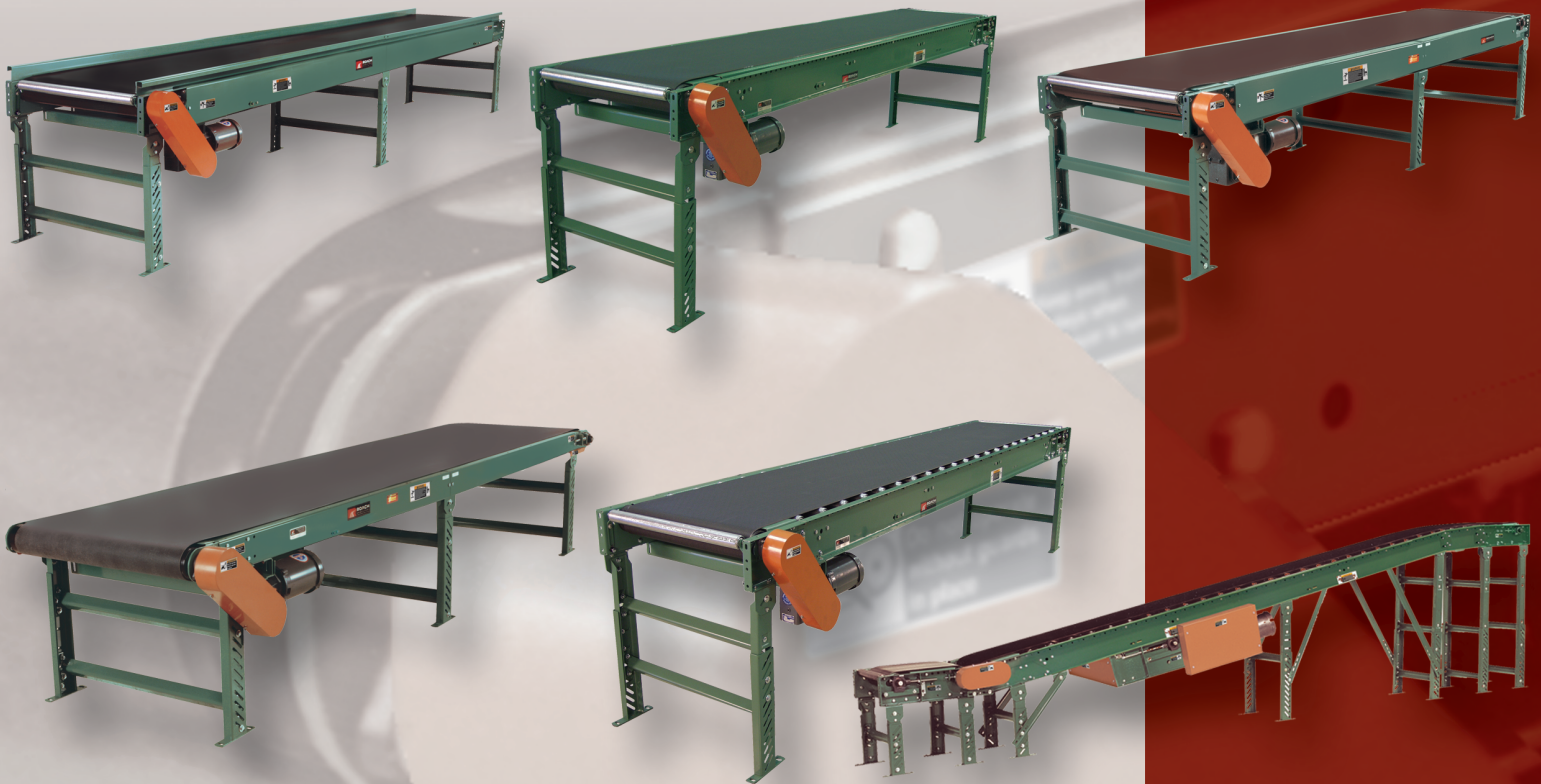




# OWNER'S MANUAL



Installing and Maintaining Your Roach Conveyor

## Belt Conveyors

Model 725TB • 700SB • 700BSB • 450BOS  
796RB • 751RB • 796RBF • 700SBF

DO NOT OPERATE BEFORE READING THIS HANDBOOK  
KEEP IN A SAFE PLACE – DO NOT DISCARD

# TECH HANDBOOK FOR 725TB/700SB/700BSB/450BOS 796RB/751RB/796RBF/700SBF

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## WARNING LABELS



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



ABOVE: Label placed near all pulleys (center drives, end drives, tail pulleys)

### ! WARNING

1. DO NOT walk, ride, climb or touch moving parts on a conveyor in operation.
2. DO NOT wear loose clothing or uncovered hair around conveyor in operation.
3. DO NOT operate a conveyor with chain or other protective guards removed.
4. DO NOT work near a conveyor without knowing how & where to shut power "OFF".
5. DO NOT remove jammed product with conveyor running.
6. DO NOT replace parts or perform maintenance on conveyor, or moving conveyor parts, without first shutting "OFF" power to conveyor.
7. DO NOT connect gravity to powered conveyor without gravity connector brackets.
8. TO PREVENT electrical shock, conveyor must be grounded and have proper electrical connections in accordance with federal, state and local codes.
9. SAFETY pop-out rollers must be retained when elevation is 7'-0" or above, but free to pop out at lower elevations.

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

# WARNING

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

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

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

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

### CAUTIONS, WARNINGS AND HAZARDS

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

### IMPORTANT SAFETY GUIDELINES

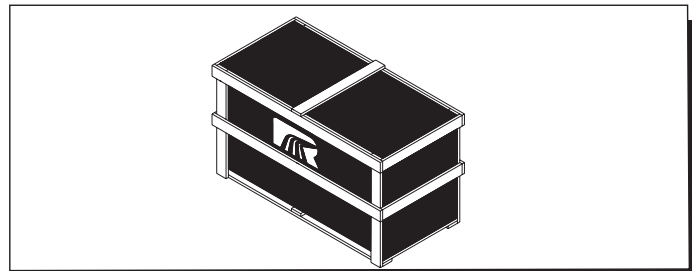
**Warning:** All personnel coming in contact with this conveyor should be aware of the following safety guidelines BEFORE USING OR WORKING AROUND CONVEYOR. Note: always notify Roach Manufacturing® whenever any conveyor is used in an application or condition other than was originally intended. Failure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

- ▲ Do not operate conveyor with protective guards removed. This includes chain guards, belt guards, snub roller guards, center drive guards and any other safety guard.
- ▲ Do not walk, ride, climb, or touch moving parts on a conveyor in operation.
- ▲ Do not wear loose clothing or uncovered hair around conveyor.
- ▲ Do not work near conveyor without knowing how & where to shut power "OFF" and lock out power source.
- ▲ Do not remove jammed product with conveyor running.
- ▲ Do not replace parts or perform maintenance on conveyor, or moving conveyor parts, without first shutting "OFF" power to conveyor and locking out power source.
- ▲ Do not connect gravity to powered conveyor without safety gravity connector brackets.
- ▲ To prevent electrical shock, conveyor must be grounded, and have proper electrical connections in accordance with federal, state, and local codes.
- ▲ Safety pop out rollers in conveyors installed above 7'-0" elevation must be retained by guard rail, clips, etc. Safety pop out rollers must be allowed to pop out when conveyors are installed at or below 7'-0" elevation.
- ▲ It is the responsibility of conveyor end-user to comply with all safety standards including OSHA and other federal, state, and local codes or regulations. Install protective guarding and other related safety precautionary equipment to eliminate hazardous operating conditions which may exist when two or more vendors supply machinery for related use.
- ▲ Any violation of above safety instructions hereby removes all product liability claims from Roach Manufacturing Corporation®.

# RECEIVING AND INSPECTION SHORTAGES, DAMAGES AND RETURN AUTHORIZATIONS

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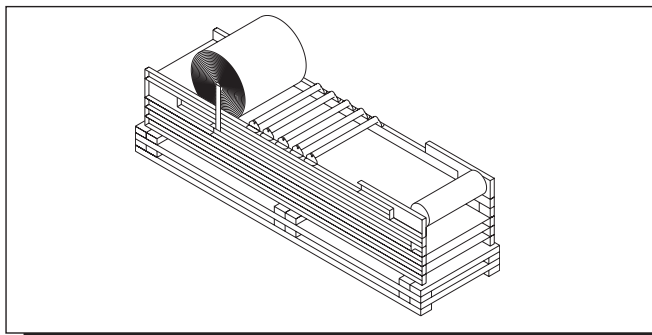
- Before uncrating, check the quantity of items received against bill of lading to confirm that all material has been received. Examine the condition of the equipment to determine if any damage has occurred.
- It is possible that some items may become separated from the original shipment. Therefore, when receiving goods, it is imperative that the bill of lading (or, accompanying freight documentation) be checked to ensure receipt of ALL units ordered including ALL accessories.
- Damage and/or shortage in shipment should be reported immediately to both vendor and carrier. Obtain a signed damage report from carrier agent and send copy to vendor.  
Do not repair any damage before obtaining this report.



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

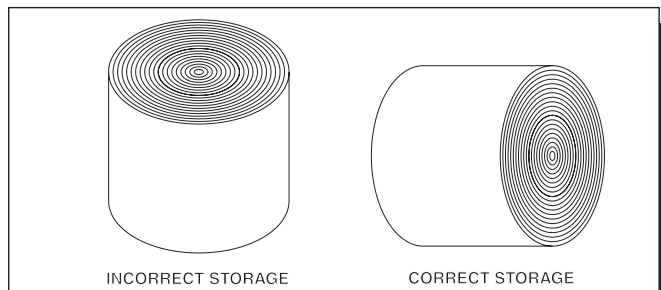
**Note: Do not return goods to factory without prior, written return authorization. Unauthorized returns are subject to refusal at factory.**

## UNCRATING AND STORAGE

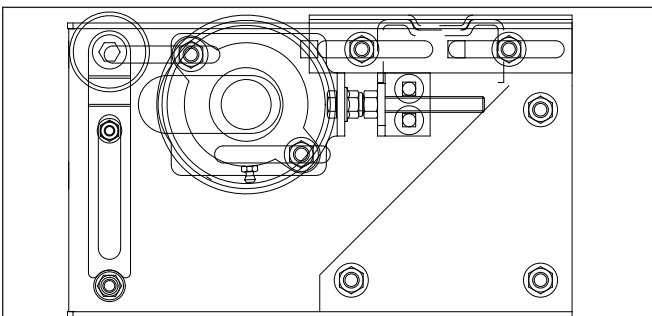


- Carefully remove crating and look for essential components and specific accessories that may have been boxed and attached (or 'banded') to crating material. Safety pop out rollers, guard rails and hardware are often packaged and shipped in this manner. Save all hardware for subsequent use by installation personnel.
- The drive section will be shipped mounted to its actual operating bed section (see illustration above). Intermediate bed sections are shipped mounted on top of drive bed section with formed steel stiffener (spacer) brackets.

- In illustration to the left, a model 700SB is shown palletized with belting and return rollers for all bed sections mounted to top of crate which is prepared for shipment.
- Some items (electric motors, gearbox, etc.) may be shipped direct from their manufacturer to final destination. Thus, the conveyor may consist of two or more separate shipments.
- Belting must be housed in dry quarters. Do not store belt on edge (see illustration below).
- Never Store belt placed directly on floor. Elevate to prevent contact with floor moisture.



## SAFETY POPOUT ROLLER STANDARD



Always leave popout roller (see illustration at left) in place when permanently attaching any gravity conveyor to power conveyor. Never connect powered belt conveyors directly to gravity conveyors without using the pop out roller.

**Never connect power belt conveyors to any other conveyor or equipment without the safety popout roller in place as shown at left.**



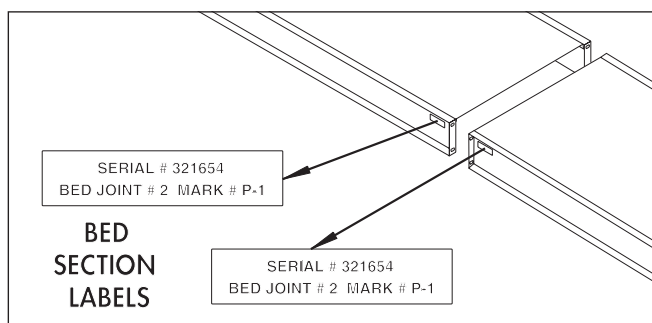
# GENERAL INSTALLATION INFORMATION

## ATTACHING BED SECTIONS

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When preparing to install conveyor:

- **Locate all component sections** in the actual installation area.
- **After uncrating, place unit bed sections conveying side up.** Each bed section is marked to indicate proper sequence for mating (see illustration for typical bed section labels).
- **It is critical for bed sections to be field assembled in proper sequence following bed section labels. Refer to bed section drawing for location of supports and assemble as shown.**
- **Conveyors are set up at the factory,** bed section labels are applied, unit is test run and receives rigorous quality assurance inspection. At this time the unit becomes field-ready. Therefore, it is critical that field installation personnel re-assemble unit by mating beds in accordance with bed section labels (and bed section drawing).



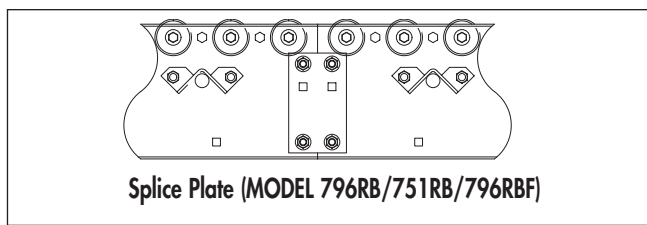
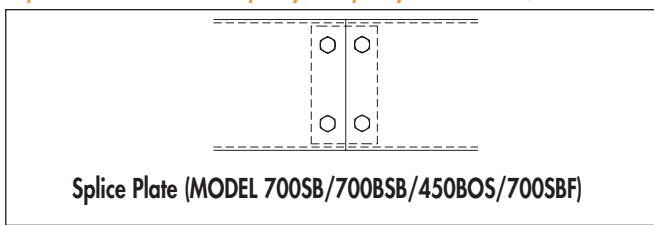
- **Create a reference base line on floor** by marking a chalk line along the center line of conveyor. Follow base line when installing unit.

## COUPLINGS AND UNIT SQUARENESS

- **Use mechanical hoist (fork truck or other available means) to raise bed sections to approximate installed elevation.** Mate intermediate sections with either butt couplings or splice plates to join bed sections (see illustration).
- **One of the most critical elements of proper installation is unit squareness. Check drive pulley, tail pulley, snub roller (if used in**

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

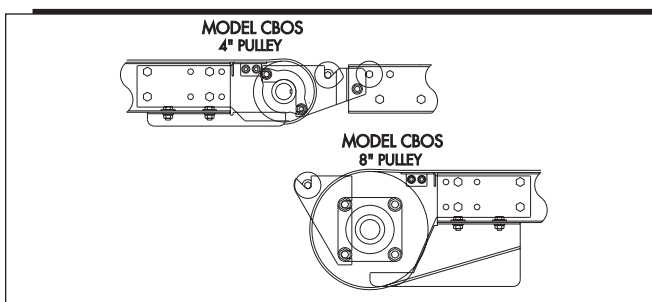
- The unit must be installed at level elevation across the width to prevent erratic belt tracking.



