

INCLINED BELT CONVEYORS

TECH HANDBOOK

MODELS 796RBF • 700SBF



**DO NOT
OPERATE BEFORE
READING THIS HANDBOOK**
Important Safety Information Enclosed

KEEP IN SAFE PLACE--DO NOT DISCARD

TECH HANDBOOK FOR 196RBF/350SBF/350BSBF

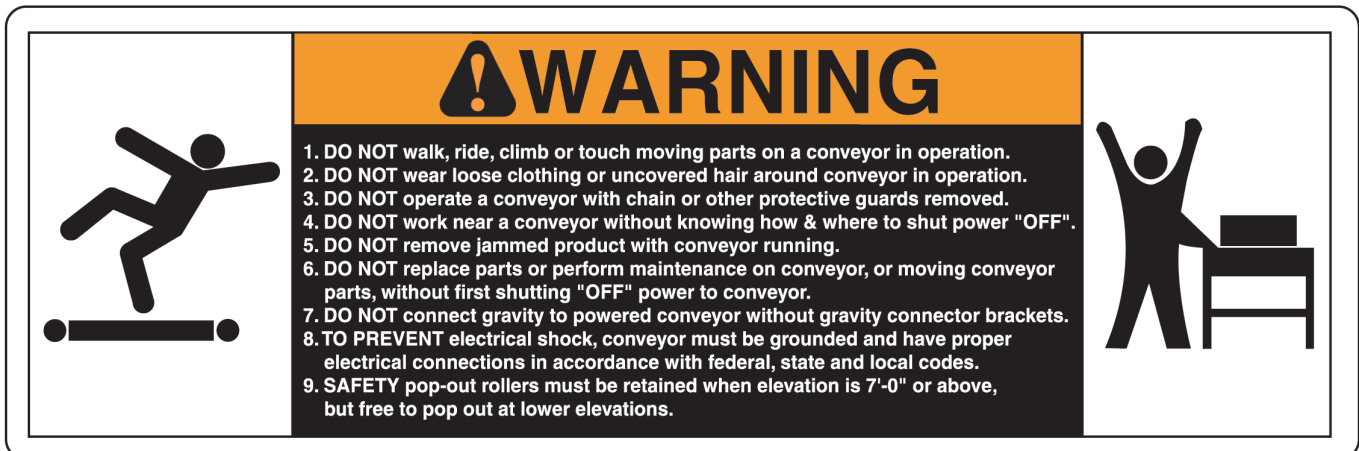
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CAUTION LABELS



ABOVE: Label attached to all protective guards (drives, spool guards, etc.)



ABOVE: Label placed near all drive assemblies and at 30' intervals

CAUTIONS, WARNINGS AND HAZARDS

INTRODUCTION

This manual was prepared as a “how-to-guide” for installers, end-users and maintenance personnel. It is also intended to educate both owner (purchaser) and all individuals working around the unit, of potential hazards.

With proper installation and maintenance, conveyors are essential for achieving a variety of functions essential in today’s industrial marketplace. By following a simple, periodic maintenance schedule, the life of a typical conveyor (or, most any type of machinery--including our automobiles!) will increase when compared to a similar

unit in an application receiving little or no maintenance. You may find that a conveyor can become your best workplace friend by following simple safety guidelines. **Failure to follow even the most basic safety suggestions can result in serious personal injury.**

Conveyors contain many moving parts--pulleys, belting, chains, sprockets, shafts, rollers, etc. Therefore, it is imperative to become familiar with basic unit operation and know all points of potential hazards.

Remember, when working around or near conveyors (and any industrial machinery)

it is **your** responsibility to become familiar with the unit, to know potential hazards (many are noted with caution labels) and to operate unit in strict accordance with the safety guidelines in this manual.


Keep this manual in a safe place for future reference. It should be placed where appropriate personnel may maintain proper maintenance and records.












This manual must be read by all new users before operating or working near this unit.

 **WARNING**

DO NOT OPERATE BEFORE READING THIS MANUAL!
KEEP IN SAFE PLACE--DO NOT DISCARD!

CAUTIONS, WARNINGS AND HAZARDS

 **WARNING**


<p> NEVER connect belt conveyors directly to gravity conveyors, machinery or fixtures without using connector brackets & pop out roller.</p> <p> ALWAYS anchor permanent supports to floor (or mounting surface). Use 3/8" x 2-1/2" (or longer) wedge anchors for permanent installation in concrete flooring.</p> <p> It is the responsibility of the customer and installation personnel to supply and install net or mesh guarding on overhead mounted conveyors to prevent product and/or debris from falling to floor in areas where required.</p> <p> If belt conveyor pulleys are adjusted during installation or maintenance, nip point guard (at drive end on end drive unit) must be readjusted. Nip point guard (take-up end) is automatically adjusted when take-up pulley is adjusted. Nip point guards at both ends of conveyor (center drive) must be readjusted. Center drive guards MUST be replaced after installation or maintenance.</p> <p> Before unit is ready for operation, snub roller guard (cover) must be adjusted to ensure safe unit operation.</p> <p> Belt lacing must be kept in good condition for safe work environment.</p>	<p> To check drive sprocket alignment, shut “OFF” and lock out power source before attempting any adjustments.</p> <p> To check drive sprocket tension, shut “OFF” and lock out power source before any adjustments are attempted.</p> <p> Electrical controls must be designed by a qualified electrical engineer to ensure that appropriate safety features (emergency stops, pull cords, switches, etc.) are installed on unit for safe operation. Before conveyor start-up, all operators and other personnel coming in contact with unit must be properly trained and must have read accompanying Tech Handbook.</p> <p> Upon start-up, if belt tracks to one side, turn unit “OFF”, lock out power source and confirm that conveyor is square and that all prime tracking components are square with bed. Belt tracking adjustments should be performed by trained personnel ONLY. Read section on “Belt Tracking” completely before attempting belt tracking adjustments.</p> <p>Only trained personnel shall perform maintenance functions.</p> <p> Before maintenance operations are performed, shut conveyor “OFF” and lock out power source to prevent unauthorized start-up. When maintenance is completed, only authorized personnel shall be permitted to start conveyor following maintenance or other emergency shut-off.</p>
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SAFETY INFORMATION


IMPORTANT SAFETY GUIDELINES


WARNING


WARNING: All personnel coming in contact with this conveyor should be aware of the following safety guidelines **BEFORE USING OR WORKING AROUND CONVEYOR**. **NOTE:** ALWAYS notify Roach Manufacturing® whenever any conveyor is used in an application or condition other than was originally intended. Failure to notify Roach® may allow conveyor to be operated in a hazardous operating condition. Injuries resulting from negligence or violation of safety instructions hereby removes responsibility of product liability claims from Roach®.


 Do not operate conveyor with protective guards removed. This includes chain guards, belt guards, snub roller guards, center drive guards and any other safety guard.


 Do not walk, ride, climb, or touch moving parts on a conveyor in operation.


 Do not wear loose clothing or uncovered hair around conveyor.


 Do not work near conveyor without knowing how & where to shut power "OFF" and lock out power source.

 Do not remove jammed product with conveyor running.


 Do not replace parts or perform maintenance on conveyor, or moving conveyor parts, without first shutting "OFF" power to conveyor and locking out power source.


 Do not connect gravity to powered conveyor without safety gravity connector brackets.

 To prevent electrical shock, conveyor must be grounded, and have proper electrical connections in accordance with federal, state, and local codes.

 Safety pop out rollers in conveyors installed above 7'-0" elevation must be retained by guard rail, clips, etc. Safety pop out rollers must be allowed to pop out

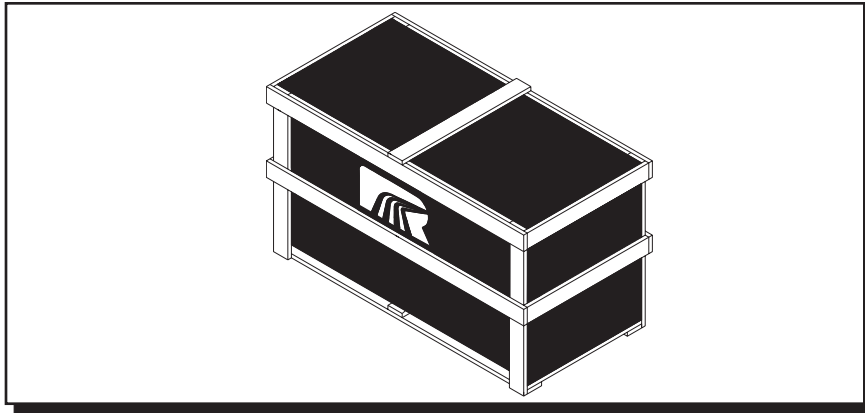
when conveyors are installed at or below 7'-0" elevation.

 It is the responsibility of conveyor end-user to comply with all safety standards including OSHA and other federal, state, and local codes or regulations. Install protective guarding and other related safety precautionary equipment to eliminate hazardous operating conditions which may exist when two or more vendors supply machinery for related use.

 Any violation of above safety instructions hereby removes all product liability claims from Roach Manufacturing Corporation®.

RECEIVING AND INSPECTION

SHORTAGES, DAMAGES AND RETURN AUTHORIZATIONS



NOTE: Do not return goods to factory without prior, written return authorization. Unauthorized returns are subject to refusal at factory.

Before uncrating, check the quantity of items received against bill of lading to confirm that all material has been received. Examine the condition of the equipment to determine if any damage has occurred.

Also, it is possible that some items may become separated from the original shipment. Therefore, when receiving goods, it is imperative that the bill of lading (or,

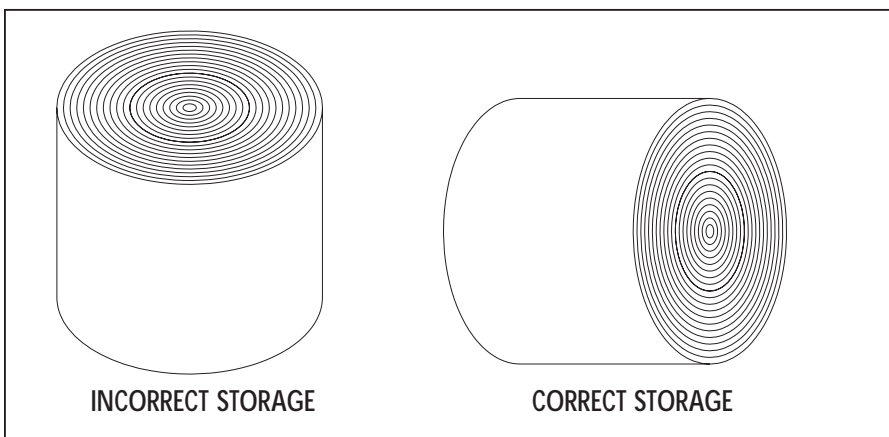
accompanying freight documentation) be checked to ensure receipt of ALL units ordered including ALL accessories.

Damage and/or shortage in shipment should be reported immediately to both vendor and carrier. Obtain a signed damage report from carrier agent and send copy to vendor. **Do not repair any damage before obtaining this report.**

For damaged shipments, consult factory to determine if entire shipment must be returned to factory for repair or if an immediate order should enter production to produce a new, replacement shipment.

In illustration A above, model 196RBF is shown palletized with belting and return rollers for all bed sections mounted to top of crate which is prepared for shipment.

UNCRATING AND STORAGE



NOTE: Never store belt placed directly on floor. Elevate belting to prevent contact with floor moisture.

After receipt and initial inspection is completed, carefully remove crating and look for essential components and specific accessories that may have been boxed and attached (or 'banded') to crating material. Safety pop out rollers, guard rails and hardware are often packaged and shipped in this manner. Save all hardware for subsequent use by installation personnel.

The drive section will be shipped mounted to its actual operating bed section (see illustration at top of page). Intermediate bed sections are shipped mounted on top of drive bed section with formed steel stiffener (spacer) brackets.

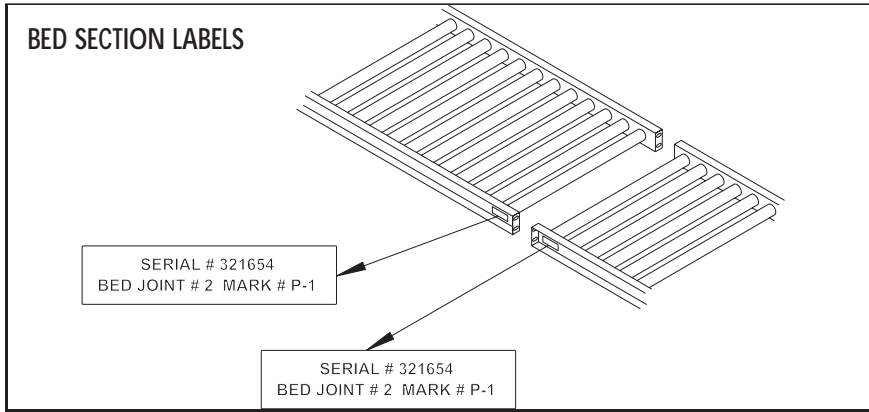
Belting must be housed in dry quarters. Do not store belt on edge (see illustration above). Also, never store belt placed

directly on floor. Elevate belting to prevent contact with floor moisture.

