

## **Safety, Operation, Maintenance & Parts Manual**

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**039520**

**rev. A1.00**

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**Safety is our #1 concern!** Read and understand all safety information and instructions before operating, setting up or maintaining this machine.

*Form #1292*

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## SECTION 1 SAFETY

### 1.1 Safety Symbols

The following symbols and signal words call your attention to instructions concerning your personal safety. Be sure to observe and follow these instructions.



**DANGER!** indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.



**WARNING!** suggests a potentially hazardous situation which, if not avoided, could result in death or serious injury.



**CAUTION!** refers to potentially hazardous situations which, if not avoided, may result in minor or moderate injury or damage to equipment.



**IMPORTANT!** indicates vital information.

**NOTE:** gives helpful information.



Warning stripes are placed on areas where a single decal would be insufficient. To avoid serious injury, keep out of the path of any equipment marked with warning stripes.

## 1.2 Safety Instructions

**NOTE:** ONLY safety instructions regarding personal injury are listed in this section. Caution statements regarding only equipment damage appear where applicable throughout the manual.



**WARNING!** Clean sawdust from all guards, vents, control boxes, or any area where sawdust may gather after every shift. Failure to do so may result in fire, causing death or serious injury.



### OBSERVE SAFETY INSTRUCTIONS



**IMPORTANT!** Read the entire Operator's Manual before operating the conveyor. Take notice of all safety warnings throughout this manual and those posted on the machine. Keep this manual with this machine at all times, regardless of ownership.

Also read any additional manufacturer's manuals and observe any applicable safety instructions including dangers, warnings, and cautions.

Only persons who have read and understood the entire operator's manual should operate the conveyor. The conveyor is not intended for use by or around children.

**IMPORTANT!** It is always the owner's responsibility to comply with all applicable federal, state and local laws, rules and regulations regarding the ownership, operation of your AWMV products. All AWMV product owners are encouraged to become thoroughly familiar with these applicable laws and comply with them fully while using the machine.



### KEEP CONVEYOR AND AREA AROUND CONVEYOR CLEAN




**DANGER!** Maintain a clean and clear path for all necessary movement around the machine and lumber stacking areas. Failure to do so will result in serious injury.

### CAUTIONS FOR CONVEYOR SETUP


**WARNING!** Securely fasten the feet of an modular conveyor to the floor before operating the machine. Failure to do so may result in serious injury or death.

### CHECK CONVEYOR BEFORE OPERATION

 **DANGER!** Make sure all guards and covers are in place and secured before operating the conveyor. Failure to do so may result in serious injury.



### KEEP PERSONS AWAY

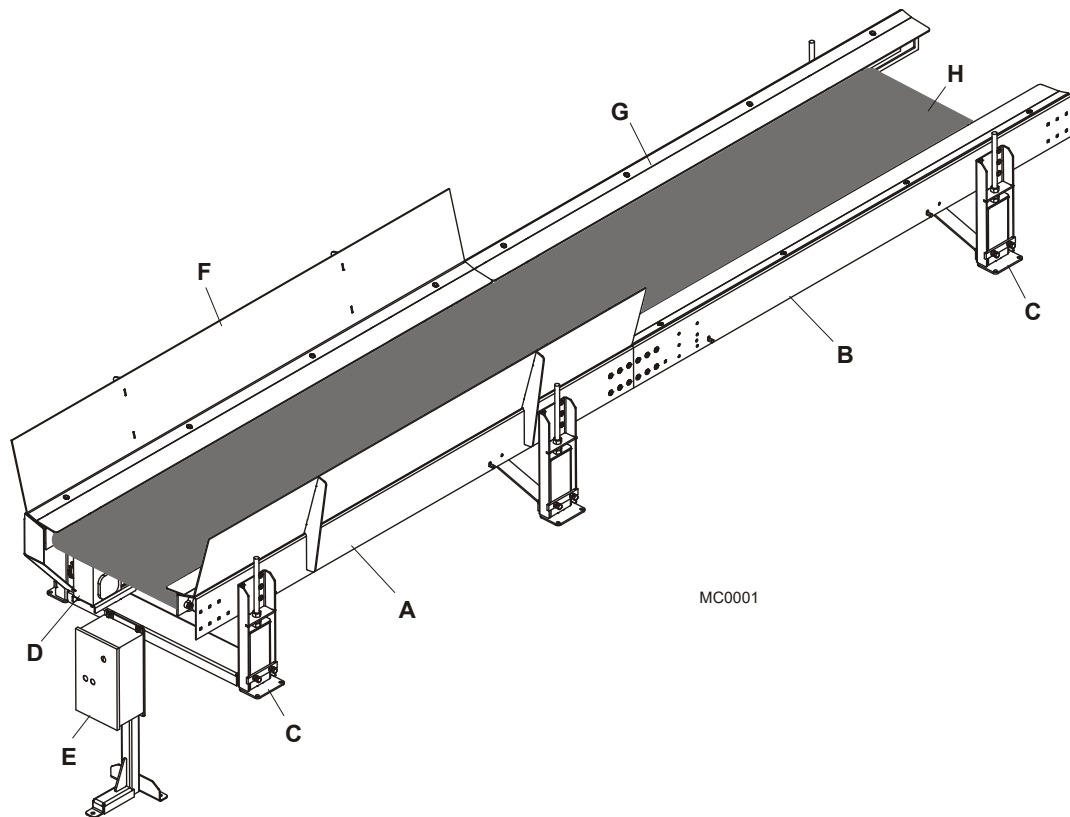
 **WARNING!** Keep all persons out of the path of moving equipment and boards while operating conveyor. Failure to do so may result in serious injury or death.

## SECTION 2 SETUP & OPERATION

### 2.1 Overview

The Modular Conveyor allows you to quickly transport material and can be customized to fit most applications. The following manual will guide you in installation, operation, and maintenance of the Modular Conveyor.

See **Figure 2-1**. The major components of the Modular Conveyor are identified below.



**FIG. 2-1**

See **Table 2-1**. Modular Conveyor component identification.

ID	Description	Part No.	Comments
<b>A</b>	Conveyor Assembly, Modular Base	039520	1 Required
<b>B</b>	Conveyor Assembly, Modular 8' Extension	039519	Add qty per length desired.

**TABLE 2-1**

# 2

## Setup & Operation

### Overview

C	Leg Assembly, 18"-24" Height	038806	Add four of desired height legs for base unit, two legs for each additional 8' extension.
	Leg Assembly, 23"-29" Height	038807	
	Leg Assembly, 29"-35" Height	038808	
	Leg Assembly, 35"-41" Height	038809	
	Leg Assembly, 41"-47" Height	038810	
	Leg Assembly, 47"-53" Height	038811	
D	Drive Assembly, 80 fpm	038829	One drive assembly required for desired belt speed.
	Drive Assembly, 107 fpm	038830	
	Drive Assembly, 120 fpm	038831	
	Drive Assembly, 180 fpm	038832	
	Drive Assembly, 241 fpm	038833	
E	Control Assembly, 2HP 480V 3PH	025293	Optional control assembly for desired electrical supply.
	Control Assembly, 2HP 240V 3PH	050934	
	Control Assembly, 2HP 240V 1PH	050999	
F	Side Rail Assembly, Conveyor Tall	038868	Optional
G	Side Rail Assembly, Conveyor Short	038869	Optional
H	Belt, 8' x 24" Conveyor	038935-8	One belt required per length of module (longer lengths available upon request).
	Belt, 16' x 24" Conveyor	038935-16	
	Belt, 24' x 24" Conveyor	038935-24	
	Belt, 32' x 24" Conveyor	038935-32	
	Belt, 40' x 24" Conveyor	038935-40	

**TABLE 2-1**

Prepare a firm, level area where the conveyor can be anchored. A cement pad with 1/2" diameter anchor bolts is recommended.



**WARNING!** Securely fasten the feet of the conveyor to the floor before operating the machine. Failure to do so may result in serious injury or death.



See Figure 2-2. The overall dimensions of the Modular Conveyor are shown below.

