Owner's Manual

Belt Driven Live Roller Conveyor

Models: BDLR & BDLN



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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 Buyer's 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.



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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.

***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.



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

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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.
DANGER	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.
WARNING	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.
CAUTION	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.
NOTICE	Is used to address practices not related to personal injury.
Equipment Specific Safety Signs & Definitions	
	**DANGER:** Climbing, sitting, walking or riding on conveyor at any time will cause severe injury or death. Keep Off.
	**WARNING:** servicing moving or energized equipment can cause severe injury. LOCK OUT POWER before servicing.
	**WARNING:** exposed moving parts can cause severe injury. LOCK OUT POWER before removing guard.
	**WARNING:** Moving equipment may cause severe injury. Keep Away.
	**WARNING:** Potential arc flash hazard.

1-2 SAFETY CONSIDERATIONS

WARNING

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

- Do not have long hair, jewelry, or loose clothing while operating or near the conveyor, as 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 operating or near the conveyor should be instructed as to the location of stopping devices. Ensure stopping devices are kept free of obstruction.
- Personnel operating or near the conveyor should watch for and be aware of conveying hazards, such as sharp edges, protruding parts, etc.
- Riding on conveyor is strictly prohibited, as serious injury may result.
- Prior to starting conveyor, ensure no work is being performed, 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. The owner is responsible for analyzing the installation of this equipment in order to make determinations regarding the posting of warning signs in order to comply with applicable OSHA standards.
- Conveyor should only be used to transport materials or items that it is originally intended and 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 can cause accidents. Keep conveyor and surrounding area clean from spilled lubricants and other materials.
- Always use extreme caution when using mechanical aids, such as hoists, cables, and other equipment to install or perform maintenance on conveyor. They can cause damage to the conveyor and cause a dangerous condition when the conveyor is turned on.

1-3 EMERGENCY SHUTDOWN

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

1. Stop the conveyor immediately by pressing the nearest emergency stop button or pulling the emergency stop cable. If access to emergency stop button or cable is restricted, or emergency stop devices 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.

3. Before restarting the conveyor, inspect the equipment and determine the cause of the emergency shutdown. Disconnect and lock out all applicable energy sources before attempting to correct the issue, following proper lockout/tagout procedures.
4. Once the issue has been resolved and the conveyor is safe to operate, restore power and restart the conveyor using the designated controls. If equipped with an emergency stop device, it must be manually reset before restarting the conveyor.

1-4 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 hand tools 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.

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 screws and guards and any accessory equipment that may be fastened to the conveyor.

2-2 SUPPORT INSTALLATION (if applicable)

- If you have slotted adjustable height supports (models SPH or SPM) as shown in *Figure 2.1,* follow instructions below. If you have jack bolt supports, see *Appendix A.*
- See *Figure 2.1*. Determine your desired conveying height (ELEVATION). Measure the conveyor frame, then subtract this measurement from the height you set the support to. Desired ELEVATION minus frame height equals support height.
- To adjust the support height, slide inner and outer legs to raise and lower the support and tighten bolts.
- Supports should be located at ends of conveyor and centered under each splice on multi-section conveyors (nominal 10 ft centers). See *Figure 2.3*.
- If supports are located on nominal 5 ft centers, center additional supports midway between supports at splices. The guard cover for the drive may need to be removed so that the bolts to fasten the supports to the frame channel can be installed.
- Bolts for attaching the supports to the frame sections are shipped in a bag attached to the supports.

