** Performance Line Shaft Conveyor. **SYSTEC's** PLSC is a “zero pressure” accumulating bundle conveyor, also known as “Line Shaft” conveyor. The shaft runs full length of the conveyor and powers the rollers with spools and belts. When pressure is applied to the load on the conveyor, the spools will slip on the shaft. This allows load to accumulate with very little back pressure on the product.

Illustration A shows a typical “straight” powered conveyor line. A conveyor line, powered by a single drive, can be made up of several intermediate sections of conveyor. It can also include curves and other material movement devices for load transfer and manipulation.

PERFORMANCE LINE SHAFT CONVEYOR



ILLUSTRATION A

Notes:

Shown is a single, self-contained section. This application requires an “end-of-line” conveyor drive with inset leg set. Multi-section drives are located between conveyor sections as illustrated later in this manual..

CONVEYOR SAFETY

Where safety is concerned, conveyor is no different from any machinery or processing equipment. In many cases, the conveyors can start running without notice. Additionally, some conveyor rollers are "free turning", and, in any case, injury could result from anyone sitting, standing, or walking on a conveyor line. **SYSTEC** Conveyors believes that a Conveyor Safety session should be incorporated into your existing safety training program for all personnel that work on or around conveyor systems.

Below is Illustration B, showing the safety labels provided with **SYSTEC**'s Conveyor Systems. These labels should be installed in the appropriate locations to alert personnel of the potential hazards caused by improper use of the conveyor equipment.

Should you need additional labels, please contact **SYSTEC**'s Parts Department at the address or phone numbers shown in the front of this manual.



ILLUSTRATION B

Notes:

Shown is a variety of caution, warning, and danger labels for application on the equipment as determined necessary in quantity and location by Systec and/or the end user.

All Motor and Photoeye location labels should be marked to identify the motor or photoeye numbers as shown on the electrical drawings.

CONVEYOR SAFETY (continued)

Lockout is a very important part of your Maintenance and Service Department procedures. **SYSTEC** provides Lockout Switches, as shown in illustration E, for each drive motor provided on each conveyor line and device.

LOCKOUT SWITCH FOR SAFETY



ILLUSTRATION D

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.

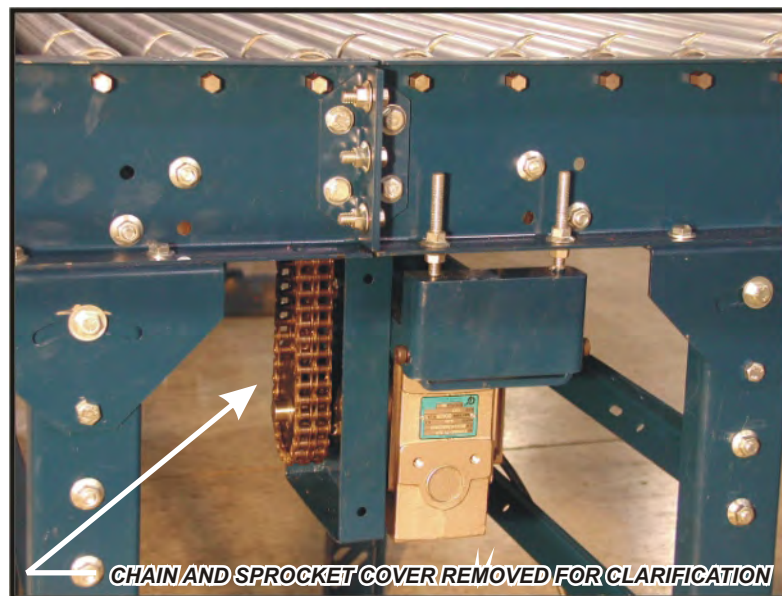
SERVICE AND PARTS

The drawings within this section are designed to help you understand how components of the conveyor are assembled and disassembled. The pictures also allow you to quickly and easily identify the parts that may need to be serviced and/or repaired.

