



# Owner's Manual

## Chain Transfer Conveyor



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LEWCO, Inc.

# Warranty

## Conveyor Products

1. LEWCO, Inc.'s warranty becomes null and void if payment in full is not received for goods and services.
2. Unless separately agreed to otherwise, warranty is for 1 year or 4200 hours, whichever comes first, free from defects by faulty material or workmanship, effective from Buyer's receipt of goods and services
3. LEWCO, Inc. will replace, F.O.B. Sandusky, Ohio, or repair equipment proving defective in material and workmanship  
Defective parts need to be shipped back to LEWCO, Inc. for inspection at Buyers cost
4. Failure due to abuse, overloading, maintenance neglect, exposure to corrosive or abrasive materials, operation under any degree of dampness, or improper use shall not be subject to this warranty
5. Any modification to equipment or systems without LEWCO, Inc.'s written consent voids this warranty
6. Component parts not of LEWCO, Inc.'s manufacture will be covered by the original manufacturer's warranty and not LEWCO, Inc.'s. In this case, contact the nearest authorized service representative of the manufacturer
7. Standard warranty does not include labor to remove and/or install defective equipment
8. If LEWCO, Inc.'s service is required for additional assistance, contact our customer service department; labor will be charged at prevailing rate plus travel expenses
9. LEWCO, Inc. shall not be liable for loss of profits, delays or expenses incurred by failure of said parts, whether incidental or consequential
10. LEWCO, Inc. shall not be liable for failure of the goods to comply with federal, state or local laws
11. See LEWCO, Inc.'s **GENERAL TERMS AND CONDITIONS** for additional warranty detail



## INTRODUCTION

Thank you for choosing LEWCO, Inc. for your material handling needs. This manual has been prepared by LEWCO engineers for use in familiarizing personnel with the design, installation, operation, and maintenance of LEWCO Conveyor Products. Information presented herein should be given careful consideration to assure safe, optimum performance of the equipment. Manual should always be accessible to the operators for quick reference.

This equipment has been designed and manufactured in accordance with applicable National Codes and Standards in effect as of the date of manufacture. It is the responsibility of the end user to update equipment as necessary to comply with future code changes or revisions.

This manual should be used in conjunction with applicable drawing(s), data sheets, and component manufacturer's literature attached hereto that clarify specific features, installation, utility connections, operation, etc.

If you have any questions regarding this manual or the use of your LEWCO Conveyor Products, please contact us by phone at (419) 625-4014 ext. 4003 or by email at [conveyorsales@lewcoinc.com](mailto:conveyorsales@lewcoinc.com).

**NOTE:** The information in this manual is subject to change without notice and does not represent an obligation on the part of LEWCO, Inc. LEWCO does not assume any responsibility for any errors that may appear in this manual and under no circumstances will LEWCO be held liable for technical or editorial omissions made herein, nor for direct, indirect, special, incidental, or consequential damages resulting from the use or defect of this manual.



### **REQUIRED READING!**

**NOTICE:** No installation or operation of this equipment should take place until this manual has been studied and understood by the person(s) responsible for that work.



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## SECTION 1 – SAFETY

To reduce the possibility of injury to personnel operating, or in the vicinity of LEWCO conveying equipment, safety signs are posted at potential hazard points on the equipment. Examine this equipment and become familiar with potential hazard areas. Additionally, instruct all personnel to heed these potential hazard areas.

### 1-1 SAFETY SIGNS & DEFINITIONS

Manual-Specific Safety Symbol Definitions	
	Safety instruction where an electrical hazard is involved.
	Safety instruction where non-compliance would affect safety.
	Safety instruction relating to safe operation of the equipment (ATTENTION).
	Safety instruction where non-compliance could potentially result in a pinch point or a description of a known existing pinch point.
	Safety instruction where non-compliance could potentially result in a pinch point or a description of a known existing pinch point.
	Indicates a hazardous situation which, if not avoided, will result in death or serious injury. The signal word "DANGER" is to be limited to the most extreme situations. DANGER [signs] should not be used for property damage hazards unless personal injury risk appropriate to these levels is also involved.
	Indicates a hazardous situation which, if not avoided, could result in death or serious injury. WARNING [signs] should not be used for property damage hazards unless personal injury risk appropriate to this level is also involved.
	Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury. CAUTION [signs] without a safety alert symbol may be used to alert against unsafe practices that can result in property damage only.
	Indicates practices requiring attention, but unrelated to personal injury.
Equipment-Specific Safety Labels & Definitions	
	<b>DANGER:</b> Climbing, sitting, walking or riding on conveyor at any time will cause severe injury or death. Keep Off.
	<b>WARNING:</b> Servicing moving or energized equipment, can cause severe injury. LOCK OUT POWER before servicing.
	<b>WARNING:</b> Exposed moving parts can cause severe injury. LOCK OUT POWER before removing guard.
	<b>WARNING:</b> Moving equipment may cause severe injury. Keep Away.
	<b>WARNING:</b> Potential arc flash hazard.

## 1-2 CONTENT DEFINITIONS

**Arc Flash**: An arc flash is a phenomenon where a flashover of electric current leaves its intended path and travels through the air from one conductor to another, or to ground. The results are often violent and when a human is near the arc flash, serious injury and even death can occur.

**Safety Device**: An instrument, a control, or other equipment that acts or initiates action, which causes the conveyor to revert to a safe condition. This occurs in the event of equipment failure or another hazardous event.

**Emergency Stop**: Safety mechanism used to shut off machinery in an emergency, when it cannot be shut down in the usual manner.

