MATERIAL HANDLING SOLUTIONS THAT WORK

Tel: (905) 624-6499 • Fax: (905) 624-0228 • www.weconsystems.com

GRAVITY CONVEYOR OWNERS MANUAL

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GRAVITY
INDUSTRIAL CONVEYORS

INTRODUCTION

Thank you for purchasing a Gravity Conveyor from Wecon Systems. This model is made of the finest materials available and is manufactured in Canada by skilled craftsmen. The conveyor is very easy to operate and to maintain, but we recommend that you read this owner's manual thoroughly before using the conveyor.

This manual provides set-up instructions, safety tips, a parts list and information regarding preventative maintenance, lubrication and general usage. This conveyor is durable and has been designed for a long service life.

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SAFETY WARNINGS

WARNING: DO NOT ATTEMPT MAINTENANCE ON ANY CONVEYOR WHILE IT IS IN OPERATION.

BEFORE STARTING MAINTENANCE

- Read and understand instruction manual and be aware of all warning stickers.
- Know where the emergency stop buttons are located.
- Know or have quick access to emergency telephone numbers in the unforeseen event that an emergency should arise.
- Maintenance functions are to be performed while the conveyor is off. The main power disconnect switch to the conveyor shall be locked out in accordance with proper written lockout procedures. This will prevent anyone from applying power to the system while maintenance personnel are at work.
- NEVER work on a conveyor while it is running unless the maintenance procedure requires the equipment to be running. When a conveyor must be operating to perform the maintenance, allow only properly trained maintenance personnel to work on the conveyor.
- Wear safety glasses when in the proximity of the conveyor.
- NEVER allow personnel with long hair near the conveyor without the use of a protective hair net.

DURING MAINTENANCE

- Do not wear loose clothing, ties or jewelry while servicing or performing maintenance on any conveyor equipment.
- Be aware of hazardous conditions, such as sharp edges and protruding parts.
- When using hoists, cables or other mechanical equipment to perform maintenance, use care to not damage conveyor components.
- Keep area clean. Clean up lubricants and other materials before starting conveyor.

AFTER MAINTENANCE

- Before starting the conveyor after any maintenance has been completed, walk around the equipment and make certain all safety devices and guards are in place, pick up tools, maintenance equipment and clear any foreign objects from equipment.
- Make certain all personnel are clear of the conveyor and made aware that the conveyor is about to be started.
- Only authorized personnel should be permitted to start any conveyor following maintenance or emergency shut-off.
- Never place any part of your body in or on any part of this conveyor while in operation.
- Do not allow anyone to stand on the conveyor.
- Do not allow horseplay around the conveyor.
- Do not remove guards, perform maintenance or clear obstructions without first locking out the main power disconnect switch.

PLEASE RECOGNIZE ALL WARNING STICKERS AND OBEY ANY SAFETY INSTRUCTIONS. WARNING STICKERS ARE PLACED ON THE EQUIPMENT FOR YOUR SAFETY – PLEASE DO NOT REMOVE THEM. CONDITIONS DO EXIST ON ANY CONVEYOR THAT CAN CAUSE INJURY OR DEATH TO PERSONNEL. NO MANUAL CAN COVER ALL THE HAZARDOUS CONDITIONS THAT MIGHT DEVELOP. ALL PERSONNEL INVOLVED IN THE OPERATION OF ANY CONVEYOR EQUIPMENT SHOULD BE CONSTANTLY AWARE OF ANY UNSAFE CONDITIONS AND USE ALL POSSIBLE CARE, ALONG WITH COMMON SENSE AND STRICT ADHERENCE TO ACCEPTED SAFETY STANDARDS TO AVOID INJURY.

GRAVITY ROLLER CONVEYOR

IMPORTANT

Wecon Systems does not warrant parts or components not manufactured by Wecon Systems. The manufacturers of electric motors and controls, air and hydraulic components and certain other items extend warranties, which may or may not be similar to that of Wecon Systems manufactured equipment. Defective material of this type should be reported by the customer to Wecon Systems whose sole responsibility is to notify the vendor of the defective material for action. Wecon Systems will not be responsible for units that have been tampered with or disassembled by anyone other than an authorized representative.