The parts identification page(s) provide the corresponding part numbers to the drawings, and indicates recommended quantities for each conveyor line, recommended spare parts, description, part number, and order quantity. This is a faxable form, for your convenience, to order parts for stock or for needed replacement parts. Simply fill in the order quantity, the necessary purchase order number, and shipping information. Then fax the form to **SYSTEC** Conveyor's number shown on the form. An Order Acknowledgment will be faxed back with the estimated ship date and pricing information.

The drawing below shows a typical splice of conveyor sections with a "multi-section" drive assembly. The "end-of-line" drive requires a single sprocket and chain drive, where the multi-section drive has the double sprocket and chain configuration as shown below.

PERFORMANCE LINE SHAFT CONVEYOR SPLICE WITH MULTI-SECTION DRIVE



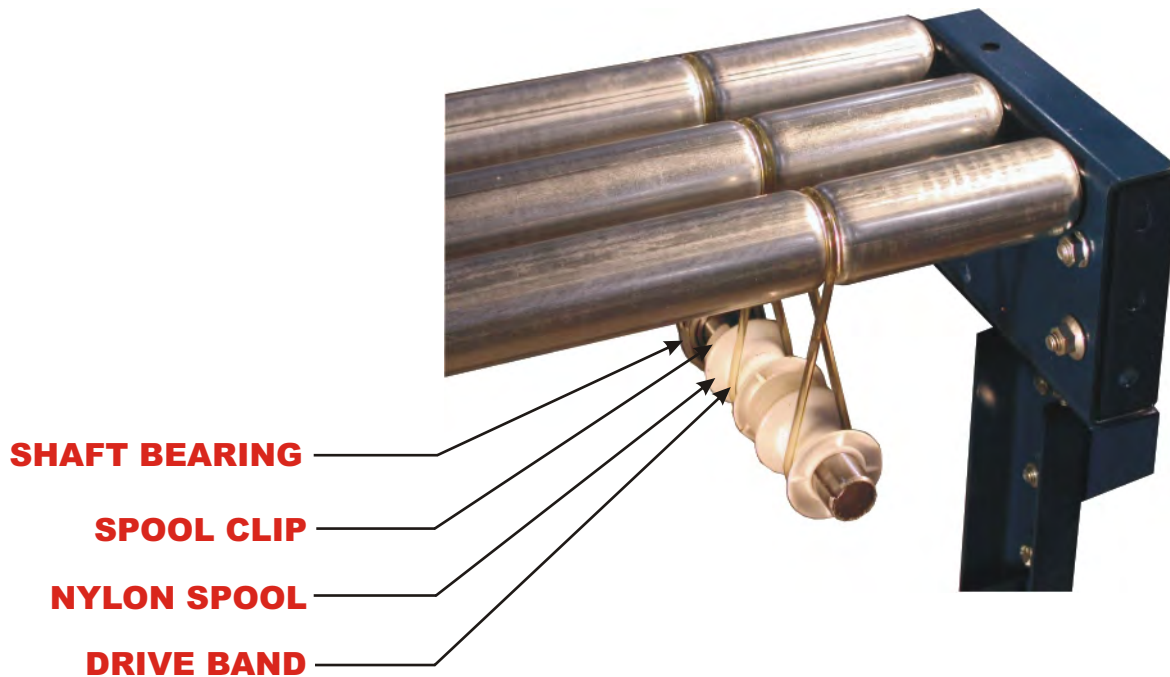
ASSEMBLY DRAWING 1

Notes:

*Allow 1/2" total slack in chain(s) when tensioning drive mounting.
Also be sure parallel alignment of gearmotor shaft is true with
conveyor line shaft.*

SERVICE AND PARTS (continued)

Internally, the lineshaft is equipped with mounting bearings, nylon spools, and spool clips. The bearings are sealed for life and will only need to be replaced after extensive use. The nylon spools drive the load carrying rollers through tension from the drive bands. The spools are engineered to slip on the shaft as load pressure builds on the load carrying rollers, or as loads are accumulating on the conveyor line. This is commonly referred to as “zero-pressure accumulation”. See illustration ___ for component reference.