**Gear Reducer**: Reduces and transmits motor speed to conveyor.

**Chain Box**: Guards against ingress of fingers, clothing, etc., into rotating equipment. Painted yellow to indicate immediate hazard if removed while conveyor is in operation.

### 1-3 SAFETY CONSIDERATIONS



## WARNING



- Disconnect and lockout electrical power and all other sources of energy before performing maintenance. Follow proper lockout/ tag out procedures. Know where arc flash is possible and take proper precautions.



- Long hair, jewelry, and loose clothing should be kept away from the conveyor while in operation. These are potential hazards that could cause entanglement.
- Do not operate equipment without proper guards in place, as bodily injury may result.



- Pinch points may exist. Inspect equipment for potential pinch points and use caution.



## CAUTION

- This equipment is to be operated by trained personnel only. Operators should be trained under normal and emergency conditions.
- Personnel who operate, service, or work near the conveyor should be instructed as to the location of stopping devices. Ensure stopping devices are always accessible and free of obstruction.
- Personnel who operate, service, or work near the conveyor should watch for and be aware of conveying hazards: sharp edges, protruding parts, pinch points, etc.
- Riding on conveyor is strictly prohibited, as serious injury may result.
- Prior to starting conveyor, ensure that all personnel are clear of the conveyor, all guards are in place, and inspect for foreign objects that could injure personnel or damage equipment.
- Operators should always alert personnel in the area prior to starting the conveyor.
- This equipment may create hazards in the work area in which it is installed. The owner is responsible for analyzing the installation of this equipment in order to determine proper warning signs to be posted in compliance with applicable OSHA standards.
- Conveyor should only be used to transport materials or items that it is designed to handle.
- Do not load conveyor beyond its designed handling capacity.
- Keep area around loading and unloading points of conveyor free from obstructions.
- After starting conveyor, make sure all areas of the conveyor are operating properly.
- Poor housekeeping practices cause accidents. Keep conveyor and surrounding area clean from spilled lubrications and other materials.
- Always exercise caution when using mechanical aids such as hoists, cables, and other equipment to install or perform maintenance on a conveyor. Damage can occur to the conveyor which could result in a dangerous condition after the conveyor is turned back on.



## 1-4 PPE (PERSONAL PROTECTIVE EQUIPMENT)

PPE (Personal Protective Equipment) required will be site and process specific. LEWCO, Inc. recommends conducting a detailed study of your installation and process to determine what PPE will be required for safe operation.

**Hearing Protection:** According to OSHA, protection against the effects of noise exposure shall be provided when the sound levels exceed those determined as unsafe.

**Safety Glasses:** It is recommended to wear safety glasses, as the potential for flying objects is present around rotating equipment.

**Steel Toe Boots (Metatarsals):** Nothing inherent to the conveyor or its process should require foot protection aside from the loading and unloading of the material. Use proper plant safety considerations for material handling and PPE.

**Gloves/Sleeves:** If the material being loaded/unloaded is sharp, protective gloves should be worn.

**Fall Protection:** Normal operation of the conveyor will not require the operator to be on top of the equipment. However, some maintenance and troubleshooting may require personnel to be more than 6' from the ground. If this is the case, proper fall protection must always be used.

## 1-5 EMERGENCY SHUTDOWN

In the event of an emergency, the following steps should be followed:

1. **PRESS EMERGENCY STOP BUTTON.** If access to emergency stop button(s) is restricted or emergency stop buttons were not provided, **TURN OFF THE ELECTRICAL DISCONNECT** providing power to the conveyor.
2. Depending on the severity of the issue, restrict access to the area until the issue has been resolved.

## 1-6 GUARDS & GUARDING

All LEWCO standard conveyor equipment is equipped with standard machine guarding methods. It is the responsibility of the owner, however, to ensure that proper guarding methods are present to comply with OSHA Standards – 29 CFR – 1910.212 Machinery and Machine Guarding. Special consideration should be given to areas where multiple pieces of equipment interface. The following links are provided for reference:

**1910.212(a): *Machine guarding.***

**1910.212(a)(1): *Types of guarding.*** One or more methods of machine guarding shall be provided to protect the operator and other employees in the machine area from hazards such as those created by point of operation, ingoing nip points, rotating parts, flying chips and sparks. Examples of guarding methods are barrier guards, two-hand tripping devices, electronic safety devices, etc.

**1910.212(a)(2): *General requirements for machine guards.*** Guards shall be affixed to the machine where possible and secured elsewhere if for any reason attachment to the machine is not possible. The guard shall be such that it does not offer an accident hazard in itself.



**1910.212(a)(3): Point of operation guarding.**

**1910.212(a)(3)(i):** Point of operation is the area on a machine where work is actually performed upon the material being processed.

**1910.212(a)(3)(ii):** The point of operation of machines, whose operation exposes an employee to injury, shall be guarded. The guarding device shall be in conformity with any appropriate standards thereof, or, in the absence of applicable specific standards, shall be so designed and constructed as to prevent the operator from having any part of his body in the danger zone during the operating cycle.

**1910.212(a)(3)(iii):** Special handtools for placing and removing material shall be such as to permit easy handling of material without the operator placing a hand in the danger zone. Such tools shall not be in lieu of other guarding required by this section, but can only be used to supplement protection provided.

