

"New Generation" Rotary

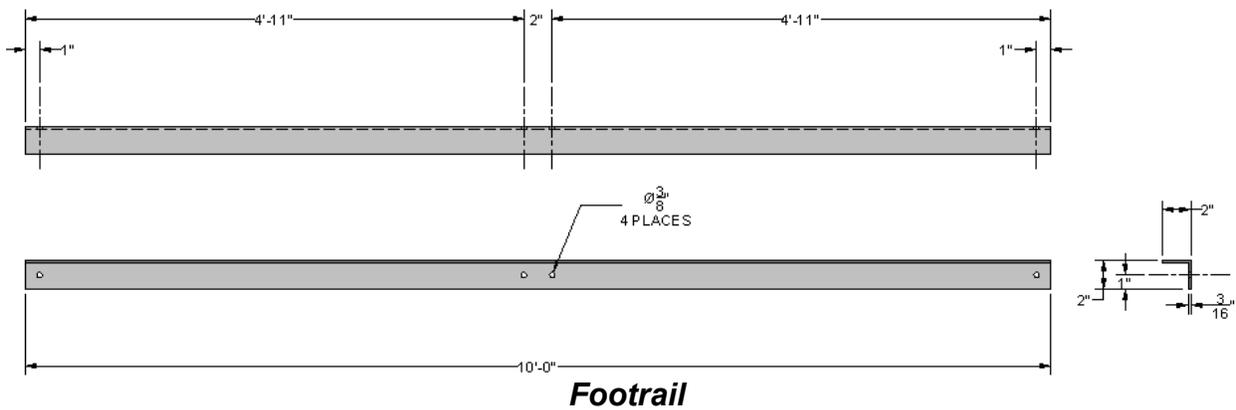


Installation & Maintenance Manual

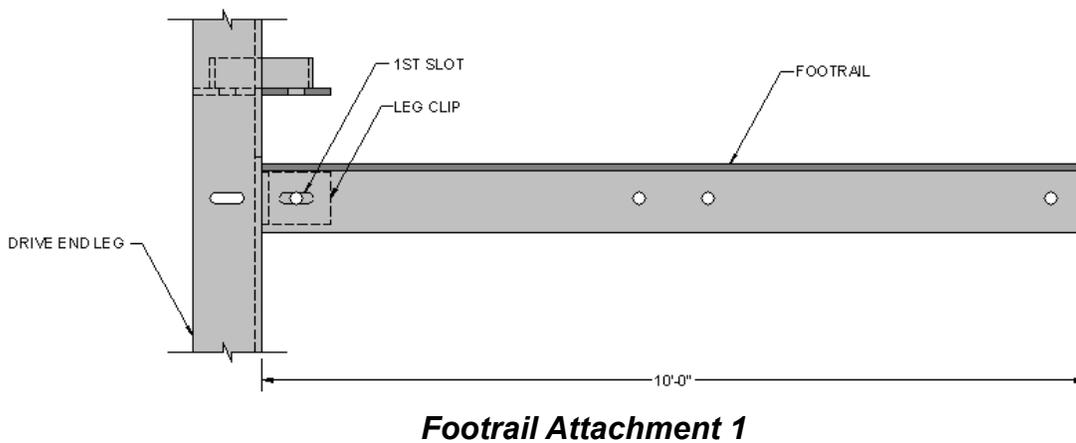
Installation & Maintenance Manual

This is the installation manual for the “New-Generation” Rotary Conveyor. It is designed to assist in the installation of your new unit.

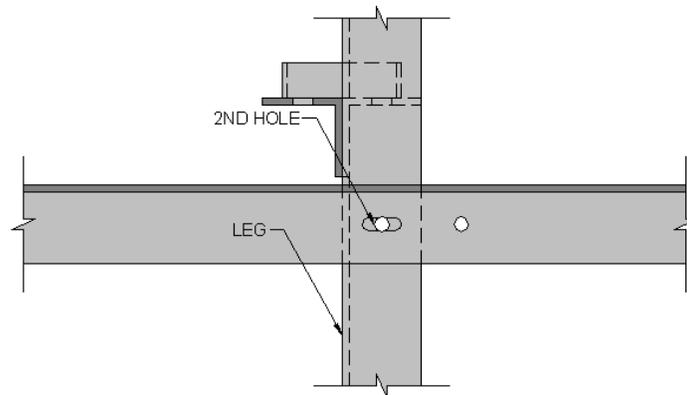
- Step 1: Determine power source location for drive end.
 Step 2: Determine floor; high or low, for leveling.
 Step 3: Start at high end with at least 2” adjusted out on the footpad of the leg.
 A. Preset all legs to determined working height.
 B. Chalk a line from one end to the other to set legs.
 Step 4: Install 10’0” sections at a time.
 Step 5: Set table in position. Level runway tops in all directions.
 Step 6: Set up the next 10’-0” section starting at the drive end.
 A. Bolt a foot rail angle on each side of the table leg when starting at the drive end.