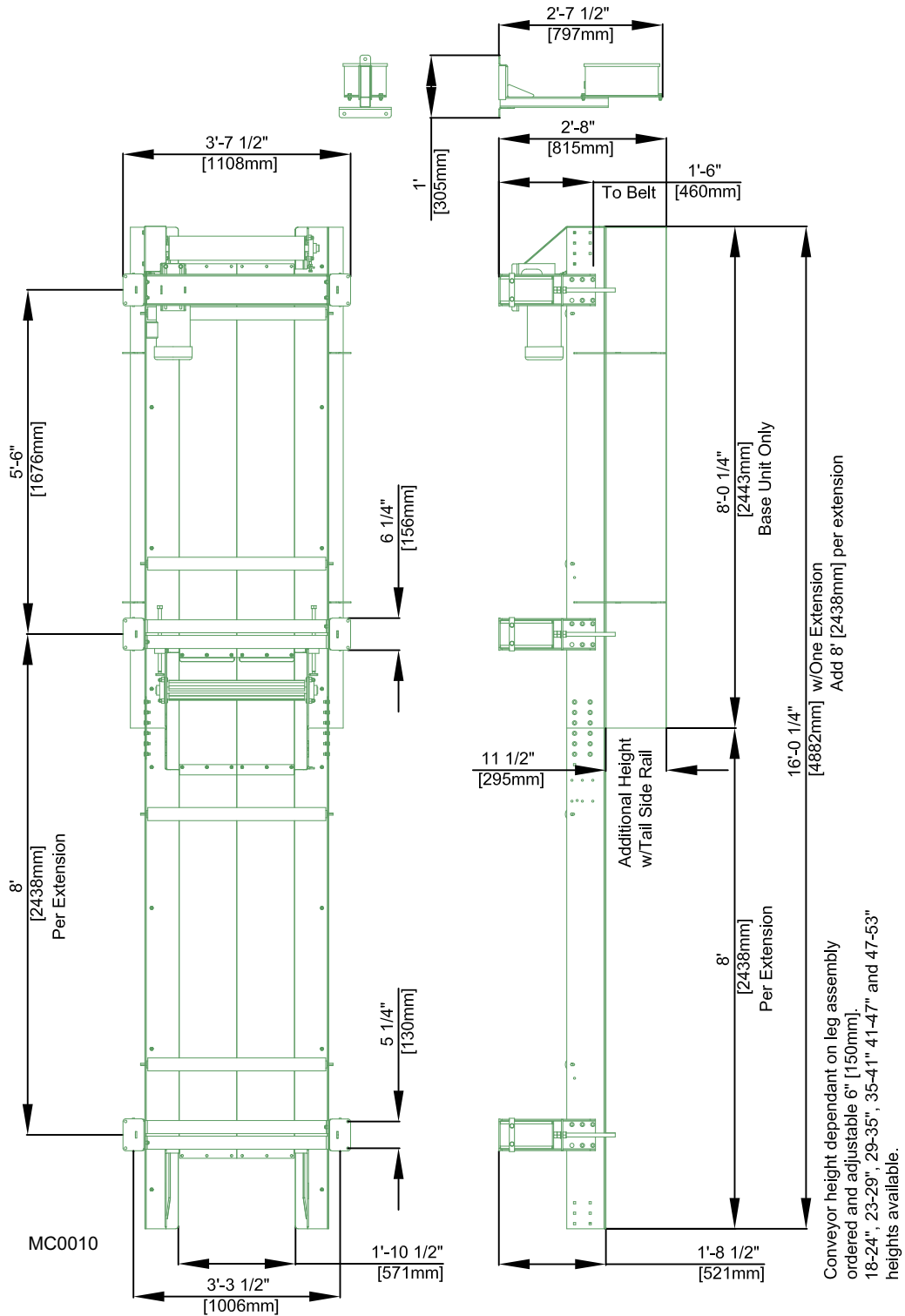


FIG. 2-2

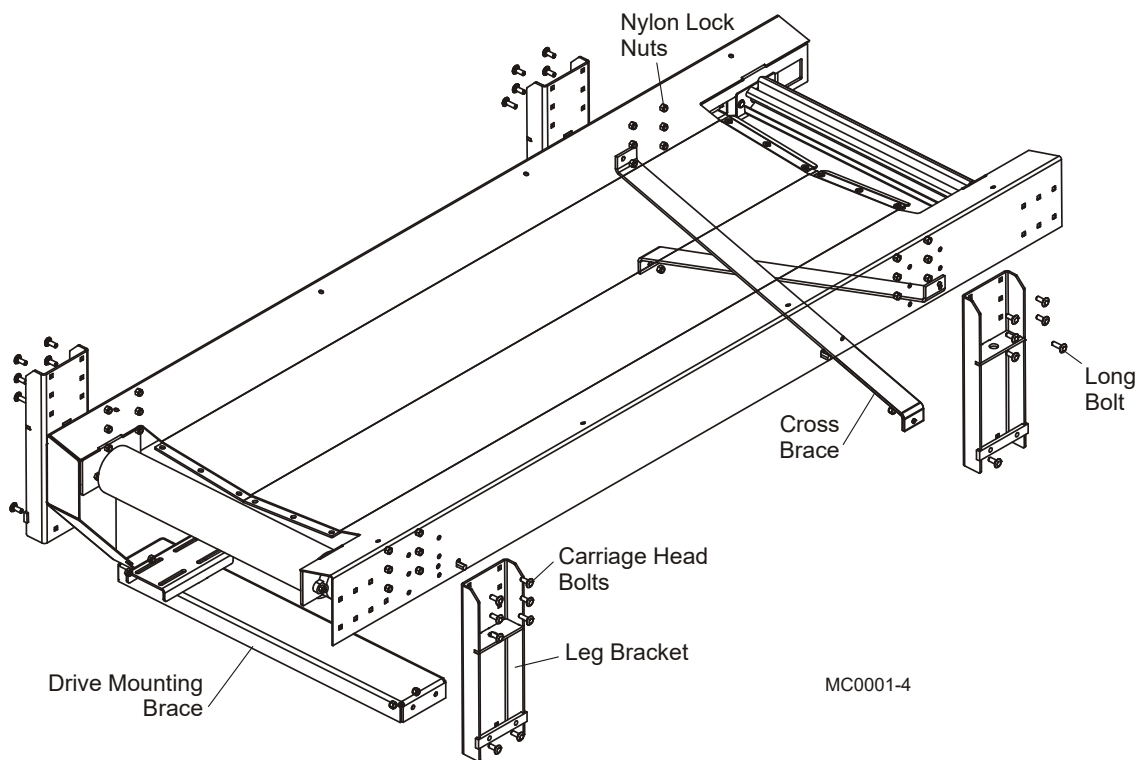
## 2.2 Conveyor Assembly

Assemble the legs, drive mounting brace and cross braces to the conveyor. Disassemble all hardware and the foot weldment from each leg assembly. Use the provided carriage head bolts and nylon lock nuts to mount each leg bracket to the conveyor frame.

When installing the rear leg brackets, place the cross braces and leg brackets in position and secure with the carriage head bolts and lock nuts provided. Be sure to use the longer bolts in the leg bracket holes where the cross braces are mounted.

Place the drive mounting brace in position between the two front leg brackets and secure with the carriage head bolts and lock nuts.

See Figure 2-3.

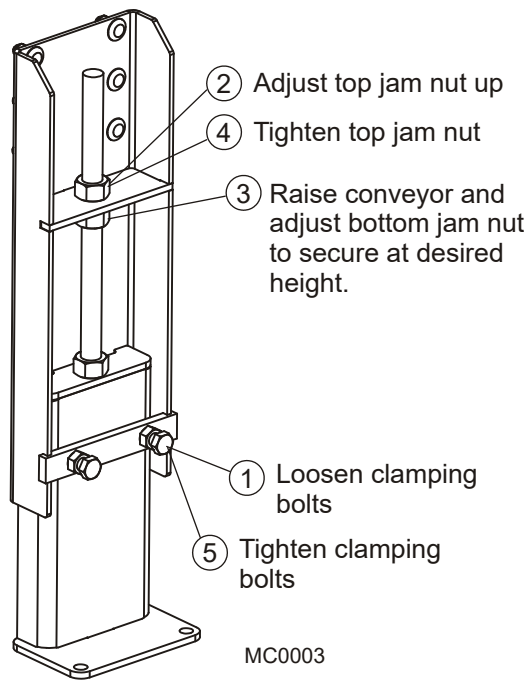


**FIG. 2-3**

Install two leg brackets and cross braces at the rear position of each conveyor extension, if applicable.

Reinstall the leg feet to each bracket and adjust so the conveyor is at the desired height.

**See Figure 2-4.** Loosen the locking bolt jam nuts on each leg. Adjust the top jam nut up past the height you will want the conveyor. Lift the conveyor to the desired height and adjust the bottom jam nut to secure the conveyor height. Tighten the top jam nut and locking bolts and jam nuts.

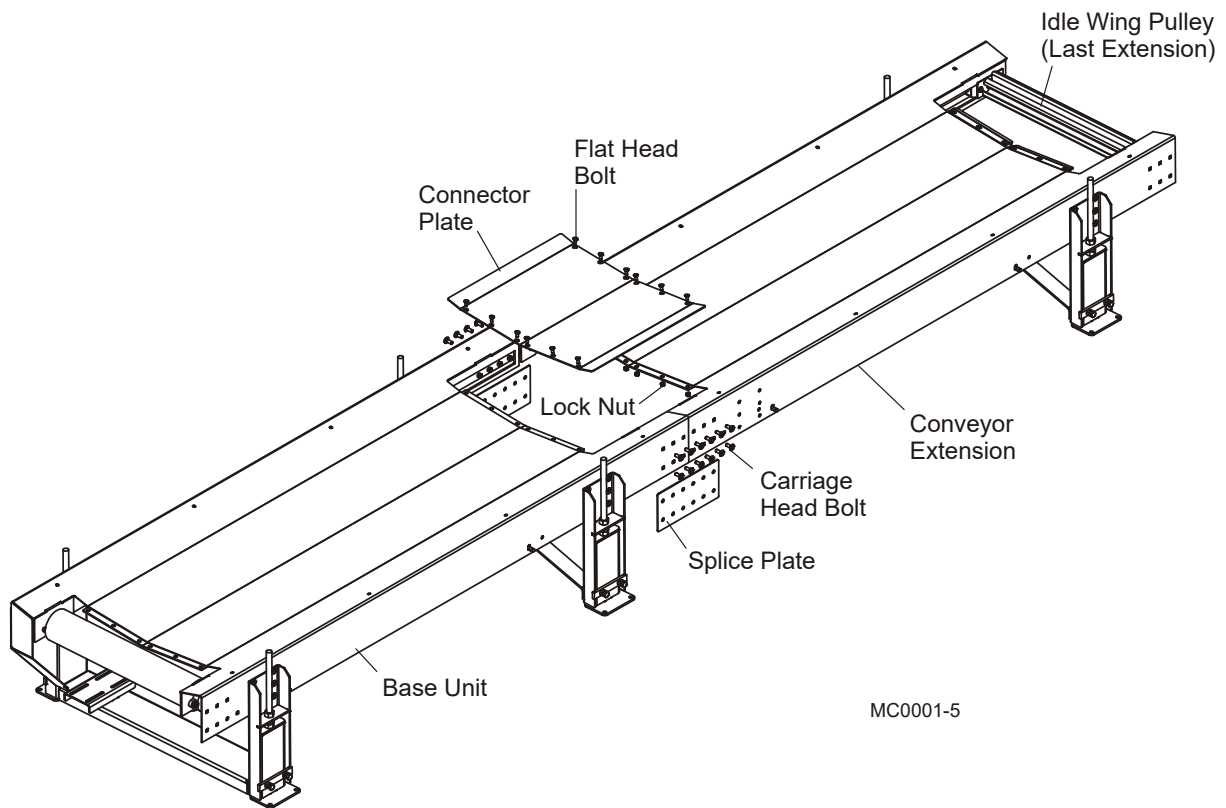


**FIG. 2-4**

### 2.3 Conveyor Extension Assembly

If applicable, assemble the conveyor extension(s) to the base unit. If more than one extension is to be used, be sure to place the extension with the conveyor belt idle wing pulley at the end. Connect the conveyors using the splice plates and secure with the carriage head bolts and nylon lock nuts provided. Install the connector plate with the flat head bolts and nylon lock nuts.

See Figure 2-5.



**FIG. 2-5**

## 2.4 Drive Assembly Installation

Place the drive assembly in position over the slotted holes of the drive mounting brace and loosely secure with the four flat washers, lock washers and bolts provided. Remove the chain guard from the conveyor and place the drive chain around the gearbox sprocket and drive roller sprocket on the conveyor.

Move the gearbox and motor to adjust the drive chain until the center of the chain can be deflected 1/2" (12.7mm). Tighten the gearbox mounting bolts.

See Figure 2-6.