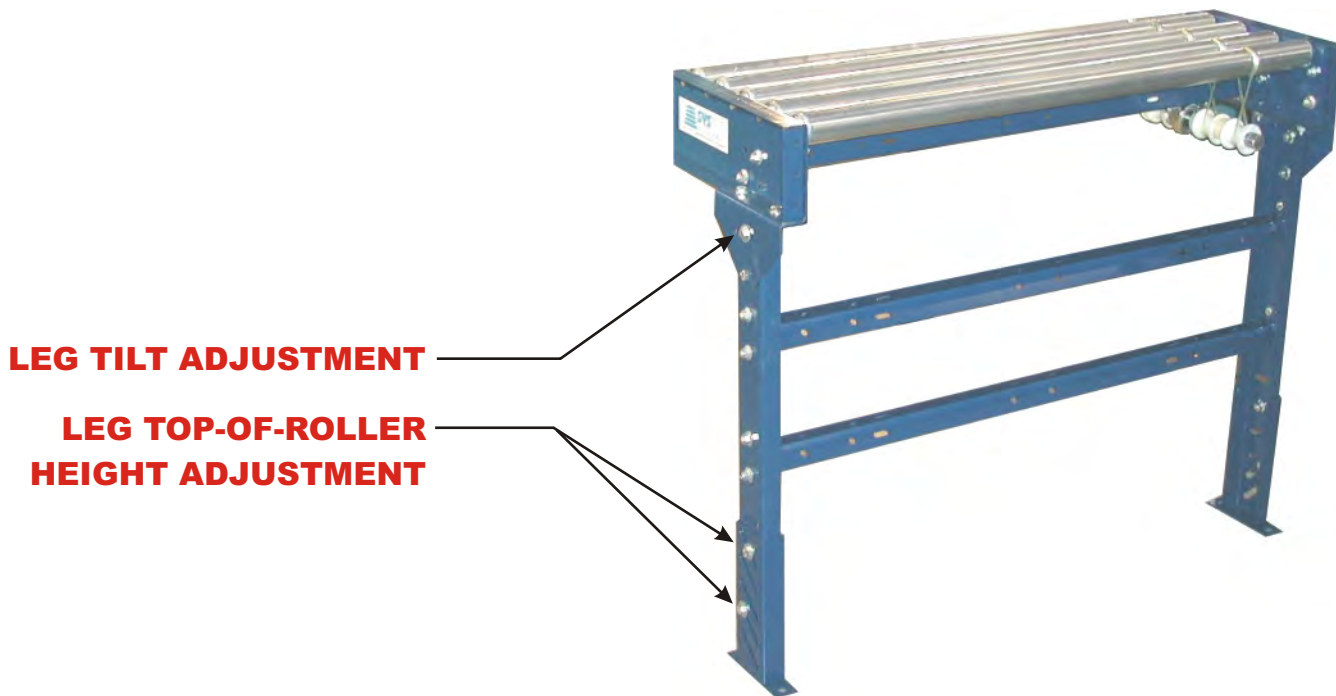
ASSEMBLY DRAWING 1

Notes:

Allow 1/2" total slack in chain(s) when tensioning drive mounting.
Also be sure parallel alignment of gearmotor shaft is true with conveyor line shaft.

SERVICE AND PARTS (continued)

PLSC has adjustable leg sets. The standard legs are adjustable from a range of 28" TOR (top-of-roller) to 42" TOR (Your TOR requirements, and provided legs may differ from standard. Refer to your Mechanical Layout for leg heights provided with your system). The leg tops are also tilt adjustable to compensate for inclines, declines, or floor surface inconsistencies.



ASSEMBLY DRAWING 2

Notes:

Legs can be end mounted or can be used as support for two adjoining sections of conveyor.