## SAFETY CONNECTOR BRACKETS (450BOS ONLY)

- Always use gravity connector bracket with pop out roller (see illustration) to permanently attach any gravity conveyor to 450 BOS conveyor.
- Never connect powered conveyors directly to gravity conveyors without using connector brackets with pop out roller.
- This simple connection eliminates hazardous pinch points that would otherwise exist by attaching a gravity conveyor directly to a powered belt unit.
- Connector Brackets are supplied as an optional component for the 450BOS.

- Connector brackets may not have been originally required for unit application, but they are readily available.



### WARNING

Never connect belt conveyors directly to gravity conveyors, machinery or fixtures without using connector brackets with pop out roller.

# INSTALLATION OF SUPPORTS

## IDENTIFYING/INSTALLING PERMANENT FLOOR SUPPORTS

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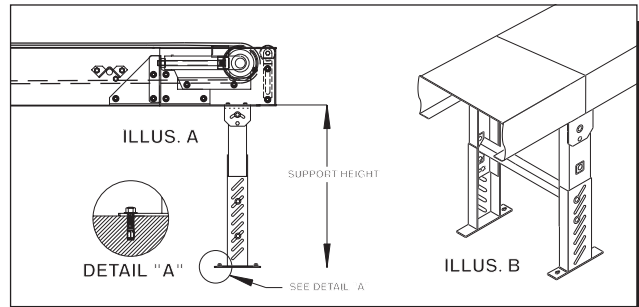
Permanent supports may be installed on conveyors at various locations. However, it is most common to use single tier permanent floor supports at each end of a powered section (see illustration A) and where intermediate bed sections are adjoined (see illustration B). Notice intermediate supports have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

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

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

Always anchor permanent supports to floor (or mounting surface).

Use 3/8" x 2-1/2" (or longer) wedge anchors for permanent installation in concrete flooring.



Supports are normally shipped at minimum support height.

### \*MINIMUM/MAXIMUM SUPPORT HEIGHT

|           |                 |             |                  |
|-----------|-----------------|-------------|------------------|
| SM-1..... | 7-1/4"-10-1/4"  | SM-7 .....  | 34-1/4"-46-1/4"  |
| SM-2..... | 10-1/4"-13-1/4" | SM-8 .....  | 46-1/4"-58-1/4"  |
| SM-3..... | 13-1/4"-16-1/4" | SM-9 .....  | 58-1/4"-70-1/4"  |
| SM-4..... | 16-1/4"-22-1/4" | SM-10 ..... | 70-1/4"-82-1/4"  |
| SM-5..... | 20-1/4"-26-1/4" | SM-11 ..... | 80-1/4"-92-1/4"  |
| SM-6..... | 24-1/4"-36-1/4" | SM-12 ..... | 92-1/4"-104-1/4" |

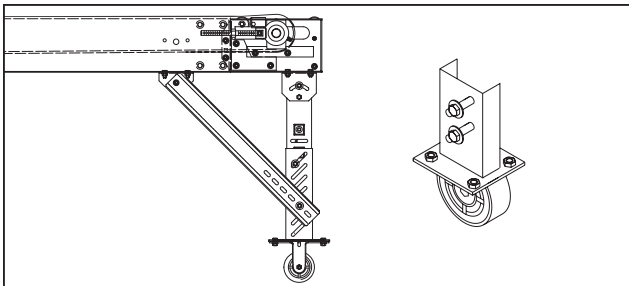
## WARNING

Always anchor permanent supports to floor (or mounting surface).

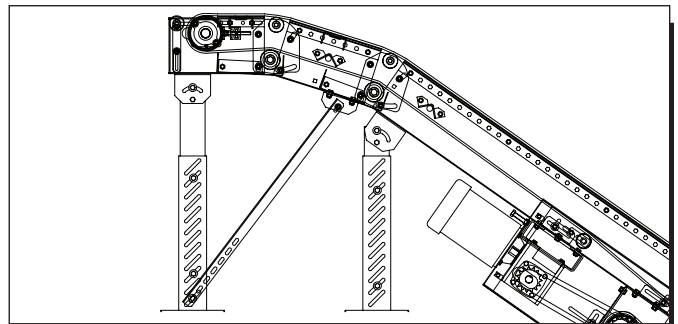
Use 3/8" x 2-1/2" (or longer) wedge anchors for permanent installation in concrete flooring.

## INSTALLING KNEE BRACES AND CASTERS

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



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



# POLYTIER SUPPORTS, CEILING HANGERS AND UNDERTRUSSING

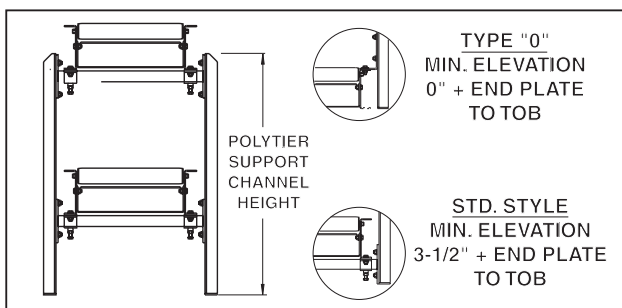
## INSTALLATION OF POLYTIER SUPPORTS

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Polytier supports provide convenient installation method for two or more tiers of conveyor. **To install, raise conveyor to desired elevation (approximate). Place 1" inside diameter cross pipe underneath lower conveyor flange. Attach cross pipe to upright legs. Use U-shaped retainer ("hat") bracket to connect cross pipe to lower conveyor flange. Do not tighten fully at this time.**

There are two styles of attachment brackets available for use with polytier supports. Minimum elevation style (see TYPE "0", illustration above) offers lowest unit elevation, 0" + frame depth utilizing L-shaped mounting bracket. Standard elevation style offers unit elevation of 3-1/2" + frame depth and includes bracket welded to cross pipe which is bolted to upright legs during installation.

When unit is at operating elevation and unit has been checked across width for level, tighten locking bolts in U-shaped bracket. Add knee braces for unit rigidity.



## INSTALLATION OF CEILING HANGERS

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

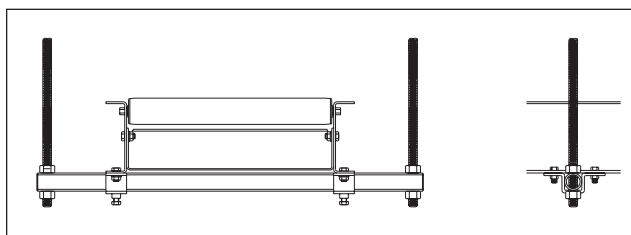
Attach and firmly tighten U-shaped retainer ("hat") bracket to underneath side of lower conveyor flange with hardware provided to hold cross pipe (1" inside diameter) against underneath side of conveyor.

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

To adjust conveyor elevation, tighten or loosen lower nut and jam nut on threaded suspension rods to desired elevation. A lock washer must be used on suspension rods to maintain unit at desired elevation.

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

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



## INSTALLATION OF UNDERTRUSSING

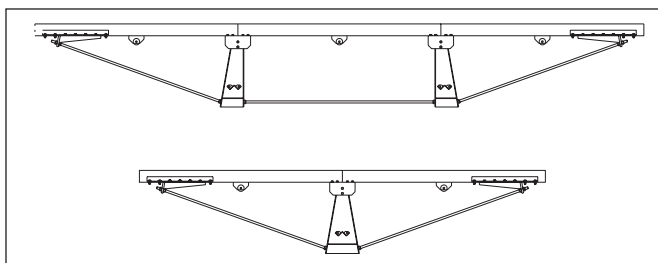
When installing some conveyors, using a permanent support or ceiling hanger is simply not practical. In this situation, three bed sections (maximum) may be joined together utilizing truss assembly, mounted underneath conveyor (see illustration at right).

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

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

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

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



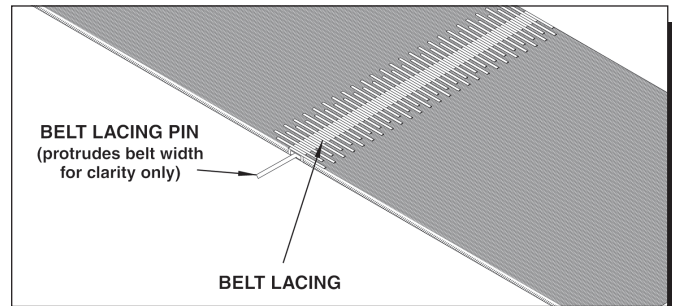
# INSTALLATION OF BELTING BELT CONNECTIONS

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- **Conveyor belting is cut to proper length, laced and assembled on conveyor at the factory.** It is test run and inspected before it is shipped to its final destination.
- **Before field installation of belting, it is critical to determine the correct side to be placed down.** One of the most common problems associated with belt installation involves placing the incorrect side down.
- **PVC belting is most commonly supplied as "COS" (cover one side).** The opposite side, or side to be placed down, is a friction surface for decreased friction and improved conveyability. The friction side appears dull and grainy. ALWAYS place this side down against the conveyor bed. The cover side is darker and shiny.
- **If unit is shipped "knocked down," belt must be re-threaded on unit during installation.** (See page 13-14 for proper belt paths.)

- **Join ends of belt as shown with lacing pin.** Loosen threaded take-up rods (if necessary) at take-up pulley equal amount on both sides and re-adjust when belt is installed keeping pulley square with conveyor bed. A belt puller can also be used to join belting.

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

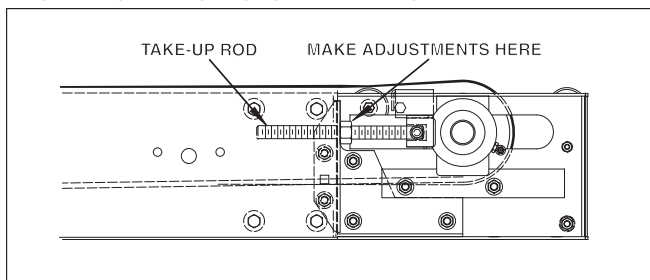


## MAINTAINING PROPER BELT TENSION

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

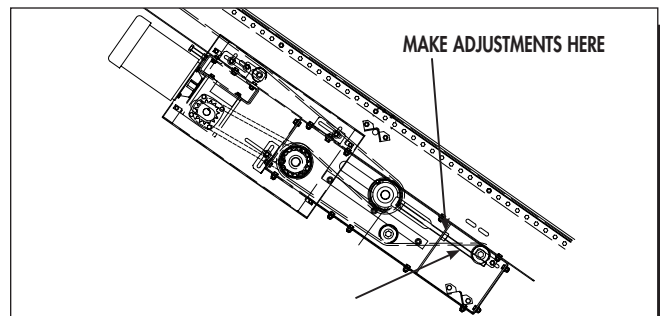
It is perfectly normal for a belt to stretch (in varying climatic conditions) under rated loading. Therefore, a short belt insert or "belt patch" (or patches) is provided for future removal when belting has stretched beyond means of conveyor take-up assembly. For yet additional belt take-up, the belt should be cut and re-laced to maintain proper belt tension.

To adjust conveyor take-up, adjust position of take-up rod (see illustration above)



as required. Remember to equally adjust both sides to hold take-up pulley square (to maintain unit squareness for belt tracking). Operating unit with slipping belt will decrease life of both belting and pulley lagging.

**Also, do not operate unit with too much tension on belt. This will decrease belt life and may harm unit drive and take-up bearings. Over tensioning belt requires additional horsepower from unit drive and can cause belt mistracking.**

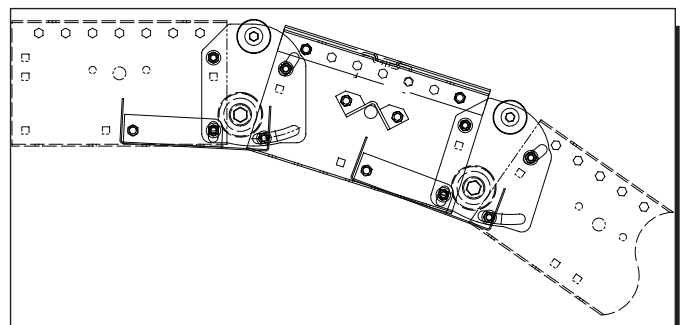


## NOSE-OVER AND SNUB ROLLER GUARD ADJUSTMENT

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

Beds are cut and nose-over brackets and rollers are installed at the factory. Before unit is ready for operation, final adjustment of snub roller assembly is required to ensure safe unit operation. Snub roller guard (cover) should be set (see illustration above) with 1/4" belt clearance between bottom of belt and top of guard, both sides of guard, during final installation.

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





# START-UP PROCEDURES

## DRIVE CHAIN AND SPROCKET ALIGNMENT

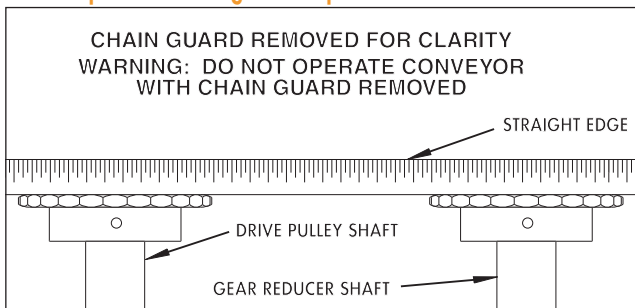
9

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

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

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

**Do not operate without guards in place.**



## DRIVE CHAIN AND SPROCKET TENSION

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

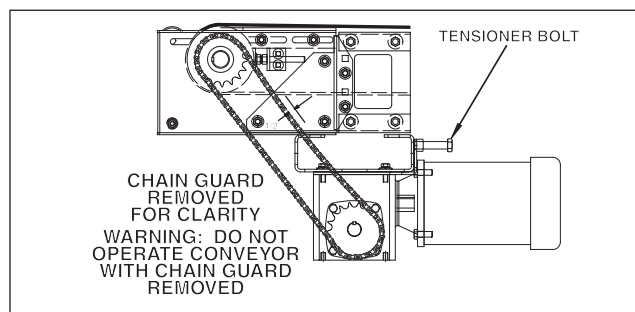
**Remember, before any adjustments are attempted, conveyor must be shut "OFF" and power source locked out.**

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

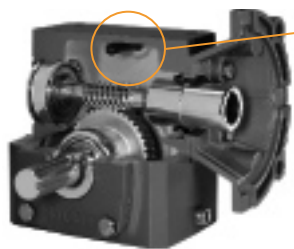
To adjust drive chain tension, tensioner bolt located on reducer push plate should be tightened (rotate clockwise) if chain tension is loose. Tighten until proper operating range is achieved. If chain tension is too tight, loosen tensioner bolt (rotate counterclockwise) as

required. When adjustment is complete replace chain guard cover.

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



## GEAR REDUCER WITH POSIVENT



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

**No vent plug required.**

## PREPARING FOR INITIAL START-UP

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

A routine maintenance program should be implemented before unit is placed into operation so that fundamental unit components are attended to. This maintenance program should include an inspection to ensure

that any dangerous or hazardous operating conditions are noted and IMMEDIATELY corrected, as well as including electrical and mechanical unit inspections and corrections.