EQUIPMENT DESCRIPTION

GENERAL EQUIPMENT DESCRIPTION

Gravity conveyors are ideal for environments with ever-changing material handling situations. They are ideally suited for shipping, receiving, or packaging and production applications. Gravity conveyors are available in wheel or roller configurations, in a variety of widths and lengths. Conveyor frames can consist of steel, galvanized, or aluminum side channels depending on the type of conveyor. Products are conveyed along the surface of the skate wheel or roller. Depending on the conveyor type, units are uniquely designed for use in operations requiring lightweight moveable sections or alternately, they can be used in permanent installations providing flexibility and adaptability to your work environment.

Gravity conveyors are non-powered and are available in straight and curved sections. They are ideally suited in applications that don't justify the cost of powered equipment. Products can be easily and effortlessly conveyed with minimal operating and maintenance costs. Sections can be pitched so that the product being conveyed moves by gravity or can be installed in a level plain requiring the product to be physically pushed. Gravity conveyors aid the operator by providing the individual with the ability to suit optimum working conditions reducing fatigue.

Gravity conveyors are available in standard 10 ft lengths. Other lengths are available. Longer lengths can be achieved by combining units. Curved gravity conveyors provide the flexibility of going around corners or bends.

Generally any boxes, cartons, packages, and totes with a flat rigid bottom can be conveyed along a gravity conveyor. For optimum conveyance, the conveyor must support the product by a minimum of three axle centers.

GRAVITY WHEEL CONVEYORS

Gravity wheel conveyors operate utilizing a series of 1.9” diameter plastic or steel wheels mounted on 5/16” diameter axles. Spacers are used to locate the wheels in predetermined locations within the bed frame. Wheel patterns are determined by axle spacing and conveyor width. Axle centers range from 1-1/2”, 3”, or 4” depending on the type of product that is being conveyed. For optimum conveyance, the conveyor must support the product by a minimum of three axle centers.

Conveyors are available in several standard widths ranging from 12” (9” B.F.R.) to 27” (24” B.F.R.) overall frame width.

Wecon’s standard gravity wheel conveyors are available with the wheels set high within the frame. When the wheels are set high, the product being conveyed can easily be moved to or from the conveyor. Guard rails are available as an option and can be used to extend the plane of the side channel above the height of the wheels to help contain the product and maintain product centering within the confines of the conveyor.

Frames are welded construction available in standard 10 ft lengths. Other lengths are available. Side channels are formed from 12 gauge steel or 1/8” aluminum x 2-1/2” deep to accommodate the wheels set in this high position.

Gravity wheel conveyors can be supplied in straight and curved sections providing optimum flexibility and adaptability to your work environment. Curved sections are available in radii ranging from 30 to 90 degrees. Products that are conveyed on a wheel curve maintain better orientation because each wheel moves independently with one another. This allows the outer lanes to revolve faster than the inner lanes providing optimum tracking of the product being conveyed.

Adjacent bed sections can be joined together by installing a support directly under a bed joint or in conjunction with optional hook connectors.

Wecon’s gravity wheel conveyors are uniquely designed to convey lightweight packages or for use in operations requiring lightweight portable sections. Alternately, they can be used in permanent installations providing flexibility and adaptability to your work environment. Typically, gravity wheel conveyors utilizing aluminum frame sections are most frequently used in portable applications because of their lightweight, while steel frames are usually preferred in permanent applications.

GRAVITY WHEEL CONVEYOR

LIGHT DUTY GRAVITY ROLLER CONVEYORS

1.4" DIAMETER ROLLER CONVEYORS

Light duty gravity roller conveyors operate utilizing a series of 1.4" diameter x 18 gauge galvanized steel rollers with oiled ball bearings. Roller axles are 5/16" hex spring loaded. Axle centers range from 1-1/2", 2", 3", 4-1/2", 6", 9" or 12" depending on the type of product that is being conveyed. For optimum conveyance, the conveyor must support the product by a minimum of three rollers.

