



XM-100 Bulk Loader

**Operation Instructions, Set-up,
And Parts List Information**



Have this information ready when calling in about your equipment:

Model: _____ Serial #: _____ Circuit Board #: _____

Warranty Start Date: _____

Model: _____ Serial #: _____ Circuit Board #: _____

Warranty Start Date: _____

Model: _____ Serial #: _____ Circuit Board #: _____

Warranty Start Date: _____

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Warranty Start Date: _____

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Illustrations in this guide are for reference only and may depict optional features that are available at additional costs.

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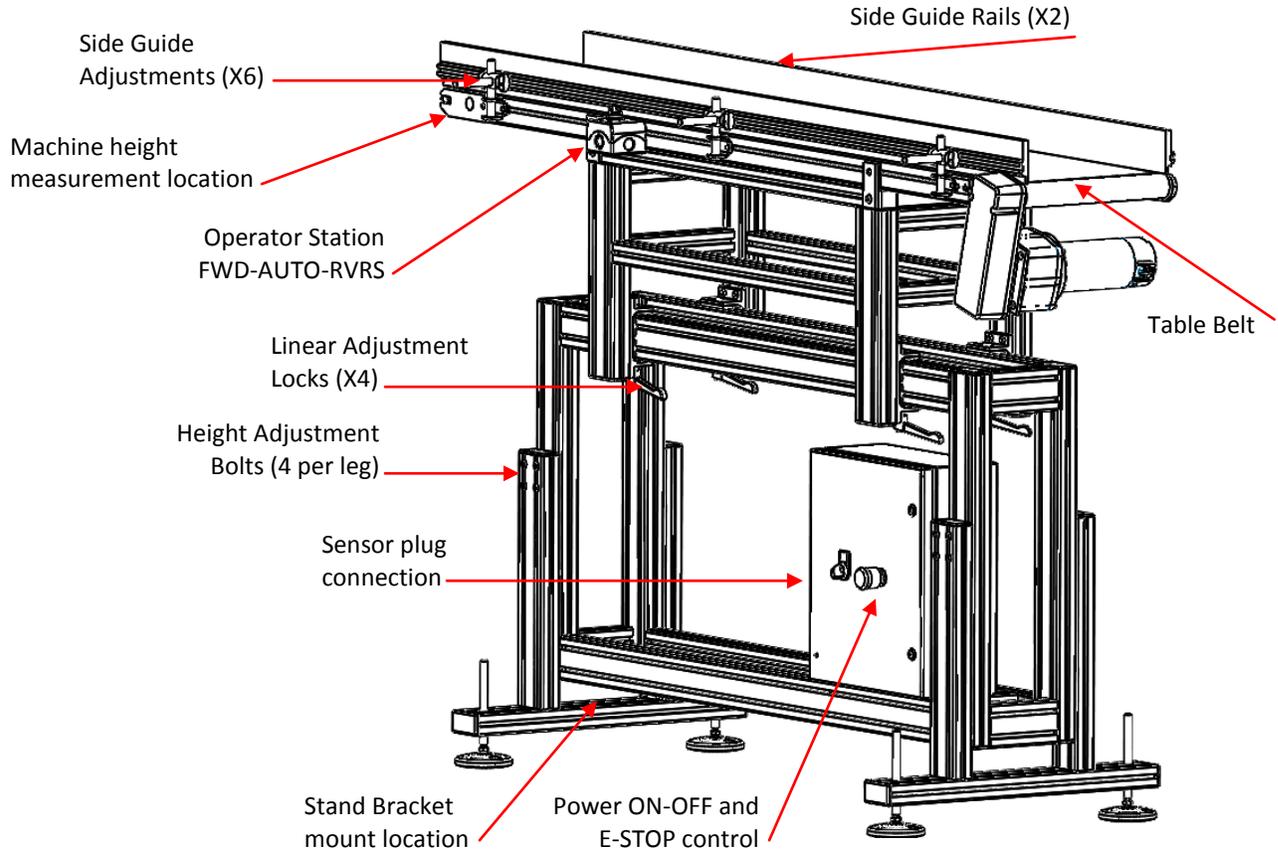
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SECTION 1: MACHINE OVERVIEW

Please review the components and descriptions to become familiarized with your new XM-100 Bulk Loader.



Below are the accessory components that ship with the XM-100 Bulk Loader. The XM Feeder Low Profile wedge assembly will already be installed on the feeder if the Bulk Loader shipped with an XM feeder.

Product sensor



Stand Bracket



Product deflector



OPTIONAL if shipped without feeder

XM Feeder Low Profile wedge assembly



SECTION 2: SETUP

This section will walk you through setup adjustments and attachment for the *Xtreme* XM-100 Bulk Loader.

Take a moment to get familiarized with the basic loader components on the previous page.

Attaching to Feeder/Stand



Figure 2.1

Set the XM-100 Height (Figure 2.1) by measuring from the 'Machine Height Measurement Location' to the floor. The adjustment requires a hand fork truck to lift the machine to the height, then by loosening the 'Height Adjustment Bolts', lower the leg assembly down to the floor and retightening the adjustment bolts

NOTE: Make sure the Low profile XM Feeder wedge is installed on the feeder. The next section will determine how the height value is figured



Figure 2.2

Make certain you have positioned the Low profile feeder wedge back far enough in the carriage to handle the longest product you will be feeding. Reference the small arrow (Figure 2.2). The height for the XM-100 will be set by measuring from the floor to $\frac{1}{4}$ " above the black wedge (larger arrow).



Figure 2.3

Loosen the 4 'Linear Adjustment Locks' and position the XM-100 table with enough travel to accommodate moving the table forward into the feeder for smaller length product. (Figure 2.3) Typically, 13" of travel should accommodate this measurement. Lock the 4 'Linear Adjustment Locks'.



Figure 2.4

Slide the XM-100 towards the feeder until the front crown of the table belt sits vertically over the feeder wedge. (Figure 2.4). (See drawing below)

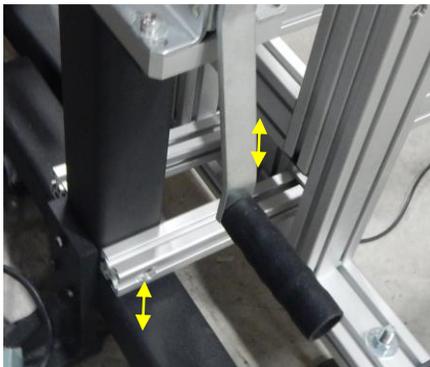
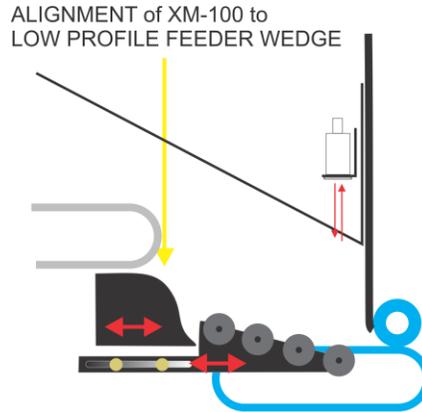


Figure 2.5

Install the Stand Bracket to the Feeder stand as shown in (Figure 2.5). This locks the XM-100 to the Feeder/Stand setup. All adjustments from this point will be handled from the 4 'Linear Adjustment Locks'. The Bracket is shipped with extrusion nuts and 2 long bolts to make the connections.

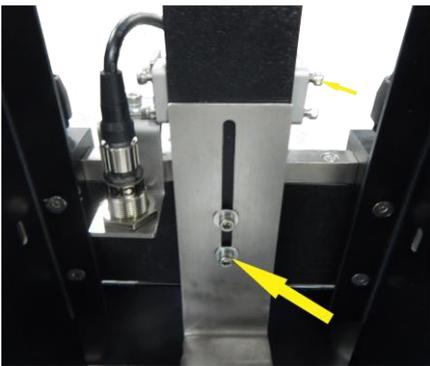


Figure 2.6

Install the Product Sensor and Deflector onto the feeder as shown (Figure 2.6).

The sensor is mounted to a "C" bracket that attaches to the feeder center hopper. There are 4 screws (small arrow) that tighten against the hopper and allow for a vertical adjustment. Plug the sensor into the XM-100 plug receptacle. The height of the sensor will be discussed in the next figure.

The deflector has 2 screws (larger arrow) that replace 2 of the 3 flat head mounting screws that are connecting the center hopper to the feeder hopper frame. The slot allows for a vertical adjustment. The deflector acts to push the product down from the XM-100 table into the hopper as product is being fed. This is important for stiffer product.



Figure 2.7

The sensor has an adjustment setting that can control the gain (Figure 2.7). After positioning the mechanical height from Figure 2.6, adjusting this setting will allow positioning of when the sensor tells the XM-100 to advance more products into the feeder.

NOTE: this is a diffuse reflective sensor that measures background suppression. Printed color on product can vary its performance. You may need to re-adjust as different printed materials are introduced

Setting up product



Figure 2.8

Set your product up in the feeder first. When setting the side guides on the feeder allow a 1/4" gap from the sides of the product. This will allow the side guides of the XM-100 to merge inside of them as shown in Figure 2.10. Once the product is setup in the feeder then position the XM-100 table with the 'Linear Adjustment Locks' (4 of them) (Figure 2.8) so that the vertical alignment in Figure 2.4 is achieved. Lock the adjustment.

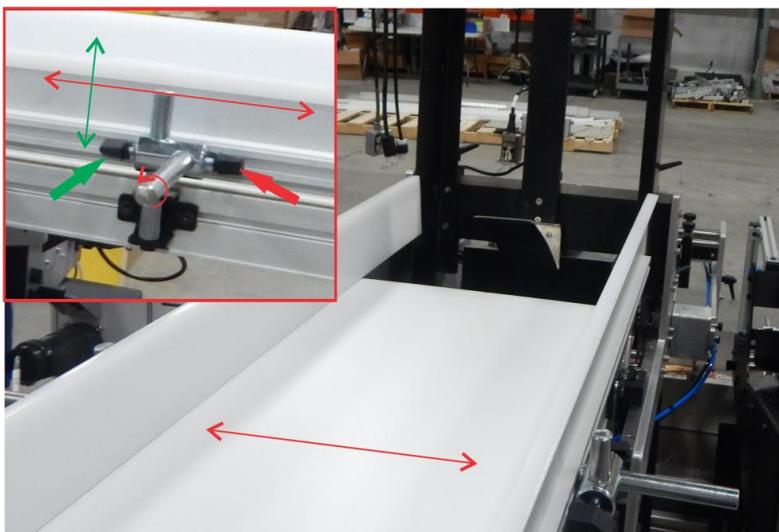


Figure 2.9

Set the side guide holders. (Figure 2.9) There are 3 per side. The knob pointed to with the red arrow, allows the width setting. With the knob loose, turning the shaft counter clockwise will allow the horizontal movement of each side. The green knob allows the vertical movement of each side guide. These should be adjusted so that the white plastic rail piece sits flush just above the table belt.

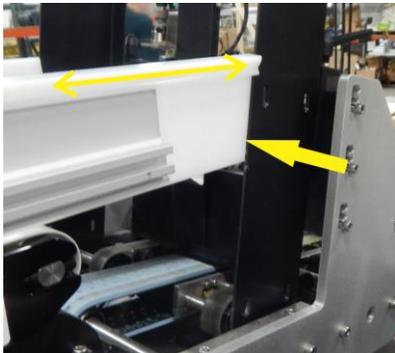


Figure 2.10

Once the side guides have been set in Figure 2.9, manually slide the plastic portion of the side guide inside the feeder hopper side rails (Figure 2.10) This ensures as product is fed into the feeder hopper from the XM-100 that no edges of the product will catch.

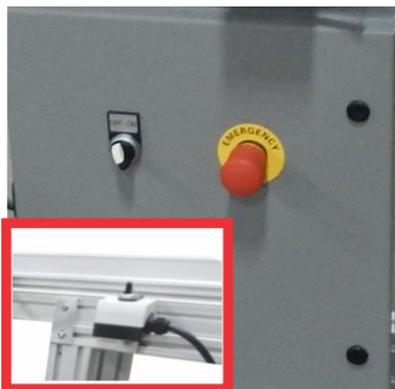
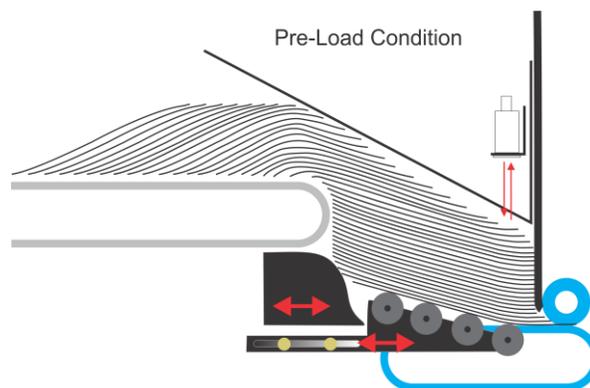


Figure 2.11

While setting up the XM-100, it's best to turn the XM-100 OFF. (Figure 2.11). When the side guides have been positioned, place product into your feeder and slightly back along the XM-100 loader table. (See below)

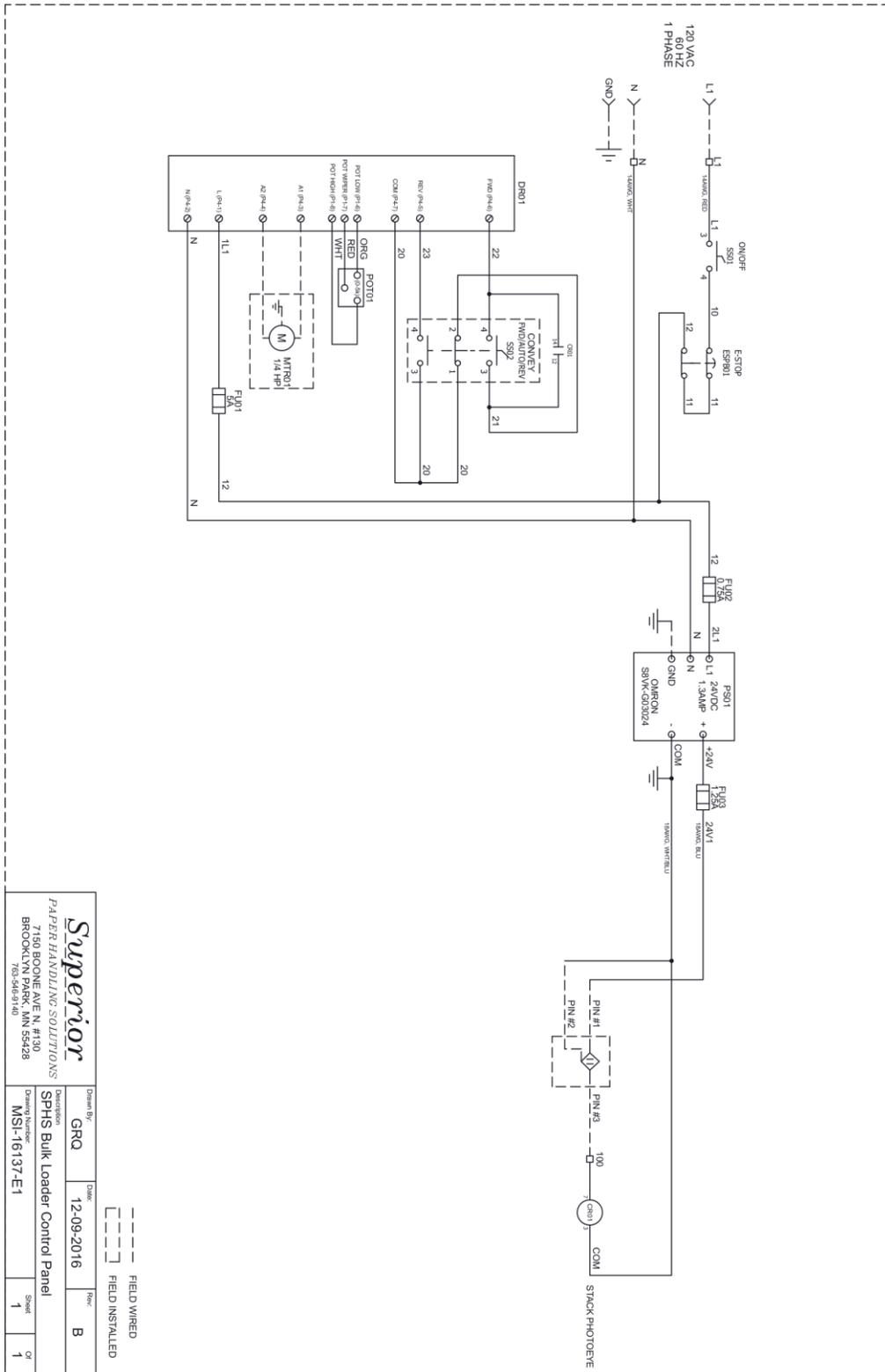


Then set the Product sensor sensitivity and height to the product. Set the product deflector height at this point as well.

Put the operator station into AUTO and turn the XM-100 ON. If your sensor is set right, the XM-100 should not advance the table belt. Run the feeder allowing product in the hopper to go down. Verify the XM-100 sensor turns on at the desired point and advances the table belt on the XM-100. If all is true, then the XM-100 is setup correctly. Load the XM-100 with product and begin operation.