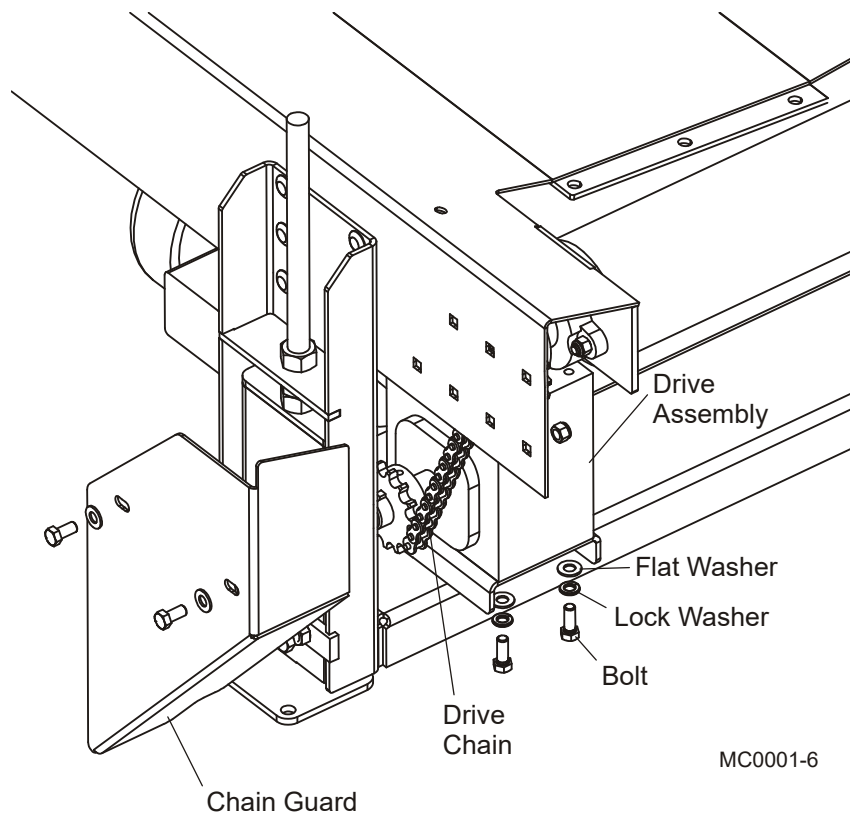


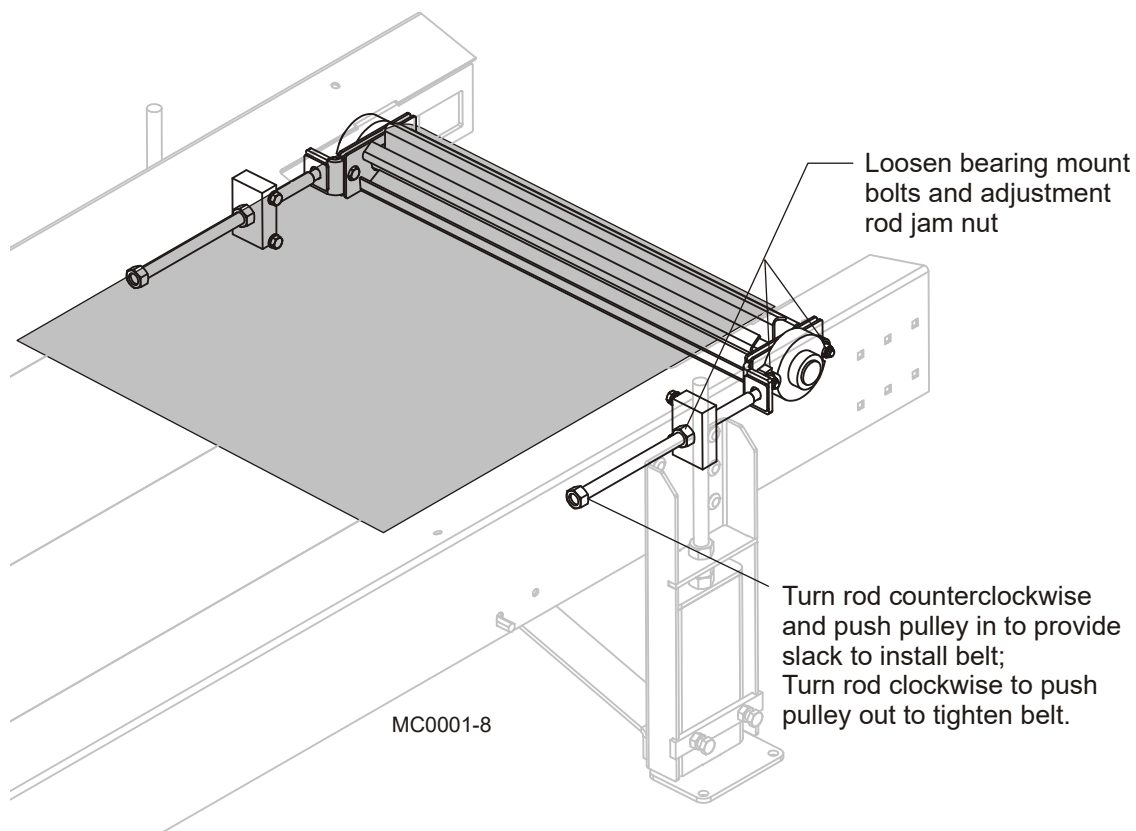
FIG. 2-6

## 2.5 Conveyor Belt Installation

Route the belt around the drive roller at the front of the base conveyor unit and around the idle wing pulley at the rear of the conveyor (or last extension). Loosen the idle wing pulley bearing mount bolts and the adjustment rod jam nuts. Turn the adjustment rods counterclockwise and push the idle wing pulley in to provide enough slack to install the belt. Fasten the belt ends together.

After the belt is installed, turn the adjustment rods clockwise to push the idle wing pulley out and tighten the belt. Be sure to adjust both rods evenly so the belt will track straight. Tighten the idle wing pulley bearing mount bolts and the adjustment rod jam nuts.

See Figure 2-7.



**FIG. 2-7**

## 2.6 Side Rail Installation

The optional side rails can be installed to the conveyor tables to help guard the conveyor belt and keep material moving efficiently. The tall side rail will catch material that may become airborne. The short and tall side rails can be configured as your application requires. Use the supplied carriage head bolts and nylon lock nuts to install the side guards to the conveyor(s).

See Figure 2-8.

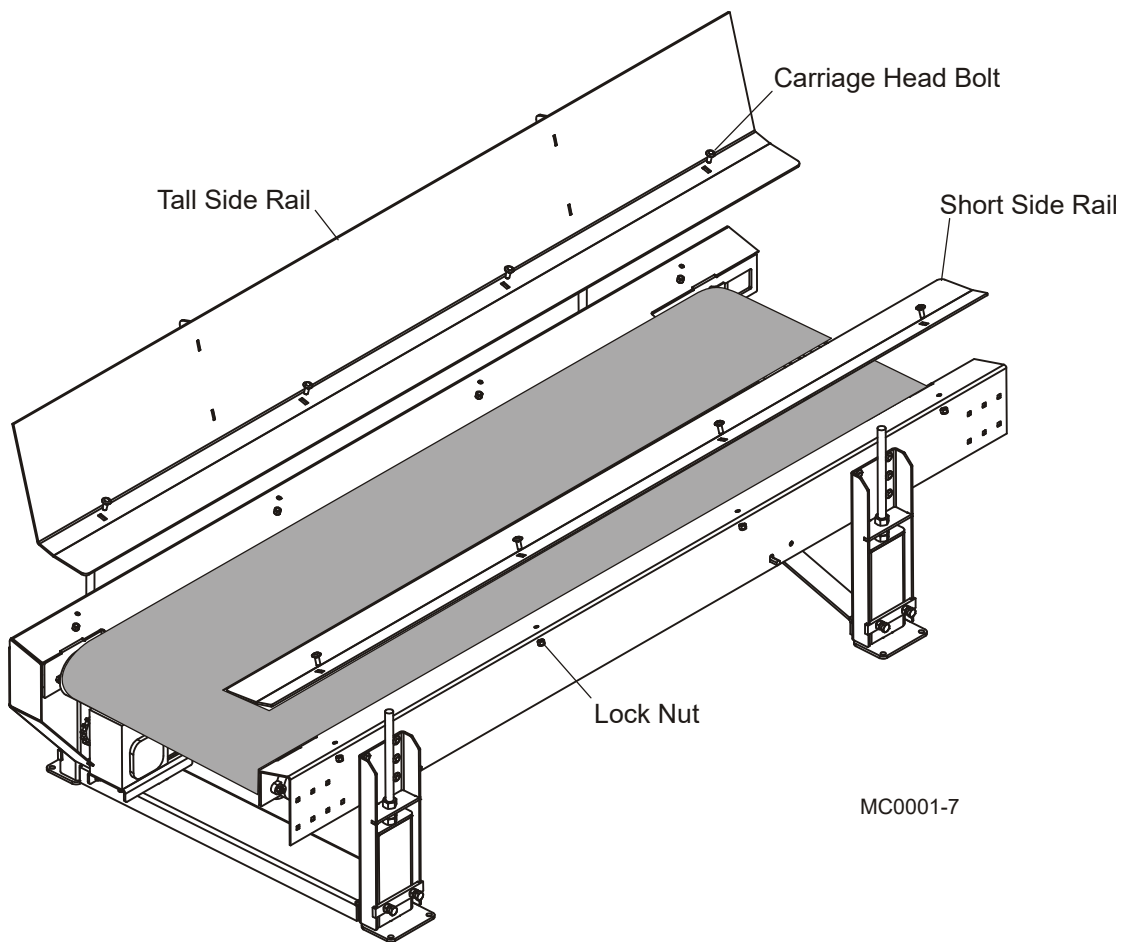


FIG. 2-8

## 2.7 Electrical Installation



**DANGER!** Make sure all electrical installation, service and/or maintenance work is performed by a qualified electrician and is in accordance with applicable electrical codes.

**DANGER!** HAZARDOUS VOLTAGE can cause shock, burns, or death. SHUT OFF & LOCK OUT POWER before performing service in any area of this machine. DO NOT restore power until all access panels are replaced and secured.

**See Table 2-2.** The customer must supply the appropriate incoming electrical service and time-delay fused disconnect ahead of the machine. The power may be connected directly to the conveyor drive assembly or the optional conveyor control box.

Control Assy. (Optional)	Electrical Service				Wire Size
	Voltage	Hz	Amperage	Phase	
025293	460	60	10	3	14 AWG
050934	230	60	20	3	14 AWG
050999	230	60	20	1	14 AWG

**TABLE 2-2**

The optional control box can be placed at any location near the machine that will suit the customer's application and is prewired to accept a remote control if the customer elects to use one (requires 16 AWG wiring).

[See SECTION 4 Electrical Information](#) for electrical diagrams and electrical component list.



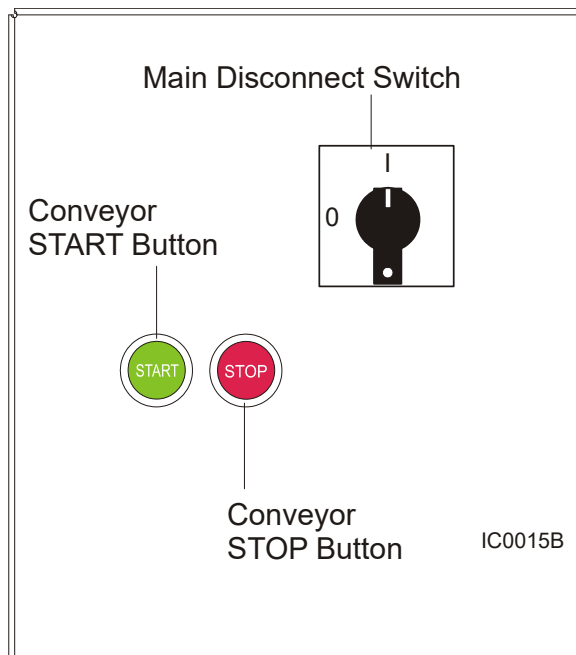
## 2.8 Operation



**WARNING!** Keep all persons out of the path of moving equipment and boards while operating conveyor. Failure to do so may result in serious injury or death.

After electrical power is installed you can start operating the conveyor.

**See Figure 2-9.** The following switch and buttons are located on the front door of the optional conveyor control box.



**FIG. 2-9**

### Conveyor Start

1. Turn the Main Disconnect Switch to the "I" ("ON") position.
2. Push the green conveyor START button.

### Conveyor Motor Shutoff

1. Push the red conveyor STOP button.

Turn the Main Disconnect Switch to the "0" ("OFF") position to turn off electrical power to the conveyor control box if necessary.

## SECTION 3 MAINTENANCE



**DANGER!** Always be aware of and take proper protective measures against rotating shafts, pulleys, fans, etc. Always stay a safe distance from rotating members and make sure that loose clothing or long hair does not engage rotating members resulting in possible injury.

**WARNING!** Always wear proper and necessary safety equipment when performing service functions. Proper safety equipment includes eye protection, breathing protection, hand protection and foot protection.



**This symbol** identifies the interval (hours of operation) at which each maintenance procedure should be performed. "AR" signifies maintenance procedures which should be performed as required.

### 3.1 Gearbox Oil



Check the gearbox oil level. Add a synthetic gear oil such as Mobil Glygoyle 460 as needed.

The Mobil Glygoyle 460 gear oil is a synthesized hydrocarbon formulated used for extremely long life. Change oil only when performing maintenance that requires gearbox disassembly.

If oil must be replaced, use only Mobil Glygoyle 460.

AWMV offers replacement gear oil in 8 ounce bottles.