Some items (electric motors, gearbox, etc.) may be shipped direct from their manufacturer to final destination. Thus, the conveyor may consist of two or more separate shipments.

GENERAL INSTALLATION INFORMATION

ATTACHING BED SECTIONS



NOTE: It is critical for bed sections to be field assembled in proper sequence following bed section labels.

When preparing to install conveyor, first locate all component sections in the actual installation area. After uncrating, place unit bed sections conveying side up. Each bed section is marked to indicate proper sequence for mating (see illustration above for typical bed section labels).

It is critical for bed sections to be field assembled in proper sequence following

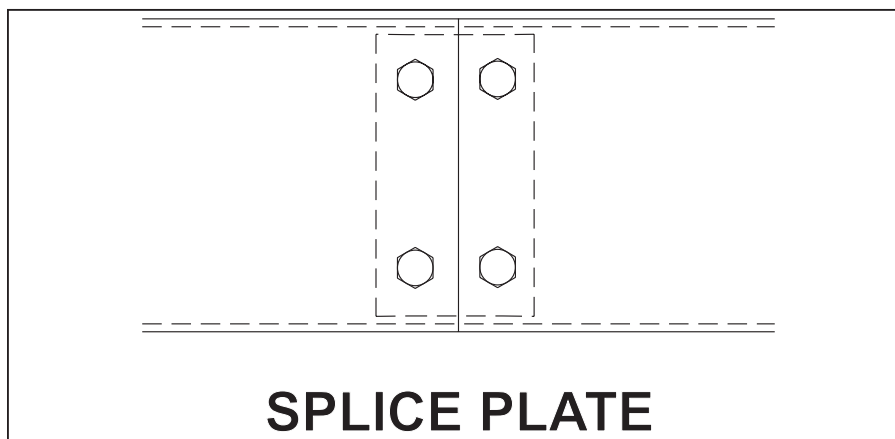
bed section labels. Refer to bed section drawing for location of supports and assemble as shown.

Conveyors are set up at the factory, bed section labels are applied, unit is test run and receives rigorous quality assurance inspection. At this time unit becomes field-ready. Therefore, it is critical that field installation personnel re-assemble unit

by mating beds in accordance with bed section labels (and bed section drawing).

Create a reference base line on floor by marking a chalk line along the centerline of conveyor. Follow base line when installing unit.

COUPLINGS AND UNIT SQUARENESS



NOTE: One of the most critical elements of proper installation is unit squareness. Check pulleys, snub and return rollers and square each with unit bed.

Use mechanical hoist (fork truck or other available means) to raise bed sections to approximate installed elevation. Mate intermediate sections with butt couplings or splice plates to join bed sections (see illustration above).

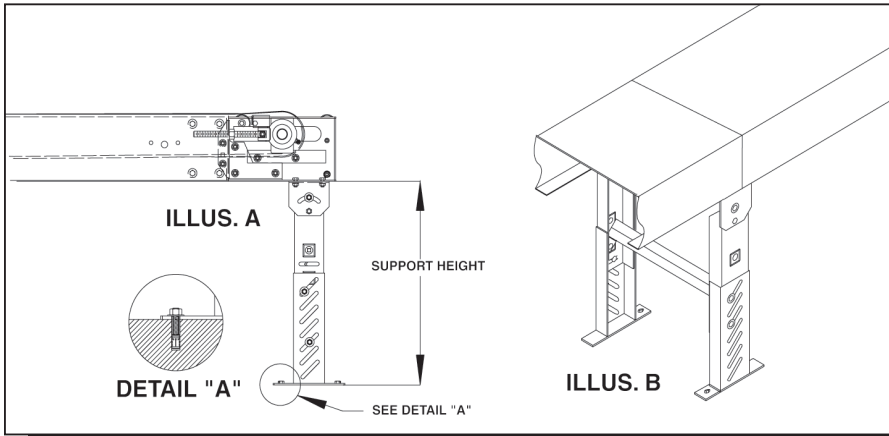
One of the most critical elements of proper installation is unit squareness. Check drive

pulley, tail pulley, snub roller (if used in drive assembly) and return roller assemblies to ensure these components are square with unit bed (see 'Belt Tracking' section later in handbook for detailed information).

The unit must be installed at level elevation across the width to prevent erratic belt tracking.

INSTALLATION OF SUPPORTS

IDENTIFYING/INSTALLING PERMANENT FLOOR SUPPORTS



CAUTION: Always anchor permanent supports to floor (or mounting surface). Use 3/8" x 2-1/2" (or longer) wedge anchors for permanent installation in concrete flooring.

*MINIMUM/MAXIMUM SUPPORT HEIGHT			
SM-1	7-1/4" — 10-1/4"	SM-7	34-1/4" — 46-1/4"
SM-2	10-1/4" — 13-1/4"	SM-8	46-1/4" — 58-1/4"
SM-3	13-1/4" — 16-1/4"	SM-9	58-1/4" — 70-1/4"
SM-4	16-1/4" — 22-1/4"	SM-10	70-1/4" — 82-1/4"
SM-5	20-1/4" — 26-1/4"	SM-11	80-1/4" — 92-1/4"
SM-6	24-1/4" — 36-1/4"	SM-12	92-1/4" — 104-1/4"

Permanent supports may be installed on conveyors at various locations. However, it is most common to use single tier permanent floor supports at each end of a powered section (see illustration A above) and where intermediate bed sections are adjoined (see illustration B above). Notice intermediate supports have two lag bolts in a diagonal pattern while end (terminal) supports have four lag bolts, one in each

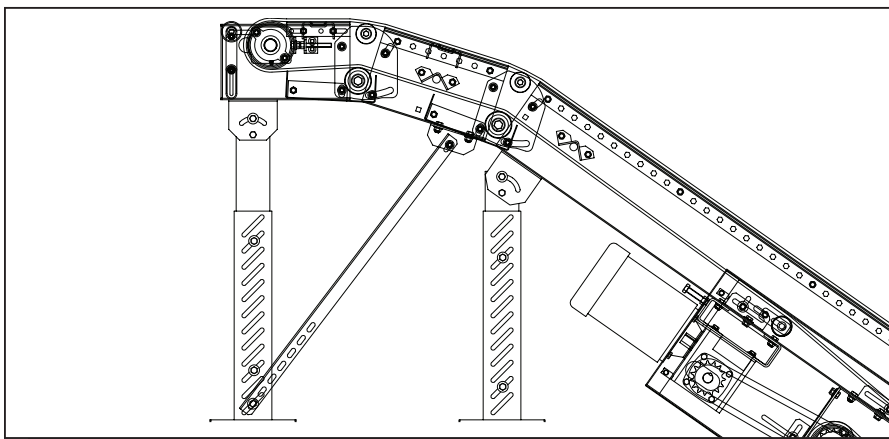
of the four foot plate mounting holes. When two (or more) powered conveyors are placed end-to-end, a single tier permanent support may be used at the end junction commonly supporting both units. Check load rating of support before using this method of installation.

Adjust elevation to top of conveyor by loosening bolts in support uprights, raising

or lowering conveyor and fully tightening bolts at desired elevation. Tighten all bolts in supports **before** unit operation. Complete support installation by lagging support attachment plates to floor. Confirm that unit is level across width of conveyor before completing final support height adj.

*Supports are normally shipped at minimum support height. See chart above.

INSTALLING KNEE BRACES



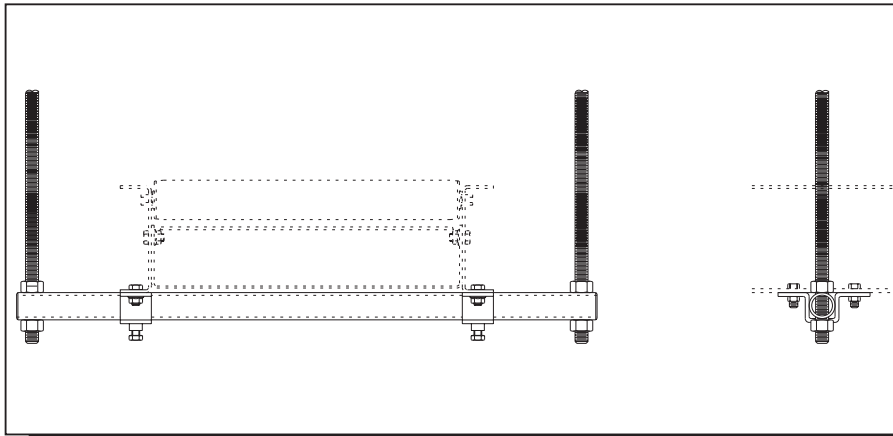
NOTE: Install knee brace (when supplied) after final permanent support installation and elevation adjustment.

Knee braces add strength and stability to permanent supports. Install knee brace (when supplied) after final permanent support installation and elevation adjustment. Its pivot bracket is bolted to underneath side of lower conveyor flange and slotted end is attached to outer side of support.

Knee braces are most commonly used at the terminal ends of long runs of conveyor lines and are recommended on inclined (or declined) floor-to-floor belt conveyors for added stability.

CEILING HANGERS AND UNDERTRUSSING

INSTALLATION OF CEILING HANGERS



WARNING: It is the responsibility of the customer and installation personnel to supply and install net or mesh guarding on conveyors mounted overhead to prevent product and/or debris from falling to floor in areas where required.

Ceiling hangers are frequently used in high-elevation applications for suspension from ceiling. The 5/8" diameter (#11 UNC) all threaded rod is supplied to allow infinite vertical adjustment along the length of the suspension rod (see illustration above).

Attach and firmly tighten U-shaped retainer ("hat") bracket to underneath side of lower

conveyor flange with hardware provided to hold cross pipe (1" inside diameter) against underneath side of conveyor.

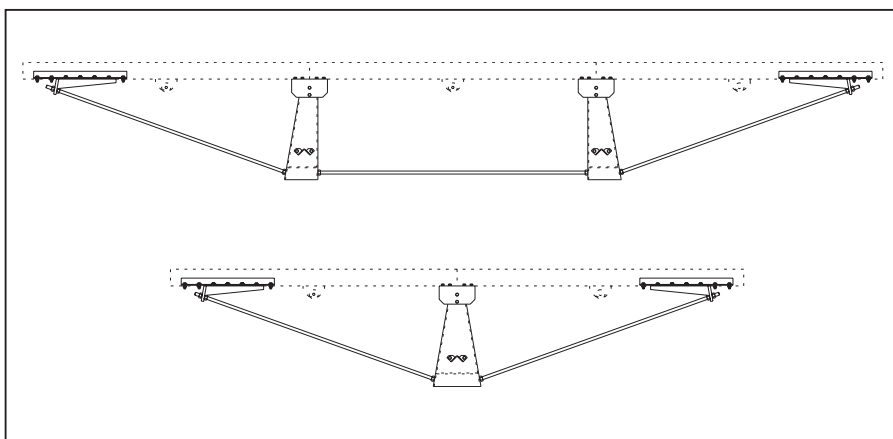
Do not tighten cross pipe locking bolts (these attach in the bottom of the U-shaped retainer bracket) until threaded suspension rods have been firmly secured to ceiling structure.

To adjust conveyor elevation, tighten or

loosen lower nut and jam nut on threaded suspension rods to desired elevation. A lock washer must be used on suspension rods to maintain unit at desired elevation.

When unit is at operating elevation and unit has been levelled across bed width, tighten locking bolts in U-shaped bracket to secure position of cross pipe.

INSTALLATION OF UNDERTRUSSING



WARNING: It is the responsibility of the customer and installation personnel to supply and install net or mesh guarding on conveyors mounted overhead to prevent product and/or debris from falling to floor in areas where required.

When installing some conveyors, using a permanent support or ceiling hanger is simply not practical. In this situation, three bed sections (maximum) may be joined together utilizing truss assembly, mounted underneath conveyor (see illustration above).

Adjoin beds on floor using both connector rod support assemblies and connector

rods (5/8" diameter-11UNC threaded rod). The diagonal connector rod is used not only to support the intermediate bed section joint but it is instrumental for setting and maintaining proper tension across intermediate spanned beds.