**It is the responsibility of the owner of the conveyor to maintain guards and safety devices in a serviceable and operational condition. The owner is also responsible for maintaining warning signs/labels in legible/visible condition.**

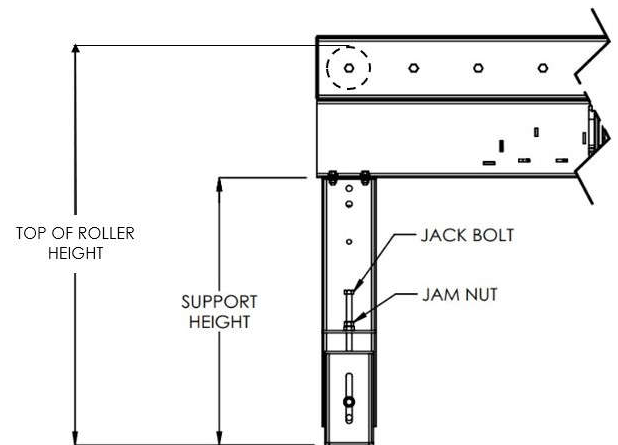
## SECTION 2 – INSTALLATION

### 2-1 RECEIVING & INSPECTION

- Check the bill of lading against the items and item quantities received.
- Examine the equipment for damage.
  - Report bill of lading discrepancies or damage immediately to the vendor and carrier.
  - Obtain a signed damage report from the carrier and send a copy to the vendor.
  - **Do not attempt to modify or repair damaged equipment without authorization from vendor.**
  - Do not return equipment to the factory without a written return authorization. Returns without written authorization will not be accepted.
- Move all crates to area of installation.
- Remove crating.
- Remove shipping supports, screws, guards, and any accessory equipment that may be fastened to the conveyor.

### 2-2 SUPPORT INSTALLATION

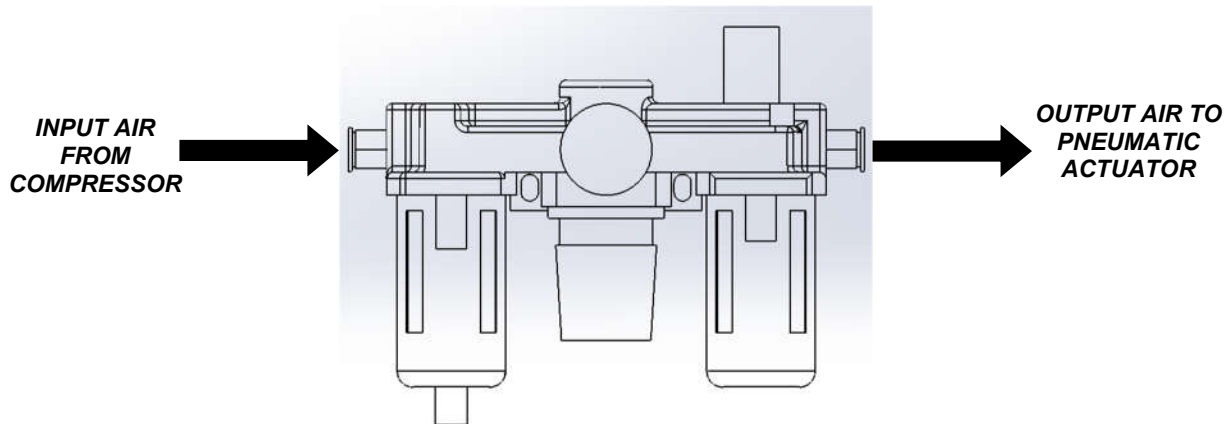
- Bolts for attaching the supports to the frame sections are shipped in a bag attached to the supports or in a separate box.
- Set the support height by loosening the jam nut, then using the adjustable jack bolt – see *Figure 2-2*. To adjust, either screw or unscrew the jack bolt. This will raise or lower the support.
- Supports should be located at ends of conveyor and centered under each splice on multi-piece conveyors (nominal 10' centers).
- If supports are located on nominal 5' centers, center additional supports midway between supports at splices.



**Figure 2-2 – Support Height Adjustment**

## 2-3 Air Requirements

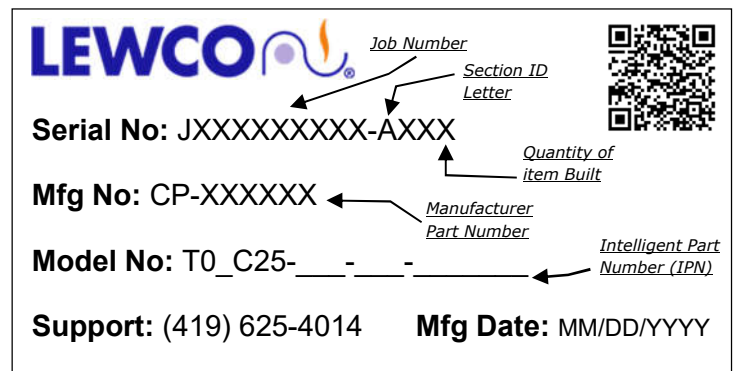
- Required air pressure for the chain transfer is 60 PSIG (gauge pressure).
- Air should be prepared by running it through FRL (See **Figure 2-3**)



**Figure 2-3 – FRL DIAGRAM**

## 2-4 CONVEYOR SET-UP

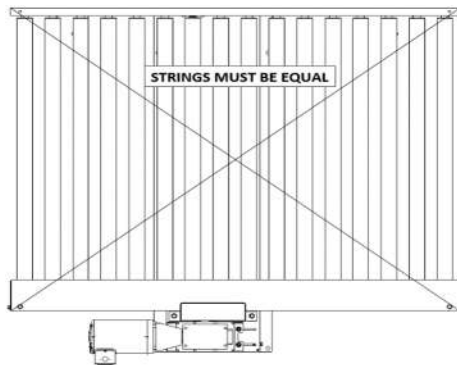
- Mark a chalk line on floor to locate center of the conveyor.
- Place the drive section in position.
- Install remaining sections in order. Conveyor sections have a section number label, which includes the Job Number, Section Assembly ID Letter, Quantity of the item built, Manufacturer Part Number, and IPN (See *Figure 2-4.1*). Conveyors made up of more than one section are to be assembled in ascending alphabetical order, starting with Section Assembly "A" at the product infeed end.



