MAINTENANCE MANUAL

STS CLOSED TRACK CONVEYOR

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www.railtechniek.com

STS CLOSED TRACK CONVEYOR
MAINTENANCE MANUAL

This manual comprises preliminary pages and four sections. The preliminary pages include General Procedures and Safety Notes; these must be read before carrying out any maintenance tasks on the conveyor system.

Section titles are shown on the overall Contents List. Each Section includes a separate detailed contents list.

General Procedures and Safety Notes

The use of this equipment does not constitute any health or safety hazard if used in a proper manner. Attention is drawn however to the following basic safety precautions that should be observed.

(1) Ensure that all personnel have had adequate training in operating and maintenance procedures.

(2) All safety guards and covers are to be fitted before a conveyor is run.

(3) Potentially dangerous voltages are present on the equipment and access covers should not be removed other than by trained maintenance personnel.

(4) Personnel should not attempt to interfere with a running conveyor.

(5) Keep hair and all loose clothing away from a running conveyor.

(6) If in doubt regarding the safe operation of the conveyor, consult our Customer Engineering Department.

WARNINGS: THESE MUST BE OBSERVED AT ALL TIMES - THEY ARE PRINTED FOR YOUR PROTECTION.

CAUTIONS: These must be observed at all times to prevent damage to the equipment.

While every effort has been made in this manual to inform users of the correct methods of maintaining the conveyor, STEWART GILL CONVEYORS accepts no liability for personal injury or damage to the conveyor howsoever such injury or damage may be caused.

This manual is believed to be accurate in all aspects at the time of printing; however customer's special requirements and other circumstances may cause STEWART GILL CONVEYORS to make modifications to the conveyor from time to time.

Although every effort will be made to keep the manual relating to every particular conveying system in step with any future modification, users are advised that if in any doubt exists, regarding any statement, illustration or diagram, reference must be made to our Customer Engineering Department.

CONTENTS

Section	Contents	Page No.
1.	INTRODUCTION	3
2.	LUBRICATION	5
3.	MAINTENANCE	33
4.	PARTS LIST	40
Appendix 1	Side Mounted STS Conveyor	
Appendix 2	EC Declaration of Conformity	

SECTION 1 - INTRODUCTION

SECTION 1 - INTRODUCTION

Modern industrial enterprises must be able to move materials efficiently from one part of a factory to another and between different production or processing stages. One method is to use an overhead conveyor system such as the STS Closed Track.

The failure of any system component however could jeopardise the operational readiness of the conveyor; causing perhaps a total stoppage of the product line. All output would cease until the faulty component has been repaired or replaced. The stoppage would be particularly significant to an enterprise operating its machinery and equipment at high capacity.

Such stoppages can be minimized with a program of preventive maintenance, the requirement of which is influenced by economic and political incentives.

There is an economic incentive for management to provide regular inspection and maintenance to minimise operating costs, particularly production losses due to unplanned shutdowns. In addition regular preventive maintenance measures, properly implemented, extend the operational life and reduce the probability of major repairs or replacement of equipment.

Political incentive is motivated by legislation making the implementation of systematic maintenance programs mandatory and current health and safety regulations, which now require that carefully prepared plans to ensure safe working conditions are positively pursued.

Ideally the plant must be able to remain almost continually operational, with any conveyor maintenance being co-ordinated with other factory schedules.

The elimination of unscheduled stoppages due to bad servicing or faulty components must be the goal of scheduled maintenance.

SECTION 2 - LUBRICATION

CONTENTS

Para.	Contents	Page No.
1	Recommended Lubricants	8
1.1	Shell Tellus Oils - Ambient Temperatures	8
1.1.1	Corrosion Resistance	8
1.1.2	Oil Seal Compatibility	8
1.1.3	Health and Safety	8
1.1.4	Typical Characteristics of Shell Tellus Oil 37	9
1.2	Mobil Pyrolube 830 Oil - High Temperatures	10
1.2.1	Ingredients Considered Hazardous to Health	10
1.2.2	Hazards Identification	10
1.2.3	First Aid Measures	10
1.2.4	Fire Fighting Measures	10
1.2.5	Accidental Release Measures	11
1.2.6	Handling and Storage	11
1.2.7	Exposure Controls/Personal Protection	11
1.2.8	Physical and Chemical Properties	12
1.2.9	Stability and Reactivity	13
1.2.10	Toxicological Data	13
1.2.11	Ecological Information	13
1.2.12	Disposal Considerations	13
1.2.13	Transport Information	13
1.2.14	Regulatory Information	14

CONTENTS (continued)

Para.	Contents	Page No.
2	Using the Lubrication Procedures	15
Tables		
2.1	Lubrication Table Symbols	15
Lubrication Procedures		
Drive Units		
275L	714801, 714802	16
550M	714901, 714902	17
Tension Units		
Draw Bolt	720201	18
Spring	720202	19
Pneumatic	722601	20
550M Chain		
Load Links	763101, 763102, 763103, 763104	21
	764101, 764102, 764103, 764104	
	769300, 769301, 769302, 769303	
Lister Lubricator		29

SECTION 2 – LUBRICATION

This section contains lubrication procedures for the conveyor system. The procedures have been simplified, comprising mainly diagrams and tables. Lubrication requirements have also been kept to a minimum.

WARNING: BEFORE ATTEMPTING ANY IN-SITU LUBRICATION OF CONVEYOR PARTS, FIRST ENSURE THAT POWER TO THE CONVEYOR IS SWITCHED OFF AND THAT IT IS ELECTRICALLY ISOLATED.

CAUTION: Over-lubrication can damage seals and bearings. Use only the specified amount of recommended lubricant.

NOTES: (1) All lubrication procedures should be carried out on completion of installation

(2) All hours quoted in the following lubrication procedures are OPERATING hours.

1 RECOMMENDED LUBRICANTS

The following lubricants are recommended:

1.1 Shell Tellus Oils - Ambient Temperatures

Shell Tellus 37 SG Part No. 7526X1 (or equivalent) is recommended for use in all ambient temperature conditions.

Shell Tellus Oils have been designed and developed for use in hydraulic power transmissions and control systems. They are based on high viscosity index and are solvent refined oils which incorporate additives to enhance the:

Anti-wear performance.

Oxidation resistance.

Corrosion protection.

Pour point.

Air release and anti-foam properties.

1.1.1 Corrosion Resistance

Shell Tellus Oils contain additives which have a powerful metal wetting ability. These additives "plate out" on the metal surfaces to provide a protective film which prevents reaction with any moisture in the system. Shell Tellus Oils pass the Cooper Strip Corrosion Test, IP 154, and are less reactive to copper and its alloys than many similar types of anti-wear hydraulic oil.

1.1.2 Oil Seal Compatibility

When formulating a hydraulic oil it is important to ensure that it does not adversely affect the types of seals commonly used in hydraulic systems.

The compatibility of an oil with seal material may be assessed by many different tests. These usually examine the effect of the oil on seal swell characteristics, a property which is influenced mainly by the base oil rather than the additives used in a hydraulic oil. The base oils for Shell Tellus Oils have been selected to ensure that they are suitable for all types of seals normally found in hydraulic systems.

1.1.3 Health and Safety

Shell Tellus Oils are unlikely to pose any toxic hazard when used in the recommended applications, provided good standards of personal and industrial hygiene are observed.

For further guidance on health and safety refer to the leaflet 'Shell Lubricants and Related Products Guide to Health and Safety'. In this guide, under product precautions, Shell Tellus Oils are of Type I in that they have been manufactured by methods which reduce the polycyclic aromatic content to a low level.

Advice on applications not covered by this leaflet can be obtained from your Shell representatives.

1.1.4 Typical Characteristics of Shell Tellus Oil 37

These are as follows:

Viscosity Grade, ISO 3448		37
ISO Oil Type		HM
Viscosity, kinematic, Cst, at IP 71	0°C	340
	20°C	93
	40°C	36.2
	100°C	6.1
Viscosity Index, IP226		108
Flash Point, closed °C IP 34		210
Pour Point °C IP 15		-30
Density at 15°C, kg/l, IP 160		0.875
Neutralisation value, mg KOH/g oil, IP139		0.70
TOST life, change in acidity, mg KOH/g of oil at 1000 hrs, IP 157		<2.0
Copper corrosion test, IP 154, 3 hrs at 100°C		Class 1
Vane pump test, IP 281, total ring and vane weight loss, mg		<100
Water separation, time in minutes, ASTM D 1401		15
Rust prevention, salt water, IP 135 B		No rust
Air release value, minutes to 0.2%, air at 50°C, IP 313		6
Foaming tendancy/stability, IP 146	ml at 24°C	20/Nil
	ml at 93.5°C	15/Nil
	ml at 24°C after test at 93.5°C	20/Nil
Seal compatibility index, IP 278		12

1.2 Mobil Pyrolube 830 Oil - High Temperatures

Mobil Pyrolube 830 SG Part No. 7526X4 is used where the component is exposed to high temperature.

1.2.1 Ingredients Considered Hazardous to Health

This product is not hazardous as defined by the EC Dangerous Substances/Preparations Directives. See paragraph 1.2.13 for a regulatory analysis of the ingredients.

1.2.2 Hazards Identification

No significant effects of overexposure expected.

1.2.3 First Aid Measures

These are as follows:

Eye Contact:	Flush thoroughly with water. If irritation occurs, call a doctor.
Skin Contact:	Wash contact areas with soap and water.
Inhalation:	Not expected to be a problem.
Ingestion:	Not expected to be a problem. However if greater than half a litre (one pint) is ingested or if feeling uncomfortable, give one to two glasses of water and obtain medical attention or call an ambulance for assistance. DO NOT INDUCE VOMITING or give anything by mouth to an unconscious person.

1.2.4 Fire Fighting Measures

In the event of fire observe the following:

Extinguishing Media:	Carbon dioxide, foam, dry chemical and water fog.
Special Firefighting Procedures:	Water or foam may cause frothing. Use water to keep fire exposed containers cool. Water spray may be used to flush spills away from exposures. Prevent run-off from fire control or dilution from entering waterways or drinking water supply.
Special Protective Equipment:	For fires in enclosed areas, firefighters MUST use self-contained breathing apparatus.
Unusual Fire and Explosion Hazards:	None.
NFPA Hazard ID:	Health: 0, Flammability: 1, Reactivity: 0.

1.2.5 Accidental Release Measures

Should accidental release occur, the following measures should be adopted:

Notification Procedures:	Report spills as required to appropriate authorities, such as the local Environment Health Officer or Fire Brigade. If spills are likely to enter any drain, waterway or groundwater, contact the Area Water Authority. In case of accident or road spill, contact the Police and Fire Brigade and, if appropriate, the Area Water Authority.
Procedures if material is released or spilled:	Contain and absorb on fire retardant treated sawdust, diatomaceous earth, etc. Shovel up and dispose of at an appropriate licensed waste disposal site in accordance with current applicable laws and regulations and product characteristics at time of disposal.
Environmental Precautions:	Prevent spills from entering storm sewers or drains and contact with soil.
Personal Precautions:	See Paragraph 1.2.7.

1.2.6 Handling and Storage

Observe the following:

Handling:	No special precautions are necessary beyond normal good hygiene practices. See Paragraph 1.2.7 for additional personal protection/advice when handling this product.
Storage:	Do not store in open or unlabelled containers. Store away from strong oxidizing agents or combustible material.

1.2.7 Exposure Controls/Personal Protection

The following protection measures should be observed:

Ventilation:	No special requirements under ordinary conditions of use and with adequate ventilation.
Respiratory Protection:	No special requirements under ordinary conditions of use and with adequate ventilation.
Eye Protection:	Normal industrial eye protection practices should be employed.
Skin Protection:	No special equipment required. However, good personal hygiene practices should always be followed.
Exposure Limits:	This product does not contain any components which have recognised exposure limits. However, a threshold limit value of 5.00 mg/m^3 is suggested for oil mist.

1.2.8 Physical and Chemical Properties

Typical physical properties are given below. Consult Product Data Sheet for specific details.

Physical State:	Liquid.
Colour:	Amber.
Odour:	Mild.
pH:	Not Applicable.
Boiling Point °C:	>316.
Melting Point °C:	Not Applicable.
Flash Point °C:	270 (IP 36/ASTM D-92).
Flammability:	Not Applicable.
Auto Flammability:	Not Established.
Explosive Properties:	Not Applicable.
Oxidising Properties:	Not Applicable.
Vapour Pressure mm Hg 20°C:	<0.1.
Relative Density 15/4°C:	0.93.
Solubility in Water:	Negligible.
Partition Coefficient:	Not Established.
Viscosity at 40°C, cSt:	180.0.
Viscosity at 100°C, cSt:	20.4.
Pour Point °C:	-46.

For further technical information, contact your marketing representative.

1.2.9 Stability and Reactivity

Stabiliity and reactivity properties are as follows:

Stability (Thermal, Light etc.):	Stable.
Conditions to avoid:	Extreme Heat.
Incompatibility (Materials to avoid):	Strong Oxidisers.
Hazardous Decomposition Products:	Carbon Monoxide.
Hazardous Polymerisation:	Will Not Occur.

1.2.10 Toxicological Data

Toxicological data is as follows:

Oral Toxicity:	Practically non-toxic (LD50: greater than 2000 mg/kg. (Based on testing of similar products and/or the components).
Dermal Toxicity:	Practically non-toxic (LD50: greater than 2000 mg/kg. (Based on testing of similar products and/or the components).
Inhalation Toxicity:	Practically non-toxic.
Eye Irritation:	Practically non-irritating.
Skin Irritation;	Practically non-irritating.

1.2.11 Ecological Information

Environmental fate and effects not established.

1.2.12 Disposal Considerations

Waste Disposal: Product is suitable for burning in an enclosed, controlled burner for fuel value or disposal by suitable incineration. Such burning may be limited by the controlling authority. In addition, the product is suitable for processing by an approved recycling facility or can be disposed of at any licensed waste disposal site. Use of these methods is subject to user compliance with applicable laws and regulations and consideration of product characteristics at time of disposal.

1.2.13 Transport Information

Applicable transport regulatory organisations are as follows:

USA DOT:	Not Regulated by USA DOT.
IMO:	Not Regulated by IMO.
IATA:	Not Regulated by IATA.

1.2.14 Regulatory Information

Regulatory information is as follows:

EC Classification and Labelling: EC labelling not required.

The following product ingredients are cited on the lists below:

Chemical Name	CAS Number	List Citations
No Reportable Ingredients		

Regulatory Lists Searched

1 = IARC 1	6 = NO ALLERGI	11 = DE TERAT B	16 = DE CARC B
2 = IARC 2A	7 = SE ALLERGY	12 = DE TERAT C	17 = AT TERAT A
3 = IARC 2B	8 = SE CARC	13 = DE TERAT D	18 = AT TERAT B
4 = NTP CARC	9 = DK CARC	14 = DE CARC A1	19 = AT TERAT C
5 = NTP SUS	10 = DE TERAT A	15 = DE CARC A2	20 = AT TERAT D
			21 = CH CARC

CARC = Carcinogen; SUS = Suspected Carcinogen; TERAT = Teratogenic

AT = Austria	DE = Germany	NO = Norway
CH = Switzerland	DK = Denmark	SE = Sweden

2 USING THE LUBRICATION PROCEDURES

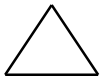
The following pages provide information on the points of application and periodicities of lubrication routines. The following procedure should be observed:

(1) Refer to Table 2.1 and note the three symbols used in the lubrication procedures.

(2) Locate the relevant procedure sheet using the section Contents List.

(3) Complete the instructions in the Lubrication Table against each position number.

Table 2.1 - Symbols Used In Lubrication Procedures

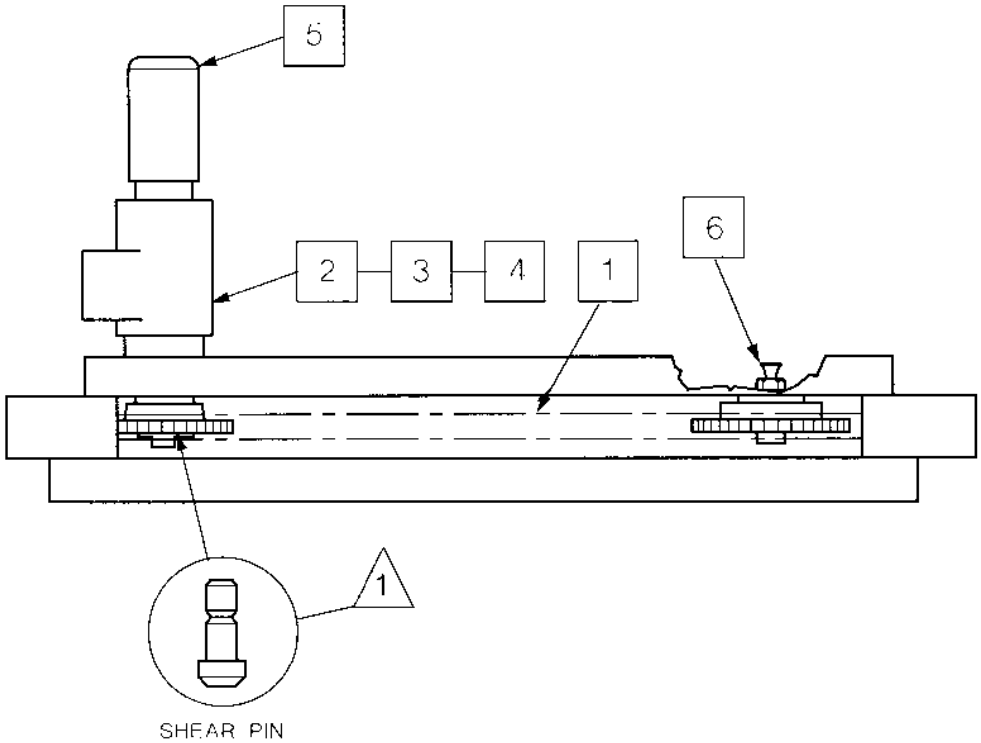
Symbol	Meaning
	Oil is the lubricating medium
	Grease is the lubricating medium
	Refer to special instructions in this manual

LUBRICATION

System: 275L

Component: 3 inch and 4 inch Drive Units

Drawing Nos. 714801, 714802



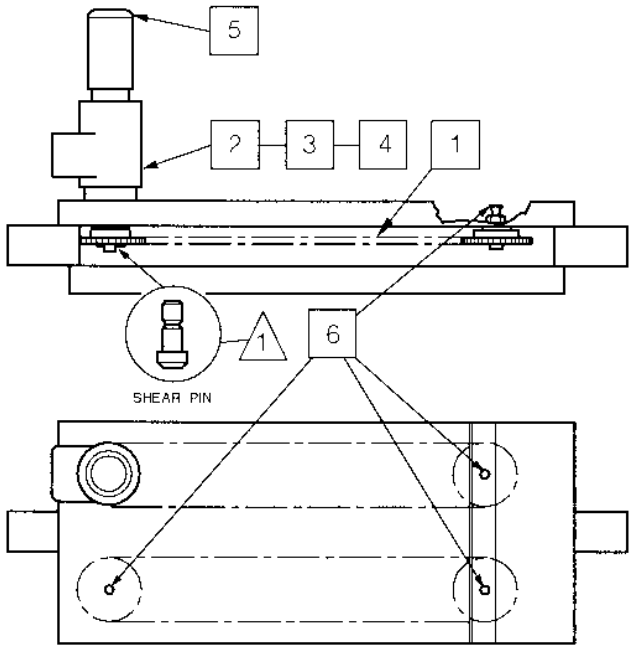
Position	Lubrication Interval	Mode and Quantity
1	35 hours	Drive Chains. Check for lubrication, lubricate as necessary. Rocol chain spray normal temp. Pyrolube 830 or HT grease high temp.
2	200 hours	Gearbox. Top up as necessary using oil recommended on the gearbox label
3	First 500 hours	Gearbox. Drain and replenish
4	2000 hours	Gearbox. Drain and replenish
5	500 hours	Motor bearings. Lightly oil with approx. 6 drops of Shell Tellus 37 or equivalent or grease sparingly if nipples are provided. Remove surplus grease
6	500 hours	Idler wheel spindles. Lightly oil with approx. 6 drops of Shell Tellus 37 or equivalent
1	Before fitting	Shear pin. Lightly grease

LUBRICATION

System: 550M

Component: 3 inch and 4 inch Drive Units

Drawing Nos. 714901, 714902



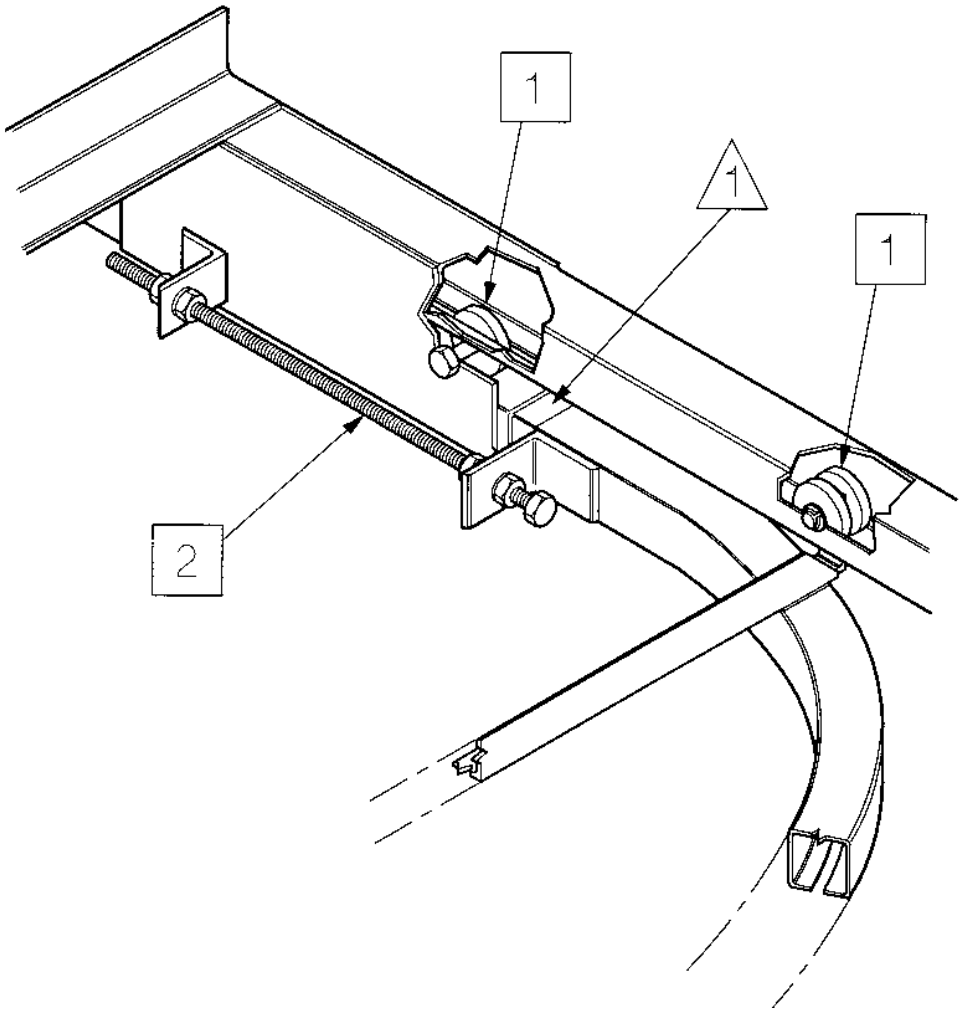
Position	Lubrication Interval	Mode and Quantity
1	35 hours	Drive Chains. Check for lubrication, lubricate as necessary. Rocol chain spray normal temp. Pyrolube 830 or HT grease high temp.
2	200 hours	Gearbox. Top up as necessary using oil recommended on the gearbox label
3	First 500 hours	Gearbox. Drain and replenish
4	2000 hours	Gearbox. Drain and replenish
5	500 hours	Motor bearings. Lightly oil with approx. 6 drops of Shell Tellus 37 or equivalent or grease sparingly if nipples are provided. Remove surplus grease
6	500 hours	Idler wheel spindles. Lightly oil with approx. 6 drops of Shell Tellus 37 or equivalent
1	Before fitting	Shear pin. Lightly grease

LUBRICATION

System: 550M

Component: Tension Unit 610mm Draw Bolt

Drawing Nos. 720201



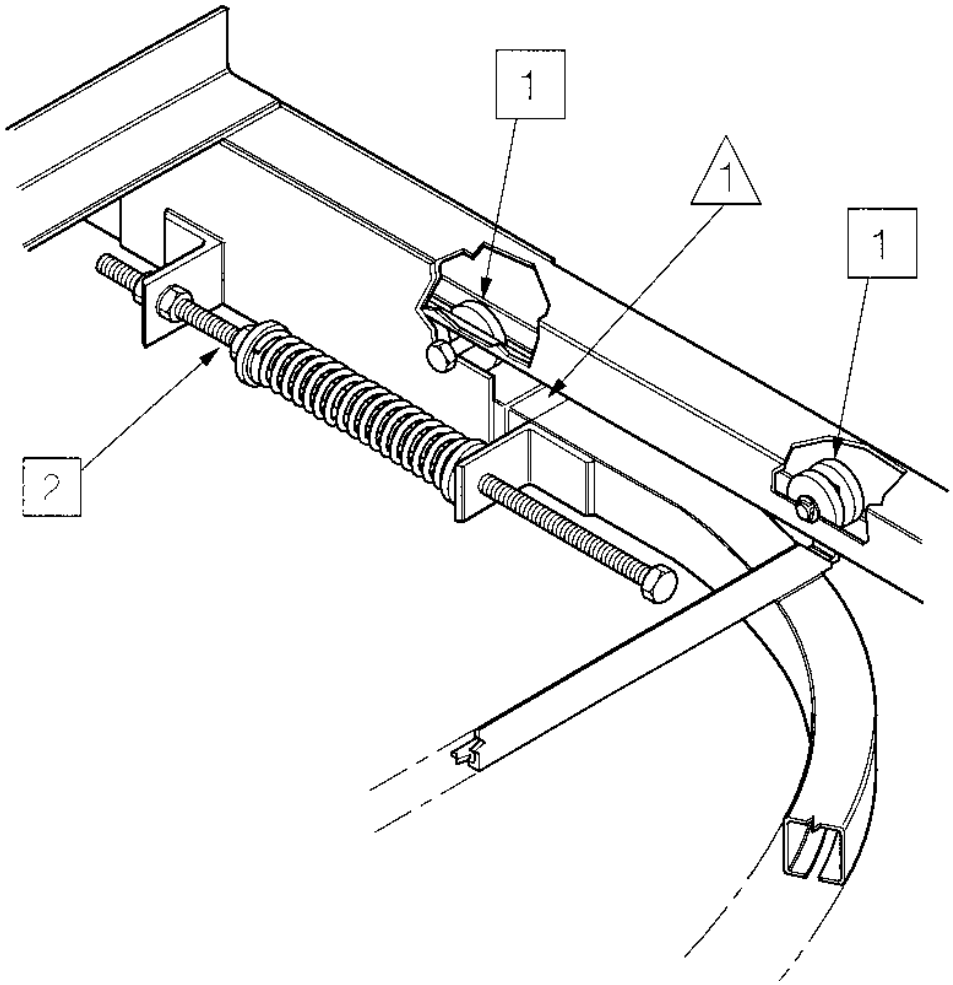
Position	Lubrication Interval	Mode and Quantity
1	500 hours	Rollers and spindles. Lightly oil with approx. 6 drops of Shell Tellus 37 or equivalent
2	500 hours	Draw Bolt. Lightly oil threads with Shell Tellus 37 or equivalent
1	500 hours	Tongue and Sleeve Unit. Grease sliding parts with Shell Alvania or equivalent