NOTE: The FWD and REV on the operator station are for manual control in setup and job change overs. DO NOT forget to put this back into AUTO when running a job.

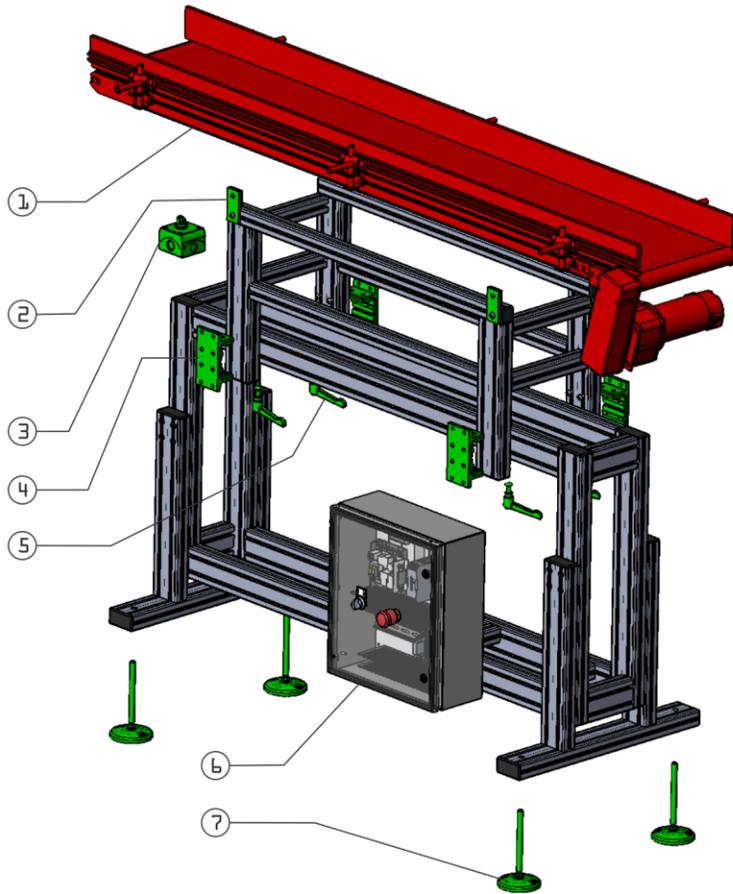
SECTION 3: WIRING AND ELECTRICAL DETAIL



--- FIELD WIRED
 [] FIELD INSTALLED

Superior		Drawn By:	GRQ	Date:	12-09-2016	Rev:	B	
PAPER HANDLING SOLUTIONS		Checked By:						
7150 BOONK AVE N, #130		SPHS Bulk Loader Control Panel		Drawing Number:		MSI-16137-E1	Sheet	1
BROOKLYN PARK, MN 55428				763-5463-140			Of	1

SECTION 4: COMPONENTS / PARTS LIST



ITEM	PART NUMBER	DESCRIPTION	QTY
1	As40	Conveyor Model (Reference attached MFG manual for breakout)	1
2	300878	Conveyor Mount Bracket	4
3	300879	Operator Station (FWD-AUTO-REVERSE)	1
4	300880	Slide Bearing (1530)	4
5	300881	Locking Handle	4
6	300882	ELECTRICAL CABINET	1
		Motor Driver	1
		Power Supply	1
		Relay	1
		E-Stop	1
		ON-OFF Selector	1
7	300883	Pedestal Feet	4

SECTION 5: WARRANTY

WARRANTY:

SUPERIOR – PHS LIMITED WARRANTY

Superior Paper Handling Solutions, Inc. (Superior – PHS) warrants this product to be free from defects in materials and workmanship, when used under recommended operating conditions, for a period of one year from the date of original shipment.

If you discover a defect during the warranty period, please notify the distributor from whom you purchased this product, who will arrange for the replacement parts to be sent to you. Defective parts must be returned to Superior – PHS for credit on replacement parts. Shipping and labor costs are not included in this warranty. If the defect is not field-repairable, and if you return it to Superior – PHS during the warranty period, Superior – PHS will, at its sole option, repair or replace this product, at no charge to you other than shipping charges to and from the facility in Minneapolis, Minnesota.

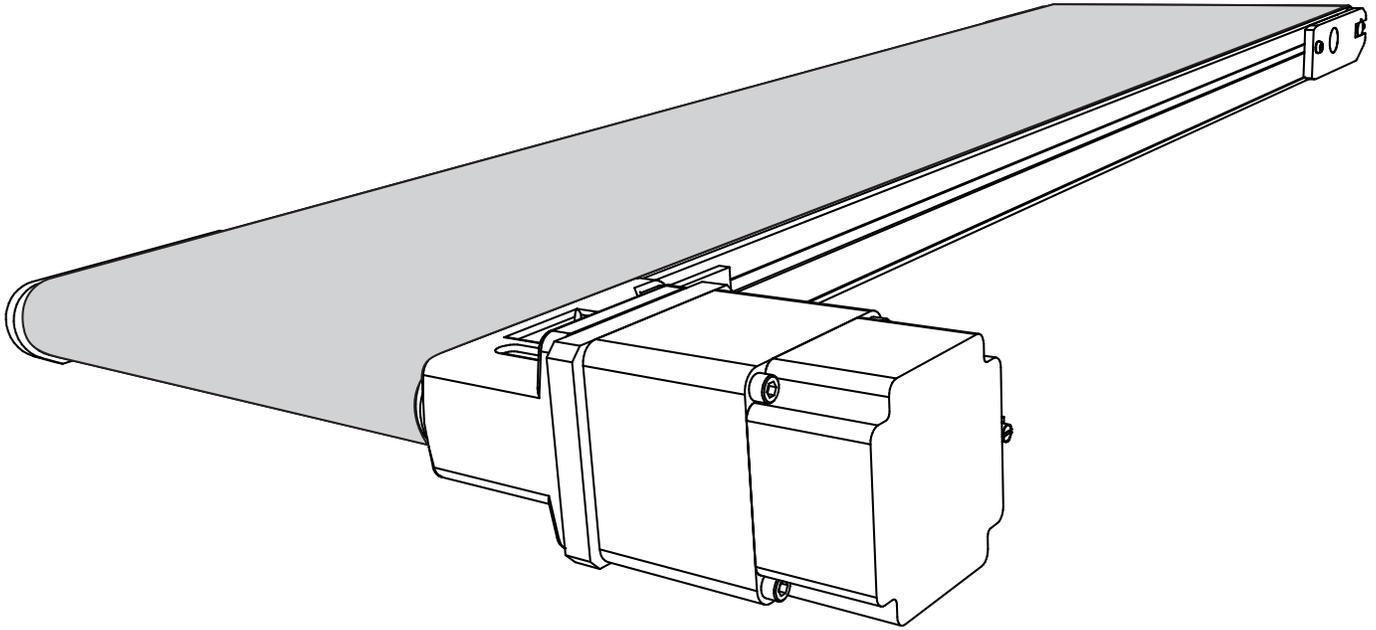
If you return this product to Superior – PHS for warranty repair or replacement, please attach to the returned product your name and your company's name, address, telephone number and fax number; a description of the problem; and a copy of the bill of sale or invoice that shows the appropriate serial number for the product. All returns must be accompanied by an authorized Superior – PHS Returned Goods Authorization (RGA) number. An authorized RGA number can be obtained from the Superior - PHS distributor from whom you purchased this product.

This warranty applies only to products manufactured by Superior - PHS. This warranty does not apply if the product has been damaged by accident, abuse, misuse, neglect, improper maintenance, misapplication, or as a result of being attached to equipment not supplied by Superior - PHS; if the product has been modified without the written permission of Superior - PHS; or if the product's serial number has been removed or defaced. This warranty further does not apply to the failure of any rubber-based or consumable components including, but not limited to, rollers, bearings, belts, fuses, or bulbs.

ALL IMPLIED WARRANTIES INCLUDING WITHOUT LIMITATION THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE AND THE IMPLIED WARRANTY OF MERCHANTABILITY ARE HEREBY DISCLAIMED.

Superior - PHS is not responsible for special, incidental, or consequential damages resulting from any breach of warranty or under any other legal theory, including lost profits, downtime, goodwill, or damage to or replacement of equipment or property.

This warranty and the remedies set forth above are exclusive and are in lieu of all others, oral or written, express or implied. There are no warranties that extend beyond the description on the face hereof. No Superior - PHS employee, distributor, or agent is authorized to make any modification, extension, or addition to this warranty.



AS40 Conveyors (For Conveyors Longer Than 13')

Installation & Maintenance Instructions



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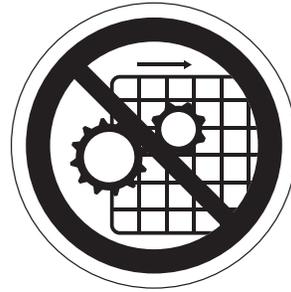
Warnings



When used improperly, conveyor rollers can pinch or maim



Lock out power before servicing conveyor



Do not use with guards removed



Read this manual before operating

DANGER

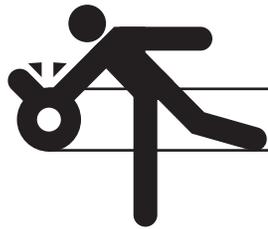
WARNING

WARNING

WARNING



Climbing, sitting, walking or riding on conveyor at any time will cause severe injury or death



Exposed moving parts can cause severe injury; DISCONNECT POWER before removing guard



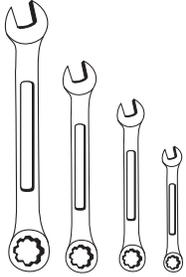
Equipment may start without warning - can cause severe injury. KEEP AWAY



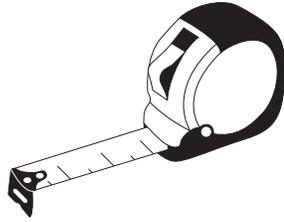
Servicing moving or energized equipment can cause severe injury LOCK OUT POWER

Tools

► Required Tools



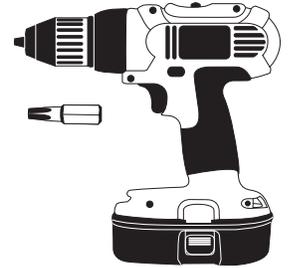
Set of Metric Wrenches (3mm-12mm)



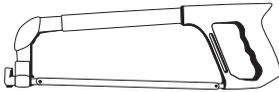
Tape Measure



10" Adjustable Wrench



Screw Gun and T-30 Torx Bit



Aluminum cutting hack saw or equivalent



Wide Flat Head Screwdriver

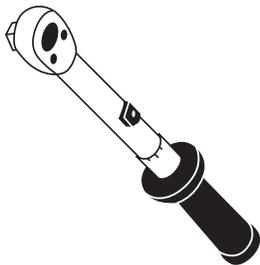


Set of Metric allen wrenches (3mm, 4mm & ball head 5mm)

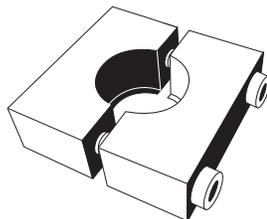


Bubble level

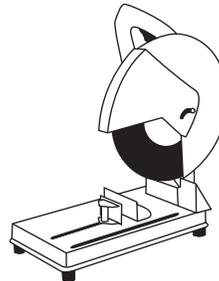
► Optional Tools



3/8" Torque wrench



QC Industries bearing removal tool (part# 1A0077A)



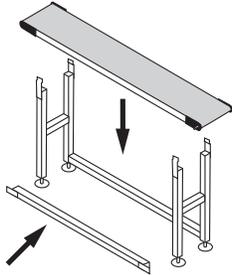
Electric Chop Saw

Installation

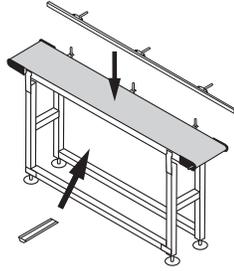
► Check Your Shipment

Before opening the shipment, visually inspect the outside of the crate/box for shipping damage. Carefully unpack the crate/box, inspecting for component damage which may have occurred inside the packing materials. Contact the carrier and QC Industries regarding any damage that may have occurred during shipment. Check the contents of your shipment against the supplied packing slip and inform QC Industries of any discrepancies.

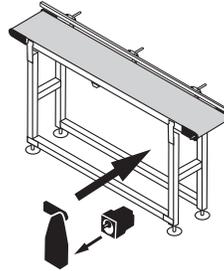
► General Sequence of Installation



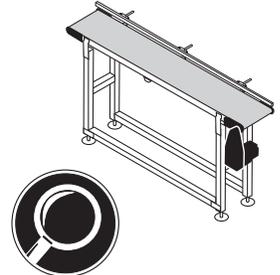
1 Mount conveyor to stands or compatible mounting brackets.



2 Attach sides, guides or underside idlers to conveyor and adjust as needed.



3 Install drive motor and mounting package.



4 Lag conveyor to floor/ Engage caster locks and inspect conveyor before use.

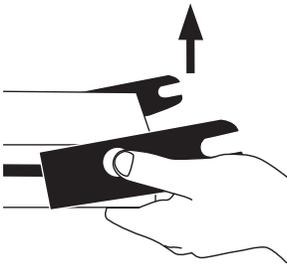
For conveyors less than 13', proceed to stand and/or mount installation.

For conveyors longer than 13', proceed to conveyor assembly on next page.

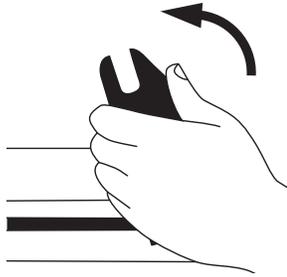
► Assistance

If you need assistance, please contact QC Industries customer service department Monday through Friday, 8am-5pm EST at (513) 753-6000. In addition, your local distributor has been trained at the factory and can provide support in many ways. You can also visit our website - qcconveyors.com - for additional information and technical documents.

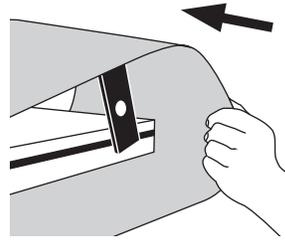
► Installation of Belt for Conveyors With and Without Stands



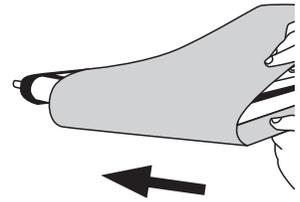
1 Press both release buttons simultaneously and lift up on tail pulley.



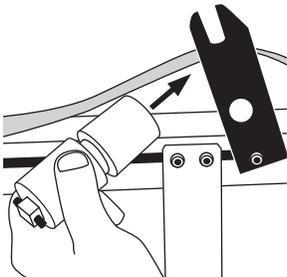
2 Ensure Tension Release tail pulley is in the disengaged position.



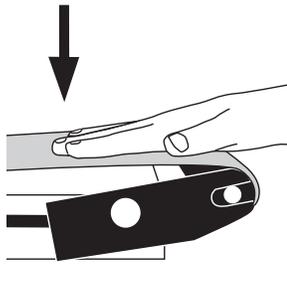
3 Loop belt over tail end.



4 Loop belt over drive end.

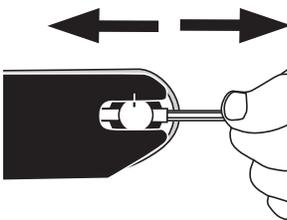


5 Insert pulley into slot in tail with dog point facing in towards conveyor.



6 Push down on tail pulley until it locks into position.

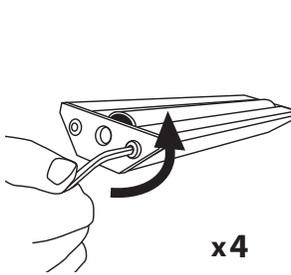
► Tensioning the Belt



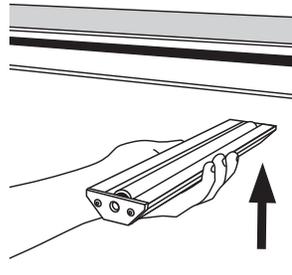
1 Rotate Tensioning screw until index marks are aligned and proper tension is achieved.

> After tensioning, belt is ready to be tracked. (See belt tracking section of this manual)

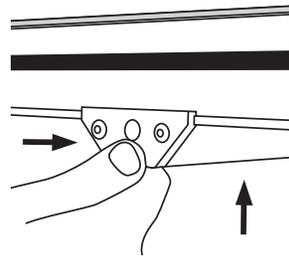
► Installation of Underside Idler Pulleys



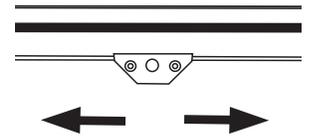
1 Loosen socket head cap screws.



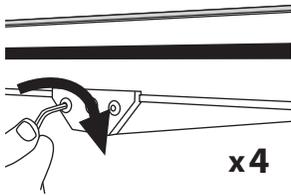
2 Place mount against underside of frame.



3 Clamp onto frame ensuring end plate engages bottom flange of conveyor frame.



4 Move idlers into position. (Usually evenly spaced along length of conveyor)



5 Tighten socket head cap screws.

Please proceed to mounting angle braces, gusset plates and cross ties or casters and leveling feet depending on your application.