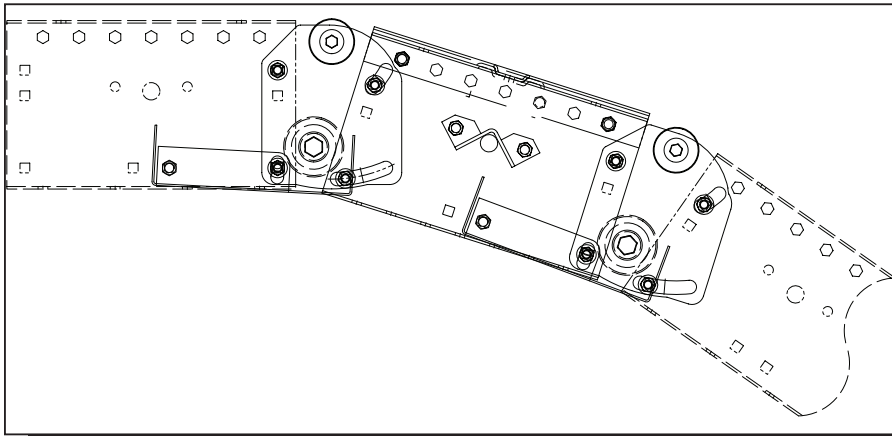
Use mechanical hoist (fork truck or other means) to raise pre-assembled bed sections (with undertrussing) to desired elevation

for final installation.

Use diagonal connector rods to level the undertrussed beds both along and across the conveyor. Remember that the tension must provide adequate for both dead load (conveyor weight) and product load during unit operation.

NOSE-OVER GUARDS AND FEEDERS

NOSE-OVER AND SNUB ROLLER GUARD ADJUSTMENT



CAUTION: Before unit is ready for operation, snub roller guard (cover) must be adjusted to ensure safe unit operation.

Nose-over assemblies may be supplied (optional) when roller belt conveyors are inclined or declined to ease the transition from inclined to horizontal. A single nose-over assembly consists of one set of nose-over brackets with carrier roller, one snub roller with snub roller guard and attachment bracket. A double nose-over

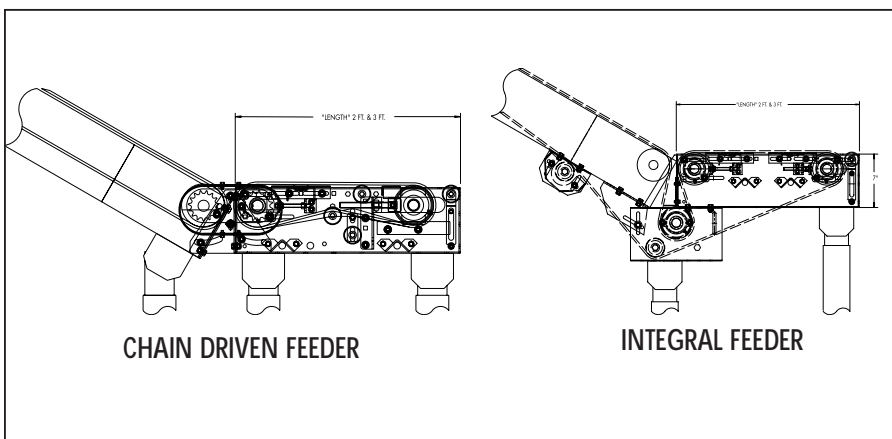
assembly includes one additional set of nose-over brackets and carrier roller.

Beds are cut and nose-over brackets and rollers are installed at the factory. Before unit is ready for operation, final adjustment of snub roller assembly is required to ensure safe unit operation. Snub roller

above) with 1/4" belt clearance between bottom of belt and top of guard, both sides of guard, during final installation.

guard (cover) should be set (see illustration

CHAIN DRIVEN AND INTEGRAL FEEDERS



NOTE: Optional integral feeders and chain driven feeders are often used to transfer product from horizontal position to inclined or declined conveyor section. Always use feeder when transferring to or from gravity conveyors.

Two types of feeders (both optional) are commonly supplied on floor-to-floor belt conveyors. Horizontal chain driven feeders (see above illustration) are powered from the inclined (or declined) conveyor section via slave drive connection. This feeder requires one support at each end of the feeder and an additional support at each intermediate feeder bed section

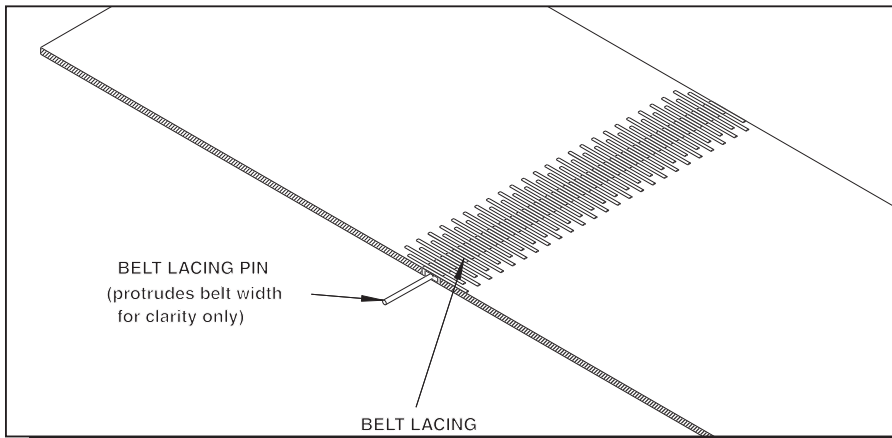
when installing.

Integral feeders (see above illustration) use a 3-pulley device to transfer the belt from its inclined section to the horizontal feeder to floor-to-floor conveyor. Here, the same type of belting, generally supplied as 2-ply ruff-top, is used on both feeder and inclined section due to the continuous travel of the

belt. Note that the support at the terminal feeder end must be 7" taller to top of support than the support assembly placed under the 3-pulley device, which commonly supports both intermediate feeder and inclined section.

INSTALLATION OF BELTING

BELT CONNECTIONS



CAUTION: Belt lacing must be kept in good condition for safe work environment.

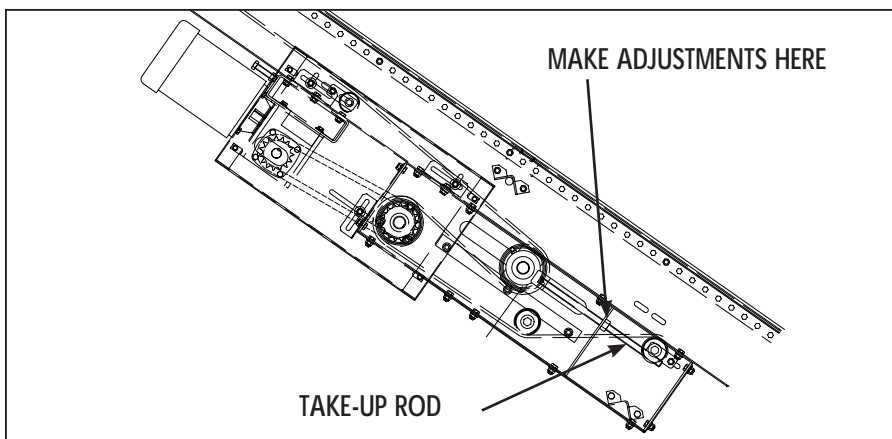
Conveyor belting is cut to proper length, laced and assembled on conveyor at the factory. It is test run and inspected before it is shipped to its final destination.

Before field installation of belting, it is critical to determine the correct side to be placed down. One of the most common problems associated with belt installation involves placing the incorrect side

down. The side to be placed down is a friction surface for decreased friction and improved conveyability. The friction side appears dull and grainy. ALWAYS place this side down against the conveyor roller bed. Inclined/declined units are generally supplied with ruff-top belting although some units feature specialty belting or even PVC. If unit is shipped "knocked down,"

belt must be re-threaded on unit during installation. (See opposite page for proper belt paths). Join ends of belt as shown in illustration above with lacing pin. Loosen threaded take-up rods (if necessary) at take-up pulley equal amount on both sides and re-adjust when belt is installed keeping pulley square with conveyor bed. A belt puller can also be used to join belting.

MAINTAINING PROPER BELT TENSION



CAUTION: Belt lacing must be kept in good condition for safe work environment. Also, do not operate unit with improper belt tension. Unit is subject to abnormal wear and maintenance when operated with belt incorrectly adjusted.

Maintaining proper belt tension is vital to unit operation. Enough tension should be maintained so that drive pulley does not slip under fully loaded conditions.

It is perfectly normal for a belt to stretch (in varying climatic conditions) under rated loading. Therefore, a short belt insert or "belt patch" (or patches) is provided for future removal when belting has stretched

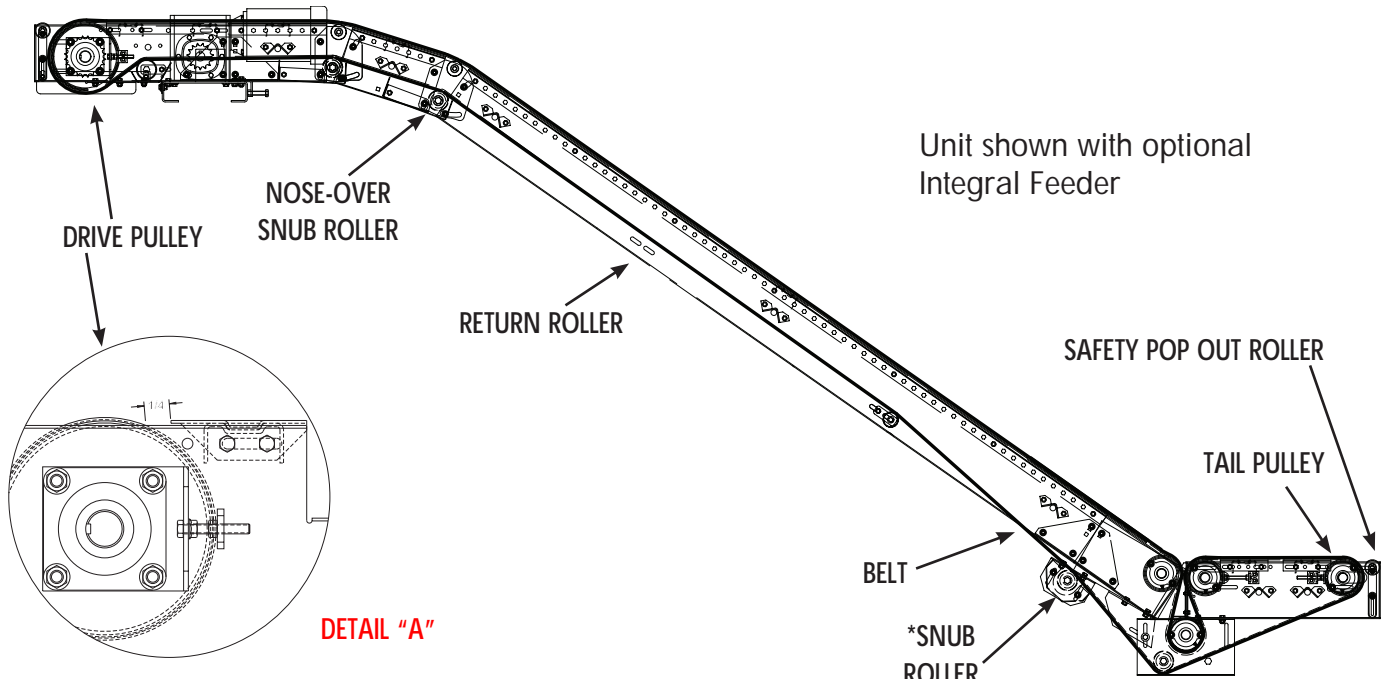
beyond means of conveyor take-up assembly. For yet additional belt take-up, the belt should be cut and re-laced to maintain proper belt tension.

To adjust conveyor take-up, adjust position of take-up rod (see illustration above) as required. Remember to equally adjust both sides to hold take-up pulley square (to maintain unit squareness for belt tracking).

Operating unit with slipping belt will decrease life of both belting and pulley lagging. Also, do not operate unit with too much tension on belt. This will decrease belt life and may harm unit drive and take-up bearings. Over tensioning belt requires additional horsepower from unit drive.