Finally, when conveyor is initially started, an immediate visual inspection should include motor, gear reducer, belt tracking (discussed in following section under "Belt Tracking") and related adjustments noted in handbook

## ELECTRICAL CONTROLS

**Warn all personnel to keep clear of CONVEYOR during unit start-up**



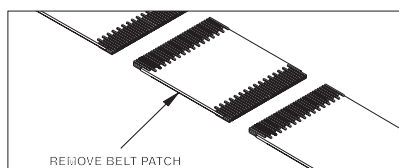
Electrical controls must be designed by a qualified electrical engineer to ensure that appropriate safety features (emergency stops, pull cords, switches, etc.) are installed on unit for safe operation.

# BELT TRACKING GENERAL INFORMATION

10

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

**ONLY trained personnel should make belt tracking adjustments.**



Belt must be tracked in both unloaded and loaded situations. The return direction of the belt must

clear supports, ceiling hangers, floor openings, etc. Dragging on such components will contribute to belt tracking problems and is certain to damage belting at extended intervals.

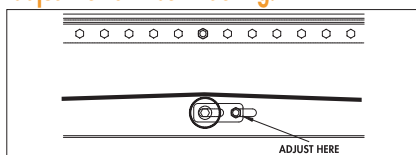
In a reversible application, a belt that runs off to one side in one direction will likely run off to the other side when operated in the opposite direction. Do not allow belt to rub against side of conveyor frame, which will surely damage belt.

## SKEWING RETURN ROLLERS

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

**ONLY trained personnel should make belt tracking adjustments. Shut unit "OFF" and**

**lock out power source before attempting adjustments in belt tracking.**



To adjust return rollers, simply loosen attachment bolt that secures bracket to the side of

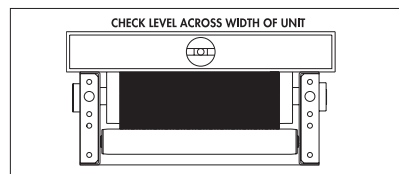
the conveyor (see illustration above). Move bracket to skew return roller assemblies (as noted in Advanced Tracking Adjustments later in manual). Remember to make adjustments in SMALL increments.

When adjustment is complete, tighten bolt firmly securing return roller bracket to the side of the conveyor.

## ERRATIC TRACKING AT START-UP

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

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



**with bed including drive pulley, tail pulley, snub roller and return rollers.** Both sides of take-up should be adjusted exactly the same amount. The conveyor should be level across

the width of the unit. Confirm that the belt has been properly threaded (see "Belt Path" section) and that belt lacing is square with the belt edges. Make adjustments as necessary; however, all adjustments should be made in small increments.

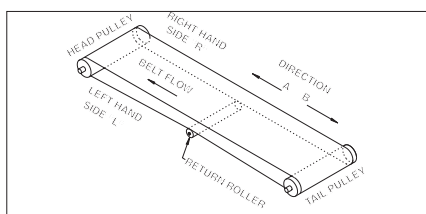
Start conveyor again and operate for at least ten minutes once initial phase of adjustments are complete. If belt continues to track erratically, turn unit "OFF" before belt is allowed to run so far off center that it rubs side of conveyor.

## ADVANCED TRACKING ADJUSTMENTS

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

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

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



toward side "L", skew return rollers in direction "A" to shift belting toward side "R".

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

belt toward side "R".

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

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

# MAINTENANCE SAFETY PRECAUTIONS BEFORE PERFORMING MAINTENANCE

11

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

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

**should be informed of the safety procedures associated with unit maintenance and performance.**

- Do not perform any work on conveyors or conveyor system while in operation unless it is impossible to otherwise conduct adjustment, lubrication or other maintenance function.
- Only experienced, trained personnel possessing advanced hazards-training should attempt such critical operations.

## MAINTENANCE AND FOLLOW-UP DETAILS

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

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

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

● After maintenance, conduct visual inspection to ensure that all safety devices and guards have been replaced. Confirm that all units are clear of tools, debris or other items. Before starting conveyor, check condition of conveyor warning labels (see "WARNING LABELS" at front of handbook). If labels have been destroyed or are not clearly legible, call 870.483.7631 to receive replacement labels. Placement of warning labels is critical to avoid unauthorized unit operation which may result in hazardous working conditions for all related personnel coming in contact with conveyor.

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

## MAINTENANCE PERIODIC MAINTENANCE SCHEDULE AND LUBRICATION

| WEEKLY RECOMMENDED MAINTENANCE SCHEDULE* |  |
|--|--|
| COMPONENT                                | DETAIL OF MAINTENANCE  |
| BELTING                                  | Inspect belt tracking  |
| PILLOW BLOCK / FLANGE BEARINGS           | Lubricate in dirty, dusty, or moist/wet conditions   |
| UNIT SAFETY CHECK                        | Confirm placement of all guards, pop-out rollers, warning labels & check for loose bolts, nip points & other hazards |

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

| MONTHLY RECOMMENDED MAINTENANCE SCHEDULE* |   |
|---|---|
| COMPONENT                                 | DETAIL OF MAINTENANCE   |
| GEAR REDUCER                              | Check for leaks   |
| BELTING                                   | Inspect belt tracking   |
| PILLOW BLOCK / FLANGE BEARINGS            | Lubricate in dirty, dusty, or moist/wet conditions            |
| DRIVE CHAIN                               | Check for proper operating tension & overall wear & lubricate |
| DRIVE SPROCKETS                           | Check for overall wear & re-tighten set screws                |

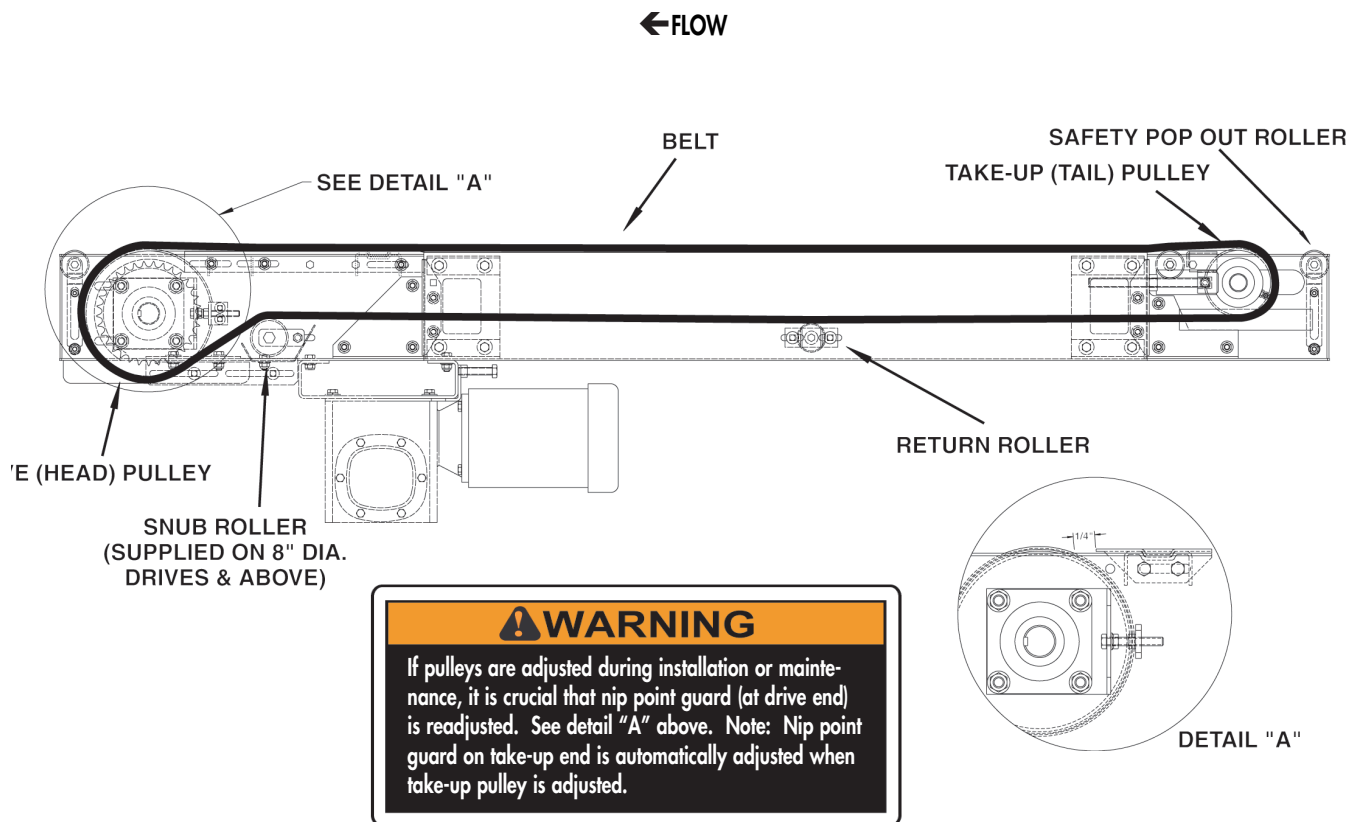
| MISC. LUBRICANTS**   |  |
|--|--|
| General Purpose Grease (For -30°F to 300°F operation)*   | Shell Dolium R (Shell Oil Co.) (or suitable equivalent)      |
| For Extreme Temperature Operation (-90°F to 350°F operation)*  | Mobiltemp SHC-32 (Mobil Oil Corp.) (or suitable equivalent)  |
| Washdown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

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

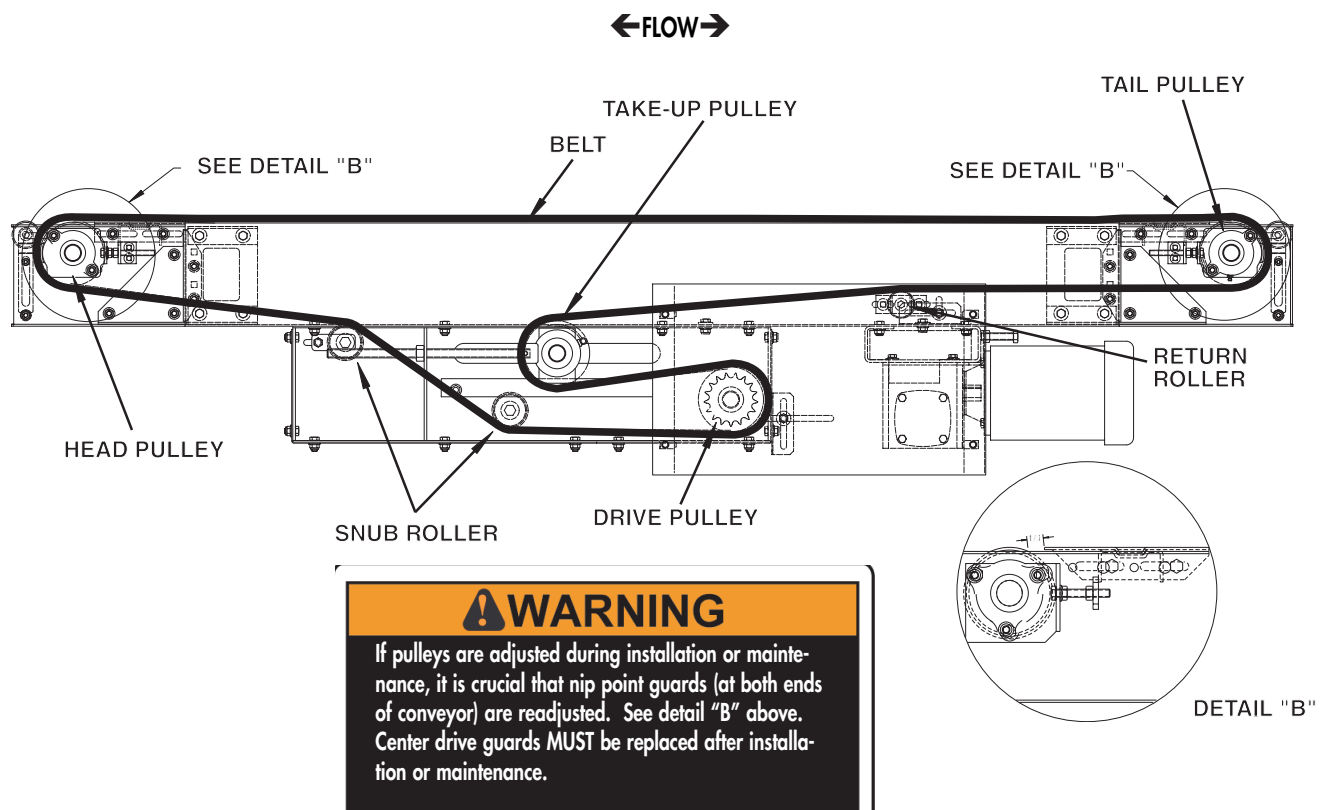
\*\*NOTE: Temperatures listed indicate the nominal operational temperature for the specific lubricant listed. This does not imply that the bearing housing, seals or any other conveyor unit component is rated to operate in this specific temperature range or environment. 250°F is the maximum operating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