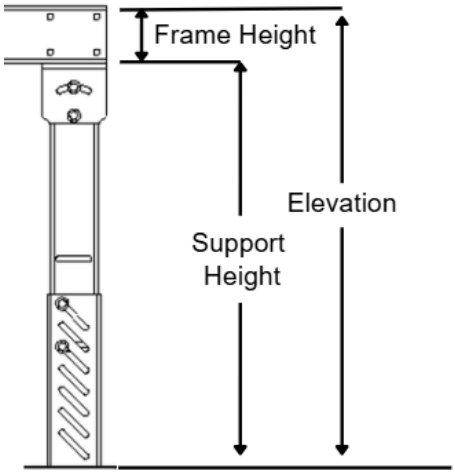


Figure 2.1 - Support Height Adjustment, Models SPH and SPM

2-3 CONVEYOR SET-UP

- Mark a chalk line on floor based on desired location of conveyor.
- Place the drive section in the desired location.
- If installing a conveyor that is longer than 10-12 ft, it will typically ship in more than one section. For example:
  - A 20 ft. long conveyor with an **end or side drive** would consist of one 10 ft. long **Take-Up** section at the infeed and one 10 ft. long **Drive** section at the outfeed end.
  - A 30 ft. long conveyor with **end or side drive** would consist of one 10 ft. long **Take-Up** section at the infeed, one 10 ft. long **Intermediate** section in the middle, and one 10 ft. long **Drive** section at the outfeed end.
  - A 20 ft. long conveyor with a **center drive** would consist of two 5 ft. long **Take-Up** sections at the infeed & outfeed and one 10 ft. long **Drive** section in the middle.

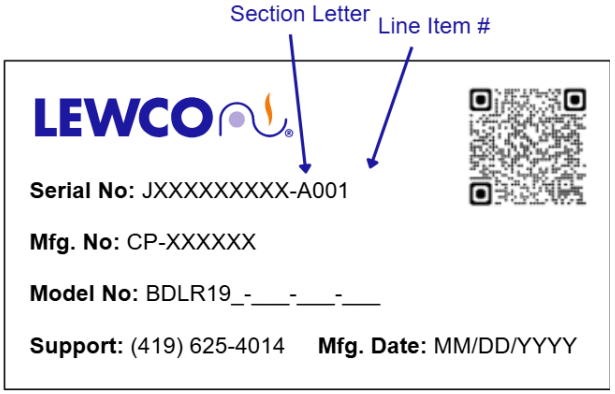


Figure 2.2 - Unit Label

- These sections should be installed according to the section label. The section label includes the order line-item number, and section assembly letter. See *Figure 2.2*. Conveyors made up of more than one section are to be assembled in alphabetical order, starting with Section Assembly A at the product infeed end.

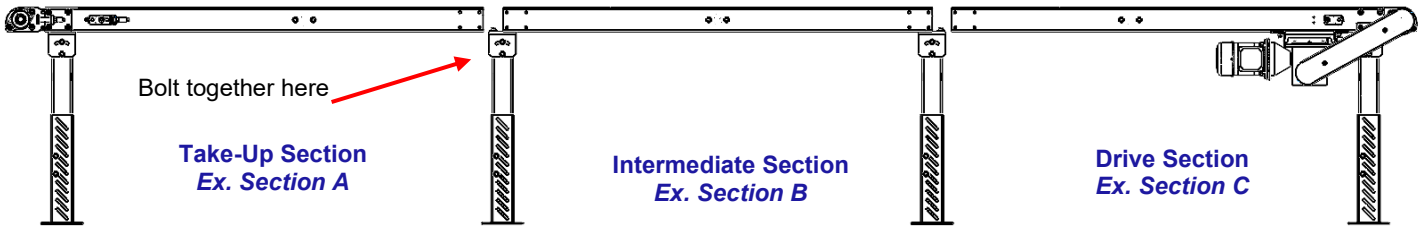


Figure 2.3 - Section Set-Up

- Bolt conveyor sections together at butt couplings.
- Check that conveyor is level across both width and length of conveyor. Adjust support height if necessary.
- Check all frame sections for square. See *Figure 2.4.* Use a string stretched from opposing corners at edge of frame to aid in straightening conveyor. Ensure that both dimensions are the same. Adjust or shim supports as required. Both sides of the conveyor must be in the same plane (frame not twisted).
- Tighten bolts at all butt couplings. Lag conveyor to floor.