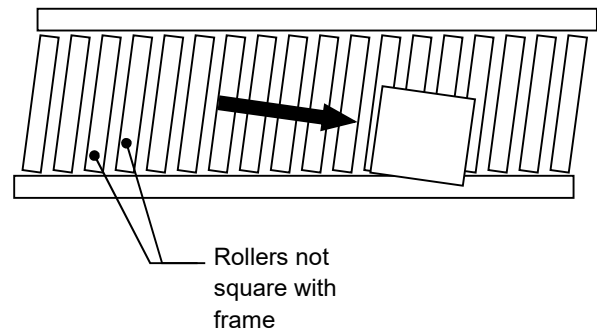
**Figure 2-4.1 – Serial Label Numbering**

- Check that conveyor is level across both width and length of conveyor. Adjust supports if necessary.
- Check all frame sections for squareness using a right-angle square. Alternatively, use a string stretched from opposing corners at edge of frame to aid in straightening conveyor (See *Figure 2-4.2 and 2-4.3*). Ensure that string length is equal corner to corner. Adjust or shim supports as required. Both sides of the conveyor must be in the same plane (frame not twisted).
- Tighten all butt couplings and support mounting bolts and lag conveyor to floor.

**Figure 2-4.2** – Check frame for squareness

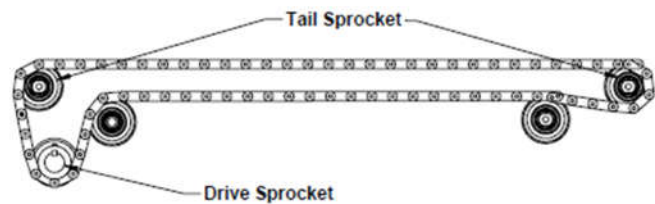


**Figure 2-4.3** – “Racked” Conveyor

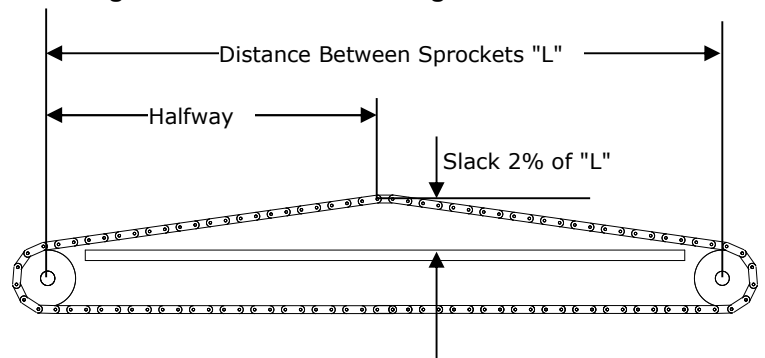


**2-5 CHAIN INSTALLATION**

- Transfer chains are installed at the factory. Chains are installed per Figure 2-5.1.
- Adjust the chain tension using the take up sprocket. Refer to Figure 2-5.2. Lift the chain halfway between tail sprockets and measure the gap. It should be 2% of the distance between tail sprockets.
- Be sure to adjust the screws evenly.
- Using a straight edge or scale, assure that the sprockets are square to the frame and in line with the chain. If the sprockets are not in line, excessive chain and sprocket wear will result.
- Recheck for proper chain tension.



**Figure 2-5.1** – Chain Routing for Transfer Chain



**Figure 2-5.2** – Tensioning Conveying Chain on Chain Conveyor

**2-6 ELECTRICAL INSTALLATION & CONTROLS**

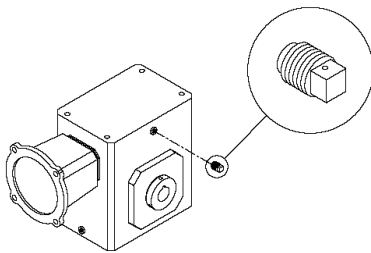


**Electrical connections should be made by a qualified electrician in accordance with NFPA 70, “National Electric Code.” The installation must also meet the requirements of any applicable state and local codes.**

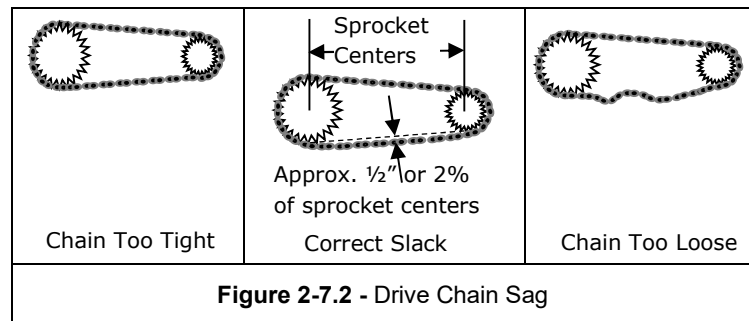
- Control stations should be installed in a place where operation of equipment can be clearly seen.
- All controls must be labeled to indicate function.
- Any conveyor which could cause hazard or injury shall not be started until personnel in the conveying area are alerted by a warning signal or by a designated person that the conveyor is about to start. Further, when a conveyor automatically runs, or is controlled from a remote location, an audible warning signal that can be heard at all points along the conveyor must sound. The warning signal shall be initiated by the controller starting device and shall sound for a certain period of time before conveyor starts. In some cases, a flashing light or similar visual warning indicator may be used in conjunction with audible warning signal if it is deemed more effective.