- B. Bolt a foot rail angle to the leg clips on the first leg on both sides of the table. Foot rail bolts are 5/16” x 1” whiz bolts and 5/16” whiz nuts.



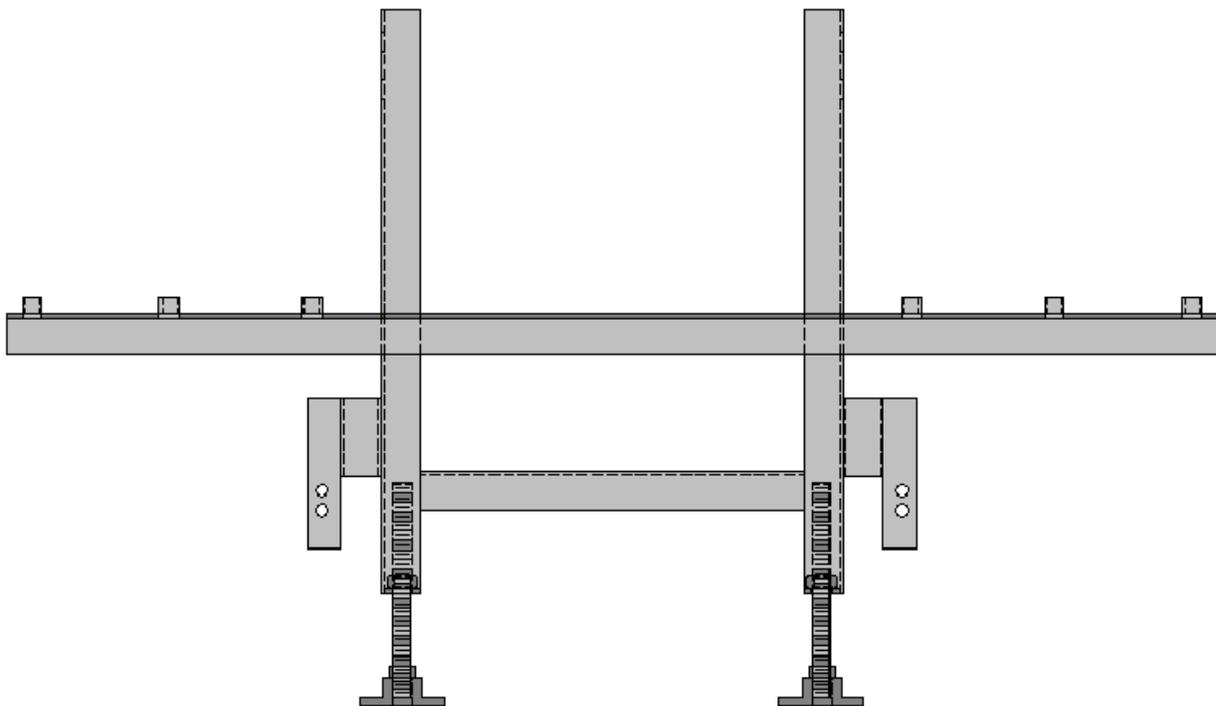
- C. Bolt the middle leg to the foot rail at the first hole of the middle two holes of the foot rail.



Footrail Attachment 3

Middle Leg Description

The middle leg has two (2) upright angles on the bottom section with two (2) adjustable foot pads.

