

AS40 Conveyors

Installation & Maintenance Instructions



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qcconveyors.com

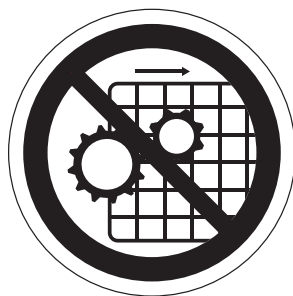
Warnings



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



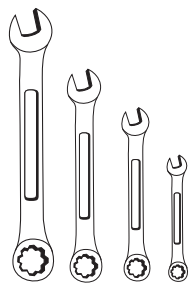
Equipment may start without warning - can cause severe injury. KEEP AWAY



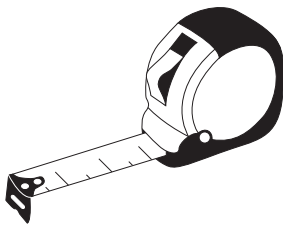
Servicing moving or energized equipment can cause severe injury LOCK OUT POWER

Tools

► Required Tools



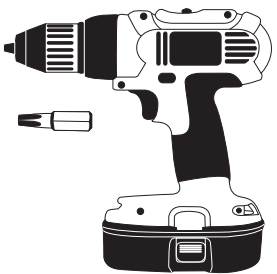
Set of Metric Wrenches (3mm-13mm)



Tape Measure



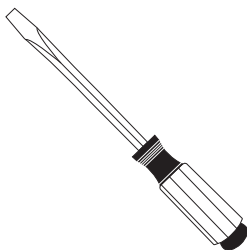
10" Adjustable Wrench



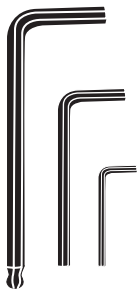
Screw Gun and T-30 Torx Bit



Aluminum cutting hack saw or equivalent



Wide Flat Head Screwdriver

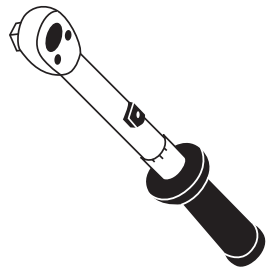


Set of Metric allen wrenches (3mm, 4mm & ball head 5mm)

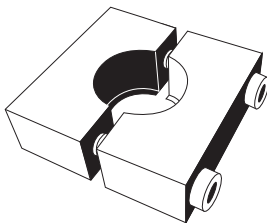


Bubble level

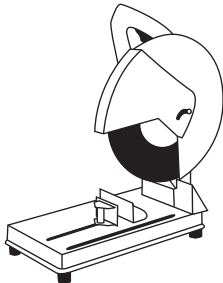
► Optional Tools



3/8" Torque wrench



QC Conveyors bearing removal tool (part# 1A0077A)



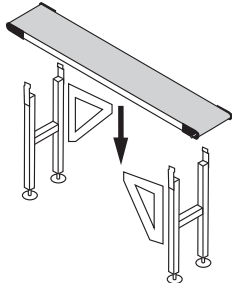
Electric Chop Saw

Installation

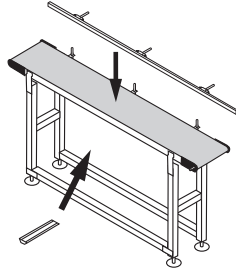
► Check Your Shipment

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 Conveyors regarding any damage that may have occurred during shipment. Check the contents of your shipment against the supplied packing slip and inform QC Conveyors of any discrepancies.

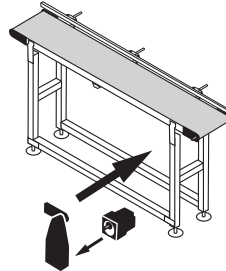
► General Sequence of Installation



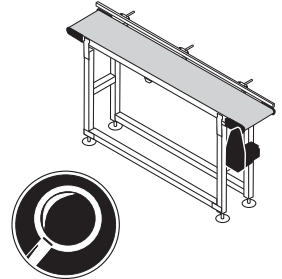
1 Mount conveyor to stands or mounting brackets; install angle brackets if appropriate. In applications with three stands, install angle braces only on outermost stands.



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.

► Assistance

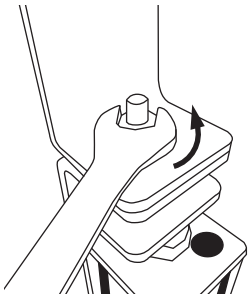
If you need assistance, please contact QC Conveyors customer service department Monday through Friday, 8am-5pm EST at (513) 753-6000. In addition, your local distributor has been trained at the factory and can provide support in many ways. You can also visit our website - qcconveyors.com - for additional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

Stand Installation

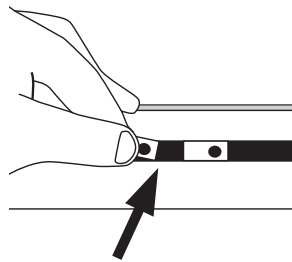
Mounting Aluminum Stands to Conveyor

► Mounting Aluminum Exact Width Stands

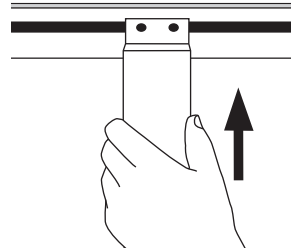
Stands should be placed as close to ends of conveyor as possible. Stands may be placed a maximum of 10' apart for conveyors 6" wide or less with a load less than 20 lbs.; conveyors 8"-12" wide with a load less than 25 lbs.; conveyors 18"-24" wide. For all other conveyors, stands should be placed a maximum of 6' apart.



1 Remove the nuts holding the stand attachment brackets to the top of the stand and remove the brackets.



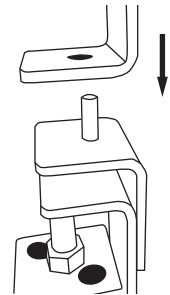
2 Insert drop in nuts into t-slot on conveyor frame.



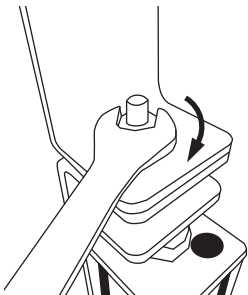
3 Attach stand attachment brackets to conveyor using a 5mm allen wrench.

For Conveyors 6" wide or less:
flange should point outboard;
spacer must be installed between
stand attachment bracket and
conveyor frame.

For conveyors more than 6" wide:
flange should point inboard; no
spacer is necessary

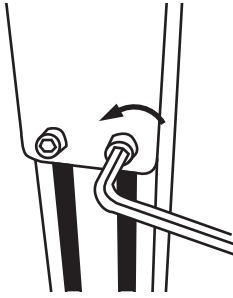


4 Place stand attachment brackets atop stands.

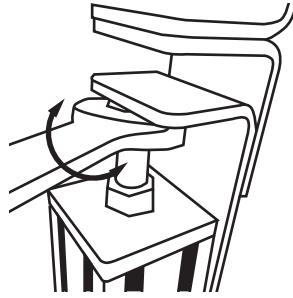


5 Replace nuts and tighten.

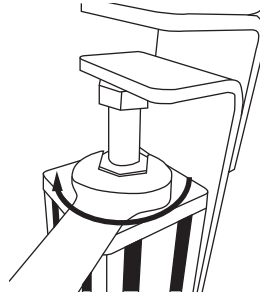
► Stand Height Adjustment



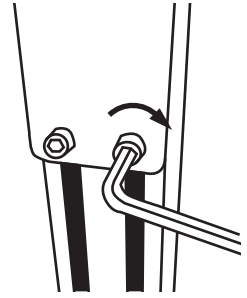
1 Loosen two lower screws in each stand bracket using a 5mm allen wrench.



2 Adjust stand height by turning bolt using a 3/4" wrench. Turn clockwise to lower or counter-clockwise to raise. Ensure conveyor is level.



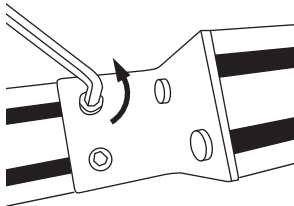
3 Tighten jam nut against top plate of stand.



4 Tighten two lower screws in each stand bracket using a 5mm allen wrench.

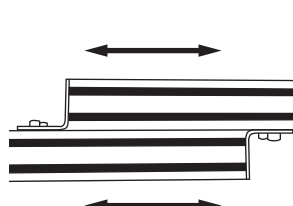
► Installing Cross Ties

For applications using a single cross tie, the cross tie should be installed between the cross bars of the stands. For applications using two cross ties, the cross ties should be installed between the uprights of the stands. The installation process is the same for each.

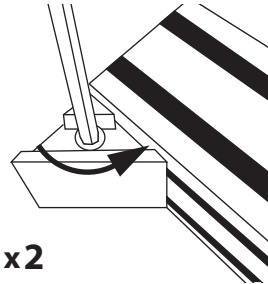


x4

1 Using a 5mm allen wrench, loosen two socket head cap screws in each cross tie adjustment plate.

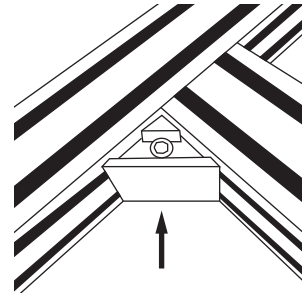


2 Slide adjustable cross tie pieces to fit between stands.

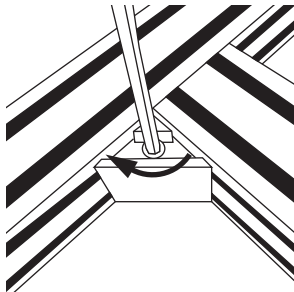


x2

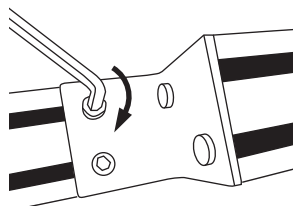
3 Loosen triangular Quick Clamp on each end of cross tie.



4 Ensuring the socket head cap screw is facing you, slide Quick Clamp into tee slot at desired mounting position.



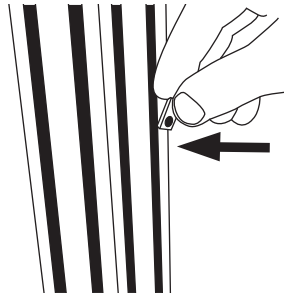
5 Using a 5mm allen wrench, tighten Quick Clamp.



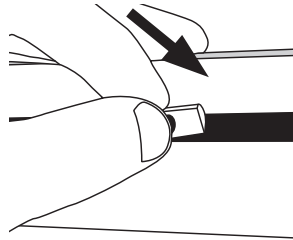
x4

6 Using a 5mm allen wrench, tighten two socket head cap screws in each cross tie adjustment plate.

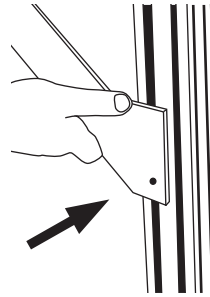
► Mounting Angle Braces



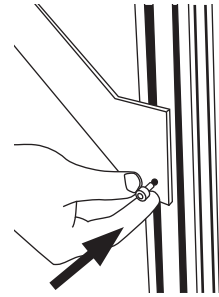
1 Insert drop in nut into inner stand leg t-slot.



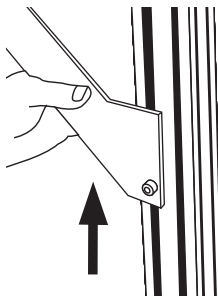
2 Insert drop in nut into conveyor frame's t-slot.