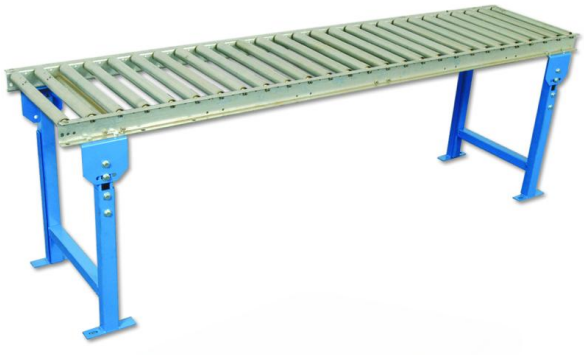
Conveyors are available in several standard widths ranging from 12" (9" B.F.R.) to 27" (24" B.F.R.) overall frame width.

Wecon's light duty gravity roller conveyors are available with the rollers set high within the frame. When the rollers are set high, the product being conveyed can easily be moved to or from the conveyor. Guard rails are available as an option and can be used to extend the plane of the side channel above the height of the rollers to help contain the product and maintain product centering within the confines of the conveyor.

Frames are welded construction available in standard 10 ft lengths. Other lengths are available. Side channels are formed from 12 gauge steel or 1/8" aluminum x 2-1/2" deep to accommodate rollers set in this high position.

Light duty gravity roller conveyors can be supplied in straight and curved sections providing optimum flexibility and adaptability to your work environment. Curved sections are available in radii ranging from 30 to 90 degrees. Split lane curves are available for conveyors with an overall frame width of 18" or greater (15" B.F.R.). The application of a double lane of rollers provides for better orientation of the product around the curve.

Adjacent bed sections can be joined together by installing a support directly under a bed joint or in conjunction with optional hook connectors.



1.4" DIAMETER GRAVITY ROLLER CONVEYOR

1.5” DIAMETER ROLLER CONVEYORS

Wecon also offers a light duty gravity roller conveyor that operates utilizing a series of 1.5” diameter x 16 gauge aluminum rollers with oiled ball bearings. Roller axles are 5/16” hex spring loaded. Axle centers range from 1-3/4”, 2”, 3”, 4-1/2”, 6”, 9” or 12” depending on the type of product that is being conveyed. For optimum conveyance, the conveyor must support the product by a minimum of three rollers.

Conveyors are available in several standard widths ranging from 12” (9” B.F.R.) to 27” (24” B.F.R.) overall frame width.

These light duty gravity roller conveyors are available with rollers set high within the frame. When rollers are set high, the product being conveyed can easily be moved to or from the conveyor. Guard rails are available as an option and can be used to extend the plane of the side channel above the height of the rollers to help contain the product and maintain product centering within the confines of the conveyor.

Frames are welded construction available in standard 10 ft lengths. Other lengths are available. Side channels are formed from 12 gauge steel or 1/8” aluminum x 2-1/2” deep to accommodate rollers set in this high position.

Light duty gravity roller conveyors can be supplied in straight and curved sections providing optimum flexibility and adaptability to your work environment. Curved sections are available in radii ranging from 30 to 90 degrees. Split lane curves are available for conveyors with an overall frame width of 18” or greater (15” B.F.R.). The application of a double lane of rollers provides for better orientation of the product around the curve.

Adjacent bed sections can be joined together by installing a support directly under a bed joint or in conjunction with optional hook connectors.

Each of Wecon’s 1.4” and 1.5” diameter light duty gravity roller conveyors are ideal for carrying lightweight packages or for use in operations requiring lightweight portable sections. Alternately, they can be used in permanent installations providing flexibility and adaptability to your work environment. Typically, gravity roller conveyors utilizing aluminum frame sections are most frequently used in portable applications because of their lightweight, while steel frames are usually preferred in permanent applications.

MEDIUM DUTY GRAVITY ROLLER CONVEYORS

1.9" DIAMETER ROLLER CONVEYORS

Medium duty gravity roller conveyors operate utilizing a series of 1.9" diameter x 16 gauge galvanized steel rollers with greased packed ball bearings. Roller axles are 7/16" hex spring loaded. Axle centers range from 2", 2-1/4", 3", 4-1/2", 6", 9" or 12" depending on the type of product that is being conveyed. For optimum conveyance, the conveyor must support the product by a minimum of three rollers.

Conveyors are available in several standard widths ranging from 12" (9" B.F.R.) to 60" (57" B.F.R.) overall width.

Wecon's medium duty gravity roller conveyors are available with the rollers set high within the frame. When the rollers are set high, the product being conveyed can easily be moved to or from the conveyor. Guard rails are available as an option and can be used to extend the plane of the side channel above the height of the rollers to help contain the product and maintain product centering within the confines of the conveyor.