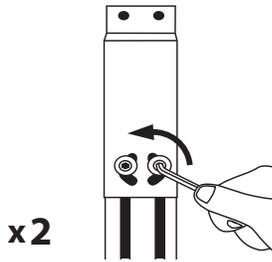
Stand Installation

Mounting Aluminum Stands to Conveyor

► Mounting Aluminum Exact Width Stands With & Without Outriggers

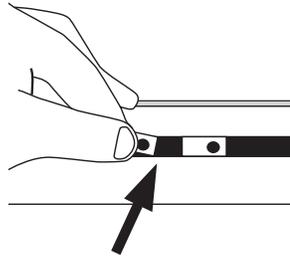
- > If installing gusset plates and cross ties or angle braces on stands with outriggers, slide them into the slots on each leg before installing legs to frame.

Stand Legs should be as close to ends of conveyor as possible. Stand legs should be placed no more than 6' apart and evenly spaced along conveyor frame.

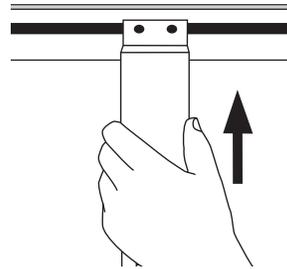


x2

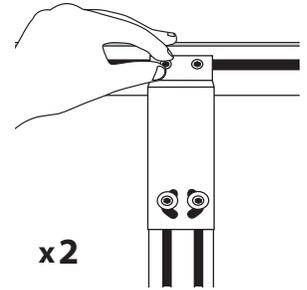
1 Loosen screws holding mounting brackets in place.



2 Insert drop in nuts into t-slot on conveyor frame.

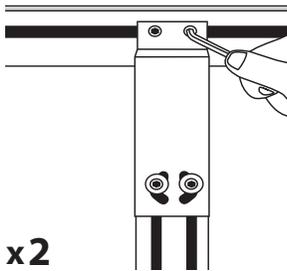


3 Slide mounting brackets up to engage conveyor frame.



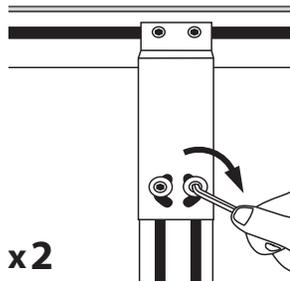
x2

4 Align holes in brackets to holes in drop in t-nuts and insert socket head cap screws.



x2

5 Tighten socket head cap screws.



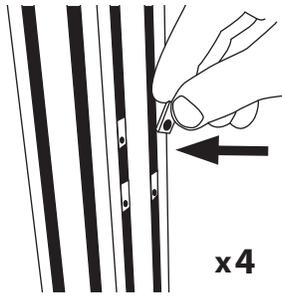
x2

6 Tighten screws holding bracket to stand.

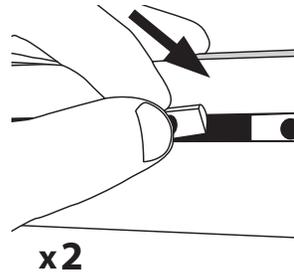


To see a video of this process, scan this code on your phone or tablet. You may also visit <http://bit.ly/as40stand>

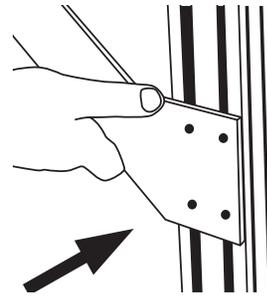
► Mounting Angle Braces



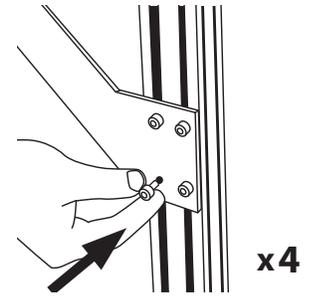
1 Insert drop in nuts into stand leg t-slots. (Two per slot)



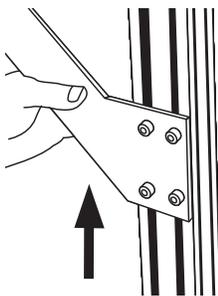
2 Insert drop in nuts into conveyor frame's t-slot.



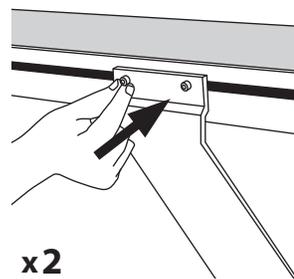
3 Place angle brace over drop in nuts in stand.



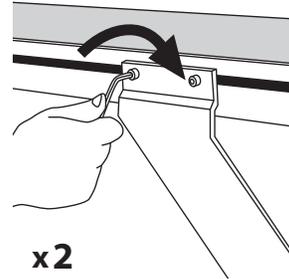
4 Insert socket head cap screws through angle brace and into drop in nuts on stand (do not fully tighten).



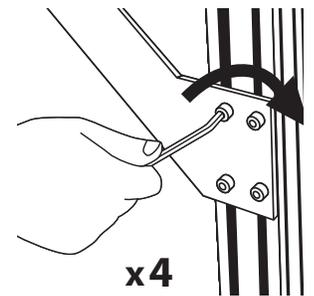
5 Slide up and align angle brace with drop in nuts in frame.



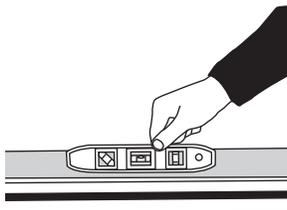
6 Insert socket head cap screws through angle brace and into nuts in conveyor frame.



7 Tighten socket head cap screws on frame.



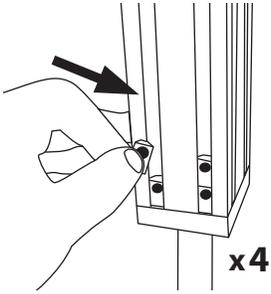
8 Tighten socket head cap screws on stand.



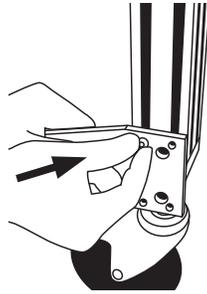
9 Check with bubble level to ensure conveyor is level.

> Repeat for opposite side.

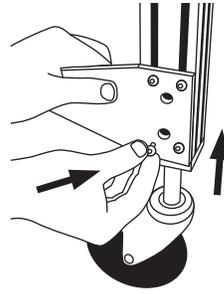
► **Installing Cross Ties**



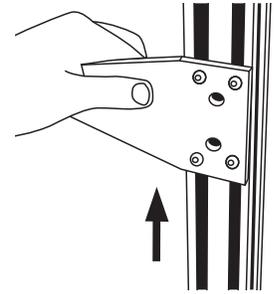
1 Insert drop in nuts into stand leg.



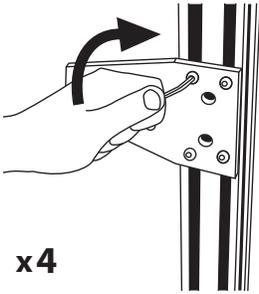
2 Position gusset plates over drop in nuts in leg and insert first two screws.



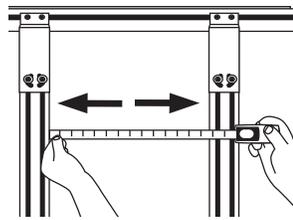
3 Slide up and insert 2 more socket head screws.



4 Slide gusset plate into desired position.



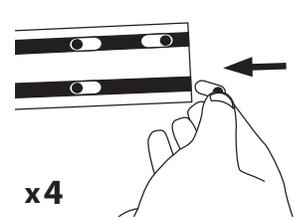
5 Tighten socket head screws.



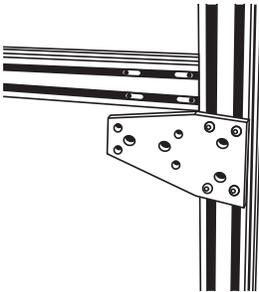
6 Measure distance between stand legs.



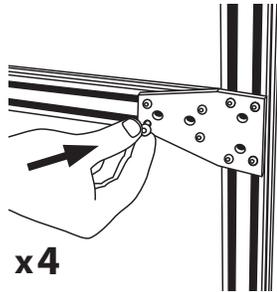
7 Cut cross ties to needed length using appropriate saw and blade. (Electric chop saw recommended)



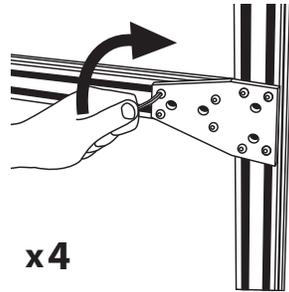
8 Slide cross tie nuts into cross ties.



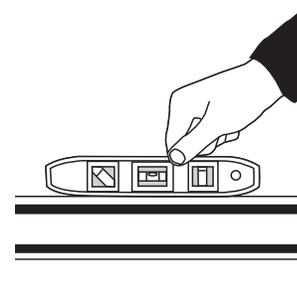
9 Position cross tie behind gusset plate.



10 Insert socket head screws.



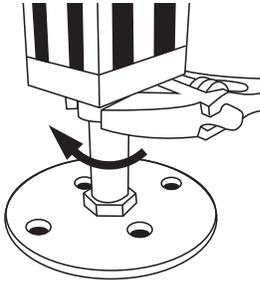
11 Tighten screws to secure cross ties.



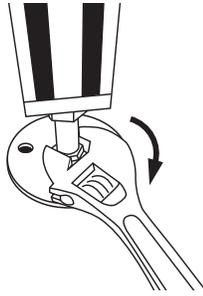
12 Check with bubble level.

> Repeat at opposite end of cross tie and again for opposite side of conveyor.

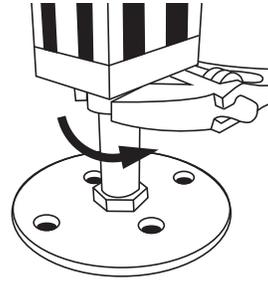
► Adjusting Leveling Feet



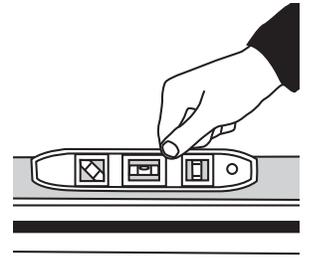
1 Use a large adjustable wrench to loosen hex nut.



2 Rotate the welded nut until desired height is achieved.



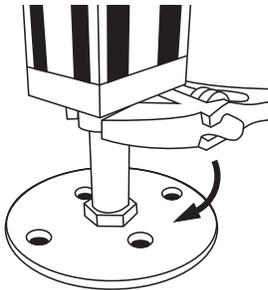
3 Retighten hex nut to secure it in position.



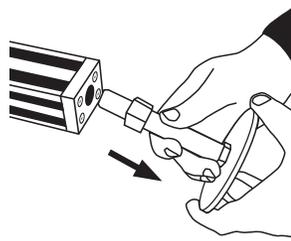
4 Check with bubble level to ensure conveyor is level.

⚠ Injury is possible if stands are not lagged to floor, cross ties are not used, or angle braces are not present. Never place a conveyor in operation until all proper mounts are installed and secured.

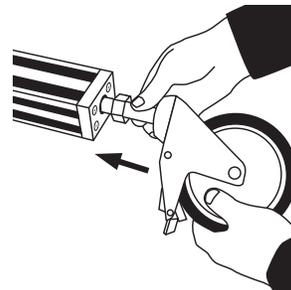
► Installing Casters



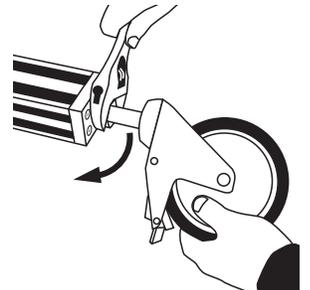
1 Loosen hex nut on leveling foot.



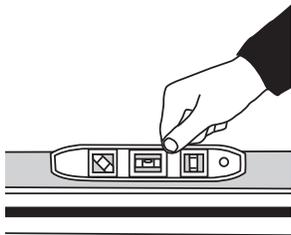
2 Unscrew and remove leveling foot from stand.



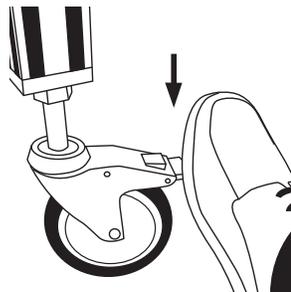
3 Thread caster stem into base of stand leg.



4 Tighten hex nut after caster is adjusted to ideal height.



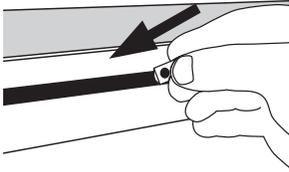
5 Use a bubble level and check measurements to ensure proper frame alignment.



6 Engage caster's swivel lock/brake before use.

⚠ **Warning:** Moving conveyors with casters can create dynamic forces that could tip conveyor. Use caution when moving a conveyor with casters.

Mount Installation

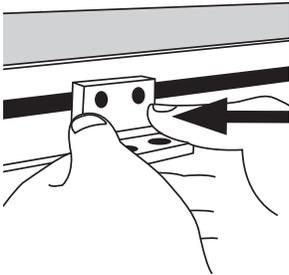


x2

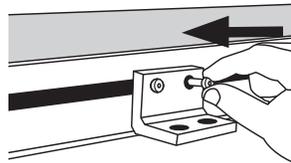
1 Insert drop in nuts into t-slot in desired mount location.

> Proceed to correct mount type.

► Flush Mount

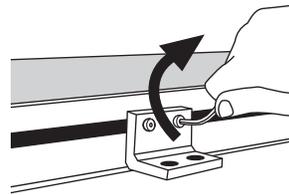


1 Align mount to drop in nuts.



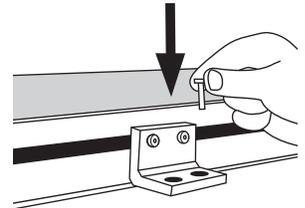
x2

2 Insert socket head cap screws through mount and into drop in nut.



x2

3 Tighten screws to secure mount to frame.

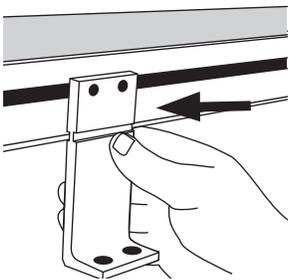


x2

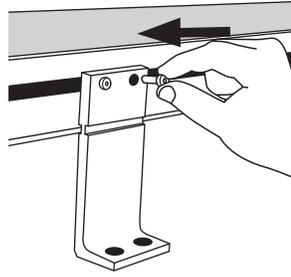
4 Insert screws (not provided) into desired mounting surface and tighten.

► Raised Mount

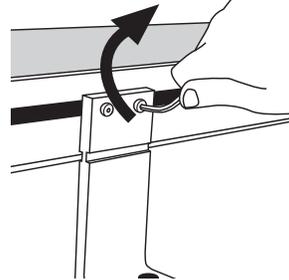
Mount's foot can be placed facing inward or outward depending on application.



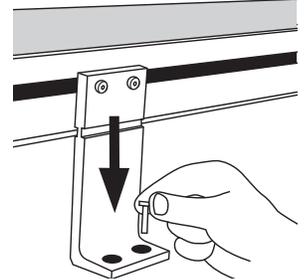
1 Align mount to drop in nuts.



2 Insert socket head cap screws through mount and into drop in nut.



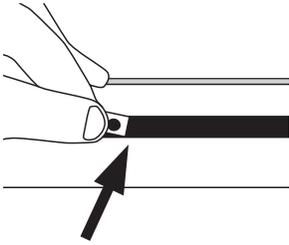
3 Tighten screws to secure mount to frame.



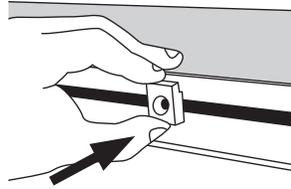
4 Insert screws (not provided) into desired mounting surface and tighten.

Side / Guide Installation

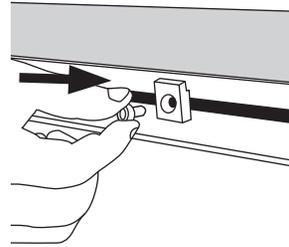
► Installing Fixed Side Rails



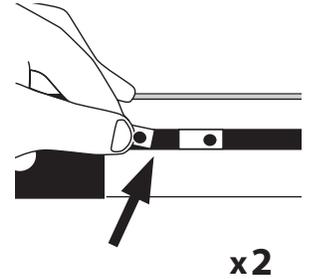
1 Insert drop in nuts into t-slot on frame.



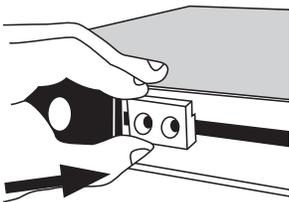
2 Align guide brackets with drop in nuts.



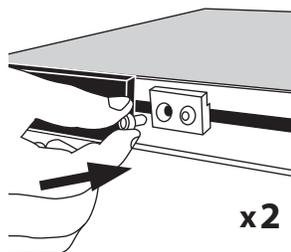
3 Insert socket head cap screw through guide clamp and into drop in nuts.