## 2-7 PRE-START CHECKS

- MOST speed reducers are shipped with oil, however, ALWAYS check for proper oil level before operating the conveyor.
- CHECK FOR REDUCER VENT PLUG AND INSTALL IF NECESSARY. (See *Figure 2-7.1*). To install, remove the solid plug and replace with vent plug.
- Remove drive chain guard and inspect drive chain and sprockets.
- Chain should have sag on the slack side per (*Figure 2-7.2*). Measure the sag halfway between the two sprockets.
- Sag should be  $1/2"$  or 2% of the sprocket center distance. Use tensioning bolts and hardware to increase or decrease tension as needed.
- Inspect sprocket set screws. These should be tight against the reducer and roller shafts. Using a straight edge, check alignment of the sprockets by placing the straight edge flush against the sprocket flanges.
- Reinstall chain guard after inspection.



**Figure 2-7.1 –**  
Reducer Vent Plug Installation

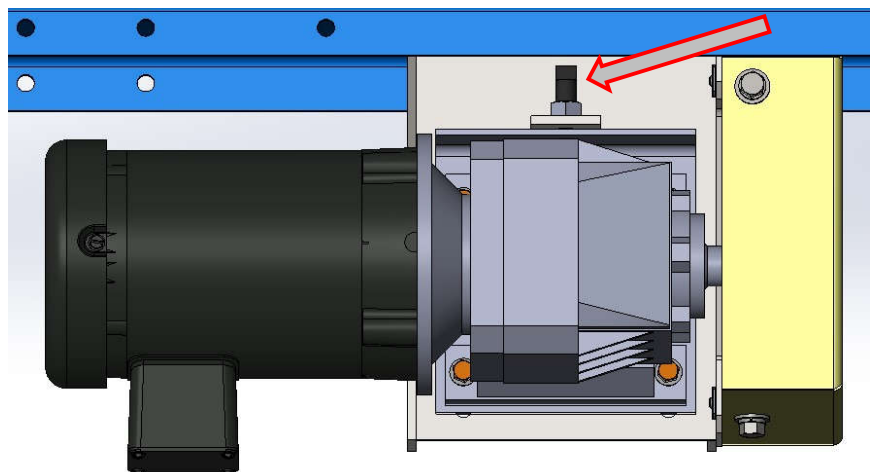


**Figure 2-7.2 - Drive Chain Sag**

## 2-8 Drive Chain Tensioning

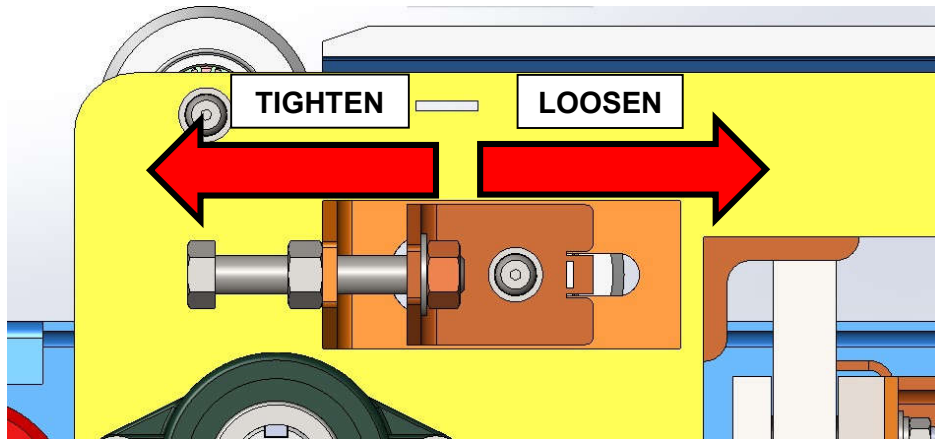
- If the drive chain is improperly tensioned, use the tensioning screw located on the motor assembly to achieve the correct amount of slack (See *Figure 2-7.2*).
- Loosening the nut attached to the tensioning screw will allow the motor assembly to move along slots on the drive mount plate. Moving the motor away from the frame will cause the chain to tighten. Moving the motor towards the frame will cause the chain to loosen and gain slack. (See *Figure 2-8*)
- NEVER allow the chain to operate while improperly tensioned. It could potentially damage components or cause a malfunction.