Frames are welded construction available in standard 10 ft lengths. Other lengths are available. Side channels are formed from 10 gauge steel x 3-1/2" deep to accommodate rollers set in this high position.

Medium duty gravity roller conveyors can be supplied in straight and curved sections providing optimum flexibility and adaptability to your work environment. Curved sections are available in radii ranging from 30 to 90 degrees. Split lane curves are available for conveyors with an overall frame width of 18" or greater (15" B.F.R.). The application of a double lane of rollers provides for better orientation of the product around the curve.

Adjacent bed sections can be joined together by installing a support directly under a bed joint or in conjunction with optional hook connectors or optional butt plates welded into the ends of the bed frames.

Wecon's 1.9" diameter medium duty gravity roller conveyors are ideal for carrying medium weight packages and are used in permanent installations providing flexibility and adaptability to your work environment.

1.9" DIAMETER GRAVITY ROLLER CONVEYOR

2.0" DIAMETER ROLLER CONVEYORS

Wecon offers a medium duty gravity roller conveyor that operates utilizing a series of 2.0" diameter x 13 gauge galvanized steel rollers with greased packed ball bearings. Roller axles are 7/16" hex spring loaded. Axle centers range from 2-1/4", 3", 4-1/2", 6", 9" or 12" depending on the type of product that is being conveyed. For optimum conveyance, the conveyor must support the product by a minimum of three rollers.

Conveyors are available in several standard widths ranging from 12" (9" B.F.R.) to 60" (57" B.F.R.) overall width.

Wecon's medium duty 2.0" gravity roller conveyors are available with the rollers set high within the frame. When the rollers are set high, the product being conveyed can easily be moved to or from the conveyor. Guard rails are available as an option and can be used to extend the plane of the side channel above the height of the rollers to help contain the product and maintain product centering within the confines of the conveyor.

Frames are welded construction available in standard 10 ft lengths. Other lengths are available. Side channels are formed from 10 gauge steel x 3-1/2" deep to accommodate rollers set in this high position. Medium duty 2.0" diameter gravity roller conveyors are supplied in straight sections only.

Adjacent bed sections can be joined together by installing a support directly under a bed joint or in conjunction with optional hook connectors or optional butt plates welded into the ends of the bed frames.

Wecon's 2.0" diameter medium duty gravity roller conveyors are ideal for carrying medium weight packages and are used in permanent installations providing flexibility and adaptability to your work environment.

2.5" DIAMETER ROLLER CONVEYORS

Wecon also offers a medium duty gravity roller conveyor that operates utilizing a series of 2.5" diameter x 14 gauge steel rollers with greased packed ball bearings. Roller axles are 7/16" hex spring loaded. Axle centers range from 3", 4-1/2", 6", 9" or 12" depending on the type of product that is being conveyed. For optimum conveyance, the conveyor must support the product by a minimum of three rollers.

Conveyors are available in several standard widths ranging from 12" (9" B.F.R.) to 60" (57" B.F.R.) overall width.

Wecon's medium duty 2.5" diameter gravity roller conveyors are available with the rollers set high within the frame. When the rollers are set high, the product being conveyed can easily be moved to or from the conveyor. Guard rails are available as an option and can be used to extend the plane of the side channel above the height of the rollers to help contain the product and maintain product centering within the confines of the conveyor.

Frames are welded construction available in standard 10 ft lengths. Other lengths are available. Side channels are formed from 10 gauge steel x 3-1/2" deep to accommodate rollers set in this high position. Medium duty 2.5" diameter gravity roller conveyors are supplied in straight sections only.

Adjacent bed sections can be joined together by installing a support directly under a bed joint or in conjunction with optional hook connectors or butt plates welded into the ends of the bed frames.

Wecon's 2.5" diameter medium duty gravity roller conveyors are ideal for carrying medium weight packages and are used in permanent installations providing flexibility and adaptability to your work environment.

Various accessories and options are available for medium duty gravity roller conveyors including butt plate connectors, diagonal bracing, fixed end stops, coated rollers, roller brakes and guard rails.