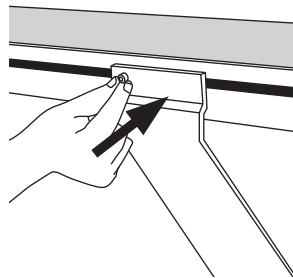
3 Align angle brace over drop in nut in stand.



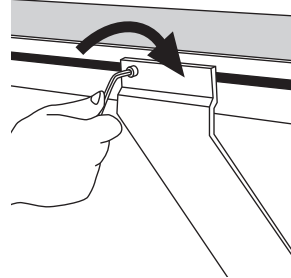
4 Insert socket head cap screw through angle brace and into drop in nut on stand (do not fully tighten).



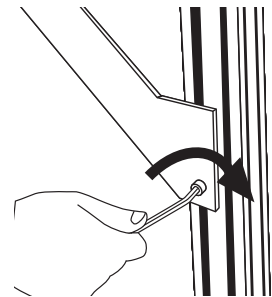
5 Slide up and align angle brace with drop in nut in frame.



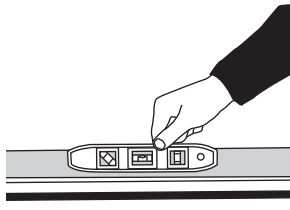
6 Insert socket head cap screw through angle brace and into nut in conveyor frame.



7 Tighten socket head cap screw on frame.



8 Tighten socket head cap screw on stand.



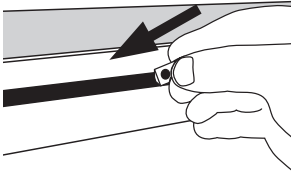
9 Check with bubble level to ensure conveyor is level.

> Repeat for opposite side.

⚠ Injury is possible if the stands are not lagged to the 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.

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

Mount Installation

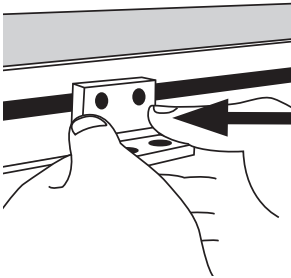


x2

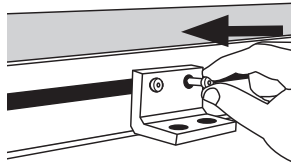
1 Insert drop in nuts into t-slot in desired mount location.

> Proceed to correct mount type.

► Flush Mount

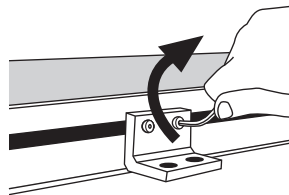


1 Align mount to drop in nuts.



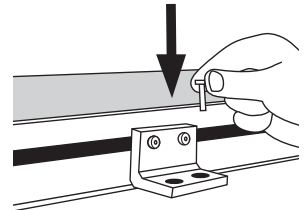
x2

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



x2

3 Tighten screws to secure mount to frame.

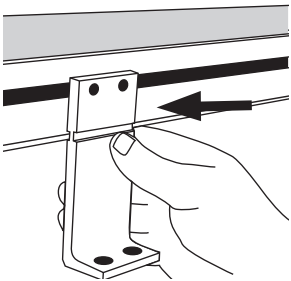


x2

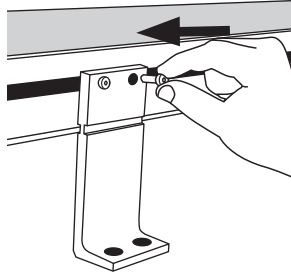
4 Insert screws (not provided) into desired mounting surface and tighten.

► Raised Mount

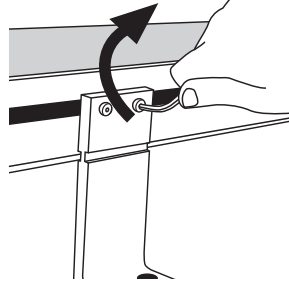
Mount's foot can be placed facing inward or outward depending on application.



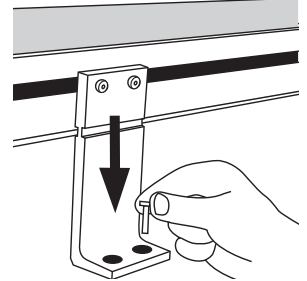
1 Align mount to drop in nuts.



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



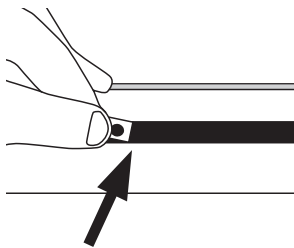
3 Tighten screws to secure mount to frame.



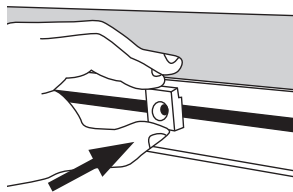
4 Insert screws (not provided) into desired mounting surface and tighten.

Side / Guide Installation

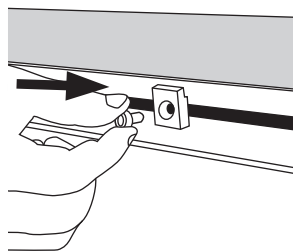
► Installing Fixed Side Rails



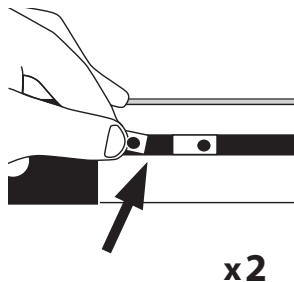
1 Insert drop in nuts into t-slot on frame.



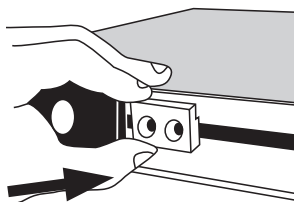
2 Align guide brackets with drop in nuts.



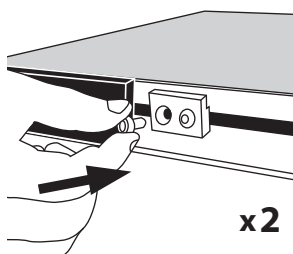
3 Insert socket head cap screw through guide clamp and into drop in nuts.



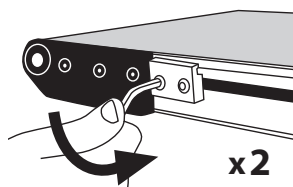
4 Insert two drop in nuts into t-slot at tail end of frame.



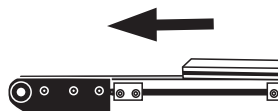
5 Align clamping block to drop in nuts.



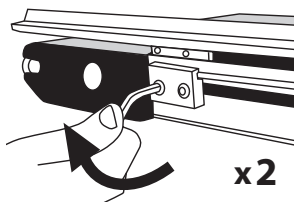
6 Insert screws through clamping block and into drop in nuts.



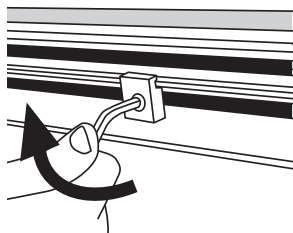
7 Loosen tracking block screws. (Do not remove)



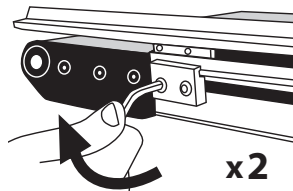
8 Slide guide rail in between clamps and frame until in place.



9 Tighten screws in clamping blocks.

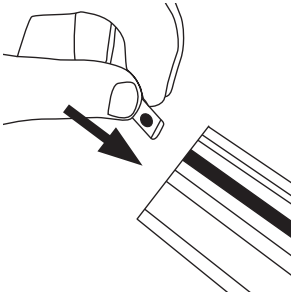


10 Tighten screws in guide clamps.

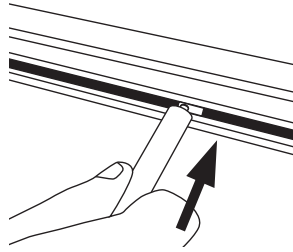


11 Retighten screws in tracking block.

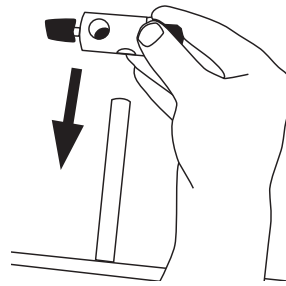
► Installing Adjustable Guide Brackets



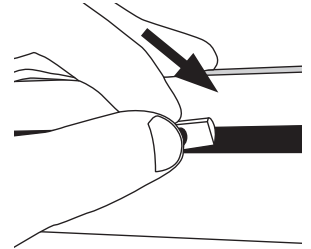
1 Insert economy nuts into t-slot of guiderail and slide into position



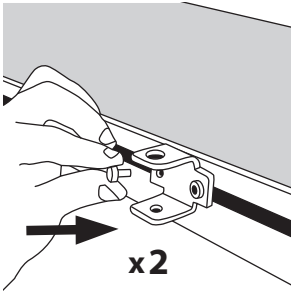
2 Loosely thread adjusting rod into nuts.



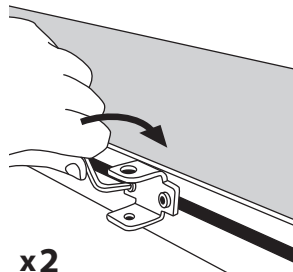
3 Place a cross block onto each guiderail and set aside.



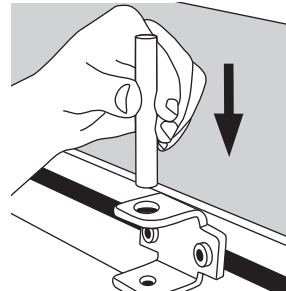
4 Insert drop in nuts into t-slot on frame.



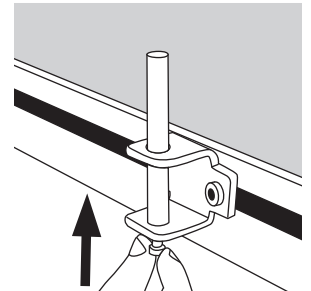
5 Align guide bracket, keeping the larger hole up, with drop in nuts and insert screws.



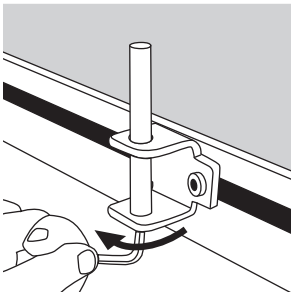
6 Tighten socket head cap screws.



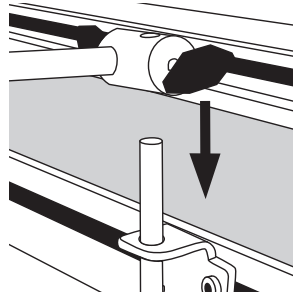
7 Insert a rod vertically through the larger hole on top of guide bracket.



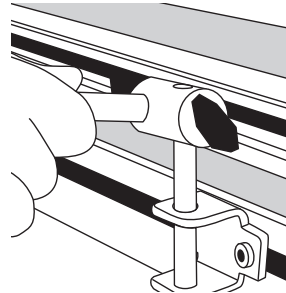
8 Secure rod from below with socket head cap screw.



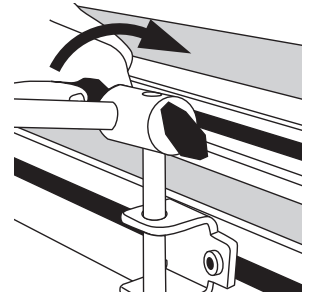
9 Tighten cap screw.



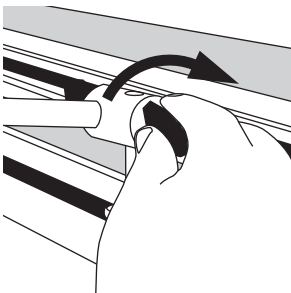
10 Slide guiderail assembly over vertical rods on frame.