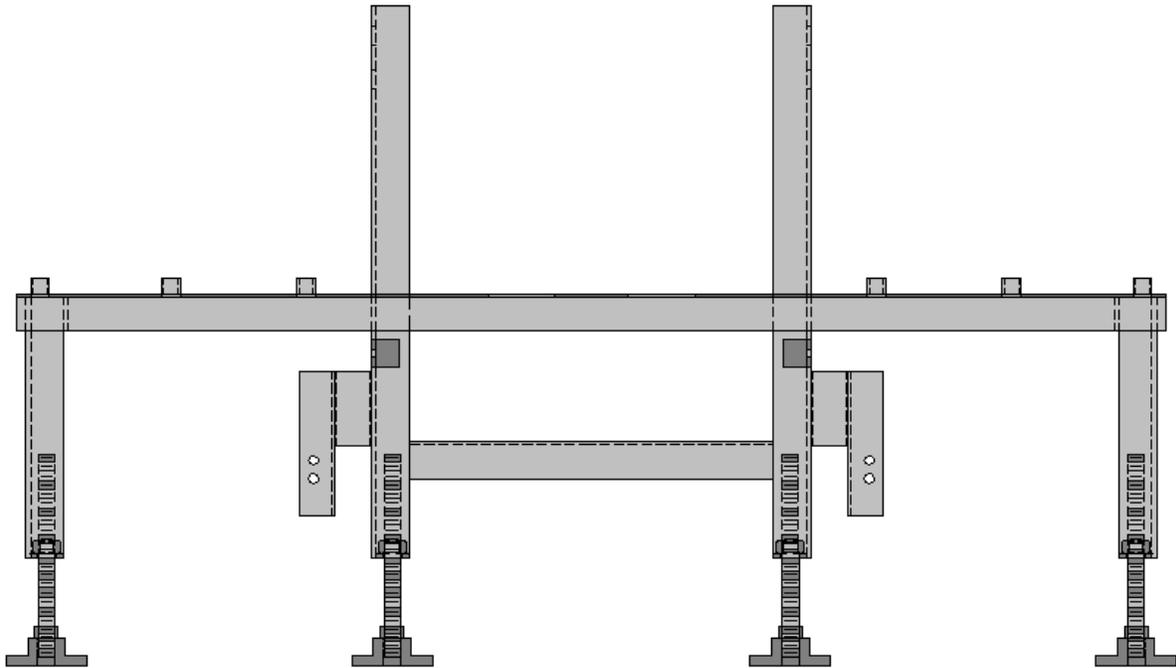


Middle Leg

D. Bolt the end leg to the foot rail at the end hole of the foot rail to the leg hole.

End Leg Description

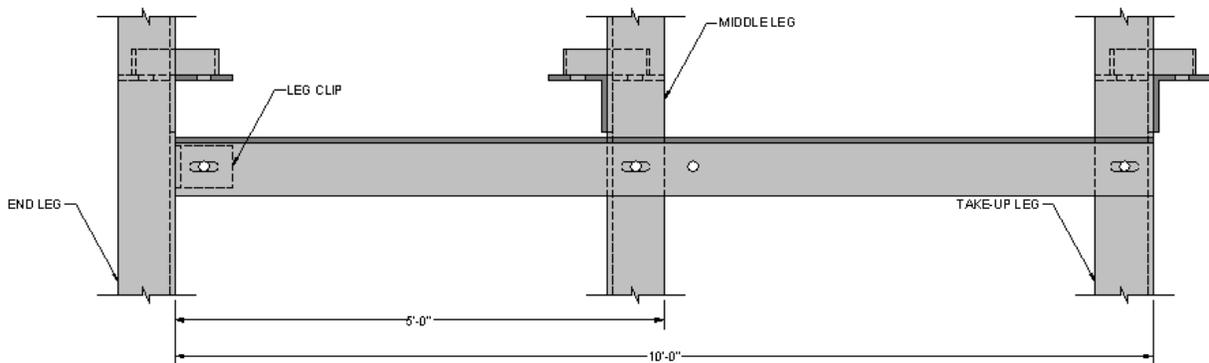
End leg has four (4) upright angles on the bottom section with four (4) adjustable foot pads and two (2) leg clips.



End Leg

1. When starting from the take-up end:

- A. Bolt foot rail at first leg of table using leg hole.
- B. Bolt foot rail to middle leg at the second hole of the middle of the foot rail.
- C. Bolt foot rail to end leg using leg clip.

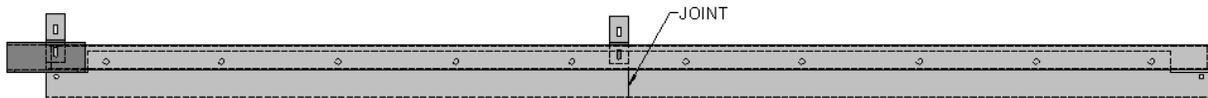


Footrail Attachment

2. Install left and right tracks to top of legs. Track bolts 3/8" x 1" whiz bolts and 3/8" whiz nuts.

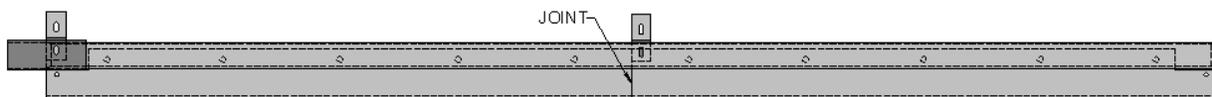
Track description

1. Track bracket is on the left side of joint.



Left Track Section

2. Track bracket is on the right side of joint.



Right Track Section

3. Lay three (3) 1" x 3" tubes on each side of leg between spacers like table ends are.
 - A. Tubing should end about 1" center of small angle.