# BELT PATH ILLUSTRATION FOR UNITS WITH END DRIVE

12



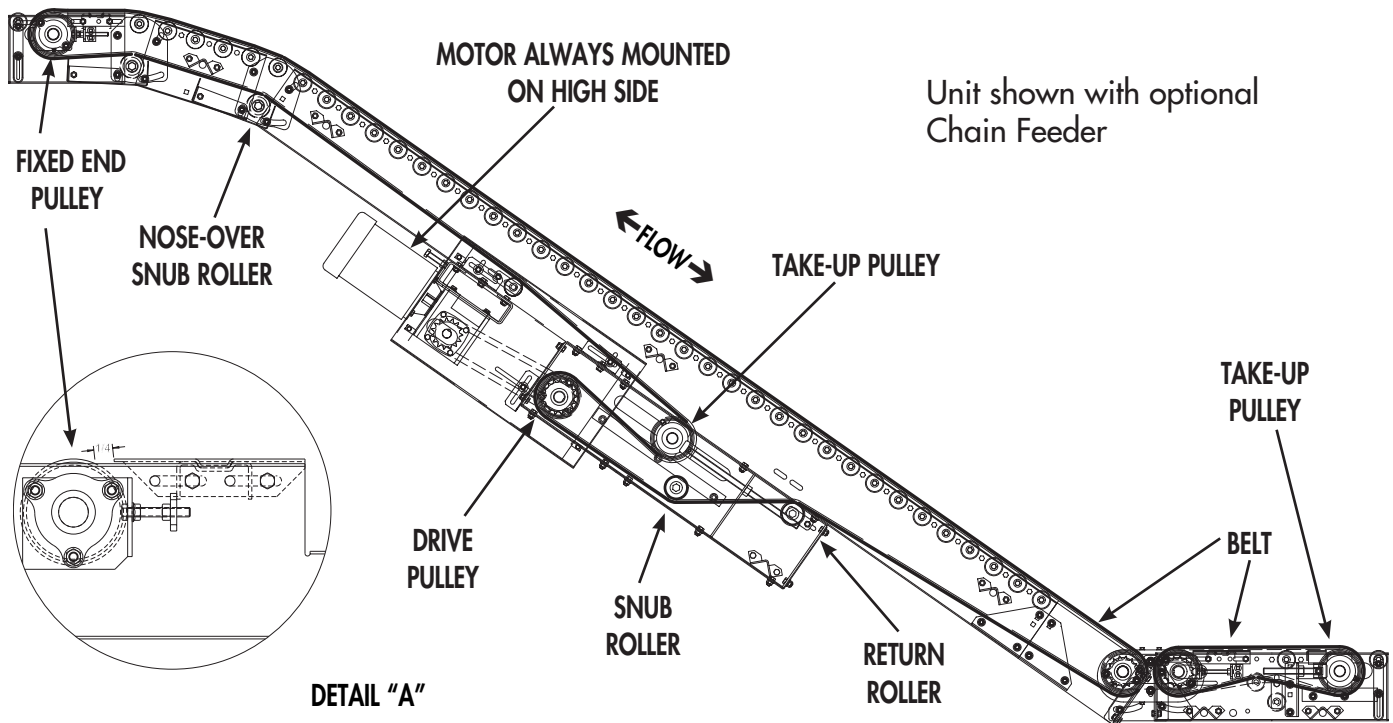
# ILLUSTRATION FOR UNITS WITH CENTER DRIVE





# BELT PATH ILLUSTRATION FOR INCLINE UNIT

13



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

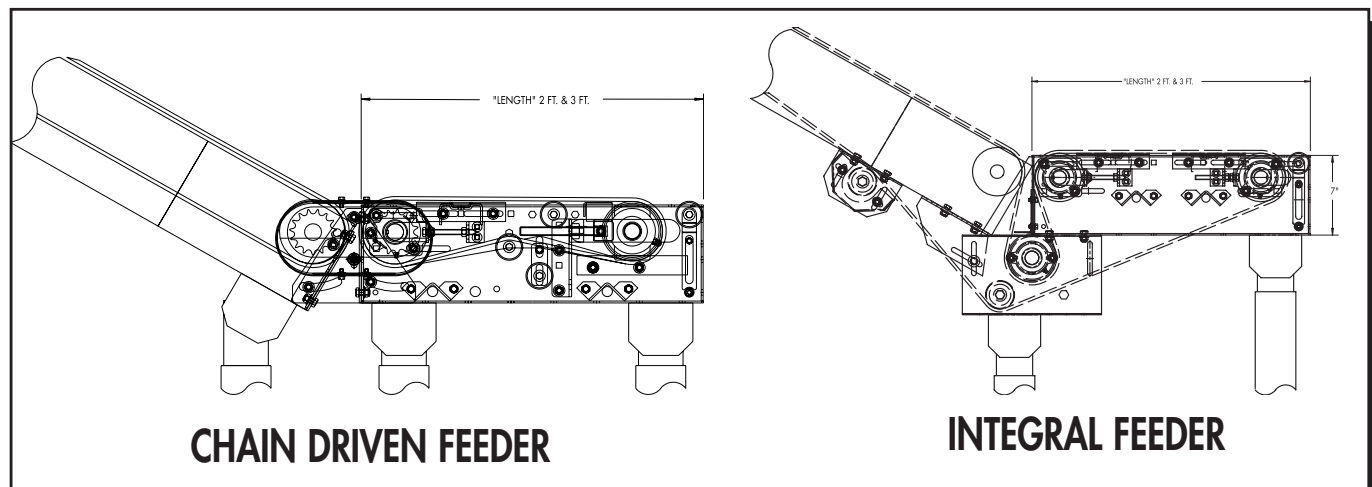
## CHAIN DRIVEN AND INTEGRAL FEEDERS

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

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

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

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



## MAINTENANCE AND LUBRICATION REPORT ON MISCELLANEOUS MAINTENANCE PERFORMED

14

[illegible]

# TROUBLE SHOOTING AND REPLACEMENT PARTS

## TROUBLE SHOOTING / SERIAL PLATE

15


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

### ORDERING REPLACEMENT PARTS

To order any replacement parts or when calling for assistance with any powered conveyor, **ALWAYS** provide the unit serial number. Shown at actual size, this aluminum plate is placed on the conveyor frame near the location of the drive assembly.

To order replacement parts or add-on components, contact the Roach distributor who originally furnished the unit if possible. If this is not possible, contact the National Sales Office at 870-483-7631 for the name of the authorized Roach distributor in your area. Have unit model number and serial number **BEFORE**

calling. Refer to unit drawings on the Roach Conveyors website ( <http://roachconveyors.com/belt-conveyor.htm> ) for part numbers if ordering replacement parts.

|  |        |  |
|--|--------|--|
|  |        | <b>ROACH CONVEYORS</b><br>808 HIGHWAY 463<br>TRUMANN, AR 72472<br>TEL 870-483-7631 |
| SERIAL NO.   | 123456 |  |

# MODEL 725TB PARTS LIST

16

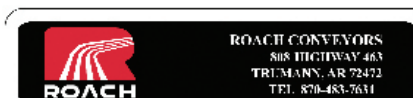
| ITEM # | DESCRIPTION                                 |
|--------|---|
| 1      | 725TB End Bed Section                       |
| 2      | Guard Rail Fastener Strap                   |
| 3      | Return Roller Bracket                       |
| 4      | Splice Plate                                |
| 5      | Bed Pan Brace Channel                       |
| 6      | 196S Roller Assembly                        |
| 7      | End Trough Bed                              |
| 8      | Intermediate Trough Bed                     |
| 9      | Box Type Bed                                |
| 10     | 725TB Full Length Bed Assembly              |
| 11     | End Trough Bed                              |
| 12     | 725TB Full Length Center Drive Bed Assembly |
| 13     | 725TB Intermediate Bed Assembly             |
| 14     | Intermediate Bed                            |
| 15     | End Take-up Assembly                        |
| 16     | 5/8" Diameter Take-up Rod                   |
| 17     | 1-3/16" Milled Take-up Bearing RH           |
| 18     | 1-3/16" Milled Take-up Bearing LH           |
| 19     | 5/16" - 18 x 2" Hex Flange HCS              |
| 20     | 5/16" - 18 Nylon Insert Locknut             |
| 21     | 1/4" Flat Washers                           |
| 22     | 5/8" - 11 Hex Nut                           |
| 23     | Safety Pop-out Roller Assembly              |
| 24     | Take-up Bearing Guide                       |
| 25     | Bolt-in Butt Coupling                       |
| 26     | Take-up Bed Joint Mounting Angle            |
| 27     | Idler Pulley Assembly                       |
| 28     | Take-up Plate                               |
| 29     | Bearing Guide Spacer                        |
| 30     | Top Take-up Bearing Guide                   |
| 31     | 5/16" Flat Washer                           |
| 32     | Fixed End Assembly                          |
| 33     | Safety Pop-out Roller Assembly              |
| 34     | Bolt-in Butt Coupling                       |
| 35     | Bearing Take-up Mounting Angle              |
| 36     | Bearing Push Plate                          |
| 37     | Bed Joint Mounting Angle                    |
| 38     | Idler Pulley Assembly                       |
| 39     | Fixed End & Drive Plate Assembly            |
| 40     | 2-Hole Flange Bearing w/ 1-3/16" Bore       |

| ITEM # | DESCRIPTION                            |
|--------|--|
| 43     | Bolt-in Butt Coupling                  |
| 44     | Bearing Take-up Mounting Angle         |
| 45     | Bearing Push Plate                     |
| 46     | Bed Joint Mounting Angle               |
| 47     | Drive Pulley Assembly                  |
| 48     | Fixed End & Drive Plate Assembly       |
| 49     | 4 Hole Flanged Bearing w/ 1-7/16" Bore |
| 50     | 2.5 Roller Keeper                      |
| 51     | 251S Roller Assembly                   |
| 52     | Belt Guards                            |
| 53     | Snub Roller Belt Guard                 |
| 54     | Center Drive Assembly                  |
| 55     | 2.5 Roller Keeper                      |
| 56     | Center Drive Take-up Bearing Guide     |
| 57     | (Milled) Take-up Bearing Assembly      |
| 58     | 251S Roller Assembly                   |
| 59     | Center Drive Plate Weld Assembly       |
| 60     | Drive Pulley                           |
| 61     | Idler Pulley Assembly                  |
| 62     | Center Drive Belt Guard                |
| 63     | Center Drive Belt Guard                |
| 64     | Frame Crossbrace                       |
| 65     | 4 Hole Flange Bearing w/ 1-15/16" Bore |
| 66     | 3 Hole Flange Bearing w/ 1-3/16" Bore  |
| 67     | Belting Assembly                       |
| 68     | Sidemount Drive Kit                    |
| 69     | Motorbase Stiffener Assembly (1HP+)    |
| 70     | Reducer Push Plate Assembly            |
| 71     | Sidemount Motorbase Plate              |
| 72     | Sidemount Chain Guard Assembly         |
| 73     | End Drive Kit                          |
| 74     | Motorbase Stiffener Assembly           |
| 75     | Chain Guard Mounting Angle             |
| 76     | Reducer Push Plate Assembly            |
| 77     | Underneath Motorbase Plate             |
| 78     | Chain Guard Assembly                   |
| 79     | Center Drive Kit                       |
| 80     | Motorbase Stiffener Assembly (1HP+)    |
| 81     | Reducer Push Plate Assembly            |

Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 15).

Recommended Spare Parts are shown in red. Charted are item numbers and part descriptions. When ordering use example below.

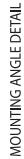
Example: Need a replacement End Take-up Assembly for a 725TB.  
Part No: SN 123456 - 15 - End Take-up Assembly



SERIAL NO. 123456



## 17



# MODEL 700SB PARTS LIST

18

| ITEM # | DESCRIPTION                            |
|--------|--|
| 1      | 700SB Intermediate Bed Assembly        |
| 2      | 1.9 Roller Keeper                      |
| 3      | Splice Plate                           |
| 4      | Bed Pan Brace Channel                  |
| 5      | 196S Roller Assembly                   |
| 6      | Slider Bed Pan                         |
| 7      | Medium Duty Side Channel               |
| 8      | Frame Crossbrace                       |
| 9      | End Take-up Assembly                   |
| 10     | 5/8" Diameter Take-up Rod              |
| 11     | Safety Pop-out Roller Assembly         |
| 12     | Take-up Bearing Guide                  |
| 13     | Bolt-in Butt Coupling                  |
| 14     | Take-up Bed Joint Mounting Angle       |
| 15     | Take-up Filler Pan                     |
| 16     | Idler Pulley Assembly                  |
| 17     | 196S Roller Assembly                   |
| 18     | Take-up Plate                          |
| 19     | Bearing Guide Spacer                   |
| 20     | Top Take-up Bearing Guide              |
| 21     | Fixed End Assembly                     |
| 22     | Safety Pop-out Roller Assembly         |
| 23     | Bearing Take-up Mounting Angle         |
| 24     | Bed Pan Brace Channel                  |
| 25     | Bearing Push Plate                     |
| 26     | Bed Joint Mounting Angle               |
| 27     | Idler Pulley Assembly                  |
| 28     | Fixed End & Drive Plate Assembly       |
| 29     | Filler Pan                             |
| 30     | 4 Hole Flanged Bearing w/ 1-7/16" Bore |
| 31     | End Drive Assembly                     |
| 32     | Safety Pop-out Roller Assembly         |
| 33     | Bearing Take-up Mounting Angle         |
| 34     | Bed Pan Brace Channel                  |
| 35     | Bearing Push Plate                     |
| 36     | Bed Joint Mounting Angle               |

| ITEM # | DESCRIPTION                             |
|--------|---|
| 38     | Fixed End & Drive Plate Assembly        |
| 39     | Filler Pan                              |
| 40     | 4 Hole Flange Bearing w/1-7/16" Bore    |
| 41     | 2.5 Roller Keeper                       |
| 42     | Belt Guard                              |
| 43     | Snub Roller Belt Guard                  |
| 44     | 251S Roller Assembly                    |
| 45     | Center Drive Assembly                   |
| 46     | 2.5 Roller Keeper                       |
| 47     | Center Drive Take-up Bearing Guide      |
| 48     | (Milled) Take-up Bearing Assembly LH/RH |
| 49     | 251S Roller Assembly                    |
| 50     | Center Drive Plate Weld Assembly        |
| 51     | Drive Pulley Assembly                   |
| 52     | Idler Pulley Assembly                   |
| 53     | Center Drive Belt Guard                 |
| 54     | Center Drive Belt Guard                 |
| 55     | Frame Crossbrace                        |
| 56     | 4 Hole Flanged Bearing w/1-7/16" Bore   |
| 57     | 3 Hole Flanged Bearing w/1-3/16" Bore   |
| 58     | Belting Assembly                        |
| 59     | Sidemount Drive Kit                     |
| 60     | Motorbase Stiffener Assembly (1HP+)     |
| 61     | Reducer Push Plate Assembly             |
| 62     | Sidemount Motorbase Plate               |
| 63     | Sidemount Chain Guard Assembly          |
| 64     | End Drive Kit                           |
| 65     | Motorbase Stiffener Assembly (1HP+)     |
| 66     | Chain Guard Angle Mount                 |
| 67     | Reducer Push Plate Assembly             |
| 68     | Underneath Motorbase Plate              |
| 69     | Chain Guard Assembly                    |
| 70     | Center Drive Kit                        |
| 71     | Motorbase Stiffener Assembly (1HP+)     |
| 72     | Reducer Push Plate Assembly             |
| 73     | Underneath Motorbase Plate              |

Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 15).

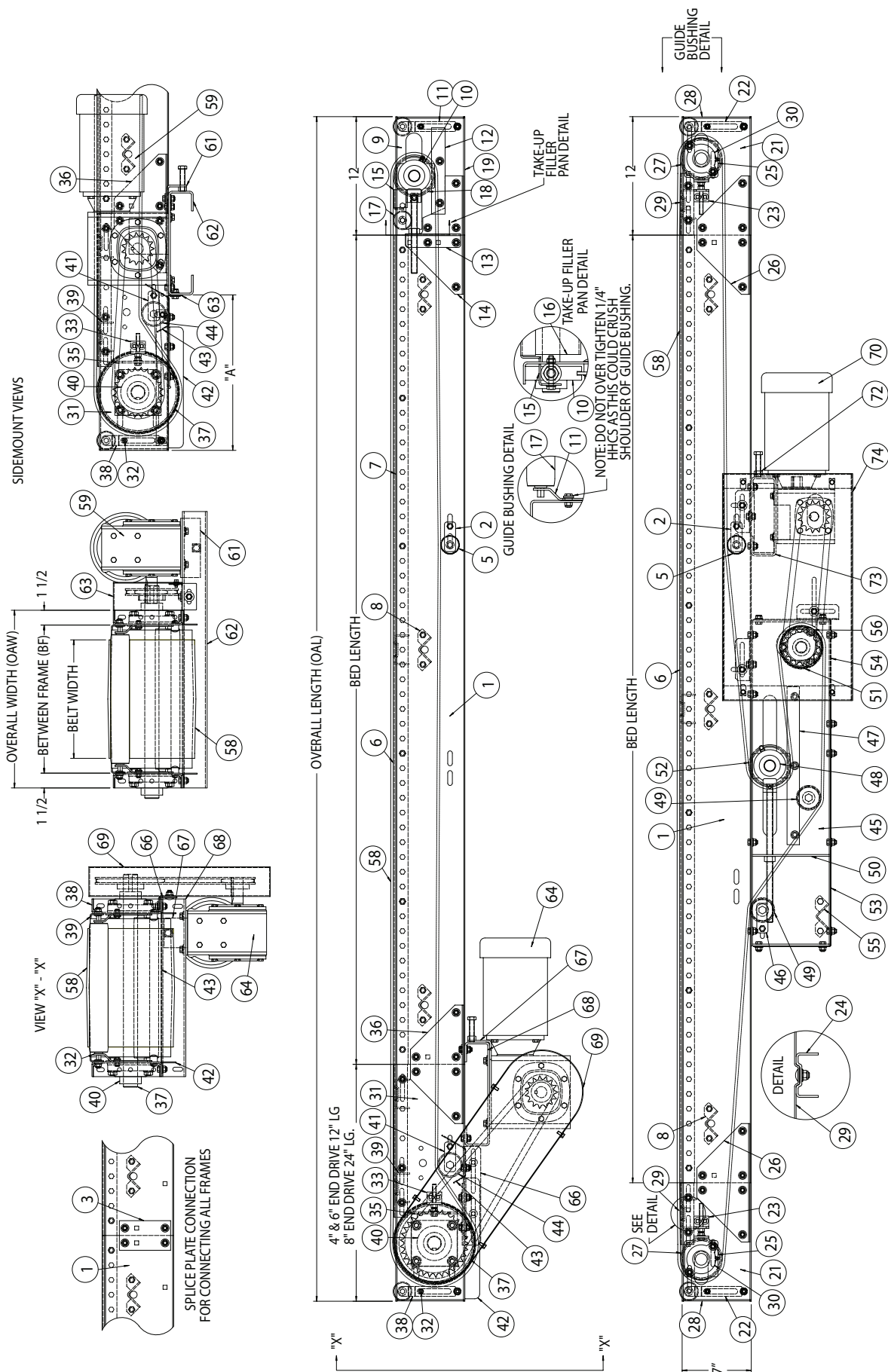
Recommended Spare Parts are shown in red. Charted are item numbers and part descriptions. When ordering use example below.