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

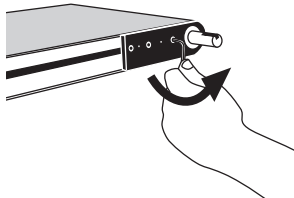
- 

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

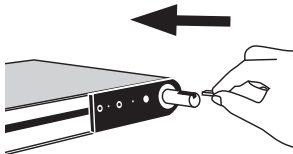
QC Conveyors recommends that all wiring be completed by a certified electrician to ensure correct installation. Refer to documentation contained in the motor's box for instructions on electrical connections.

► Side Drive Mounting Package

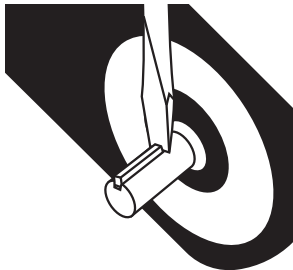
The Drive Package will ship separate from the conveyor with the speed reducer attached, and the speed reducer's coupler already attached to its shaft. For Standard Duty Drives the speed reducer and motor will ship installed on the drive mounting package.



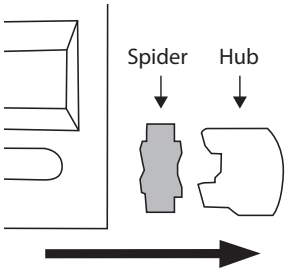
1 Remove and discard three cap head screws from drive side bearing block. (Leave bearing block in place)



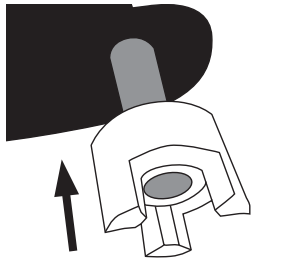
2 Install 4mm x 14mm key to conveyor drive pulley. (Shipped with mounting package)



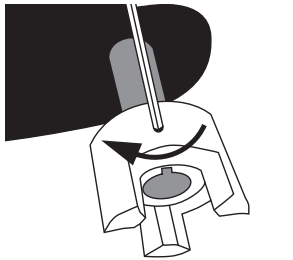
3 Using a flathead screwdriver, stake key. This will stop key from sliding



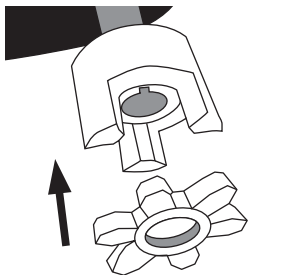
4 In the mounting package, remove coupling hub and spider that connect to conveyor drive pulley.



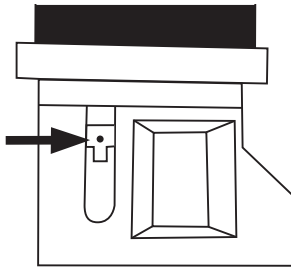
5 Install coupling hub onto conveyor drive pulley and align coupling face to end of shaft.



6 Lightly tighten coupling hub onto drive pulley to allow for possible axial adjustment.



7 Install spider onto drive pulley coupling hub.

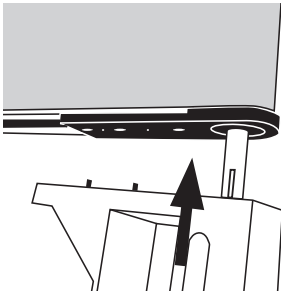


8 Confirm gearmotor coupling set screw has the correct torque value per Table 1 (below).

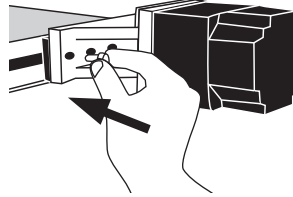
Table 1: Set Screw Tightening Torque

ID Bore	Torque Value
12mm/Drive Pulley	58-62 in-lbs
18mm	44 in-lbs

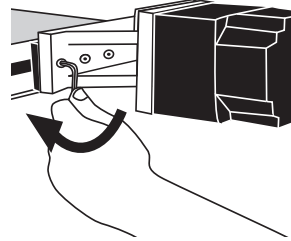
► Side Drive Mounting Package (continued)



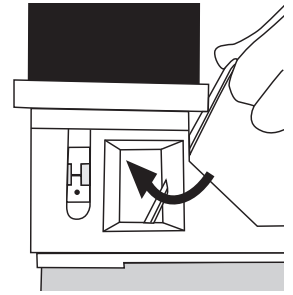
9 Align pins to bearing plate and slide mounting package over drive pulley against bearing plate. Align coupling jaws while sliding into place.



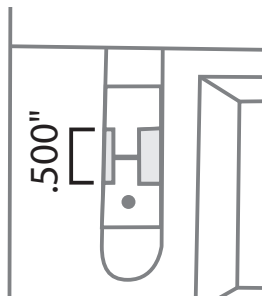
10 Insert three socket head cap screws and loosely tighten.



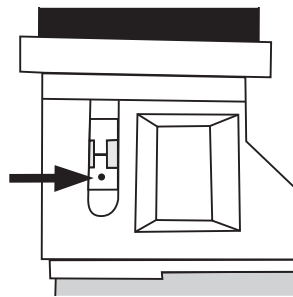
11 Ensure mounting package is parallel to top of conveyor and tighten two socket head cap screws.



12 Tighten third socket head cap screw at an angle through access points using a ball head allen wrench.



13 Ensure distance of .500" ($\pm .022$ ") is maintained between hub faces and hubs are making contact with the spider without excess pressure.



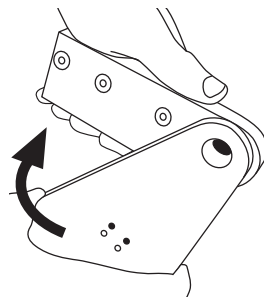
14 Tighten 12mm drive pulley coupling to the torque value in Table 1 (previous page).

► Pivot Drive Mounting Package

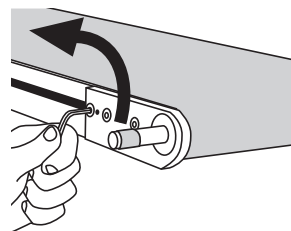
The Drive Package will ship separate from the conveyor. For Standard Duty Drives the speed reducer and motor will ship installed on the drive mounting package.



1 Loosen two set screws in drive mounting plate.

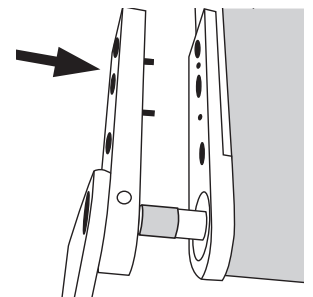


2 Rotate drive mounting plate into workable position.



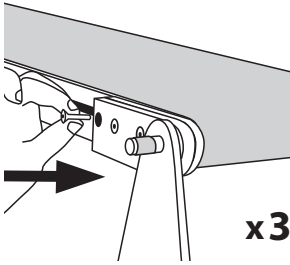
x3

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

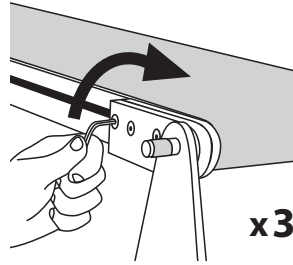


4 Align pins on mounting plate to holes on bearing plate and slide assembly over shaft.

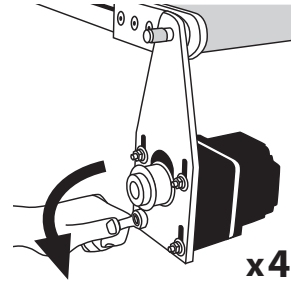
► **Pivot Drive Mounting Package (continued)**



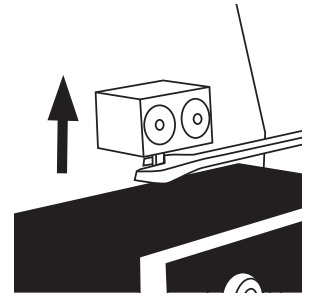
5 Install flat head screws into countersunk holes.



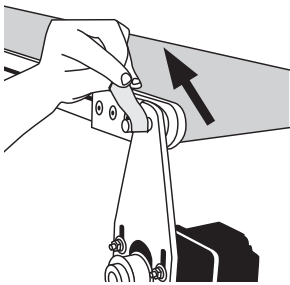
6 Tighten screws in countersunk holes.



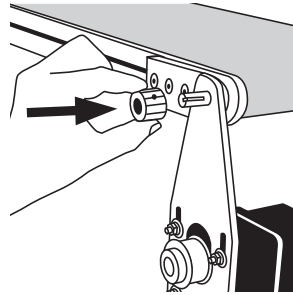
7 Loosen four hex nuts holding gearbox in position.



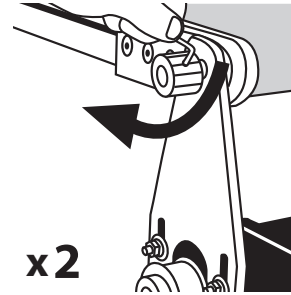
8 Tighten jacking screw to allow gearbox to move toward conveyor.



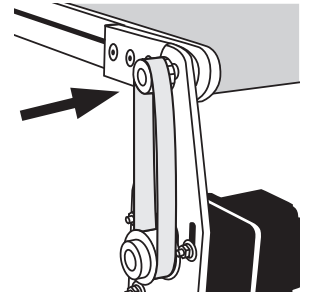
9 Remove tape holding key in place. (Do not remove Key)



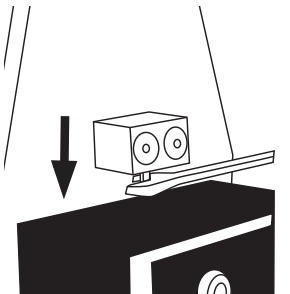
10 Slide top sprocket onto conveyor's output shaft and key.



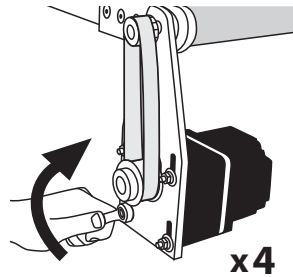
11 Tighten set screws to secure top sprocket.



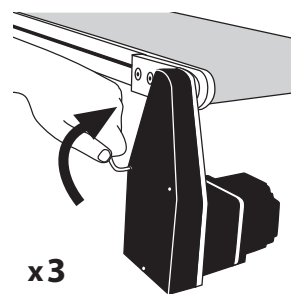
12 Install timing belt over sprockets.



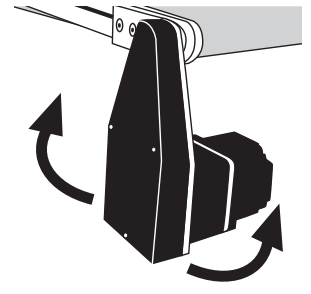
13 Run jacking screw out to create tension on belt. (Approximately 6lbs of force to deflect one span of belt .09")



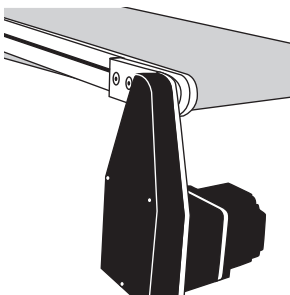
14 Retighten four hex nuts.



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



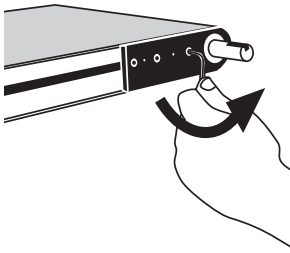
16 Rotate pivot drive into desired position for operation.