LUBRICATION

System: 550M

Component: Tension Unit 610mm Spring

Drawing Nos. 720202



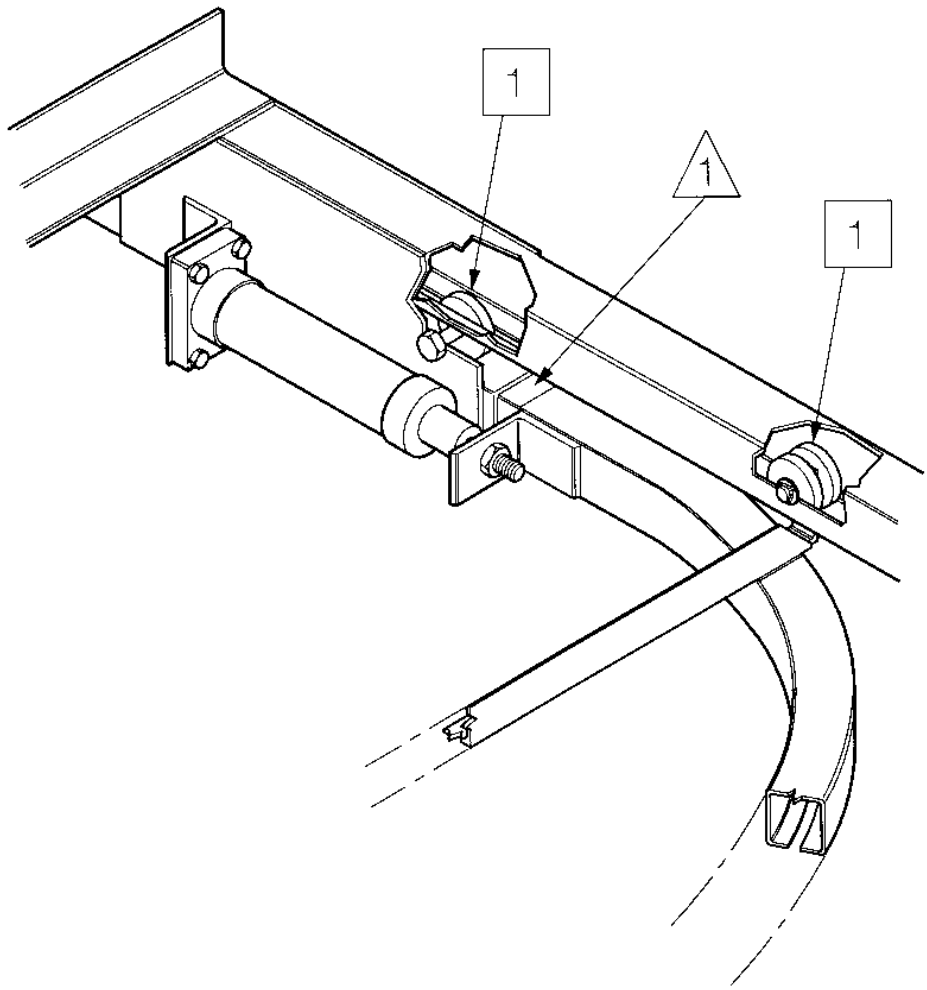
Position	Lubrication Interval	Mode and Quantity
1	500 hours	Rollers and spindles. Lightly oil with approx. 6 drops of Shell Tellus 37 or equivalent
2	500 hours	Tension Studding Bolt. Lightly oil threads with Shell Tellus 37 or equivalent
1	500 hours	Tension Tongue. Grease sliding parts with Shell Alvania or equivalent

LUBRICATION

System: 550M

Component: Tongue and Sleeve Pneumatic Tensioner

Drawing Nos. 722601



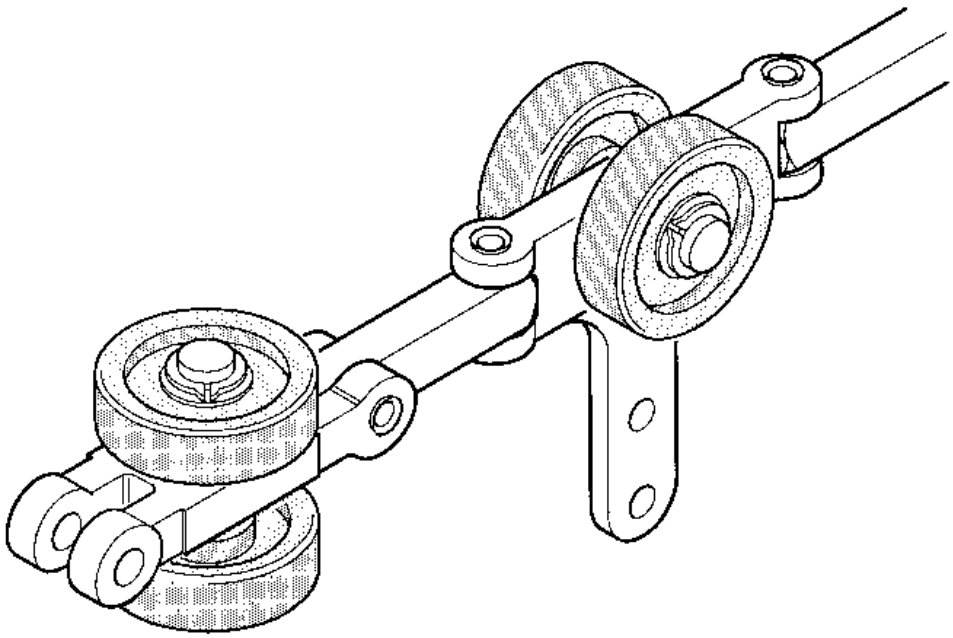
Position	Lubrication Interval	Mode and Quantity
1	500 hours	Rollers and spindles. Lightly oil with approx. 6 drops of Shell Tellus 37 or equivalent
1	500 hours	Tongue and Sleeve. Grease sliding parts with Shell Alvania or equivalent

LUBRICATION

System: 550M Chain

Component: Load Links (Black Nylon Rollers)

Drawing Nos. 763101, 764101,



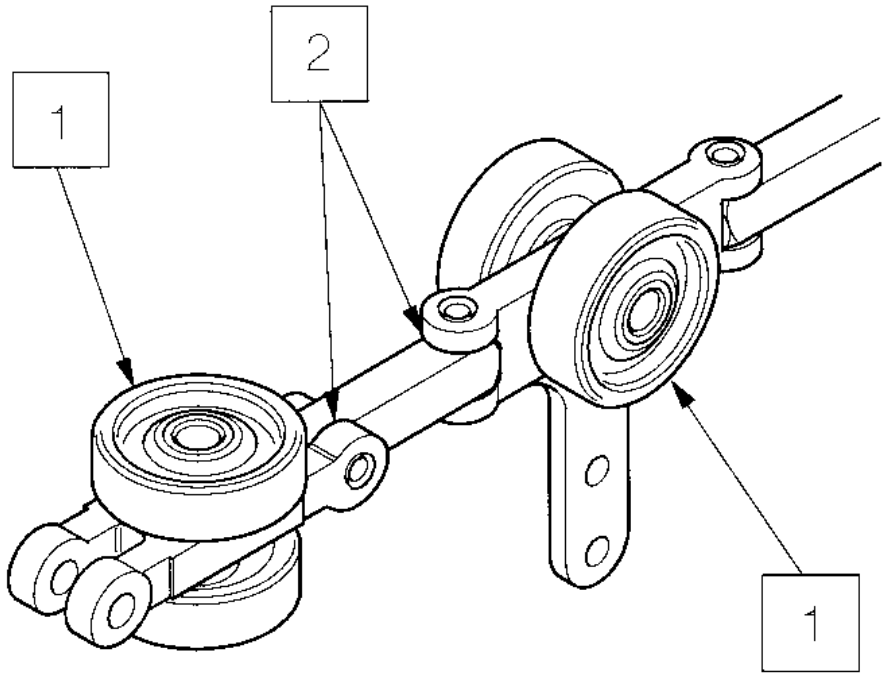
THESE ROLLERS ARE SELF-LUBRICATING

LUBRICATION

System: 550M Chain

Component: Load Links (Pressed Steel Rollers)

Drawing Nos. 763102, 764102,



IF CONVEYOR IS NOT FITTED WITH AN
AUTOMATIC LUBRICATOR CARRY OUT THE FOLLOWING

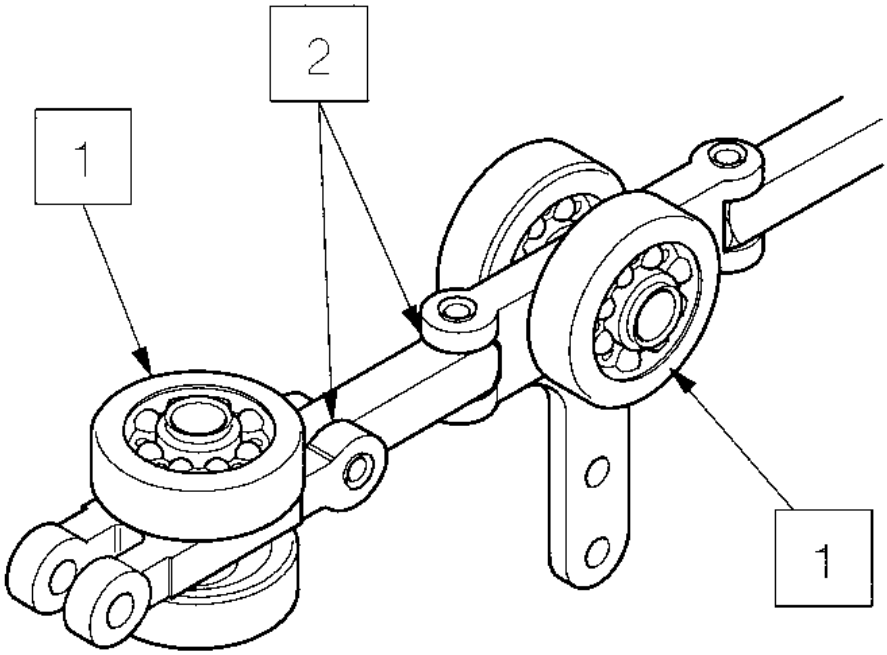
Position	Lubrication Interval	Mode and Quantity
1	200 hours	Rollers. Lightly oil with Shell Tellus 37 or equivalent
2	200 hours	Chain links. Lightly oil with Shell Tellus 37 or equivalent

LUBRICATION

System: 550M Chain

Component: Load Links (Semi-shielded Rollers)

Drawing Nos. 763103, 764103,



IF CONVEYOR IS NOT FITTED WITH AN
AUTOMATIC LUBRICATOR CARRY OUT THE FOLLOWING

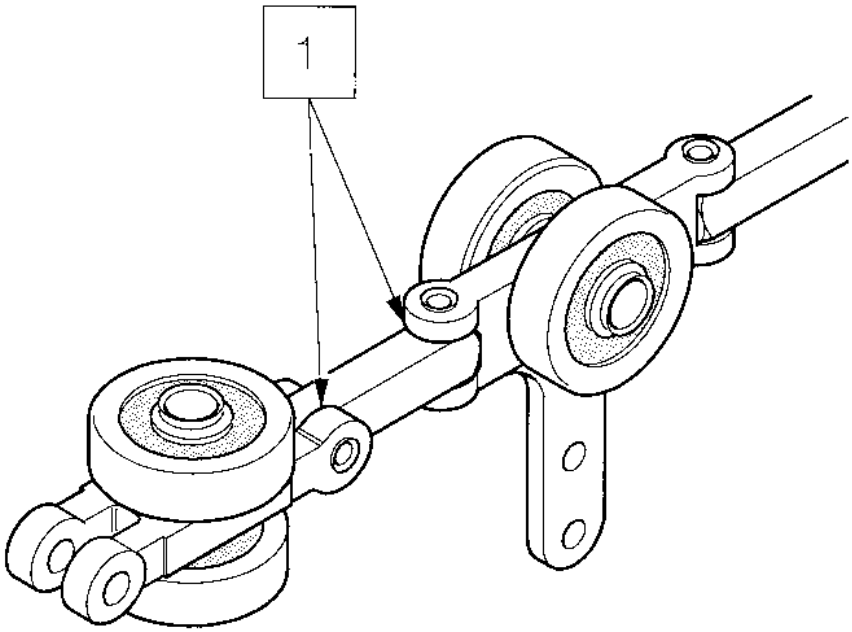
Position	Lubrication Interval	Mode and Quantity
1	200 hours	Rollers. Lightly oil with Shell Tellus 37 or equivalent
2	200 hours	Chain links. Lightly oil with Shell Tellus 37 or equivalent

LUBRICATION

System: 550M Chain

Component: Load Links (Fully Sealed Rollers)

Drawing Nos. 763104, 764104,



IF CONVEYOR IS NOT FITTED WITH AN
AUTOMATIC LUBRICATOR CARRY OUT THE FOLLOWING

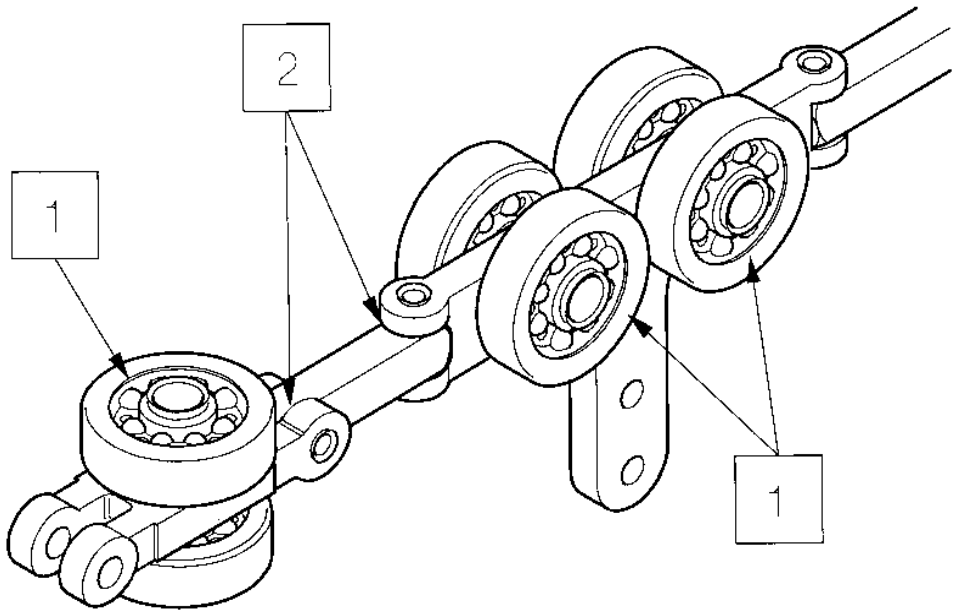
Position	Lubrication Interval	Mode and Quantity
1	200 hours	Chain links. Lightly oil with Shell Tellus 37 or equivalent

LUBRICATION

System: 550M Chain

Component: 4-wheel Load Links
(Semi-shielded Rollers)

Drawing No. 769300



IF CONVEYOR IS NOT FITTED WITH AN
AUTOMATIC LUBRICATOR CARRY OUT THE FOLLOWING

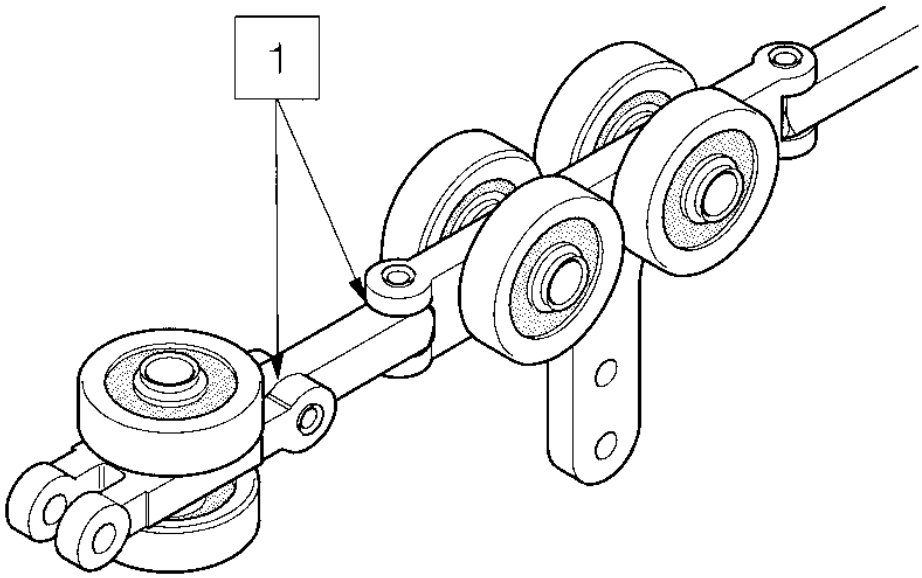
Position	Lubrication Interval	Mode and Quantity
1	200 hours	Rollers. Lightly oil with Shell Tellus 37 or equivalent
2	200 hours	Chain links. Lightly oil with Shell Tellus 37 or equivalent

LUBRICATION

System: 550M Chain

Component: 4-wheel Load Links
(Fully Sealed Rollers)

Drawing No. 769301



IF CONVEYOR IS NOT FITTED WITH AN
AUTOMATIC LUBRICATOR CARRY OUT THE FOLLOWING

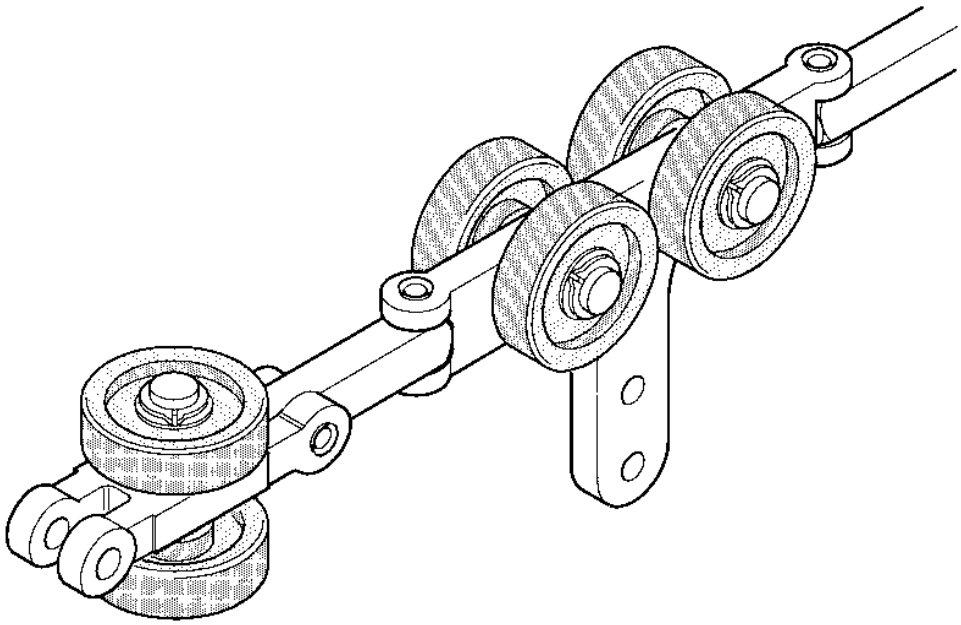
Position	Lubrication Interval	Mode and Quantity
1	200 hours	Chain links. Lightly oil with Shell Tellus 37 or equivalent

LUBRICATION

System: 550M Chain

Component: 4-wheel Load Links (Black Nylon Rollers)

Drawing Nos. 769302



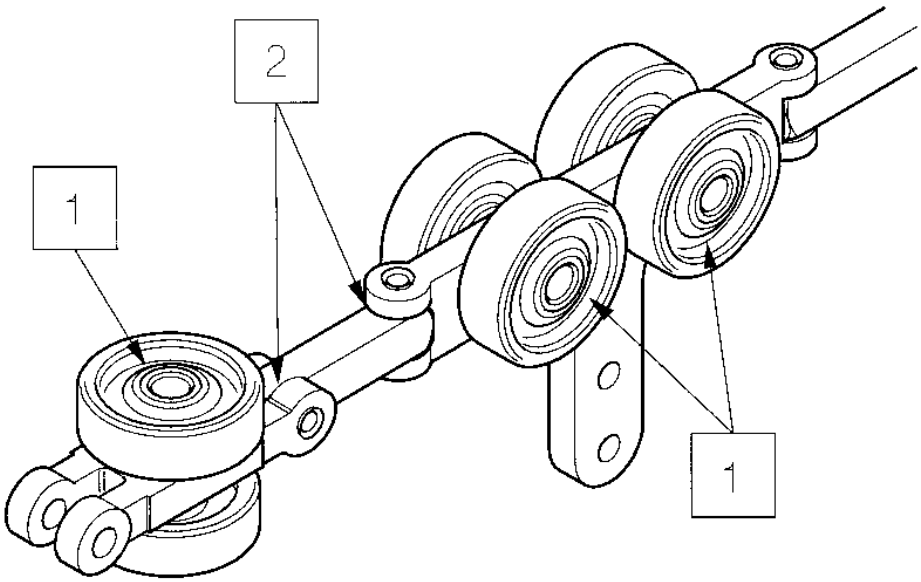
THESE ROLLERS ARE SELF-LUBRICATING

LUBRICATION

System: 550M Chain

Component: 4-wheel Load Links
(Pressed Steel Rollers)

Drawing Nos. 769303



IF CONVEYOR IS NOT FITTED WITH AN
AUTOMATIC LUBRICATOR CARRY OUT THE FOLLOWING

Position	Lubrication Interval	Mode and Quantity
1	200 hours	Rollers. Lightly oil with Shell Tellus 37 or equivalent
2	200 hours	Chain links. Lightly oil with Shell Tellus 37 or equivalent

LUBRICATION

Component: Lister Lubricator for Bi-planer Conveyor Chains

Type: DP Range

SG Part No. 752407

Mechanical Principle

The lubricator is operated by an air cylinder (A), the piston rod of which forms the ram of a displacement-type oil pump.

A three-way valve (B) is opened by contact with the conveyor chain and admits air to the cylinder, causing the ram to move forward and enter the pump chamber. The travel of the ram (and therefore the volume of oil displaced) is governed by the setting of an external limit screw (C).

The oil charge is transferred to a distributor turret (D) which is provided with as many outlets as the conveyor system may require (E).

The onward movement of the conveyor allows the actuating valve to close, the piston rod retracts and draws in a fresh charge of oil while the air exhausting from the cylinder passes back through the valve to the base of the distributor turret and ejects the stored oil charge on to the chain link pins and wheels (F).

Note: This is not a mist lubricator - the oil 'shot' is loaded into the turret by the oil pump ram and then ejected by a tiny pulse of compressed air precisely in the manner of a shot from a gun. The turret can sub-divide a single charge of oil into extremely small amounts but these are ejected in the form of droplets which are too large to become airborne as a mist.

Operating Instructions

Fill the reservoir with clean lubricant. (See Notes on recommended oils).

Slacken the locknut on the metering screw and turn the screw clockwise as far as it will go, taking care not to apply undue pressure. The ram of the oil pump is now fully retraced and held in that position by the metering screw. To commission the lubricator, turn the metering screw anti-clockwise five full turns (each turn represents 35 mm^3 of oil delivery.

Supply air at a preferred 5 bar to Port 1 of the actuating valve.

Adjust the position of the valve so that its actuating roller is fully opened by contact with the conveyor load wheel, but is not forced. The maximum travel of the wheel is 5 mm.

The ram of the oil pump moves forward as the valve opens and back as it closes. At each actuation a slight 'knock' will be heard and felt at the reservoir as the oil pump ram contacts the end of the metering screw.

After a few strokes oil will be observed in the transparent delivery pipe leading from the top of the pump block to the base of the distributor turret. This column of oil should move forward about one centimetre each time the valve operates until it enters the base of turret.

Continue to operate the valve until the oil is seen to be ejected from the oiler heads on to the conveyor chain.

Once the conveyor is in service the amount of oil applied should be progressively reduced until the chain is running with its components just moist with oil but not dripping off.

LUBRICATION

Component:	Lister Lubricator for Bi-planer Conveyor Chains
Type:	DP Range
SG Part No.	752407

Operating Instructions (Continued)

Conveyor systems operating in high temperature environments may require the constant application of a suitable extreme temperature lubricant, while those working in less arduous conditions may be lubricated intermittently - preferably by Fault Finding and Diagnosis.

Lister Pneumatic Conveyor Lubricators (DP Models) have only two moving parts - the actuating valve and the piston rod of the pump cylinder. If these are not working, check:

1. That air is supplied to the valve at the correct pressure and that it is reaching the cylinder (blue pipe).
2. That the cylinder is working: remove the metering screw and insert a thin rod to contact the end of the pump ram. Actuate the valve and forward movement of the ram should be felt - if not, either the valve or the cylinder is defective. If the latter, do not attempt to dismantle it from the pump block, but return either the pump unit alone or the complete reservoir and pump assembly to the manufacturer, who will replace it at a nominal cost. (Free, within the 12 month's warranty period).
3. If the valve and pump unit are working but no oil is being ejected, the non-return valve or the delivery pipe is probably obstructed by dirt or, if graphite or molysulphide dispersions are being used, by settled-out residues of solid lubricant.

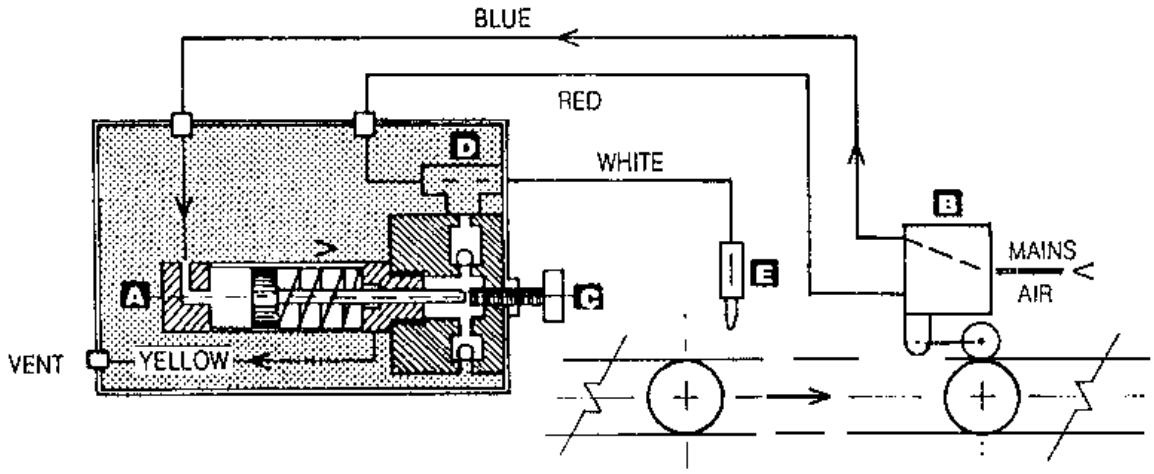
Recommended Lubricating Oils

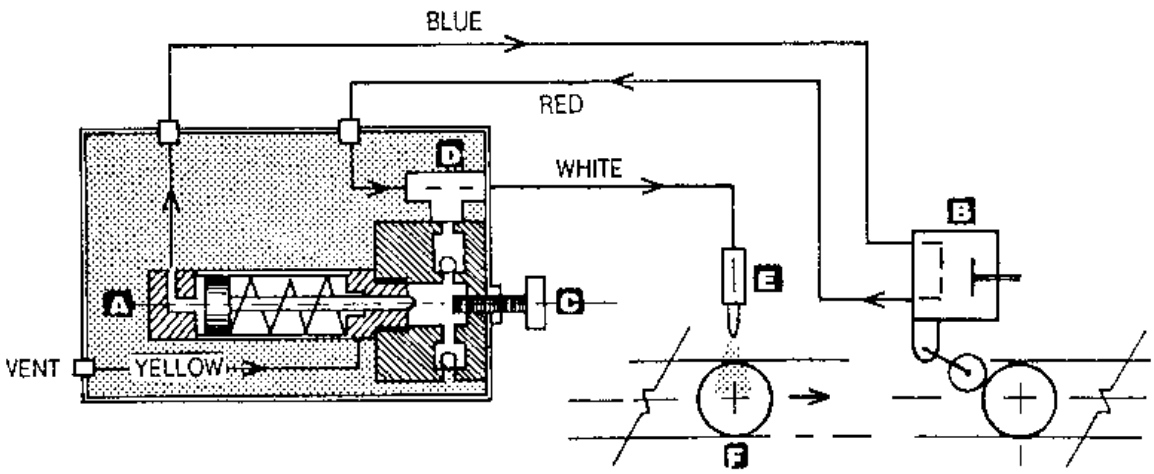
High temperature applications (max. 260°) - use Mobil Pyrolube 830.

Ambient temperature conditions - use Shell Tellus 37 or equivalent.