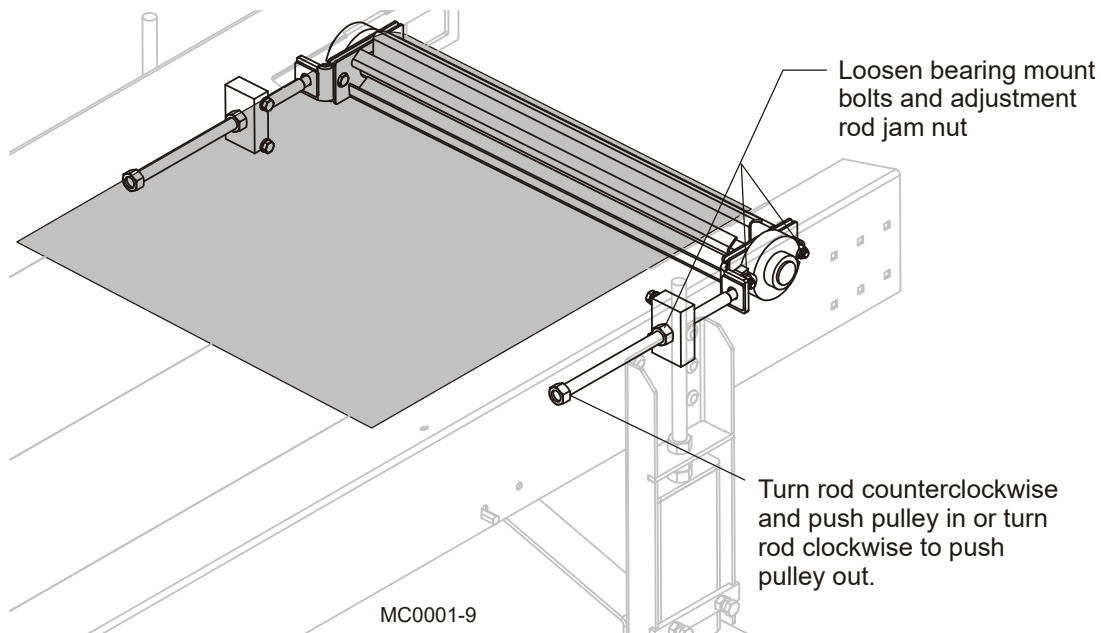
### 3.2 Belt Alignment

0 The Modular Conveyor is factory-aligned. Periodically check and realign the conveyor belt if necessary. Make sure the belt remains centered on the drive roller and idle wing pulley while running. If the conveyor belt keeps travelling to the side of the drive roller and/or idle wing pulley follow the realignment procedure below.

To realign the conveyor belt:

2. Loosen the idle wing pulley bearing mount bolts and the adjustment rod jam nut on one or both ends of the pulley.

See Figure 3-1.



**FIG. 3-1**

3. Turn the adjustment rod counter clockwise and push the idle wing pulley in or turn rod-clockwise to move the idle wing pulley out. Adjust until the conveyor belt stays in place on the drive roller and idle wing pulley while running.
4. Tighten the idle wing pulley bearing mount bolts and the adjustment rod jam nuts when the belt alignment procedure is complete.

0 Periodically check the conveyor belt for wear. Replace a damaged or worn belt as needed. Always check the conveyor belt alignment after installing a new belt. Align the conveyor belt after replacing if necessary.

### 3.3 Drive Chain Adjustment



Periodically check the modular conveyor drive chain tension. Adjust the drive chain tension as needed. The drive chain should be adjusted if the chain slack exceeds 1" (25.4mm).



**DANGER!** Always turn off and disconnect power supply before performing any service to the machine. Failure to do so may result in serious injury or death.

1. Make sure the motor is not running.
2. Remove the chain guard and check the chain tension.
3. If the chain requires adjustment, loosen the four bolts securing the conveyor gearbox to the mounting brace. Move the gearbox and motor to adjust the drive chain until the center of the chain can be deflected 1/2" (12.7mm).

See Figure 3-2.

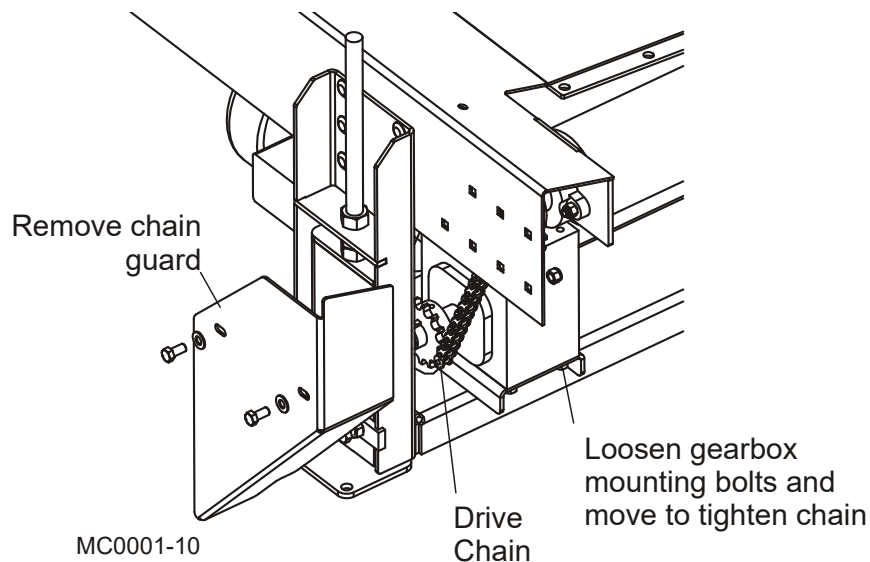


FIG. 3-2

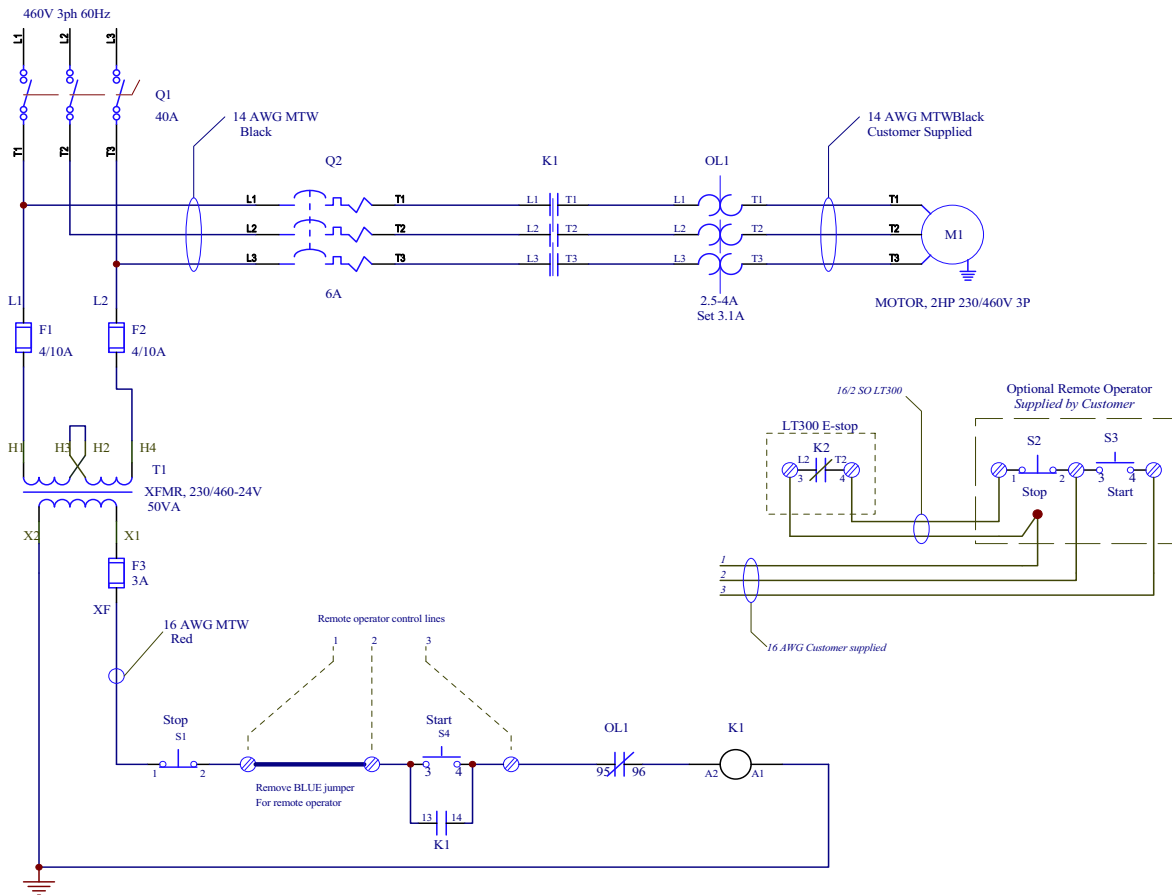


**CAUTION!** Do not over-tension the conveyor drive chain. Damage to the gearbox will occur.

4. After the drive chain has been adjusted, tighten the gearbox mounting bolts and reinstall the drive guard and hardware.

## SECTION 4 ELECTRICAL INFORMATION

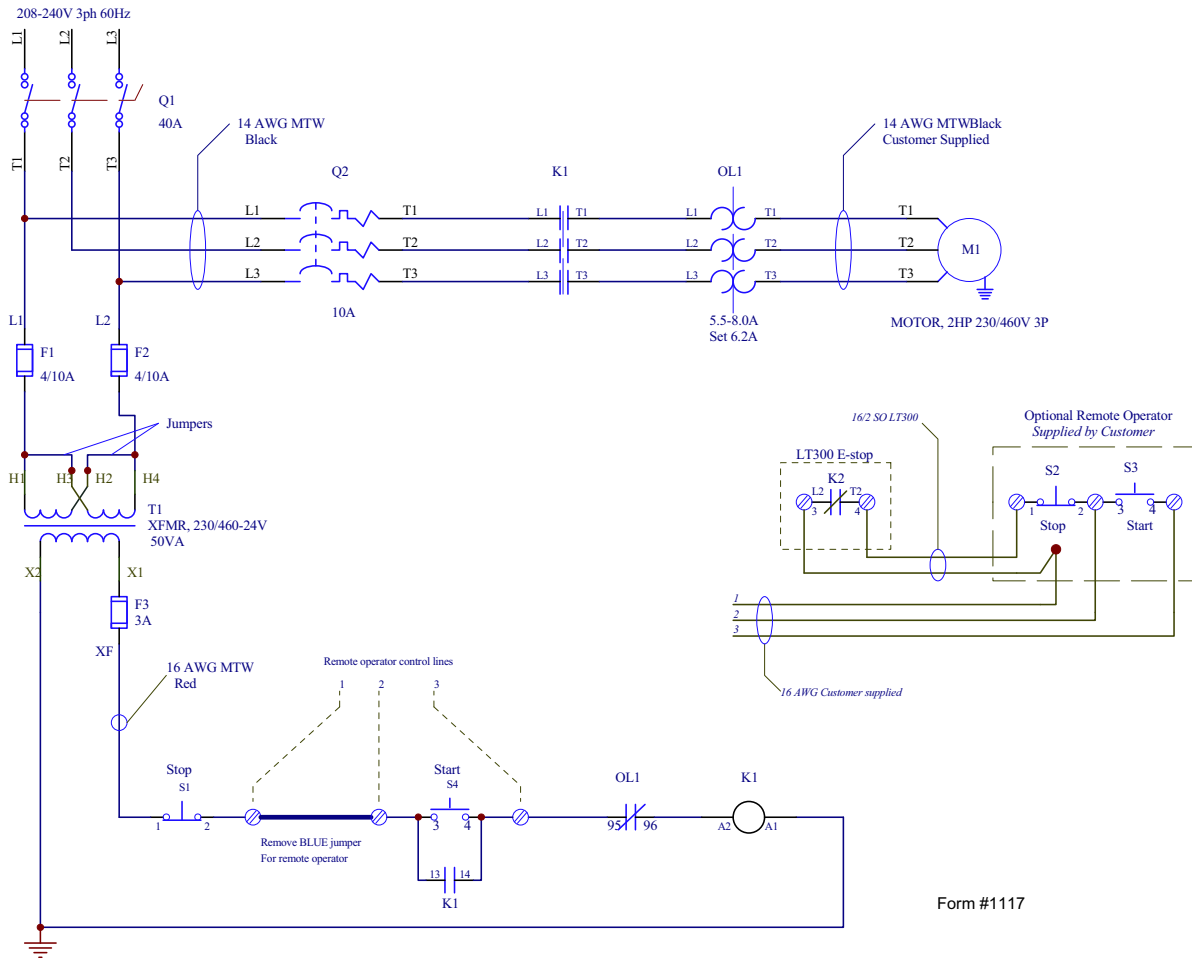
### 4.1 Electrical Symbol Diagram (460V 3Ph)