BELT PATH

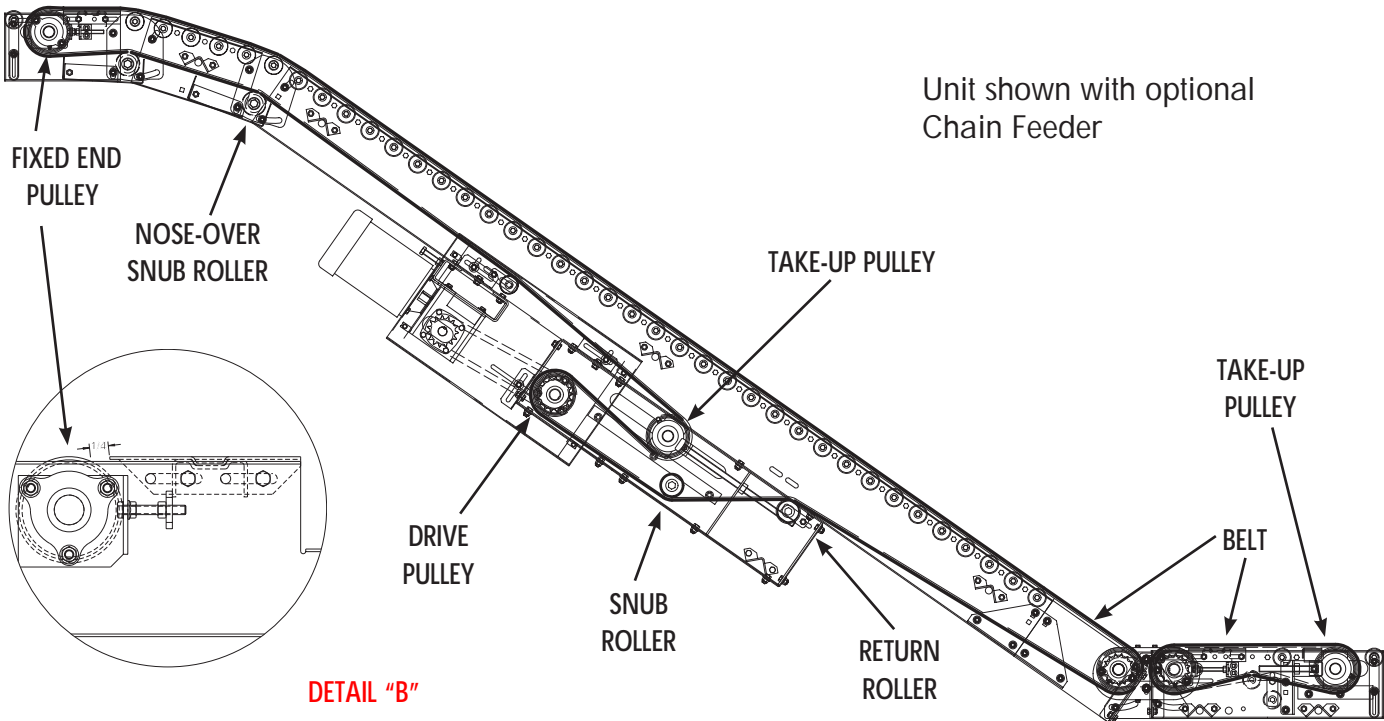
ILLUSTRATION FOR UNITS WITH (SIDEMOUNT) END DRIVE



*Supplied on 8" dia. drives and above

CAUTION: If pulleys are adjusted during installation or maintenance, it is crucial that nip point guard (at drive end) is readjusted. See detail "A" above. Note: Nip point guard on take-up end is automatically adjusted when take-up pulley is adjusted. If optional feeder is used, nip point guards in end assemblies (including drive or fixed end pulley) must be adjusted when feeder pulleys are adjusted.

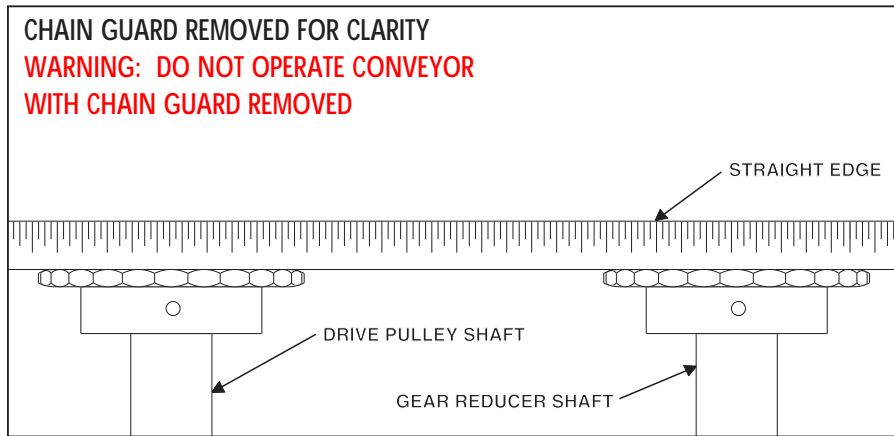
ILLUSTRATION FOR UNITS WITH CENTER DRIVE



CAUTION: If pulleys are adjusted during installation or maintenance, it is crucial that nip point guards (at both ends of conveyor) are readjusted. See detail "B" above. Center drive guards **MUST** be replaced after installation or maintenance. If optional feeder is used, nip point guards in end assemblies (including drive or fixed end pulley) must be adjusted when feeder pulleys are adjusted.

START-UP PROCEDURES

DRIVE CHAIN AND SPROCKET ALIGNMENT



WARNING: To check drive sprocket alignment, it is imperative that conveyor is shut "OFF" and power source is locked out before any adjustments are attempted.

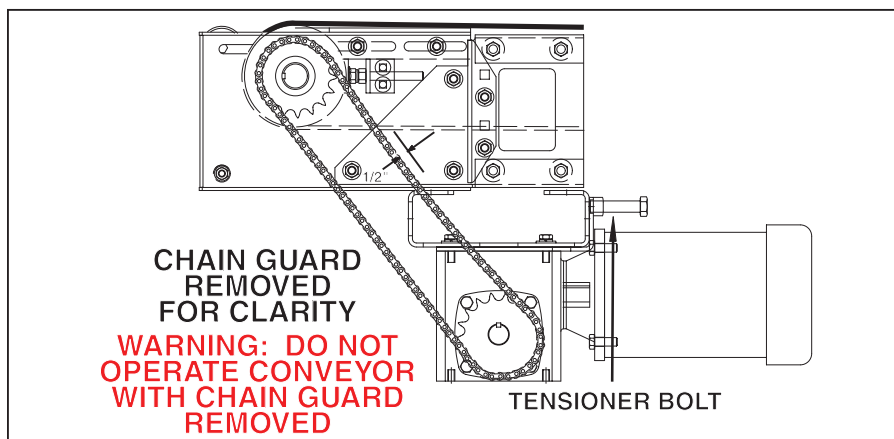
Set up and maintenance of drive sprocket and drive chain alignment is critical. A periodic visual inspection is recommended to confirm alignment of drive components (which includes both drive sprockets and drive chain). Should set screws become loose, drive sprockets are subject to excessive wear and ultimately, to untimely replacement.

To check drive sprocket alignment, it is imperative that conveyor is shut "OFF" and power source is locked out before any adjustments are attempted. Remove chain guard cover and place straight-edge (see illustration above) across face of both drive sprockets. If re-alignment is necessary, loosen set screws and adjust drive

sprockets as required. **Remember to securely tighten set screws when alignment is complete.**

Before replacing chain guard cover, check drive chain tension as described in following section, "Drive Chain and Sprocket Tension."

DRIVE CHAIN AND SPROCKET TENSION



WARNING: To check drive sprocket tension, shut "OFF" and lock out power source before any adjustments are attempted.

Maintaining proper chain tension is especially important. Again, a periodic visual inspection is recommended to ensure chain tension within a pre-determined operating range.

Remember, before any adjustments are attempted, conveyor must be shut "OFF" and power source locked out.

Before replacing chain guard cover, check

to see if drive chain is operating within 1/2" range (see above illustration). If unit is out of tolerance, adjustment is necessary.

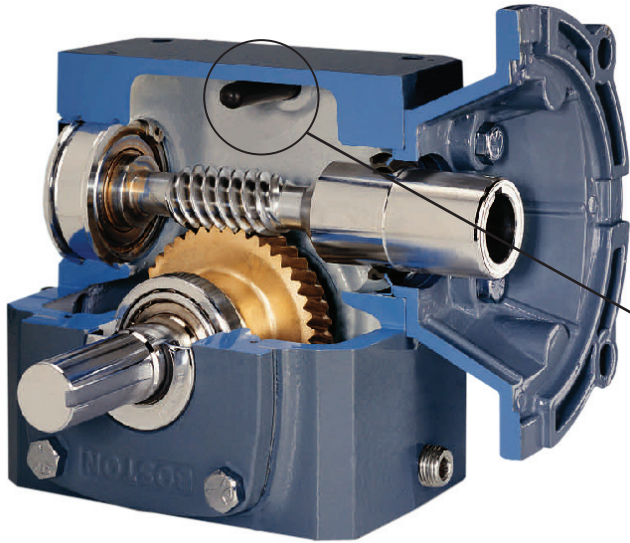
To adjust drive chain tension, tensioner bolt located on reducer push plate should be tightened (rotate clockwise) if chain tension is loose. Tighten until proper operating range is achieved. If chain tension is too tight, loosen tensioner bolt (rotate counter-

clockwise) as required. When adjustment is complete replace chain guard cover.

WARNING: Do not operate unit until chain guard cover is replaced. Serious operator or other personal injury could result if protective guarding is not replaced.

START-UP PROCEDURES

GEAR REDUCER VENT PLUG



NOTE
The gear reducer is supplied with a "PosiVent®". No vent plugs are required.

PosiVent Unique design incorporates a single seam construction. Factory filled with synthetic lubrication for universal mounting. Lubed for life, no oil changes are required.

To expedite the installation and start-up process, all gear reducers are shipped filled with oil. The reducers are sealed and lubed for life and require no oil changes.

PREPARING FOR INITIAL START-UP



⚠ DANGER
WARN ALL PERSONNEL TO KEEP CLEAR OF CONVEYOR DURING UNIT START-UP
Electrical controls must be designed by a qualified electrical engineer to ensure that appropriate safety features (emergency stops, pull cords, switches, etc.) are installed on unit for safe operation. Before conveyor start-up, all operators and other personnel coming in contact with unit must be properly trained and must have read accompanying Tech Handbook.

Before conveyor start-up, all operators and other personnel coming in contact with unit must be properly trained and must have read accompanying Tech Handbook.

Provisions must be in order to instruct all personnel coming in contact with conveyor on the location of emergency stops, pull cords, etc.

A routine maintenance program should be implemented before unit is placed into

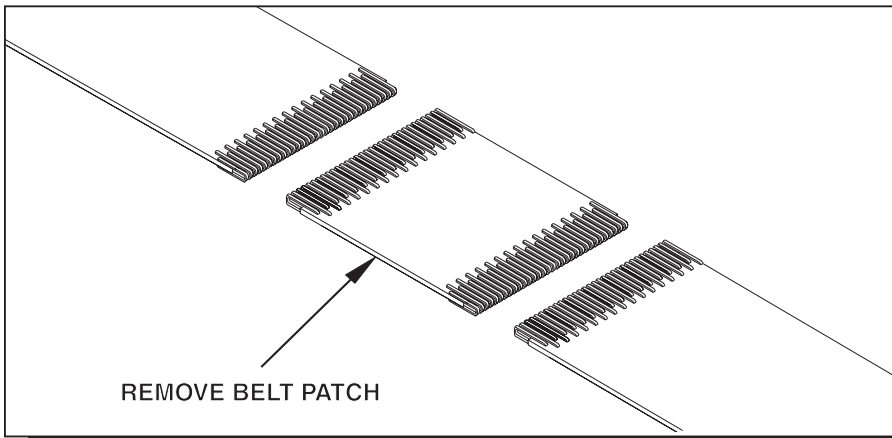
operation so that fundamental unit components are attended to. This maintenance program should include an inspection to ensure that any dangerous or hazardous operating conditions are noted and IMMEDIATELY corrected, as well as including electrical and mechanical unit inspections and corrections.

Finally, when conveyor is initially started, an immediate visual inspection should

include motor, gear reducer, belt tracking (discussed in following section under "Belt Tracking") and related adjustments noted in handbook for unit/component corrections.

BELT TRACKING

GENERAL INFORMATION



CAUTION: Upon initial operation the belt will stretch. To maintain proper belt tension, adjustment of the take-up pulley or removal of belt patch will be required. ONLY trained personnel should make belt tracking adjustments.

Upon initial use the belting will stretch after a few days of operation. Remember that maintaining proper belt tension is a crucial element in belt tracking. Therefore, this stretching of a belt when placed into operation may affect its ability to track. Adjustment of the take-up pulley will likely adequately compensate for initial stretch. However, depending on the overall unit

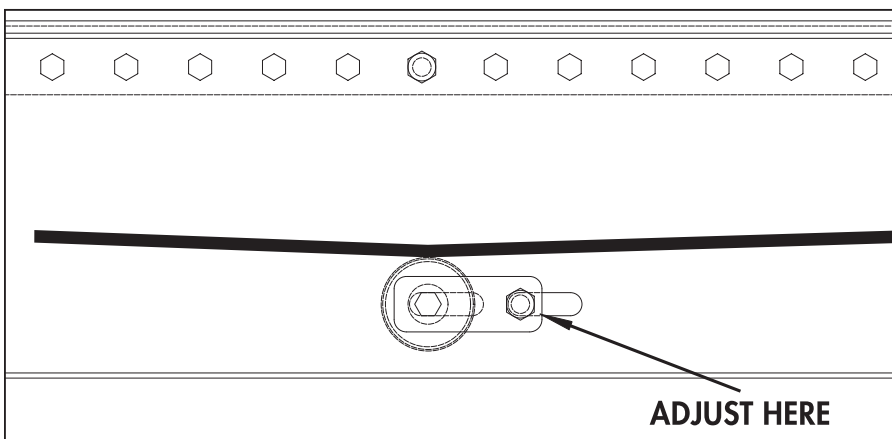
length, removal of a belt patch may be necessary to correct.