LUBRICATION

Component:	Lister Lubricator for Bi-planer Conveyor Chains
Type:	DP Range
SG Part No.	752407



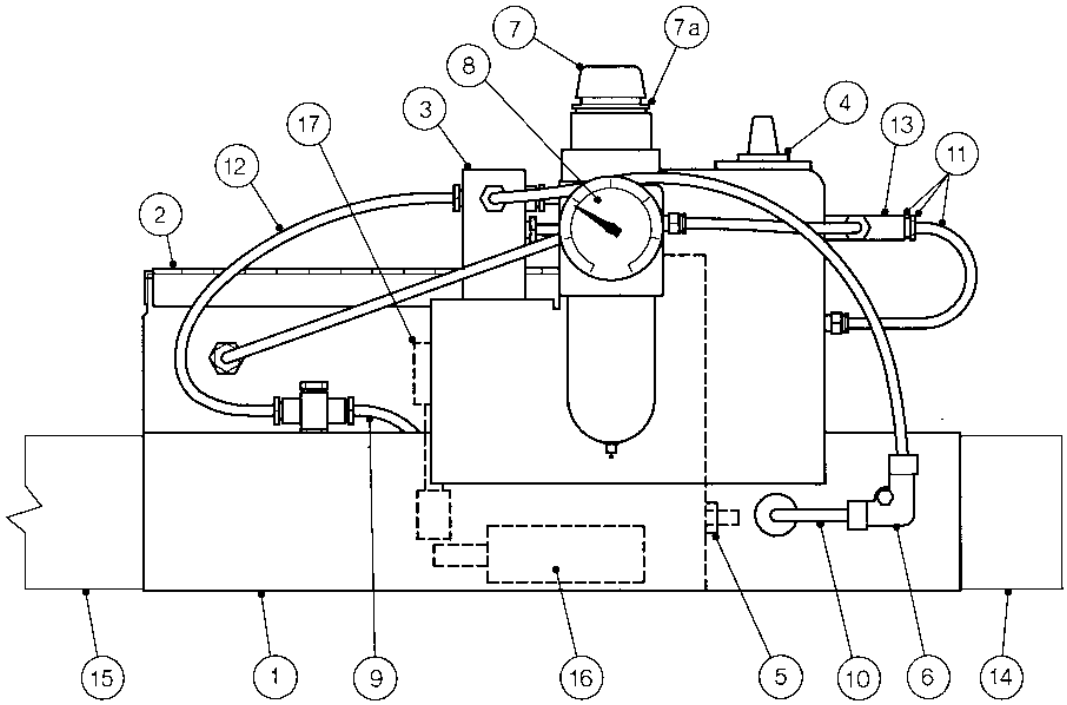


LUBRICATION

Component: Lister Lubricator for Bi-planer Conveyor Chains

Type: DP Range

SG Part No. 752407



Item No.	Description	Item No.	Description
1	Saddle Plate	9	Upper Oil Head Pipe
2	Reservoir	10	L/Wheel Oil Head Pipe
3	Distributor Turret	11	Tubes, Nuts and Sleeves
4	Actuating Valve	12	Nylon Piping **Error!** inch dia.
5	Metering Screw (Complete)	13	Male Side Tee
6	Pipe Connectors	14	'STS' Track
7	Air Filter/Regulator	15	Inspection Station
7a	Pressure Lock	16	Pneumatic Oil Pump
8	Pressure Gauge	17	Oil Level Indicator

SECTION 3 - MAINTENANCE

CONTENTS

System	Component	Page No.
275L	3 inch and 4 inch Drive Units	35
550M Mk. 2	3 inch and 4 inch Drive Units	36
275L/550M	Track, Track Connectors and Supports	37
275L/550M	Load Links	38
275L/550M	Tension Units	39

SECTION 3 – MAINTENANCE

This section contains the preventive maintenance procedures applicable to the conveyor. It is essential that these routines are carried out at the intervals specified in order to achieve optimum plant perfomance and long life.

Additional maintenance for harsh environments.

When the conveyor system is installed in a particularly dusty or abrasive environment (e.g. shot blasting), the chain should be removed and thoroughly cleaned at intervals not exceeding 6 months using a degreasing agent suchas JIZER. At this stage, the track and drive unit should be examined and thoroughly cleaned.

All parts must be thoroughly rinsed prior to re-use.

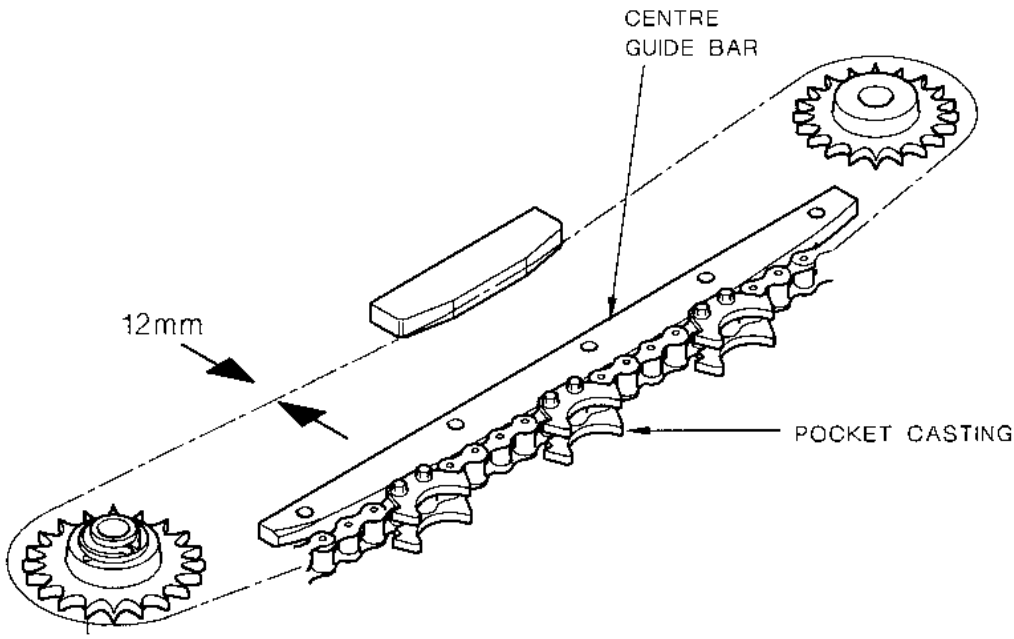
Note: Care must be taken when handling solvent based cleaning products. Manufacturers Health & Safety guidelines must always be followed. (See Appendix 1 for Health & Safety Data Sheet)

MAINTENANCE

System: 275L

Component: 3 inch and 4 inch Drive Units

Drawing No. 714801, 714802



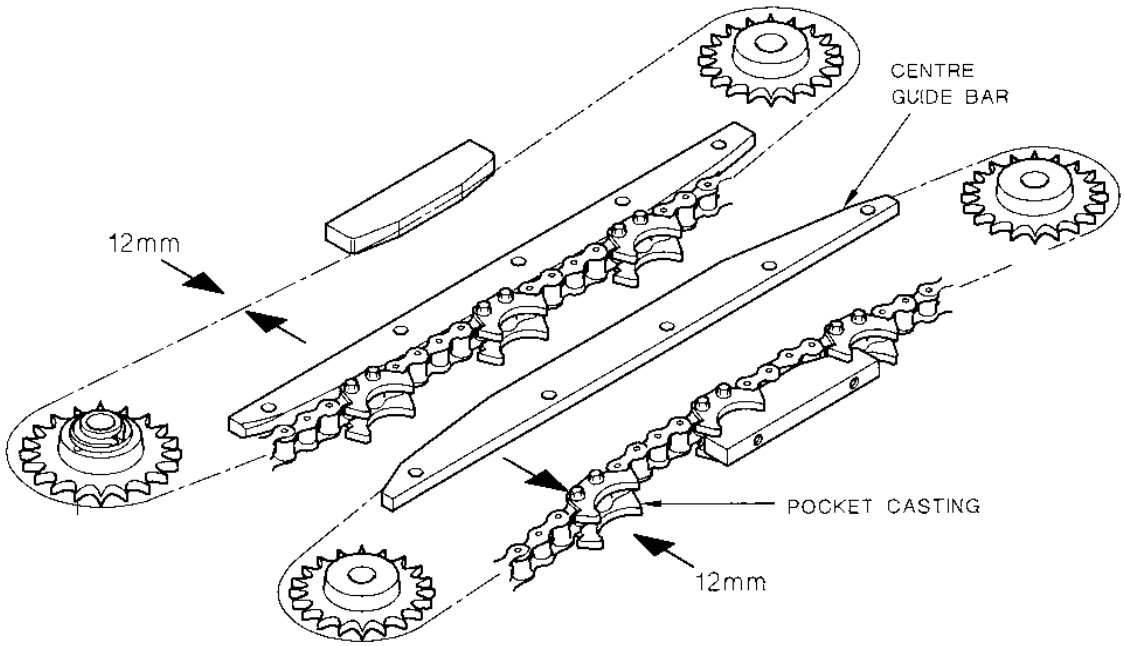
Servicing Interval	Servicing Instruction	Remarks
35 hours	Check the tension of the driving chains within the drive unit as shown. Adjust as necessary. If too much slack to adjust - replace chain. Check lubrication.	See Section 2
200 hours	Carry out drive unit gearbox lubrication routine.	See Section 2
500 hours	Carry out drive unit gearbox lubrication routine.	See Section 2
500 hours	Carry out drive motor and idler wheel spindle lubrication routines.	See Section 2
500 hours	Remove the drive sprocket shear pin and inspect. If not damaged grease and replace.	
500 hours	Check for any wear on centre guide bars. Replace if worn.	
500 hours	Check for excessive wear on pocket castings. Replace if necessary.	

MAINTENANCE

System: 550M Mk. 2

Component: 3 inch and 4 inch Drive Units

Drawing No. 714901, 714902

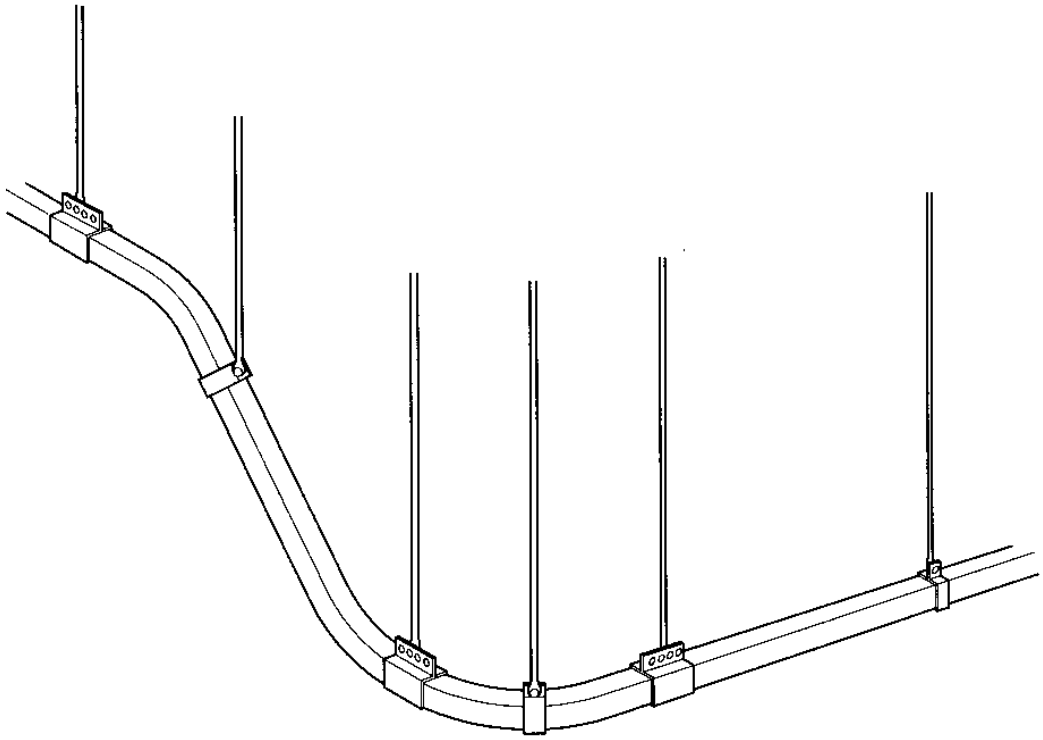


Servicing Interval	Servicing Instruction	Remarks
35 hours	Check the tension of the driving chains within the drive unit as shown. Adjust as necessary. If too much slack to adjust - replace chains. Check lubrication.	See Section 2
200 hours	Carry out drive unit gearbox lubrication routine.	See Section 2
500 hours	Carry out drive unit gearbox lubrication routine.	See Section 2
500 hours	Carry out drive motor and idler wheel spindle lubrication routines.	See Section 2
500 hours	Remove the drive sprocket shear pin and inspect. If not damaged grease and replace.	
500 hours	Check for any wear on centre guide bars. Replace if worn.	
500 hours	Check for excessive wear on pocket castings. Replace if necessary.	

MAINTENANCE

System: 275L/550M

Component: Track, Track Connectors and Supports



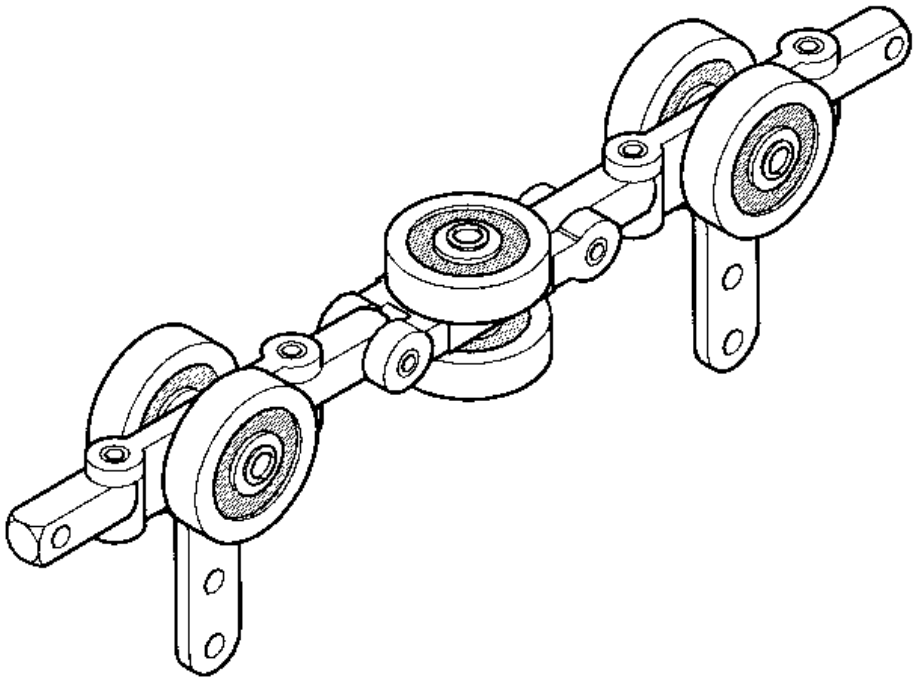
Servicing Interval	Servicing Instruction	Remarks
500 hours	Check the security of all track connectors and support fittings especially at the track 'rise' and 'fall' sections. Tighten bolts and nuts as necessary. Examine track for signs of wear. Replace in case of fault. Contact Customer Engineering Department.	

MAINTENANCE

System: 275L/550M

Component: Load Links

Drawing Nos. 763101, 763102, 763103, 763104,
764101, 764102, 764103, 764104,
769300, 769301, 769302, 769303



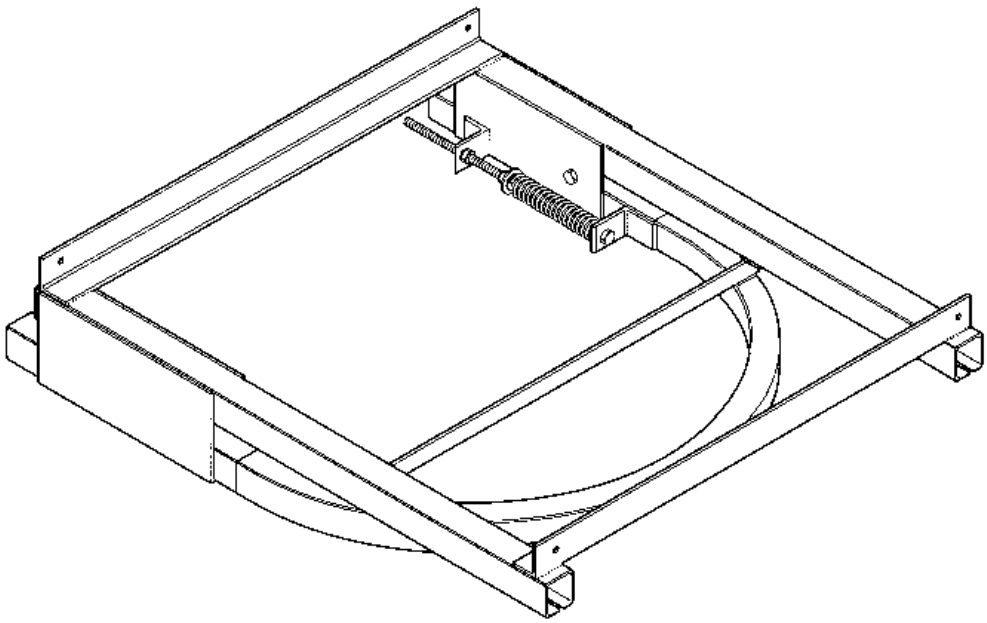
Servicing Interval	Servicing Instruction	Remarks
200 hours	Carry out load link lubrication routine (not black nylon rollers).	See Section 2
500 hours	Look for wear on load links and for play at rollers.	
500 hours	Check the security of the chain parts such as roller retaining circlips (black nylon rollers) and connecting pins.	
500 hours	Check for wear on load links Check for roller play. Replace in case of fault. Contact Customer Engineering Department.	

MAINTENANCE

System: 275L/550M

Component: Tension Units

Drawing Nos. 720201, 720202, 722601



Servicing Interval	Servicing Instruction	Remarks
35 hours	Check the conveyor chain tension and adjust if necessary. Replace in case of fault. Contact Customer Engineering Department.	Avoid excessive tensioning
500 hours	Carry out lubrication routine.	See Section 2

SECTION 4 - PARTS LISTS

CONTENTS

System	Component	Page No.
275L	3 inch Drive Basic In-line	43
275L	4 inch Drive Basic In-line	48
550M Mk. 2	3 inch Drive Basic In-line for RF60	53
550M Mk. 2	3 inch Drive Basic In-line for RF70	58
550M Mk. 2	3 inch Drive Basic In-line for RF80	63
550M Mk. 2	4 inch Drive Basic In-line for RF60	68
550M Mk. 2	4 inch Drive Basic In-line for RF70	73
550M Mk. 2	4 inch Drive Basic In-line for RF80	78
275L/550M	3 inch Pitch Drive Chain	83
275L/550M	4 inch Pitch Drive Chain	84
550M	Sprocket Drive Housing RF70 180 Degrees	85
550M	Drive Wheel 4 inch Pitch RF70 570 CTRS	85
275L/550M	Tension Unit 610mm Draw Bolt	87
275L/550M	Tension Unit 610mm Spring	90
275L/550M	Tongue and Sleeve Pneumatic Tensioner	93
275L/550M	Bends Vertical	98
275L/550M	Bends Horizontal	100
275L/550M	Track with Chamfer	102
275L/550M	Lister Lubricator and Inspection Station	103
275L/550M	Inspection Station Plated	104
275L/550M	Track 'Z' Bracket Pair Plated	105
275L/550M	Track Hanger Bracket Pair Plated	106
275L/550M	Track Connector Pair Plated	107
550M	4-wheel Load Link with Guide Roller	108
550M	4 inch P x 8 inch LL with Guide Roller	109
550M	Load Link Nylon Roller S/A	110
550M	Load Link S/S Roller S/A	111

CONTENTS (continued)

System	Component	Page No.
550M	Load Link P/S Roller S/A	112
550M	Load Link F/S Roller S/A	113
550M	4-wheel Load Link with P/S Roller	114
550M	4-wheel Load Link with Nylon Roller	115
550M	4-wheel Load Link with F/S Roller	116
550M	4-wheel Load Link with S/S Roller	117
550M Chain	4 inch P x 8 inch LL F/S Pitch	118
550M Chain	4 inch P x 8 inch LL S/S Pitch	119
550M Chain	4 inch P x 8 inch LL P/S Pitch	120
550M Chain	4 inch P x 8 inch LL MDS Pitch	121
550M Chain	3 inch P x 6 inch LL F/S Pitch	122
550M Chain	3 inch P x 6 inch LL S/S Pitch	123
550M Chain	3 inch P x 6 inch LL P/S Pitch	124
550M Chain	3 inch P x 6 inch LL MDS Pitch	125

SECTION 4 - PARTS LISTS

This section comprises comprehensive parts lists for the conveyor system. To obtain details of the item required, first identify the main assembly from the contents sheet, then turn to the appropriate parts list. Smaller assemblies or components are identified by reference to the diagrams and to the accompanying tables.

When ordering parts please give a full description, quoting its position and part number and state the quantity required.

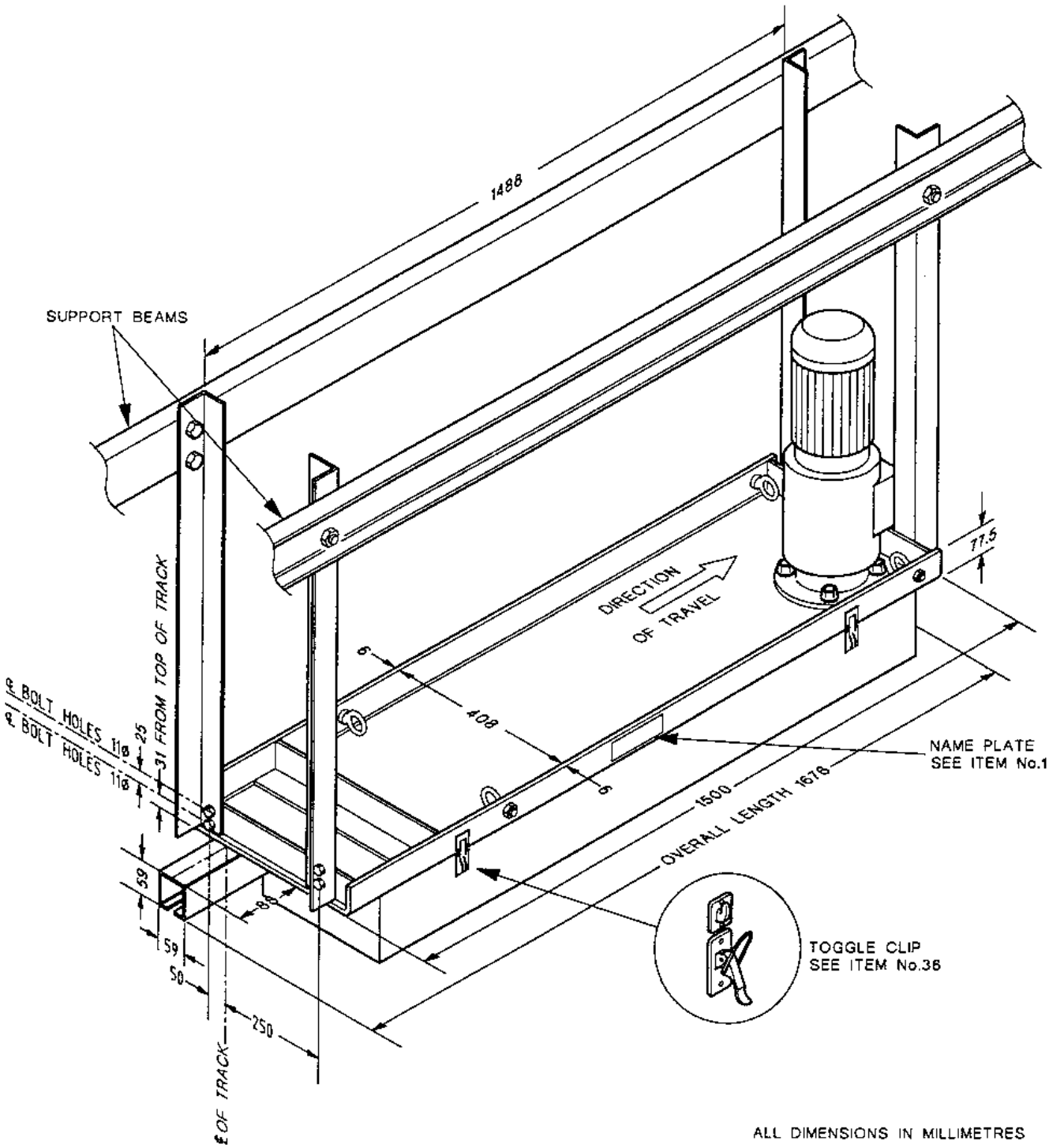
To order any 'special-to-type' items not listed, contact our Customer Engineering Department, quoting the plant number (found on any installed drive unit).

PARTS LIST

System: 275L

Component: 3 inch Drive Basic In-line

Drawing No. 714801

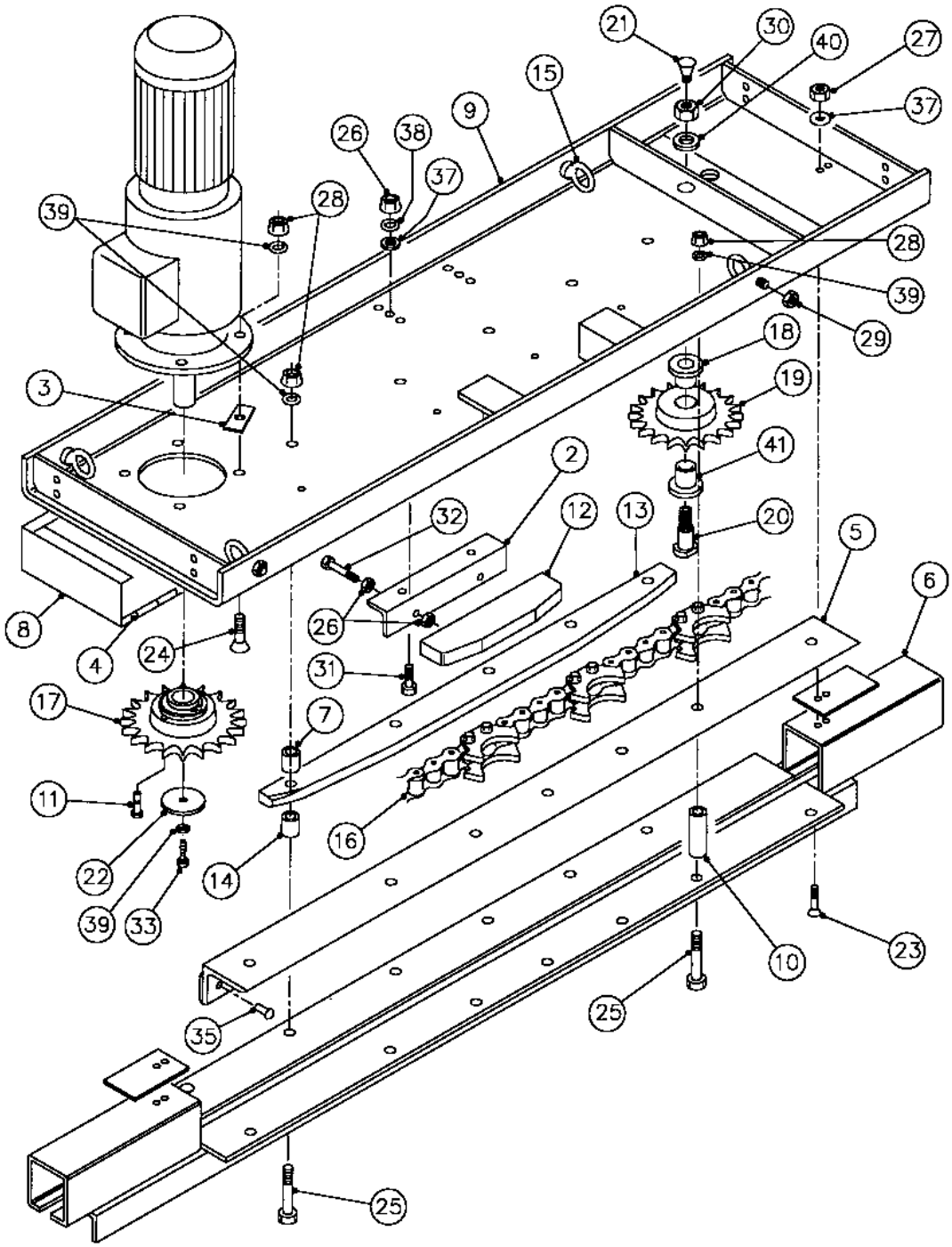


PARTS LIST

System: 275L

Component: 3 inch Drive Basic In-line

Drawing No. 714801



PARTS LIST

System: 275L

Component: 3 inch Drive Basic In-line

Drawing No. 714801

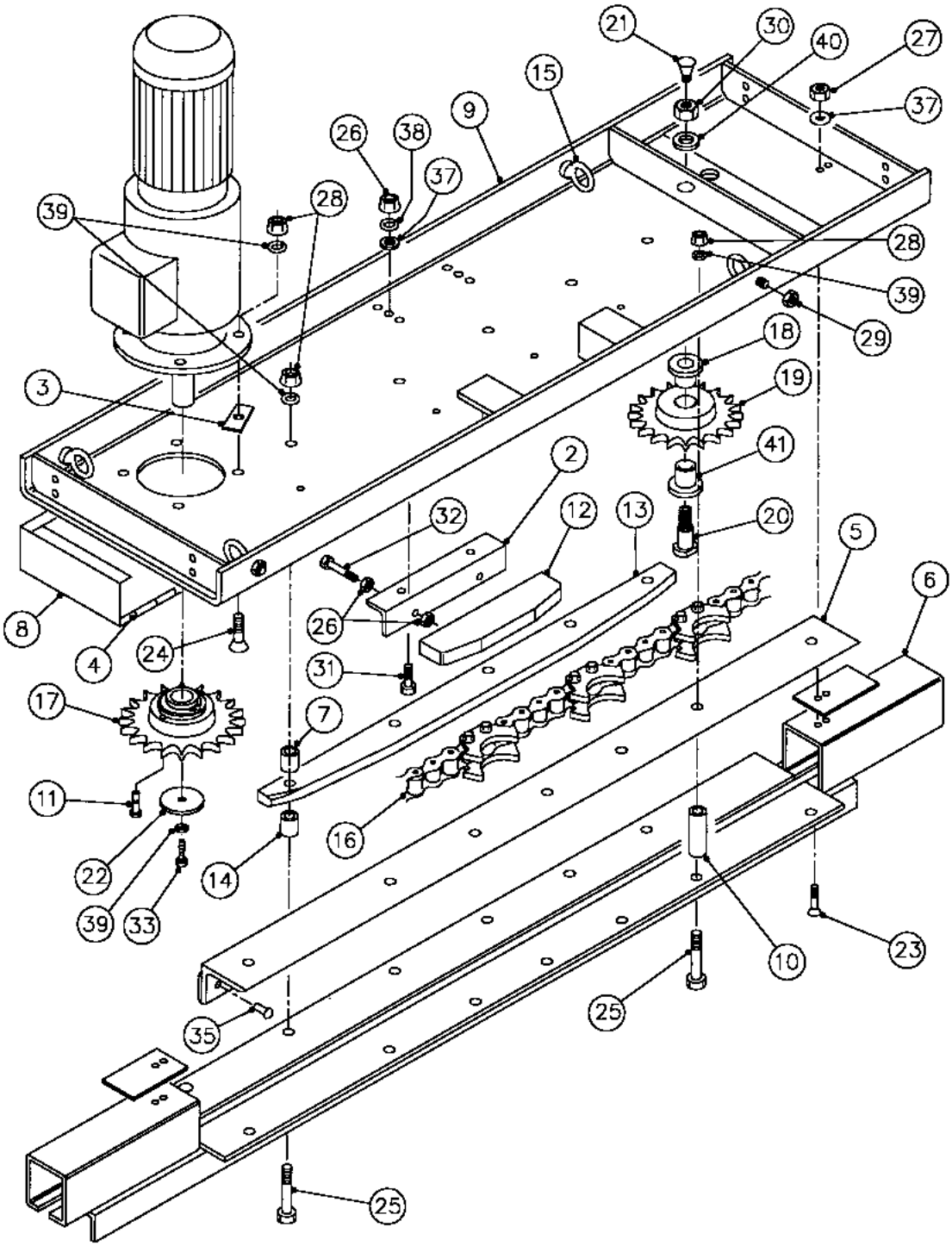
Item No.	Description	Part No.	Qty.	Remarks
1	SG Standard Nameplate (HO No.)	1015X0	1	See Page 1
2	275L Tension Blade Support	713100	1	
3	275L Gearbox Packing Block	713300	4	
4	200L Drive Guard Hinge (Piano)	7136X0	3	
5	275L Rear Track Section & Strip	714804	1	
6	275L Running Track Assembly	714805	1	
7	275L Drive Guide Bar Spacer 22.4mm Long	714807	5	
8	275L Drive Guard Hinge and N/plate S/A	714809	1	
9	275L Drive Base Plate	7148X0	1	
10	275 Rear Track Spacer	7148X3	7	
11	275L Shearpin 5.5mm Groove	7148X4	20	Only One Fitted
12	275/550 Drive Chain Retaining Blade Nylon	7148X6	1	
13	275L/550M Drive Guide Bar	7148X9	1	
14	550 Drive Guide Bar Spacer 21.5mm	714906	5	
15	M12 Dynamo Lifting Eyebolts	7149X2	4	
16	550M Drive Chain 3 inch Pitch	716603	1	
17	Drive Parts 30mm Bore RF60	717003	1	
18	Idler Bearing FGH401 Machined	717500	2	
19	Idler Sprocket 1**Error!** inch Bore	7175X0	1	
20	Idler Sprocket Spindle 20mm	7176X0	1	
21	Idler Sprocket Fl/Flap Lub. BS 1516	7176X1	1	
22	Gearbox Retaining Plate	717900	1	
23	M8 x 25 Slotted C'sk Screw Plated	CSM08025P	4	
24	M10 x 40 Slotted C'sk Screw Plated	CSM10040P	4	