HEAVY DUTY GRAVITY ROLLER CONVEYORS

2.5" DIAMETER ROLLER CONVEYORS

Heavy duty gravity roller conveyors operate utilizing a series of 2.5" diameter x 11 gauge steel rollers with greased packed ball bearings. Roller axles are 11/16" hex spring loaded. Axle centers range from 3", 4", 6", 8", 9" or 12" depending on the type of product that is being conveyed. For optimum conveyance, the conveyor must support the product by a minimum of three rollers.

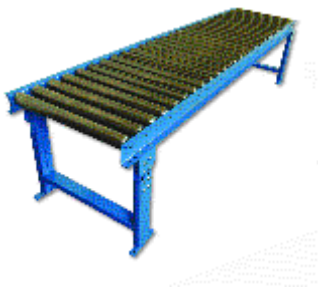
Conveyors are available in several standard widths ranging from 12" (9" B.F.R.) to 63" (60" B.F.R.) overall width.

Wecon's heavy duty gravity roller conveyors are available with the rollers set high within the frame. When the rollers are set high, the product being conveyed can easily be moved to or from the conveyor. Guard rails are available as an option and can be used to extend the plane of the side channel above the height of the rollers to help contain the product and maintain product centering within the confines of the conveyor.

Frames are welded construction available in standard 10 ft lengths. Other lengths are available. Side channels are formed from 3/16" steel x 4" deep to accommodate rollers set in this high position. Heavy duty gravity roller conveyors are supplied in straight sections only.

Adjacent bed sections can be joined together by installing a support directly under a bed joint or in conjunction with optional hook connectors or butt plates welded into the ends of the bed frames.

Wecon's 2.5" diameter heavy duty gravity roller conveyors are ideal for carrying medium to heavy weight packages or pallets and are used in permanent installations providing flexibility and adaptability to your work environment.



2.5" DIAMETER GRAVITY ROLLER CONVEYOR

3.5" DIAMETER ROLLER CONVEYORS

Heavy duty gravity roller conveyors operate utilizing a series of 3.5" diameter x 1/4" wall steel rollers with greased packed ball bearings. Roller axles are 1-1/16" hex spring loaded. Axle centers range from 4", 6", 8", 10" or 12" depending on the type of product that is being conveyed. For optimum conveyance, the conveyor must support the product by a minimum of three rollers.

Conveyors are available in several standard widths ranging from 12" (9" B.F.R.) to 63" (60" B.F.R.) overall width.

Wecon's heavy duty gravity roller conveyors are available with the rollers set high within the frame. When the rollers are set high, the product being conveyed can easily be moved to or from the conveyor. Guard rails are available as an option and can be used to extend the plane of the side channel above the height of the rollers to help contain the product and maintain product centering within the confines of the conveyor.

Frames are welded construction available in standard 10 ft lengths. Other lengths are available. Side channels are 6" commercial channel @ 8.2 #/ft to accommodate rollers set in this high position. Heavy duty gravity roller conveyors are supplied in straight sections only.

Adjacent bed sections can be joined together by installing a support directly under a bed joint or in conjunction with optional hook connectors or butt plates welded into the ends of the bed frames.

Wecon's 3.5" diameter heavy duty gravity roller conveyors are ideal for carrying heavy weight packages or pallets and are used in permanent installations providing flexibility and adaptability to your work environment.

Various accessories and options are available for heavy duty gravity roller conveyors including butt plate connectors, diagonal bracing, fixed end stops, coated rollers, roller brakes and guard rails.

INSTALLATION INSTRUCTIONS

SET–UP INSTRUCTIONS

Gravity conveyors, both Wheel and Roller come completely assembled and ready to use. It is recommended that all set up procedures be performed by at least two qualified people. Set up for these units will consist of determining the required height and location of the equipment then simply installing the supports to the conveyor and making adjustments to suit the desired operation.

POSITION AND ALIGNMENT

Proper mechanical installation is vital for the equipment to operate as described. Our installation standards show the importance that Wecon places on a quality installation.

Installation Standards

- In General:
  The following standards, where applicable, will be used as guidelines by Wecon approved installers.

- Dimensional Reference Points:
  The location of each conveyor in the system will be determined by establishing a reference point to the center of each conveyor from the fixed building column lines as indicated on approved general arrangement drawings.