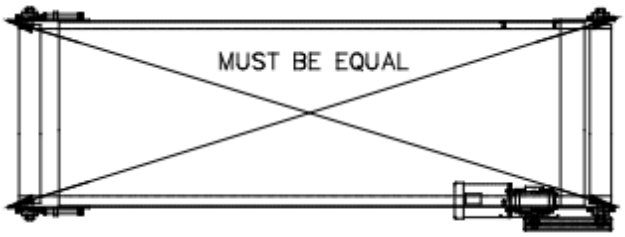


Figure 2.4 - Check frame for square

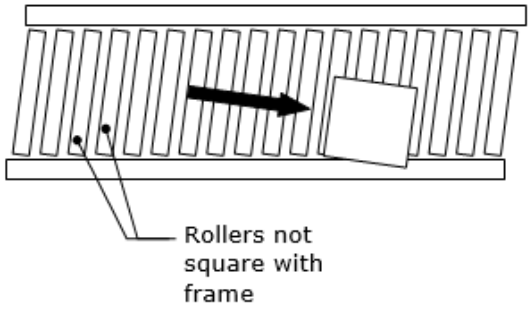


Figure 2.5 – "Racked" Conveyor

2-4 BELT INSTALLATION & TRACKING PROCEDURE

- Install belt per *Figure 2.6.*
- With the tread roller axles resting in the bottom of the slot, level and adjust tension rollers so belt makes contact with the tread rollers with minimal pressure. Heavy loads may require increased belt pressure on the tread rollers. If so, raise the tension rollers evenly. Make small adjustments and monitor the results. Non-level tension rollers will cause the belt to track incorrectly.
- Prior to starting the conveyor, again ensure that all pulleys and rollers are square and level. Initially, avoid the situation shown in *Figure 2.7.*
- Start the conveyor.
- Check for proper belt tension. When properly adjusted, there should be no slippage between the drive pulley and the conveyor belt and the drive motor amp draw will be under the rated full load amps as indicated on the motor name-plate.
- If the belt slips on the drive pulley, more tension is required. Adjust the take-up pulley to increase the tension on the belt. Make small, even adjustments; monitoring the results before readjusting.
- If the belt is over-tensioned, the belt lacing will pull away and the motor amp draw will be high. Adjust the take-up pulley to decrease the tension on the belt. Make small, even adjustments; monitoring the results before readjusting.
- Review belt position at all pulleys. Track belt if necessary based on *Figure 2.7.*

Scan QR Code or click HERE for Belt Tension and Tracking Video

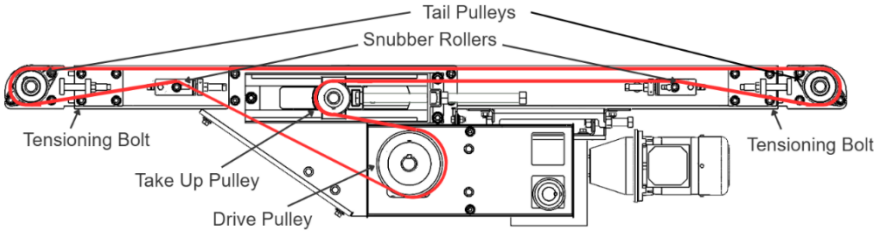


Figure 2.6 - Center Drive Belt Routing

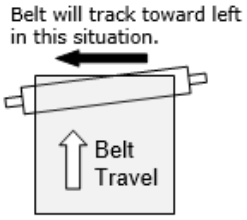


Figure 2.7 – Pulley Adjustment for Belt Tracking (Plan View)

2-5 ELECTRICAL INSTALLATION & CONTROLS

Electrical connections should be made by a qualified electrician in accordance with NFPA 70, National Electrical Code (NEC). 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.

NOTICE: When conveyor is not in use, the power source should be disconnected or turned off.

2-6 PRE-START CHECKS

- MOST speed reducers are shipped with oil, however, ALWAYS check for proper oil level before operating the conveyor.
- Remove drive chain guard and inspect drive chain and sprockets. Chain should have sag on the slack side per *Figure 2.8*. Measure the sag halfway between the two sprockets.
- Sag should be ¼" or 2% of the sprocket center distance.
- Inspect drive sprocket and set screws. These should be tight against the reducer and roller drive shaft. Using a straight edge check to assure the sprockets are aligned by placing the straight edge flush against the sprocket flanges.
- Re-install chain guard after inspection.

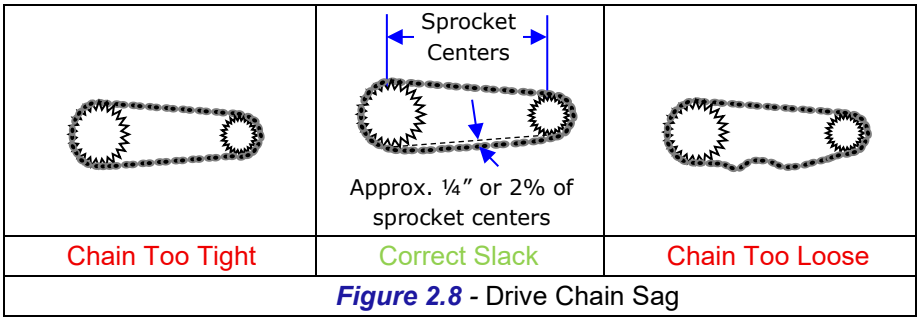


Figure 2.8 - Drive Chain Sag

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 parts replacements. General inspections of all conveyors should be performed at regular intervals depending on use and service conditions.