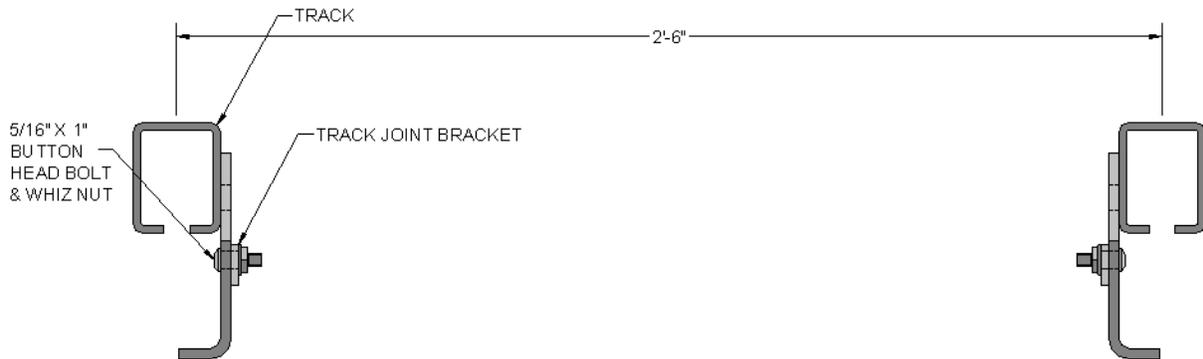
3" Tubing Locations

4. Put on 10 ft. zinc plated runways, 1 left and 1 right.
 - A. Runway bolts are 1/4" – 20 x 1-1/2" countersunk bolts and 1/4" whiz nuts.
 - B. Bolt runways to legs. Level and plumb the legs from side to side.
5. Tighten foot rail bolts.
6. Tighten runway bolts.
7. To tighten track and adjust track, use height gauges. Height gauges sit on top of runways and track sits on top of height gauge.
8. Connect track sections using a track joint bracket.



Track Joint Bracket

- A. Brackets go inside of track close to the middle of the rotary. Track joint bolts are 5/16" x 1" button head bolts and 5/16" whiz nuts.



Track Joint Bracket Attachment

- B. Bolt insert through guide track to bracket.
 C. Pull bracket up as you tighten bolts.

9. Repeat procedures 6-14 for each 10'0" Intermediate Section.

Assembling Carts

1. Install casters keeping zerkl fittings out.
2. Install front and rear pusher blocks keeping the front pusher block up front.
3. Install brushes, front and rear.
4. Install yokes.
5. Assemble two (2) roller guides.

Installing Carts

1. Apply light coat of lubriplate grease to angle guide.
2. Place cart on the runways straight section surface and position it onto guide angle.
3. Push cart along stopping with track joint midway between front and rear pusher blocks.
4. Adjust track down until it just touches cart guide block.
5. Tighten bracket and joint plates.
6. Repeat procedures 1-5 around entire rotary.

Aligning Track

1. Assemble chain keeping load pins on the same side.
2. Install conveyor chain through the inspection section located on the take-up end.
3. Disconnect the #50 roller chain at the drive and pull conveyor chain through the drive.
4. Adjust the take-up so there is slack in the chain.

5. Connect conveyor chain together, and extend the take-up to obtain a snug chain tension. (NOT TIGHT) approximately 1/4" – 1/2" lift.
6. Install two (2) three piece pendants at curve, 18" apart.
7. Allow power to conveyor and index until proper jig spacing is obtained.
8. Repeat above procedure until pendants are at opposite ends.
9. Start attaching carts to pendants.
10. Put in the radius block and delatching pin.
11. Repeat above until all carts are installed.
12. Apply a light coat of lubriplate grease to wear areas of angle rail. (supplied)
13. Fill oiler with 5-10W oil. Adjust during run in until chain is lightly oiled. Do not allow oiling to become excessive and drip from track.
14. Allow rotary to run for a 6-8 hour period.

Weekly Maintenance

1. Grease caster rollers with one shot of lithium grease.
2. Check oiler and fill if necessary.

Monthly Maintenance

1. Grease caster swivel with one shot lithium grease.
2. Check and grease cat chain (drive) with lithium grease.
3. Check conveyor chain tension.
4. Lubricate #50 drive chain with 5-10W oil.

Yearly Maintenance

1. Grease (one shot) at the two zerk fittings on the motor bearing.

Recommended Spare Parts

1. Casters
2. Wear Strips
3. Roller Sleeves
4. Pendants
5. Motor Controller

If you have any questions please feel free to call...

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