Form #1029

**FIG. 4-1**

**4.2 Electrical Symbol Diagram (230V 3Ph)**



**FIG. 4-2**

4.3 Electrical Symbol Diagram (230V 1Ph)

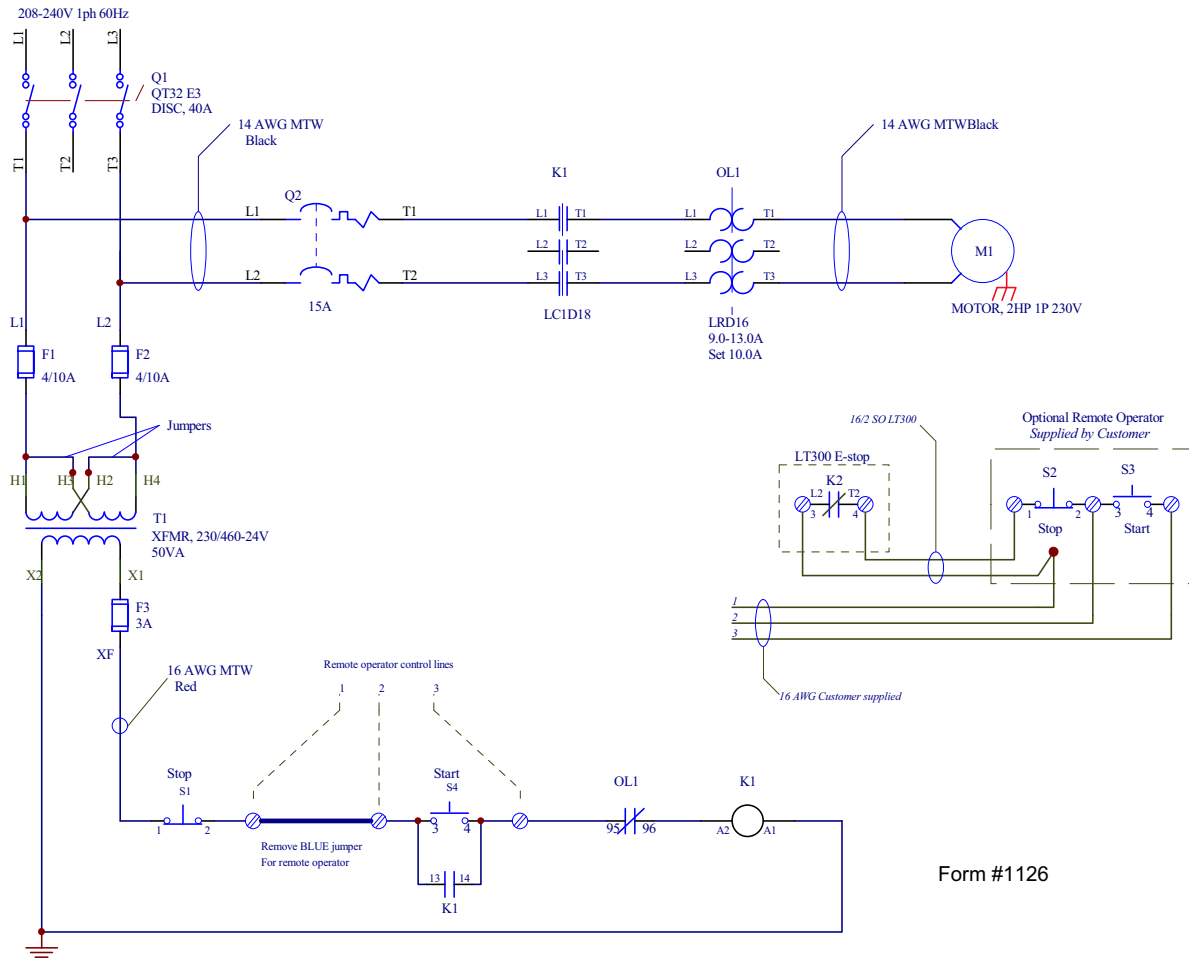


FIG. 4-3

**4.4 Electrical Component List**

Component	AWMV Part No.	Description
<b>F1, F2</b>	P03151	Fuse, FNQR - 4/10, 600V
<b>F3</b>	025297	Fuse, 3 Amp 250V 1/4 x 1-1/4 Delay
<b>OL1</b>	E23393	Relay, 2.5 - 4 Amp Overload (460V)
	E23297	Relay, 5.5 - 8.0 Amp Overload (230V 3Ph)
	051252	Relay, 9.0 - 13.0 Amp Overload (230V 1Ph)
<b>K1</b>	025290	Contact, 24VAC Coil 3 Pole 9Amp (230/460V 3Ph)
	052689	Contact, 24VAC Coil 3 Pole 18Amp (230V 1Ph)
<b>M1</b>	042390	Motor, 2HP 230/460V 1725 RPM (80 & 107FPM)
	038564	Motor/Gearbox Assy, (120, 180, & 241FPM)
<b>Q1</b>	050903	Switch, 40 Amp 3P Non-Fused Disconnect
<b>Q2</b>	024691	Breaker, 6 Amp 480V 3P Curve D (460V)
	051265	Breaker, 10 Amp 480V 3P Curve D (230V 3Ph)
	051266	Breaker, 15 Amp 480V 2P Curve D (230V 1 Ph)
<b>S1, S2</b>	025306	Switch, Red STOP
	025161	Switch Body, 1NC 22mm XB4
<b>S3, S4</b>	025305	Switch, Green START
	025242	Switch Body, 1NO 22mm XB4
<b>T1</b>	025291	Transformer, 240/480 24VAC 50VA w/fuses



### 4.5 Component Layout Diagram (230/460V 3Ph)

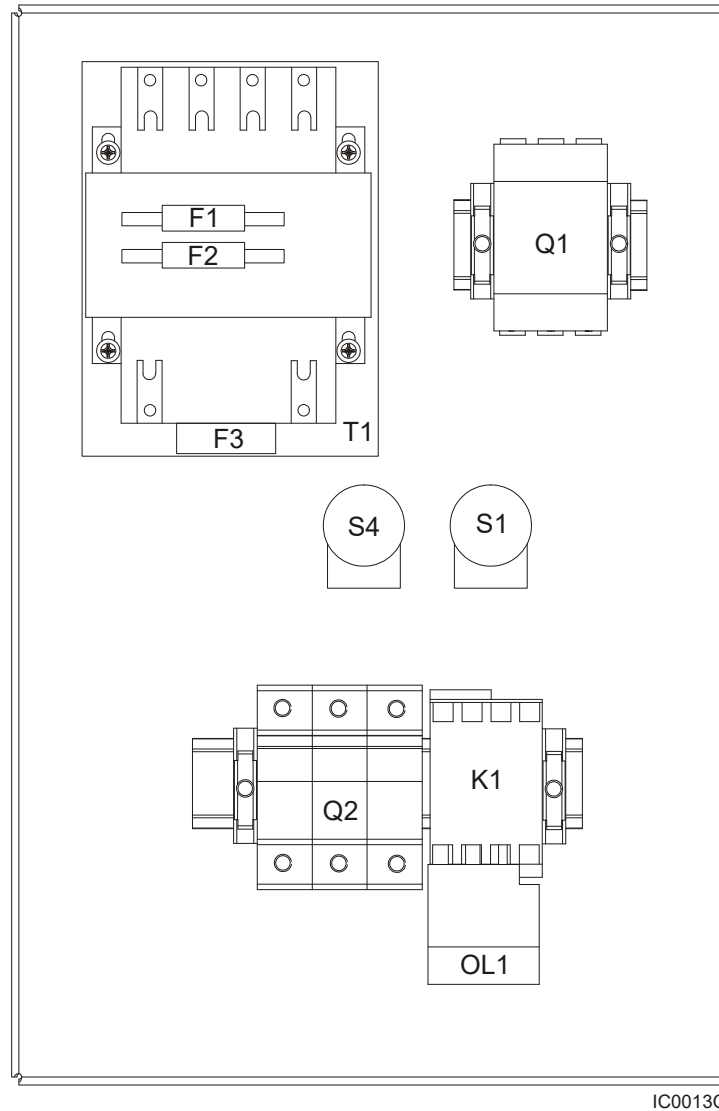
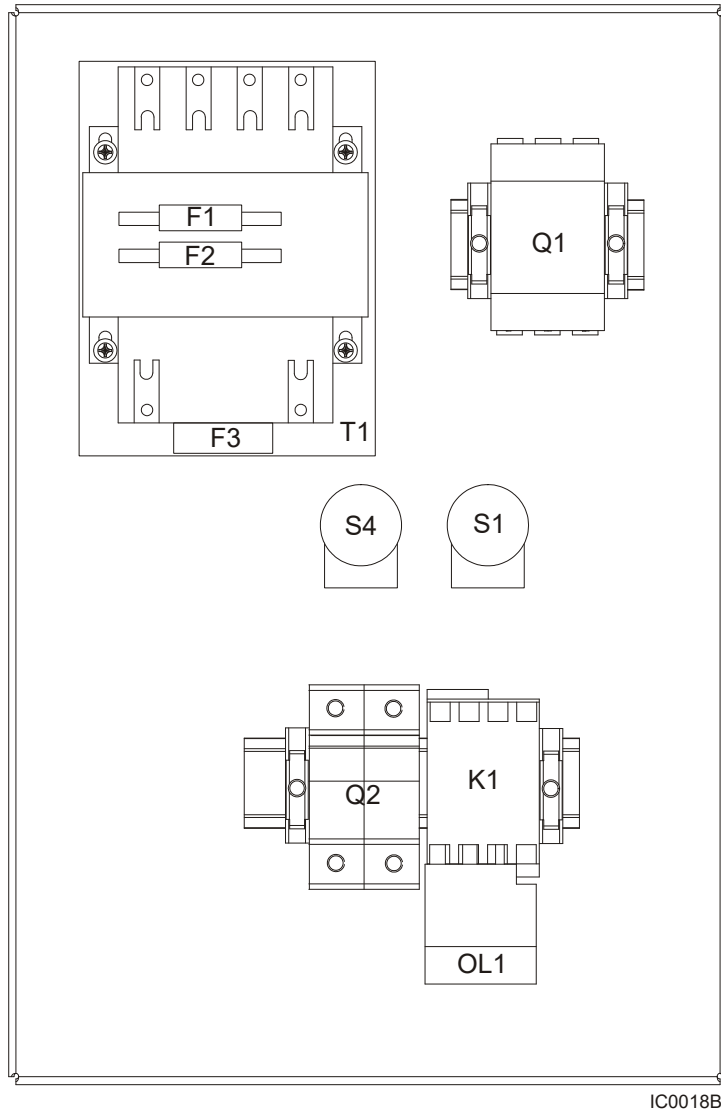