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

***NOTICE*:** 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 overheat.	✓		
	Check mounting bolts are secure.		✓	
REDUCER	Listen for irregular noise.	✓		
	Check for overheat.		✓	
	Check oil level.			✓
DRIVE CHAIN	Check for tension.			✓
	Lubricate.	✓		
	Inspect for wear.			✓
SPROCKETS	Inspect for wear.			✓
	Check set screws and keys.			✓
BELT	Check belt tracking.		✓	
	Check for tension.		✓	
	Inspect lacing.	✓		
BEARINGS (Pulleys & 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.		✓	
	If applicable, test Emergency Stop switches for proper function.		✓	

3-2 MAINTENANCE PROCEDURES

3-2.1 Motor & Reducer

- Make sure the reducer is filled to the proper level with oil.
- Make sure vent plug (*Figure 3.1*) is clean and the orifice is open.
- Inspect reducer for leaks.
- Only use oil recommended by the reducer manufacturer. Refer to the reducer manufacturer's manual for detail.
- Refer to the motor & reducer manufacturers' manuals for specific detail.

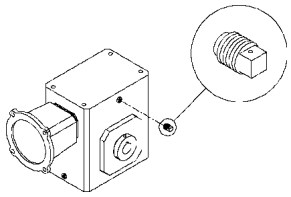


Figure 3.1 -
Reducer Vent Plug

3-2.2 Belt

- Check front, back, and edges of belt for wear, rips, tears, holes, and dirt accumulation. Clean belt with detergent and water. Replace belt as required.
- Check belt tension under load. The belt should be just tight enough to prevent slipping at the drive pulley with a rated load. Loose belts cause excessive wear on the drive pulley, lagging, and jerky load movement. Tight belts cause tears, lacing failure, and excessive motor power.
- Check belt lacing for broken, bent, loose, or missing clips and pins. Replace lacing as required.

3-2.3 Pulleys, Rollers, & Bearings

- Check drive roller lagging for rips, tears, and missing areas. Replace pulley as required.
- Check all rollers and pulleys 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. Snub roller and return roller bearings are not regreasable.
- Listen to bearing for excessive noise. Replace as required.

3-2.4 Cleaning

- Periodically remove drive chain and clean by immersing in solvent and scrubbing with a wire brush. Rinse thoroughly, dry, and re-lubricate. Upon reinstalling, verify proper chain tension.
- Clean chain box and keep free of all debris.

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. 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 conveyor section. See *Figure 3.2.*

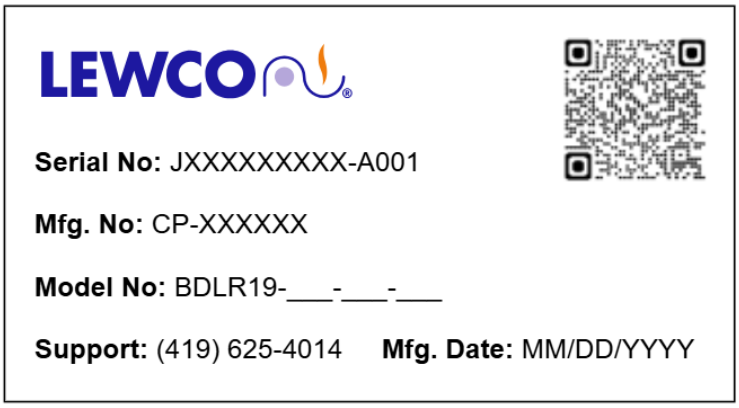


Figure 3.2 **- Unit Label**

SECTION 4 – TROUBLESHOOTING

TROUBLE	CAUSE	SOLUTION
Conveyor does not start or motor stalls.	No power.	Ensure conveyor is plugged in to a source with power.
	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.
Excessive wear on drive chain and/or sprockets.	Lack of lubrication.	Lubricate chain.
	Sprockets out of alignment.	Align sprockets.
	Loose drive chain.	Correct chain slack (*See Pre-Start Checks on page 8*).
Loud popping and/or grinding noise.	Defective bearing.	Replace bearing.
	Loose drive sprocket set screw.	Tighten sprocket set screws and check key.
	Loose drive chain.	Correct chain slack (See "Pre-Start Checks").
Motor or reducer overheating. *Note: Many motors and reducers can be hot to the touch and still be operating within normal parameters*	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.
Conveyor does not achieve desired speed. *Note: Conveyor speed can vary by up to 5% from set speed.*	Overloaded	Compare to design parameters on drawing.