Example: Need a replacement Drive Pulley Assembly for a 700SB.  
Part No: SN 123456 - 51 - Drive Puller Assembly



SERIAL NO. 123456

## 19



# MODEL 700BSB PARTS LIST

20

| ITEM # | DESCRIPTION                            |
|--------|--|
| 1      | 700BSB Intermediate Bed Assembly       |
| 2      | Return Roller Bracket                  |
| 3      | Splice Plate                           |
| 4      | 196S Roller Assembly                   |
| 5      | 700 Box Type Bed Section               |
| 6      | Bed Pan Brace Channel                  |
| 7      | 700 Box Side Channel                   |
| 8      | Bed Pan                                |
| 9      | Frame Crossbrace                       |
| 10     | End Take-up Assembly                   |
| 11     | 5/8" Diameter Take-up Rod              |
| 12     | Safety Pop-out Roller Assembly         |
| 13     | Take-up Bearing Guide                  |
| 14     | Bolt-in Butt Coupling                  |
| 15     | Take-up Bed Joint Mounting Angle       |
| 16     | Take-up Filler Pan                     |
| 17     | Idler Pulley Assembly                  |
| 18     | 196S Roller Assembly                   |
| 19     | Take-up Plate                          |
| 20     | Bearing Guide Spacer                   |
| 21     | -                                      |
| 22     | Fixed End Assembly                     |
| 23     | Safety Pop-out Roller                  |
| 24     | Bolt-in Butt Coupling                  |
| 25     | Bearing Take-up Mounting Angle         |
| 26     | Bed Pan Brace                          |
| 27     | Bearing Push Plate                     |
| 28     | Bed Joint Mounting Angle               |
| 29     | Idler Pulley Assembly                  |
| 30     | Fixed End & Drive Plate Assembly       |
| 31     | Filler Pan                             |
| 32     | 4 Hole Flanged Bearing w/ 1-7/16" Bore |
| 33     | End Drive Assembly                     |
| 34     | Safety Pop-out Roller Assembly         |
| 35     | Bolt-in Butt Coupling                  |
| 36     | Bearing Take-up Mounting Angle         |
| 37     | Bed Pan Brace                          |
| 38     | Bearing Push Plate                     |

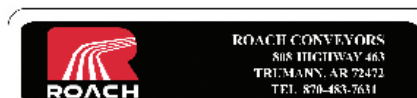
| ITEM # | DESCRIPTION                             |
|--------|---|
| 40     | Drive Pulley Assembly                   |
| 41     | Fixed End & Drive Plate Assembly        |
| 42     | Filler Pan                              |
| 43     | 4 Hole Flanged Bearing w/ 1-7/16" Bore  |
| 44     | 2.5 Roller Keeper                       |
| 45     | Belt Guard                              |
| 46     | Snub Roller Belt Guard                  |
| 47     | 251S Roller Assembly                    |
| 48     | Center Drive Assembly                   |
| 49     | 2.5 Roller Keeper                       |
| 50     | Center Drive Take-up Bearing Guide      |
| 51     | (Milled) Take-up Bearing Assembly LH/RH |
| 52     | 251S Roller Assembly                    |
| 53     | Center Drive Plate Weld Assembly        |
| 54     | Drive Pulley Assembly                   |
| 55     | Idler Pulley Assembly                   |
| 56     | Center Drive Belt Guard                 |
| 57     | Center Drive Belt Guard                 |
| 58     | Frame Crossbrace                        |
| 59     | 4 Hole Flanged Bearing w/ 1-7/16" Bore  |
| 60     | 3 Hole Flanged Bearing w/ 1-3/16" Bore  |
| 61     | Belting Assembly                        |
| 62     | Sidemount Drive Kit                     |
| 63     | Motorbase Stiffener Assembly (1HP+)     |
| 64     | Reducer Push Plate Assembly             |
| 65     | Sidemount Motorbase Plate               |
| 66     | Sidemount Chain Guard Assembly          |
| 67     | End Drive Kit                           |
| 68     | Motorbase Stiffener Assembly (1HP+)     |
| 69     | Chain Guard Angle Mount                 |
| 70     | Reducer Push Plate Assembly             |
| 71     | Underneath Motorbase Plate              |
| 72     | Chain Guard Assembly                    |
| 73     | Center Drive Kit                        |
| 74     | Motorbase Stiffener Assembly (1HP+)     |
| 75     | Reducer Push Plate Assembly             |

Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 15).

Recommended Spare Parts are shown in red. Charted are item numbers and part descriptions. When ordering use example below.

Example: Need a replacement Center Drive Chain Guard Assembly for a 700BSB.

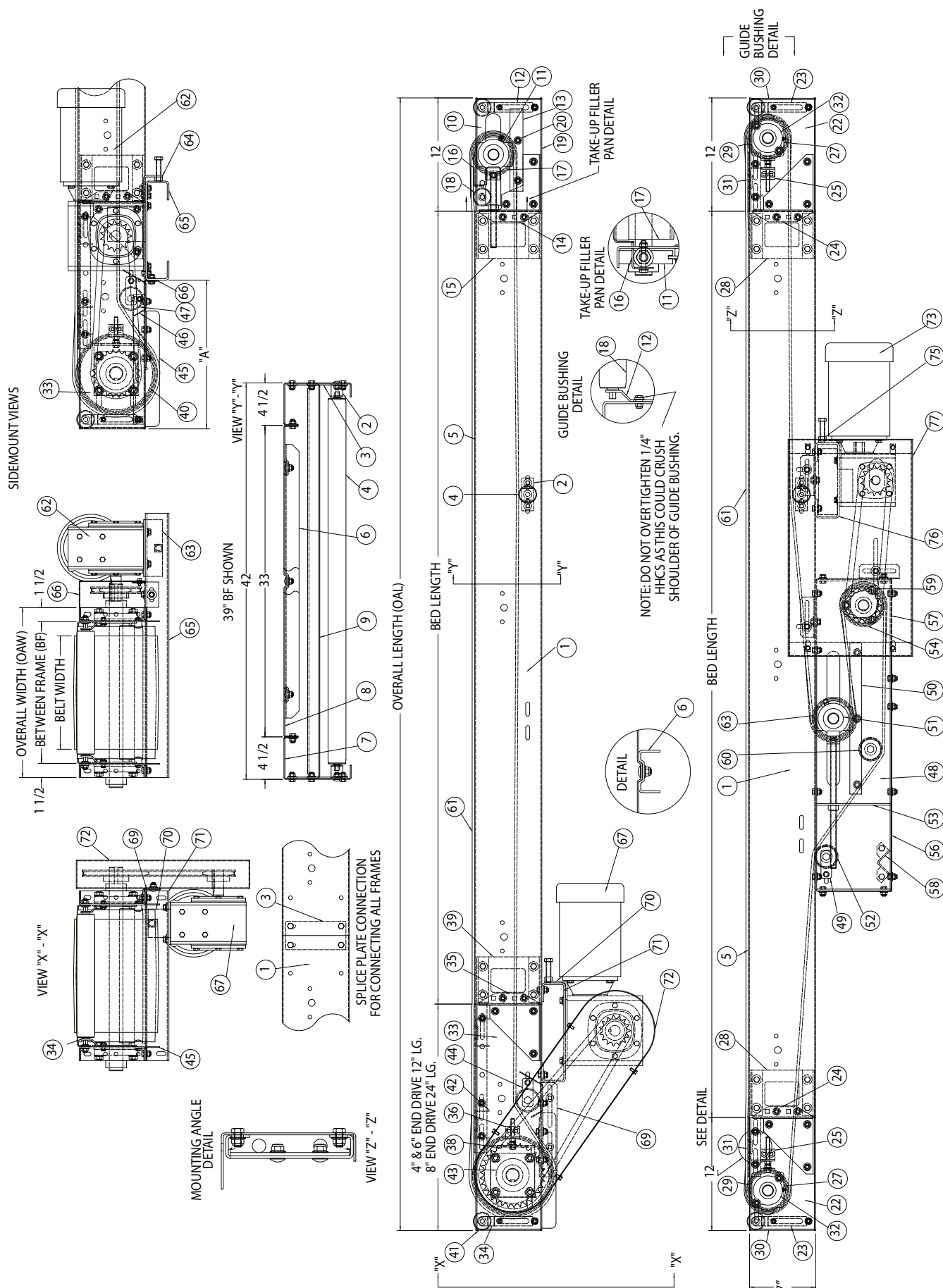
Part No: SN 123456 - 77 - C/D Chain Guard Assembly



SERIAL NO. 123456



## 21



# MODEL 450BOS PARTS LIST

22

| ITEM # | DESCRIPTION   |
|--------|---|
| 1      | End Bed Assembly  |
| 2      | 1.9 Return Roller Bracket                                 |
| 3      | 196S Roller Assembly                                      |
| 4      | Splice Plate  |
| 5      | 450 Box Type End Bed                                      |
| 6      | Bed Pan Brace Channel                                     |
| 7      | Full Length Bed Assembly                                  |
| 8      | Intermediate Bed Assembly                                 |
| 9      | 196 Snub Roller Guard<br>(4" Fixed, End Drive, & Take-up) |
| 10     | 196 Snub Roller Guard<br>(4" Sidemount Drive)             |
| 11     | 4" End Take-up Assembly                                   |
| 12     | 4" Round Style Take-up Plate                              |
| 13     | 4" Round Style Take-up Plate                              |
| 14     | 4" Idler Pulley Assembly                                  |
| 15     | Filler Pan (Universal)                                    |
| 16     | Bolt-on Take-up Plate                                     |
| 17     | 2 Hole Flanged Bearing                                    |
| 18     | Take-up Bolt 1/2" - 13 x 6" LG.                           |
| 19     | 4" Fixed End Assembly                                     |
| 20     | 4" Round Style Fixed End Plate                            |
| 21     | 4" End Drive Assembly                                     |
| 22     | 4" Drive Pulley Assembly                                  |
| 23     | 8" End Drive Assembly                                     |
| 24     | 8" Fixed End & Drive Plate                                |
| 25     | 2.5 Return Roller Bracket                                 |
| 26     | 251S Roller Assembly                                      |
| 27     | Snub Roller Guard for 8" Drives                           |
| 28     | 8" Drive Pulley Assembly                                  |
| 29     | Filler Pan (8" End Drives)                                |
| 30     | 4 Hole Flanged Bearing                                    |
| 31     | 4" Center Drive Assembly                                  |
| 32     | 2.5 Roller Keeper   |
| 33     | Center Drive Bearing Guide                                |
| 34     | Take-up Bearing Assembly (LH)                             |

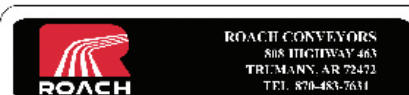
| ITEM # | DESCRIPTION                               |
|--------|---|
| 35     | Take-up Bearing Assembly (RH)             |
| 36     | 251S Roller Assembly                      |
| 37     | 4" Center Drive Plate (LH)                |
| 38     | 4" Center Drive Plate (RH)                |
| 39     | 4" Drive Pulley Assembly                  |
| 40     | 4" Idler Pulley Assembly                  |
| 41     | 4" Center Drive Belt Guard                |
| 42     | 4" Center Drive Belt Guard                |
| 43     | Frame Crossbrace                          |
| 44     | 3 Hole Flanged Bearing                    |
| 45     | Bearing Guide Spacer                      |
| 46     | 8" Center Drive Plate (LH)                |
| 47     | 8" Center Drive Plate (RH)                |
| 48     | 8" Drive Pulley Assembly                  |
| 49     | 8" Center Drive Belt Guard                |
| 50     | 8" Center Drive Belt Guard                |
| 51     | 4 Hole Flanged Bearing                    |
| 52     | Belting Assembly                          |
| 53     | Gear Reducer                              |
| 54     | Motor                                     |
| 55     | Sidemount Drive Assembly                  |
| 56     | Motorbase Stiffener Assembly (1HP+)       |
| 57     | Motorbase Spacer 8" End Drive             |
| 58     | Reducer Push Plate Assembly               |
| 59     | Side Mount Motorbase Plate                |
| 60     | Side Mount Chain Guard Assembly           |
| 61     | Underneath Mount Drive Assembly           |
| 62     | Underneath Mount Motorbase Plate          |
| 63     | Reducer Push Plate Assembly               |
| 64     | Guard Mounting Bracket                    |
| 65     | Underneath Mount Chain Guard              |
| 66     | Drive Assembly for Center Drive           |
| 67     | Center Drive Chain Guard Mounting Bracket |
| 68     | Center Drive Chain Guard Assembly         |

Specify Unit Serial Number when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 15).

Recommended Spare Parts are shown in red. Charted are item numbers and part descriptions. When ordering use example below.