**Figure 2-8 –**  
Chain Tensioning Bolt  
for the Drive Chain



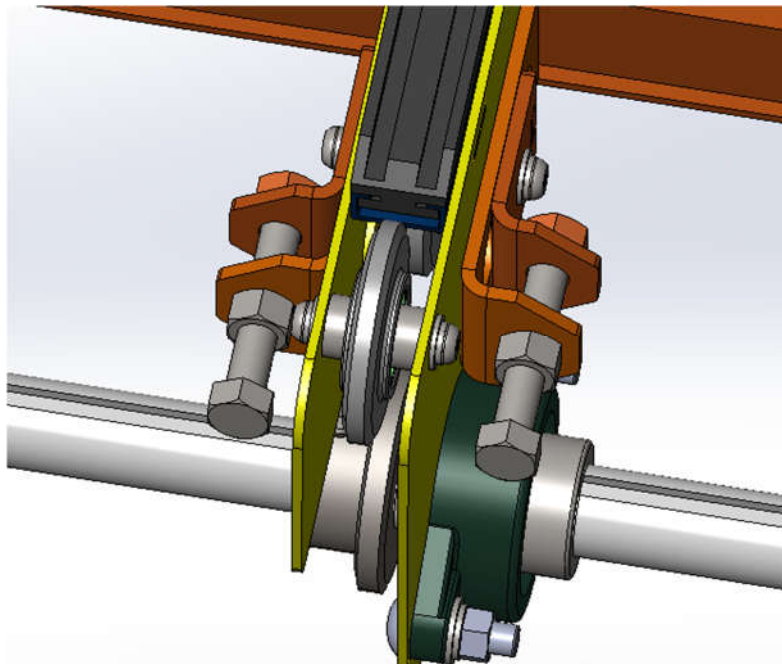
## 2-9 Transfer Chain Tensioning

- If the transfer chains are improperly tensioned, they can jam up and cause the transfer assembly to not function properly.
- The tension of the transfer chains can be adjusted by using the tensioning screws on either side of each transfer strand. (See Figure 2-9.1)
- To make an adjustment to the chain, loosen the nut attached to the tensioning screws. The screw can either tighten or loosen the chain. Be sure to make equal adjustments on both sides of the transfer strand to keep the idler sprocket in-line.



**Figure 2-9.1 –**

Chain Tensioning Bolt for Transfer Strand Chain Loop



**Figure 2-9.2 –**

View of both chain tensioning bolts

## SECTION 3 – MAINTENANCE

Effective operation and useful life of any equipment is directly related to the care and service it receives. A pre-determined maintenance schedule, including inspection, lubrication, and cleaning, should be established for each conveyor. Establish and maintain “Log Sheets” on each conveyor to record date and results of inspections, lubrication, and replacement parts. General inspections of all conveyors should be performed at regular intervals depending on use and service conditions.



Do not attempt any maintenance on this equipment unless all sources of energy are disconnected and locked out by properly trained personnel.

Do not perform any work on the conveyor while it is running unless the nature of the maintenance absolutely requires operation of the conveyor. If the conveyor must be operated to perform maintenance procedures, allow only experienced conveyor maintenance personnel to do the work. **Use extreme caution!**

### 3-1 MAINTENANCE INTERVALS

This list of maintenance items is a general overview of the minimum items that may need to be addressed on your LEWCO Conveyor. The actual list may vary depending on the specific equipment provided. The customer should make the final determination on maintenance intervals and tasks to be performed while considering the working environment. Please review applicable component literature for further detail and potential additional maintenance items.

COMPONENT	ACTION	SCHEDULE		
		WEEKLY	MONTHLY	QUARTERLY
MOTOR	Listen for irregular noise.	✓		
	Check for overheating.	✓		
	Check mounting bolts are secure.		✓	
REDUCER	Listen for irregular noise.	✓		
	Check for overheating.		✓	
	Check oil level.			✓
DRIVE CHAIN/ TRANSFER CHAINS	Check for tension.			✓
	Lubricate.	✓		
	Inspect for wear.			✓
WEDGE BLOCKS & LIFT BLOCKS	Lubricate/Grease with Lithium All-Purpose Grease, N.L.G.I. #2		✓	
SPROCKETS	Inspect for wear.			✓
	Check set screws and keys.			✓
BEARINGS (Drive Rollers)	Listen for irregular noise.	✓		
	Check mounting bolts are secure.			✓
STRUCTURAL	General check: Loose nuts, bolts, etc. Tighten as necessary.		✓	
ELECTRICAL	Inspect all wiring for secure connection. Ensure there are no loose or cut wires.		✓	
	Test Emergency Stop switches for proper function.		✓	
CYLINDER	Check air line for water. Drain water (if any).			✓

## 3-2 MAINTENANCE PROCEDURES

### 3.2.1 Conveyor Frames and Supports

- Check conveyor frame, couplers, supports, and bearings for loose or missing hardware. Replace hardware as required.

### 3.2.2 Motor and Reducer

- Make sure the reducer is filled to the proper level with oil per Grove Gear manual. Make sure breather hole is clean and the orifice is open.
- Inspect reducer for leaks.

### 3.2.3 Rollers and Bearings

- Check all rollers for tightness. All rollers must rotate freely. If roller does not turn freely check for dirt accumulation in bearing area and clean.
- Lubricate all flange type bearings that have grease fittings. Use NLGI Grade 2 Lithium base grease, Shell Alvania EP2, or equal.
- Listen to bearing for excessive noise. Replace as required.
- When installing replacement rollers, standard axle pushes in on sprocketed side.

### 3.2.4 Sprocket and Chain Maintenance

- Remove drive chain guard and inspect drive chain and sprockets.
- Chain should have 1/2" or 2% sag when measured on the lower run of chain halfway between the two sprockets. See "Pre-Startup Checks".
- A loose chain can jump the drive sprockets and can cause sprocket wear and failure. A tight chain requires excessive motor power and can also cause chain and sprocket failure.
- Inspect drive sprocket and set screws for tightness against the reducer.
- Check sprocket alignment. Misalignment causes wear on one side of the sprocket. Check for a misaligned shaft or a sprocket off center.
- Check shaft bearing set screws.
- Lubricate the drive chain approximately every 40 hours of operation. Rinse chain in solvent before lubricating. Use SAE-30 oil. Lubricate more frequently under extreme ambient conditions.
- Reinstall chain guard after inspection and maintenance.