ORDERING PARTS

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.

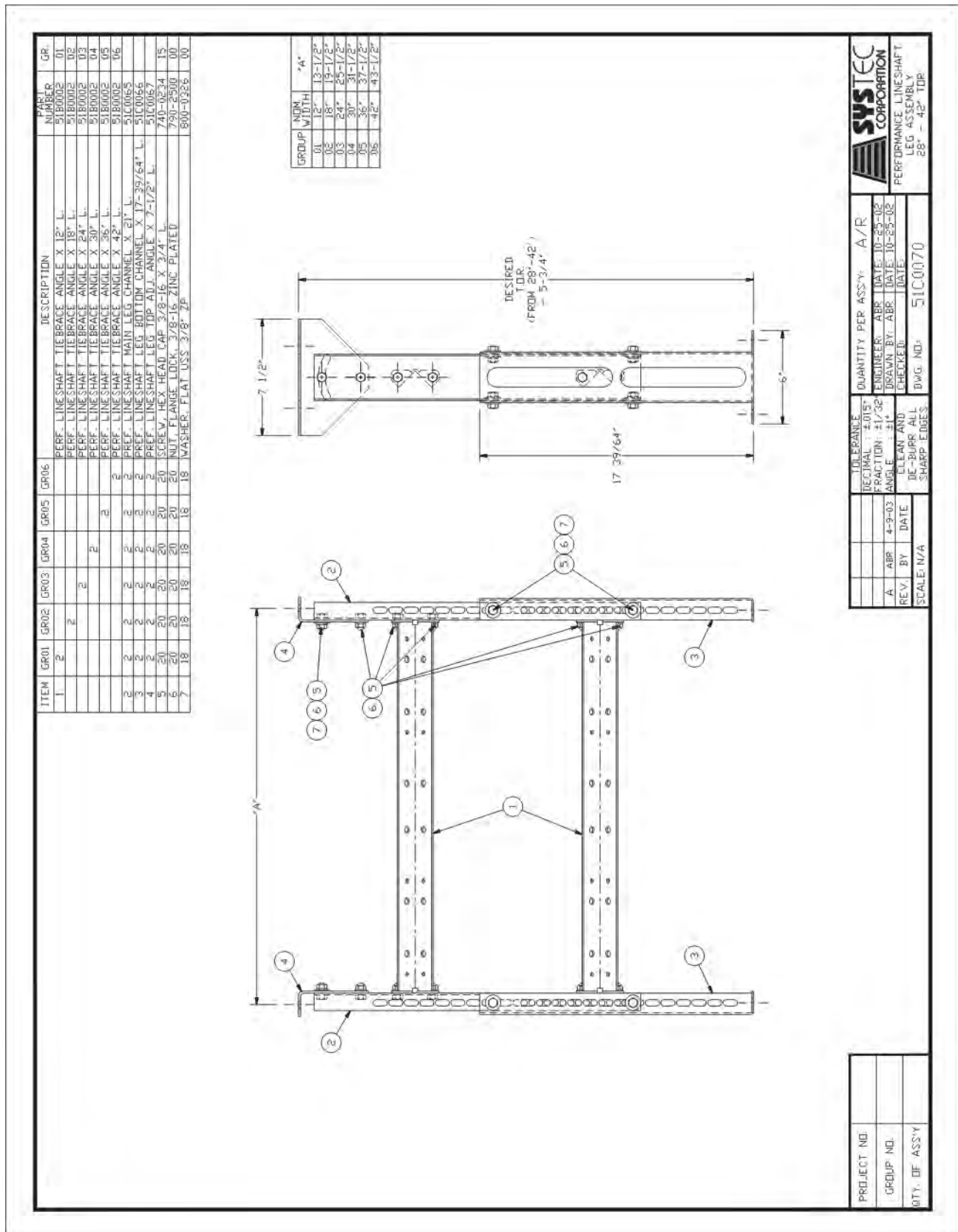
After your message is completed, the pager of the person on call at Systec will be activated. The person will then return your phone call.