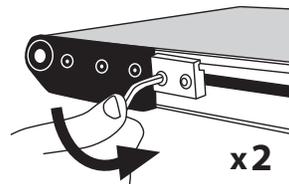
4 Insert two drop in nuts into t-slot at tail end of frame.



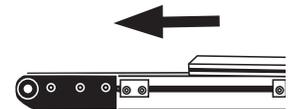
5 Align clamping block to drop in nuts.



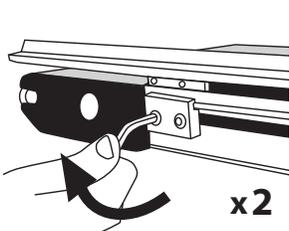
6 Insert screws through clamping block and into drop in nuts.



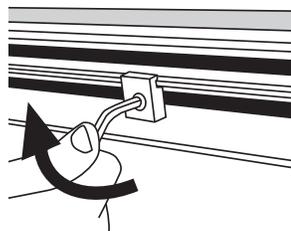
7 Loosen tracking block screws. (Do not remove)



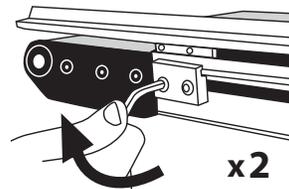
8 Slide guide rail in between clamps and frame until in place.



9 Tighten screws in clamping blocks.

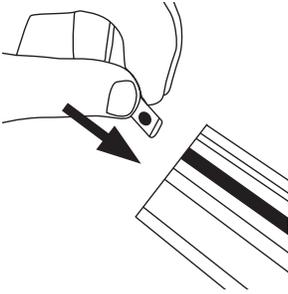


10 Tighten screws in guide clamps.

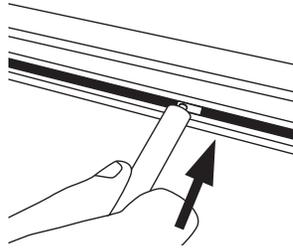


11 Retighten screws in tracking block.

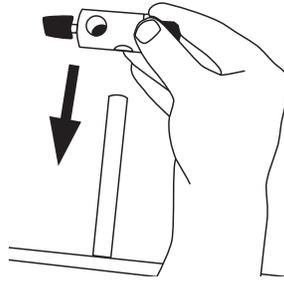
► **Installing Adjustable Guide Brackets**



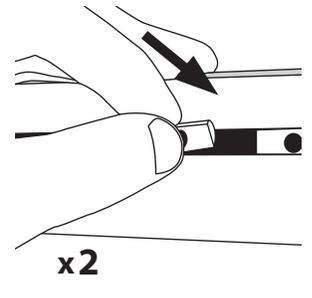
1 Insert economy nuts into t-slot of guiderail and slide into position



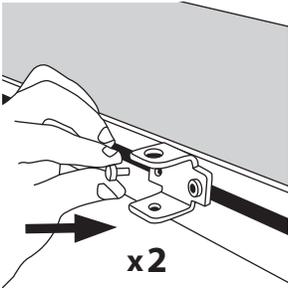
2 Loosely thread adjusting rod into nuts.



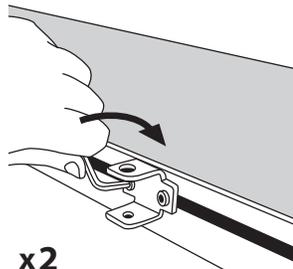
3 Place a cross block onto each guiderail and set aside.



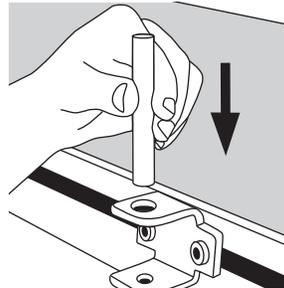
4 Insert drop in nuts into t-slot on frame.
x2



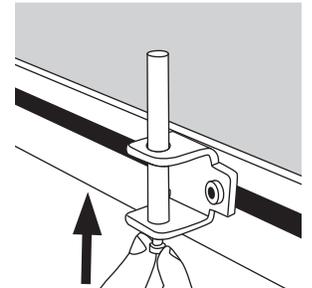
5 Align guide bracket, keeping the larger hole up, with drop in nuts and insert screws.
x2



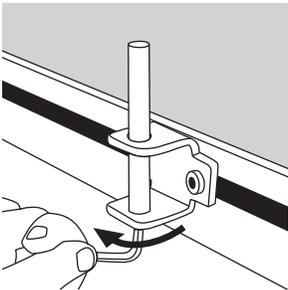
6 Tighten socket head cap screws.
x2



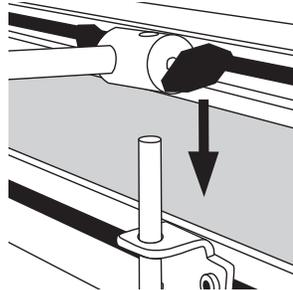
7 Insert a rod vertically through the larger hole on top of guide bracket.



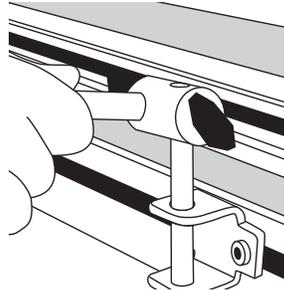
8 Secure rod from below with socket head cap screw.



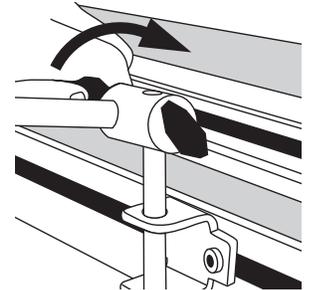
9 Tighten cap screw.



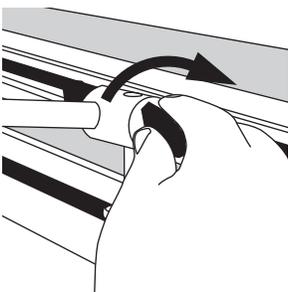
10 Slide guiderail assembly over vertical rods on frame.



11 Adjust guides to desired width and tighten rods.



12 Tighten screw on cross block to secure rod.



13 Adjust guide to desired height and tighten screw on crossblock to secure. (Guide should NOT touch belt)

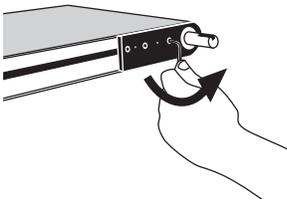
Drive Packages

 Conveyor may tip after motor is installed if feet are not properly lagged to floor if outriggers are not installed.

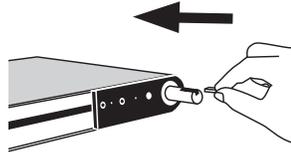
 QC Industries recommends that all wiring be completed by a certified electrician to ensure correct installation. Refer to documentation contained in the motor's box for instructions on electrical connections.

► Side Drive Mounting Package

The Drive Package will ship separate from the conveyor with the speed reducer attached, and the speed reducer's coupler already attached to its shaft. For Standard Duty Drives the speed reducer and motor will ship installed on the drive mounting package.



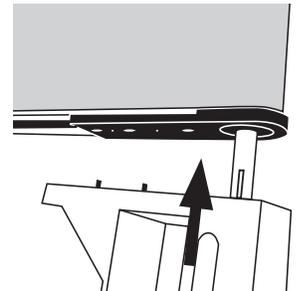
1 Remove and discard three cap head screws from drive side bearing block. (Leave bearing block in place)



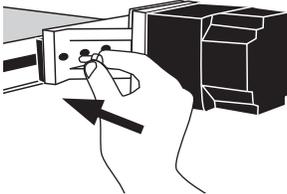
2 Install 4mm x 14mm key to shaft. (Shipped with mounting package)



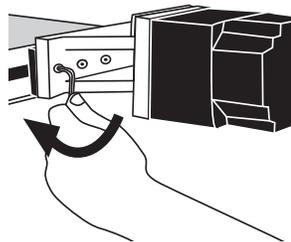
3 Using a flathead screwdriver, stake key. This will stop it from sliding



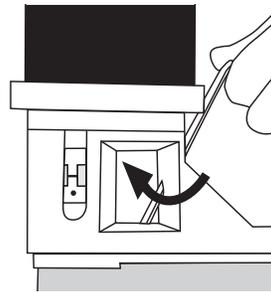
4 Align pins to bearing plate and slide mounting package over pulley's shaft against bearing plate.



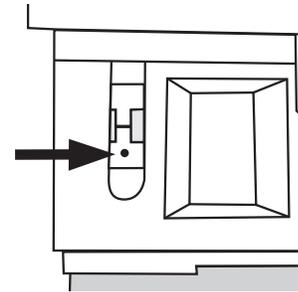
5 Insert three socket head cap screws.



6 Tighten two socket head cap screws.



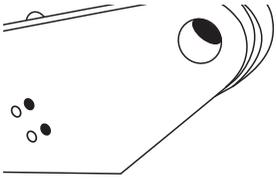
7 The third socket head cap screw will need to be tightened at an angle through access points using a ball head allen wrench.



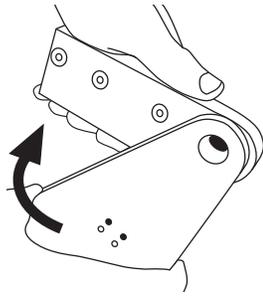
8 Ensure set screws on couplings are tight. (Belt may need to be rotated to reveal set screws in window)

► Pivot Drive Mounting Package

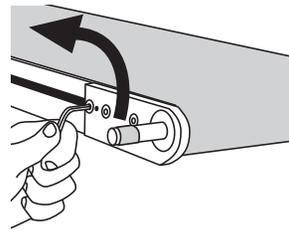
The Drive Package will ship separate from the conveyor. For Standard Duty Drives the speed reducer and motor will ship installed on the drive mounting package.



1 Loosen two set screws in drive mounting plate.

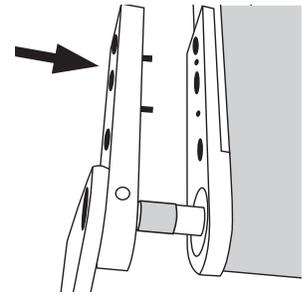


2 Rotate drive mounting plate into workable position.

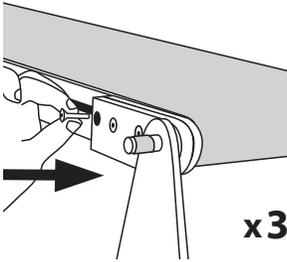


x3

3 Remove and discard three socket head cap screws from drive side bearing plate. (Do not remove bearing plate)

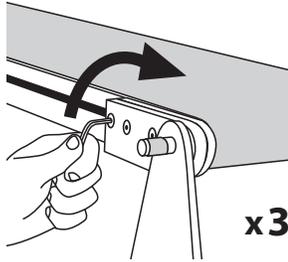


4 Align pins on mounting plate to holes on bearing plate and slide assembly over shaft.



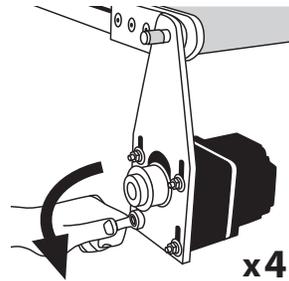
x3

5 Install flat head screws into countersunk holes.



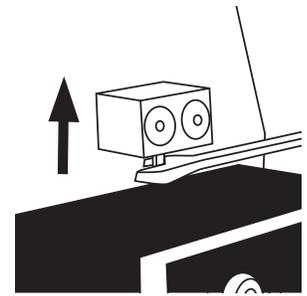
x3

6 Tighten screws in countersunk holes.

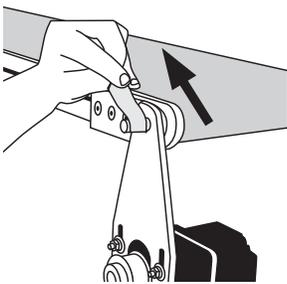


x4

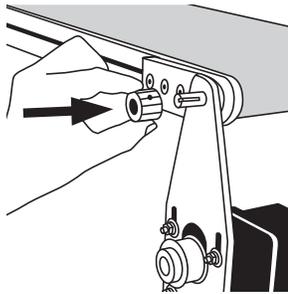
7 Loosen four hex nuts holding gearbox in position.



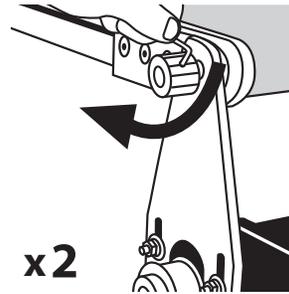
8 Tighten jacking screw to allow gearbox to move toward conveyor.



9 Remove tape holding key in place. (Do not remove Key)

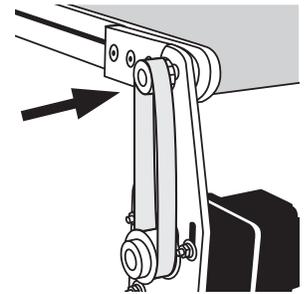


10 Slide top sprocket onto conveyor's output shaft and key.



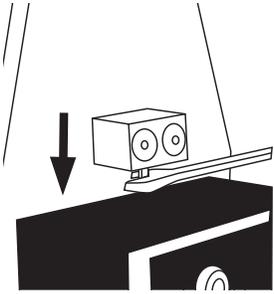
x2

11 Tighten set screws to secure top sprocket.

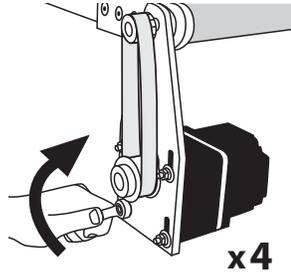


12 Install timing belt over sprockets.

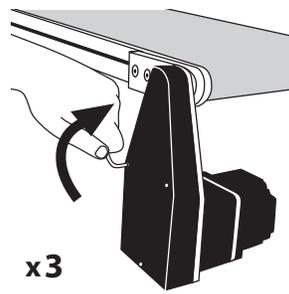
► **Pivot Drive Mounting Package (continued)**



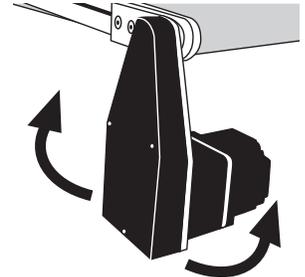
13 Run jacking screw out to create tension on belt.
(Approximately 6lbs of force to deflect one span of belt .09")



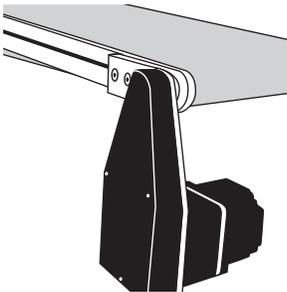
14 Retighten four hex nuts.



15 Replace guard and secure in place with socket head cap screws.



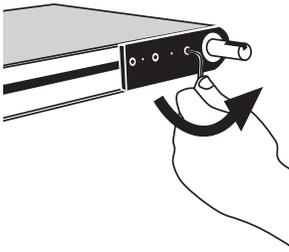
16 Rotate pivot drive into desired position for operation.



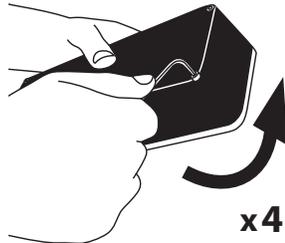
17 Retighten set screws to secure pivot drive in place.

► Heavy Duty Top/Bottom Drive Mounting Packages

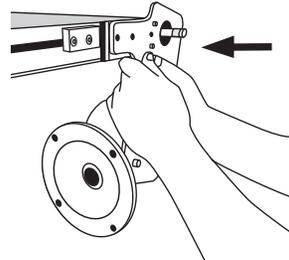
The Drive Package will ship separate from the conveyor. For Heavy Duty Drives, the motor is always shipped in its own box; the right angle speed reducer will be attached to the drive mounting package.



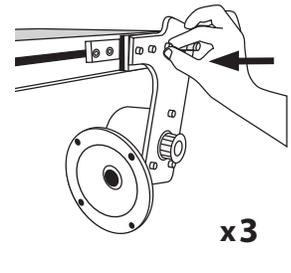
1 Remove and discard three socket head cap screws from drive side bearing plate. (Do not remove bearing plate)



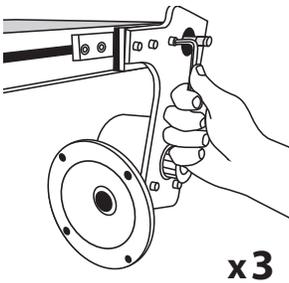
2 Remove four socket head cap screws from guard and remove guard.



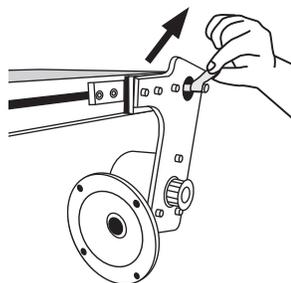
3 Mount drive package over drive mounting plate.



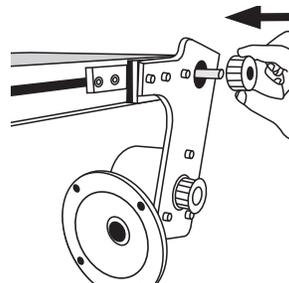
4 Align mounting holes and install three socket head screws.