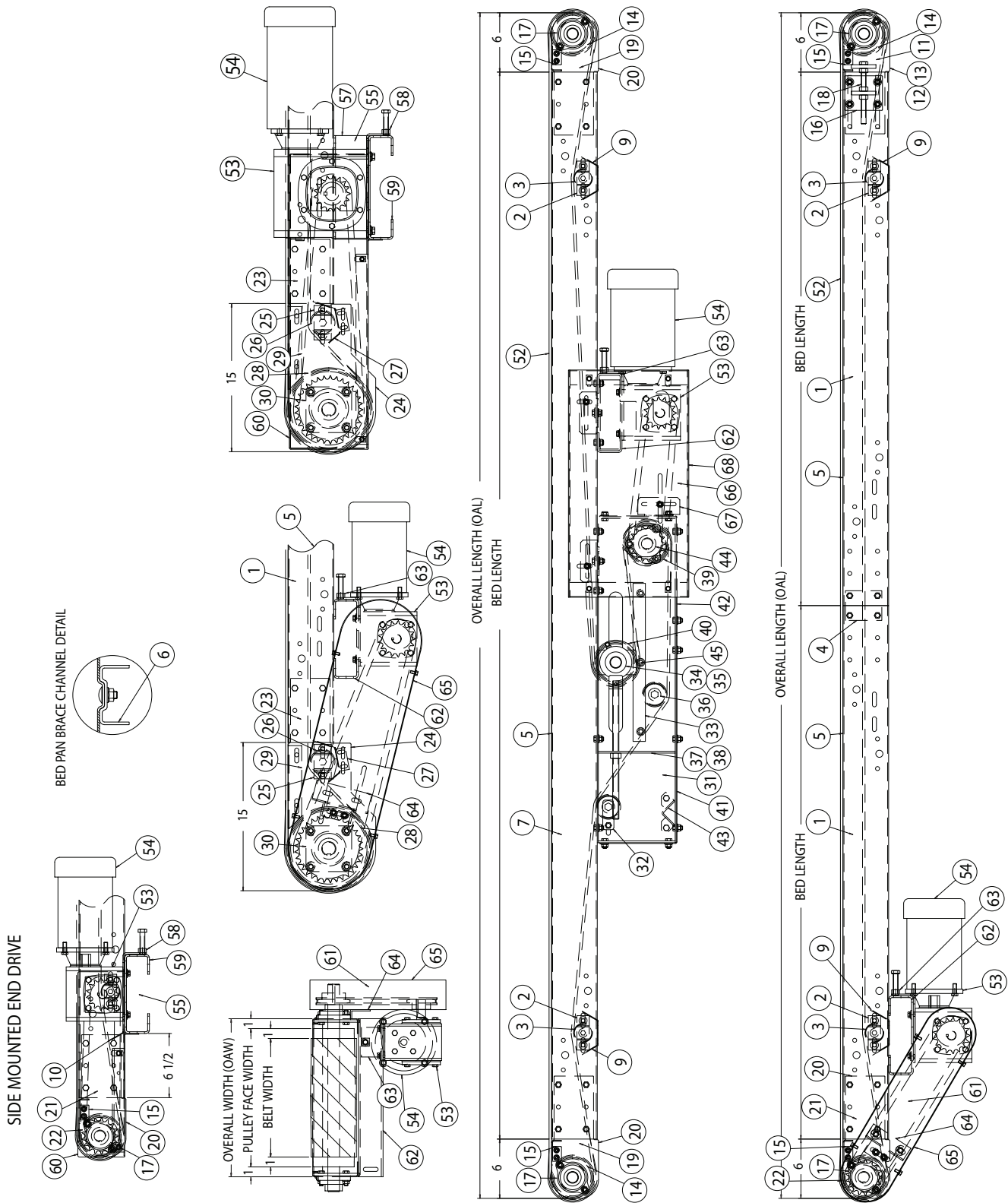
Example: Need a replacement Return Roller Bracket for a 450BOS.

Part No: SN 123456 - 2 - 1.9 Return Roller Bracket



SERIAL NO. 123456

# MODEL 450BOS END DRIVE, END SIDE MOUNT DRIVE & CENTER DRIVE DRAWINGS



## !WARNING

Use connector bracket with safety pop out roller to permanently attach gravity conveyor sections to 450BOS

# MODEL 796RB

## PARTS LIST

| ITEM # | DESCRIPTION                                     | ITEM # | DESCRIPTION                                     |
|--------|---|--------|---|
| 1      | 796RB Intermediate Bed Section                  | 26     | 6" Fixed & End Drive Plate (LH/RH)              |
| 2      | 1.9 Roller Keeper                               | 27     | Filler Pan                                      |
| 3      | Splice Plate                                    | 28     | 4 Hole Flange Bearing w/1-7/16" Bore (BRW04070) |
| 4      | 196S Roller Assembly                            | 29     | 4" End Drive Assembly                           |
| 5      | Side Channel (12"-120")                         | 30     | Safety Pop-Out Roller Assembly                  |
| 6      | Frame Crossbrace                                | 31     | Bearing Take-Up Mounting Angle                  |
| 7      | 4" End Take-Up Assembly                         | 32     | Bearing Push Plate                              |
| 8      | Take-Up Bearing Assembly                        | 33     | Bed Pan Brace (For 27"BF and above)             |
| 9      | Safety Pop-Out Roller Assembly                  | 34     | Bed Joint Mounting Angle                        |
| 10     | 4" Take-Up Bearing Guide                        | 35     | 4" Drive Pulley Assembly                        |
| 11     | Bolt-In Butt Coupling                           | 36     | 4" Fixed & End Drive Plate (LH/RH)              |
| 12     | 4" Take-Up Bed Joint (Left Hand/Right Hand)     | 37     | Filler Pan                                      |
| 13     | 4" Take-Up Filler Pan Assembly                  | 38     | 2 Hole Flange Bearing w/1-3/16" Bore (BRW04014) |
| 14     | 4" Idler Pulley Assembly                        | 29     | 6" Drive End Assembly                           |
| 15     | 196S Roller Assembly                            | 30     | Safety Pop-Out Roller Assembly                  |
| 16     | 4" Take-Up Plate (LH/RH)                        | 31     | Bearing Take-Up Mounting Angle                  |
| 17     | Bearing Guide Spacer                            | 32     | Bearing Push Plate                              |
| 7      | 6" End Take-Up Assembly                         | 33     | Bed Pan Brace (For 27"BF and above)             |
| 8      | Take-Up Bearing Assembly                        | 34     | Bed Joint Mounting Angle                        |
| 9      | Safety Pop-Out Roller Assembly                  | 35     | 6" Drive Pulley Assembly                        |
| 10     | 6" Take-Up Bearing Guide                        | 36     | 6" Fixed & End Drive Plate (LH/RH)              |
| 11     | Bolt-In Butt Coupling                           | 37     | Filler Pan                                      |
| 12     | 6" Take-Up Bed Joint Angle (LH/RH)              | 38     | 4 Hole Flange Bearing w/1-7/16" Bore (BRW04070) |
| 13     | 6" Take-Up Filler Pan Assembly                  | 29     | 8" End Drive Assembly                           |
| 14     | 6" Take-Up Idler Pulley Assembly                | 30     | Safety Pop-Out Roller Assembly                  |
| 15     | —   | 31     | Bearing Take-Up Mounting Angle                  |
| 16     | 6" Take-Up Plate (LH/RH)                        | 32     | Bed Pan Brace (For 27"BF and above)             |
| 17     | Bearing Guide Spacer - 5/16" Flat Washer        | 33     | Bearing Push Plate                              |
| 18     | Top take-Up Bearing Guide                       | 34     | Bed Joint Mounting Angle                        |
| 19     | 4" Fixed End Assembly                           | 35     | 8" Drive Pulley Assembly                        |
| 20     | Safety Pop-Out Roller Assembly                  | 36     | 8" Fixed & End Drive Plate (LH/RH)              |
| 21     | Bearing Take-Up Mtg. Angle                      | 37     | Filler Pan                                      |
| 22     | Bed Pan Brace (For 27"BF and above)             | 38     | 4 Hole Flange Bearing w/1-7/16" Bore (BRW04070) |
| 23     | Bearing Push Plate                              | 39     | 2.5 Roller Keeper                               |
| 24     | Bed Joint Mounting Angle                        | 40     | Belt Guard (LH/RH)                              |
| 25     | 4" Idler Pulley Assembly                        | 41     | Snub Roller Belt Guard                          |
| 26     | 4" Fixed & End Drive Plate (LH/RH)              | 42     | 251S Roller Assembly                            |
| 27     | Filler Pan                                      | 43     | 196S Tread Roller Assembly                      |
| 28     | 2 Hole Flange Bearing w/1-3/16" Bore (BRW04014) | 44     | 4" Center Drive Assembly                        |
| 19     | 6" Fixed End Assembly                           | 45     | 2.5 Roller Keeper                               |
| 20     | safety Pop-Out Roller Assembly                  | 46     | Center Drive Take-Up Bearing Guide              |
| 21     | Bearing Take-Up Mounting Angle                  | 47     | Take-Up Bearing Assembly (LH/RH)                |
| 22     | Bed Pan Brace (For 27"BF and above)             | 48     | 251S Roller Assembly                            |
| 23     | Bearing Push Plate                              | 49     | 4" Center Drive Plate Weld Assembly (LH/RH)     |
| 24     | Bed Joint Mounting Angle                        | 50     | 4" Drive Pulley Assembly                        |
| 25     | 6" Idler Pulley Assembly                        |        |   |

# MODEL 796RB

## PARTS LIST CONT. (DRAWINGS ON NEXT PAGE)

25

| ITEM # | DESCRIPTION                                      | ITEM # | DESCRIPTION   |
|--------|--|--------|---|
| 51     | 4" Idler Pulley Assembly                         | 44     | 12" Center Drive Assembly w/6" or 8" Take-Up Pulley |
| 52     | 4" Center Drive Belt Guard                       | 45     | Bearing Push Plate (LH/RH)                          |
| 53     | 4" Center Drive Belt Guard                       | 46     | Center Drive Take-Up Bearing Guide                  |
| 54     | Frame Crossbrace                                 | 47     | Take-Up Bearing Assembly w/1-7/16" Bore (A26253)    |
| 55     | 3 Hole flange Bearing w/1-3/16" Bore (BRW04040)  | 48     | 4" Idler Pulley Assembly                            |
| 44     | 8" Center Drive Assembly                         | 49     | 12" Center Drive Plate Weld Assembly (LH/RH)        |
| 45     | 2.5 Roller Keeper                                | 50     | 12" Drive Pulley                                    |
| 46     | Center Drive Take-Up Bearing Guide               | 51     | 6" Idler Pulley Assembly                            |
| 47     | Take-Up Bearing Assembly (LH/RH)                 | 52     | 12" Center Drive Belt Guard                         |
| 48     | 251S Roller Assembly                             | 53     | 12" Center Drive Belt Guard                         |
| 49     | 8" Center Drive Plate Weld Assembly (LH/RH)      | 54     | Frame Crossbrace                                    |
| 50     | 8" Drive Pulley Assembly                         | 55     | 4 Hole Flange Bearing w/1-15/16" Bore (BRW04080)    |
| 51     | 4" Idler Pulley Assembly                         | 56     | 3 Hole Flange Bearing w/1-3/16" Bore (BRW04040)     |
| 52     | 8" Center Drive Belt Guard                       | 57     | Belting Assembly                                    |
| 53     | 8" Center Drive Belt Guard                       | 58     | Motor   |
| 54     | Frame Crossbrace                                 | 59     | Motorbase Stiffener Assembly                        |
| 55     | 4 Hole Flange Bearing w/1-7/16" Bore (BRW04070)  | 60     | Reducer Push Plate Assembly                         |
| 44     | 12" Center Drive Assembly w/4" Take-Up Pulley    | 61     | Sidemount Motorbase Plate                           |
| 45     | Bearing Push Plate (LH/RH)                       | 62     | Sidemount Chain Guard Assembly                      |
| 46     | Center Drive Take-Up Bearing Guide               | 63     | Reducer   |
| 47     | Take-Up Bearing Assembly (LH/RH)                 | 64     | Chain Guard Angle Mount (LH/RH)                     |
| 48     | 4" Idler Pulley Assembly                         | 65     | Underneath Motorbase Plate                          |
| 49     | 12" Center Drive Plate Weld Assembly (LH/RH)     | 66     | Chain Guard Assembly                                |
| 50     | 12" Drive Pulley                                 | 67     | Center Drive Chain Guard Assembly                   |
| 51     | 4" Idler Pulley Assembly                         |        |   |
| 52     | 12" Center Drive Belt Guard                      |        |   |
| 53     | 12" Center Drive Belt Guard                      |        |   |
| 54     | Frame Crossbrace                                 |        |   |
| 55     | 4 Hole Flange Bearing w/1-15/16" Bore (BRW04080) |        |   |
| 56     | 3 Hole Flange Bearing w/1-3/16" Bore (BRW04040)  |        |   |

Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 15).

**Recommended Spare Parts** are shown in red. **Charted** are item numbers and part descriptions. When ordering use example below.

Example: Need a replacement 6" End Take-up Assembly for a 796RB.  
Part No: SN 123456 - 7 - 6" End Take-up Assembly