Belt must be tracked in both unloaded and loaded situations. The return direction of the belt must clear supports, ceiling hangers, floor openings, etc. Dragging on such components will contribute to belt tracking problems and is certain to damage belting

at extended intervals.

In a reversible application, a belt that runs off to one side in one direction will likely run off to the other side when operated in the opposite direction. Do not allow belt to rub against side of conveyor frame, which will surely damage belt.

SKEWING RETURN ROLLERS



CAUTION: ONLY trained personnel should make belt tracking adjustments. Shut unit "OFF" and lock out power source before attempting adjustments in belt tracking.

One of the most common and productive means to track conveyor belting is to skew return rollers. Do not **excessively** skew return rollers simply to track belt. Excess skewing of rollers, which may cause belt to bow and may force belt to rub on side frame causing belt damage, usually will not completely solve belt tracking problems.

To adjust return rollers, simply loosen both

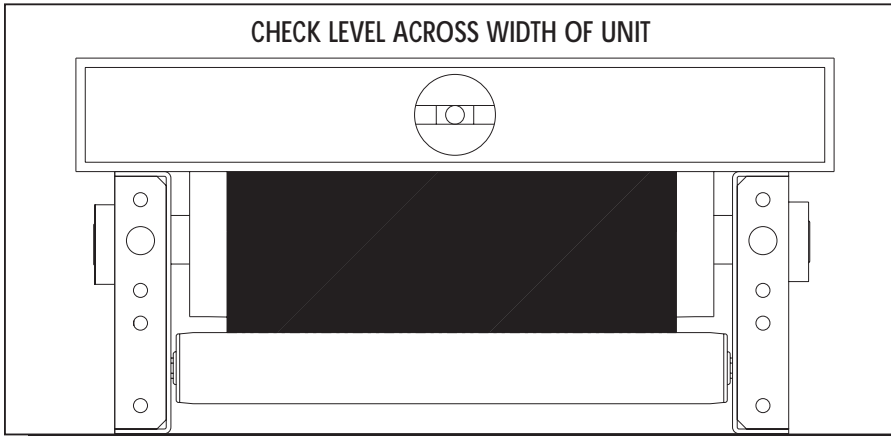
attachment bolts securing brackets to lower flange underneath conveyor (see illustration above). Move brackets to skew return roller assemblies (as noted in Advanced Tracking Adjustments later in manual). Remember to make adjustments in **SMALL** increments.

When adjustments are complete, tighten both bolts firmly securing return roller

brackets to lower conveyor flange.

BELT TRACKING

ERRATIC TRACKING AT START-UP



CAUTION: Upon start-up, if belt tracks to one side of unit, turn unit "OFF", lock out power source and confirm that conveyor is square and that all prime tracking components are square with bed. Belt tracking adjustments should be performed by trained personnel ONLY.

Improper tracking of conveyor belting should be considered a "systems" problem rather than solely a deficiency in the belt. To explain, a belt is tracked with adjustments made in the system or entire conveyor rather than just the belting.

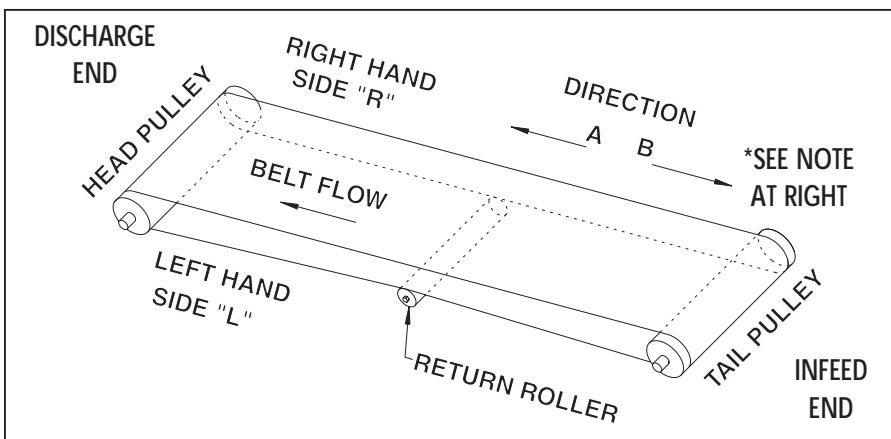
Upon start-up, if belt tracks to one side of unit, turn unit "OFF", lock out power source and confirm that conveyor is square. All

prime tracking components must be square with bed including drive pulley, tail pulley, snub roller and return rollers. Both sides of take-up should be adjusted exactly the same amount. The conveyor should be level across the width of the unit. Confirm that the belt has been properly threaded (see "Belt Path" section) and that belt lacing is square with the belt edges. Make

adjustments as necessary; however, all adjustments should be made in small increments.

Start conveyor again and operate for at least ten minutes once initial phase of adjustments are complete. If belt continues to track erratically, turn unit "OFF" before belt is allowed to run so far off center that it rubs side of conveyor.

ADVANCED TRACKING ADJUSTMENTS



CAUTION: Belt tracking adjustments should be performed by trained personnel ONLY. Read section on "Belt Tracking" completely before attempting belt tracking adjustments.

***NOTE:** When making adjustments in direction "A" or direction "B", component must pivot from side "L" with actual component movement on side "R".

When adjustments noted in section above have been completed and belt continues to track erratically, a second series of tracking adjustments are necessary.

First, determine the infeed and discharge ends of the conveyor. The following adjustments will be made with the infeed end as the reference point.

If belt tracks toward side "R" (see illustra-

tion above), skew return rollers in direction "B" to shift belting toward side "L". If belt tracks toward side "L", skew return rollers in direction "A" to shift belting toward side "R".

Skewing head pulley (pulley at unit discharge) in direction "A" moves belt toward side "L". Skewing head pulley in direction "B" moves belt toward side "R".

As a rule of thumb, do not use drive and take-up pulley for belt tracking since this will overly increase belt tension. When adjusting take-up pulley, adjust both sides an equal amount.

As a last resort, shift the tail pulley in direction "B" to move belting toward side "L"; shift head pulley in direction "A" to move belting toward side "L".

MAINTENANCE SAFETY PRECAUTIONS BEFORE PERFORMING MAINTENANCE

CAUTION: Only trained personnel shall perform maintenance functions. Before maintenance operations are performed, conveyor must be shut "OFF" and disconnects locked in the "OFF" position to prevent unit from unauthorized start-up.

One of the most important guidelines for maximizing conveyor operation and personnel safety is to implement a regular maintenance schedule and train personnel on the appropriate needs of the specific unit.

Only trained personnel shall perform maintenance functions. Before maintenance operations are performed, conveyor must be shut "OFF" and disconnects locked in the "OFF" position to prevent unit from unauthorized start-up during maintenance. All personnel should be informed of the safety procedures associated with unit maintenance and performance.

Do not perform any work on conveyors or conveyor system while

in operation unless it is impossible to otherwise conduct adjustment, lubrication or other maintenance function. Only experienced, trained personnel possessing advanced hazards-training should attempt such critical operations.

MAINTENANCE AND FOLLOW-UP DETAILS

CAUTION: Only trained personnel shall perform maintenance functions. When maintenance is completed, only authorized personnel shall be permitted to start conveyor following maintenance or other emergency shut-off.

While performing maintenance do not wear loose clothing. Immediately report any hazardous conditions--sharp edges, pinch (or nip) points or other conditions that may result when several manufacturers supply machinery which may create operating hazards.

When using mechanical aids such as hoists, cables, or cranes exercise extreme caution to prevent damage to conveyors or other integrated machinery which may create a working hazard when maintenance is completed and units are in operation.

Clean up any spilled lubricants or other materials used in the maintenance process or those which may be deposited during unit operation. Eliminating poor housekeeping practices increases unit efficiency while creating safer personnel working conditions.

After maintenance, conduct visual inspection to ensure that all safety devices and guards have been replaced. Confirm that all units are clear of tools, debris or other items. Before starting

conveyor, check condition of unit caution labels (see "CAUTION LABELS" at front of handbook). If labels have been destroyed or are not clearly legible, call 870.483.7631 to receive replacement labels. Placement of caution labels is critical to avoid unauthorized unit operation which may result in hazardous working conditions for all related personnel coming in contact with conveyor.

Warn personnel that conveyor is being prepared for start-up and to stay clear of unit. Do not start conveyor until all personnel are clear. When maintenance is completed, only authorized personnel shall be permitted to start conveyor following maintenance or other emergency shut-off.

MAINTENANCE AND LUBRICATION MAINTENANCE SCHEDULES

MODEL NO. _____

WEEKLY RECOMMENDED MAINTENANCE SCHEDULE*	
COMPONENT	DETAIL OF MAINTENANCE
Belting	Inspect belt tracking.
Pillow Block / Flange Bearings	Lubricate in dirty, dusty, or moist/wet conditions.
Unit Safety Check	Confirm placement of all guards, pop-out rollers, warning labels & check for loose bolts, nip points & other hazards.

MONTHLY RECOMMENDED MAINTENANCE SCHEDULE*	
COMPONENT	DETAIL OF MAINTENANCE
Gear Reducer	Check for leaks.
Belting	Check for proper operating tension & laced connections
Drive Sheaves	Check & re-tighten set screws & check for overall wear.
Pillow Block / Flange Bearings	Lubricate (normal conditions).
Drive Chain	Check for proper operating tension & overall wear & lubricate.
Drive Sprockets	Check for overall wear & re-tighten set screws.

PERIODIC RECOMMENDED MAINTENANCE SCHEDULE*	
COMPONENT	DETAIL OF MAINTENANCE
Gear Reducer	Check for leaks.
Drive Chain	Clean (brush in solvent) & re-lubricate by applying lubricant to inside of chain with brush or spout can at 2000 hour intervals.
Motor	Check & clear motor ventilation openings at 500 hour intervals Check miscellaneous operating conditions (normal heat & noise).

*All charts are for guidelines in normal operating or 'as noted' conditions. Severe applications may warrant additional maintenance

MAINTENANCE AND LUBRICATION

RECOMMENDED LUBRICANTS

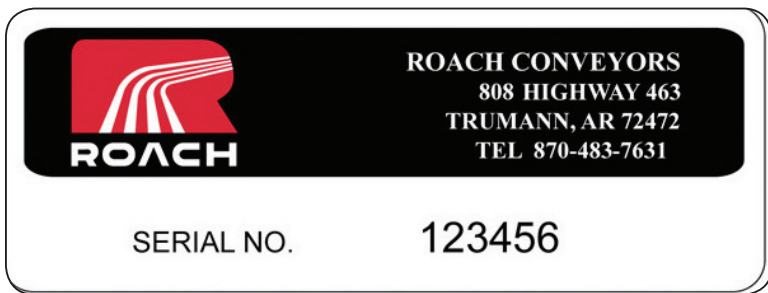
MISC. LUBRICANTS	
LUBRICANT	BRAND/DESCRIPTION
General Purpose Grease (For -30°F to 300° operation)*	Shell Dolium R (Shell Oil Co.) (or Suitable equivalent)
For extreme Temperature Operation (-90°F to 350°F operation)*	Mobiltemp SHC-32 (Mobil Oil Corp.) (or suitable equivalent)
Washdown Application* (-30°F to 225°F operation) (May require special consideration -- consult factory)	Shell Alvania No. 3 (Shell Oil Co.) (or suitable equivalent)
General Purpose Oil	SAE 10; SAE 20 or SAE 30

*NOTE: Temperatures listed indicate the nominal operational temperature for the specific **lubricant** listed. This does not imply that the bearing housing, seals or any other conveyor unit component is rated to operate in this specific temperature range or environment. 250°F is the maximum operating temperature for standard bearing lubricants and bearing components. Although various lubricants may enhance bearing operation, special-order bearings may be required to achieve optimal bearing performance. For additional information, consult factory.