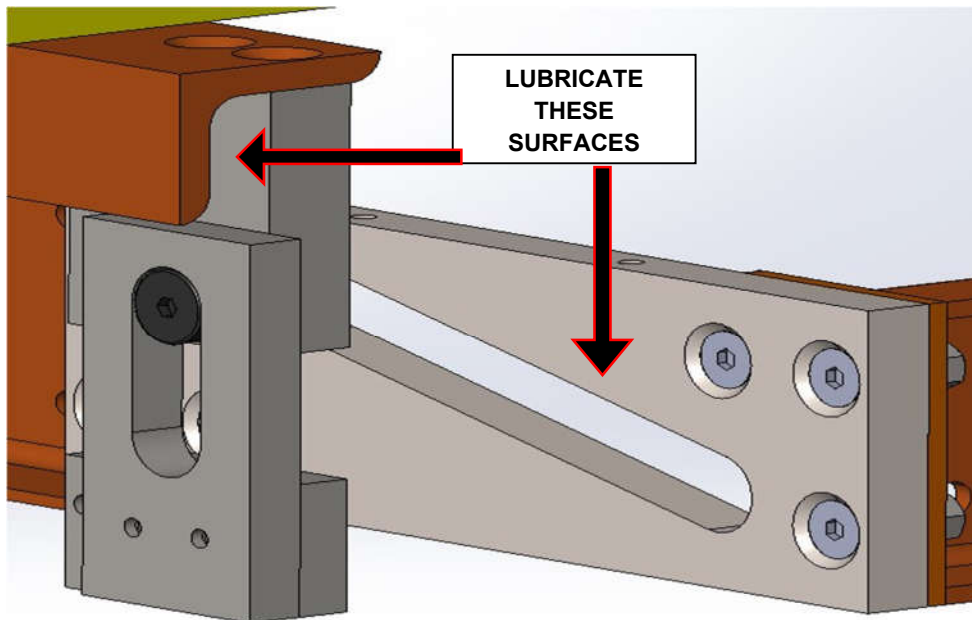
### 3.2.5 Cleaning

- Periodically remove drive chains and clean by immersing in solvent and scrubbing with a wire brush. Rinse thoroughly and relubricate. Verify proper chain tension.
- Clean chain box and keep free of all debris.

### 3.2.6 Chain Transfer Maintenance

- Keep the inside face (metal on metal contact side) of the Lift Block Wedge Plate AND the inside face of the lift block cam mount plate greased to prevent wear on the transfer assembly. Use Lithium All-Purpose Grease, N.L.G.I. #2
- To access the lift block wedge plate, remove the access covers on the side of the frame. To access lift block cam mount plate, set the transfer to the raised position and apply grease. (See *Figure 3-2.1*)
- Check for any debris (pallet chips, dirt, etc.) accumulation on greased locations. Accumulation can lead to equipment jamming and not operating as intended.
- See above section "*Sprocket and Chain Maintenance*" for the transfer sprocket and chain maintenance.



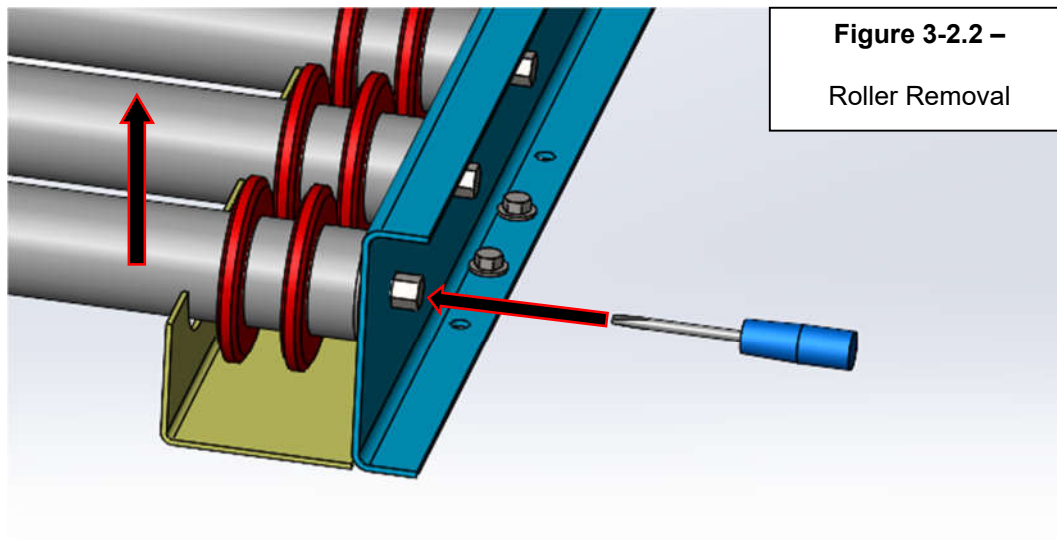


**Figure 3-2.1**

Lift Block Grease Locations

**3.2.7 Roller Removal**

- If for any reason you need to remove a roller(s), go through the following steps:
  - a. Confirm that power is off and all powered equipment is off.
  - b. Remove the top chain guard.
  - c. Remove chain loops connected to rollers that are being removed.
  - d. Get a screwdriver/ an object that can depress the spring-loaded axle on the sprocketed side of the roller. Use the object to push the axle in and pull up on the roller.



### 3-3 REPLACEMENT PARTS

To order replacement parts, please contact your LEWCO distributor. If unable to contact distributor, please contact LEWCO's Customer Service Department by calling 419-625-4014 ext. 4012, or emailing [customerservice@lewcoinc.com](mailto:customerservice@lewcoinc.com).

For LEWCO's Sales Department call 419-625-4014 ext. 4003 or email [conveyorsales@lewcoinc.com](mailto:conveyorsales@lewcoinc.com). Please be prepared to provide both your MODEL and SERIAL NUMBER when ordering. Serial numbers can be found on unit-labels. There is one unit-label per each section of conveyor.