- Level and Elevations:
  Conveyors will be installed in accordance with the elevations shown on the layout drawing(s).
  After the first elevation is established, the elevation of all other points will be related to this first point. The practice of dimensioning elevations from the floor at each point of support will not be followed. When the floor level changes significantly, such as the system going to an upper or lower floor, or into another building or room, a new elevation will be established from the first floor at that point. This new elevation will then become the reference point for subsequent elevations.

- Standards For Floor Mounting:
  Anchoring will be accomplished by drilling into the floor and inserting a suitable anchor bolt in an approved manner in accordance with the manufacturer's instructions.
  Drive and intermediate stands will be anchored with 3/8" diameter minimum bolts, one in each leg.
  Explosive type anchors will not be used. Adhesive or specialized anchors will be used only when specified.

Floor Mounted Units

- At the desired position for the conveyor, snap a chalk line (not in excess of 100 feet per run) on the floor location for the centre line of the unit.
- Use a plumb line to align the centre line of each conveyor section to the chalk line.
- Set height of unit.
- Adjust the conveyor both lengthwise and diagonally using a level.

NOTE: Beds must be level from side to side to prevent the possibility of product being skewed from the conveyor.

SUPPORT ASSEMBLY

Supports are fastened to the bottom flange utilizing holes designed into each bed section. Supports can be installed directly under a bed joint to support two adjacent bed sections. For single or end bed applications, supports can be mounted in the first available set of holes at the charge and the discharge ends of the conveyor. Mounting a support can be accomplished by either lifting the bed section into position onto a support or attaching the support directly to a bed section prior to lifting it into position. After the conveyor has been aligned and leveled, anchor the supports to the floor in an approved manner in accordance with the anchor bolt manufacturer's instructions.

HD SUPPORT MOUNTED ON END

HD SUPPORT MOUNTED ON JOINT

For curved beds, bolt a floor support single leg on the on the lower outer side channel flange of the curve using the holes designed in the bed. Adjust the height by loosening the two bolts on the support leg and moving the support into the sought after position. Tighten all fasteners.

If diagonal braces are required to provide additional stability, they should be installed at the ends of the curve or in the direction of the flow of the product.

CONVEYOR FRAME INSTALLATION

It is recommended that only trained personnel install or service this equipment.

Wecon GRAVITY conveyors are shipped on skids, generally, not exceeding 4000 pounds, for lift truck unloading and handling. The skids may also be handled with a crane if one is available. If a crane is utilized, ensure the operator is certified in the competency of its operation. Each skid will vary in width, length and height depending upon the style of product purchased.

The conveyor frames, supports, rollers and accessories should be thoroughly inspected before proceeding with the conveyor installation. Upon delivery, be sure to check the following items very carefully:

- The alignment of frames, to ensure horizontal and parallel orientation.
- The equipment to ensure there is no visible damage to the frames or rollers.

GRAVITY WHEEL CONVEYORS

- To achieve longer lengths, adjacent sections can be joined together by installing a support directly under a bed joint or in conjunction with optional hook and bar connectors. On units where hook and bar connectors are utlized, the frame end with the hooks is simply coupled over the bar on the adjacent bed.
- On units requiring pitch, experience and testing under field conditions is the only practical method for determining actual pitch requirements for the equipment. Adjustments can be made to the elevation by regulating the height of the supports.
- Once position has been established, tighten fasteners.

GRAVITY ROLLER CONVEYORS

***Note: It is recommended if your conveyor is supplied with rollers not installed in the bed that the supports be mounted to the conveyor prior to the installation of the rollers.

- Rollers are spring loaded. To install the rollers into a frame, push the spring loaded end of the axle and slide the protruding end of the axle into the desired hex hole. When the opposite end of the roller is positioned with the corresponding hex hole in the frame, release the tension in the axle. The roller will situate itself in the frame.

- To achieve longer lengths, adjacent sections can be joined together by installing a support directly under a bed joint or in conjunction with optional hook and bar connectors or optional using butt plates welded into the ends of the bed frames. On units where hook and bar connectors are utlized, the frame end with the hooks is simply coupled over the bar on the adjacent bed. For conveyors joined with optional butt plates, beds are connected using the holes provided. Fasteners should initially be finger tightened only to allow for positioning of the bed.
- On units requiring pitch, experience and testing under field conditions is the only practical method for determining actual pitch requirements for the equipment. Adjustments can be made to the elevation by regulating the height of the supports.
- Once position has been established, tighten fasteners.