TROUBLE SHOOTING AND REPLACEMENT PARTS

TROUBLE SHOOTING / SERIAL PLATE

TROUBLE SHOOTING		
TROUBLE	PROBABLE CAUSE	REMEDY
Motor & gear reducer running excessively hot, or hard to start	A. Drag on conveyor B. Lack of lubricant C. Frozen sprocket D. Frozen roller E. Overload F. Electrical	A. Inspect entire conveyor for obstruction causing drag on chain. B. Check for leaks. C. Check and inspect all sprockets and bearings. Replace sprockets failing to rotate or that are difficult to rotate. D. Check all rollers for rotation. E. Reduce cause and/or increase motor horsepower. F. Check wiring and circuits, take ampere reading, replace motor if necessary.
Motor & gear reducer makes excessive noise	A. Lack of lubrication B. Damaged Gears C. Faulty Bearing	A. Check for leaks. B. Replace unit. C. Replace bearing.
Drive chain, conveying chain or sprockets experience excessive wear	A. Excessive chain tension B. Sprockets misaligned C. Chain not lubricated D. Damaged sprocket or chain E. Misalignment of chain guard F. Dirty chain	A. Reduce chain tension. B. Realign with straight edge across sprocket faces. C. Lubricated chain with approved lubricant, wipe away excess lubricant. D. Replace Damaged Component. E. Adjust chain guard assembly as necessary. F. Clean thoroughly and lubricate with approved lubricant.
Drive chain, conveying chain or sprockets make excessive noise	A. Insufficient chain tension B. Chain not adequately lubricated C. Sprockets misaligned	A. Adjust chain tension. B. Lubricate chain with approved lubricant, wipe away excess lubricant. C. Realign sprockets with straight edge across sprocket faces.
Pulsating chain	A. Insufficient chain tension B. Misalignment of chain guard C. Overload	A. Adjust chain tension. B. Adjust chain guard assembly as necessary. C. Inspect for obstruction to or drag on conveyor.
Broken chain	A. Frozen bearing or sprocket shaft B. Worn or damaged chain C. Obstructed or jam	A. Inspect for damaged bearings, replace if necessary. Replace links as required. B. Replace chain as required. C. Remove obstruction to clear jam.
Sprocket loose on shaft	A. Loose set screws B. Worn or damaged key	A. Realign sprockets with straight edge and tighten set screws. B. Replace with new key.
Excessive slack in chain	A. Normal wear	A. Expect rapid chain growth in first two weeks of operation. B. Adjust chain tension as specified in the manual.



Shown at actual size, this aluminum plate is placed on the conveyor frame near the location of the drive assembly.

To order replacement parts or add-on components, contact the Roach distributor who originally furnished the unit if possible. If this is not possible, contact the National Sales Office at 870-483-7631 for the name of the authorized Roach distributor in your area. Have unit model number and serial number **BEFORE** calling. Refer to unit drawings (in rear section of handbook) for part numbers if ordering replacement parts.

ORDERING REPLACEMENT PARTS

To order any replacement parts or when calling for assistance with any powered conveyor, **ALWAYS** provide the unit serial number.

MODEL 796RBF

PARTS LIST

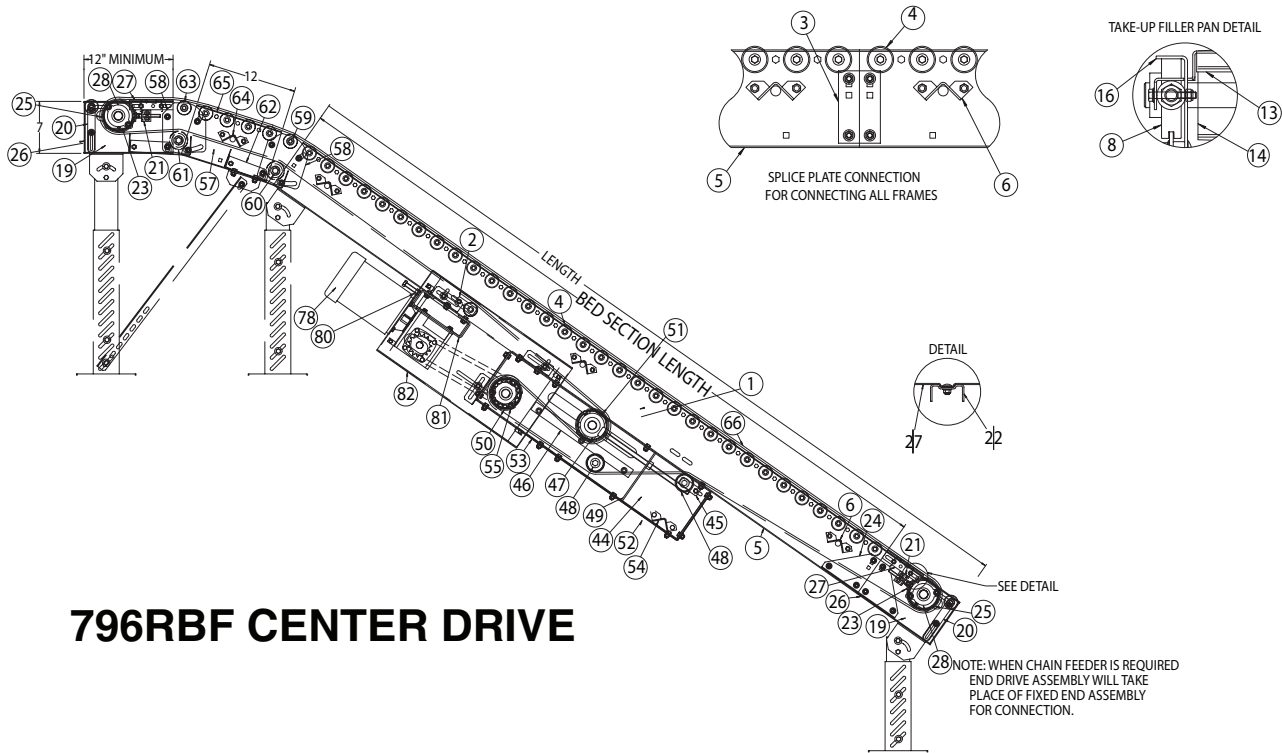
Item #	Description	Item #	Description
1	796RB Intermediate bed assembly	22	Bed pan brace (27" BF & Above)
2	1.9 Roller keeper	23	Bearing push plate
3	splice Plate	24	Bed joint mounting angle
4	196S Roller Assembly	25	6" idler pulley assembly
5	Medium duty side channel 12"-120"	26	6" fixed & end drive plate (LH/RH)
6	Frame crossbrace	27	Filler pan
7	4" end take-up assembly	28	4 hole flange bearing w/1-7/16" bore
8	Take-Up Bearing Assembly	29	4" end drive assembly
9	Safety pop-out roller assembly	30	Safety pop-out roller assembly
10	4" Take-up bearing guide	31	Bearing take-up mounting angle
11	Bolt-in butt coupling	32	Bed pan brace (27" BF and above)
12	4" take-up bed joint mounting angle (LH/RH)	33	Bearing push plate
13	4" take-up filler pan assembly	34	Bed joint mounting angle
14	4" idler pulley assembly	35	4" drive pulley assembly
15	196S roller assembly	36	4" fixed & end drive plate (LH/RH)
16	4" take-up plate (LH/RH)	37	Filler pan
17	Bearing guide spacer	38	2 hole flange bearing w/1-3/16" bore
7	6" end take-up assembly	29	6" drive end assembly
8	Take-Up Bearing Assembly	30	Safety pop-out roller assembly
9	Safety pop-out roller assembly	31	Bearing take-up mounting angle
10	6" Take-up bearing guide	32	Bed pan brace (27" BF and above)
11	Bolt-in butt coupling	33	Bearing push plate
12	6" take-up bed joint mounting angle (LH/RH)	34	Bed joint mounting angle
13	6" take-up filler pan assembly	35	6" drive pulley assembly
14	6" idler pulley assembly	36	6" fixed & end drive plate (LH/RH)
15	196S roller assembly	37	Filler pan
16	6" take-up plate (LH/RH)	38	4 hole flange bearing w/1-7/16" bore
17	Bearing guide spacer	29	8" end drive assembly
18	Top take-up bearing guide	30	Safety pop-out roller assembly
19	4" fixed end assembly	31	Bearing take-up mounting angle
20	Safety pop-out roller assembly	32	Bed pan brace (27" BF and above)
21	Bearing take-up mounting angle	33	Bearing push plate
22	Bed pan brace (27" BF & Above)	34	Bed joint mounting angle
23	Bearing push plate	35	8" drive pulley assembly
24	Bed joint mounting angle	36	8" fixed & end drive plate (LH/RH)
25	4" idler pulley assembly	37	Filler pan
26	4" fixed & end drive plate (LH/RH)	38	4 hole flange bearing w/1-7/16" bore
27	Filler pan	39	2.5 roller keeper
28	2 hole flange bearing w/1-3/16" bore	40	Belt guard (LH/RH)
19	6" fixed end assembly	41	Snub roller belt guard
20	Safety pop-out roller assembly	42	251S roller assembly
21	Bearing take-up mounting angle	43	196S roller assembly (tread)

MODEL 796RBF

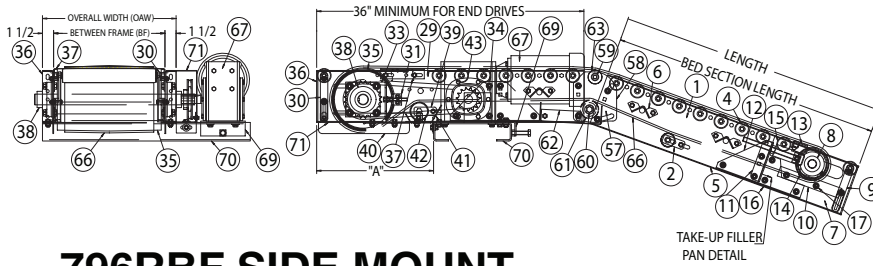
PARTS LIST

Item #	Description	Item #	Description
44	4" Center drive assembly	49	12" center drive plate weld assembly (LH/RH)
45	2.5 roller keeper	50	12" drive pulley
46	Center drive take-up bearing guide	51	8" idler pulley assembly
47	(milled) take-up bearing assembly (LH/RH)	52	12" center drive belt guard
48	251S roller assembly	53	12" center drive belt guard
49	4" center drive plate weld assembly (LH/RH)	54	Frame crossbrace
50	4" drive pulley assembly	55	4 hole flange bearing w/1-1-15/16" bore
51	4" idler pulley assembly	56	3 hole flange bearing w/1-3/16" bore
52	4" center drive belt guard	57	Single nose over assembly
53	4" center drive belt guard	58	Noseover plate
54	Frame crossbrace	59	7/16" hex washer
55	3 hole flange bearing w/1-3/16" bore	60	11/16" hex washer
44	8" center drive assembly	61	251S roller assembly
45	2.5 roller keeper	62	Snub roller guard
46	Center drive take-up bearing guide	63	196S roller assembly
47	(milled) take-up bearing assembly (LH/RH)	57	Double noseover assembly
48	251S roller assembly	58	Noseover plate
49	8" center drive plate weld assembly (LH/RH)	59	7/16" hex washer
50	8" drive pulley assembly	60	11/16" hex washer
51	4" idler pulley assembly	61	251S roller assembly
52	8" center drive belt guard	62	Snub roller guard
53	8" center drive belt guard	63	196S roller assembly
54	Frame crossbrace	64	Frame crossbrace
55	4 hole flange bearing w/1-7/16" bore	65	Side channel 12" long
44	12" center drive assembly w/4" take-up pulley	66	Belting assembly
45	Bearing push plate (LH/RH)	67	Sidemount drive kit
46	Center drive take-up bearing guide	68	Motorbase stiffener assembly
47	(milled) take-up bearing assembly (LH/RH)	69	Reducer push plate assembly
48	4" idler (snub) pulley assembly	70	Sidemount motorbase plate
49	12" center drive plate weld assembly (LH/RH)	71	sidemount chain guard assembly
50	12" drive pulley	72	End drive kit
51	4" idler pulley assembly	73	Motorbase stiffener assembly
52	12" center drive belt guard	74	Chain guard angle mount (LH/RH)
53	12" center drive belt guard	75	Reducer push plate assembly
54	Frame crossbrace	76	Underneath motorbase plate
55	4 hole flange bearing w/1-1-15/16" bore	77	Chain guard assembly
56	3 hole flange bearing w/1-3/16" bore	78	Center drive kit
44	12" center drive assembly w/6" or 8" take-up pulley	79	Motorbase stiffener assembly
45	Bearing push plate (LH/RH)	80	Reducer push plate assembly
46	Center drive take-up bearing guide	81	Underneath motorbase plate
47	Take-up bearing assembly w/1-7/16" bore	82	Center drive chain guard assembly
48	4" idler (snub) pulley assembly		

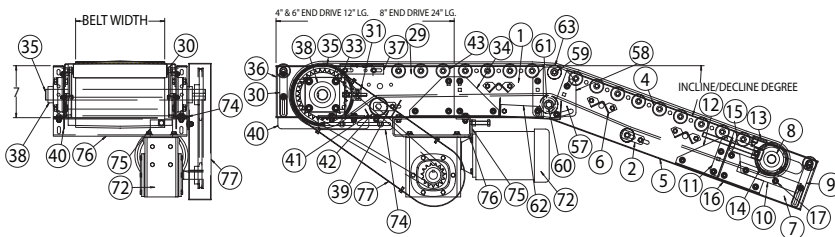
MODEL 796RBF DRAWINGS



796RBF CENTER DRIVE



796RBF SIDE MOUNT



796RBF END MOUNT

Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 20).