FIG. 4-4

**4** **Electrical Information**  
*Component Layout Diagram (230V 1Ph)*

**4.6 Component Layout Diagram (230V 1Ph)**

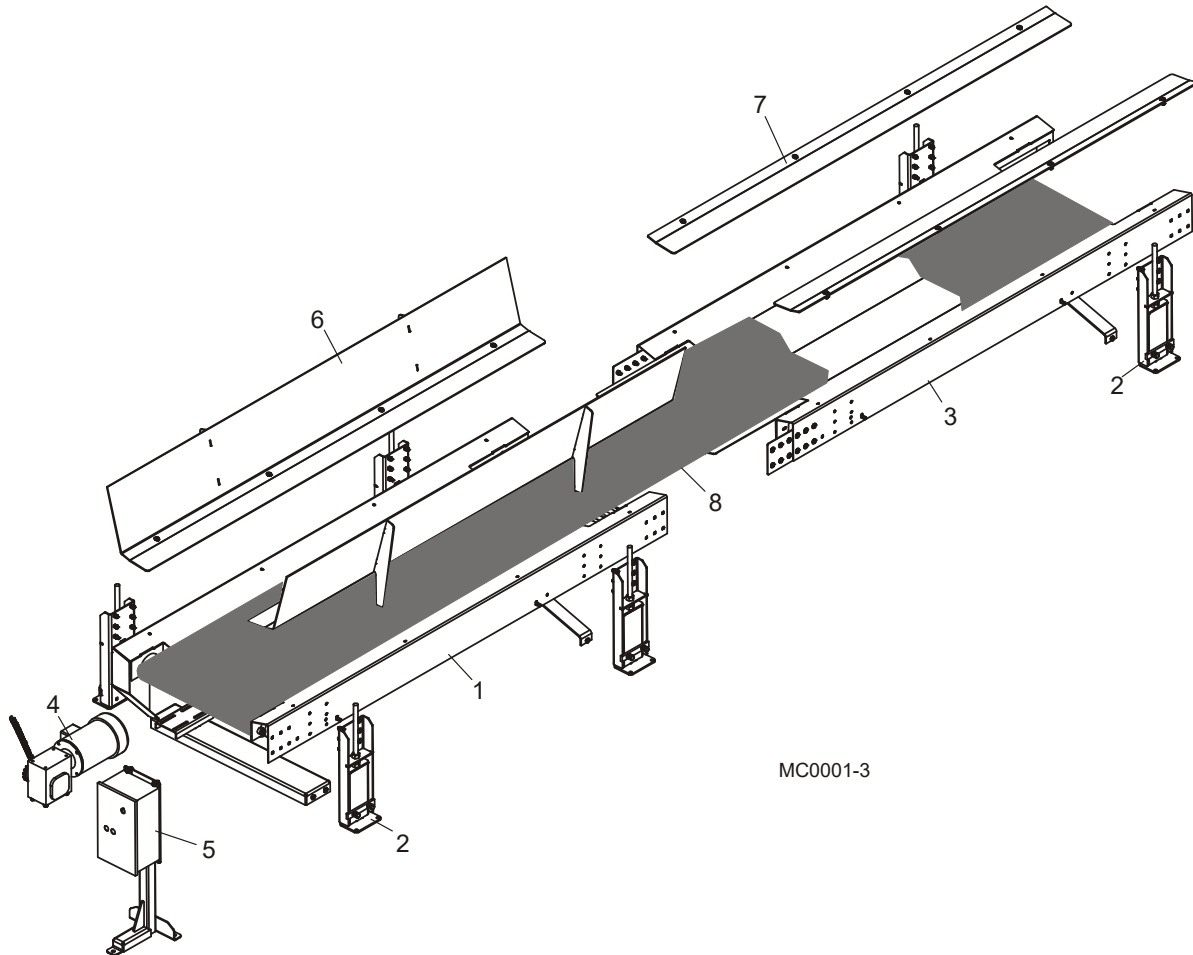


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**FIG. 4-5**

## SECTION 5 REPLACEMENT PARTS

### 5.1 Modular Conveyor Complete

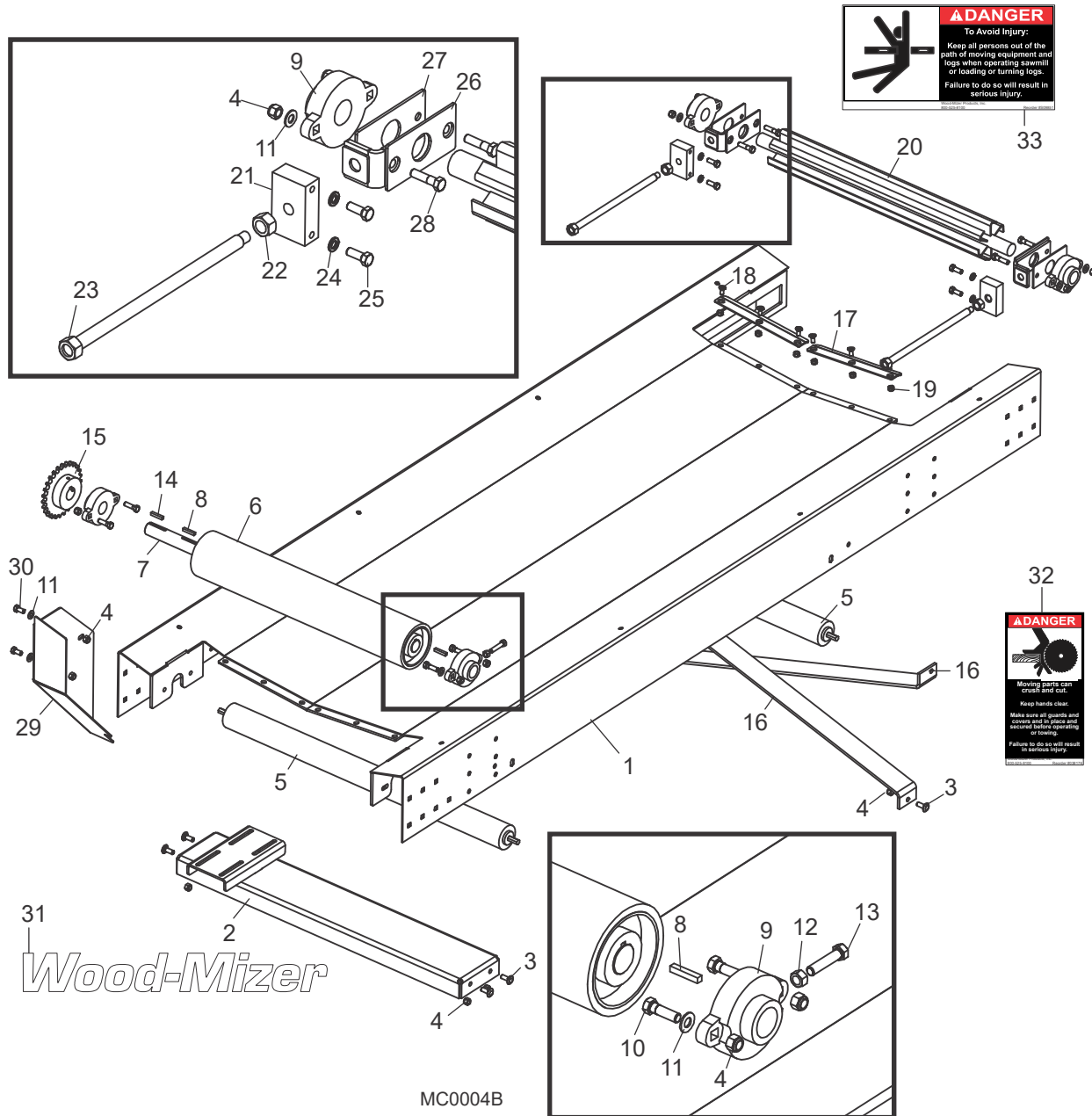


REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	CONVEYOR ASSEMBLY, MODULAR BASE ( <a href="#">See Section 5.2</a> )		
2	LEG ASSEMBLY ( <a href="#">See Section 5.4</a> )		
3	CONVEYOR ASSEMBLY, MODULAR 8' EXTENSION ( <a href="#">See Section 5.3</a> )		
4	DRIVE ASSEMBLY ( <a href="#">See Section 5.5</a> )		
5	CONTROL ASSEMBLY, 2HP 480V 3PH ( <a href="#">See Section 5.6</a> )		
6	RAIL ASSEMBLY, CONVEYOR TALL ( <a href="#">See Section 5.8</a> )		
7	RAIL ASSEMBLY, CONVEYOR SHORT ( <a href="#">See Section 5.7</a> )		
8	BELT, 8' X 24" CONVEYOR	038935-8	1
	BELT, 16' X 24" CONVEYOR	038935-16	1
	BELT, 24' X 24" CONVEYOR	038935-24	1
	BELT, 32' X 24" CONVEYOR	038935-32	1
	BELT, 40' X 24" CONVEYOR	038935-40	1
	LONGER BELTS AVAILABLE UPON REQUEST		

# 5 Replacement Parts

## Base Conveyor

### 5.2 Base Conveyor



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>CONVEYOR ASSEMBLY, MODULAR BASE</b>	039520	1
1	Top Weldment, Conveyor	039461	1
2	Mount Weldment, Conveyor Drive	038803	1
3	Bolt, 3/8-16 x 1" Carriage Head Grade 5	F05007-165	6
4	Nut, 3/8-16 Hex Nylon Lock	F05010-10	16