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

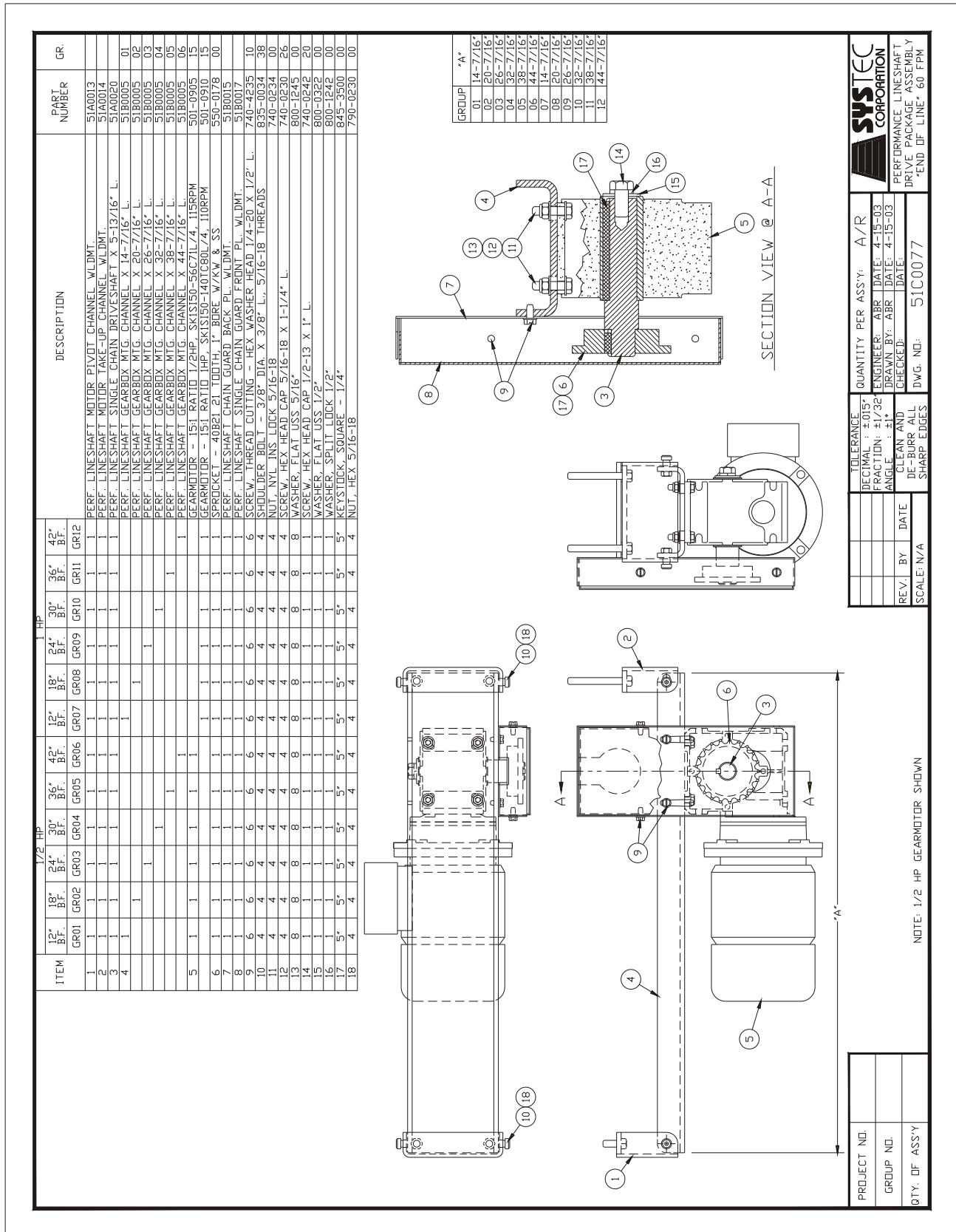
ORDER CONFIRMATION:

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.