Recommended Spare Parts are shown in red. Charted are item numbers and part descriptions.

When ordering use example below.

Example: Need a replacement Center drive it for 796RBF

Part No: SN 123456 - 78 - Center drive kit



ROACH CONVEYORS
 808 HIGHWAY 463
 TRUMANN, AR 72472
 TEL. 870-483-7631

SERIAL NO. 123456

CAUTION: Use connector bracket with safety pop out roller to permanently attach gravity conveyor sections to 350BSBF.

MODEL 700SBF

PARTS LIST

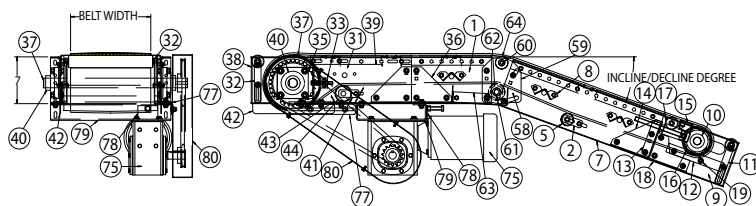
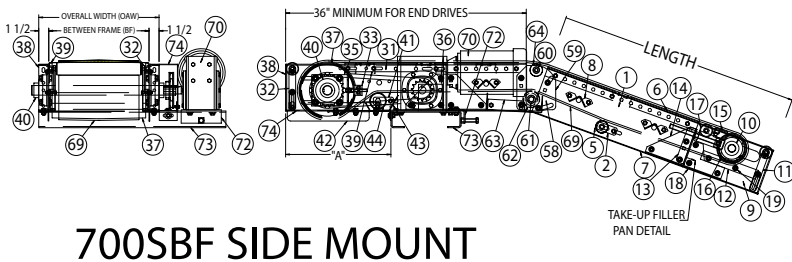
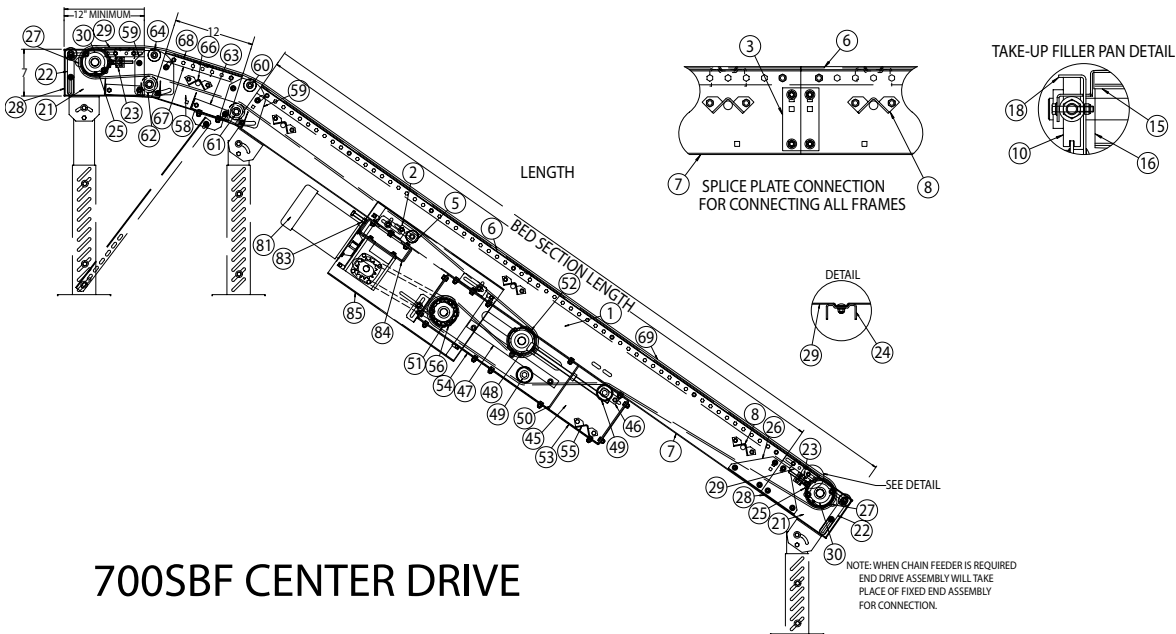
Item #	Description	Item #	Description
1	700Sb intermediate bed assembly	22	Safety pop-out roller assembly
2	1.9 roller keeper	23	Bearing take-up mounting angle
3	Splice plate	24	Bed pan brace (27" BF and above)
4	Bed pan brace (27" and above)	25	Bearing push plate
5	196S roller assembly	26	Bed joint mounting angle
6	Slider bed pan	27	6" idler pulley assembly
7	Medium duty side channel 12"-120"	28	6" fixed & end drive plate (LH/RH)
8	Frame crossbrace	29	Filler pan
9	4" end take-up assembly	30	4 Hole flange bearing w/1-7/16" bore
10	Take-up bearing assembly	31	4" end drive assembly
11	Safety pop-out roller assembly	32	Safety pop-out roller assembly
12	4" take-up bearing guide	33	Bearing take-up mounting angle
13	Bolt-in butt coupling	34	Bed pan brace (27" BF and above)
14	4" take-up bed joint mounting angle (LH/RH)	35	Bearing push plate
15	4" take-up filler pan assembly	36	Bed joint mounting angle
16	4" idler pulley assembly	37	4" drive pulley assembly
17	196S roller assembly	38	4" fixed and end drive plate (LH/RH)
18	4" take-up plate (LH/RH)	39	filler pan
19	Bearing guide spacer	40	2 hole flange bearing w/1-3/16" bore
9	6" end take-up assembly	31	6" drive end assembly
10	Take-up bearing assembly	32	Safety pop-out roller assembly
11	Safety pop-out roller assembly	33	Bearing take-up mounting angle
12	6" take-up bearing guide	34	Bed pan brace (27" BF and above)
13	Bolt-in butt coupling	35	Bearing push plate
14	6" take-up bed joint mounting angle (LH/RH)	36	Bed joint mounting angle
15	6" take-up filler pan assembly	37	6" drive pulley assembly
16	6" idler pulley assembly	38	6" fixed and end drive plate (LH/RH)
17	196S roller assembly	39	filler pan
18	6" take-up plate (LH/RH)	40	4 hole flange bearing w/1-7/16" bore
19	Bearing guide spacer	31	8" end drive assembly
20	Top take-up bearing guide	32	Safety pop-out roller assembly
21	4" fixed end assembly	33	Bearing take-up mounting angle
22	Safety pop-out roller assembly	34	Bed pan brace (27" BF and above)
23	Bearing take-up mounting angle	35	Bearing push plate
24	Bed pan brace (27" BF and above)	36	Bed joint mounting angle
25	Bearing push plate	37	8" drive pulley assembly
26	Bed joint mounting angle	38	8" fixed & end drive plate (LH/RH)
27	4" idler pulley assembly	39	Filler pan
28	4" fixed & end drive plate (LH/RH)	40	4 hole flange bearing w/1-7/16" bore
29	Filler pan	41	2.5 roller keeper
30	2 Hole flange bearing w/1-3/16" bore	42	Belt Guard (LH/RH)
21	6" fixed end assembly	43	Snub roller belt guard
		44	251S roller assembly

MODEL 700SBF

PARTS LIST

Item #	Description	Item #	Description
45	4" center drive assembly	51	12" drive pulley
46	2.5 roller keeper	52	6" or 8" idler pulley assembly
47	center drive take-up bearing guide	53	12" center drive belt guard
48	(Milled) take-up bearing assembly (LH/RH)	54	12" center drive belt guard
49	251S roller assembly	55	Frame crossbrace
50	4" center drive plate weld assembly (LH/RH)	56	4 hole flange bearing w/1-15/16" bore
51	4" drive pulley assembly	57	3 hole flange bearing w/1-3/16" bore
52	4" Idler pulley assembly	58	Single noseover assembly
53	4" center drive belt guard	59	Noseover plate
54	4" center drive belt guard	60	7/16" hex washer
55	Frame crossbrace	61	11/16" hex washer
56	3 hole flange bearing w/1-3/16" bore	62	251S roller assembly
45	8" center drive assembly	63	Snub roller guard
46	2.5 roller keeper	64	196S roller assembly
47	center drive take-up bearing guide	58	Double noseover assembly
48	(Milled) take-up bearing assembly (LH/RH)	59	Noseover plate
49	251S roller assembly	60	7/16" hex washer
50	8" center drive plate weld assembly (LH/RH)	61	11/16" hex washer
51	8" drive pulley assembly	62	251S roller assembly
52	4" Idler pulley assembly	63	Snub roller guard
53	8" center drive belt guard	64	196S roller assembly
54	8" center drive belt guard	65	Bed pan brace (27" BF and above)
55	Frame crossbrace	66	Frame crossbrace
56	4 hole flange bearing w/1-7/16" bore	67	Slider bed pan
45	12" center drive assembly w/4" take-up pulley	68	Side channel 12" long
46	Bearing push plate (LH/RH)	69	Belting assembly
47	Center drive take-up bearing guide	70	Sidemount drive kit
48	(Milled) take-up bearing assembly (LH/RH)	71	Motorbase stiffener assembly
49	4" idler (snub) pulley assembly	72	Reducer push plate assembly
50	12" center drive plate weld assembly (LH/RH)	73	Sidemount motorbase plate
51	12" drive pulley	74	Sidemount chain guard assembly
52	4" idler pulley assembly	75	End drive kit
53	12" center drive belt guard	76	Motorbase stiffener assembly
54	12" center drive belt guard	77	Chain guard angle mount (LH/RH)
55	Frame crossbrace	78	Reducer push plate assembly
56	4 hole flange bearing w/1-15/16" bore	79	Underneath motorbase plate
57	3 hole flange bearing w/1-3/16" bore	80	Chain guard assembly
45	12" center drive assembly w/6" or 8" take-up pulley	81	Center drive kit
46	Bearing push plate (LH/RH)	82	Motorbase stiffener assembly
47	Center drive take-up bearing guide	83	Reducer push plate assembly
48	Take-up bearing assembly	84	Underneath motorbase plate
49	4" idler (snub) pulley assembly	85	Center drive chain guard assembly
50	12" center drive plate weld assembly (LH/RH)		

MODEL 700SBF DRAWINGS



Specify Unit Serial Number when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 20).

Recommended Spare Parts are shown in red. Charted are item numbers and part descriptions.

When ordering use example below.