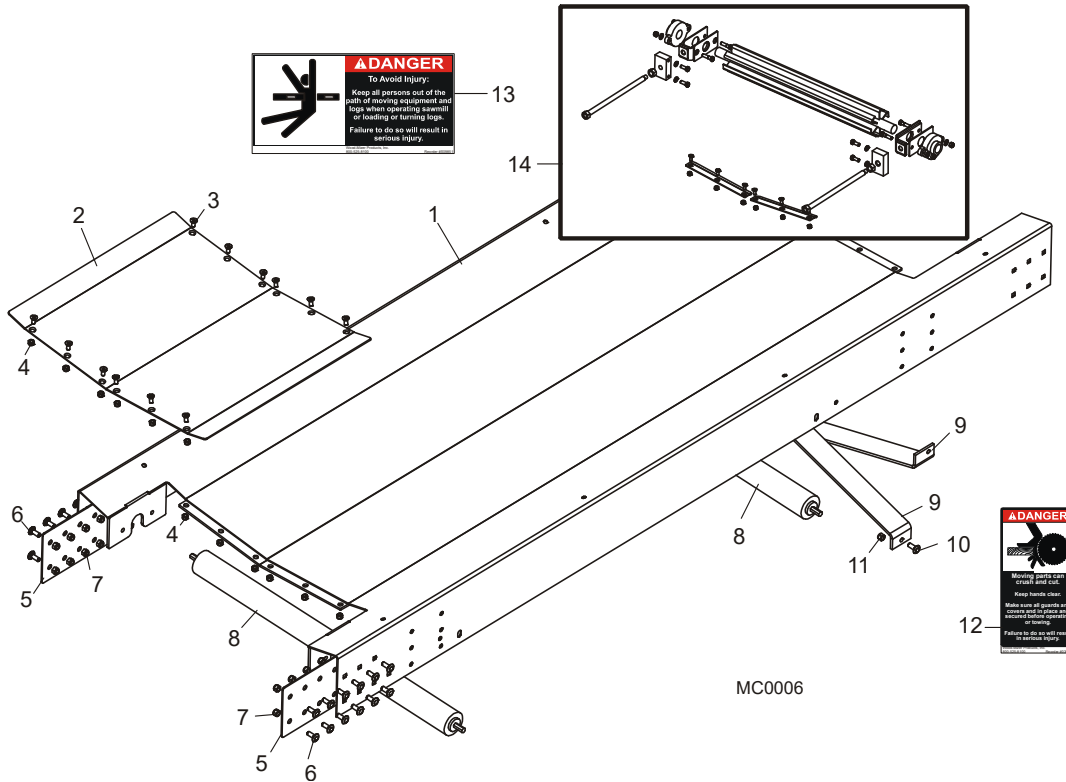
<b>5</b>	Roller, 2 1/2" Dia. x 34 3/4" Painted	038931	2	
	Roller Assembly, Conveyor Drive	039495	1	
<b>6</b>	Roller, Conveyor Drive	017831	1	
<b>7</b>	Shaft, Conveyor Drive Roller	016745	1	
<b>8</b>	Key, 1/4" Square x 1 3/8"	017832	2	
<b>9</b>	Bearing, 1 1/4" Flanged	016744	4	
<b>10</b>	Bolt, 3/8-16 x 1 1/4" Hex Head Grade 5	F05007-123	4	
<b>11</b>	Washer, 3/8" SAE Flat	F05011-3	8	
<b>12</b>	Nut, 3/8-16 Hex	F05010-1	1	
<b>13</b>	Bolt, 3/8-16 x 1 3/4" Hex Head Full Thread Grade 5	F05007-129	1	
<b>14</b>	Key, 1/4" Square x 1 3/8"	017832	1	
<b>15</b>	Sprocket, #50 -27T x 1 1/4" Bore	047418	1	
<b>16</b>	Bracket, Cross Brace	039470	2	
<b>17</b>	Plate, Conveyor Ramp <sup>1</sup>	038904	2	
<b>18</b>	Bolt, 5/16-18 x 3/4" Flat Socket Head	F05006-95	6	
<b>19</b>	Nut, 5/16-18 Hex Nylon Lock	F05010-58	6	
<b>20</b>	Pulley, Idle Wing Painted <sup>1</sup>	016920	1	
<b>21</b>	Block, Idle Pulley Tensioner	016766	2	
<b>22</b>	Nut, 5/8-18 Hex	F05010-50	2	
<b>23</b>	Bolt Weldment, Idle Pulley Tensioner	016697	2	
<b>24</b>	Washer, 3/8" Split Lock	F05011-4	4	
<b>25</b>	Bolt, 3/8-16 x 1" Hex Head Grade 8	F05007-82	4	
<b>26</b>	Bracket Weldment, Idle Pulley Tensioner	016912	2	
<b>27</b>	Plate, Bearing Washer	016760	2	
<b>28</b>	Bolt, 3/8-16 x 1 1/2" Hex Head Grade 5	F05007-78	4	
<b>29</b>	Guard, Drive Chain	039498	1	
<b>30</b>	Bolt, 3/8-16 x 3/4" Hex Head Grade 5	F05007-118	2	
<b>31</b>	Decal, 10.25" Wood-Mizer Logo	052287	2	
<b>32</b>	Decal, Hand Hazard Danger	038176	2	
<b>33</b>	Decal, Keep Away Danger	S09851	2	

<sup>1</sup> Ramps, Idle Wing Pulley and associated hardware assembled to last extension table if applicable.

# 5 Replacement Parts

## Extension Conveyor

### 5.3 Extension Conveyor

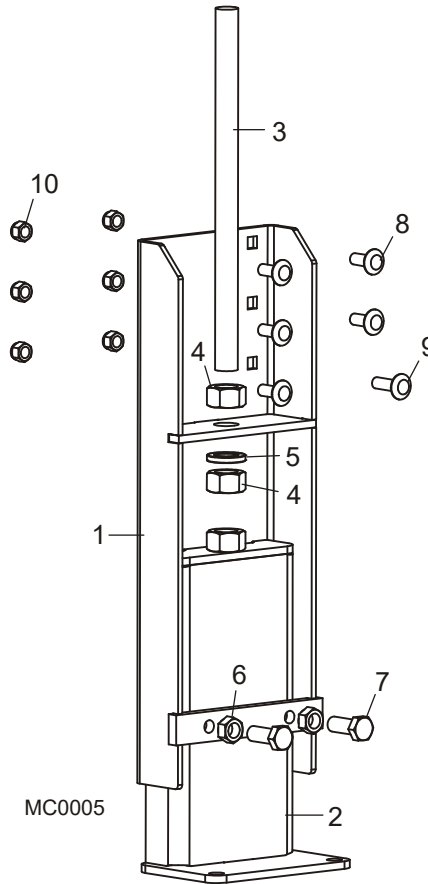


MC0006

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>CONVEYOR ASSEMBLY, MODULAR 8' EXTENSION</b>	039519	1
1	Top Weldment, Conveyor	039461	1
	Plate Assembly, Conveyor Connector	039483	1
2	Plate, Conveyor Connector	039476	1
3	Bolt, 3/8-16 x 1" Carriage Head Grade 5	F05007-165	12
4	Nut, 3/8-16 Hex Nylon Lock	F05010-10	12
	Splice Assembly, Conveyor	039493	2
5	Plate, Conveyor Splice	039494	1
6	Bolt, 3/8-16 x 1" Carriage Head Grade 5	F05007-165	12
7	Nut, 3/8-16 Hex Nylon Lock	F05010-10	12
8	Roller, 2 1/2" Dia. x 34 3/4" Painted	038931	2
9	Bracket, Cross Brace	039470	2
10	Bolt, 3/8-16 x 1" Carriage Head Grade 5	F05007-165	2
11	Nut, 5/16-18 Hex Nylon Lock	F05010-10	2
12	Decal, Hand Hazard Danger	038176	2
13	Decal, Keep Away Danger	S09851	2
14	<b>CONVEYOR RAMP &amp; IDLE WING PULLEY PARTS <sup>1</sup></b>		

<sup>1</sup> Parts supplied with base conveyor assembly and moved to extension when applicable ([See Section 5.2](#)).

## 5.4 Leg Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>LEG ASSEMBLY, 18-24" HEIGHT</b>	038806	4 <sup>1</sup>	
	<b>LEG ASSEMBLY, 23-28" HEIGHT</b>	038807	4 <sup>1</sup>	
	<b>LEG ASSEMBLY, 29-35" HEIGHT</b>	038808	4 <sup>1</sup>	
	<b>LEG ASSEMBLY, 35-41" HEIGHT</b>	038809	4 <sup>1</sup>	
	<b>LEG ASSEMBLY, 41-47" HEIGHT</b>	038810	4 <sup>1</sup>	
	<b>LEG ASSEMBLY, 47-53" HEIGHT</b>	038811	4 <sup>1</sup>	
<b>1</b>	Leg Weldment, 18-24" Height	038812	1	
	Leg Weldment, 23-28" Height	038813	1	
	Leg Weldment, 29-35" Height	038814	1	
	Leg Weldment, 35-41" Height	038815	1	
	Leg Weldment, 41-47" Height	038816	1	
	Leg Weldment, 47-53" Height	038817	1	
<b>2</b>	Foot Weldment, Conveyor	038818	1	
<b>3</b>	Rod, 3/4-10 x 12" Threaded	054017	1	
<b>4</b>	Nut, 3/4-10 Hex	F05010-7	2	

## **5** Replacement Parts

### *Leg Assembly*

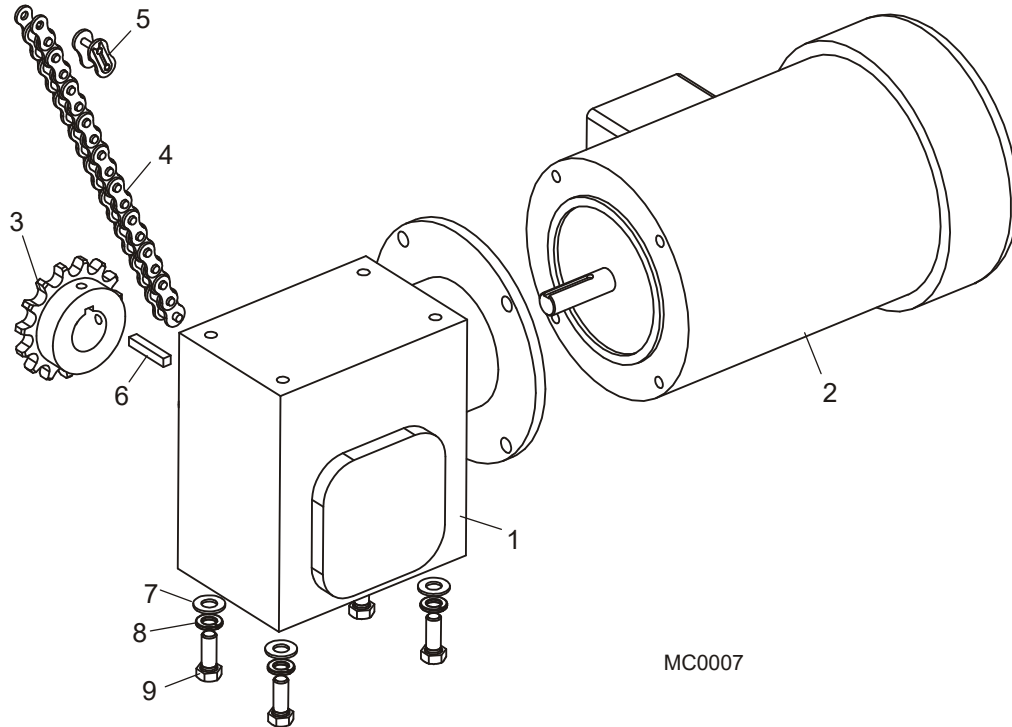
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<b>5</b>	Washer, 3/4" Split Lock	F05011-6	1	
<b>6</b>	Nut, 1/2-13 Hex	F05010-35	2	
<b>7</b>	Bolt, 1/2-13 x 1 1/4" Hex Head Grade 5	F05008-37	2	
<b>8</b>	Bolt, 3/8-16 x 1" Carriage Head Grade 5	F05007-165	5	
<b>9</b>	Bolt, 3/8-16 x 1 1/4" Carriage Head Grade 5	F05007-127	1	
<b>10</b>	Nut, 3/8-16 Hex Nylon Lock	F05010-10	6	

<sup>1</sup> Four assemblies required for base conveyor unit. Add two leg assemblies for each conveyor extension.