PREPARING THE UNIT FOR USE

- Make certain that installation is in conformance to all local codes and regulations.
- Ensure the conveyor path is free from oil, debris and other foreign objects.
- Check to ensure that all hardware has been tightened and securely fastened.
- Ensure that all personnel are clear, then run unit and observe travel.

GRAVITY CONVEYOR OPERATION

- With conveyor operational, observe travel of product along the conveyor over the length of the bed.
- Listen for any noisy bearings, rollers or vibrations. Correct any problems immediately.
- Operate conveyor with a moderate load of product and check for functionality.
- Check to ensure supports are aligned to accommodate desired product flow and orientation.
- Remove any dirt build up from the skate wheels or rollers that could effect the operation of the conveyor.
- Any skate wheels or rollers that show visual signs of damage should be replaced immediately.

MAINTENANCE

WARNING: DO NOT ATTEMPT MAINTENANCE ON ANY CONVEYOR WHILE IT IS IN OPERATION.

Gravity conveyors are self-contained and almost maintenance free. Suggested maintenance should include a visual inspection of the gravity conveyor for damage, periodic lubrication of any moving components and a general inspection of all nuts and bolts for tightness. A light grade oil is all that is required.

MECHANICAL MAINTENANCE

Item	Schedule Service	Suggested Maintenance
Skate wheels	Monthly	Periodic lubrication
Rollers	Monthly	Periodic lubrication
Roller bearings	Weekly	Check for unusual noise or excessive wear, replace as required
Supports	Weekly	Check to ensure supports have not been damaged and fasteners are properly secure
Hardware	At set-up and every week of operation	Check to ensure all fasteners are in place and properly tightened

PARTS GUIDE

SKATE WHEELS

TYPE	PART NUMBER
Plastic - standard	FC-SW-P
Plastic – stainless steel bearings	FC-SW-PSS
Steel	FC-SW-S

5/16" DIAMETER SKATE WHEEL AXLES

CONVEYOR WIDTH nominal	BFR	PART NUMBER
12"	9"	SW-AX-09
15"	12"	SW-AX-12
18"	15"	SW-AX-15
21"	18"	SW-AX-18
24"	21"	SW-AX-21
27"	24"	SW-AX-24

HARDWARE

TYPE	PART NUMBER
5/16-18 Two way lock nut	GC-HW-1

1.4" DIAMETER X 18 GAUGE GALVANIZED STEEL ROLLERS

CONVEYOR WIDTH nominal	BFR	PART NUMBER
12"	9"	1418-09
15"	12"	1418-12
18"	15"	1418-15
21"	18"	1418-18
24"	21"	1418-21
27"	24"	1418-24

1.5” DIAMETER X 16 GAUGE ALUMINUM ROLLERS

CONVEYOR WIDTH nominal	BFR	PART NUMBER
12”	9”	1516-09
15”	12”	1516-12
18”	15”	1516-15
21”	18”	1516-18
24”	21”	1516-21
27”	24”	1516-24

1.9” DIAMETER X 16 GAUGE GALVANIZED STEEL ROLLERS

CONVEYOR WIDTH nominal	BFR	PART NUMBER
12”	9”	1916-09
15”	12”	1916-12
18”	15”	1916-15
21”	18”	1916-18
24”	21”	1916-21
27”	24”	1916-24
30”	27”	1916-27
33”	30”	1916-30
36”	33”	1916-33
39”	36”	1916-36
42”	39”	1916-39
45”	42”	1916-42
48”	45”	1916-45
51”	48”	1916-48
54”	51”	1916-51
57”	54”	1916-54
60”	57”	1916-57

2.0" DIAMETER X 13 GAUGE STEEL ROLLERS

CONVEYOR WIDTH nominal	BFR	PART NUMBER
12"	9"	2013-09
15"	12"	2013-12
18"	15"	2013-15
21"	18"	2013-18
24"	21"	2013-21
27"	24"	2013-24
30"	27"	2013-27
33"	30"	2013-30
36"	33"	2013-33
39"	36"	2013-36
42"	39"	2013-39
45"	42"	2013-42
48"	45"	2013-45
51"	48"	2013-48
54"	51"	2013-51
57"	54"	2013-54
60"	57"	2013-57