Example: Need a replacement Center drive kit for 700SBF

Part No: SN 123456 - 81 - Center drive kit



ROACH CONVEYORS
808 HIGHWAY 463
TRUMANN, AR 72472
TEL. 870-483-7631

SERIAL NO. 123456

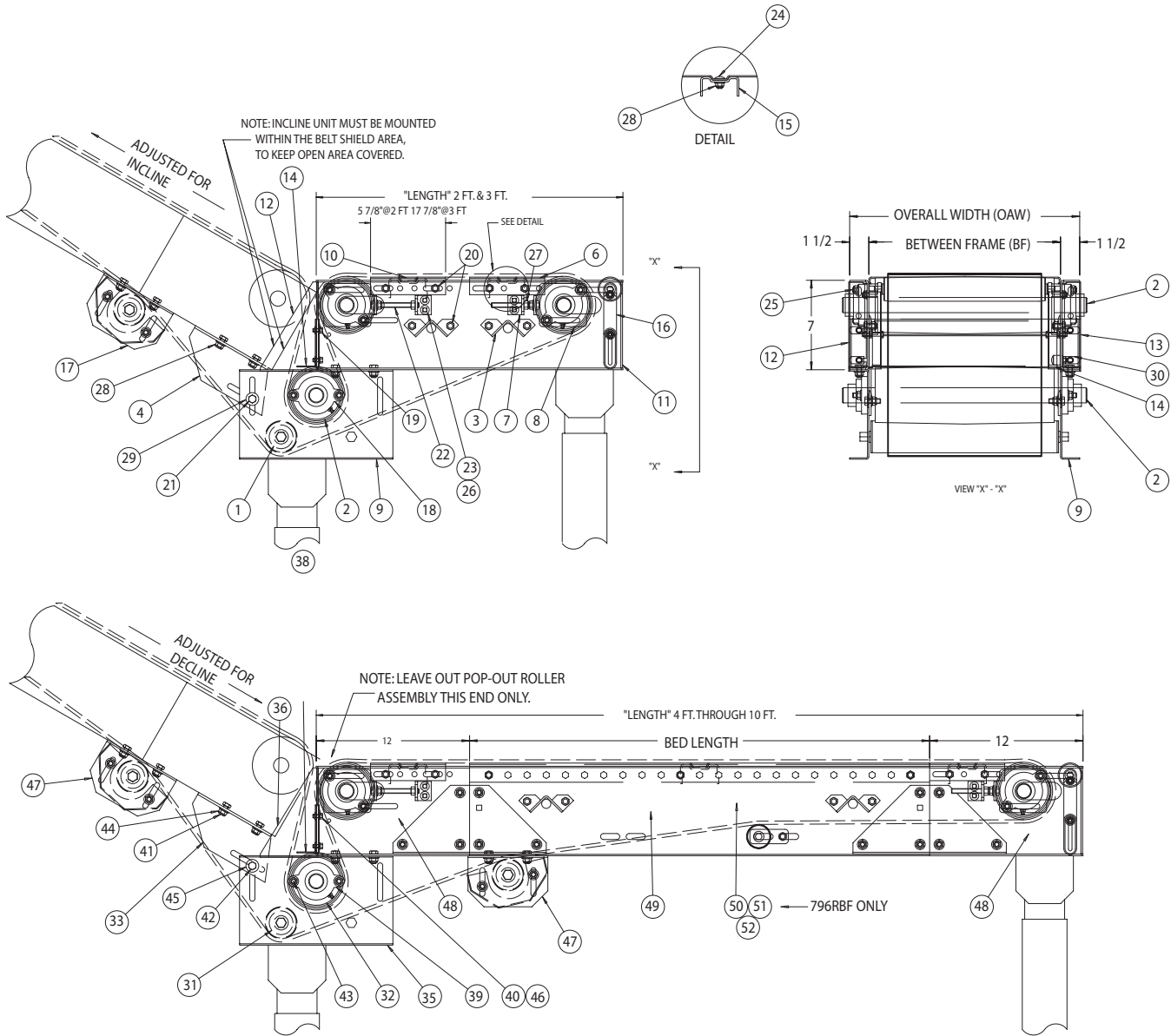
CAUTION: Use connector bracket with safety pop out roller to permanently attach gravity conveyor sections to 350BSBF.

MODEL BFI INTEGRAL BELT FEEDER

PARTS LIST FOR FEEDER (WHEN USED WITH CENTER DRIVE)

Item #	Description	Item #	Description
	2' x 3' Feeder Assembly	27	3/8" hex nut
1	251S roller assembly	28	3/8" nylon insert flange nut
2	4" idler pulley assembly	29	3/8" flat washer
3	Frame crossbrace	30	1/4" steel spring nut
4	Feeder pivot plate left hand		4' through 10' Feeder Assembly
5	Feeder pivot plate right hand	31	251S roller assembly
6	Filler pan (5-7/8")	32	4" idler pulley assembly
7	Bearing take-up mounting angle	33	Feeder pivot plate left hand
8	Bearing push plate	34	Feeder pivot plate right hand
9	Feeder mounting plate	35	Feeder mounting plate
10	Filler pan (17-7/8")	36	Integral feeder belt shield left hand
11	Integral feeder side channel	37	Integral feeder belt shield right hand
12	Integral feeder belt shield left hand	38	Integral feeder pulley guard
13	Integral feeder belt shield right hand	39	2 hole flange bearing 1-3/16" bore
14	Integral feeder pulley guard	40	1/4" - 20 x 1/2" whiz lock screw
15	Bed pan brace channel	41	3/8" x 3/4" long HHCS
16	Safety pop-out roller assembly	42	3/8" x 1" long HHCS
17	Snub roller kit	43	3/8" x 1-1/4" carriage bolt
18	2 hole flange bearing 1/3/16" bore	44	3/8" nylon insert flange nut
19	1/4" - 20 x 1/2" whiz lock screw	45	3/8" flat washer
20	3/8" x 3/4" long HHCS	46	1/4" steel spring nut
21	3/8" x 1" long HHCS	47	Snub roller kit
22	3/8" x 3-1/2" long HHTB	48	4" fixed end assembly
23	5/16" x 3/4" carriage bolt	49	700Sb intermediate bed section
24	3/8" x 3/4" long carriage bolt	50	Squaring rod (short) (796RB)
25	3/8" x 1-1/4" carriage bolt	51	Squaring rod (long) (796RB)
26	5/16" - 18 flange nut	52	Turnbuckle (796RB only)

MODEL BFI INTEGRAL BELT FEEDER DRAWINGS



Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 20).

Recommended Spare Parts are shown in red. Charted are item numbers and part descriptions.

When ordering use example below.

Example: Need a replacement 251S Roller assembly for BFI integral belt feeder

Part No: SN 123456 - 1- 251S Roller Assembly



ROACH CONVEYORS
808 HIGHWAY 463
TRUMANN, AR 72472
TEL. 870-483-7631

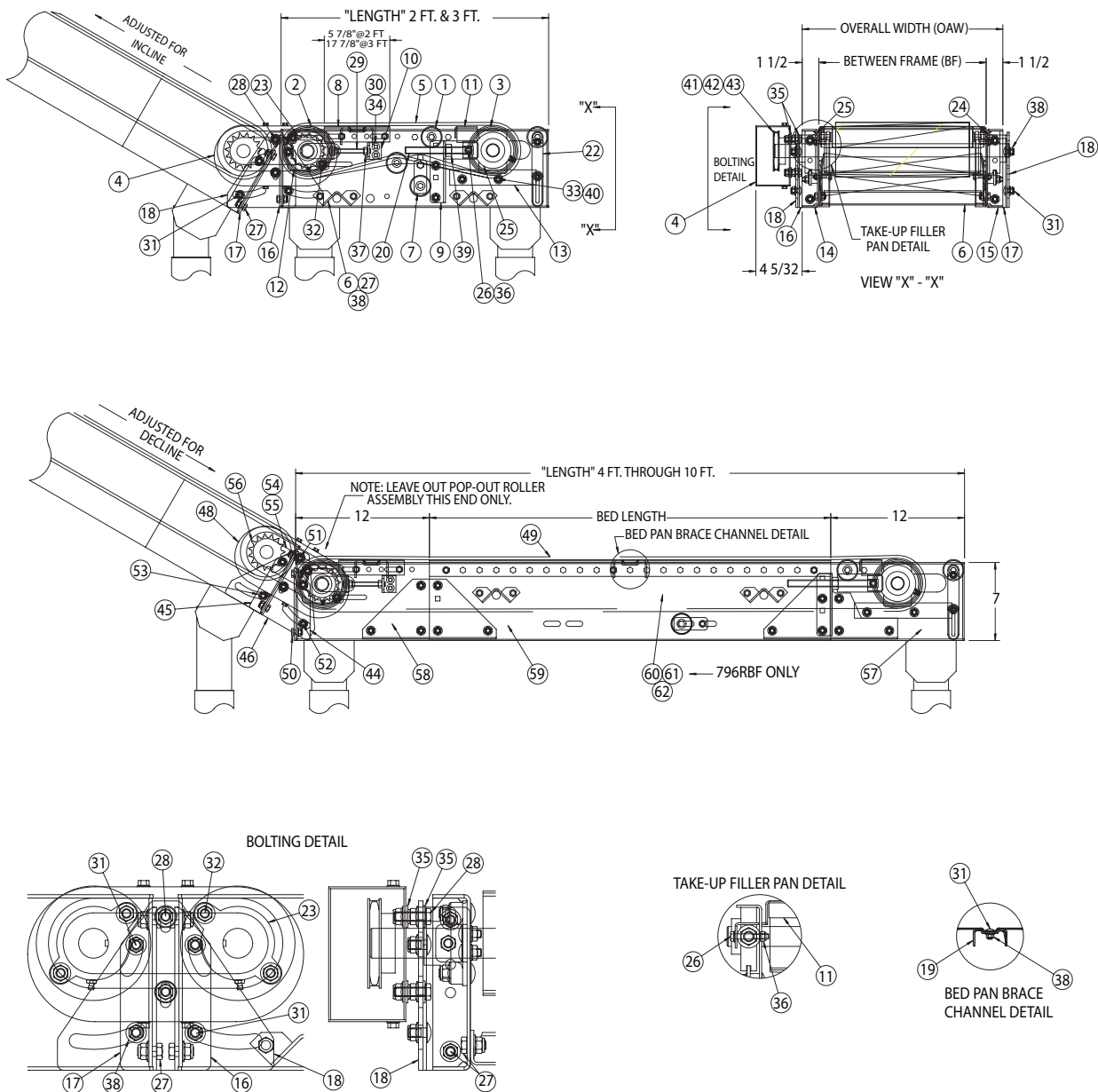
SERIAL NO. 123456

MODEL BFGD CHAIN DRIVEN FEEDER

PARTS LIST FOR FEEDER (WHEN USED WITH CENTER DRIVE)

Item #	Description	Item #	Description
	2' & 3' Feeder Assembly	32	3/8" x 1-1/4" carriage bolt
1	196S roller assembly	33	3/8" x 1-1/2" carriage bolt
2	4' O.D. drive pulley assembly	34	5/16" - 18 flange nut
3	4' O.D. Idler pulley assembly	35	5/16" flat washer
4	Chain guard assembly	36	5/16" - 18 nylon insert locknut
5	Belt kits w/assembly instructions	37	3/8" hex nut
6	Frame crossbrace	38	3/8" nylon insert flange nut
7	1.9 roller keeper	39	5/8" - 11 hex nut
8	Filler pan	40	Bearing guide spacer
9	Bolt-in butt coupling	41	#50 chain
10	Bearing take-up mounting angle	42	#50 connector link
11	4" end take-up filler pan	43	Sprocket 1-3/16" bore
12	Bearing push plate		4' through 10' Feeder Assembly
13	Take-up bearing guide	44	Pivot mounting angle left hand
14	Feeder side channel left hand	45	Pivot mounting angle right hand
15	Feeder side channel right hand	46	Pivot mounting plate
16	Pivot mounting angle left hand	47	1/4" SQ x 7/8" long keystock
17	Pivot mounting angle right hand	48	Chain guard assembly
18	Pivot mounting plate	49	Belt kits w/assembly instructions
19	Bed pan brace channel	50	3/8" x 3/4" long HHCS
20	5/8" dia. take-up rod x 6" long	51	3/8" x 1-1/4" long HHCS
21	1/4" SQ x 7/8" long keystock	52	3/8" x 3/4" long carriage bolt
22	Safety pop-out roller assembly	53	3/8" nylon insert flange nut
23	2 hole flange bearing 1-3/16" bore	54	#50 chain
24	1.19" bore milled take-up bearing right hand	55	#50 connector link
25	1.19" bore milled take-up bearing left hand	56	Sprocket 1-3/16" bore
26	5/16" - 18 x 2" hex flange HHCS	57	4" end take-up assembly
27	3/8" x 3/4" long HHCS	58	4" end drive assembly
28	3/8" x 1-1/4" long HHCS	59	700SB intermediate bed section
29	3/8" x 3-1/2" long HHTB	60	Squaring rod (short) (796RB)
30	5/16" x 3/4" carriage bolt	61	Squaring rod (long) (796RB)
31	3/8" x 3/4" long carriage bolt	62	Turnbuckle (796RB only)

MODEL BFGD CHAIN DRIVEN FEEDER DRAWINGS



Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 20).

Recommended Spare Parts are shown in red. Charted are item numbers and part descriptions.

When ordering use example below.

Example: Need a replacement 196S Roller assembly for BFGD Chain driven feeder

Part No: SN 123456 - 1 - 196S Roller Assembly



ROACH CONVEYORS
 808 HIGHWAY 463
 TRUMANN, AR 72472
 TEL. 870-483-7631

SERIAL NO. 123456

CAUTION: Use connector bracket with safety pop out roller to permanently attach gravity conveyor sections to feeder.



ROACH CONVEYORS

WARRANTY

- Materials used by Roach Conveyors are of good quality.
- Any part proving to be defective in materials or workmanship upon Roach inspection, will be replaced at NO cost, FOB, Trumann, Arkansas, for one year. Installation expense will be paid by others.
- Roach liability includes furnishing said part or parts; Roach is not liable for consequential damages, such as loss of profit, delays or expenses incurred by failure of said part or parts.
- Failure due to abuse, incorrect adjustments, exposure to corrosive or abrasive environment or operation under damp conditions does not constitute failure due to defects in workmanship or materials.
- Component parts not manufactured by Roach (motors, gear reducers, etc.) will be repaired or replaced at the option of their manufacturer. Contact nearest authorized service center for all warranty claims.

NOTE: Motors or gear reducers tampered with before inspection shall be considered free of ALL Warranty Claims.

--All specifications are subject to change without notice--
--Drawings are intended for illustration ONLY and are not to scale--

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