## 5.5 Drive Assembly



MC0007

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>DRIVE ASSEMBLY, CONVEYOR 80FPM</b>	038829	1
	<b>DRIVE ASSEMBLY, CONVEYOR 107FPM</b>	038830	1
	<b>DRIVE ASSEMBLY, CONVEYOR 120FPM</b>	038831	1
	<b>DRIVE ASSEMBLY, CONVEYOR 180FPM</b>	038832	1
	<b>DRIVE ASSEMBLY, CONVEYOR 241FPM</b>	038833	1
<b>1</b>	Gearbox, 15:1 (80 & 107FPM Only)	051444	1
	Gearbox/Motor, Conveyor (120, 180 & 241FPM Only)	016764	1
<b>2</b>	Motor, 2HP 3PH 230/460V TEFC 56C w/o Base (80 & 107FPM Only)	042390	1
	Motor (Included w/Gearbox - 120, 180 & 241FPM Only)		
<b>3</b>	Sprocket, 50B15 x 1 1/8" Bore (80FPM Only)	039489	1
	Sprocket, 50B20 x 1 1/8" Bore (107FPM Only)	038564	1
	Sprocket, 50-15 x 1" Bore (120FPM Only)	039489	1
	Sprocket, 50B23 x 1" Bore (180FPM Only)	003941	1
	Sprocket, 50B29 x 1" Bore (241FPM Only)	003942	1
<b>4</b>	Chain, #50 x 36 7/8" (59 Pitches - 80FPM Only)	038932	1
	Chain, #50 x 39 3/8" (63 Pitches - 107 & 180FPM Only)	048039	1
	Chain, #50 x 38 3/4" w/Master Link (61 Pitches - 120FPM Only)	038184	1
	Chain, #50 x 41 7/8" (67 Pitches - 241FPM Only)	038933	1
<b>5</b>	Link, #50 Master (80, 107, 180 & 240FPM Only)	P20208	1
	Master Link (Included w/Chain - 120FPM Only)		

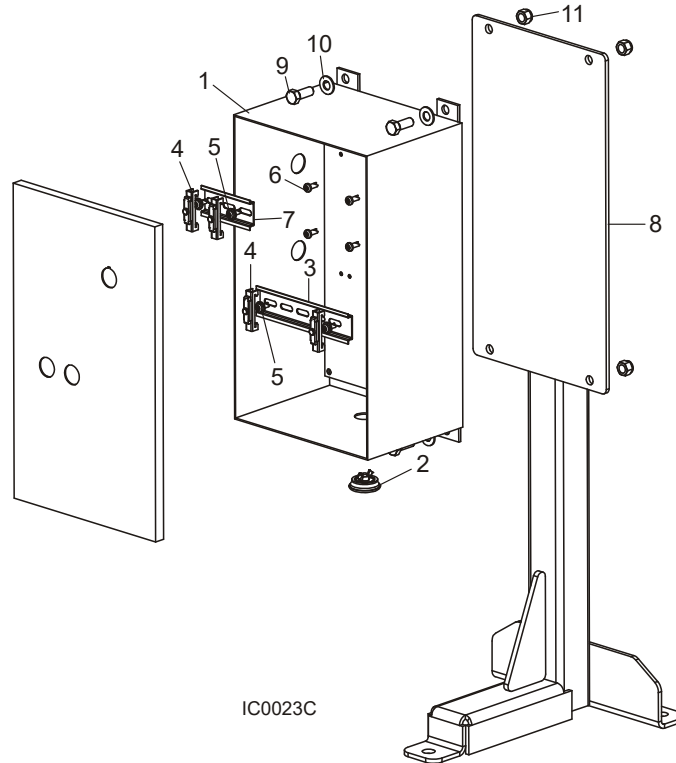
## **5** Replacement Parts

*Drive Assembly*

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<b>6</b>	Key, 1/4" Square x 1 3/8"	017832	1	
<b>7</b>	Washer, 3/8" SAE Flat	F05011-3	4	
<b>8</b>	Washer, 3/8" Split Lock	F05011-4	4	
<b>9</b>	Bolt, 3/8-16 x 1" Hex Head Grade 8	F05007-82	4	

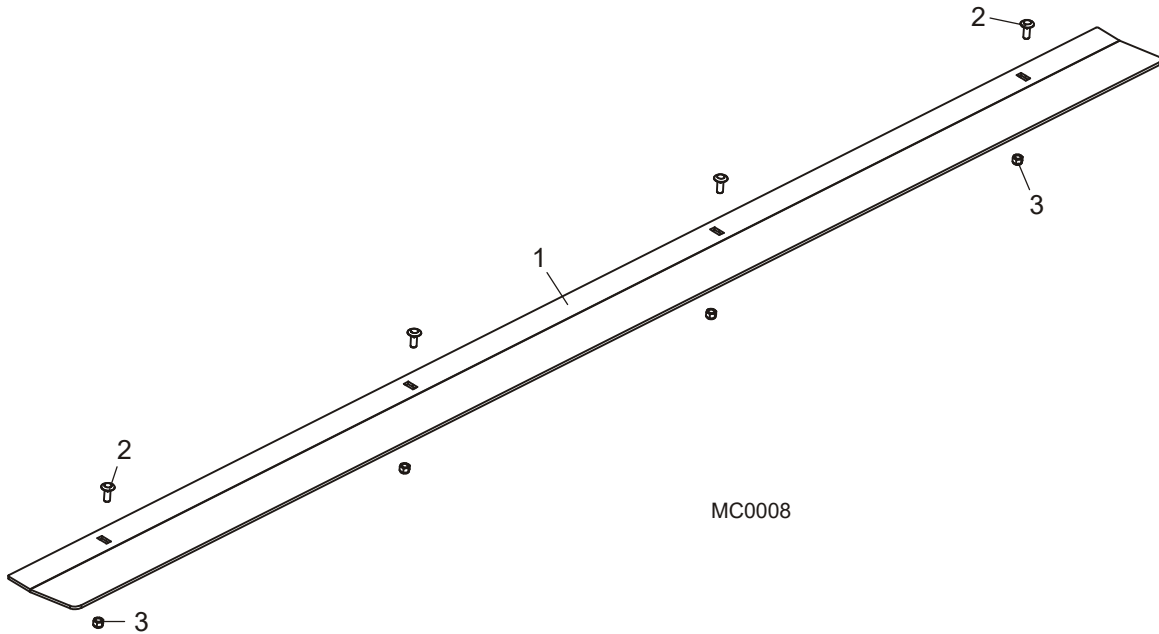
## 5.6 Control Assembly (Optional)



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>CONTROL ASSEMBLY, 480V 3P 2HP START/STOP</b>	025293	1
	<b>CONTROL ASSEMBLY, 240V 3P 2HP START/STOP</b>	050934	1
	<b>CONTROL ASSEMBLY, 240V 1P 2HP START/STOP</b>	050999	1
<b>1</b>	Enclosure, 14" x 8" x 6" NEMA12 Custom (w/Cover)	025292	1
	Electrical Components ( <a href="#">See Section 4.4</a> )		
<b>2</b>	Plug, AS050 Oiltite	024685	1
<b>3</b>	Rail, 35mm x 7.5mm x 5 1/2" DIN	024474-5_5	1
<b>4</b>	Clamp, DIN Rail	E22707	4
<b>5</b>	Screw, #10-24 x 1/2" Phillips Head	F05004-186	4
<b>6</b>	Bolt, #10-24 x 1/2" Phillips Pan Head Type 23	F05015-17	4
<b>7</b>	Rail, 35mm x 7.5mm x 3" DIN	024474-3	1
<b>8</b>	<b>STAND WELDMENT, IC CONTROL</b>	038648	1
<b>9</b>	<b>BOLT, 3/8-16 X 1" HEX HEAD GRADE 5</b>	F05007-87	4
<b>10</b>	<b>WASHER, 3/8" SAE FLAT</b>	F05011-3	4
<b>11</b>	<b>NUT, 3/8-16 HEX NYLON LOCK</b>	F05010-10	4

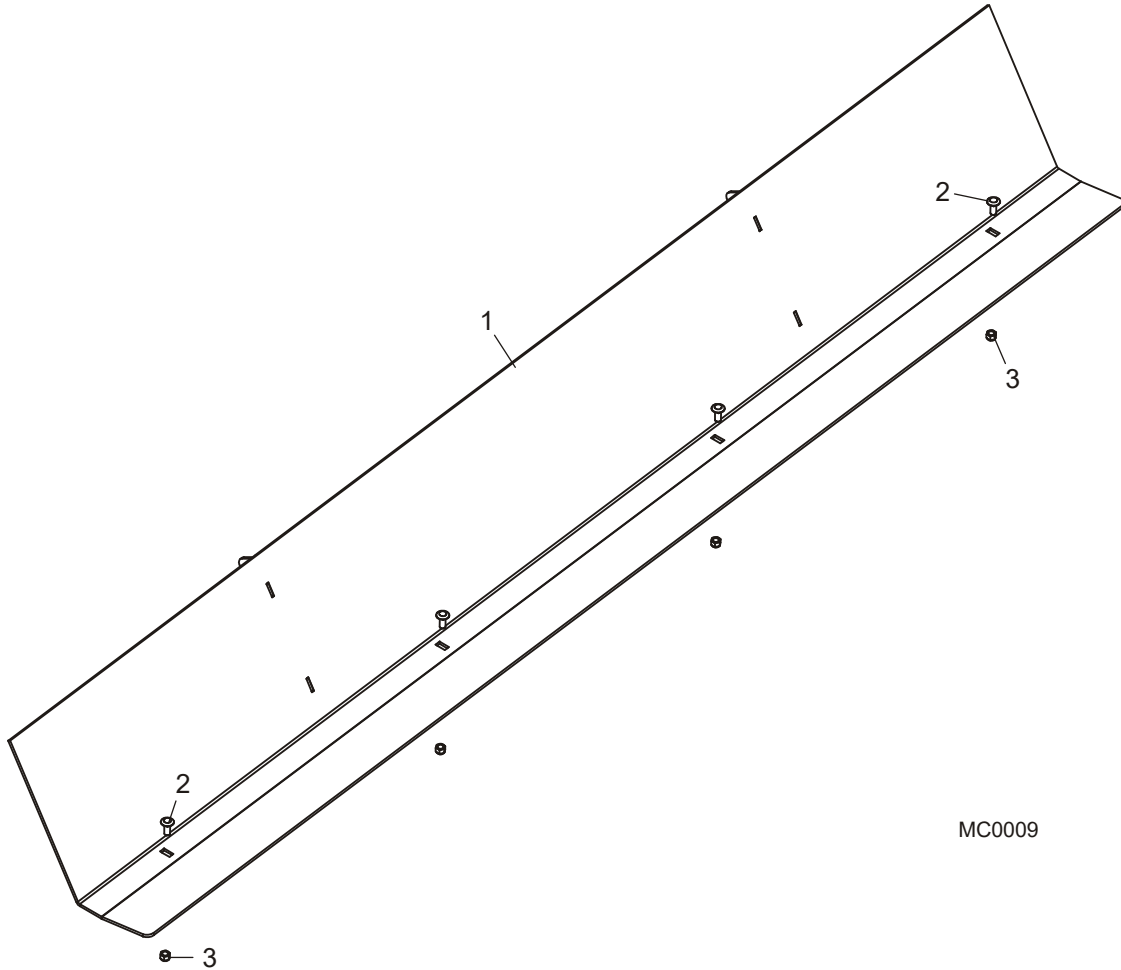
**5** Replacement Parts  
*Side Rail Assembly, Short (Optional)*

**5.7 Side Rail Assembly, Short (Optional)**



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>RAIL ASSEMBLY, SHORT CONVEYOR SIDE</b>	038869	1
1	Rail Weldment, Short Conveyor Side	039491	1
2	Bolt, 3/8-16 x 1" Carriage Head Grade 5	F05007-165	4
3	Nut, 3/8-16 Hex Nylon Lock	F05010-10	4

5.8 Side Rail Assembly, Tall (Optional)



MC0009

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>RAIL ASSEMBLY, TALL CONVEYOR SIDE</b>	038868	1	
1	Rail Weldment, Tall Conveyor Side	039490	1	
2	Bolt, 3/8-16 x 1" Carriage Head Grade 5	F05007-165	4	
3	Nut, 3/8-16 Hex Nylon Lock	F05010-10	4	

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