2.5" DIAMETER X 14 GAUGE STEEL ROLLERS

CONVEYOR WIDTH nominal	BFR	PART NUMBER
12"	9"	2514-09
15"	12"	2514-12
18"	15"	2514-15
21"	18"	2514-18
24"	21"	2514-21
27"	24"	2514-24
30"	27"	2514-27
33"	30"	2514-30
36"	33"	2514-33
39"	36"	2514-36
42"	39"	2514-39
45"	42"	2514-42
48"	45"	2514-45
51"	48"	2514-48
54"	51"	2514-51
57"	54"	2514-54
60"	57"	2514-57

2.5” DIAMETER X 11 GAUGE STEEL ROLLERS

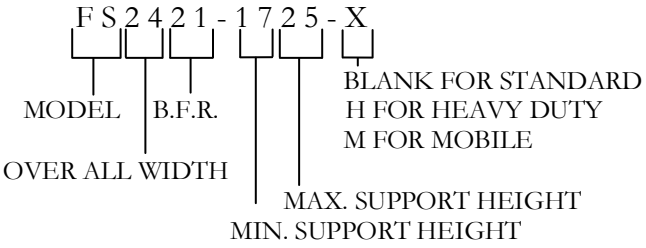
CONVEYOR WIDTH nominal	BFR	PART NUMBER
12”	9”	2511-09
15”	12”	2511-12
18”	15”	2511-15
21”	18”	2511-18
24”	21”	2511-21
27”	24”	2511-24
30”	27”	2511-27
33”	30”	2511-30
36”	33”	2511-33
39”	36”	2511-36
42”	39”	2511-39
45”	42”	2511-42
48”	45”	2511-45
51”	48”	2511-48
54”	51”	2511-51
57”	54”	2511-54
60”	57”	2511-57
63”	60”	2511-60

3.5” DIAMETER X 1/4” WALL STEEL ROLLERS

CONVEYOR WIDTH nominal	BFR	PART NUMBER
12”	9”	3525-09
15”	12”	3525-12
18”	15”	3525-15
21”	18”	3525-18
24”	21”	3525-21
27”	24”	3525-24
30”	27”	3525-27
33”	30”	3525-30
36”	33”	3525-33
39”	36”	3525-36
42”	39”	3525-39
45”	42”	3525-42
48”	45”	3525-45
51”	48”	3525-48
54”	51”	3525-51
57”	54”	3525-54
60”	57”	3525-57
63”	60”	3525-60

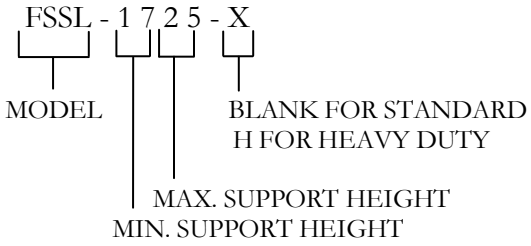
SUPPORTS

WHEN ORDERING SUPPORTS USE THE FOLLOWING FORMAT



FLOOR SUPPORTS SINGLE LEG (FOR GRAVITY CURVES)

WHEN ORDERING FLOOR SUPPORTS SINGLE LEG USE THE FOLLOWING FORMAT



FIXED END STOPS

CONVEYOR WIDTH nominal	PART NUMBER
12”	FES-12
15”	FES-15
18”	FES-18
21”	FES-21
24”	FES-24
27”	FES-27
30”	FES-30

FORMED ANGLE GUARD RAILS

TYPE	PART NUMBER
1" x 1" x 120" long	FAGR-11-120
1" x 3" x 120" long	FAGR-13-120
1" x 6" x 120" long	FAGR-16-120
Nylon protective cap strip	40-106

TOUCH-UP PAINT

COLOUR	PART NUMBER
Wecon (shop) blue	P-S-BLUE
Ermanco blue (ER-1)	P-E-BLUE-ER-1
Ermanco blue (ER-2)	P-E-BLUE-ER-2
Medium grey	P-M-GREY
Wecon (shop) green	P-S-GREEN
Safety yellow	P-S-YELLOW