## STANDARD CHAIN TRANSFER CONVEYOR COMPONENTS

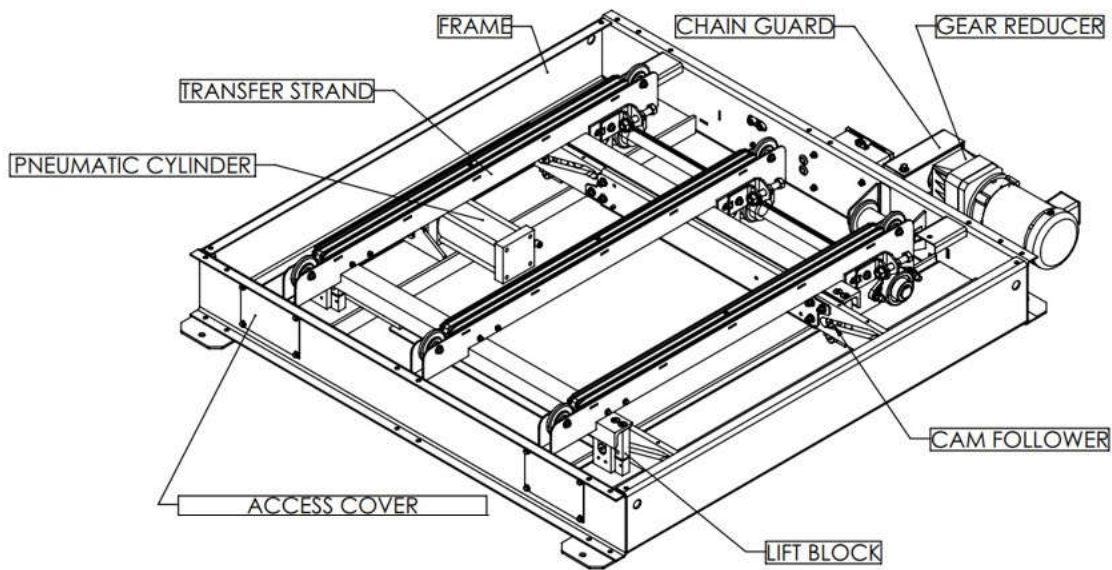


Figure 3-3.1 –

### Chain Transfer Component Names

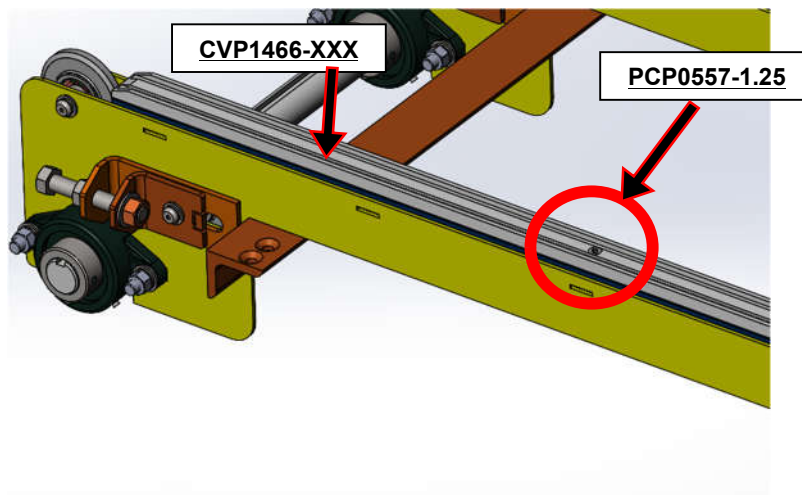


Figure 3-3.2 –

UHMW Chain Guide, fastened using the circled Flat Head Socketed Cap Screw

## SECTION 4 – TROUBLESHOOTING

TROUBLE	CAUSE	SOLUTION
<b>Conveyor does not start or motor stalls.</b>	No power	Verify main disconnect switch is on.
	Motor overloaded	Check conveyor loading against design parameters.
	Motor drawing excessive current.	Check circuit breaker.
	Emergency Stop button is engaged.	Verify the initial reason for the emergency stop. If reason has been corrected, release the Emergency Stop.
<b>Excessive wear on drive chain and/or sprockets.</b>	Lack of lubrication.	Lubricate chain.
	Sprockets out of alignment.	Align sprockets.
	Loose drive chain.	Correct chain slack (See "Pre-Startup Checks").
<b>Loud popping and/or grinding noise.</b>	Defective bearing.	Replace bearing.
	Loose drive sprocket set screw.	Tighten sprocket set screws and check key.
	Loose drive chain.	Correct chain slack (See "Pre-Startup Checks").
<b>Motor or reducer overheating.</b> <small><i>Note: Many motors and reducers can be hot to the touch and still be operating within normal parameters</i></small>	Conveyor overloaded.	Check conveyor loading against design parameters.
	Low voltage to motor.	Correct voltage level as stated on motor name plate.
	Reducer lubricant level low.	Fill reducer reservoir.
<b>Chain moves with jerky motion.</b>	Conveyor overloaded.	Check conveyor loading against design parameters.
	Loose chain.	Tighten chain. (See belt tensioning and adjustment section.)
<b>Chain does not return evenly to down position.</b>	Loose frame.	Tighten frame fasteners.
	Out of square frame.	Loosen frame fasteners, square frame, tighten frame fasteners.
<b>Chain doesn't raise to the up position</b>	Worn wedge blocks.	Replace wedge blocks.