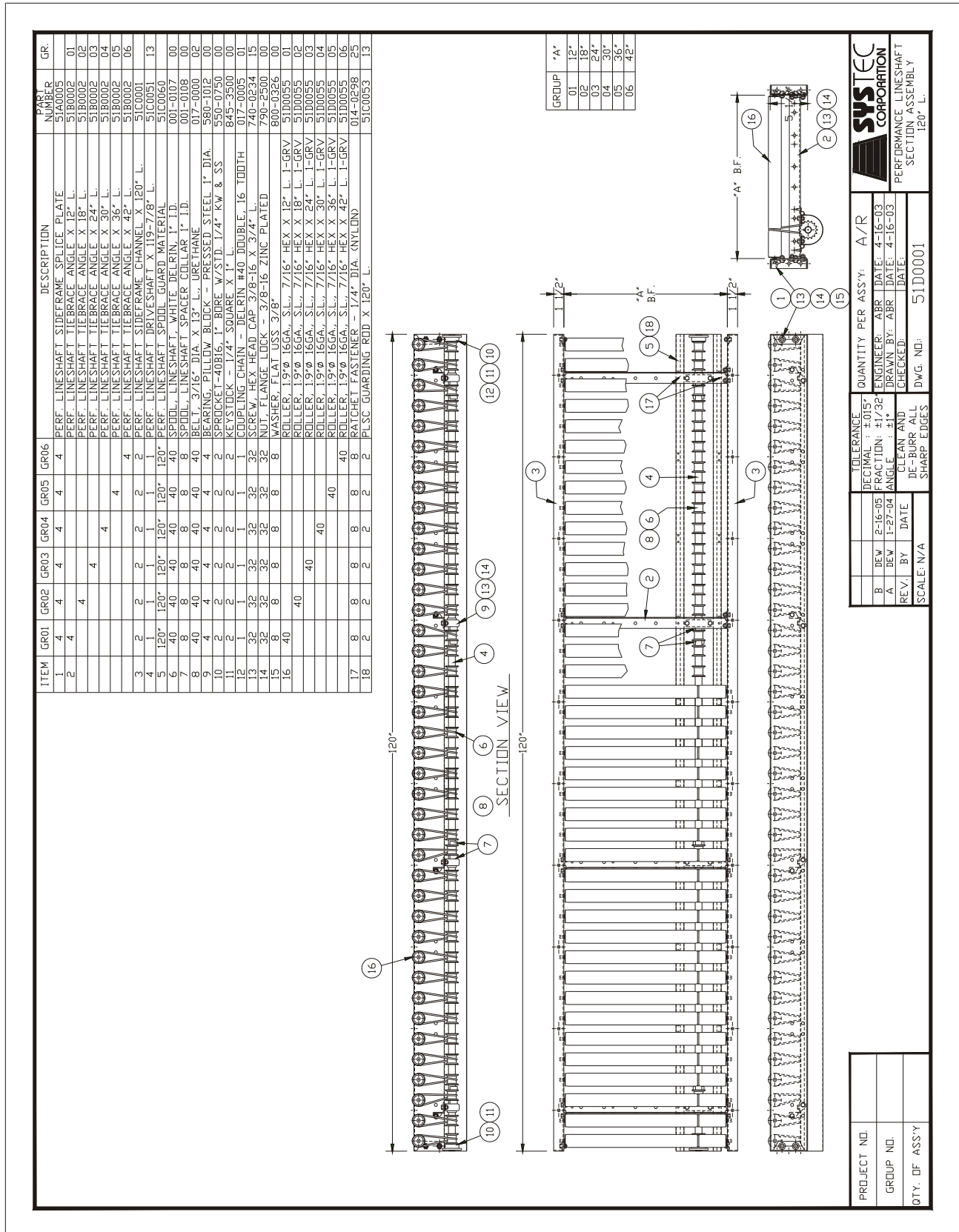
reference parts drawing



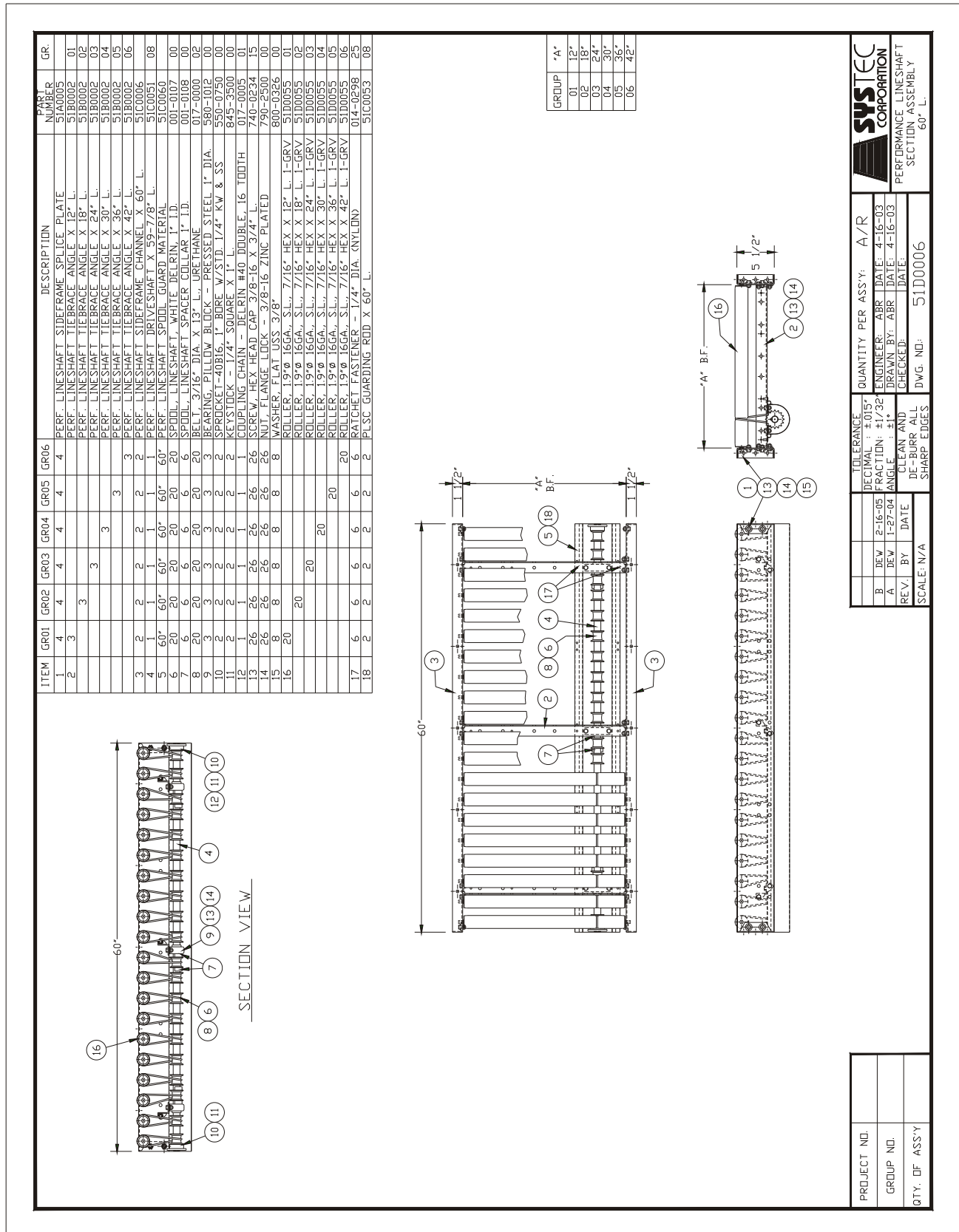