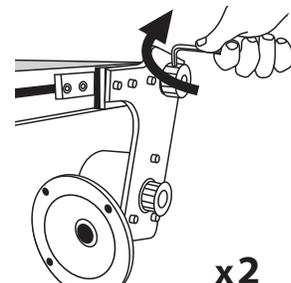
5 Tighten three socket head screws.



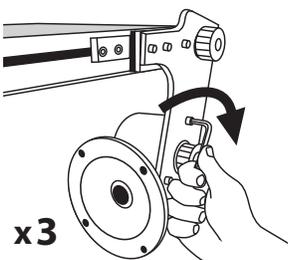
6 Remove nylon tape holding key in place (do not remove key).



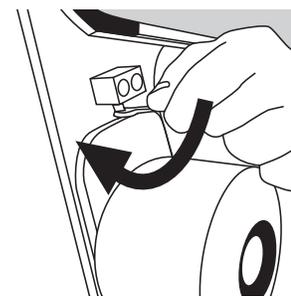
7 Slide top sprocket onto conveyor's output shaft and key.



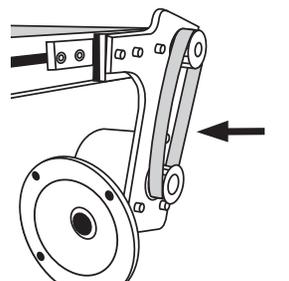
8 Tighten set screws to secure in place.



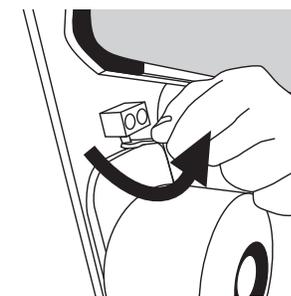
9 Loosen three socket head cap screws holding speed reducer in position.



10 Tighten jacking screw so speed reducer can move toward conveyor.

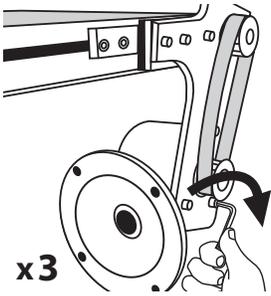


11 Install timing belt over sprockets.

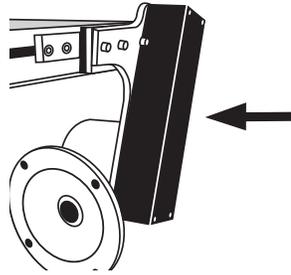


12 Run square head screw out, moving speed reducer away from conveyor and creating tension on belt.

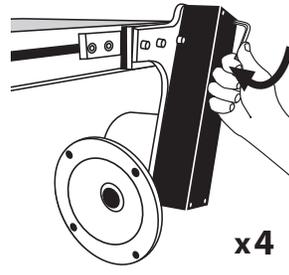
► **Heavy Duty Top/Bottom Drive Mounting Packages (continued)**



13 Retighten three socket head cap screws.

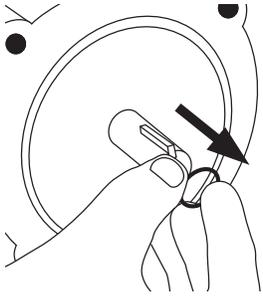


14 Replace guard.

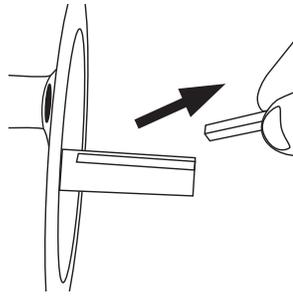


15 Insert and tighten four socket head cap screws.

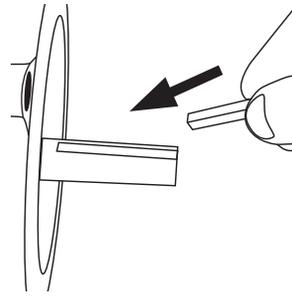
► **Install Heavy Duty Motor to Speed Reducer**



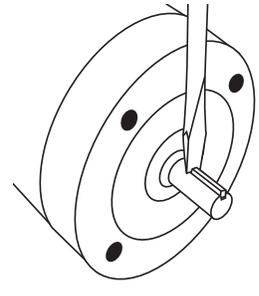
1 Remove ring holding key in place.



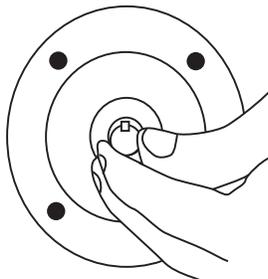
2 Remove and discard key that is included with motor.



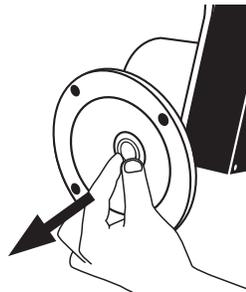
3 Install Leeson speed reducer key to keyway on motor.



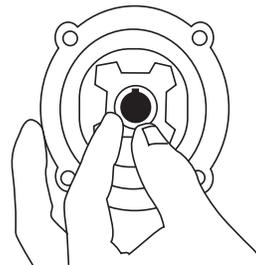
4 Lightly strike just behind the key with a screwdriver and hammer.



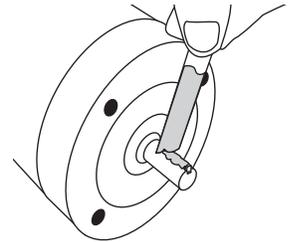
5 Rotate keyway on motor to 12 o'clock position.



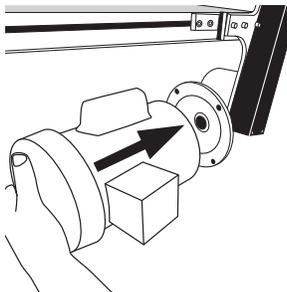
6 Remove plug from speed reducer.



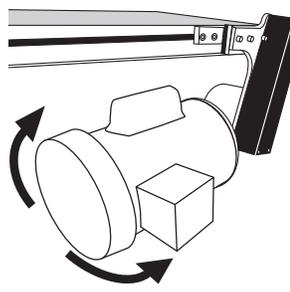
7 Rotate quill pin on speed reducer so that keyway is in 12 o'clock position.



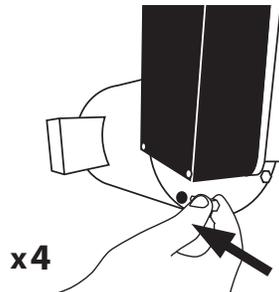
8 Apply anti-seize compound to speed reducer input quill and motor shaft.



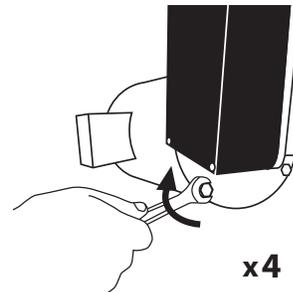
9 Install motor onto speed reducer.



10 Rotate motor so workbox is in desired position.



11 Install 4 hex head screws.



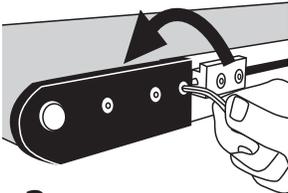
12 Tighten 4 hex head screws to secure.

Maintenance

Belt Tracking

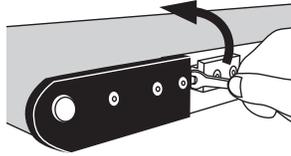
> For best results, make adjustments to only one side.

► Belt Tracking at Drive End

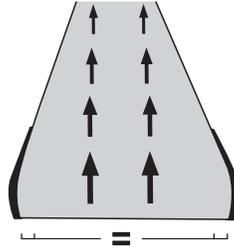


x3

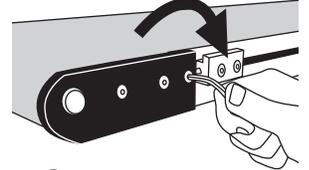
1 Loosen three driver assembly screws on each side of bearing block.



2 With conveyor running, rotate square head tracking screw toward drive pulley on side where belt is riding too close.



3 Let conveyor make several rotations to ensure belt is tracking properly.

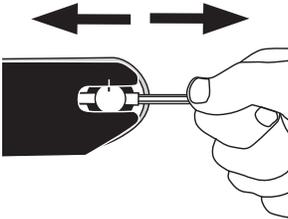


x3

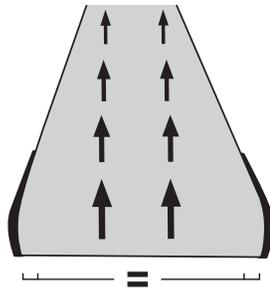
4 Retighten driver assembly screws. (Three on each side)

The Drive End is tracked when the belt can make a full revolution without contacting either bearing plate.

► Belt Tracking at Tail End



1 Rotate adjustment screw to move tail on side where belt is riding too close.



2 Let belt make several rotations to ensure proper tracking.

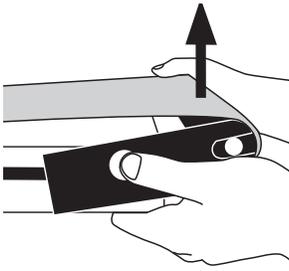
Tail End is tracked when belt can make a full revolution without contacting either side of frame.



To see a video of this process, scan this code on your phone or tablet. You may also visit <http://bit.ly/as40tracking>

Belt Change

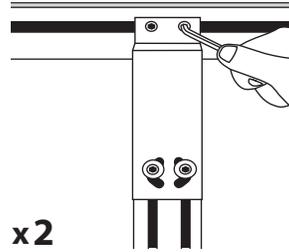
► Removal of Existing Belt



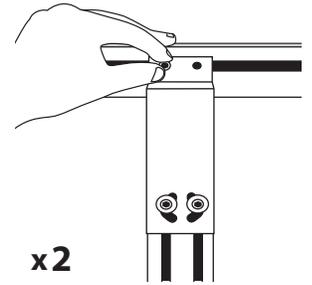
1 Simultaneously push in both buttons to disengage locking mechanism. (Frame end could have sharp edges)



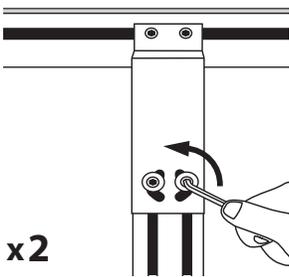
2 Rotate tension release tail assembly up and towards the drive end.



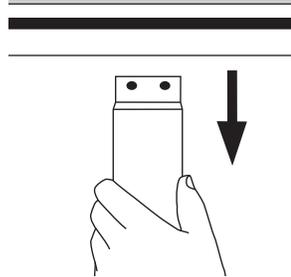
3 Loosen screws on mounts/brackets on opposite side of drive.



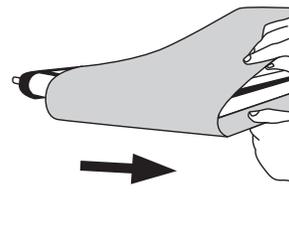
4 Remove screws from stand brackets or mounts. (if stand brackets are not used, proceed to step 7)



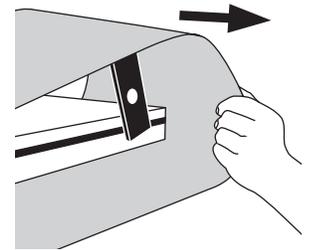
5 Loosen screws on stand. (Do not remove)



6 Slide stand bracket down for clearance.



7 Slide belt sideways to clear drive pulley bearing plate.



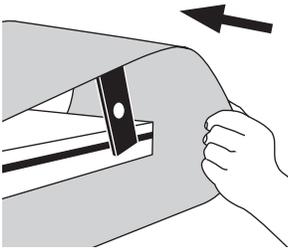
8 Pull belt off of tension release tail.



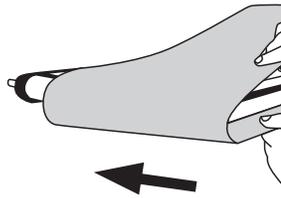
To see a video of this process, scan this code on your phone or tablet. You may also visit <http://bit.ly/as40belt>

► Installation of New Belt

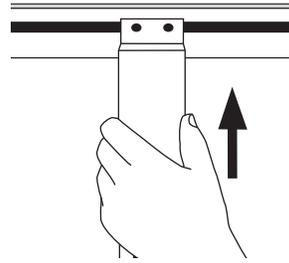
> If stand brackets are not being used, skip steps 3 & 6.



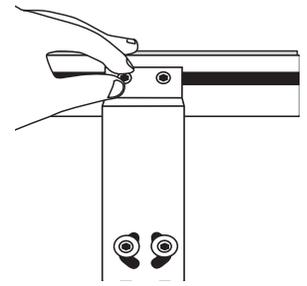
1 Starting at tail end, loop belt over frame and tension release tail assembly.



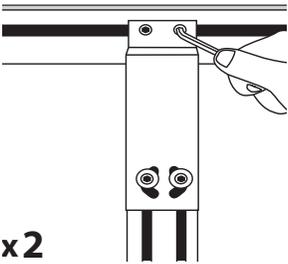
2 Loop belt around conveyor frame towards drive end.



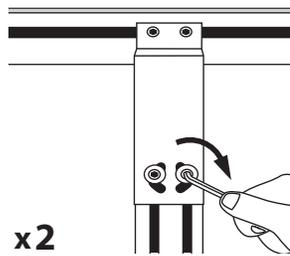
3 Slide frame bracket up to engage conveyor frame.



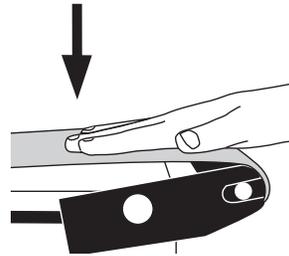
4 Insert screws through bracket or mount used and into frame's drop in nuts.



5 Tighten screws.



6 Tighten screws on stand.

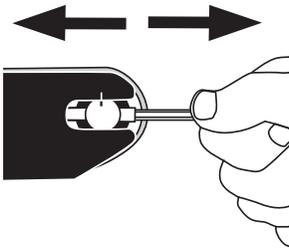


7 Rotate tension release tail assembly down and into the locked position. (Frame end could have sharp edges)

Conveyor is now ready to be tracked. See belt tracking section of manual.

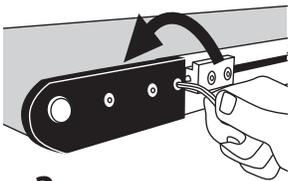
Belt Tensioning

► Belt Tension at Tail End

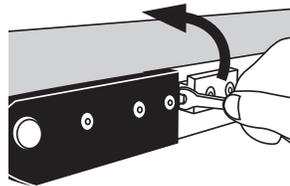


- 1** Adjust the set screws on the tail assembly so the tail pulley assembly moves direction need. (In to relieve tension, out to increase tension) (Adjust both screws the same amount).

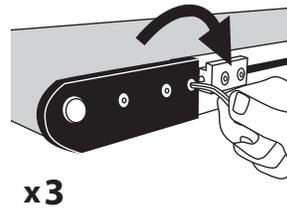
► Belt Tension at Drive End



- 1** Loosen six driver assembly screws in bearing blocks about half a turn.



- 2** Extend the square head tracking screws on both sides of the conveyor until desired tension is achieved (extend screws the same amount).

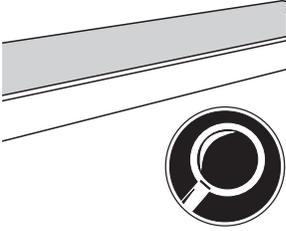


- 3** Retighten six driver assembly screws to lock assembly into position.

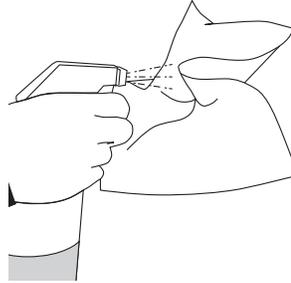
If additional belt tension is needed after following these steps, it is recommended that a new belt be installed.

Care and Cleaning

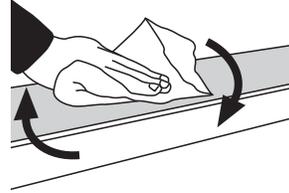
► Belt Care / Cleaning



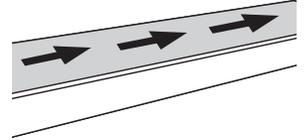
1 Inspect Belt for any fraying or tears and replace if needed.



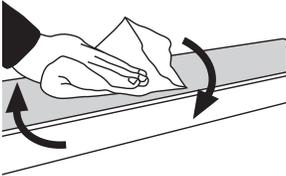
2 Spray proper cleaning solution on a clean rag.