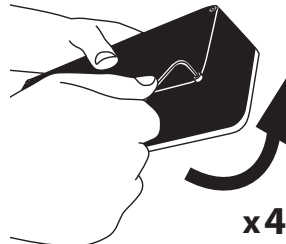
17 Retighten set screws to secure pivot drive

► Heavy Duty Top/Bottom Drive Mounting Packages

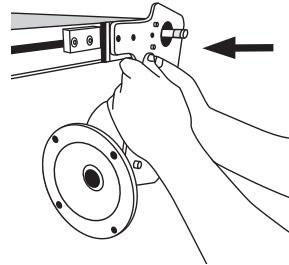
The Drive Package will ship separate from the conveyor. For Heavy Duty Drives, the motor is always shipped in its own box; the right angle speed reducer will be attached to the drive mounting package.



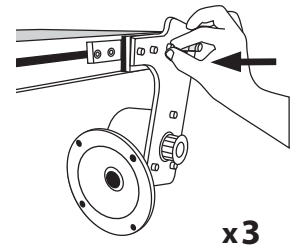
1 Remove and discard three socket head cap screws from drive side bearing plate. (Do not remove bearing plate)



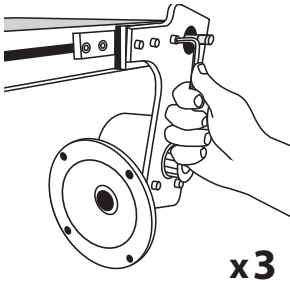
2 Remove four socket head cap screws from guard and remove guard.



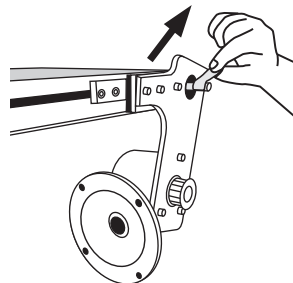
3 Mount drive package over drive mounting plate.



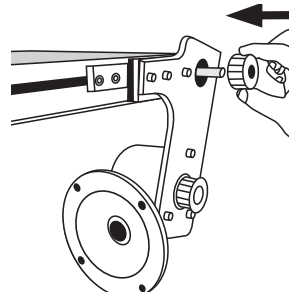
4 Align mounting holes and install three socket head screws.



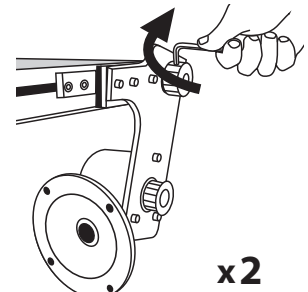
5 Tighten three socket head screws.



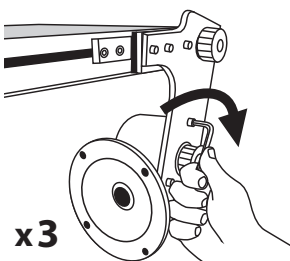
6 Remove nylon tape holding key in place (do not remove key).



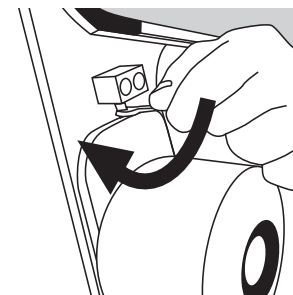
7 Slide top sprocket onto conveyor's output shaft and key.



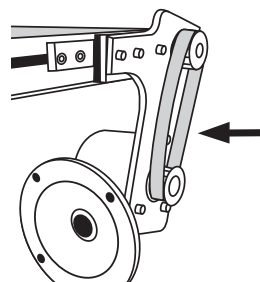
8 Tighten set screws to secure in place.



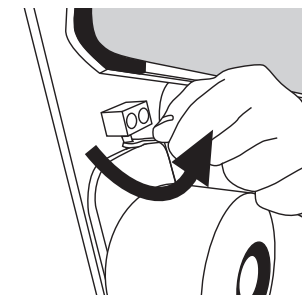
9 Loosen three socket head cap screws holding speed reducer in position.



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

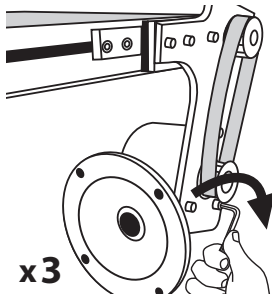


11 Install timing belt over sprockets.

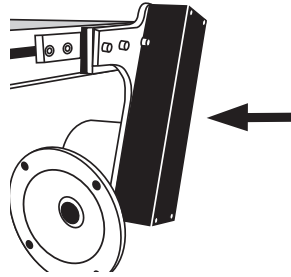


12 Run square head screw out, moving speed reducer away from conveyor and creating tension on belt.

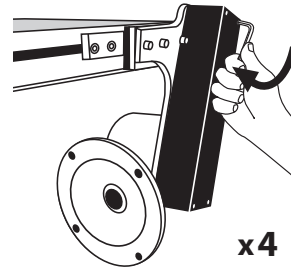
► **Heavy Duty Top/Bottom Drive Mounting Packages (continued)**



13 Retighten three socket head cap screws.

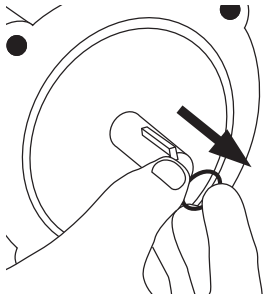


14 Replace guard.

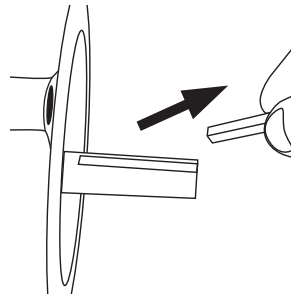


15 Insert and tighten four socket head cap screws.

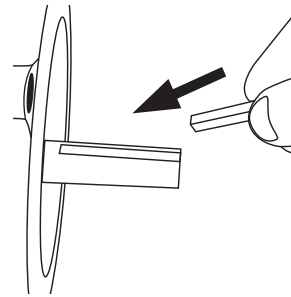
► **Install Heavy Duty Motor to Speed Reducer**



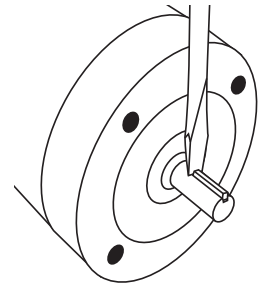
1 Remove ring holding key in place.



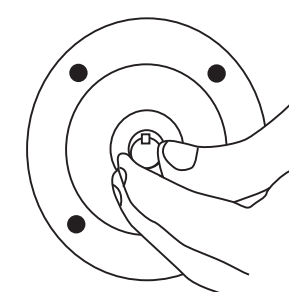
2 Remove and discard key that is included with motor.



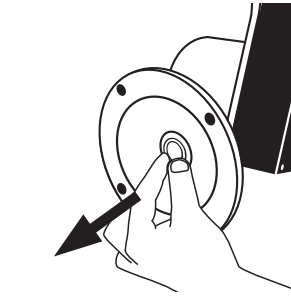
3 Install Leeson speed reducer key to keyway on motor.



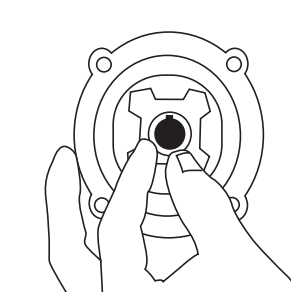
4 Lightly strike just behind the key with a screwdriver and hammer.



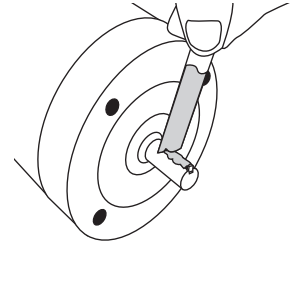
5 Rotate keyway on motor to 12 o'clock position.



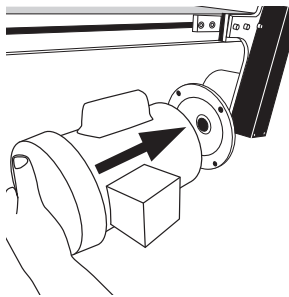
6 Remove plug from speed reducer.



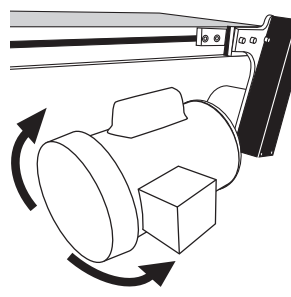
7 Rotate quill pin on speed reducer so that keyway is in 12 o'clock position.



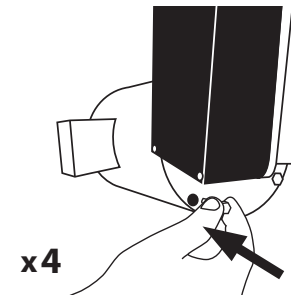
8 Apply anti-seize compound to speed reducer input quill and motor shaft.



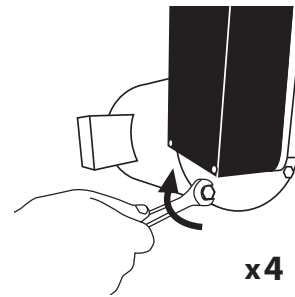
9 Install motor onto speed reducer.



10 Rotate motor so workbox is in desired position.



11 Install 4 hex head screws.



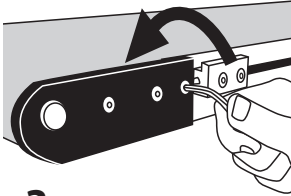
12 Tighten 4 hex head screws to secure.

Maintenance

Belt Tracking

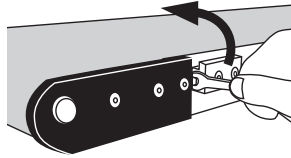
> For best results, make adjustments to only one side.

► Belt Tracking at Drive End

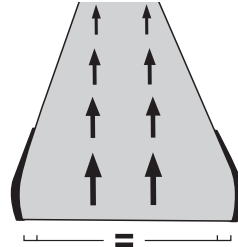


x3

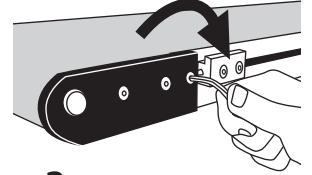
1 Loosen three driver assembly screws on each side of bearing block.



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.

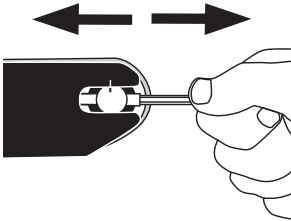


x3

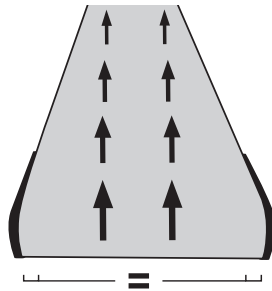
4 Retighten driver assembly screws. (Three on each side)

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.

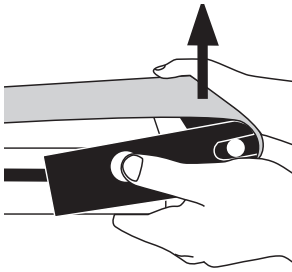
Tail End is tracked when belt can make a full revolution without contacting either side of frame.