reference parts drawing



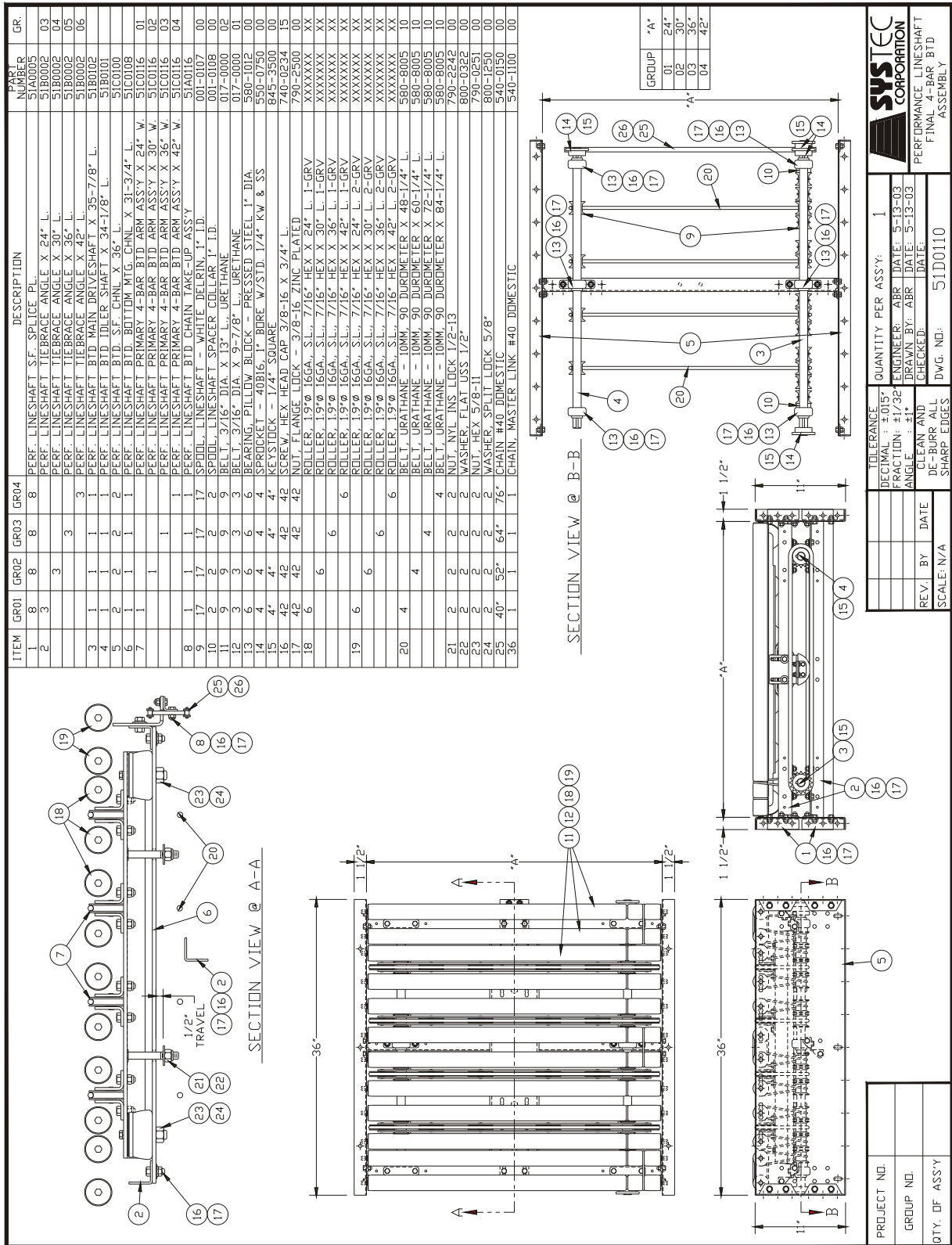
reference parts drawing



reference parts drawing



reference parts drawing



reference parts drawing