3 Wipe belt with rag.



4 Cycle conveyor to reveal opposite side of belt.

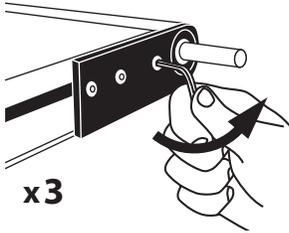


5 Wipe belt with rag.

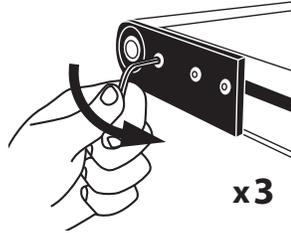
Bearing & Pulley Replacement

► Bearing & Drive Pulley Assembly Replacement

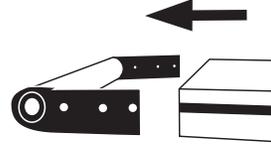
> Remove belt and drive package. (Follow steps for your drive package in Drive Package section of this manual in reverse order)



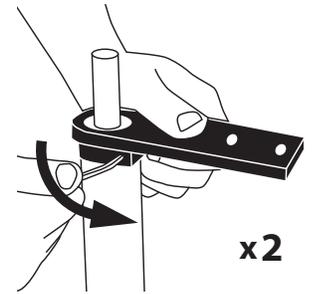
1 Loosen but do not remove three screws holding bearing plate on drive side.



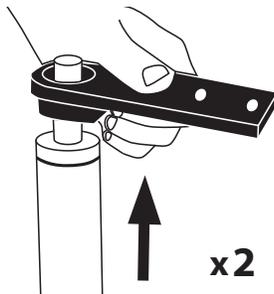
2 Loosen but do not remove three screws holding bearing plate on opposite side of pulley.



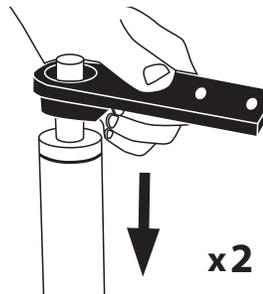
3 Slide bearing plates out of frame.



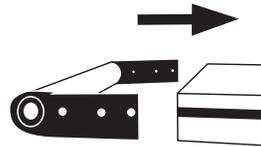
4 Loosen set screws in both bearing plates.



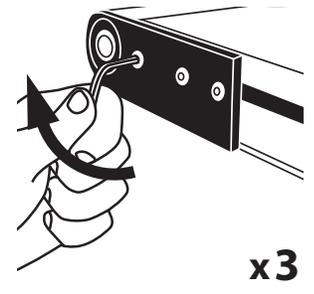
5 Remove both bearing plates from drive pulley.



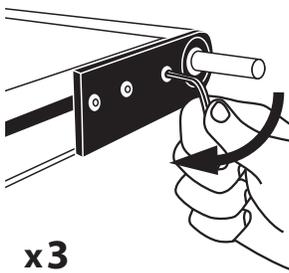
6 Install bearing plates onto new drive pulley.



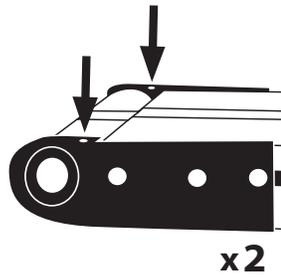
7 Slide pulley back into frame.



8 Install and tighten three set screws on one bearing plate.



9 Install final three screws on opposite bearing plate.



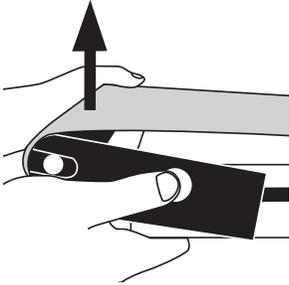
10 Align pulley's V-Guide with V-Guide in frame and tighten set screws on both bearing plates.

> Re-install belt and drive package. (Follow steps for your drive package in Drive Package section of this manual)

If tensioning adjustment is needed, refer to belt tensioning section of this manual.

If tracking adjustment is needed, refer to belt tracking section of this manual.

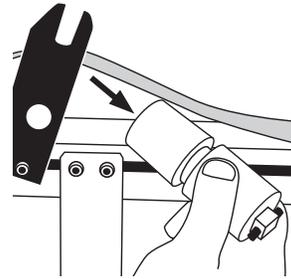
► Tail Pulley Replacement



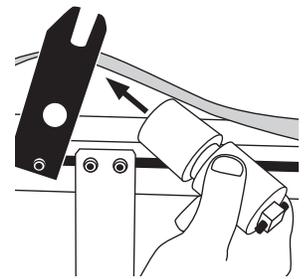
1 Press both tension release buttons and lift up simultaneously.



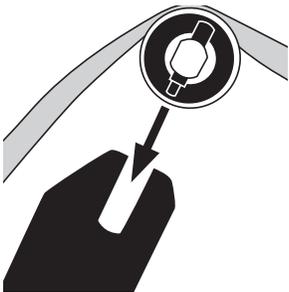
2 Lift idler pulley out of slot.



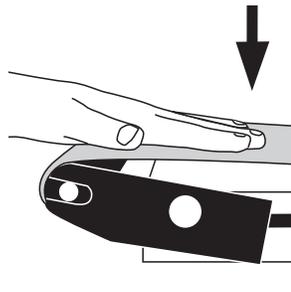
3 Remove Idler pulley from conveyor.



4 Replace with new idler pulley.



5 Making sure to keep dog point of set screw facing down, insert idler pulley back into slot.



6 Press Tension Release tail pulley down until it "Locks" into the locked position.

> Re-tensioning and tracking of belt may be necessary. (Refer to tracking and tensioning sections of this manual.)

Recommended Spare Parts

► Parts List

Part #	Description
1A0039B00WW	Tail Assembly
AE4-WW-LLL-MAE	White Urethane Belt (MVE for V-Guided)
1A0102C	Drive End Bearing Housing LH
1A0103C	Drive End Bearing Housing RH
1A0033A00WW	Underside Idler Roller Full Width
1A0036A	Underside Idler 2" - 6" Wide Stub Roller
1A0037A	Underside Idler 8" - 24" Wide Stub Roller
C-0117-090	Drive Timing Belt (090 for ≤ 50 Sprocket teeth, 100 for ≥ 52 sprocket teeth)
1A0099C00WW	Single Output Drive Pulley and Bearing Assembly
1A0100C00WW	Dual Output Drive Pulley and Bearing Assembly

- > Use the two digit width of the conveyor for "WW".
Use the width and 3-digit length of the conveyor for "LLL".
- > To order parts, please visit QCconveyors.com/serial or call us at +1 (513) 753-6000.

Troubleshooting

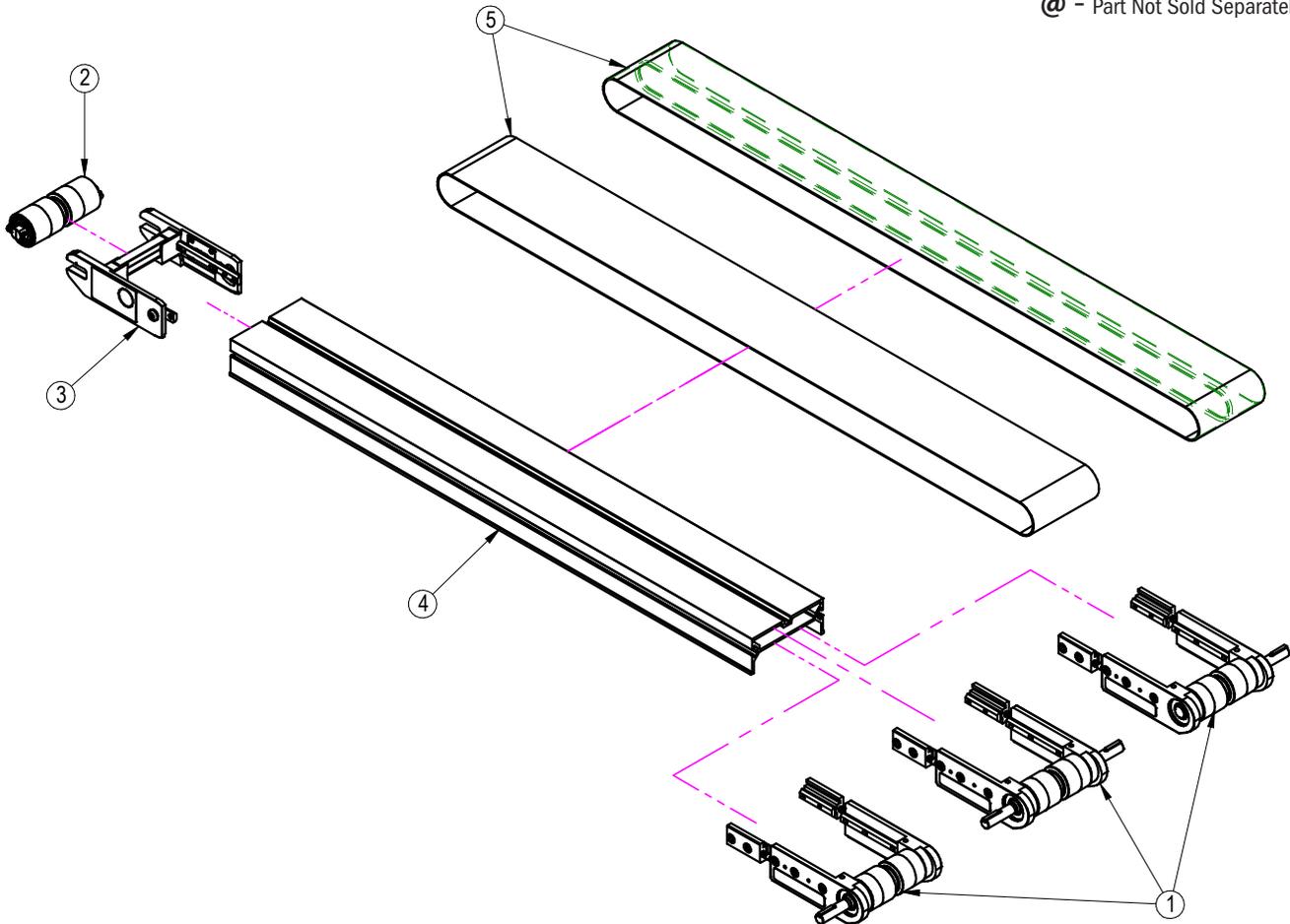
Symptom	Possible Cause	Corrective Action
Belt is slipping or stops under load	Demand is more than the conveyor is rated for	Verify conveyor capacity
	Lubrication between drive pulley and belt	Clean bottom of belt and drive pulley
	Tail pulley assembly not rotated into proper position	Refer to section on tensioning the belt (page 23)
Belt does not move without load	Timing belt under drive guard is not connected	Verify correct installation by referring to drive package section of this manual (page 14)
	Tail pulley assembly not tensioned properly	Refer to section on tensioning the belt (page 23)
Belt will not track at drive end	Accumulation or belt wear	Refer to Belt Tracking section of this manual (page 20)
	Improper tension	Refer to Belt Tensioning section of this manual (page 23)
Belt will not track at tail end	Irregular product loading or belt wear	Refer to Belt Tracking section of this manual (page 20)
	Improper tension	Refer to Belt Tensioning section of this manual (page 23)
Belt is brittle, delaminating or is discolored	Belt is being attacked by chemicals or excessive heat	Contact factory to discuss belt application
	Belt life has expired	Replace belt
	Urethane belts can discolor when exposed to UV light	No corrective action
Motor is hot	Motor can run with a skin temperature of 221°F	No corrective action
	Motor is not protected with overload protection and is drawing too much current.	Install overload protection on motor
Speed reducer is getting hot	Speed reducer can run with skin temperature of 225°F	No corrective action
Speed reducer is leaking oil	Speed reducer's life has expired	Replace speed reducer
	Installation was performed incorrectly and input seal was damaged	Replace speed reducer
Bearing noise	Bearings are damaged or failing	Refer to Bearing Replacement section of this manual (page 25)
Belt is traveling reverse of desired direction	Motor or speed reducer not wired properly	Check wiring and correct per wiring instructions

If you are unable to remedy the problem with these corrective actions, please contact QC Industries Customer Service at (513) 753-6000. Failure to correct the problem may lead to abnormal use of the conveyor, thereby voiding the warranty.

Exploded Views / BoM's

► 2"-12" Wide Automation Series Conveyor

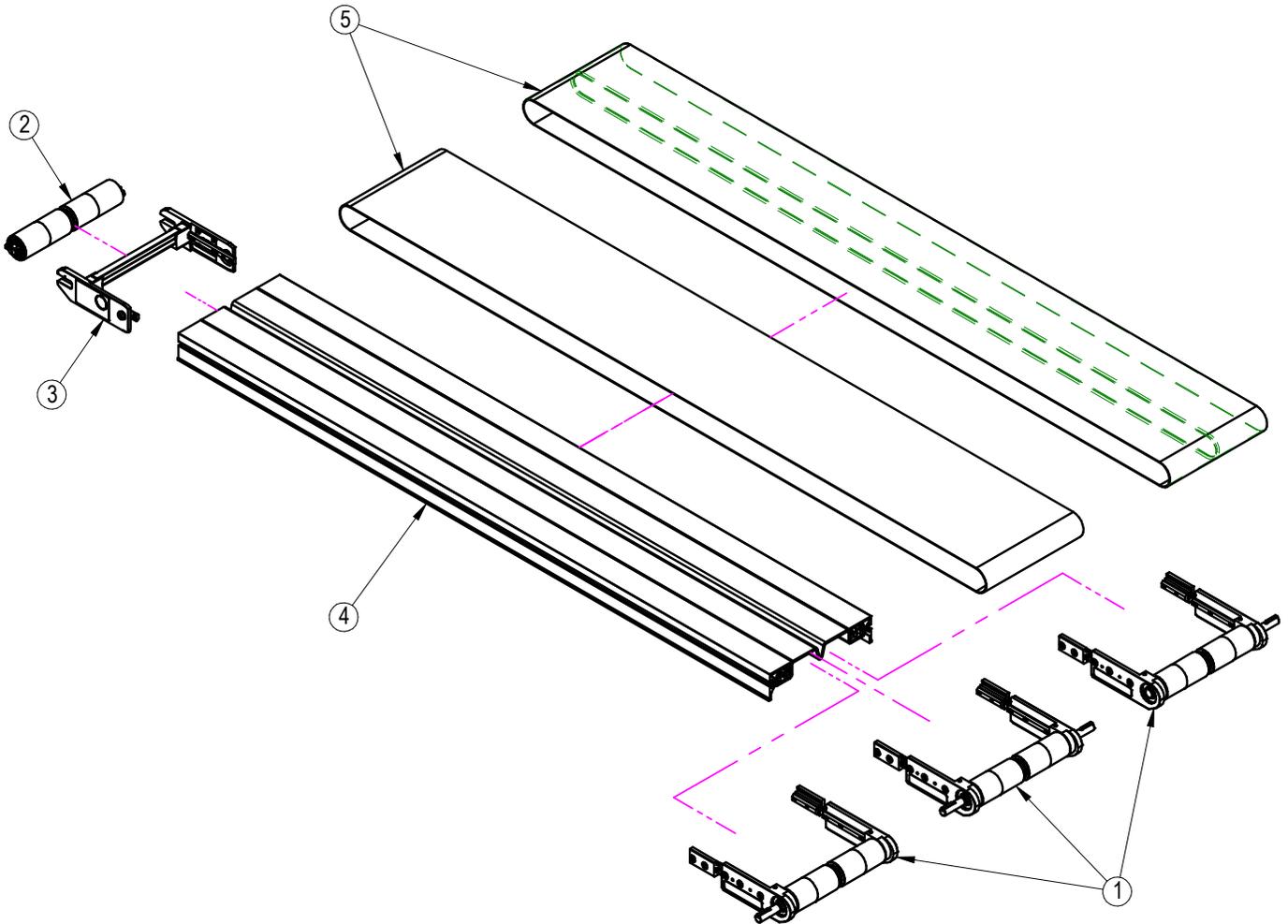
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#	Part #	Description
1	1A0028C00WW	ASSY END DRIVE SINGLE OUTPUT LH
	1A0029C00WW	ASSY END DRIVE SINGLE OUTPUT RH
	1A0031C00WW	ASSY END DRIVE DUAL OUTPUT
2	1A0039B00WW	ASSY TAIL V-GUIDED
3	1A0038A00WW	ASSY TENSION RELEASE TAIL
4	1D0012ALLL	SLIDER BED ALUMINUM EXTRUSION 2" WIDE
	1D0013ALLL	SLIDER BED ALUMINUM EXTRUSION 3" WIDE
	1D0014ALLL	SLIDER BED ALUMINUM EXTRUSION 4" WIDE
	1D0015ALLL	SLIDER BED ALUMINUM EXTRUSION 5" WIDE
	1D0016ALLL	SLIDER BED ALUMINUM EXTRUSION 6" WIDE
	1D0017ALLL	SLIDER BED ALUMINUM EXTRUSION 8" WIDE
	1D0060ALLL	SLIDER BED ALUMINUM EXTRUSION 10" WIDE
	1D0061ALLL	SLIDER BED ALUMINUM EXTRUSION 12" WIDE
5	AE4-WW-LLL-MAE	BELT AUTOMATION SERIES END DRIVE STANDARD
	AE4-WW-LLL-MVE	BELT AUTOMATION SERIES END DRIVE V-GUIDED