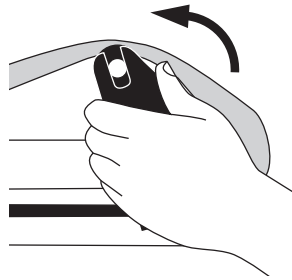
To see a video of this process, scan this code on your phone or tablet. You may also visit <http://bit.ly/as40tracking>

Belt Change

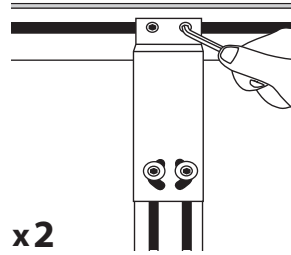
► Removal of Existing Belt



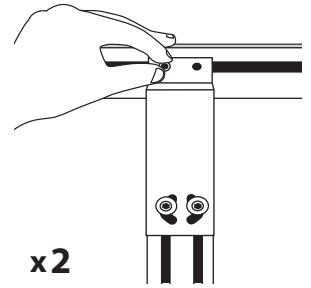
1 Simultaneously push in both buttons to disengage locking mechanism. (Frame end could have sharp edges)



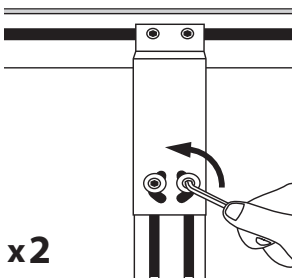
2 Rotate tension release tail assembly up and towards the drive end.



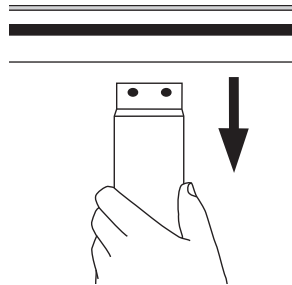
3 Loosen screws on mounts/brackets on opposite side of drive.



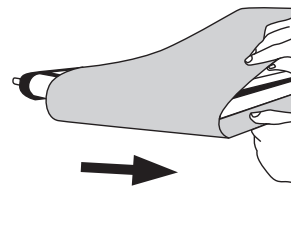
4 Remove screws from stand brackets or mounts. (if stand brackets are not used, proceed to step 7)



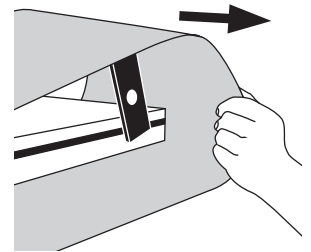
5 Loosen screws on stand. (Do not remove)



6 Slide stand bracket down for clearance.



7 Slide belt sideways to clear drive pulley bearing plate.



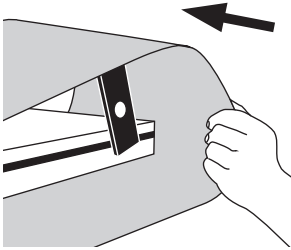
8 Pull belt off of tension release tail.



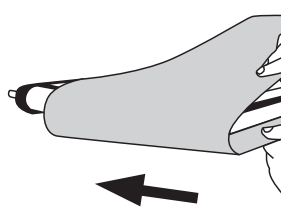
To see a video of this process, scan this code on your phone or tablet. You may also visit <http://bit.ly/as40belt>

► Installation of New Belt

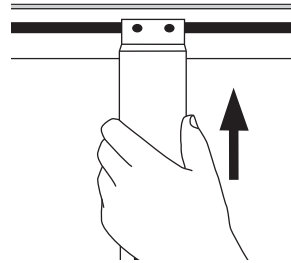
- > If stand brackets are not being used, skip steps 3 & 6.



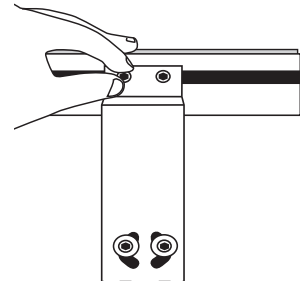
1 Starting at tail end, loop belt over frame and tension release tail assembly.



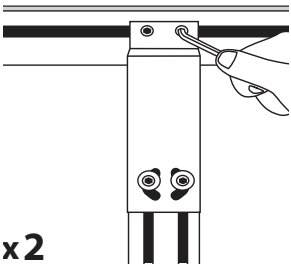
2 Loop belt around conveyor frame towards drive end.



3 Slide frame bracket up to engage conveyor frame.

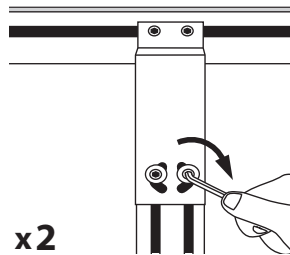


4 Insert screws through bracket or mount used and into frame's drop in nuts.



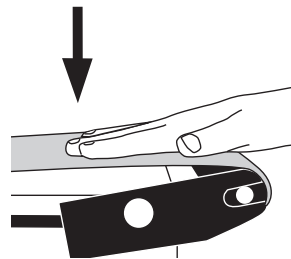
x2

5 Tighten screws.



x2

6 Tighten screws on stand.

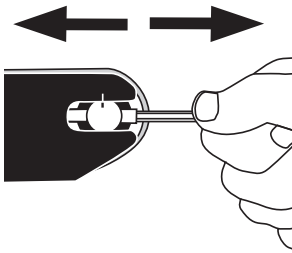


7 Rotate tension release tail assembly down and into the locked position. (Frame end could have sharp edges)

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

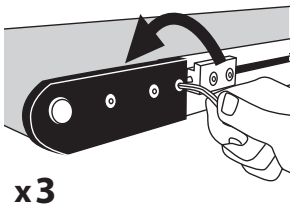
Belt Tensioning

► Belt Tension at Tail End

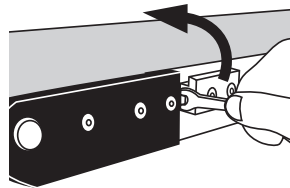


- 1** Adjust the set screws on the tail assembly so the tail pulley assembly moves direction need. (In to relieve tension, out to increase tension) (Adjust both screws the same amount).

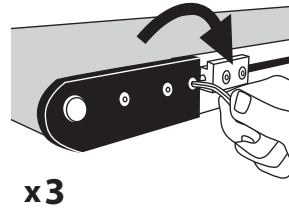
► Belt Tension at Drive End



- 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).

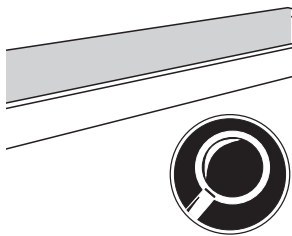


- 3** Retighten six driver assembly screws to lock assembly into position.

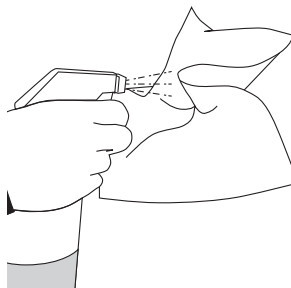
If additional belt tension is needed after following these steps, it is recommended that a new belt be installed.

Care and Cleaning

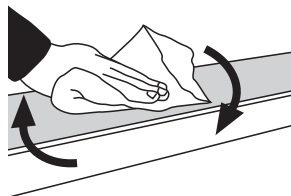
► Belt Care / Cleaning



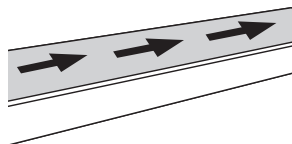
1 Inspect Belt for any fraying or tears and replace if needed.



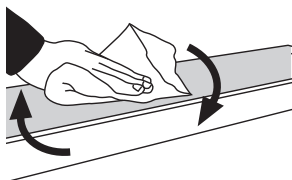
2 Spray proper cleaning solution on a clean rag.



3 Wipe belt with rag.



4 Cycle conveyor to reveal opposite side of belt.

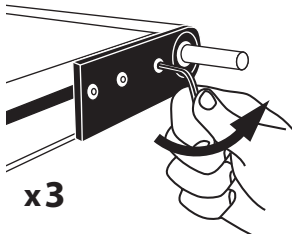


5 Wipe belt with rag.

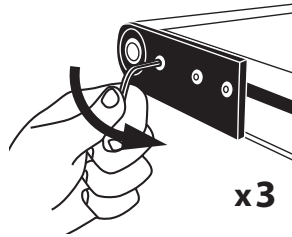
Bearing & Pulley Replacement

► Bearing & Drive Pulley Assembly Replacement

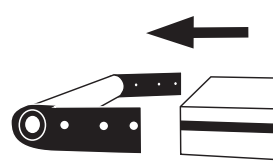
- > Remove belt and drive package. (Follow steps for your drive package in Drive Package section of this manual in reverse order)



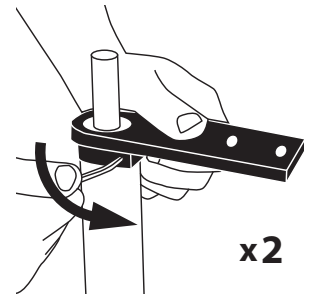
1 Loosen but do not remove three screws holding bearing plate on drive side.



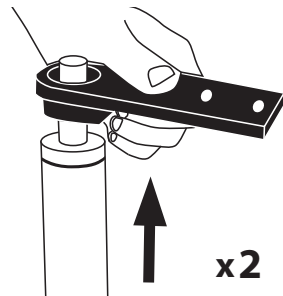
2 Loosen but do not remove three screws holding bearing plate on opposite side of pulley.



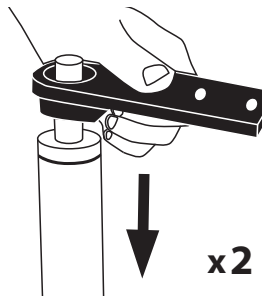
3 Slide bearing plates out of frame.



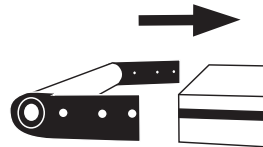
4 Loosen set screws in both bearing plates.



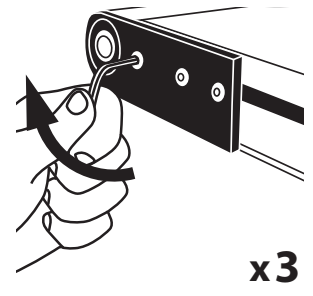
5 Remove both bearing plates from drive pulley.



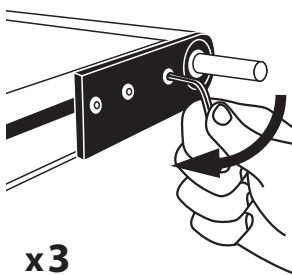
6 Install bearing plates onto new drive pulley.



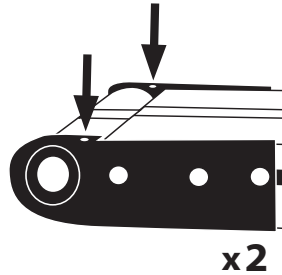
7 Slide pulley back into frame.



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



9 Install final three screws on opposite bearing plate.



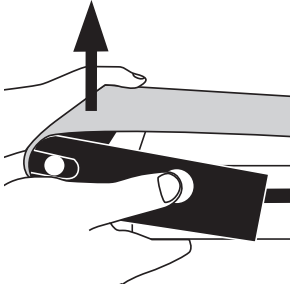
10 Align pulley's V-Guide with V-Guide in frame and tighten set screws on both bearing plates.

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

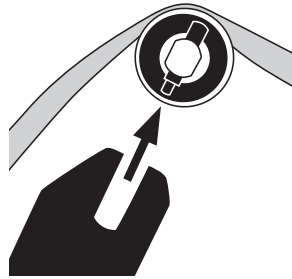
If tensioning adjustment is needed, refer to belt tensioning section of this manual.