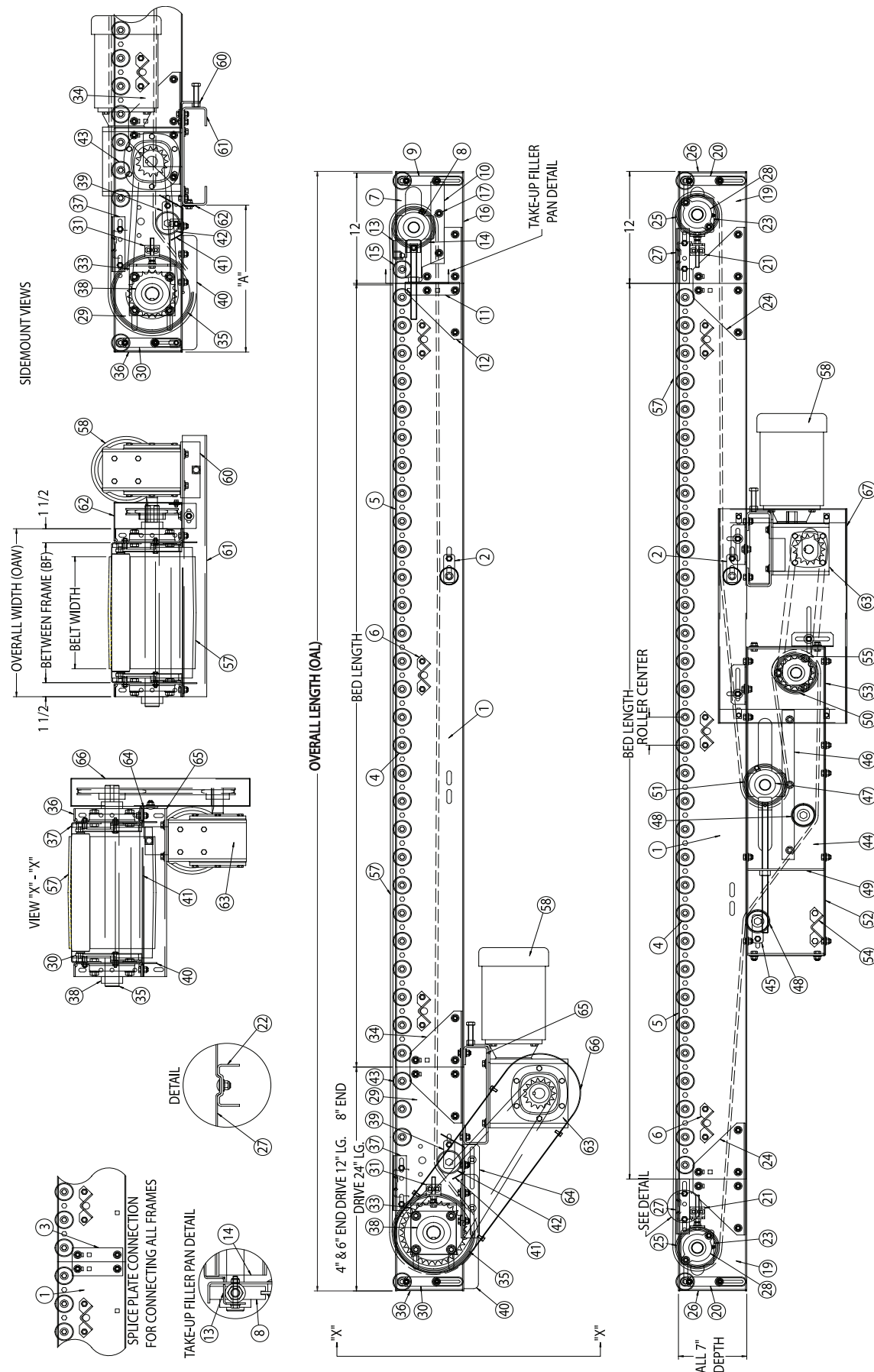




# MODEL 796RB

## END DRIVE, END SIDE MOUNT DRIVE & CENTER DRIVE DRAWINGS

26



# MODEL 751RB

## PARTS LIST

27

| ITEM # | DESCRIPTION                                     | ITEM # | DESCRIPTION                                      |
|--------|---|--------|--|
| 1      | 751 RB Intermediate Bed Assembly                | 27     | 6" Fixed & End Drive Plate                       |
| 2      | 1.9 Roller Keeper                               | 28     | Filler Pan                                       |
| 3      | Splice Plate                                    | 29     | 4 Hole Flange Bearing w/1-7/16" Bore (BRW04070)  |
| 4      | 251S Roller Assembly                            | 30     | 8" End Drive Assembly                            |
| 5      | 196S Roller Assembly                            | 31     | Safety Pop-Out Roller Assembly                   |
| 6      | Heavy Duty Side Channel 12"-120"                | 32     | Bearing Take-Up Mounting Angle                   |
| 7      | Frame Crossbrace                                | 33     | Bed Pan Brace (27" BF & Above)                   |
| 8      | 4" End Take-Up Assembly                         | 34     | Bearing Push Plate                               |
| 9      | Take-Up Bearing Assembly                        | 35     | Bed Joint Mounting Angle                         |
| 10     | Safety Pop-Out Roller Assembly                  | 36     | 8" Drive Pulley Assembly                         |
| 11     | 4" Take-Up Bearing Guide                        | 37     | 8" Fixed & End Drive Plate                       |
| 12     | Bolt-In Butt Coupling                           | 38     | Filler Pan                                       |
| 13     | 4" Take-Up Bed Joint Mounting Angle             | 39     | 4 Hole Flange Bearing w/1-7/16" Bore (BRW04070)  |
| 14     | 4" Take-Up Filler Pan Assembly                  | 40     | 2.5 Roller Keeper                                |
| 15     | 4" Idler Pulley Assembly                        | 41     | Belt Guard                                       |
| 16     | 251S Roller Assembly                            | 42     | Roller Belt Guard                                |
| 17     | 4" Take-Up Plate                                | 43     | 251S Roller Assembly                             |
| 18     | Bearing Guide Spacer                            | 30     | 12" End Drive Assembly                           |
| 8      | 6" End Take-Up Assembly                         | 31     | Safety Pop-Out Roller                            |
| 9      | Take-Up Bearing Assembly                        | 32     | Bearing Take-Up Mounting Angle                   |
| 10     | Safety Pop-Out Roller Assembly                  | 33     | Bed Pan Brace (27" BF & Above)                   |
| 11     | 6" Take-Up Bearing Guide                        | 34     | Bearing Push Plate                               |
| 12     | Bolt-In Butt Coupling 6" Take-Up                | 36     | 12" Drive Pulley Assembly                        |
| 13     | 6" Take-Up Bed Joint Mounting Angle             | 37     | 12" Fixed & End Drive Plate                      |
| 14     | 6" Take-Up Filler Pan Assembly                  | 38     | Filler Pan                                       |
| 15     | 6" Idler Pulley Assembly                        | 39     | 4 Hole Flange Bearing w/1-15/16" Bore (BRW04080) |
| 17     | 6" Take-Up Plate                                | 40     | 2.5 Roller Keeper                                |
| 18     | Bearing Guide Spacer (5/16" Flat Washer)        | 42     | Snub Roller Belt Guard                           |
| 19     | Top Take-Up Bearing Guide                       | 43     | 251S Roller Assembly                             |
| 20     | 4" Fixed End Assembly                           | 44     | 4" Center Drive Assembly                         |
| 21     | Safety Pop-Out Roller Assembly                  | 45     | 2.5 Roller Keeper                                |
| 22     | Bearing Take-Up Mounting Angle                  | 46     | Center Drive Take-Up Bearing Guide               |
| 23     | Bed Pan Brace (27" BF & Above)                  | 47     | (Milled) Take-Up Bearing Assembly                |
| 24     | Bearing Push Plate                              | 48     | 251S Roller Assembly                             |
| 25     | Bed Joint Mounting Angle                        | 49     | 4" Center Drive Plate Weld Assembly              |
| 26     | 4" Idler Pulley Assembly                        | 50     | 4" Drive Pulley Assembly                         |
| 27     | 4" Fixed & End Drive Plate                      | 51     | 4" Idler Pulley Assembly                         |
| 28     | Filler Pan                                      | 52     | 4" Center Drive Belt Guard                       |
| 29     | 2 Hole Flange Bearing w/1-3/16" Bore (BRW04014) | 53     | 4" Center Drive Belt Guard                       |
| 20     | 6" Fixed End Assembly                           | 54     | Frame Crossbrace                                 |
| 21     | Safety Pop-Out Roller Assembly                  | 55     | 3 Hole Flange Bearing w/1-3/16" Bore (BRW04040)  |
| 22     | Bearing Take-Up Mounting Angle                  | 44     | 8" Center Drive Assembly                         |
| 23     | Bed Pan Brace (27" BF & Above)                  | 45     | 2.5 Roller Keeper                                |
| 24     | Bearing Push Plate                              | 46     | Center Drive Take-Up Bearing Guide               |
| 25     | Bed Joint Mounting Angle                        | 47     | (Milled) Take-Up Bearing Assembly                |
| 26     | 6" Idler Pulley Assembly                        | 48     | 251S Roller Assembly                             |

# MODEL 751RB

## PARTS LIST CONT. (DRAWINGS ON NEXT PAGE)

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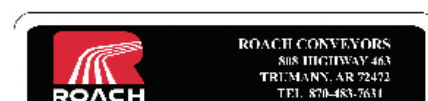
| ITEM # | DESCRIPTION  | ITEM # | DESCRIPTION                                      |
|--------|--|--------|--|
| 49     | 8" Center Drive Plate Weld Assembly                | 49     | 12" Center Drive Plate Weld Assembly             |
| 50     | 8" Drive Pulley Assembly                           | 50     | 12" Drive Pulley                                 |
| 51     | 4" Idler Pulley Assembly                           | 51     | 6" or 8" Idler Pulley Assembly                   |
| 52     | 8" Center Drive Belt Guard                         | 52     | 12" Center Belt Guard                            |
| 53     | 8" Center Drive Belt Guard                         | 53     | 12" Center Belt Guard                            |
| 54     | Frame Crossbrace                                   | 54     | Frame Crossbrace                                 |
| 55     | 4 Hole Flange Bearing w/1-7/16" Bore (BRW04070)    | 55     | 4 Hole Flange Bearing w/1-15/16" Bore (BRW04080) |
| 44     | 12" Center Drive Assembly, 4" Take-Up Pulley       | 56     | 3 Hole Flange Bearing w/1-3/16" Bore (BRW04040)  |
| 45     | Bearing Push Plate                                 | 57     | Belting Assembly                                 |
| 46     | Center Drive Take-Up Bearing Guide                 | 58     | Motor  |
| 47     | (Milled) Take-Up Bearing Assembly                  | 59     | Motorbase Stiffener Assembly                     |
| 48     | 4" Idler Pulley Assembly                           | 60     | Reducer Push Plate Assembly                      |
| 49     | 12" Center Drive Plate Weld Assembly               | 61     | Sidemount Motorbase Plate                        |
| 50     | 12" Drive Pulley                                   | 62     | Sidemount Chain Guard Assembly                   |
| 51     | 4" Idler Pulley Assembly                           | 63     | Reducer  |
| 52     | 12" Center Belt Guard                              | 64     | Chain Guard Angle Mount                          |
| 53     | 12" Center Belt Guard                              | 65     | Underneath Motorbase Plate                       |
| 54     | Frame Crossbrace                                   | 66     | Chain Guard Assembly                             |
| 55     | 4 Hole Flange Bearing w/1-15/16" Bore (BRW04080)   | 67     | Center Drive Chain Guard Assembly                |
| 56     | 3 Hole Flange Bearing w/1-3/16" Bore (BRW04040)    |        |  |
| 44     | 12" Center Drive Assembly, 6" or 8" Take-Up Pulley |        |  |
| 45     | Bearing Push Plate                                 |        |  |
| 46     | Center Drive Take-Up Bearing Guide                 |        |  |
| 47     | Take-Up Bearing Assembly w/1-7/16" Bore (A26253)   |        |  |

Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 15).

**Recommended Spare Parts are shown in red. Charted are item numbers and part descriptions.** When ordering use example below.

Example: Need a replacement 4" End Take-Up Assembly for a 751RB.

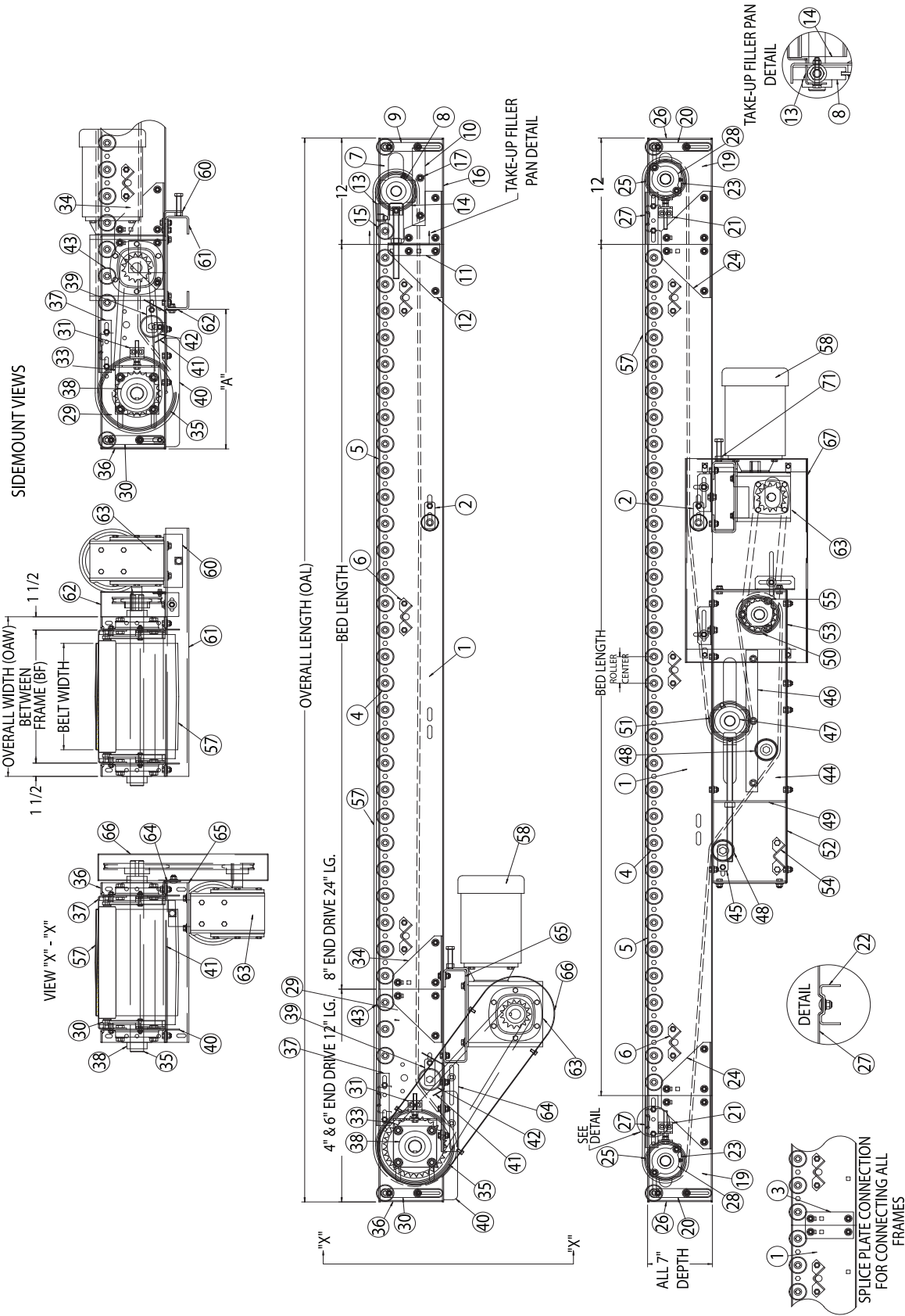
Part No: SN 123456 - 8 - End Take-up Assembly