► 18"-24" Wide Automation Series Conveyor

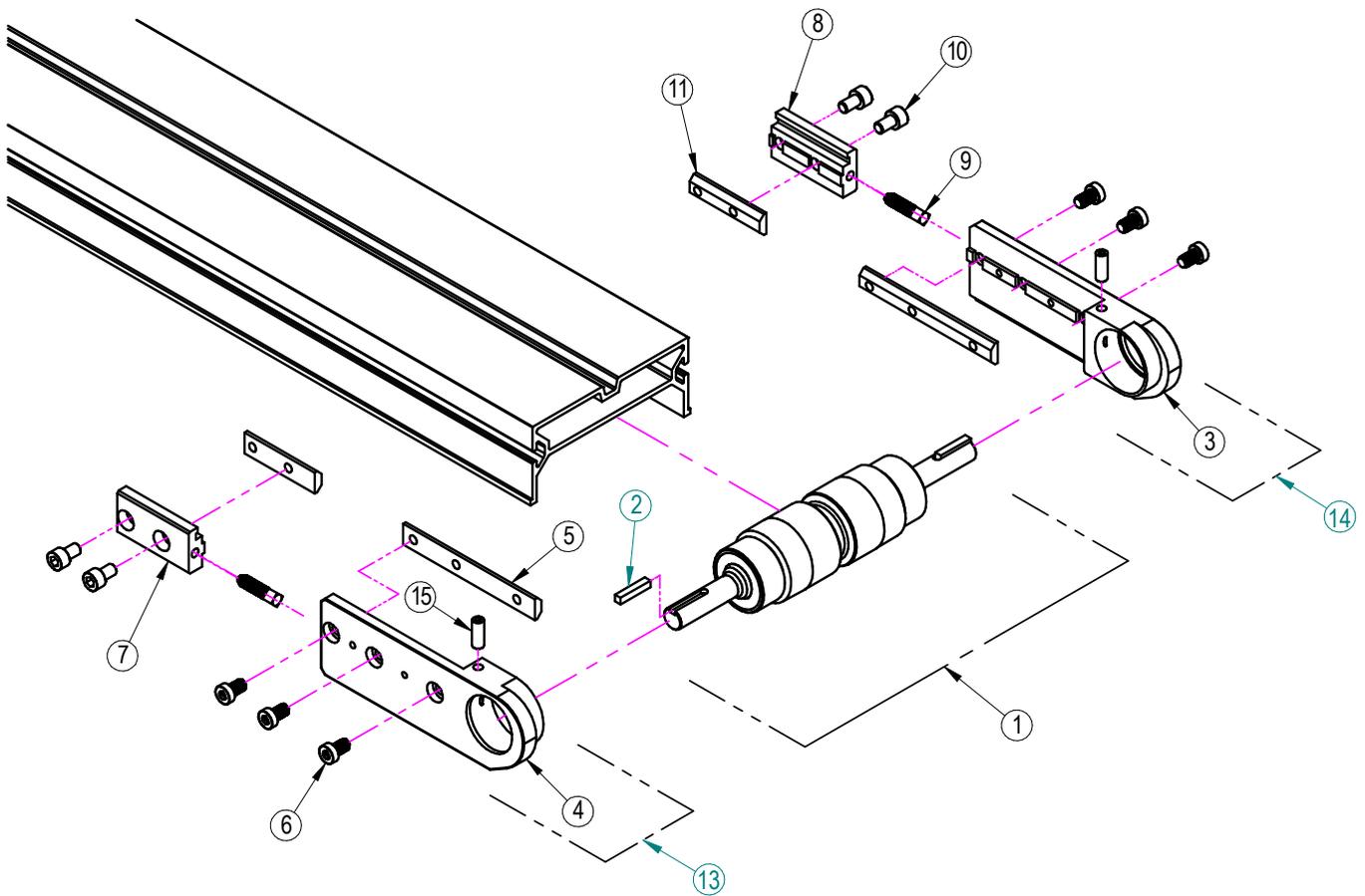
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#	Part #	Description
1	1A0028C00WW	ASSY END DRIVE SINGLE OUTPUT LH
	1A0029C00WW	ASSY END DRIVE SINGLE OUTPUT RH
	1A0031C00WW	ASSY END DRIVE DUAL OUTPUT
2	1A0039B00WW	ASSY TAIL V-GUIDED
3	1A0038A00WW	ASSY TENSION RELEASE TAIL
4	1A0071A-WW-LLL	ASSY MULTI-PIECE FRAME
5	AE4-WW-LLL-MAE	BELT AUTOMATION SERIES END DRIVE STANDARD
	AE4-WW-LLL-MVE	BELT AUTOMATION SERIES END DRIVE V-GUIDED

► Automation Series Dual Output Driver Assembly

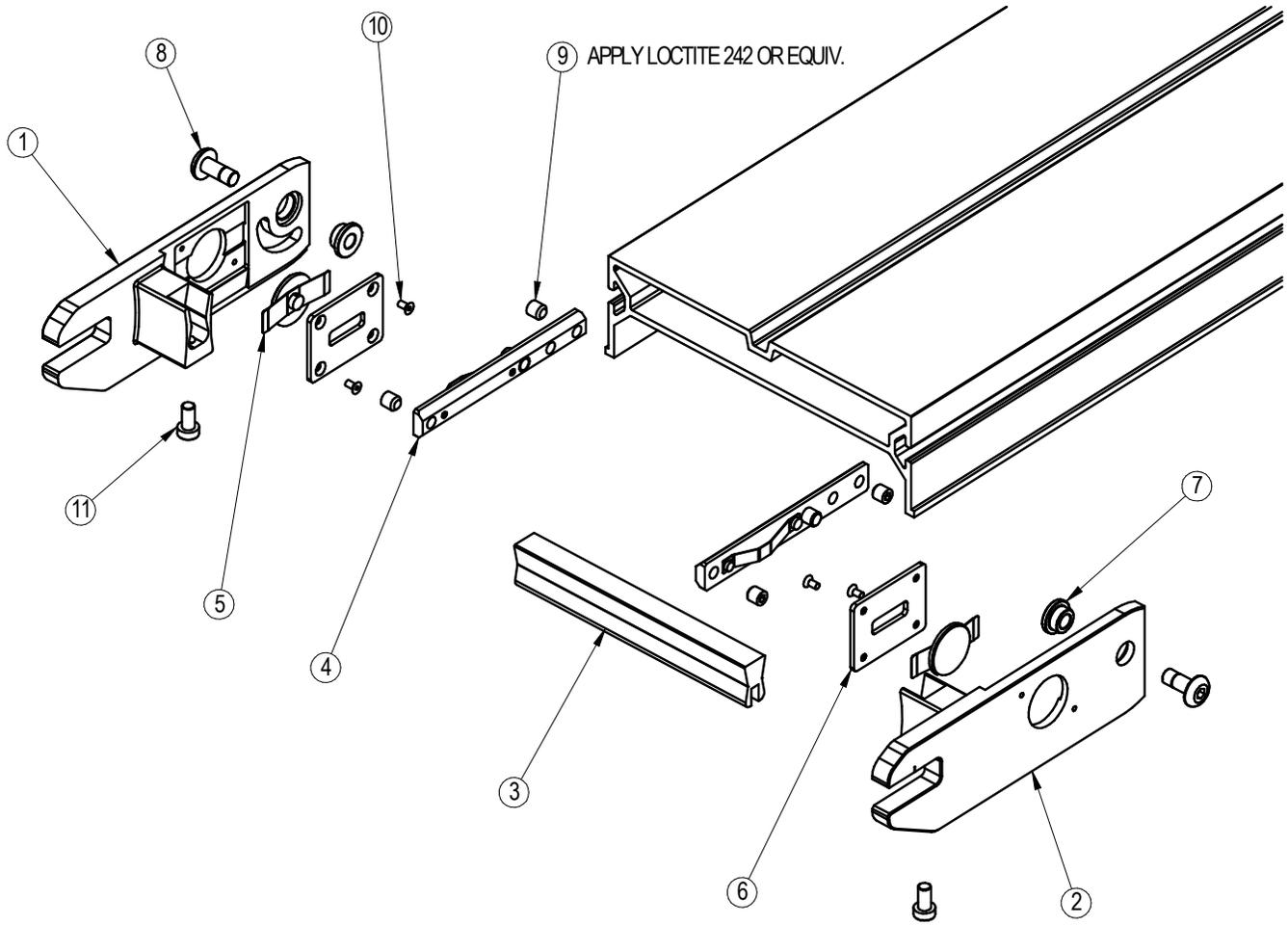
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#	Part #	Description
1	1D0123C00WW	PULLEY END DRIVE DUAL OUTPUT WITH BEARINGS AND KEYS
2	1D0084A	KEY 4MM X 4MM SQ. X 21MM LG.
3	1D0065B	DRIVE BEARING HOUSING RH
4	1D0064B	DRIVE BEARING HOUSING LH
5	1D0080A	ANCHOR BAR BEARING HOUSING
6	SLHCS-M6X100X010-BX	SCREW SOCKET LOW HEAD CAP M6x1.0 10MM LG.
7	1D0125A	BLOCK JACKING LH DRIVE END
8	1D0126A	BLOCK JACKING RH DRIVE END
9	1D0116A	SCREW JACKING SQ. HEAD M6x1.0 20MM LG.
10	SHCS-M06X100X010-ZP	SCREW SOCKET HEAD CAP M6x1.0 10MM LG.
11	1D0124A	ANCHOR BAR JACKING BLOCK
12	1D0317A	BEARING DOUBLE ROW BALL DOUBLE SEAL
13	1A0034C	ASSY BEARING PLATE LH
14	1A0035C	ASSY BEARING PLATE RH
15	SHSS-M06X100X016-ZP	SOCKET HEAD SCREW M6X1.0X16MM LG

► Automation Series Tension Release Tail Assembly

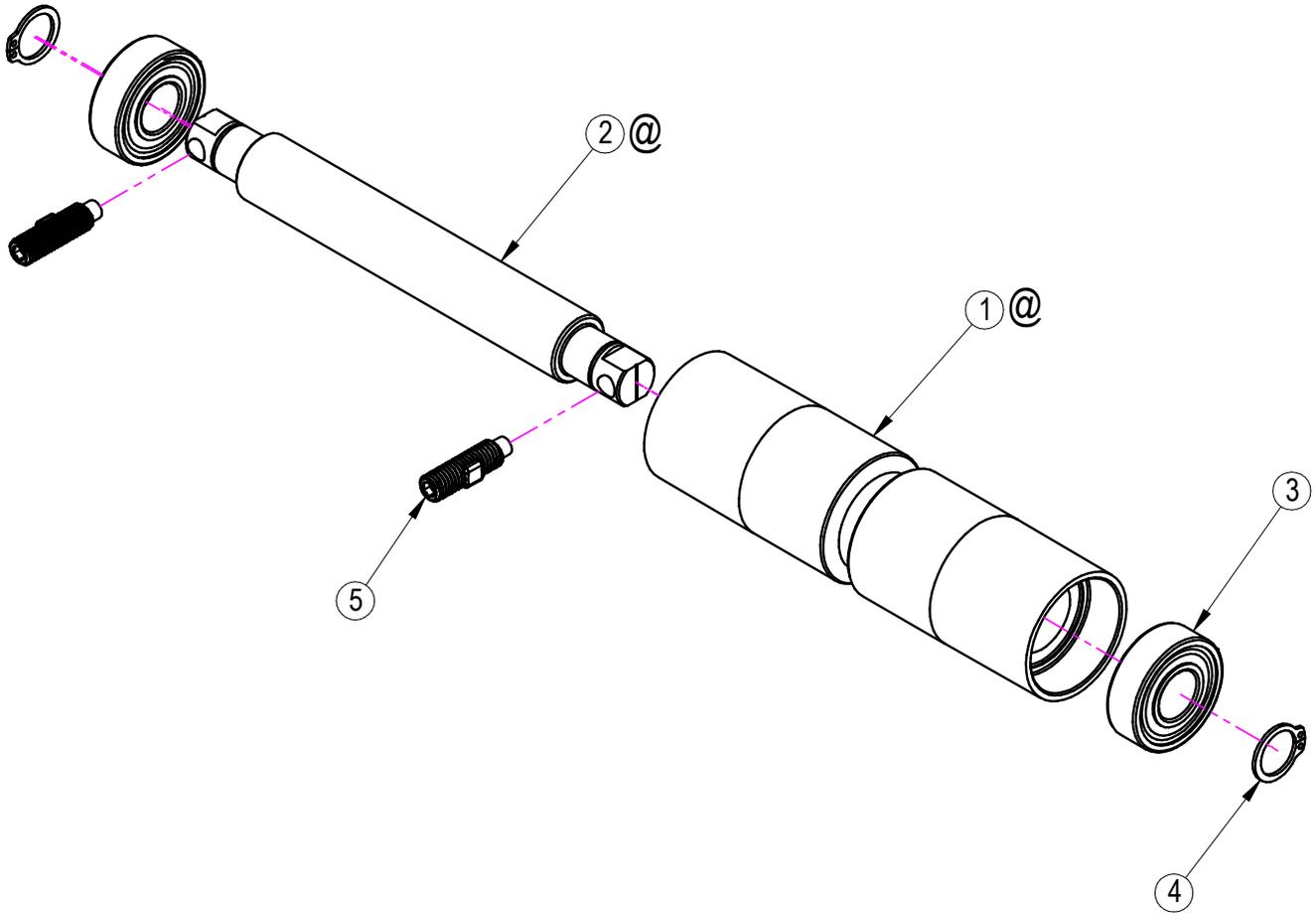
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#	Part #	Description
1	1D0181A	TAIL PLATE RH
2	1D0182A	TAIL PLATE LH
3	1D0172A00WW	TAIL STIFFENER
4	1A0072A	ASSY ANCHOR BAR/TIE SPRING/DOWEL PIN
5	1D0164A	TAIL BUTTON
6	1D0165A	BUTTON RETAINING PLATE
7	1D0168A	BUSHING
8	1D0225A	BUTTON HEAD SHOULDER SCREW
9	SHSS-M06X100X006-ZP	SCREW SOCKET HEAD SET M6x1.0 6mm LG.
10	FHCS-M02.5X045X005-BX	SCREW SOCKET FLAT HEAD M2.5x0.45 5mm LG.
11	SLHCS-M05X080X010-ZP	SCREW SOCKET LOW HEAD CAP M5x0.8 10mm LG.
12	WSHF-M06X12X16-ZP	WASHER FLAT M6

► Automation Series Tail Pulley Assembly

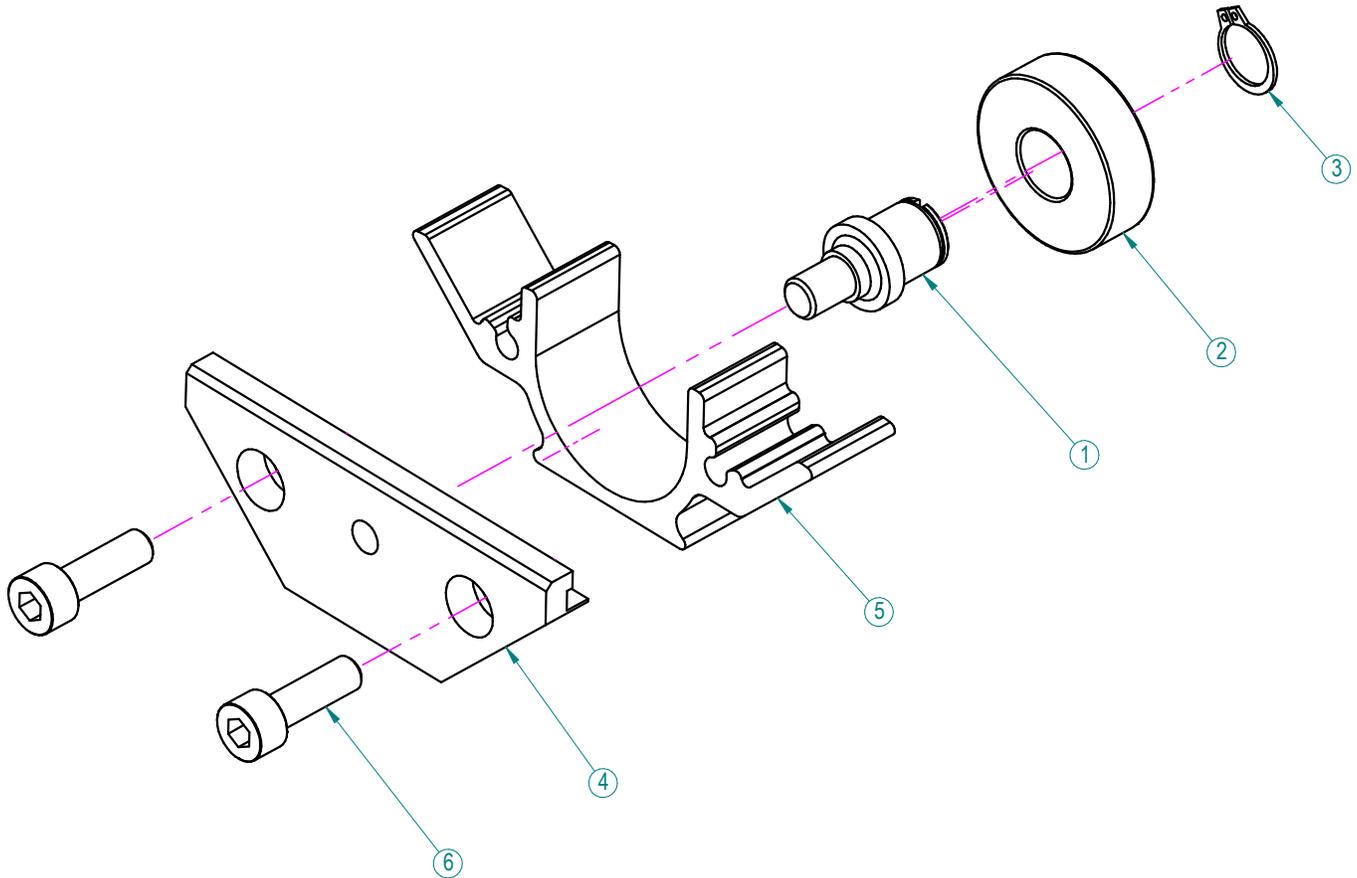
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#	Part #	Description
1	1D0157B00WW	TAIL PULLEY
2	1D0158A00WW	TAIL SHAFT
3	1D0132A	BEARING
4	1D0121A	RETAINING RING
5	SHDSS-M08X125X030-BX	SET SCREW, SOCKET HEAD, DOG PT, M8X1.25X30 LG