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

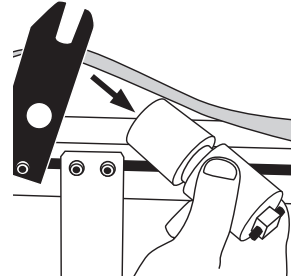
► Tail Pulley Replacement



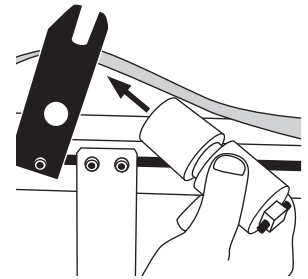
1 Press both tension release buttons and lift up simultaneously.



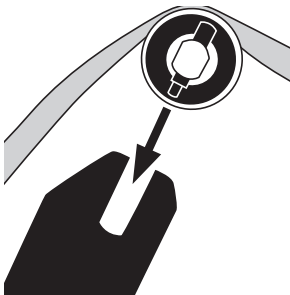
2 Lift idler pulley out of slot.



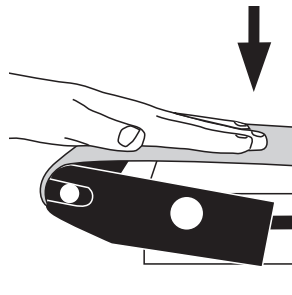
3 Remove Idler pulley from conveyor.



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

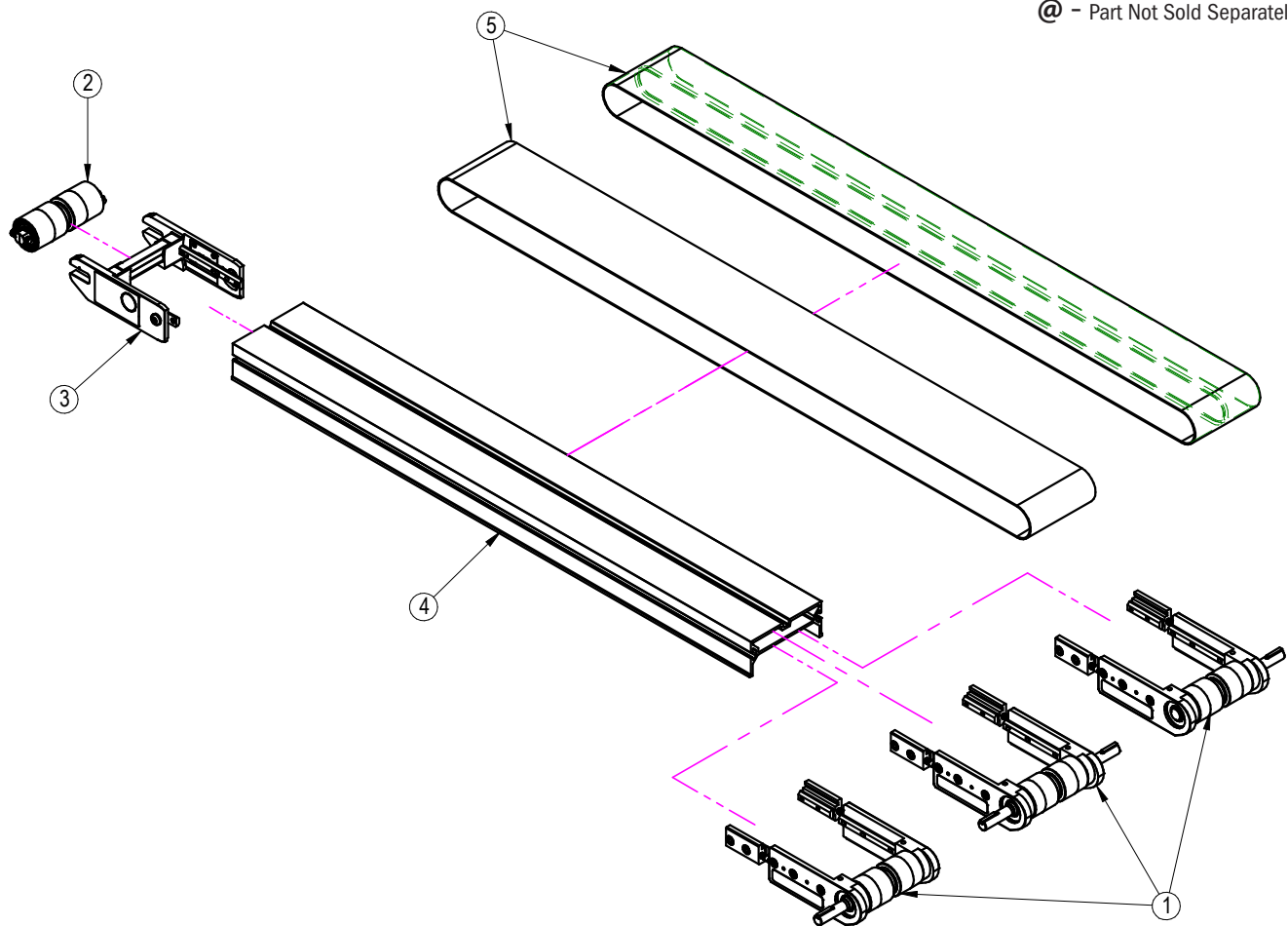
Symptom	Possible Cause	Corrective Action
Belt is slipping or stops under load	Demand is more than the conveyor is rated for	Verify conveyor capacity
	Lubrication between drive pulley and belt	Clean bottom of belt and drive pulley
	Tail pulley assembly not rotated into proper position	Refer to section on tensioning the belt (page 19)
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 11)
	Tail pulley assembly not tensioned properly	Refer to section on tensioning the belt (page 19)
Belt will not track at drive end	Accumulation or belt wear	Refer to Belt Tracking section of this manual (page 16)
	Improper tension	Refer to Belt Tensioning section of this manual (page 19)
Belt will not track at tail end	Irregular product loading or belt wear	Refer to Belt Tracking section of this manual (page 16)
	Improper tension	Refer to Belt Tensioning section of this manual (page 19)
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 21)
Belt is traveling reverse of desired direction	Motor or speed reducer not wired properly	Check wiring and correct per wiring instructions
Conveyor belt has prematurely worn out	Correct belt not selected for application	Contact factory to discuss belt application

If you are unable to remedy the problem with these corrective actions, please contact QC Conveyors 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