TROUBLE	CAUSE	SOLUTION
One part of belt creeps to one side.	Belt ends at fasteners not cut square; fasteners not joined properly.	Use T-square to cut belt ends perfectly square; replace with the correct fasteners.
	Belt is bowed.	If belt is new, this condition should straighten out after belt is run under full load tension or is “broken in”; if not, belt must be replaced.
Ply separation in belt carcass.	Edge of belt worn or broken due to excessive rubbing.	Check alignment of conveyor frame, pulleys and idlers.
	Damage by abrasive, acid, heat chemicals, mildew, or oil.	Use a belt properly compounded to resist deterioration from acids, etc.
Belt stretches excessively.	Tension on belt too high.	Reduce tension roller to a point where belt will run without slipping; lag the drive pulley.
Belt creeps to one side of tail pulley.	Tail pulley or return idlers near the tail pulley are out of alignment (not perpendicular with centerline of conveyor).	Re-align by advancing (in the direction of the return belt travel) the end of the pulley or idler to which the belt has shifted.
Belt creeps to one side of head pulley.	Head pulley or idlers immediately preceding head pulley are out of alignment (not perpendicular with centerline of conveyor).	Re-align by advancing (in the direction of belt travel) the end of the pulley or idler to which the belt has shifted.
Belt creeps to one side at one spot only on long conveyor.	One or more idlers (usually immediately preceding the trouble spot) are out of alignment (not perpendicular with centerline of conveyor).	Advance (in direction of belt travel) the end of the idler to which the belt has shifted.
	Improper loading of belt.	Loading should be in direction of belt travel and centered on belt.
	Frozen idlers or idlers not properly located.	Lubricate idlers and improve maintenance; relocate improperly placed idlers and check alignment with a T-square.
	Conveyor frame or structure are crooked or not level which causes belt to shift to low side.	Check alignment by stretching a string along edge of frame and make correction; level structure.
	Foreign material build-up on pulleys or idlers.	Clean pulleys and idlers and improve maintenance by installing scrapers or other cleaning devices; check belt carcass for “bleeding”.
	Pulleys (drive, tail, idlers or snubbers) out of alignment (not perpendicular with centerline of conveyor).	Re-check and square by using a T-square against edge of conveyor and pulleys of idler.
Belt does not move, but drive is running.	Conveyor is overloaded.	Reduce the load
	Belt is too loose.	Adjust the belt take-up to increase tension.
	Lagging on drive pulley is worn.	Replace the drive pulley

APPENDIX A – SUPPORTS

A-1 SUPPORT INSTALLATION, JACK BOLT SUPPORTS

- See *Figure A-1*. Determine your desired conveying height (ELEVATION). Measure the conveyor frame then subtract this measurement from the height you set the support to. Desired ELEVATION minus frame height equals support height.
- To adjust the support height, 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-section conveyors (nominal 10 ft centers). See *Figure 2.3 on page 6*.
- If supports are located on nominal 5 ft centers, center additional supports midway between supports at splices. The guard cover for the drive may need to be removed so the bolts that fasten the supports to the frame channel can be installed.
- Bolts for attaching the supports to the frame sections are shipped in a bag attached to the supports.

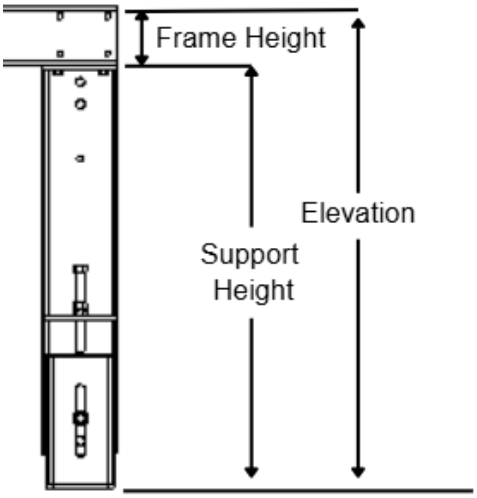


Figure A-1 - Support Height Adjustment, Jack Bolts