► Automation Series 2"-6" Wide Stub Underside Idler Assembly

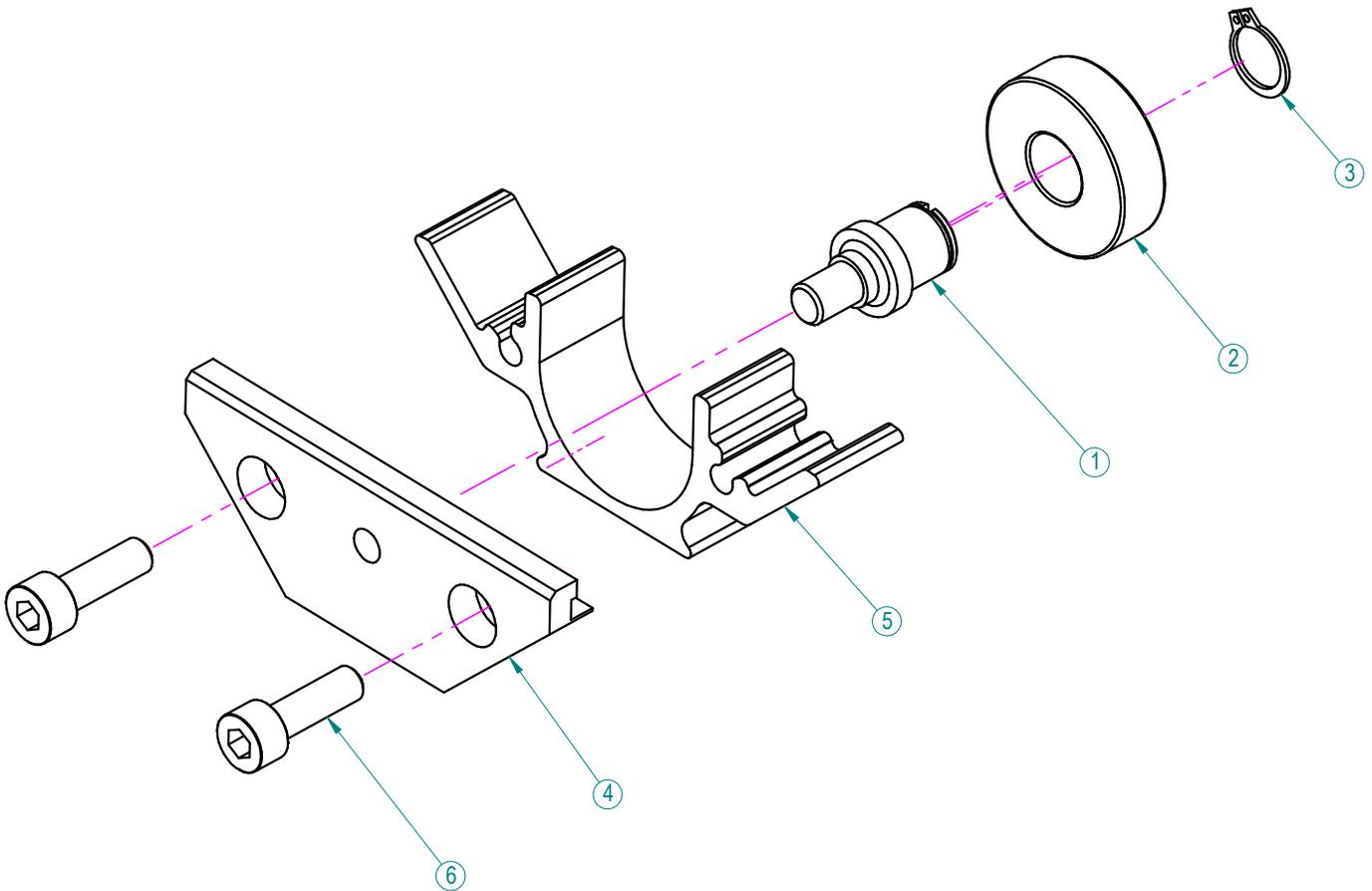
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#	Part #	Description
1	1D0152A	SHAFT STUB UNDERSIDE IDLER 2"-6"
2	43-0050-51	BEARING UNDERSIDE IDLER STUB
3	43-0050-52	RETAINING RING
4	1D0151A	CLAMP UNDERSIDE IDLER STUB
5	1D0148A	GUARD UNDERSIDE IDLER STUB 2"-6"
6	SHCS-M05X080X016-ZP	SCREW SOCKET HEAD CAP M5x0.8 16mm LG.

► Automation Series 8"-24" Wide Stub Underside Idler Assembly

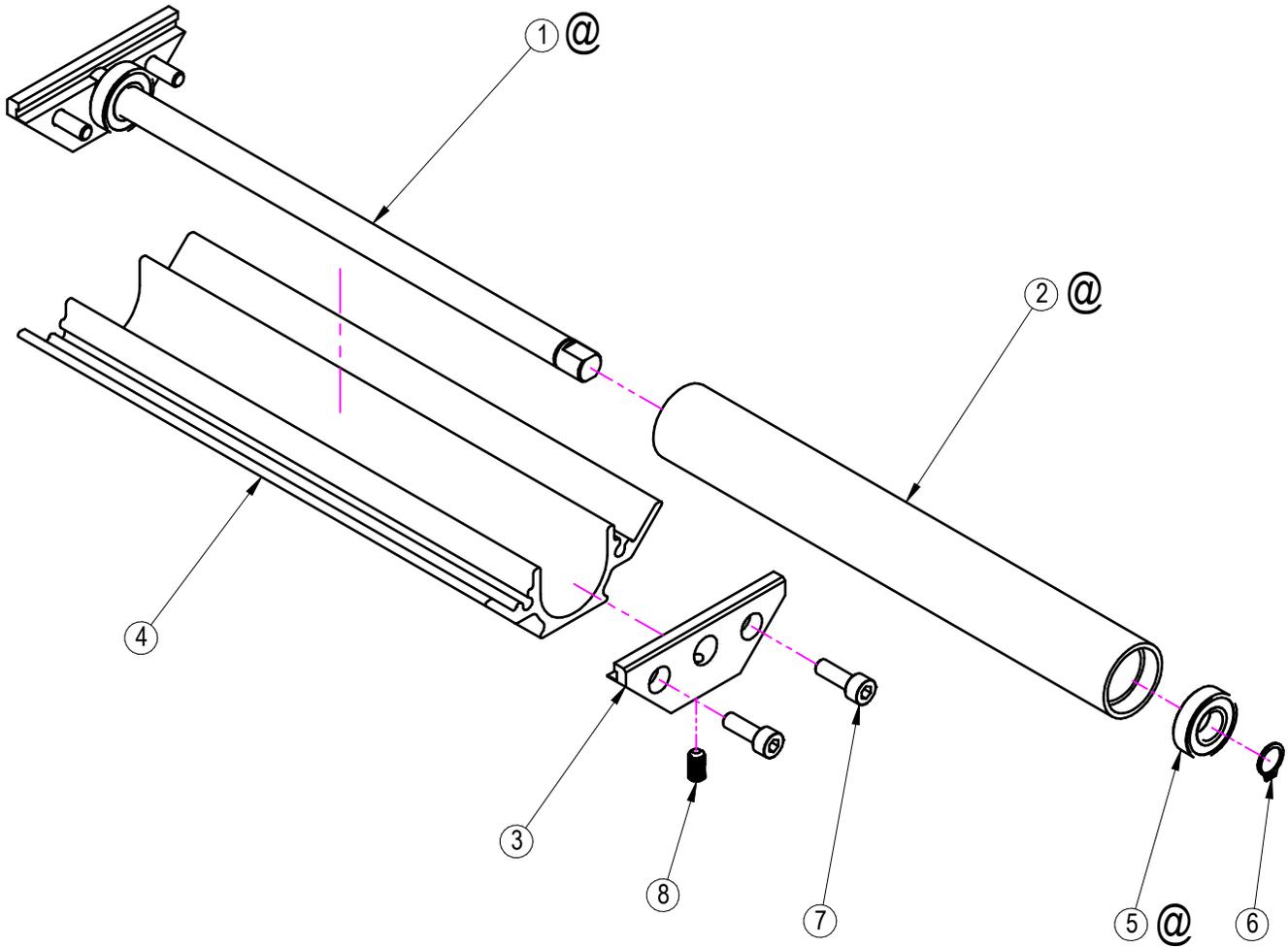
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#	Part #	Description
1	1D0152A	SHAFT STUB UNDERSIDE IDLER 8"-24"
2	43-0050-51	BEARING UNDERSIDE IDLER STUB
3	43-0050-52	RETAINING RING
4	1D0151A	CLAMP UNDERSIDE IDLER STUB
5	1D0148A	GUARD UNDERSIDE IDLER STUB 8"-24"
6	SHCS-M05X080X016-ZP	SCREW SOCKET HEAD CAP M5x0.8 16mm LG.

► Automation Series 8"-24" Wide Full Width Underside Idler Assembly

@ - Part Not Sold Separately



#	Part #	Description
1	1D0215A00WW	SHAFT UNDERSIDE IDLER FULL WIDTH
2	1D0155A00WW	ROLLER UNDERSIDE IDLER FULL WIDTH
3	1D0208A	CLAMP UNDERSIDE IDLER FULL WIDTH
4	1D0155A00WW	GUARD UNDERSIDE IDLER FULL WIDTH
5	1D02040A	BEARING UNDERSIDE IDLER FULL WIDTH
6	43-0050-52	RETAINING RING
7	SHCS-M05X080X016-ZP	SCREW SOCKET HEAD CAP M5x0.8 16mm LG.
8	SHCS-M05X080X10-BX	SCREW SOCKET HEAD SET M5x0.8 10mm LG.

Warranty Information

QC INDUSTRIES warrants that our conveyors are free from defects in materials and workmanship and fit for the ordinary purposes for which such goods are used, under normal installation, use and service for ten (10) years* from date of purchase or 21,000 hours* of running use, whichever is sooner. QC INDUSTRIES will replace any defective part within the warranty period, without charge, provided:

- > The Purchaser gives QC INDUSTRIES prompt written notice of the defect, including the date of purchase and original purchase order number.
- > The Purchaser will then be given a return goods authorization number (RGA#) which must be displayed on all labels and packing slips returned with merchandise. (See Return Policy section)
- > The Purchaser pays for delivery of the defective part to QC INDUSTRIES for inspection and verification of the defect.
- > The Purchaser shall pay any costs of installing the replacement part.

This warranty is limited to the replacement of defective parts. **QC INDUSTRIES WILL NOT BE LIABLE FOR ANY DAMAGES CAUSED BY ANY DEFECT IN THIS UNIT.** This warranty shall not apply if any failure of this unit or its parts is caused by unreasonable use, lack of maintenance, improper maintenance and/or repairs, incorrect adjustments, exposure to corrosive or abrasive material, damage causing moisture, or any modification or alteration affecting the operation of the unit which is not authorized by QC INDUSTRIES in writing. This warranty shall not apply to the following items that are covered by their manufacturer's warranty, subject to any limitation contained in those warranties.

- > Bearings
- > Motors
- > Reducers
- > Controllers
- > Casters
- > Belts (unless otherwise agreed to in writing)

CAUTION: Any attempt to repair such items may actually void the manufacturer's warranty. Any description of this unit is only to identify it and is not a warranty that the unit fits the description. Any warranties implied by law are limited in duration to the ten (10) year term of this warranty. EXCEPT AS SET FORTH HEREIN, QC INDUSTRIES MAKES NO OTHER WARRANTIES, WHETHER EXPRESS, IMPLIED, OR STATUTORY, INCLUDING MERCHANTABILITY FOR FITNESS OR ANY PARTICULAR PURPOSE.

*Warranty is five years/10,500 hours without registration at qcconveyors.com/serial.

► Lost or Damaged Goods

Shipments should be inspected immediately upon receipt for lost or damaged goods. Any loss or damage should be noted on the carriers receipt (or bill of lading) at the time of acceptance. If items are perceived to be lost or damaged after the shipment has been accepted, it becomes more difficult to file a claim with the carrier if the receipt does not indicate such loss or damage. Do not, at any time, request the carrier to return any items or shipment to QC Industries without previous authorization from our company for such a return. Please notify QC Industries as soon as any loss or damage is discovered and request the department that handles the lost or damaged goods. You will need to know a complete description of all lost or damaged items. If replacement items are needed, a purchase order made out to QC Industries will need to be supplied. QC Industries will then contact the carrier's local agent and request that an inspection of the items be performed. This is absolutely necessary. Unless an inspection is performed, the carrier will not entertain any claim for loss or damage. After the inspection has been completed, the carrier will notify QC Industries. If the carrier takes responsibility for the claim, a credit will be issued to you for the replacement item(s), including freight charges from QC Industries, where applicable. If the carrier does not take responsibility for the claim, a representative of QC Industries will contact you.

► Return Policy

If, for any reason, an item needs to be returned to QC Industries or an in-house order needs to be canceled or revised, the Purchaser is required to adhere to the following series of steps to ensure that the return or cancellation is handled in the proper manner.

- > Promptly call QC Industries Customer Service at (513) 753-6000 and request a Returned Goods Authorization. At this time, you will be asked to answer pertinent questions relating to the returned items. We ask that you have the following information ready:
 - (A) Name of distributor (if applicable) through which item(s) were purchased.
 - (B) Name of the Customer and/or end user of the item(s).
 - (C) Any/all purchase order numbers related to the item(s) in question.
 - (D) Phone numbers and names of contacts involved in the return (if it becomes necessary that they be contacted later).
 - (E) Complete part numbers of all items involved in the return.
 - (F) Complete description as to the reason for the return and the actions that need to be taken. (If the item is to be replaced, a new purchase order number must be supplied by the Purchaser along with complete shipping and billing instructions. These replacements will be treated as separate orders by QC Industries and evaluated for possible credit only after returned items are received and evaluated.

- > After the call is made to QC Industries, we will process your RGA and you will be e-mailed the RGA number to use for returning the item(s). RGA numbers will not be given verbally over the phone.
- > Upon receipt of your RGA, you are required to return the item(s) within 30 days of receipt of authorization. After 30 days, the Return Authorization will be void if item(s) are not received by QC Industries. All shipping charges and freight insurance charges of returned goods will be the responsibility of the Purchaser.
- > The RGA number must be clearly marked on the outside of all packages. It must also be on any paperwork, packing slips, or delivery receipts. If there is no RGA number visible on the package, the package may be refused and sent back at the Purchaser's expense.
- > After receipt of returned goods, QC Industries will evaluate the item(s) for credit and take the appropriate action. Standard items that are returned in new, resalable condition will be credited for the amount of the purchase less 20%. Full credit will only be issued on items that are considered to be defective at the time of shipment from QC Industries and are evaluated to be under warranty. Please allow 30 days for credits to be issued.

► Order Cancellation / Revision Policy

If it becomes necessary to cancel or revise an order prior to the order being shipped, QC Industries reserves the right to evaluate each order that is to be canceled or revised and determine if any charges are applicable. A 20% restocking charge will apply if an order is assembled and ready to ship prior to its cancellation or revision and the order is totally comprised of standard stock items. If the order contains other than stock items, an evaluation will be made based on the status of the order. Additional charges will be included with the 20% restocking charge if any of the following conditions are met:

- (A) The order contains any items that are considered to be non-stock items and these items have already been produced by QC Industries or one of its suppliers.
- (B) The order contains any items that require special handling or assembly and these processes have been completed.
- (C) The Customer has specified that they will pick-up an order from QC Industries' facility by a predetermined time and that time frame has expired. In this case, QC Industries will make an attempt to notify the Customer. If this cannot be accomplished in a reasonable time, the order will be disassembled and the Customer will be charged a restocking fee and any additional charges based on the orders contents as explained herein.

»» qcconveyors.com/serial

Manuals, Videos, Replacement Parts

» Register today to double your warranty to 10 Years

QC Industries conveyors come standard with a 5 Year manufacturer's warranty, but if you register online we'll double that to 10 Years, giving you the longest warranty in the conveyor industry.



Register today at qcconveyors.com/serial!

While You're There, You'll Have Access to

- » All the installation and maintenance manuals for your product
- » Product-specific videos to guide you through routine maintenance tasks
- » A complete list of replacement parts along with the original bill of materials and exploded views to help you find exactly the right part
- » Easy replacement part quoting



Registration also entitles you to all the benefits of our Conveyor Configurator, where you can configure and quote conveyor systems with help from our engineering-based configuration tools to ensure your conveyor and components will work together perfectly in your application.