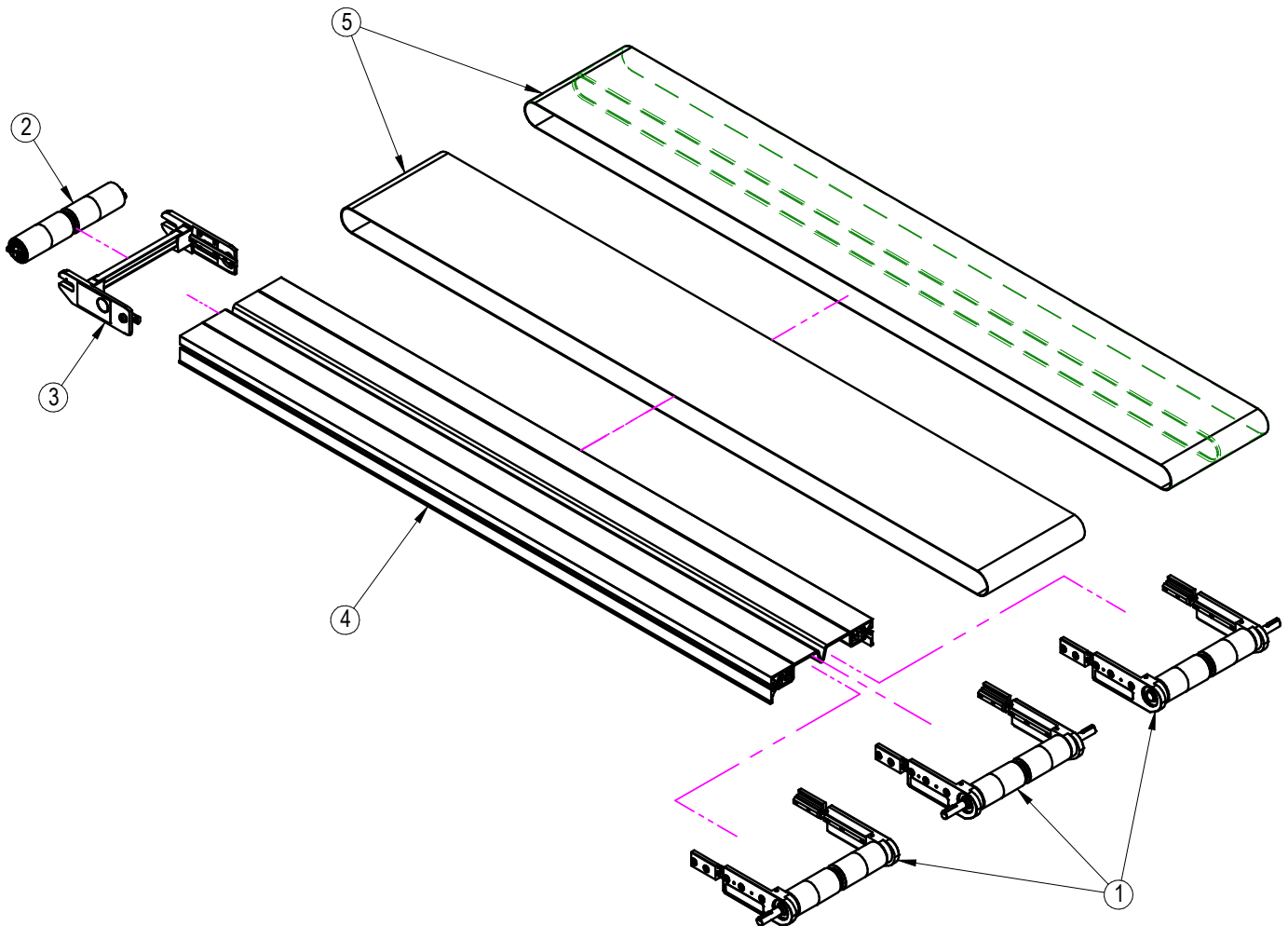
@ - Part Not Sold Separately



#	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

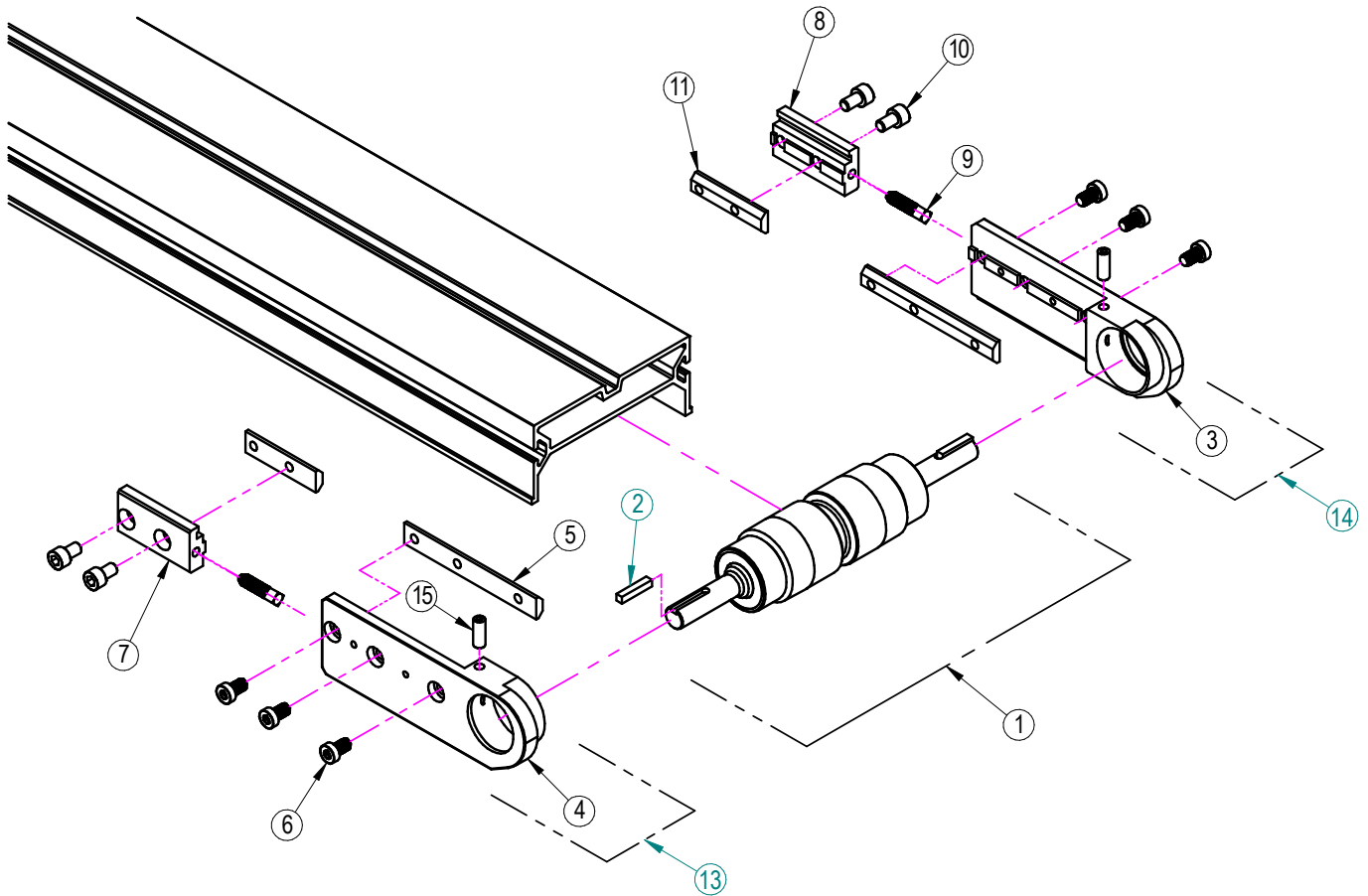
@ - Part Not Sold Separately



#	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

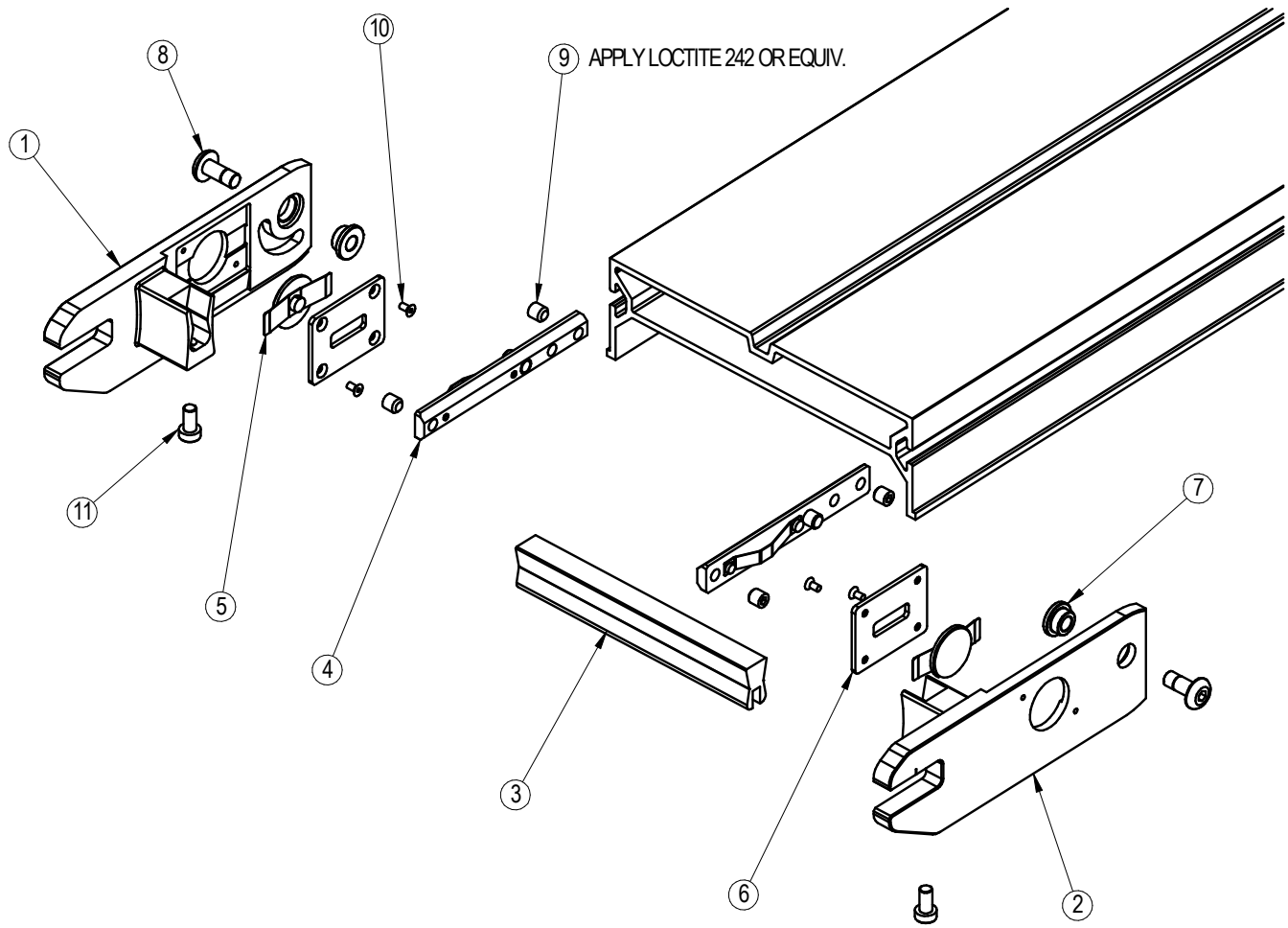
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#	Part #	Description
1	1D0123C00WW	PULLEY END DRIVE DUAL OUTPUT WITH BEARINGS AND KEYS
2	1D0084A	KEY 4MM X 4MM SQ. X 21MM LG.
3	1D0065B	DRIVE BEARING HOUSING RH
4	1D0064B	DRIVE BEARING HOUSING LH
5	1D0080A	ANCHOR BAR BEARING HOUSING
6	SLHCS-M6X100X010-BX	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