PARTS LIST

System: 275L

Component: 3 inch Drive Basic In-line

Drawing No. 714801



PARTS LIST

System: 275L

Component: 3 inch Drive Basic In-line (Continued)

Drawing No. 714801

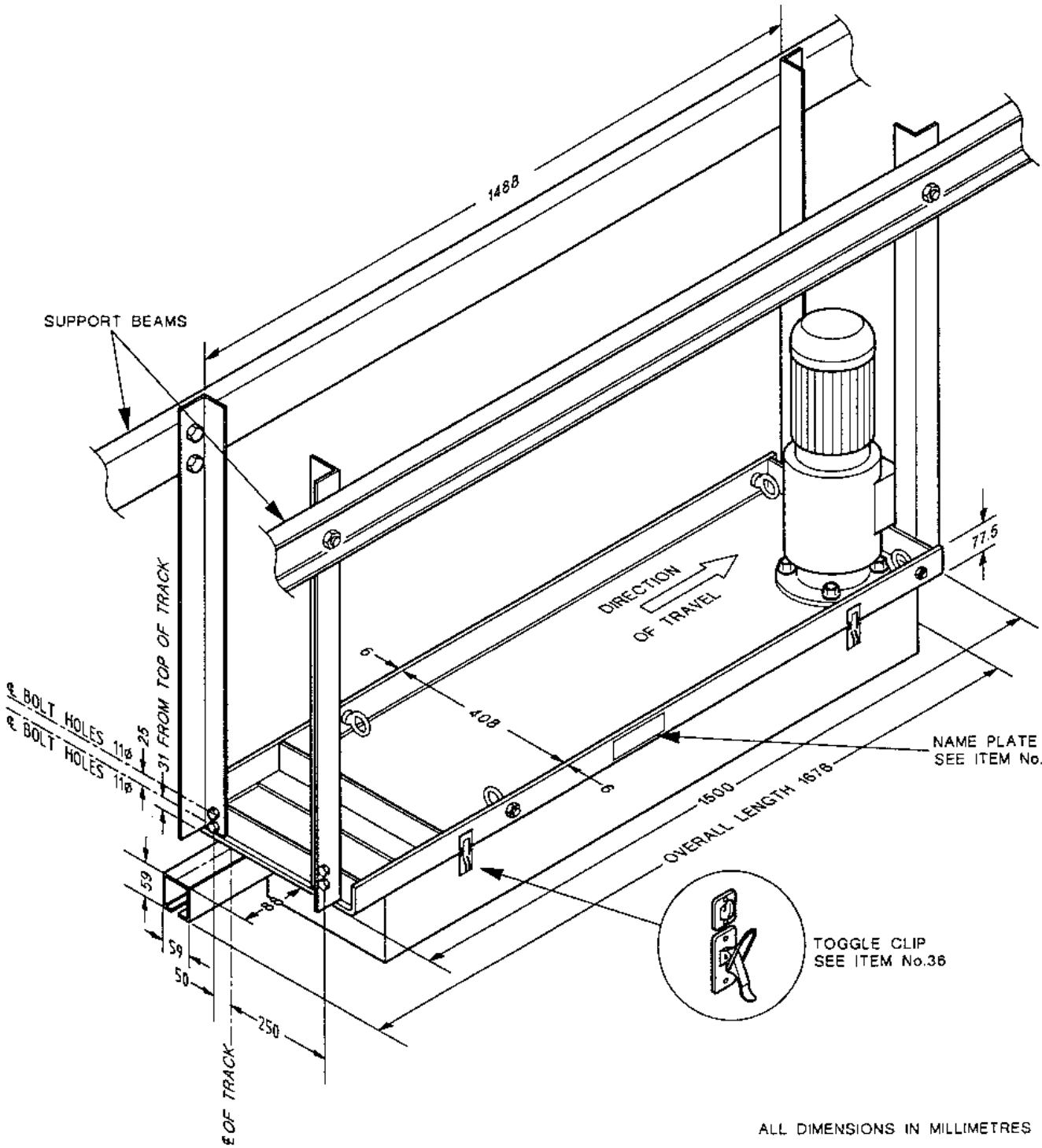
Item No.	Description	Part No.	Qty.	Remarks
25	M10 x 90 Hex. Headed Bolt Plated	HBM10090P	12	
26	M8 Hex. Full Nut Plated	HNM08NUTP	6	
27	M8 Nylon Insert Lock Nut Plated	HNM08NYLP	4	
28	M10 Hex. Full Nut Plated	HNM10NUTP	16	
29	M12 Hex. Full Nut Plated	HNM12NUTP	4	
30	M20 Nylon Insert Locknut Plated	HNM20NYLP	1	
31	M8 x 25 Hex. Headed Screw Plated	HSM08025P	2	
32	M8 x 75 Hex. Headed Screw Plated	HSM08075P	2	
33	M10 x 40 Hex. Headed Set Screw Plated	HSM10040P	1	
34	Warning Drive Guard Assembly	Label 3	1	Not Shown
35	3.2 Dia x 9. 1 LG Domed Head Al. Pop Rivet	PR3. 2D9. 1	20	
36	Toggle Clip (Drive Guard Assembly)	TOGL CLIP	2	See Page 1
37	M8 Flat Washer Plated	WAM08FLTP	6	
38	M8 Spring Washer Plated	WAM08SPRP	2	
39	M10 Spring Washer Plated	WAM10SPRP	17	
40	M20 Flat Washer Plated	WAM20FLTP	1	
41	Idler Bearing 1FGH 401	7175X1	1	

PARTS LIST

System: 275L

Component: 4 inch Drive Basic In-line

Drawing No. 714802

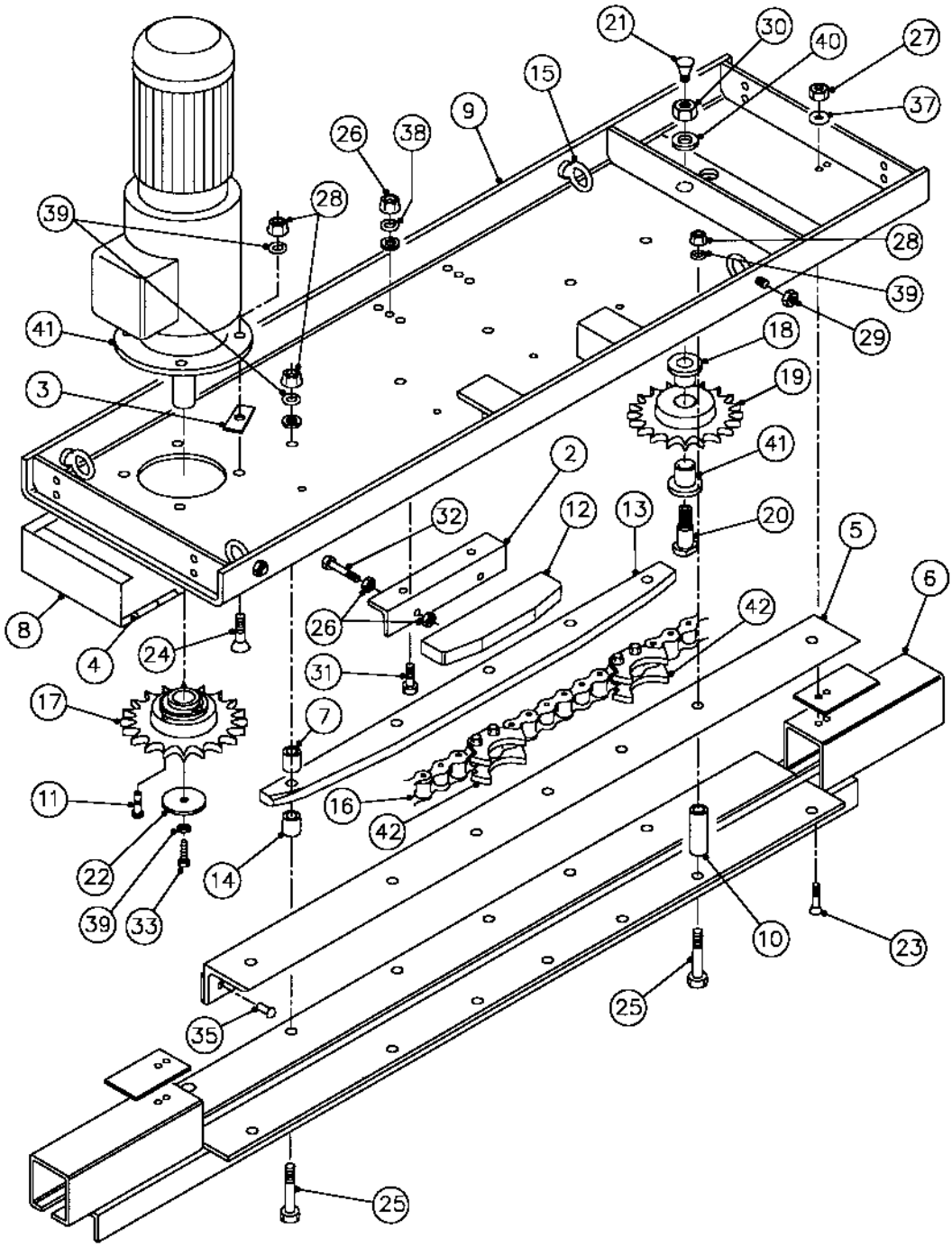


PARTS LIST

System: 275L

Component: 4 inch Drive Basic In-line

Drawing No. 714802



PARTS LIST

System: 275L

Component: 4 inch Drive Basic In-line

Drawing No. 714802

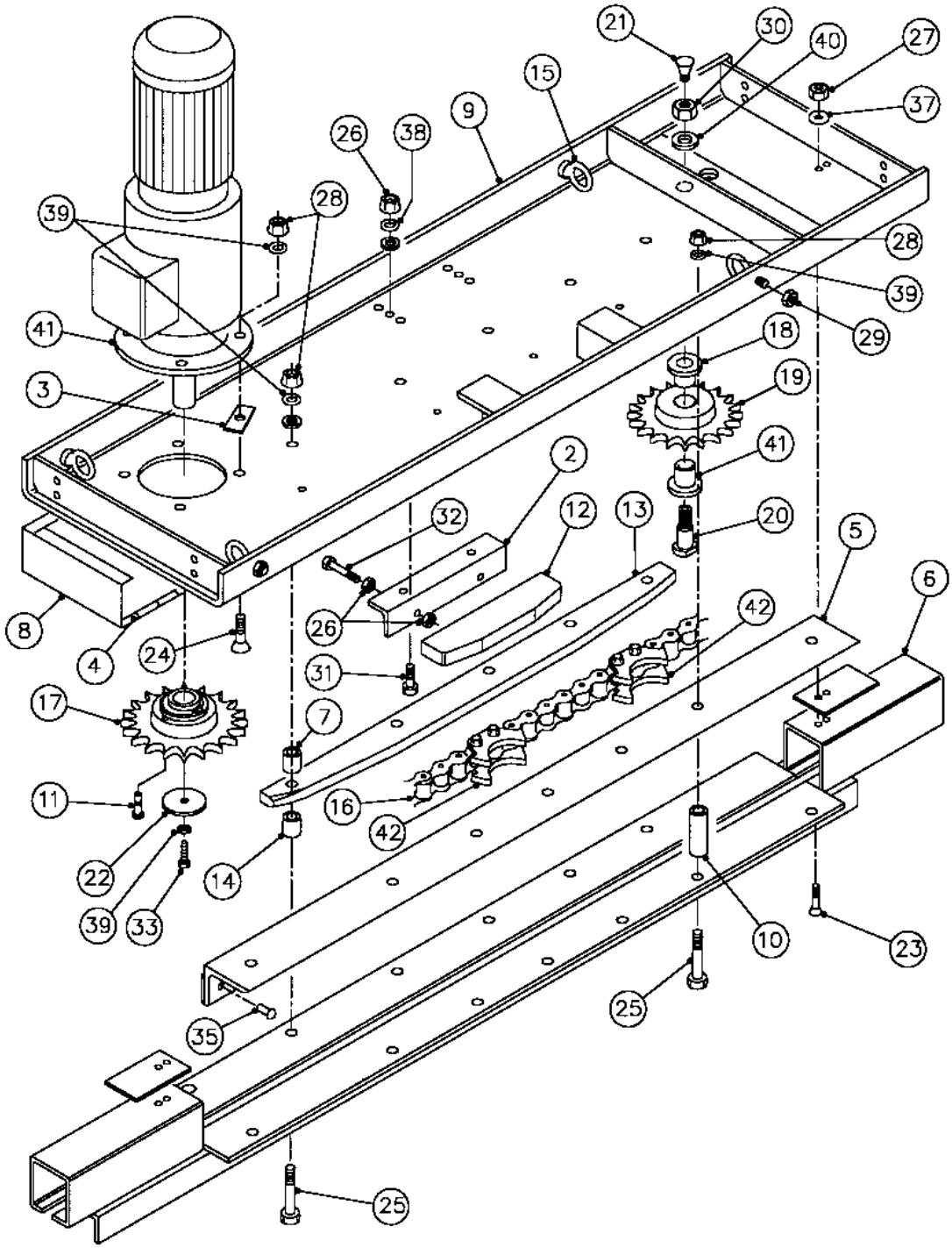
Item No.	Description	Part No.	Qty.	Remarks
1	SG Standard Nameplate (HO No.)	1015X0	1	See Page 1
2	275L Tension Blade Support	713100	1	
3	275L Gearbox Packing Block	713300	4	
4	200L Drive Guard Hinge (Piano)	7136X0	3	
5	275L Rear Track Section & Strip	714804	1	
6	275L Running Track Assembly	714805	1	
7	275L Drive Guide Bar Spacer 22.4mm Long	714807	5	
8	275L Drive Guard Hinge and N/plate S/A	714809	1	
9	275L Drive Base Plate	7148X0	1	
10	275 Rear Track Spacer	7148X3	7	
11	275L Shearpin 5.5mm Groove	7148X4	20	Only One Fitted
12	275/550 Drive Chain Retaining Blade Nylon	7148X6	1	
13	275L/550M Drive Guide Bar	7148X9	1	
14	550 Drive Guide Bar Spacer 21.5mm	714906	5	
15	M12 Dynamo Lifting Eyebolts	7149X2	4	
16	550M Drive Chain 4 inch Pitch	716604	1	
17	Drive Parts 30mm Bore RF60	717003	1	
18	Idler Sprocket Bearing 1 inch FGH401 Machined	717500	2	
19	Idler Sprocket 1**Error!** inch Bore	7175X0	1	
20	Idler Sprocket Spindle 20mm	7176X0	1	
21	Idler Sprocket Fl/Flap Lub. BS 1516	7176X1	1	
22	Gearbox Retaining Plate	717900	1	
23	M8 x 25 Slotted C'sk Screw Plated	CSM08025P	4	
24	M10 x 40 Slotted C'sk Screw Plated	CSM10040P	4	

PARTS LIST

System: 275L

Component: 4 inch Drive Basic In-line

Drawing No. 714802



PARTS LIST

System: 275L

Component: 4 inch Drive Basic In-line (Continued)

Drawing No. 714802

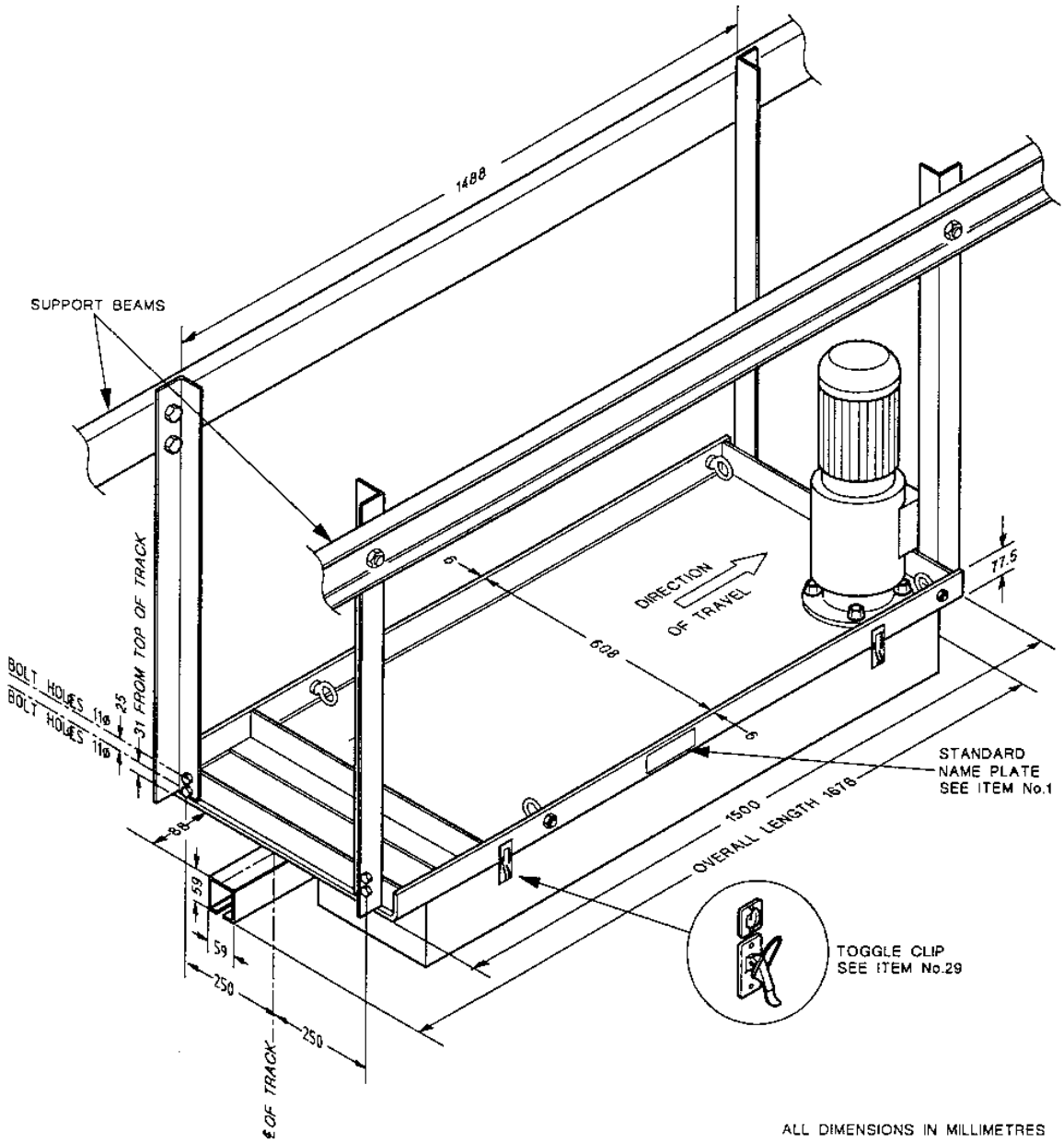
Item No.	Description	Part No.	Qty.	Remarks
25	M10 x 90 Hex. Headed Bolt Plated	HBM10090P	12	
26	M8 Hex. Full Nut Plated	HNM08NUTP	6	
27	M8 Nylon Insert Locknut Plated	HNM08NYLP	4	
28	M10 Hex. Full Nut Plated	HNM10NUTP	16	
29	M12 Hex. Full Nut Plated	HNM12NUTP	4	
30	M20 Nylon Insert Locknut Plated	HNM20NYLP	1	
31	M8 x 25 Hex. Headed Screw Plated	HSM08025P	2	
32	M8 x 75 Hex. Headed Screw Plated	HSM08075P	2	
33	M10 x 40 Hex. Headed Screw Plated	HSM10040P	1	
34	'Warning' (Drive Guard Assembly)	Label 3	1	Not Shown
35	3.2 Dia x 9. 1 LG Domed Head Al. Pop Rivet	PR3. 2D9. 1	20	
36	Toggle Clip (Drive Guard Assembly)	TOGL CLIP	2	See Page 1
37	M8 Flat Washer Form B Plated	WAM08FLBP	6	
38	M8 Spring Washer Plated	WAM08SPRP	2	
39	M10 Spring Washer Plated	WAM10SPRP	17	
40	M20 Flat Washer Plated	WAM20FLTP	1	
41	Idler Bearing 1FGH 401	7175X1	1	

PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF60

Drawing No. 714901

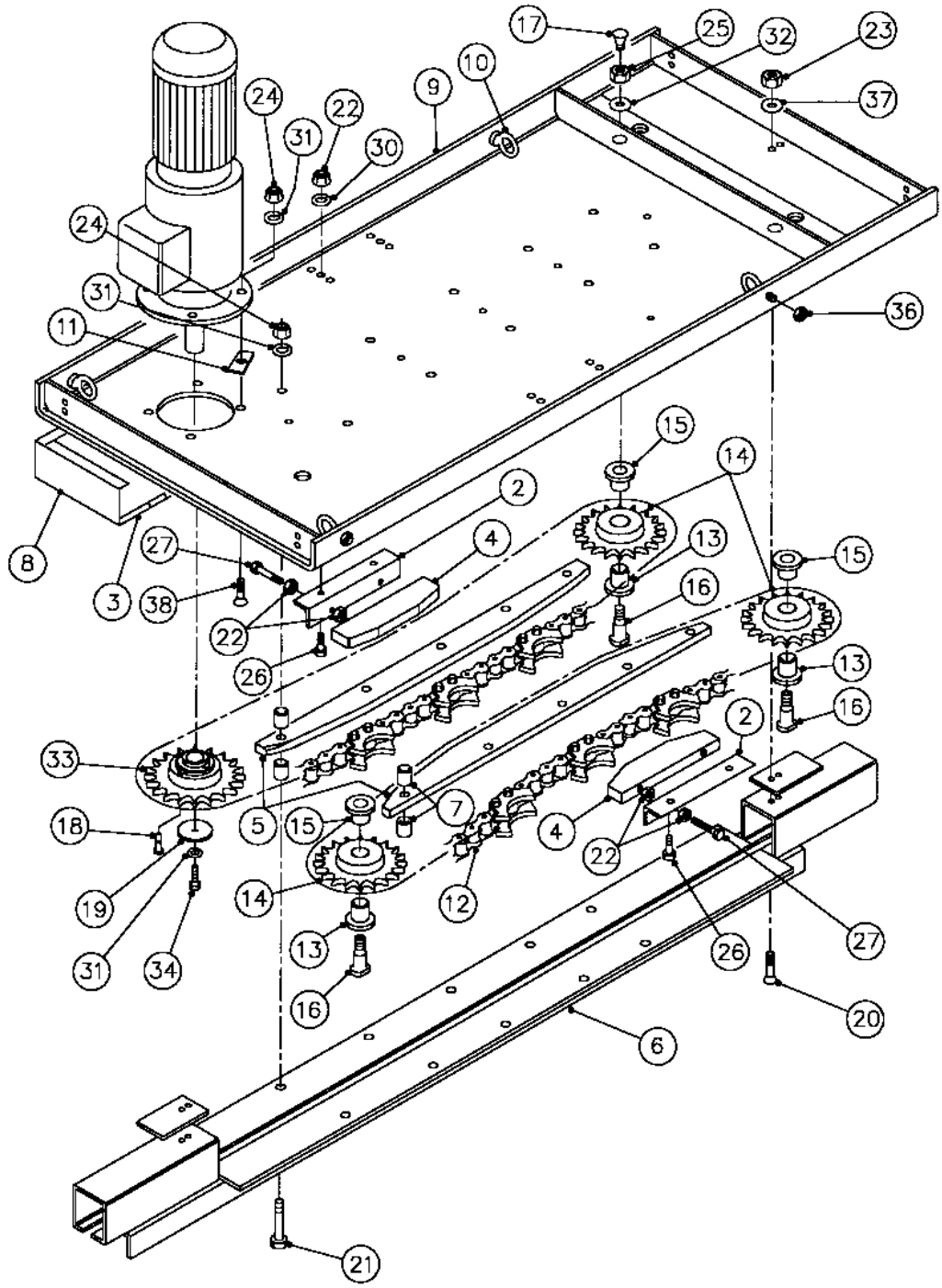


PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF60

Drawing No. 714901



PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF60

Drawing No. 714901

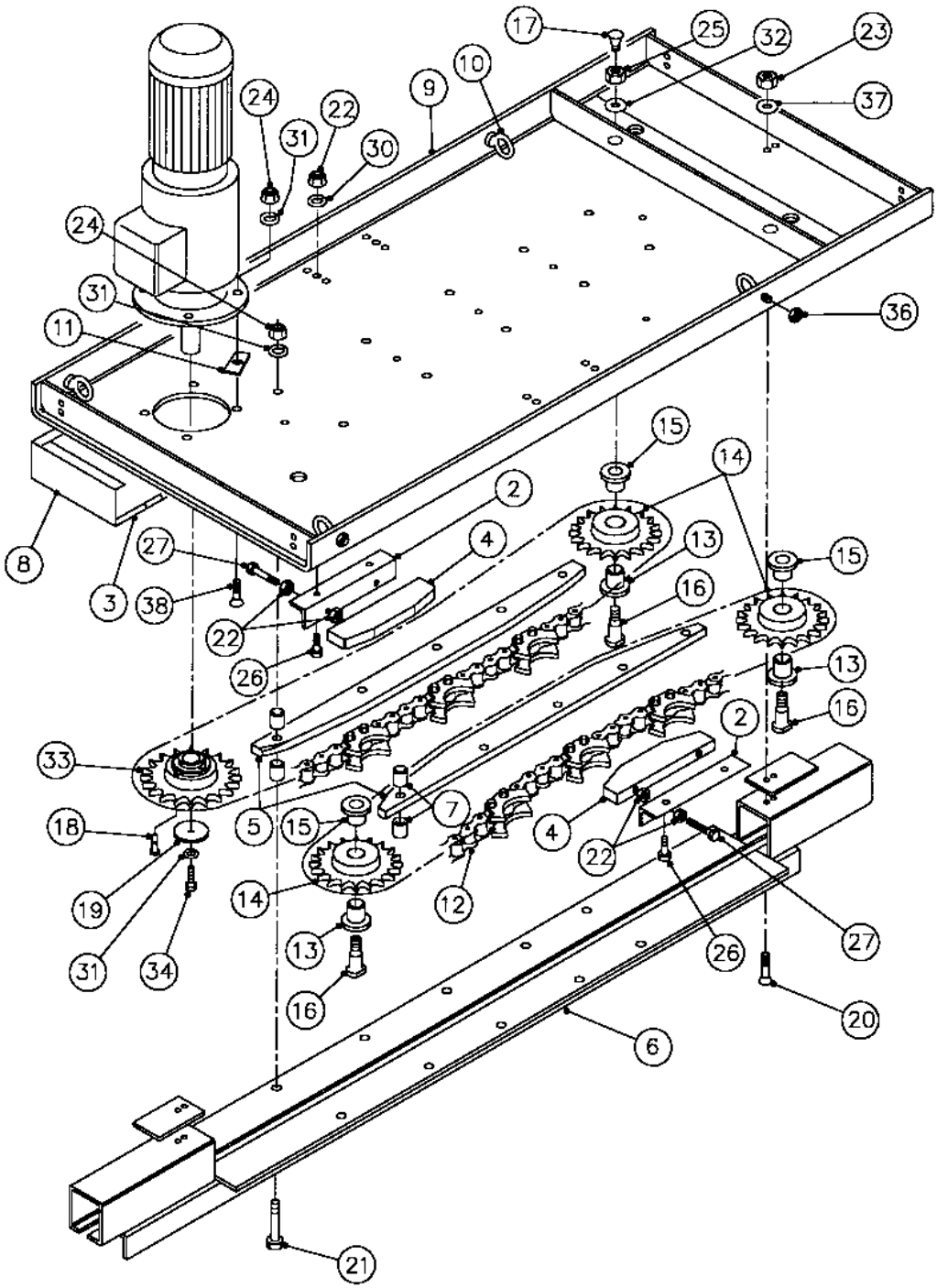
Item No.	Description	Part No.	Qty.	Remarks
1	SG Standard Nameplate (HO No.)	1015X0	1	See Page 1
2	275L Tension Blade Support	713100	2	
3	200L Drive Guard Hinge (Piano)	7136X0	3	
4	275/550 Drive Chain Retaining Blade Nylon	7148X6	2	
5	275L/550M Drive Guide Bar	7148X9	2	
6	550M Centre Track	714905	1	
7	550 Drive Guide Bar Spacer 21.5mm	714906	20	
8	550M Mk. 2 Drive Guard Hinge and N/plate	714910	2	
9	550M Mk. 2 Drive Base Plate	7149X0	1	
10	M12 Dynamo Lifting Eyebolts	7149X2	4	
11	550M Gearbox Packing Block	716000	4	
12	550M Drive Chain 3 inch Pitch	716603	2	
13	Idler Bearing FGH401 Machined	717500	6	
14	Idler Sprocket 1**Error!** inch Bore	7175X0	3	
15	Idler Bearing 1FGH 401	7175X1	3	
16	Idler Sprocket Spindle 20mm	7176X0	3	
17	Idler Sprocket Fl/Flap Lub. BS 1516	7176X1	3	
18	Shearpin **Error!** Groove 550 M	717700	20	One Only Fitted
19	Gearbox Retaining Plate	717900	1	
20	M8 x 25 Slotted C'sk Headed Screw Plated	CSM08025P	4	
21	M10 x 90 Hex. Headed Bolt Plated	HBM10090P	10	
22	M8 Hex. Full Nut Plated	HNM08NUTP	12	
23	M8 Nylon Insert Lock Nut Plated	HNM08NYLP	4	

PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF60

Drawing No. 714901



PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF60 (Continued)

Drawing No. 714901

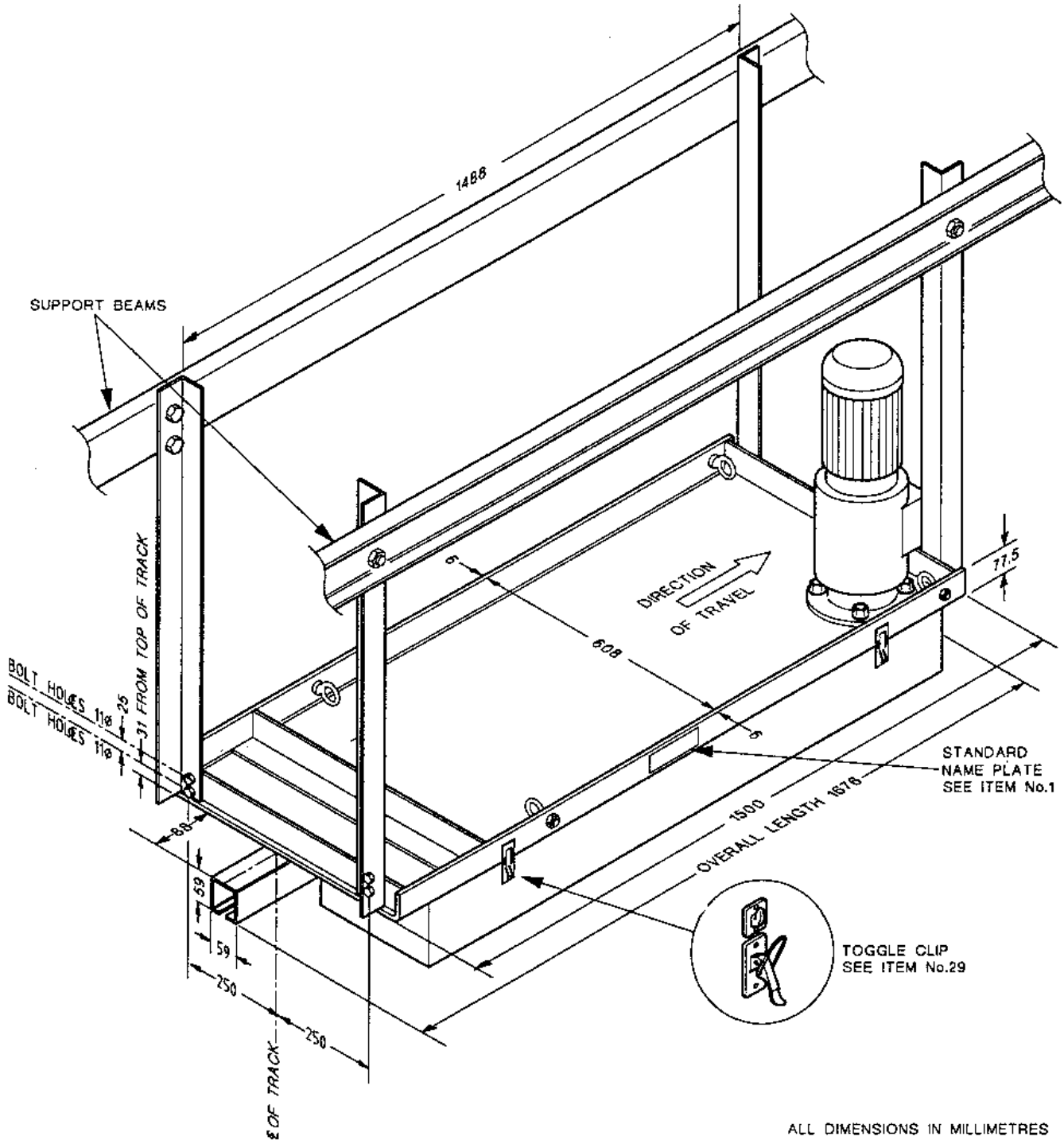
Item No.	Description	Part No.	Qty.	Remarks
24	M10 Hex. Full Nut Plated	HNM10NUTP	14	
25	M20 Nylon Insert Locknut Plated	HNM20NYLP	3	
26	M8 x 25 Hex. Headed Screw Plated	HSM08025P	4	
27	M8 x 75 Hex. Headed Screw Plated	HSM08075P	4	
28	3.2 Dia x 9. 1 LG Domed Head Al. Pop Rivet	PR3. 2D9. 1	36	Not Shown
29	Toggle Clip (Drive Guard Assembly)	TOGL CLIP	4	See Page 1
30	M8 Spring Washer Plated	WAM08SPRP	4	
31	M10 Spring Washer Plated	WAM10SPRP	15	
32	M20 Flat Washer Plated	WAM20FLTP	3	
33	Drive Parts 30mm Bore RF60	717003	1	
34	M10 x 40 Hex. Headed Screw Plated	HSM10040P	1	
35	'Warning' for Drive Guards	LABEL 3	1	Not Shown
36	M12 Hex. Full Nut Plated	HNM12NUTP	4	
37	M8 Flat Washer Plated	WAM08FLTP	4	
38	M10 x 40 Slotted C'sk Screw Plated	CSM10040P	4	

PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF70

Drawing No. 714901

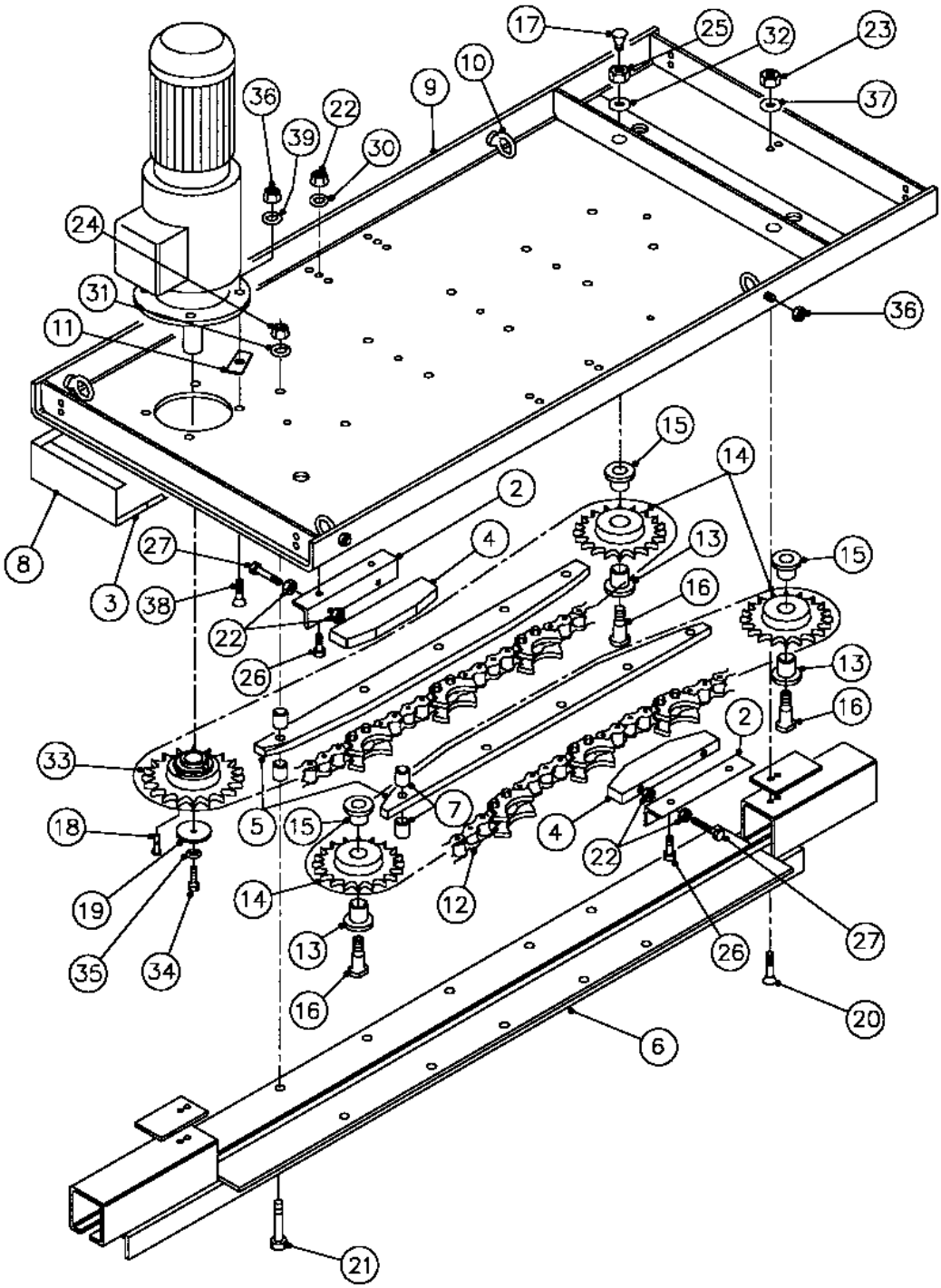


PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF70

Drawing No. 714901



PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF70

Drawing No. 714901

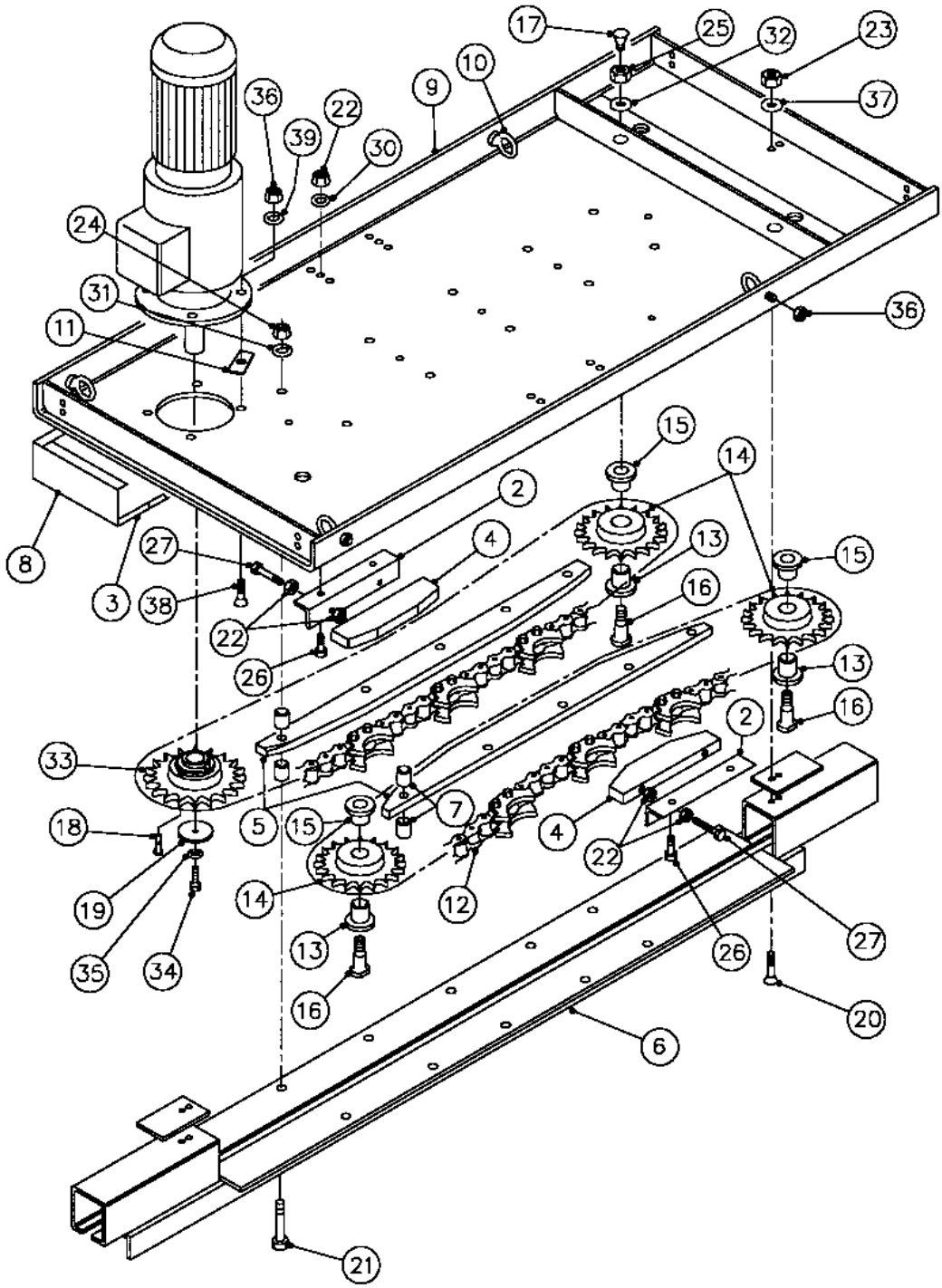
Item No.	Description	Part No.	Qty.	Remarks
1	SG Standard Nameplate (HO No.)	1015X0	1	See Page 1
2	275L Tension Blade Support	713100	2	
3	200L Drive Guard Hinge (Piano)	7136X0	3	
4	275/550 Drive Chain Retaining Blade Nylon	7148X6	2	
5	275L/550M Drive Guide Bar	7148X9	2	
6	550M Centre Track	714905	1	
7	550 Drive Guide Bar Spacer 21.5mm	714906	20	
8	550M Mk. 2 Drive Guard Hinge and N/plate	714910	2	
9	550M Mk. 2 Drive Base Plate	7149X0	1	
10	M12 Dynamo Lifting Eyebolts	7149X2	4	
11	550M Gearbox Packing Block	716000	4	
12	550M Drive Chain 3 inch Pitch	716603	2	
13	Idler Bearing FGH401 Machined	717500	6	
14	Idler Sprocket 1**Error!** inch Bore	7175X0	3	
15	Idler Bearing 1FGH 401	7175X1	3	
16	Idler Sprocket Spindle 20mm	7176X0	3	
17	Idler Sprocket Fl/Flap Lub. BS 1516	7176X1	3	
18	Shearpin **Error!** Groove 550 M	717700	20	One Only Fitted
19	Gearbox Retaining Plate	717900	1	
20	M8 x 25 Slotted C'sk Headed Screw Plated	CSM08025P	4	
21	M10 x 90 Hex. Headed Bolt Plated	HBM10090P	10	
22	M8 Hex. Full Nut Plated	HNM08NUTP	12	
23	M8 Nylon Insert Lock Nut Plated	HNM08NYLP	4	

PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF70

Drawing No. 714901



PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF70 (Continued)

Drawing No. 714901

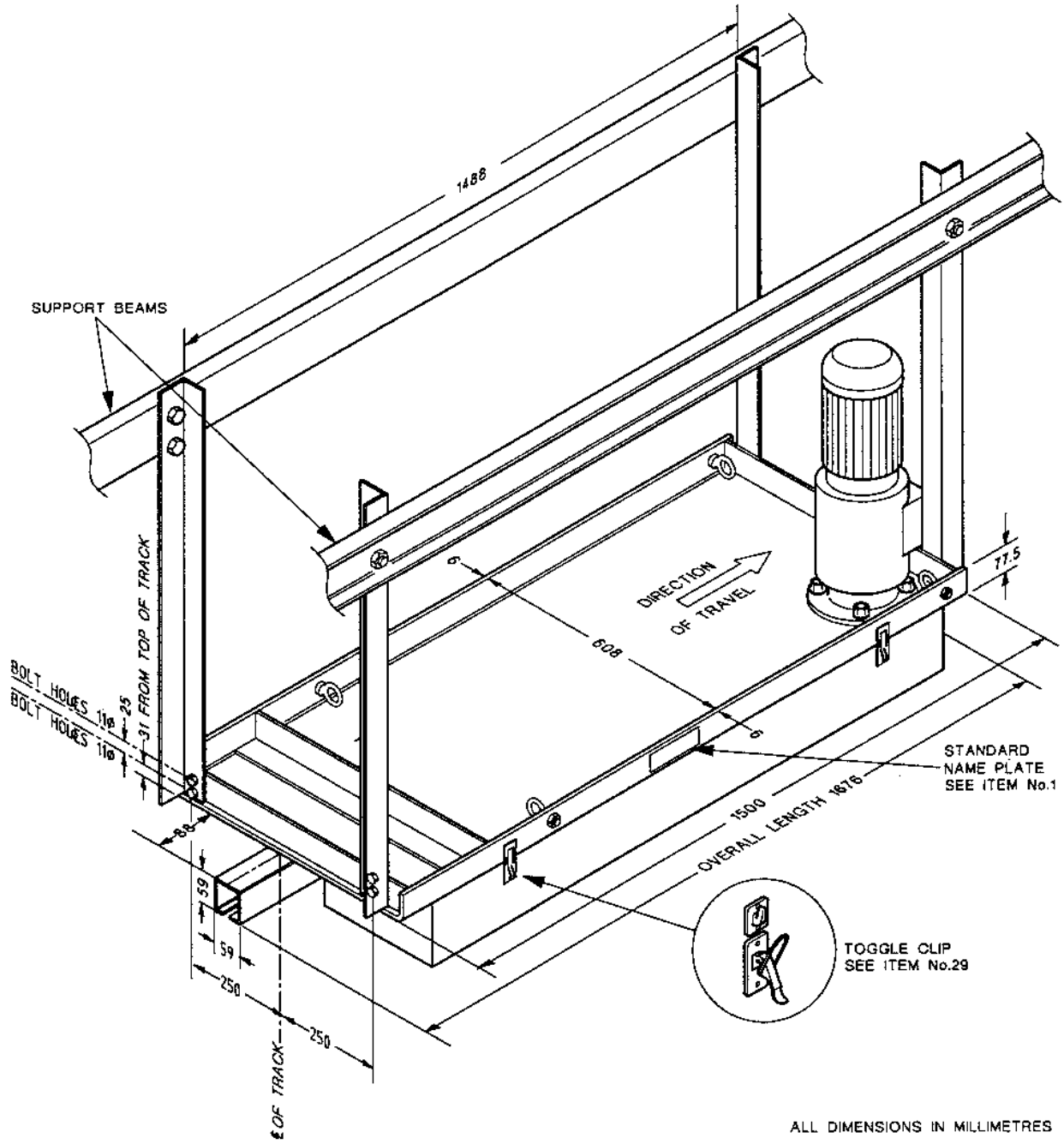
Item No.	Description	Part No.	Qty.	Remarks
24	M10 Hex. Full Nut Plated	HNM10NUTP	10	
25	M20 Nylon Insert Locknut Plated	HNM20NYLP	3	
26	M8 x 25 Hex. Headed Screw Plated	HSM08025P	4	
27	M8 x 75 Hex. Headed Screw Plated	HSM08075P	4	
28	3.2 Dia x 9. 1 LG Domed Head Al. Pop Rivet	PR3. 2D9. 1	36	Not Shown
29	Toggle Clip (Drive Guard Assembly)	TOGL CLIP	4	See Page 1
30	M8 Spring Washer Plated	WAM08SPRP	4	
31	M10 Spring Washer Plated	WAM10SPRP	10	
32	M20 Flat Washer Plated	WAM20FLTP	3	
33	Drive Parts 40mm Bore RF70	717004	1	
34	M16 x 40 Hex. Headed Screw Plated	HSM16040P	1	
35	M16 Spring Washer Plated	WAM16SPRP	1	
36	M12 Hex. Full Nut Plated	HNM12NUTP	8	
37	M8 Flat Washer Plated	WAM08FLTP	4	
38	M12 x 60 Slotted C'sk Screw Plated	CSM12060P	4	
39	M12 Spring Washer Plated	WAM12SPRP	4	
40	'Warning' for Drive Guards	LABEL 3	2	Not Shown

PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF80

Drawing No. 714901

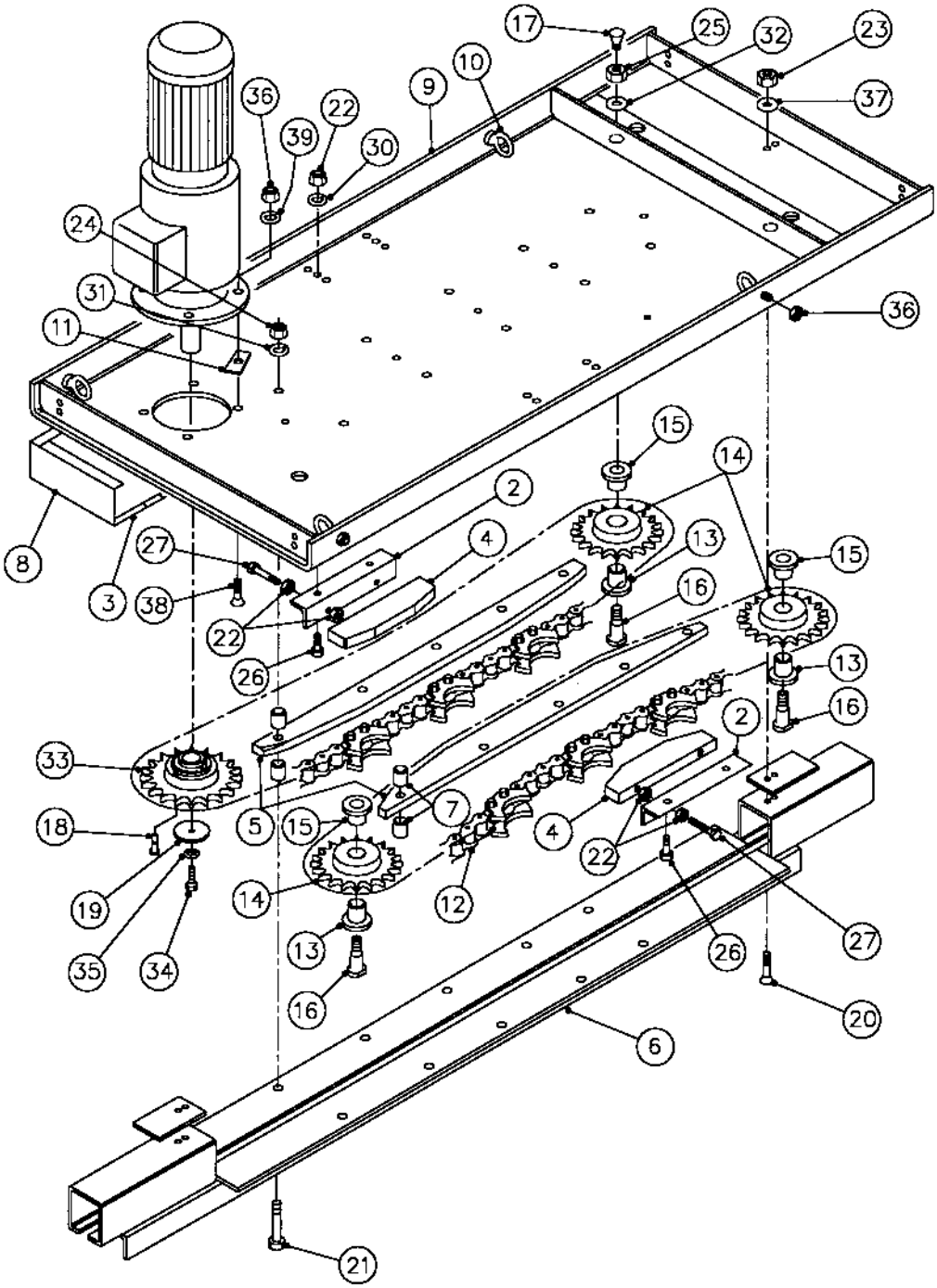


PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF80

Drawing No. 714901



PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF80

Drawing No. 714901

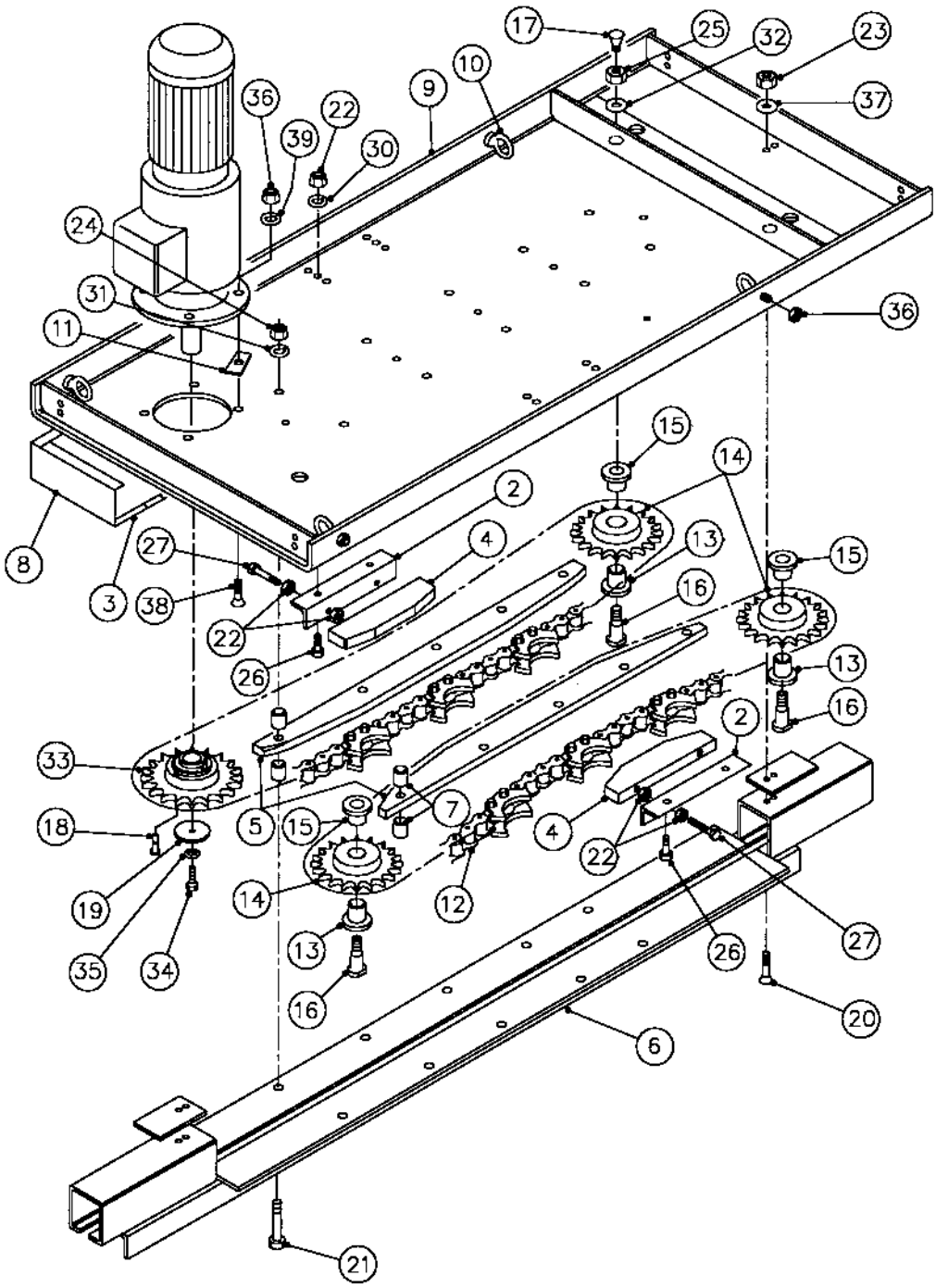
Item No.	Description	Part No.	Qty.	Remarks
1	SG Standard Nameplate (HO No.)	1015X0	1	See Page 1
2	275L Tension Blade Support	713100	2	
3	200L Drive Guard Hinge (Piano)	7136X0	3	
4	275/550 Drive Chain Retaining Blade Nylon	7148X6	2	
5	275L/550M Drive Guide Bar	7148X9	2	
6	550M Centre Track	714905	1	
7	550 Drive Guide Bar Spacer 21.5mm	714906	20	
8	550M Mk. 2 Drive Guard Hinge and N/plate	714910	2	
9	550M Mk. 2 Drive Base Plate	7149X0	1	
10	M12 Dynamo Lifting Eyebolts	7149X2	4	
11	550M Gearbox Packing Block	716000	4	
12	550M Drive Chain 3 inch Pitch	716603	2	
13	Idler Bearing FGH401 Machined	717500	6	
14	Idler Sprocket 1**Error!** inch Bore	7175X0	3	
15	Idler Bearing 1FGH 401	7175X1	3	
16	Idler Sprocket Spindle 20mm	7176X0	3	
17	Idler Sprocket Fl/Flap Lub. BS 1516	7176X1	3	
18	Shearpin **Error!** Groove 550 M	717700	20	One Only Fitted
19	Gearbox Retaining Plate	717900	1	
20	M8 x 25 Slotted C'sk Headed Screw Plated	CSM08025P	4	
21	M10 x 90 Hex. Headed Bolt Plated	HBM10090P	10	
22	M8 Hex. Full Nut Plated	HNM08NUTP	12	
23	M8 Nylon Insert Lock Nut Plated	HNM08NYLP	4	

PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF80

Drawing No. 714901



PARTS LIST

System: 550M Mk. 2

Component: 3 inch Drive Basic In-line for RF80 (Continued)

Drawing No. 714901

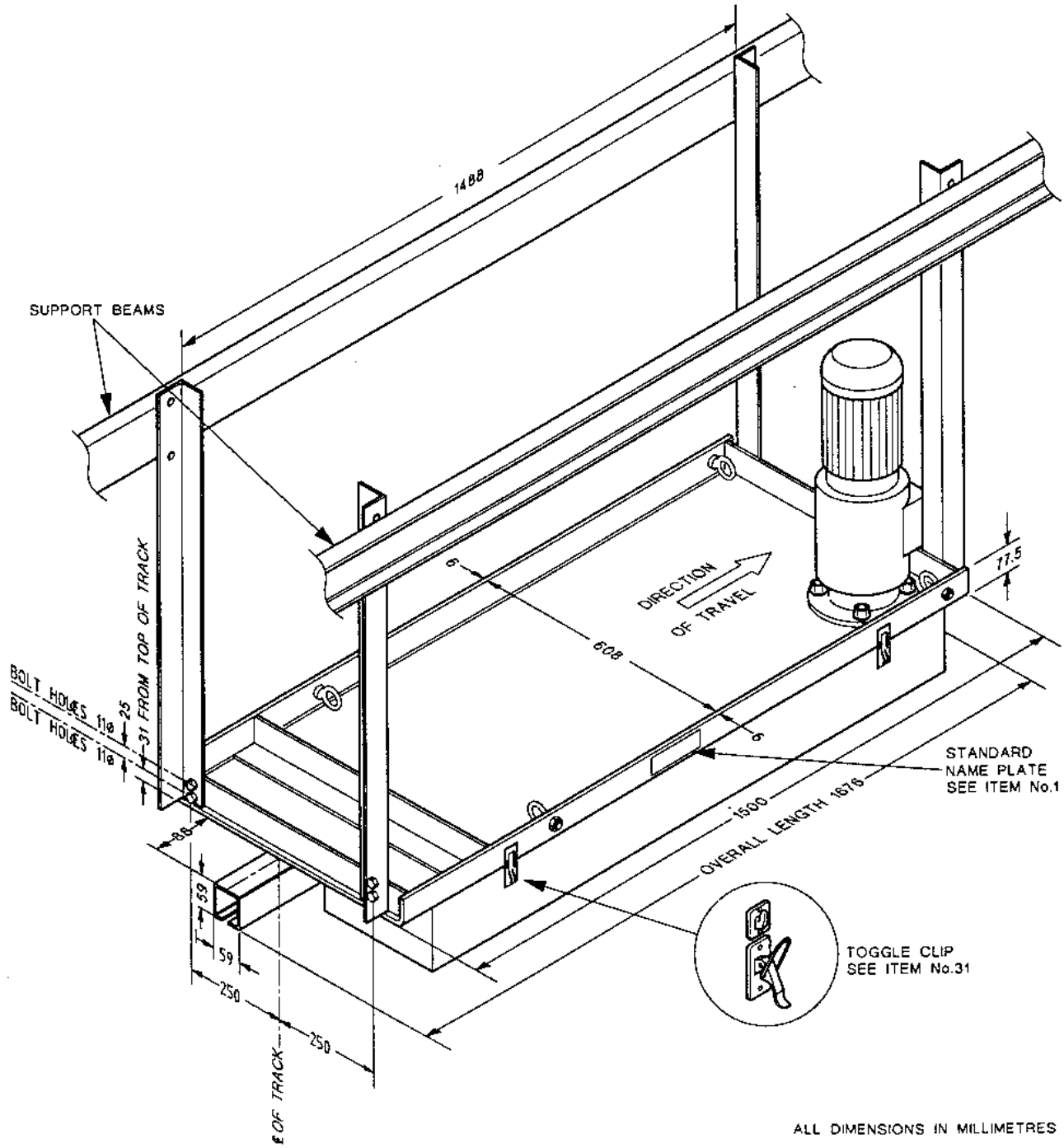
Item No.	Description	Part No.	Qty.	Remarks
24	M10 Hex. Full Nut Plated	HNM10NUTP	10	
25	M20 Nylon Insert Locknut Plated	HNM20NYLP	3	
26	M8 x 25 Hex. Headed Screw Plated	HSM08025P	4	
27	M8 x 75 Hex. Headed Screw Plated	HSM08075P	4	
28	3.2 Dia x 9. 1 LG Domed Head Al. Pop Rivet	PR3. 2D9. 1	36	Not Shown
29	Toggle Clip (Drive Guard Assembly)	TOGL CLIP	4	See Page 1
30	M8 Spring Washer Plated	WAM08SPRP	4	
31	M10 Spring Washer Plated	WAM10SPRP	10	
32	M20 Flat Washer Plated	WAM20FLTP	3	
33	Drive Parts 50mm Bore RF80	717005	1	
34	M16 x 40 Hex. Headed Screw Plated	HSM16040P	1	
35	M16 Spring Washer Plated	WAM16SPRP	1	
36	M12 Hex. Full Nut Plated	HNM12NUTP	8	
37	M8 Flat Washer Plated	WAM08FLTP	4	
38	M12 x 65 Slotted C'sk Screw Plated	CSM12065P	4	
39	M12 Spring Washer Plated	WAM12SPRP	4	
40	'Warning' for Drive Guards	LABEL 3	2	Not Shown

PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF60

Drawing No. 714902

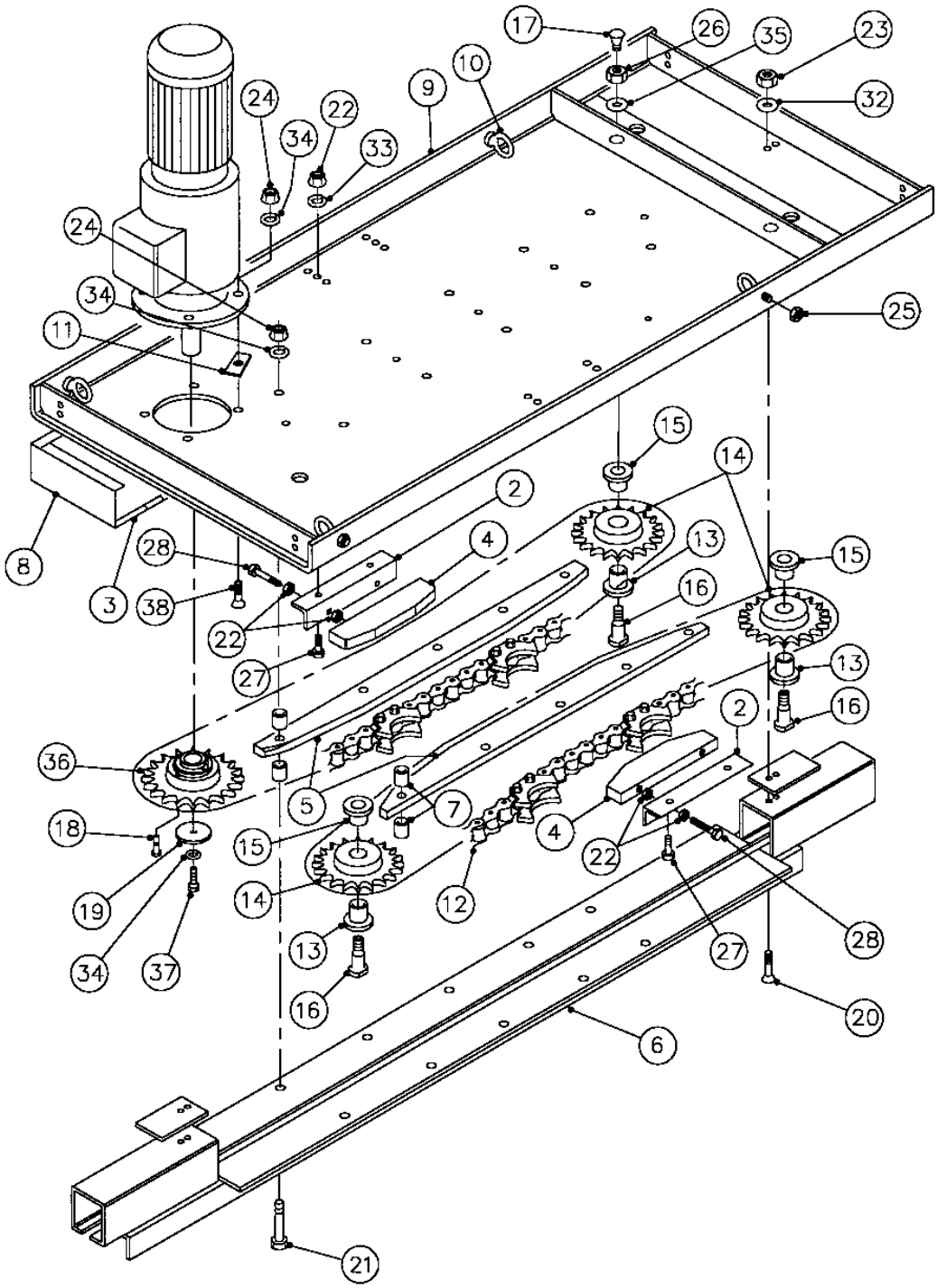


PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF60

Drawing No. 714902



PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF60

Drawing No. 714902

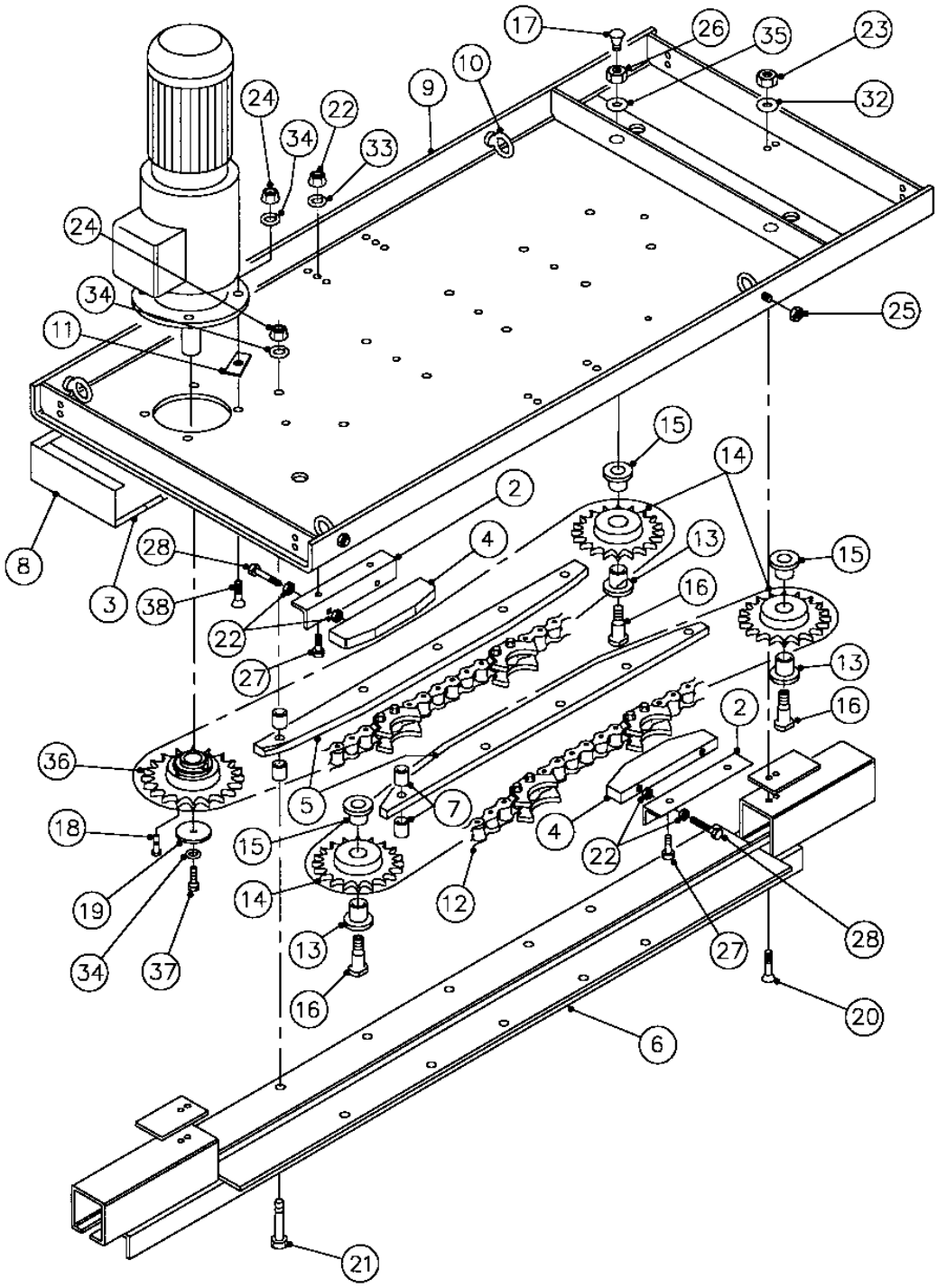
Item No.	Description	Part No.	Qty.	Remarks
1	SG Standard Nameplate (HO No.)	1015X0	1	See Page 1
2	275L Tension Blade Support	713100	2	
3	200L Drive Guard Hinge (Piano)	7136X0	3	
4	275/550 Drive Chain Retaining Blade Nylon	7148X6	2	
5	275L/550M Drive Guide Bar	7148X9	2	
6	550M Centre Track	714905	1	
7	550 Drive Guide Bar Spacer 21.5mm	714906	20	
8	550M Mk. 2 Drive Guard Hinge and N/plate	714910	2	
9	550M Mk. 2 Drive Base Plate	7149X0	1	
10	M12 Dynamo Lifting Eyebolts	7149X2	4	
11	550M Gearbox Packing Block	716000	4	
12	550M Drive Chain 4 inch Pitch	716604	2	
13	Idler Bearing FGH401 Machined	717500	6	
14	Idler Sprocket 1 inch Bore	7175X0	3	
15	Idler Bearing 1FGH 401	7175X1	3	
16	Idler Sprocket Spindle 20mm	7176X0	3	
17	Idler Sprocket Fl/Flap Lub. BS 1516	7176X1	3	
18	Shearpin Groove 550 M	717700	20	One Only Fitted
19	Gearbox Retaining Plate	717900	1	
20	M8 x 25 Slotted C'sk Headed Screw Plated	CSM08025P	4	
21	M10 x 90 Hex. Headed Bolt Plated	HBM10090P	10	
22	M8 Hex. Full Nut Plated	HNM08NUTP	12	
23	M8 Nylon Insert Lock Nut Plated	HNM08NYLP	4	

PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF60

Drawing No. 714902



PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF60 (Continued)

Drawing No. 714902

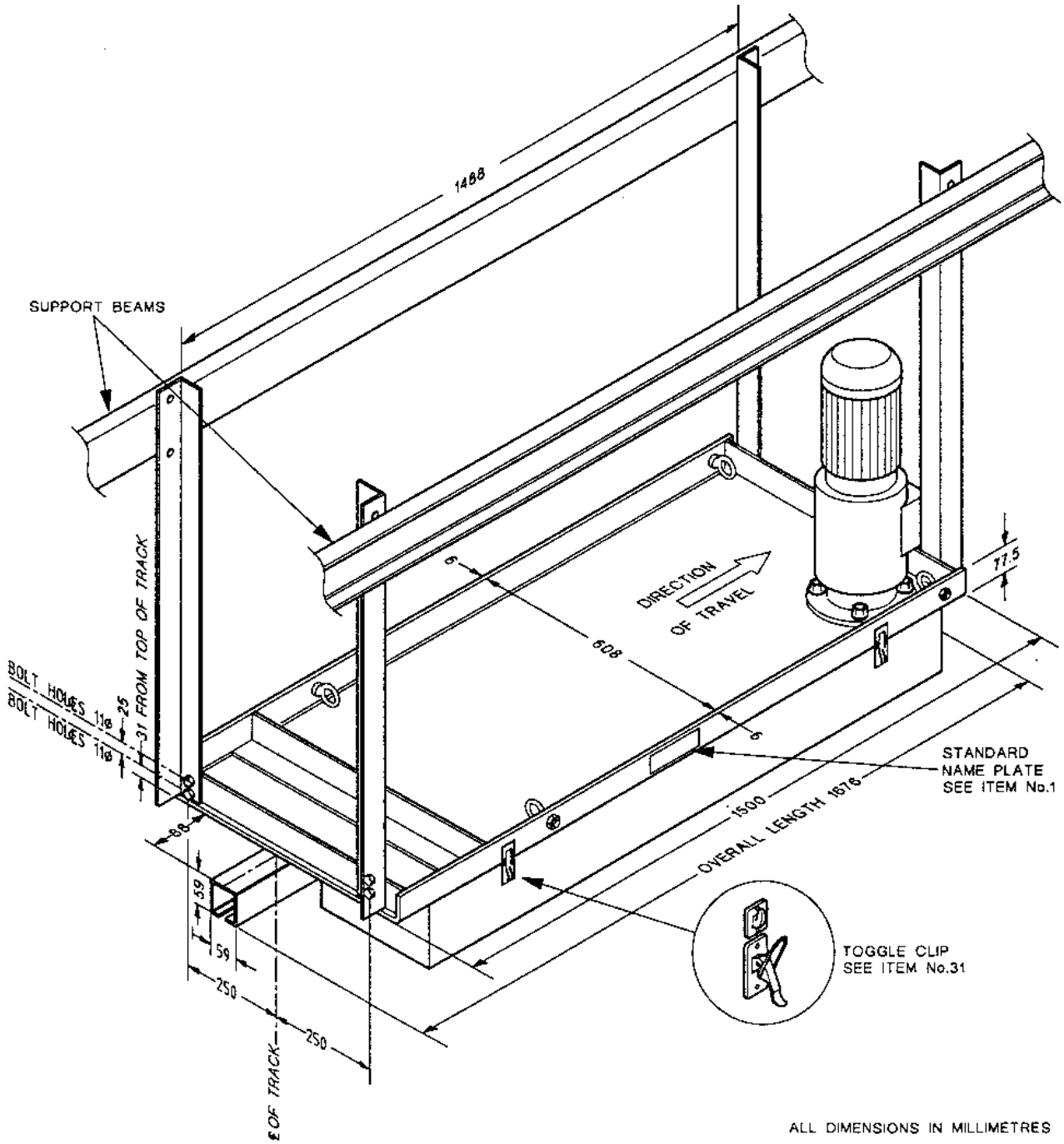
Item No.	Description	Part No.	Qty.	Remarks
24	M10 Hex. Full Nut Plated	HNM10NUTP	15	
25	M12 Hex. Full Nut Plated	HNM12NUTP	4	
26	M20 Nylon Insert Locknut Plated	HNM20NYLP	3	
27	M8 x 25 Hex. Headed Screw Plated	HSM08025P	4	
28	M8 x 75 Hex. Headed Screw Plated	HSM08075P	4	
29	'Warning' for Drive Guards	LABEL 3	2	Not Shown
30	3.2 Dia x 9. 1 LG Domed Head Al. Pop Rivet	PR3. 2D9. 1	40	Not Shown
31	Toggle Clip	TOGL CLIP	4	See Page 1
32	M8 Flat Washer Form B Plated	WAM08FLBP	4	
33	M8 Spring Washer Plated	WAM08SPRP	4	
34	M10 Spring Washer Plated	WAM10SPRP	15	
35	M20 Flat Washer Plated	WAM20FLTP	3	
36	Drive Parts 30mm Bore RF60	717003	1	
37	M10 x 40 Hex. Headed Screw Plated	HSM10040P	1	
38	M10 x 40 Slotted C'sk Screw Plated	CSM10040P	4	

PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF70

Drawing No. 714902

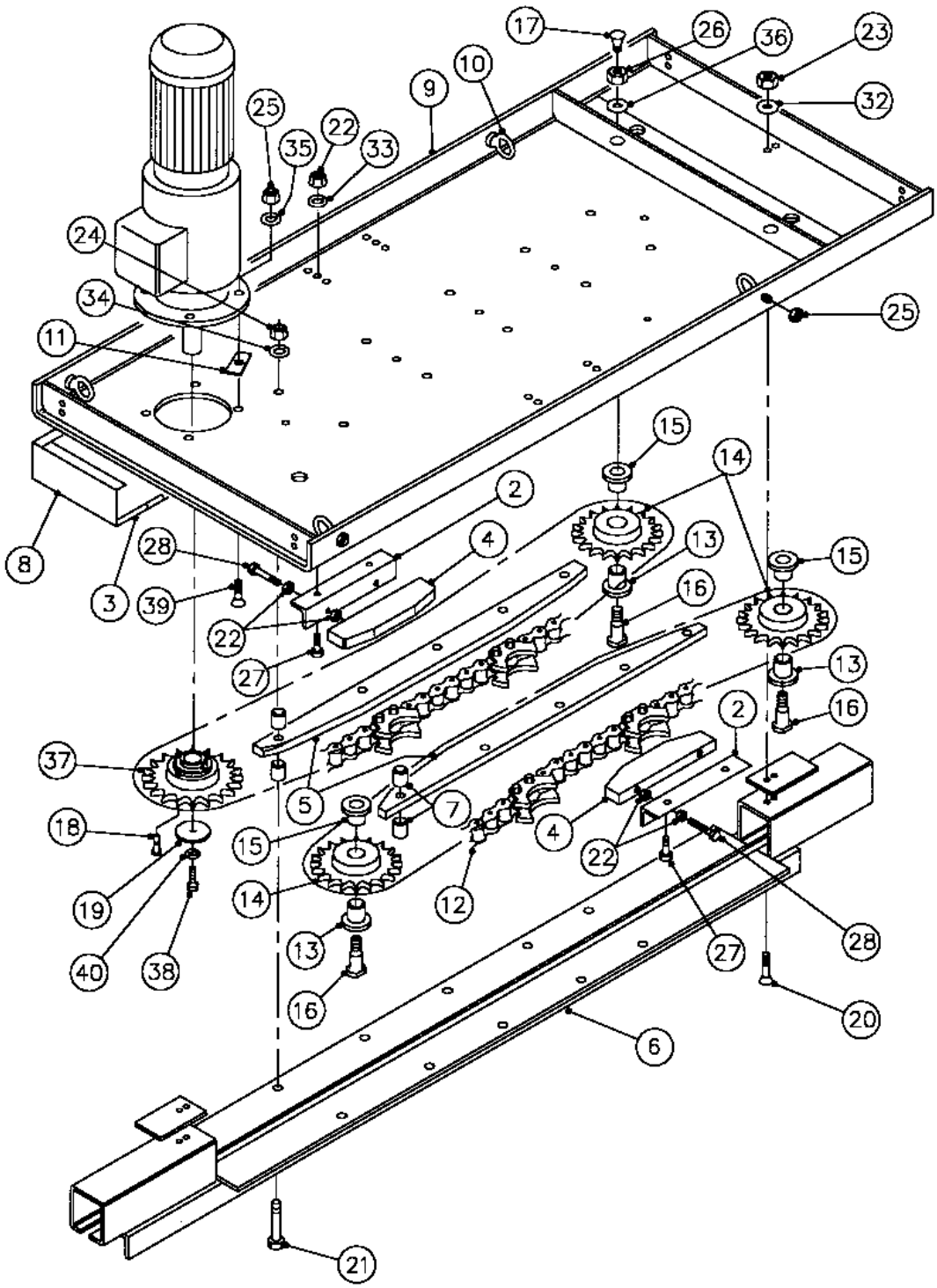


PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF70

Drawing No. 714902



PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF70

Drawing No. 714902

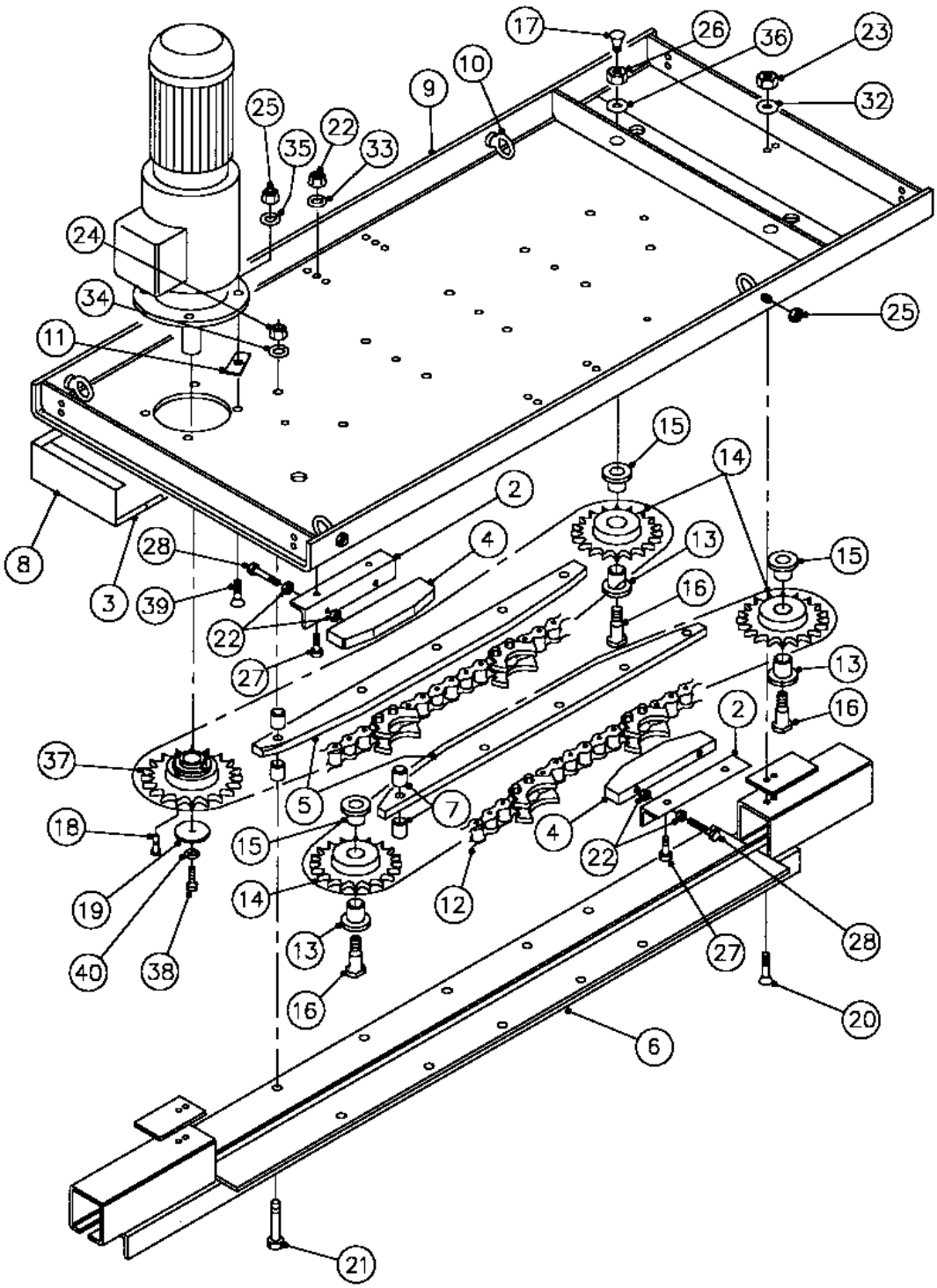
Item No.	Description	Part No.	Qty.	Remarks
1	SG Standard Nameplate (HO No.)	1015X0	1	See Page 1
2	275L Tension Blade Support	713100	2	
3	200L Drive Guard Hinge (Piano)	7136X0	3	
4	275/550 Drive Chain Retaining Blade Nylon	7148X6	2	
5	275L/550M Drive Guide Bar	7148X9	2	
6	550M Centre Track	714905	1	
7	550 Drive Guide Bar Spacer 21.5mm	714906	20	
8	550M Mk. 2 Drive Guard Hinge and N/plate	714910	2	
9	550M Mk. 2 Drive Base Plate	7149X0	1	
10	M12 Dynamo Lifting Eyebolts	7149X2	4	
11	550M Gearbox Packing Block	716000	4	
12	550M Drive Chain 4 inch Pitch	716604	2	
13	Idler Bearing FGH401 Machined	717500	6	
14	Idler Sprocket 1 inch Bore	7175X0	3	
15	Idler Bearing 1FGH 401	7175X1	3	
16	Idler Sprocket Spindle 20mm	7176X0	3	
17	Idler Sprocket Fl/Flap Lub. BS 1516	7176X1	3	
18	Shearpin **Error!** Groove 550 M	717700	20	One Only Fitted
19	Gearbox Retaining Plate	717900	1	
20	M8 x 25 Slotted C'sk Headed Screw Plated	CSM08025P	4	
21	M10 x 90 Hex. Headed Bolt Plated	HBM10090P	10	
22	M8 Hex. Full Nut Plated	HNM08NUTP	12	
23	M8 Nylon Insert Lock Nut Plated	HNM08NYLP	4	

PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF70

Drawing No. 714902



PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF70 (Continued)

Drawing No. 714902

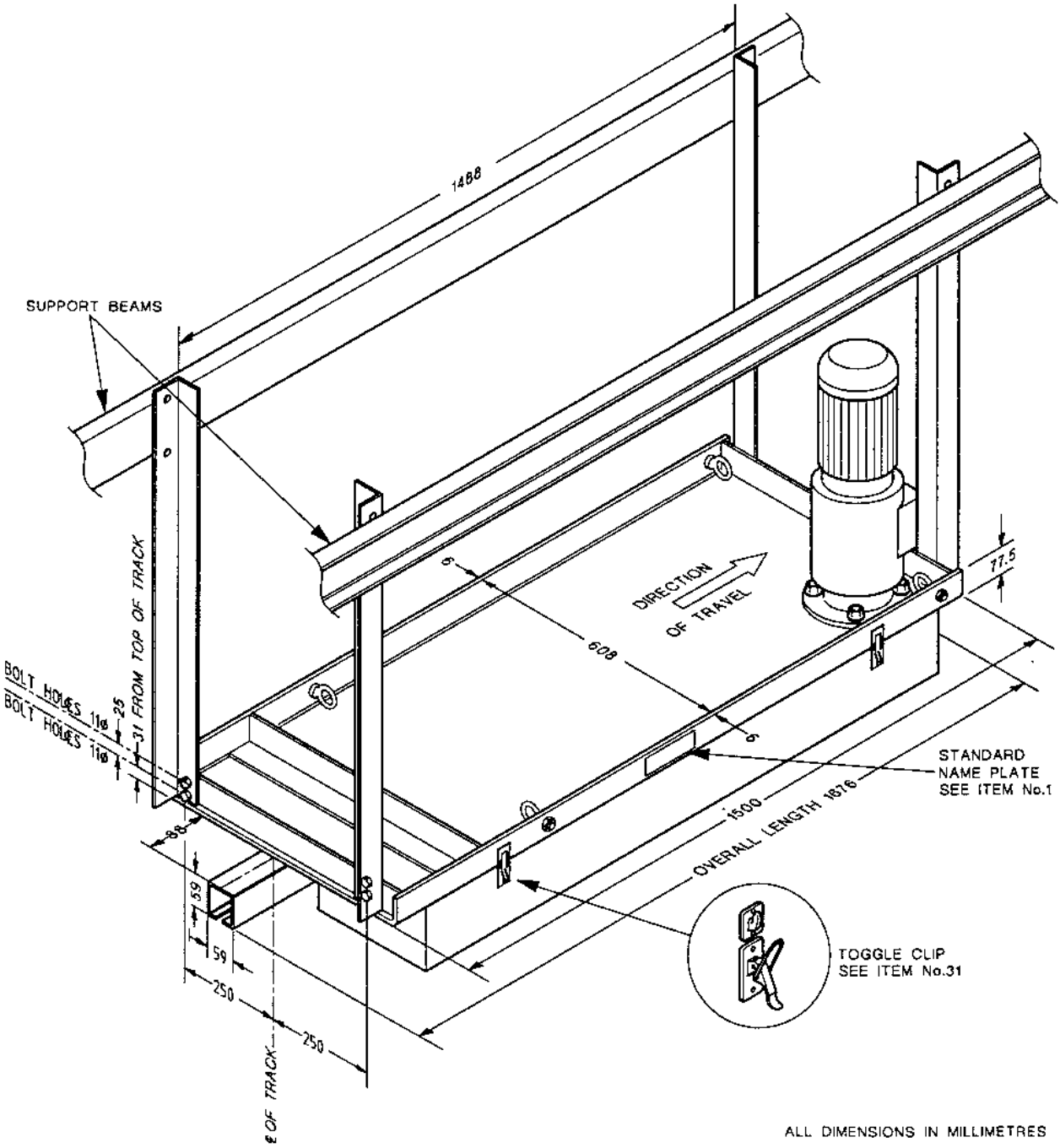
Item No.	Description	Part No.	Qty.	Remarks
24	M10 Hex. Full Nut Plated	HNM10NUTP	10	
25	M12 Hex. Full Nut Plated	HNM12NUTP	8	
26	M20 Nylon Insert Locknut Plated	HNM20NYLP	3	
27	M8 x 25 Hex. Headed Screw Plated	HSM08025P	4	
28	M8 x 75 Hex. Headed Screw Plated	HSM08075P	4	
29	'Warning' for Drive Guards	LABEL 3	2	Not Shown
30	3.2 Dia x 9. 1 LG Domed Head Al. Pop Rivet	PR3. 2D9. 1	36	Not Shown
31	Toggle Clip	TOGL CLIP	4	See Page 1
32	M8 Flat Washer Form B Plated	WAM08FLBP	4	
33	M8 Spring Washer Plated	WAM08SPRP	4	
34	M10 Spring Washer Plated	WAM10SPRP	10	
35	M12 Spring Washer Plated	WAM12SPRP	4	
36	M20 Flat Washer Plated	WAM20FLTP	3	
37	Drive Parts 40mm Bore RF70	717004	1	
38	M16 x 40 Hex. Headed Screw Plated	HSM16040P	1	
39	M12 x 60 Slotted C'sk Screw Plated	CSM12060P	4	
40	M16 Spring Washer Plated	WAM16SPRP	1	

PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF80

Drawing No. 714902

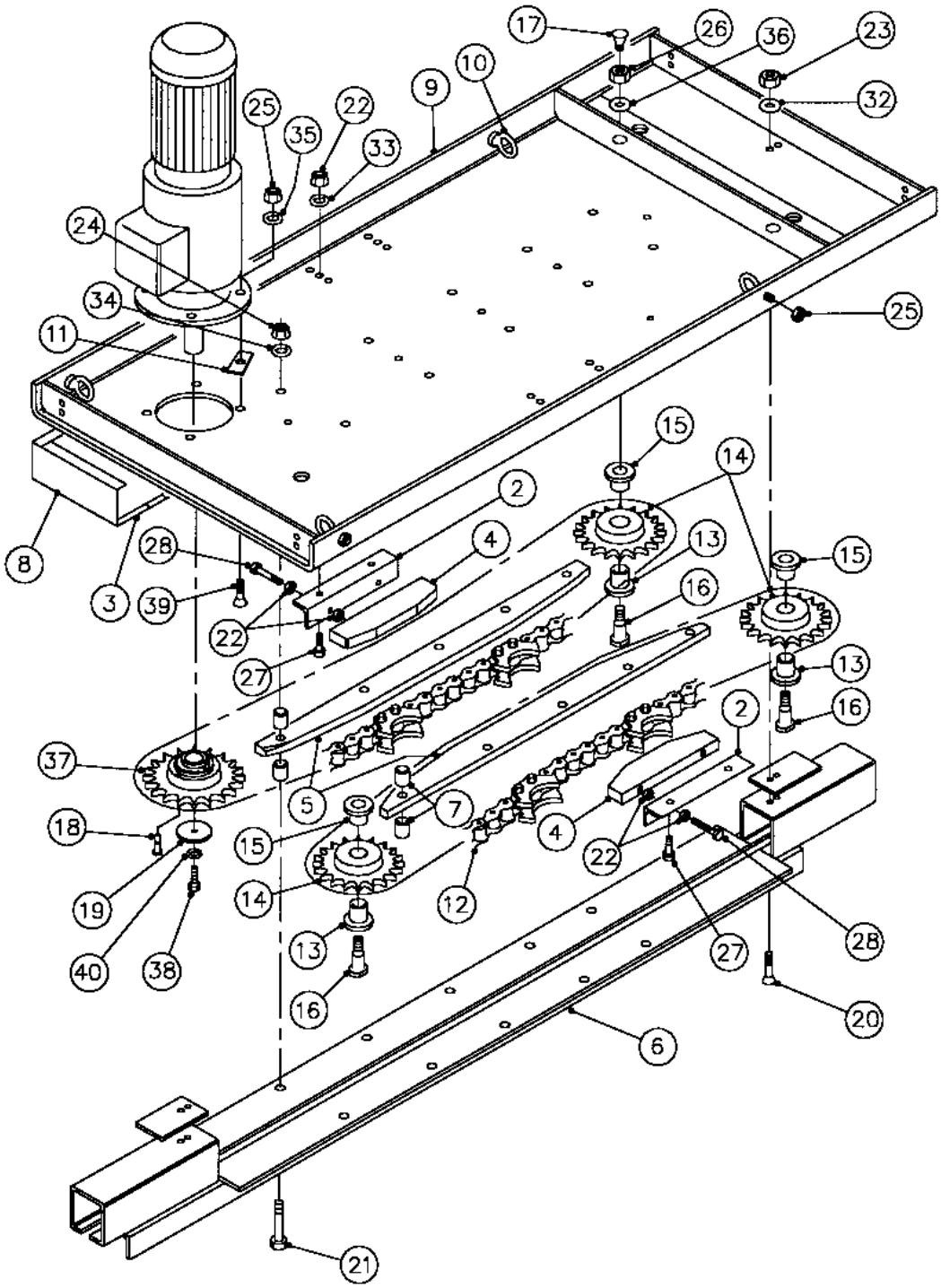


PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF80

Drawing No. 714902



PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF80

Drawing No. 714902

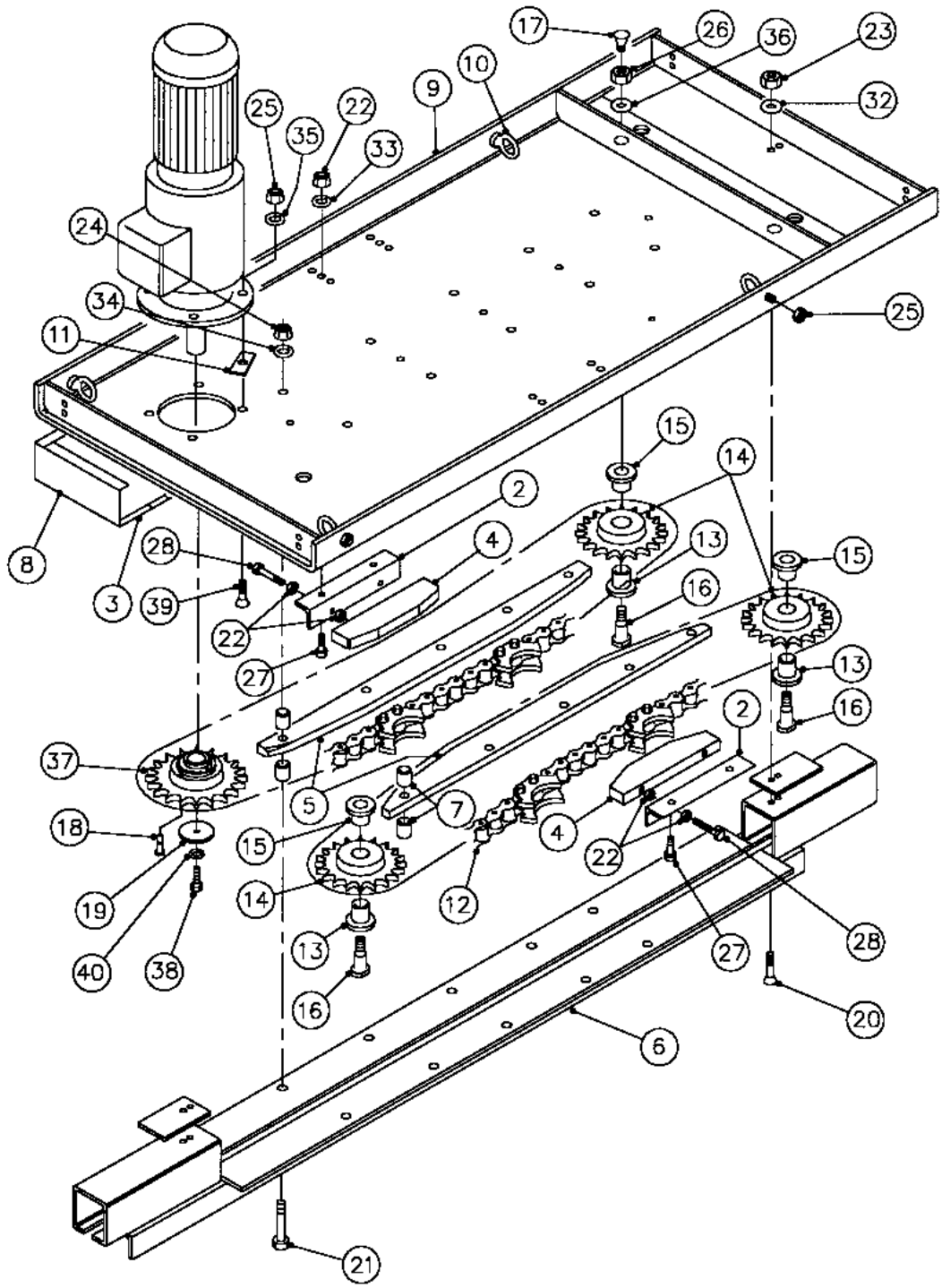
Item No.	Description	Part No.	Qty.	Remarks
1	SG Standard Nameplate (HO No.)	1015X0	1	See Page 1
2	275L Tension Blade Support	713100	2	
3	200L Drive Guard Hinge (Piano)	7136X0	3	
4	275/550 Drive Chain Retaining Blade Nylon	7148X6	2	
5	275L/550M Drive Guide Bar	7148X9	2	
6	550M Centre Track	714905	1	
7	550 Drive Guide Bar Spacer 21.5mm	714906	20	
8	550M Mk. 2 Drive Guard Hinge and N/plate	714910	2	
9	550M Mk. 2 Drive Base Plate	7149X0	1	
10	M12 Dynamo Lifting Eyebolts	7149X2	4	
11	550M Gearbox Packing Block	716000	4	
12	550M Drive Chain 4 inch Pitch	716604	2	
13	Idler Bearing FGH401 Machined	717500	6	
14	Idler Sprocket 1 inch Bore	7175X0	3	
15	Idler Bearing 1FGH 401	7175X1	3	
16	Idler Sprocket Spindle 20mm	7176X0	3	
17	Idler Sprocket Fl/Flap Lub. BS 1516	7176X1	3	
18	Shearpin Groove 550 M	717700	20	One Only Fitted
19	Gearbox Retaining Plate	717900	1	
20	M8 x 25 Slotted C'sk Headed Screw Plated	CSM08025P	4	
21	M10 x 90 Hex. Headed Bolt Plated	HBM10090P	10	
22	M8 Hex. Full Nut Plated	HNM08NUTP	12	
23	M8 Nylon Insert Lock Nut Plated	HNM08NYLP	4	

PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF80

Drawing No. 714902



PARTS LIST

System: 550M Mk. 2

Component: 4 inch Drive Basic In-line for RF80 (Continued)

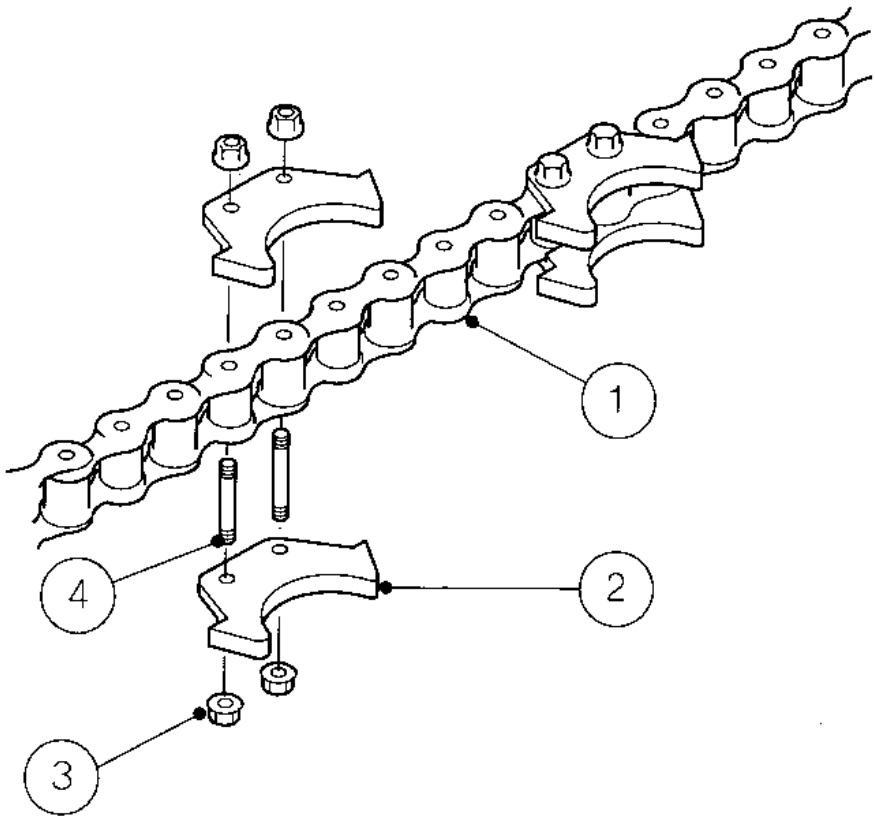
Drawing No. 714902

Item No.	Description	Part No.	Qty.	Remarks
24	M10 Hex. Full Nut Plated	HNM10NUTP	10	
25	M12 Hex. Full Nut Plated	HNM12NUTP	8	
26	M20 Nylon Insert Locknut Plated	HNM20NYLP	3	
27	M8 x 25 Hex. Headed Screw Plated	HSM08025P	4	
28	M8 x 75 Hex. Headed Screw Plated	HSM08075P	4	
29	'Warning' for Drive Guards	LABEL 3	2	Not Shown
30	3.2 Dia x 9. 1 LG Domed Head Al. Pop Rivet	PR3. 2D9. 1	40	Not Shown
31	Toggle Clip	TOGL CLIP	4	See Page 1
32	M8 Flat Washer Form B Plated	WAM08FLBP	4	
33	M8 Spring Washer Plated	WAM08SPRP	4	
34	M10 Spring Washer Plated	WAM10SPRP	10	
35	M12 Spring Washer Plated	WAM12SPRP	4	
36	M20 Flat Washer Plated	WAM20FLTP	3	
37	Drive Parts 50mm Bore RF80	717005	1	
38	M16 x 40 Hex. Headed Screw Plated	HSM16040P	1	
39	M12 x 65 Slotted C'sk Screw Plated	CSM12065P	4	
40	M16 Spring Washer Plated	WAM16SPRP	1	

System: 275L/550M

Component: 3 inch Pitch Drive Chain

Drawing No. 716603



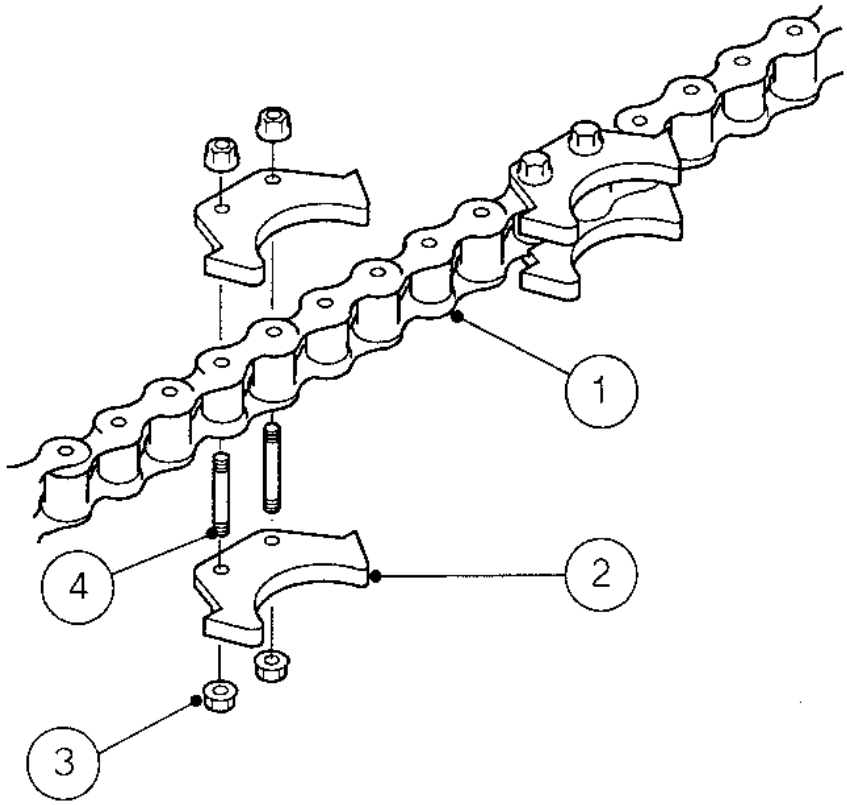
Item No.	Description	Part No.	Qty.	Remarks
1	Chain 1 inch Pitch x 5 Link Lengths 3 inch Pitch	7168X5	2	1 only for 275L
2	Pocket Casting Drilled and Plated	716700	36	
3	M6 Thin Self-lock Nut	HX1M06PHTP	72	
4	Drive Chain Link Pin	716900	36	

PARTS LIST

System: 275L/550M

Component: 4 inch Pitch Drive Chain

Drawing No. 716604



Item No.	Description	Part No.	Qty.	Remarks
1	Chain 1 inch Pitch x 7 Link Lengths 4 inch Pitch	7168X7	2	1 only for 275L
2	Pocket Casting Drilled and Plated	716700	28	
3	M6 Thin Self-lock Nut	HX1M06PHTP	56	
4	Drive Chain Link Pin	716900	28	

PARTS LIST

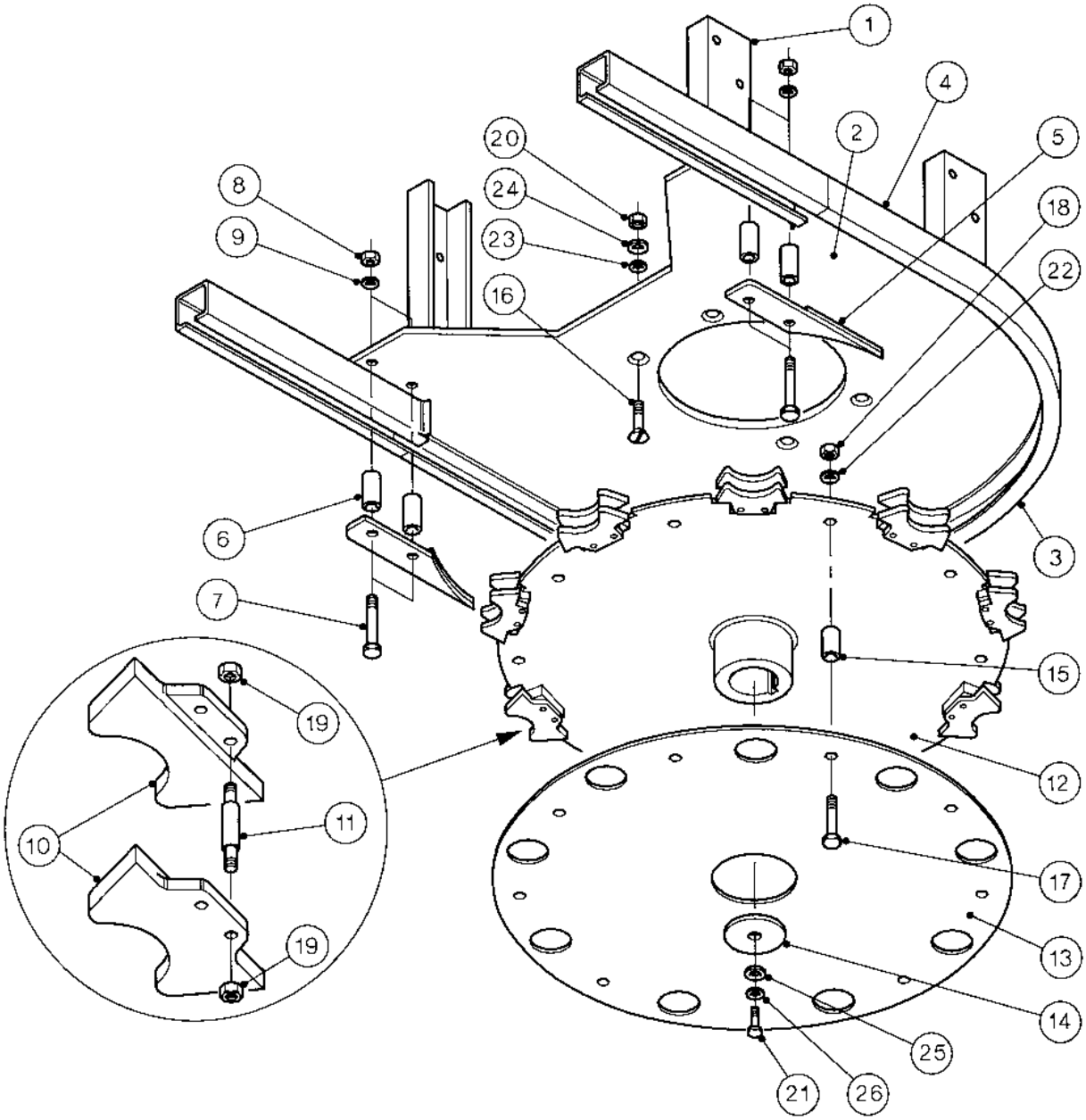
System: 550M

Component: Sprocket Drive Housing RF70 180 Degrees

Drawing No. 717813

Component: Drive Wheel 4 inch Pitch RF70 570 CTRS

Drawing No. 717804



PARTS LIST

System: 550M

Component: Sprocket Drive Housing RF70 180 Degrees

Drawing No. 717813

Item No.	Description	Part No.	Qty.	Remarks
1	Channel 76 x 38mm MS Black	0207X0		
2	Top Plate Fr 582mm CRS Drv & Ten	717840	1	
3	550M Channel for 610mm Horizontal Bend	7399X2	1	
4	550M Track Untreated 6M	7504X0		
5	Stiffener Plate	810101	2	
6	Spacer Tube	810241	4	
7	M10 x 100 Hex. Headed Bolt Plated	HBM10100P	4	
8	M10 Hex. Full Nut Plated	HNM10NUTP	4	
9	M10 Flat Washer Plated	WAM10FLTP	4	