SERIAL NO. 123456

MODEL 751RB

END DRIVE, END SIDE MOUNT DRIVE & CENTER DRIVE DRAWINGS



# MODEL 796RBF

## PARTS LIST

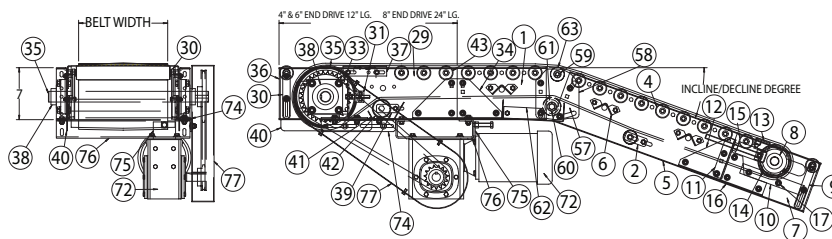
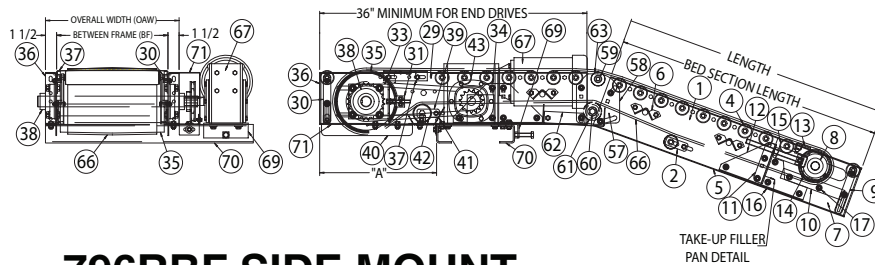
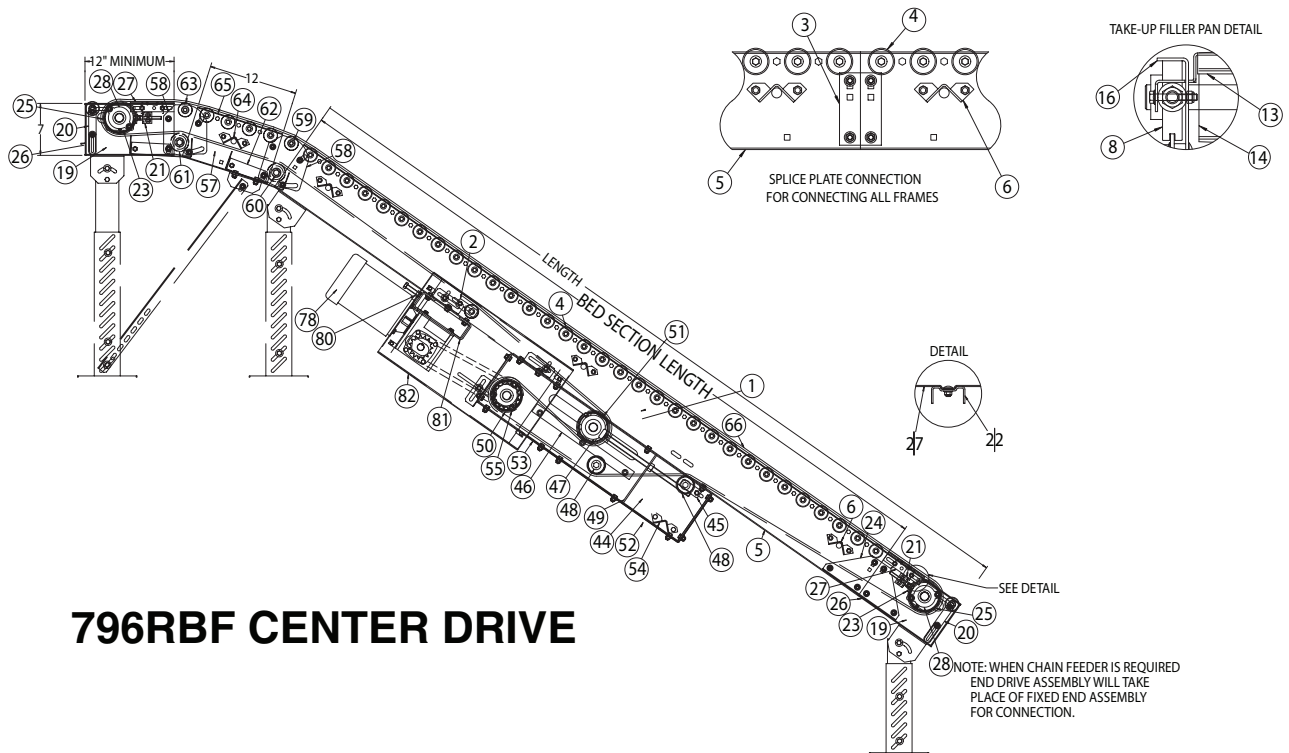
| Item # | Description                                 | Item # | Description                          |
|--------|---|--------|--------------------------------------|
| 1      | 796RB Intermediate bed assembly             | 22     | Bed pan brace (27" BF & Above)       |
| 2      | 1.9 Roller keeper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



# MODEL 796RBF

## PARTS LIST

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



Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 15).

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

When ordering use example below.

Example: Need a replacement Center drive it for 796RBF

Part No: SN 123456 - 78 - Center drive kit



SERIAL NO. 123456

# MODEL 700SBF

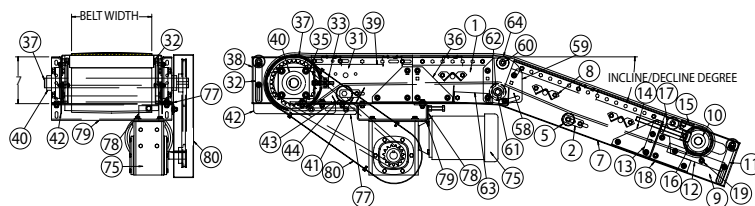
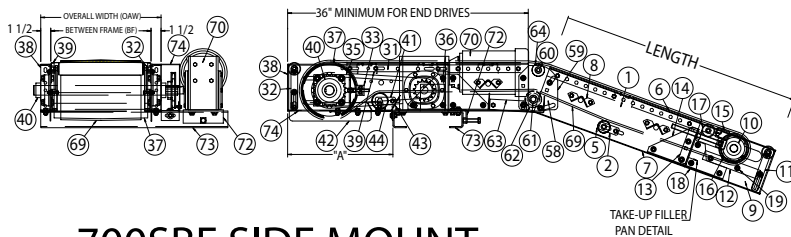
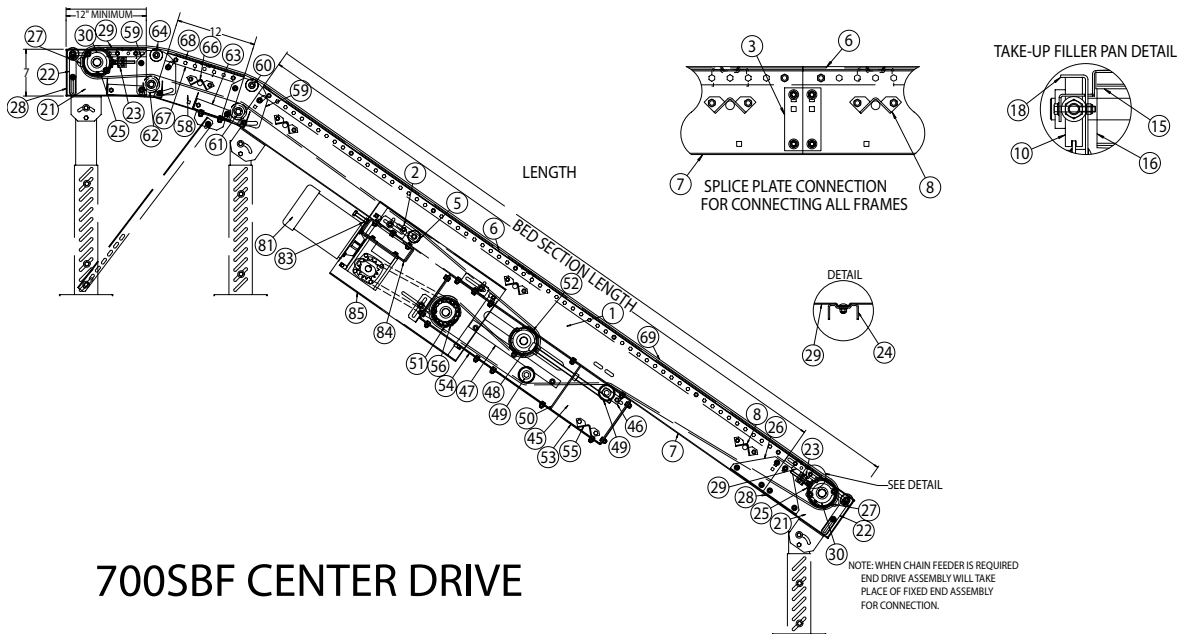
## PARTS LIST

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

# MODEL 700SBF

## PARTS LIST

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



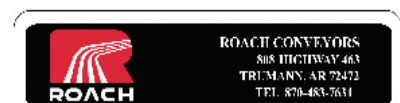
Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 15).

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

When ordering use example below.

Example: Need a replacement Center drive kit for 700SBF

Part No: SN 123456 - 81 - Center drive kit



SERIAL NO. 123456



# MODEL BFI INTEGRAL BELT FEEDER

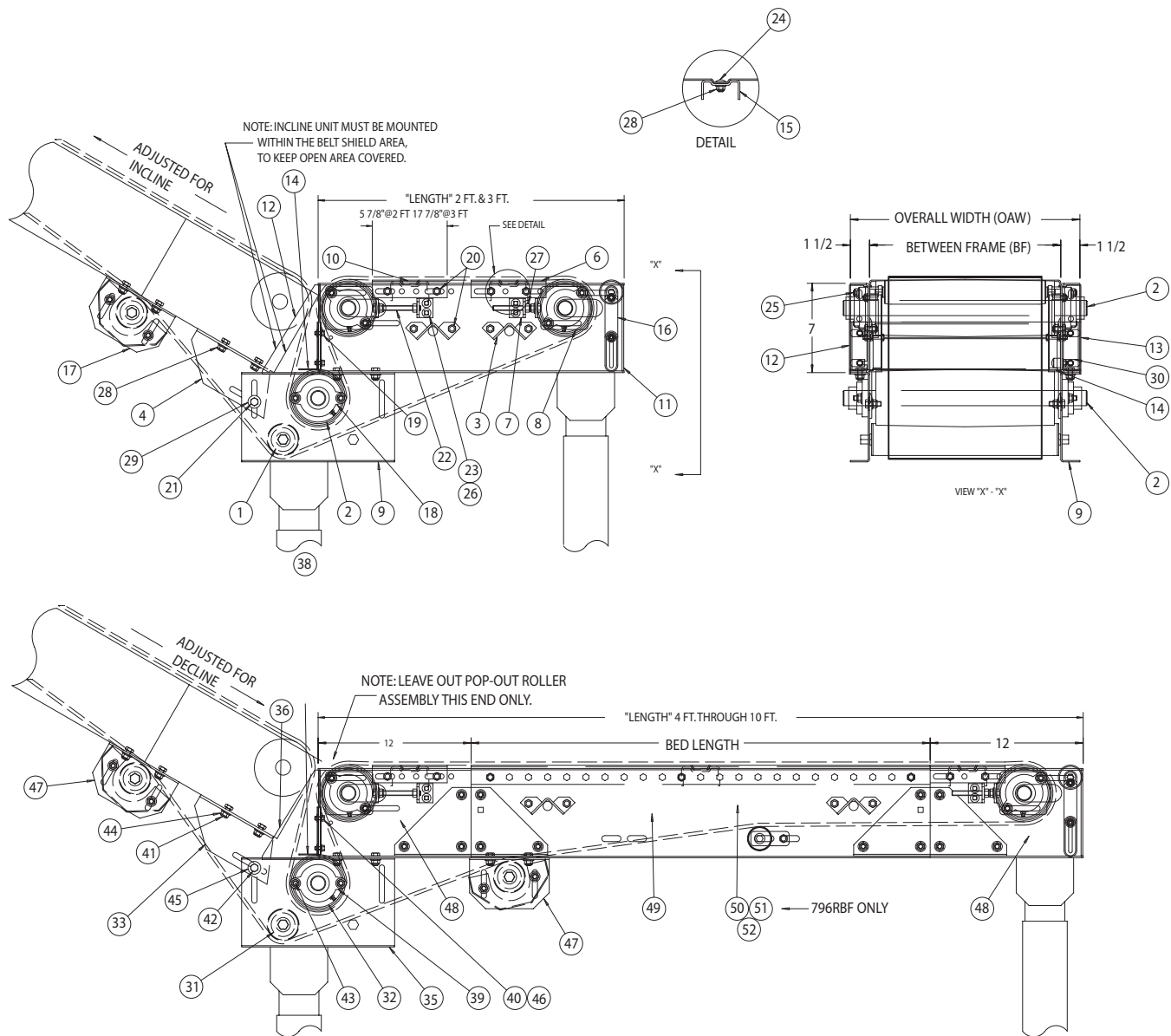
## PARTS LIST FOR FEEDER (WHEN USED WITH CENTER DRIVE)

36

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

# MODEL BFI INTEGRAL BELT FEEDER DRAWINGS

37



Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 15).

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

When ordering use example below.

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

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



# MODEL BFCD CHAIN DRIVEN FEEDER

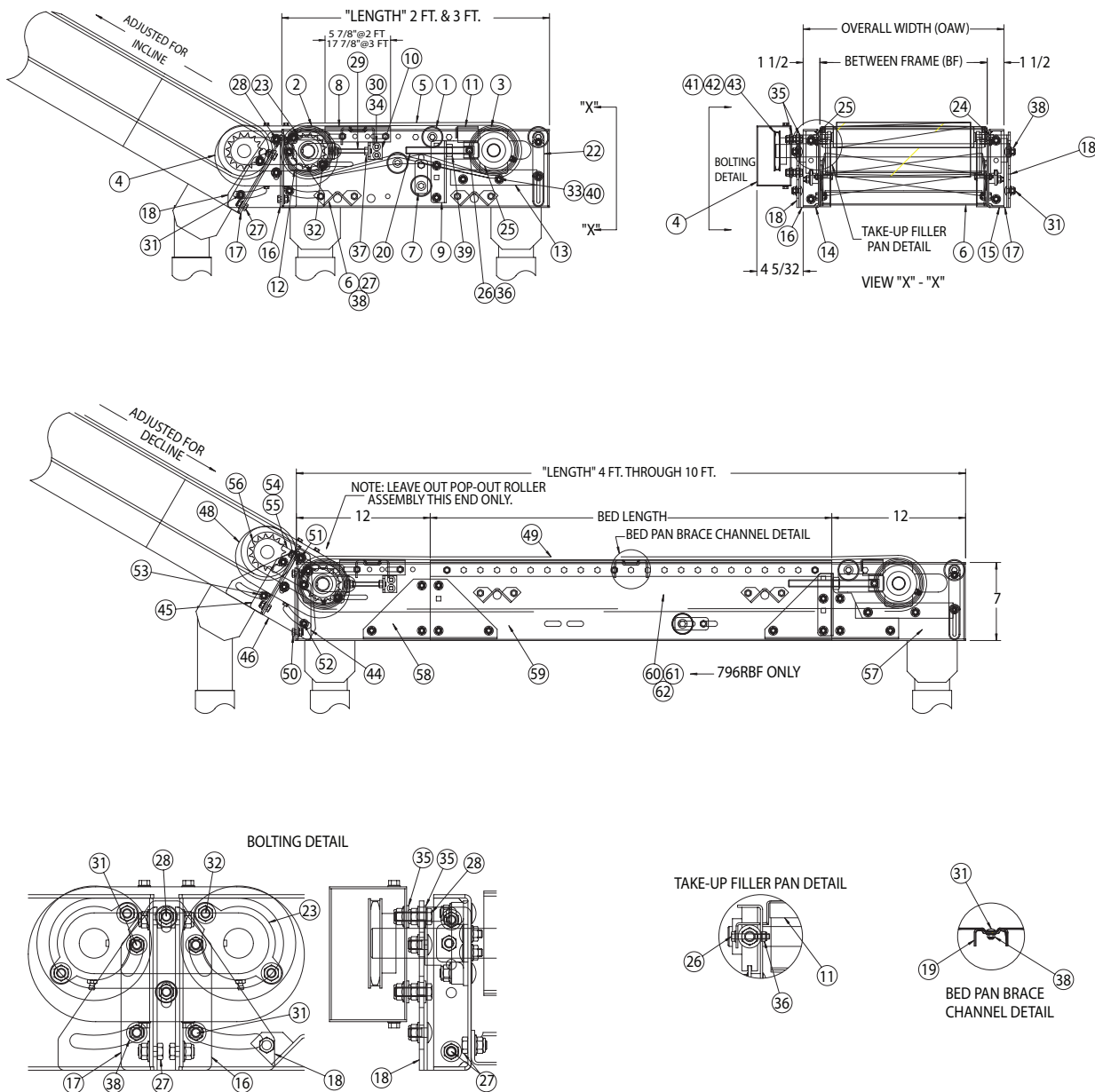
## PARTS LIST FOR FEEDER (WHEN USED WITH CENTER DRIVE)

38

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

# MODEL BFGD CHAIN DRIVEN FEEDER DRAWINGS

39



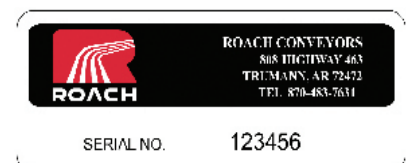
Specify **Unit Serial Number** when ordering replacement parts to ensure proper allocation of components (See Ordering Replacement Parts on page 15).

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

When ordering use example below.

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

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





# ROACH CONVEYORS

## WARRANTY

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

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

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

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