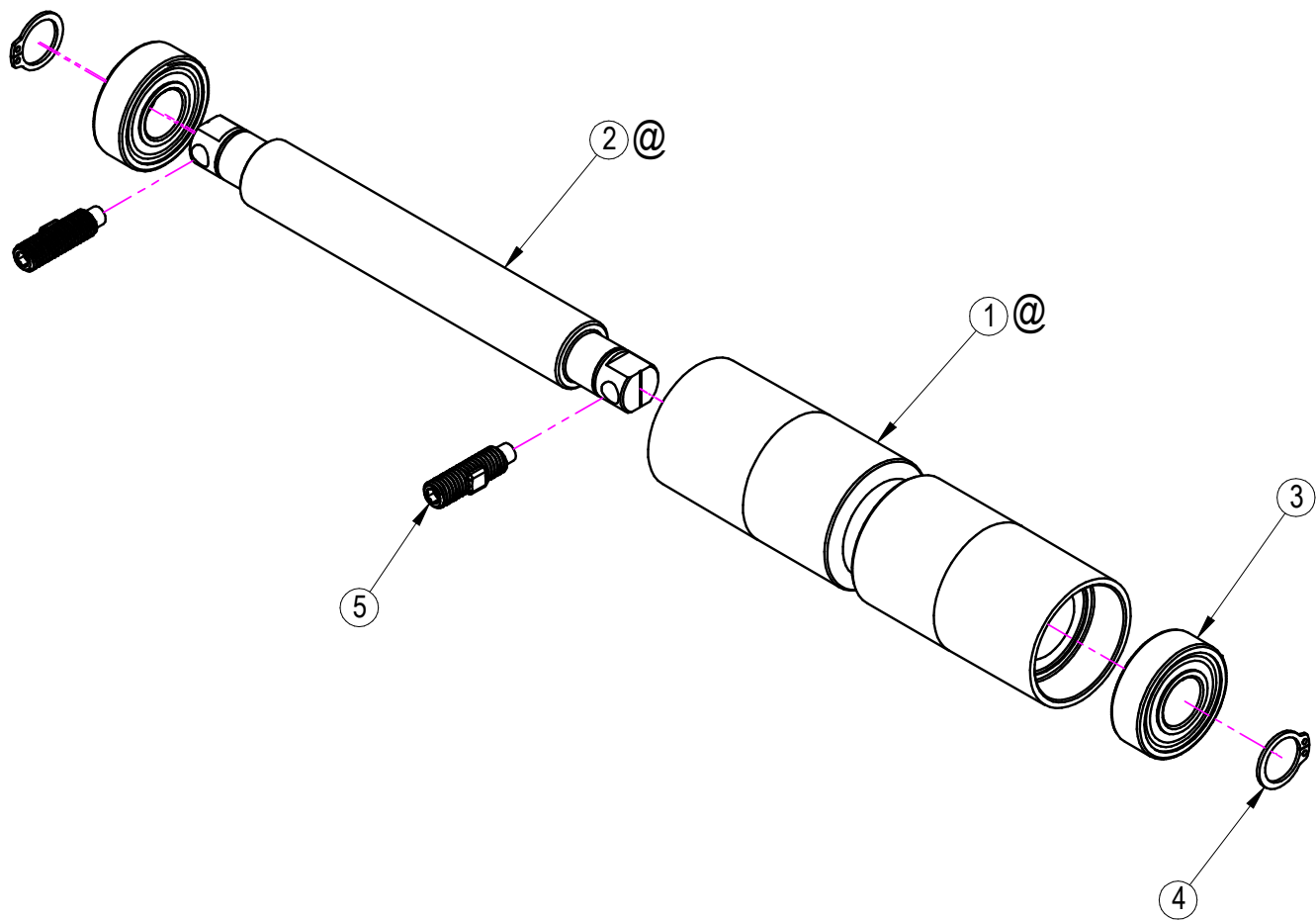
@ - Part Not Sold Separately



#	Part #	Description
1	1D0182A	TAIL PLATE RH
2	1D0181A	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

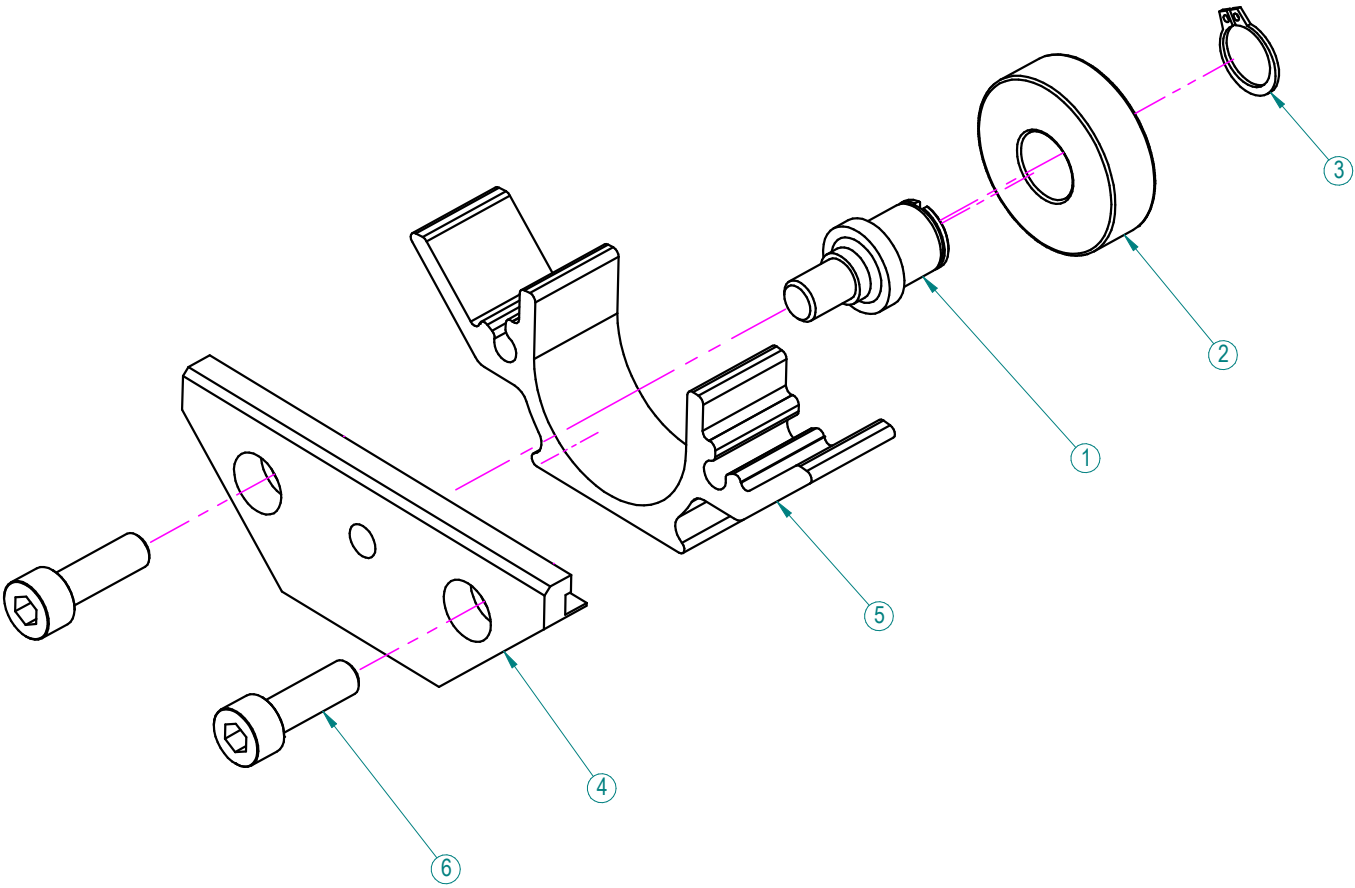
@ - Part Not Sold Separately



#	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

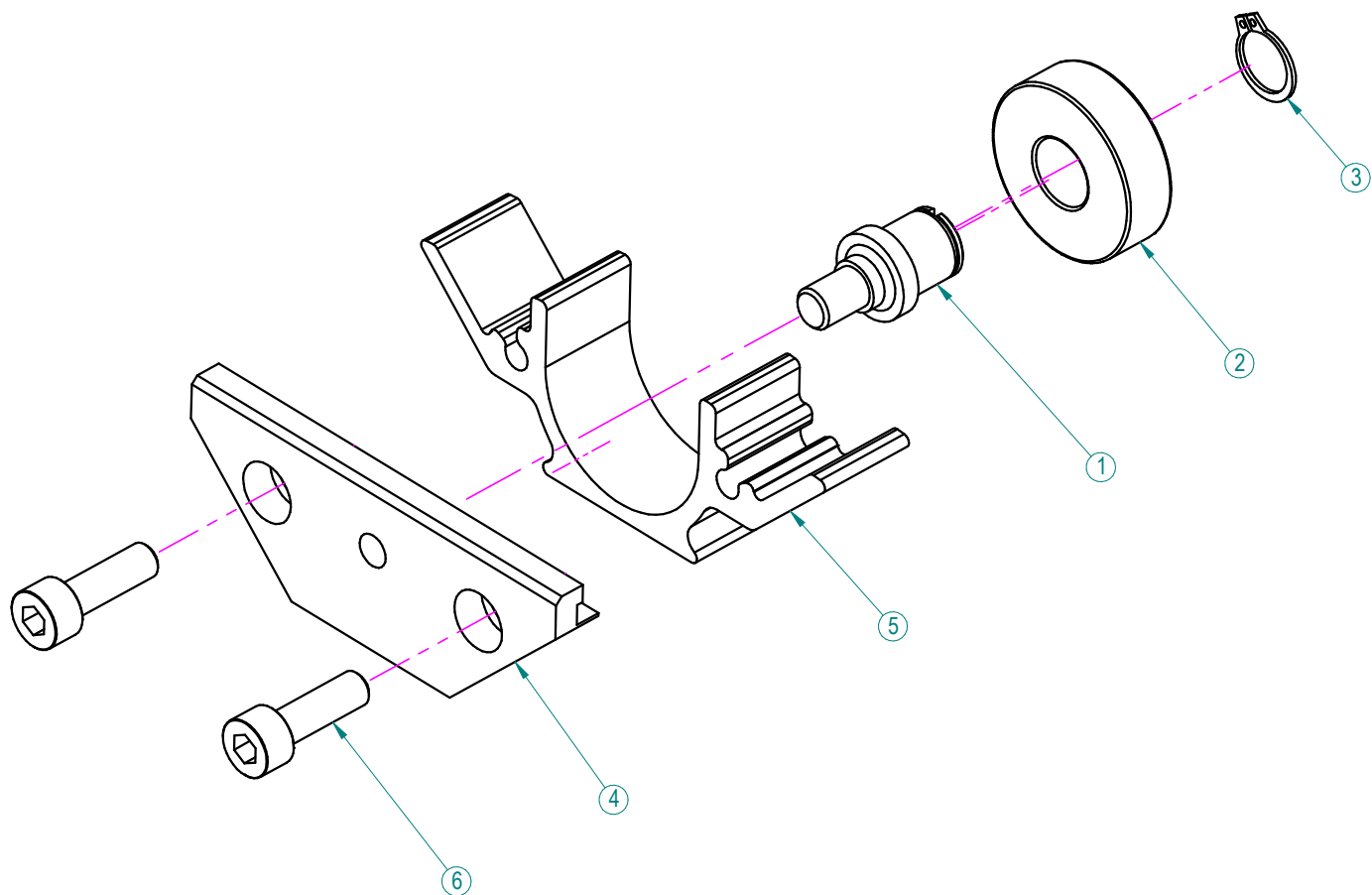
@ - Part Not Sold Separately



#	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

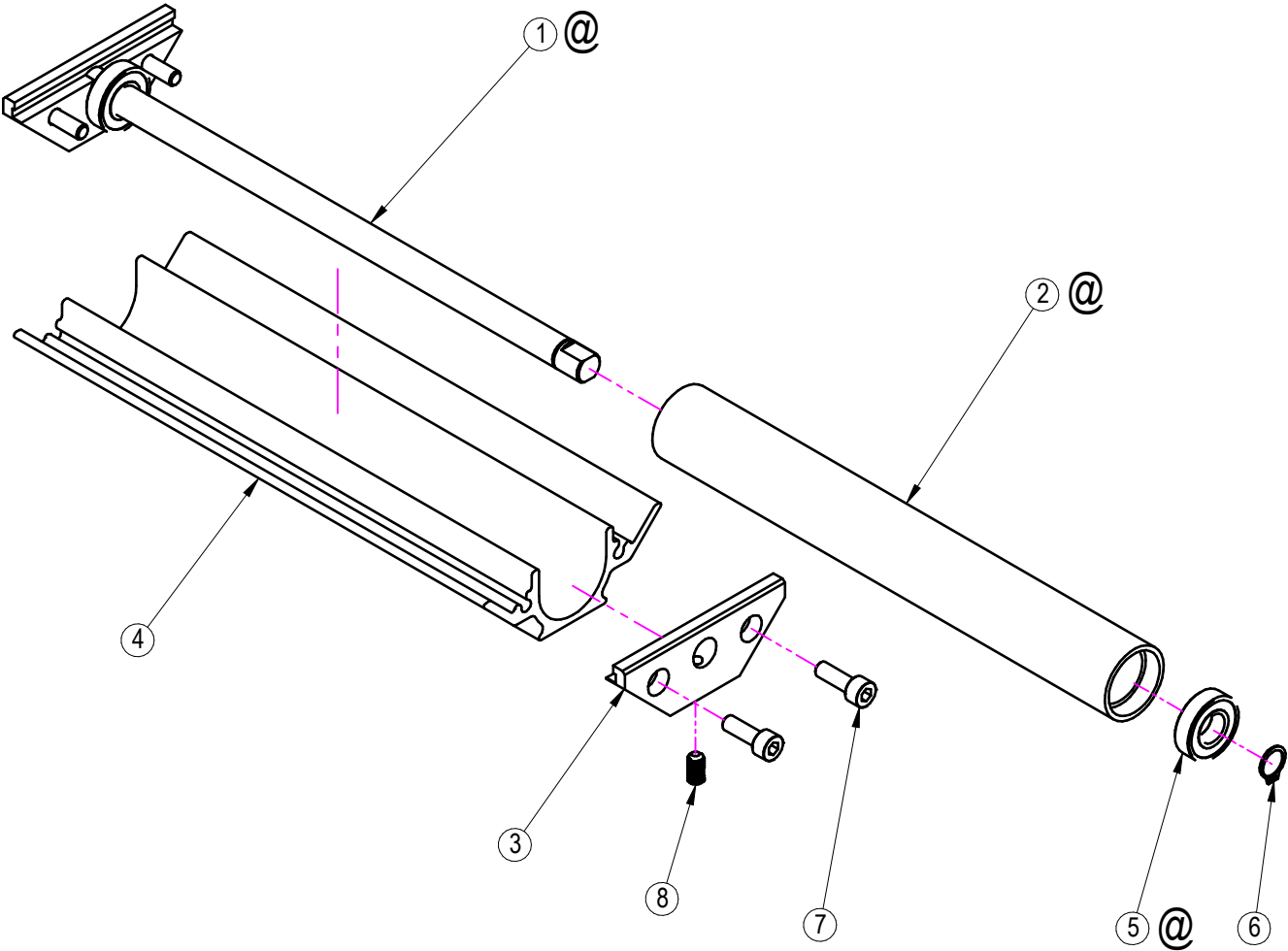
@ - Part Not Sold Separately



#	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 Conveyors 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 Conveyors will replace any defective part within the warranty period, without charge, provided:

- > The Purchaser gives QC Conveyors 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 Conveyors 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 Conveyors 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 Conveyors 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 | > Controllers |
| > Motors | > Casters |
| > Reducers | > 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 Conveyors 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 Conveyors without previous authorization from our company for such a return. Please notify QC Conveyors 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 Conveyors will need to be supplied. QC Conveyors 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 Conveyors. 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 Conveyors, where applicable. If the carrier does not take responsibility for the claim, a representative of QC Conveyors will contact you.

► Return Policy

If, for any reason, an item needs to be returned to QC Conveyors 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 Conveyors 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 Conveyors and evaluated for possible credit only after returned items are received and evaluated.
- > After the call is made to QC Conveyors, 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 Conveyors. 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 Conveyors 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 Conveyors 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 Conveyors 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 Conveyors 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 Conveyors' facility by a predetermined time and that time frame has expired. In this case, QC Conveyors 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 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.

Service Record

Date	Service Performed

► **Serial Number**

► **Date of Installation**

Service Record

Date	Service Performed

► **Serial Number**

► **Date of Installation**