Component: Drive Wheel 4 inch Pitch RF70 570 CTRS

Drawing No. 717804

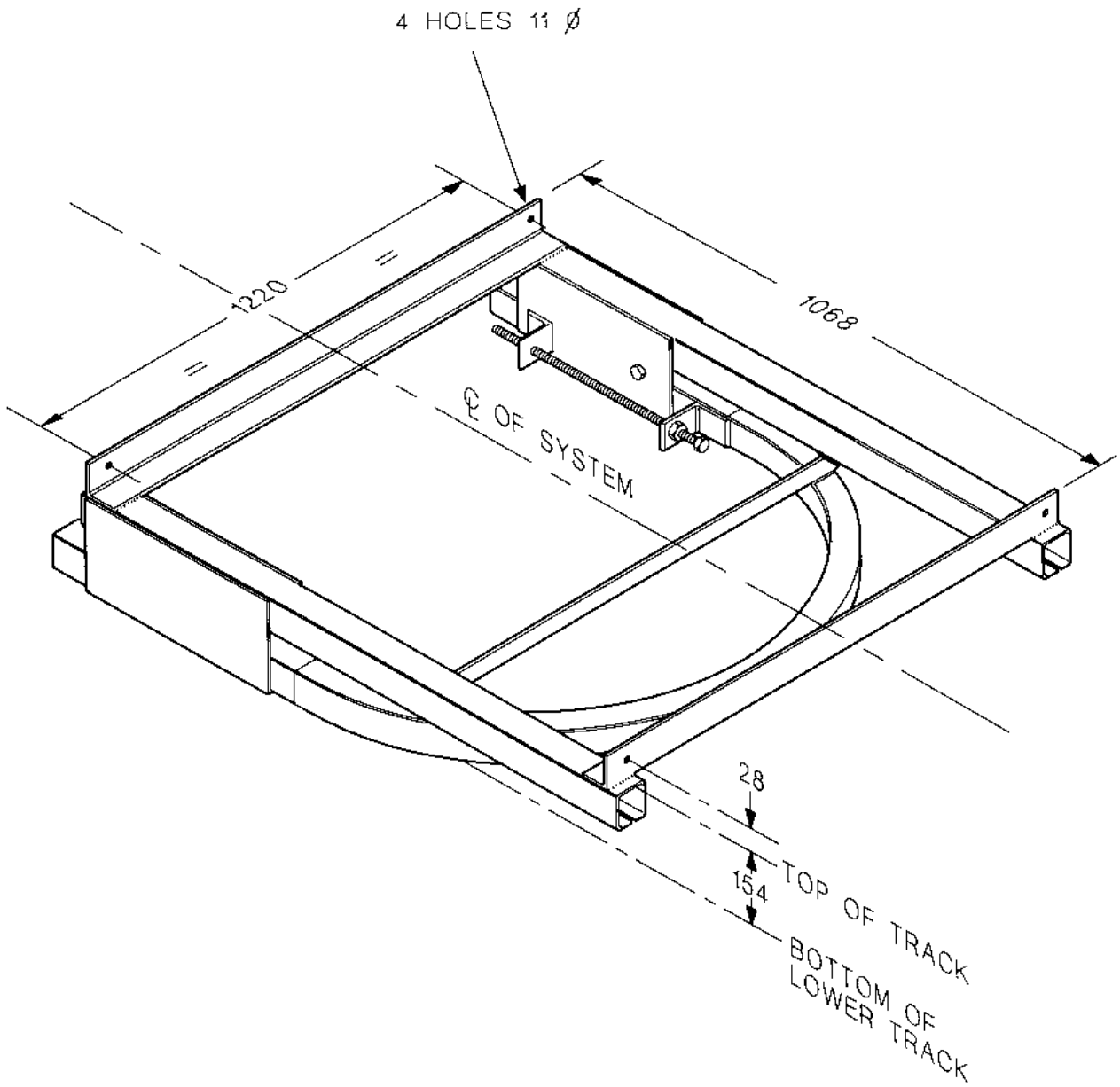
10	Pocket Casting Drilled and Plated	716701	18	
11	Drive Chain Link Pin	716900	18	
12	Drive Plate 4 inch Pitch	717820	1	
13	Drivewheel Support Plate	717835	1	
14	Gearbox Retaining Plate	717900	1	
15	Spacer	8101X2	9	
16	M12 x 50 Socket Csk. Headed Screw Plated	CSM12050P	4	
17	M6 x 40 Hex. Headed Bolt Plated	HBM06040P	9	
18	M6 Nylon Insert Lock Nut Plated	HNM06NYLP	9	
19	M6 Hex. Thin Lock Nut Phils Plated	HNM06PHTP	36	
20	M12 Hex. Full Nut Plated	HNM12NUTP	4	
21	M16 x 45 Hex. Headed Screw Plated	HSM16045P	1	
22	M6 Flat Washer Plated	WAM06FLTP	9	
23	M12 Flat Washer Plated	WAM12FLTP	4	
24	M12 Spring Washer Plated	WAM12SPRP	4	
25	M16 Flat Washer Plated	WAM16FLTP	1	
26	M16 Spring Washer Plated	WAM16SPRP	1	

PARTS LIST

System: 275L/550M

Component: Tension Unit 610mm Draw Bolt

Drawing No. 720201

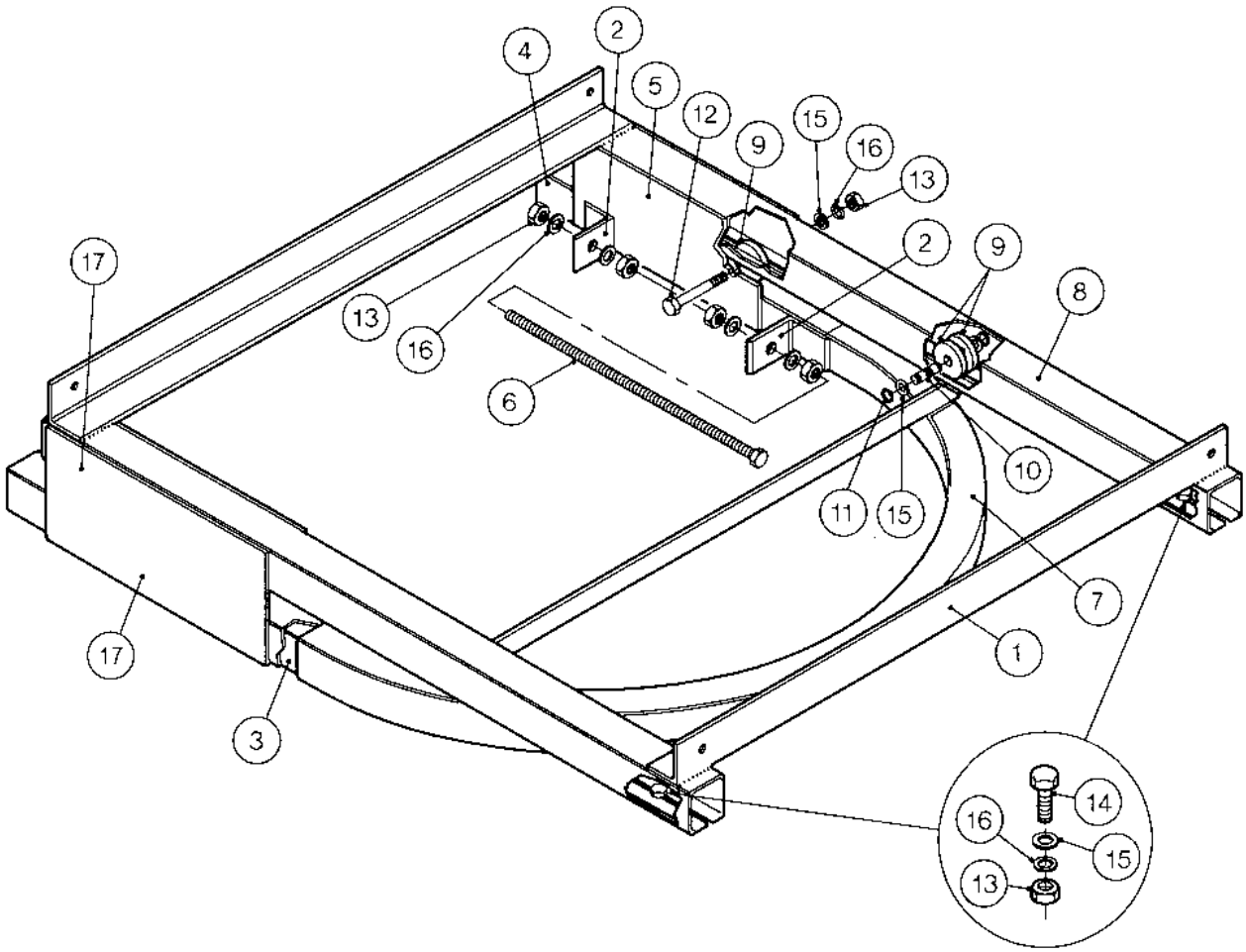


PARTS LIST

System: 275L/550M

Component: Tension Unit 610mm Draw Bolt

Drawing No. 720201



PARTS LIST

System: 275L/550M

Component: Tension Unit 610mm Draw Bolt

Drawing No. 720201

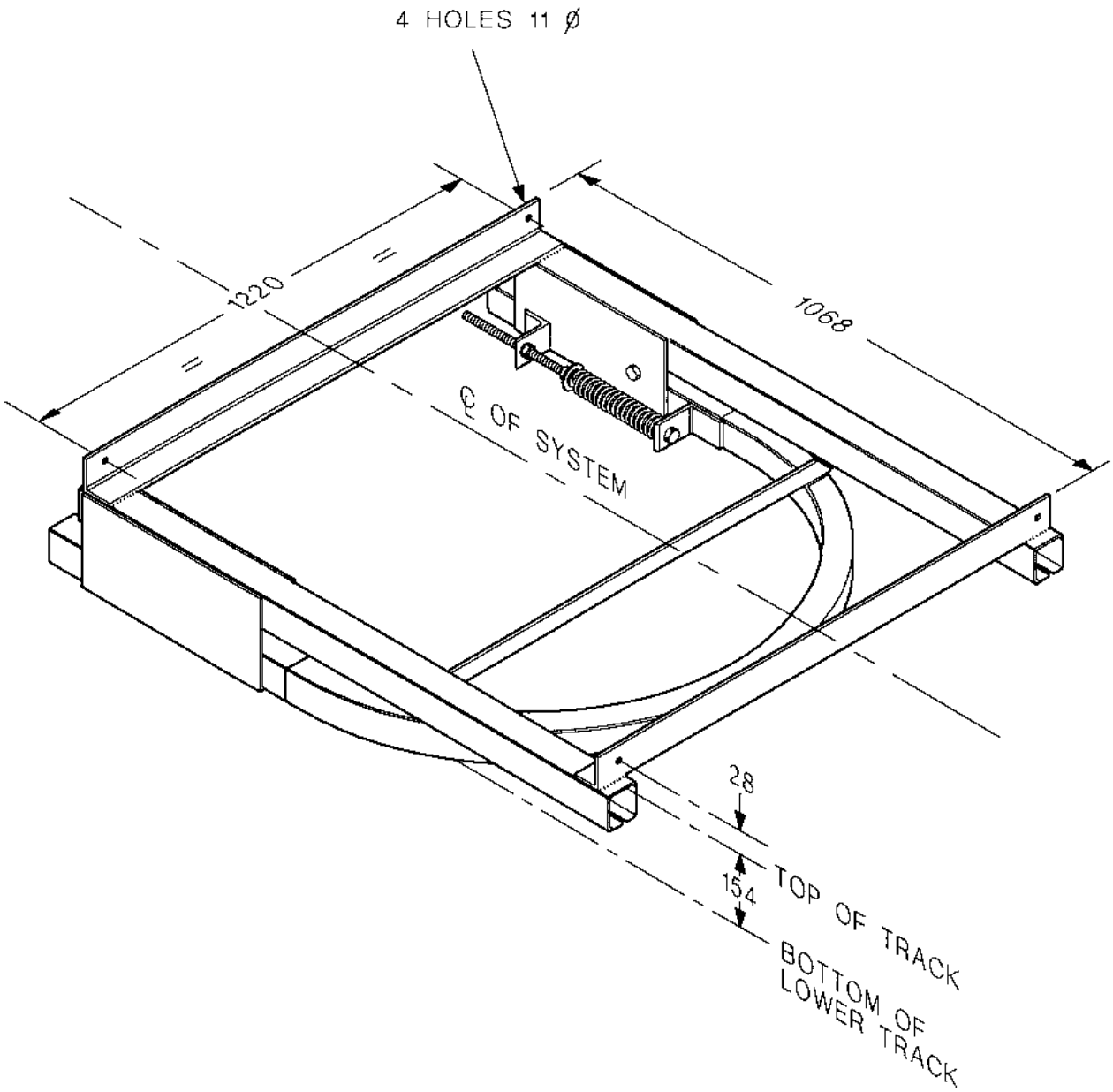
Item No.	Description	Part No.	Qty.	Remarks
1	Angle 50 x 50 x 6mm MS Black	0150X0		
2	Angle 75 x 50 x 6mm MS Black	0175X0		
3	550M Tension Tongue	722305	2	
4	550M Tension End	722306	2	
5	STS Tension Plate Standard	722307	4	
6	550M Tongue and Sleeve Unit Draw Bolt	722001	2	
7	550M Bend Hor. 180 x 610mm Plain	733001	1	
8	550M Track Untreated 6m	7504X0		
9	550M Roller P/S for Tension Unit	7666X7	6	
10	550M Knurled Pin inch S/Steel	7667X1	2	
11	Circlip inch Type 1500 Ref. 396E	CIR15396E	4	
12	Hexagon Headed Bolt M12 x 90 Lg Plated Plated	HBN12090P	2	
13	M12 Hex. Full Nut Plated	HNM12NUTP	10	
14	M12 x 25 Hex. Headed Screw Plated	HSM12025P	2	
15	M12 Flat Washer Form B Plated	WAM12FLBP	16	
16	M12 Spring Washer Plated	WAM12SPRP	4	
17	MS Black 4 mm	0504X0	-	

PARTS LIST

System: 275L/550M

Component: Tension Unit 610mm Spring

Drawing No. 720202

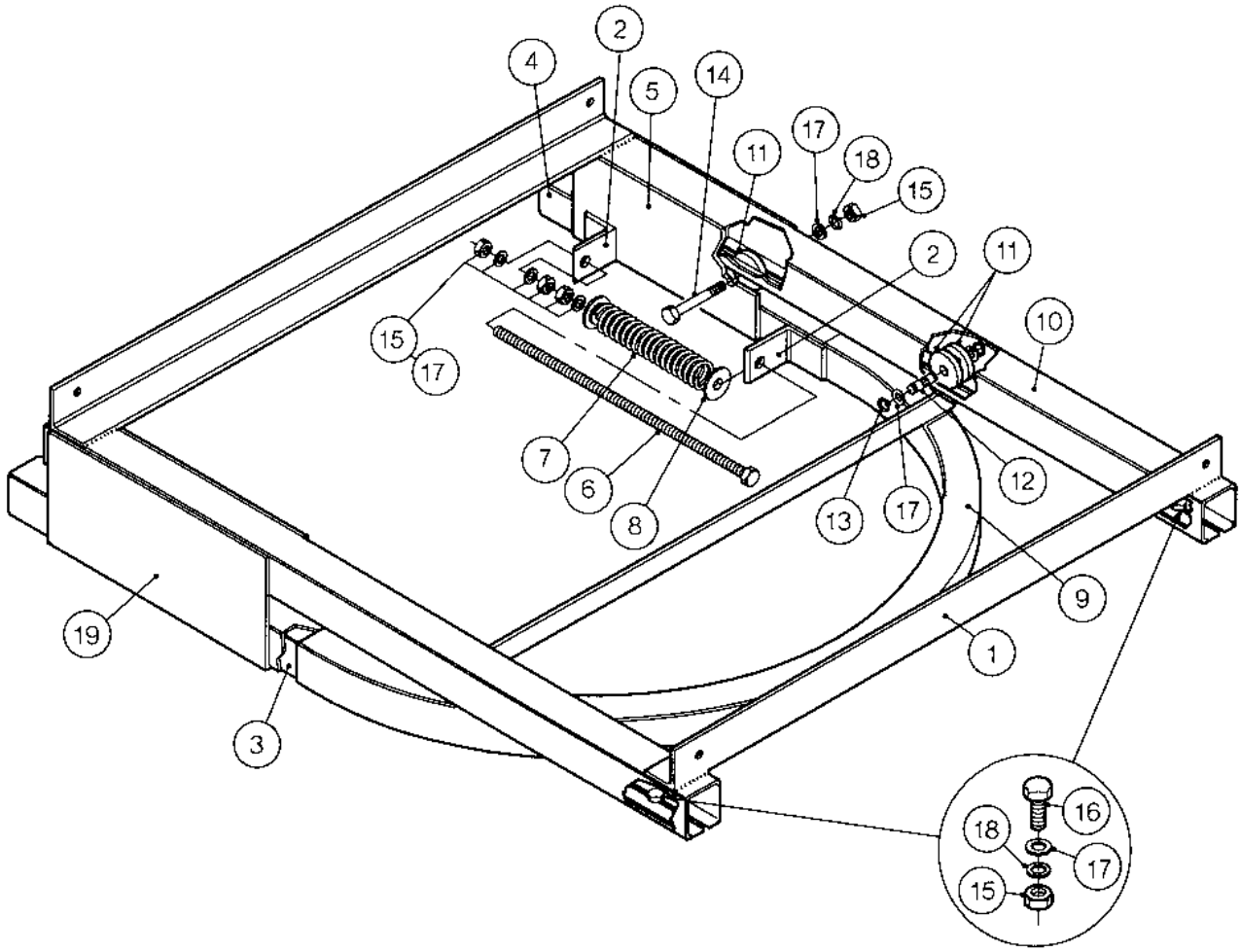


PARTS LIST

System: 275L/550M

Component: Tension Unit 610mm Spring

Drawing No. 720202



PARTS LIST

System: 275L/550M

Component: Tension Unit 610mm Spring

Drawing No. 720202

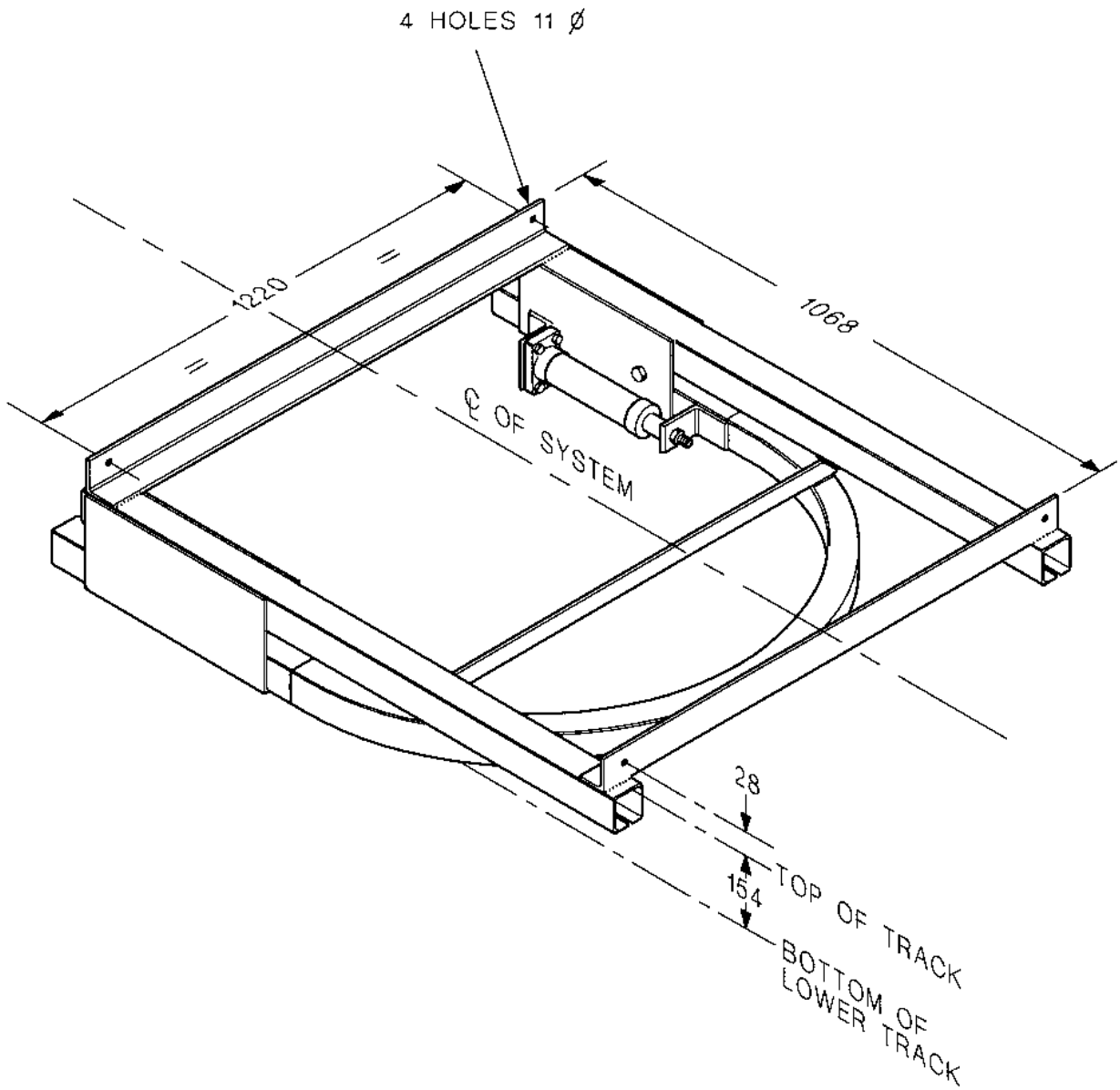
Item No.	Description	Part No.	Qty.	Remarks
1	Angle 50 x 50 x 6mm MS Black	0150X0		
2	Angle 75 x 50 x 6mm MS Black	0175X0		
3	550M Tension Tongue	722305	2	
4	550M Tension End	722306	2	
5	STS Tension Plate Standard	722307	4	
6	Tension Studding Bolt Plated	722401	2	
7	Tension Spring Plated	7225X1	2	
8	Tension Boss Plated	722600	4	
9	550M Bend Hor. 180 x 610mm Plain	733001	1	
10	550M Track Untreated 6m	7504X0		
11	550M Roller P/S for Tension Unit	7666X7	6	
12	550M Knurled Pin **Error!** inch S/Steel	7667X1	2	
13	Circlip **Error!** inch Type 1500 Ref. 396E	CIR15396E	4	
14	Hex. Headed Bolt M12 x 90 Lg Plated	HBN12090P	2	
15	M12 Hex. Full Nut Plated	HNM12NUTP	10	
16	M12 x 25 Hex. Headed Screw Plated	HSM12025P	2	
17	M12 Flat Washer Form B Plated	WAM12FLBP	10	
18	M12 Spring Washer Plated	WAM12SPRP	4	
19	MS Black 4 mm	0504X0	-	

PARTS LIST

System: 275L/550M

Component: Tongue and Sleeve Pneumatic Tensioner

Drawing No. 720301

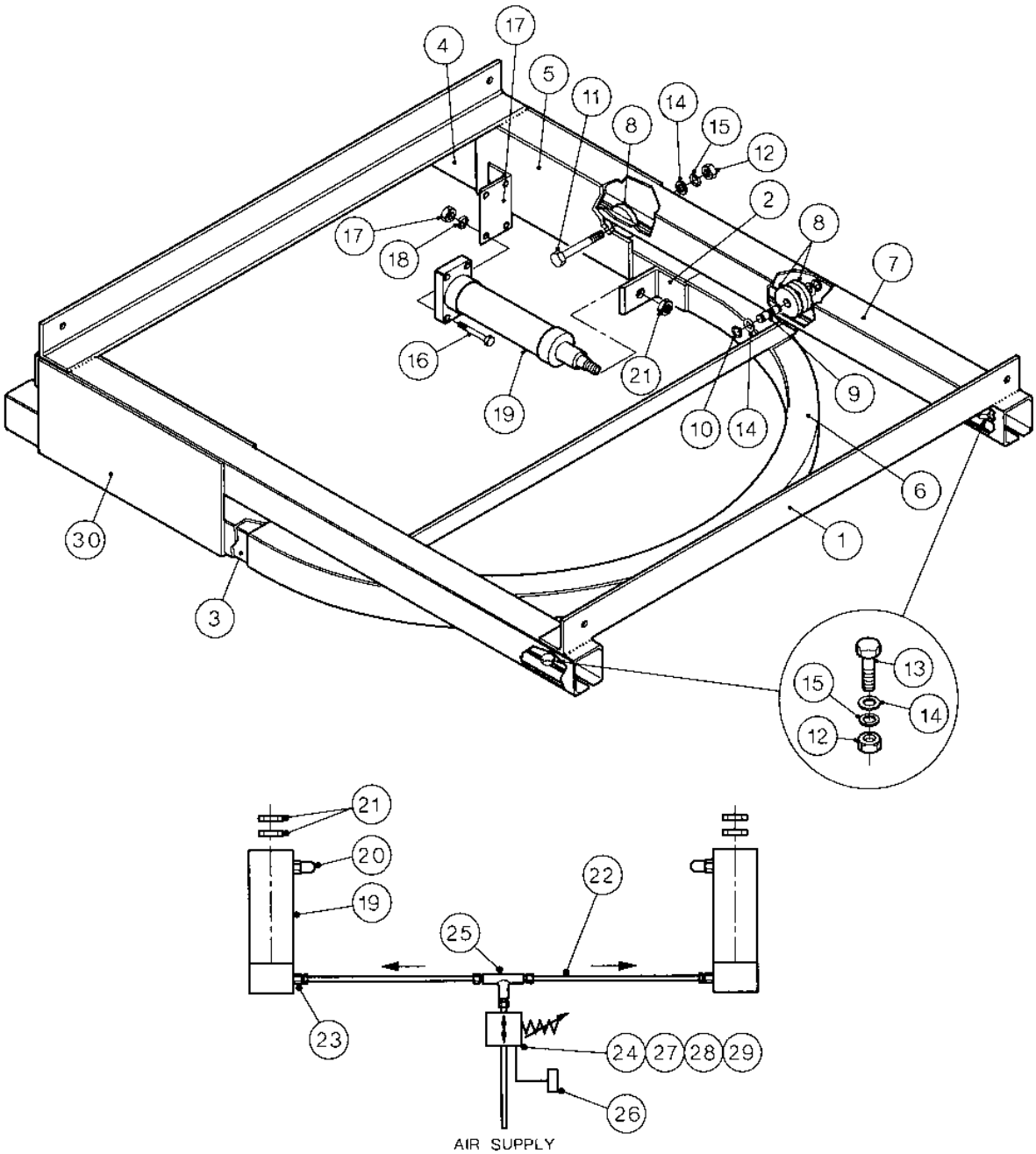


PARTS LIST

System: 275L/550M

Component: Tongue and Sleeve Pneumatic Tensioner

Drawing No. 720301



PARTS LIST

System: 275L/550M

Component: Tongue and Sleeve Pneumatic Tensioner

Drawing No. 720301

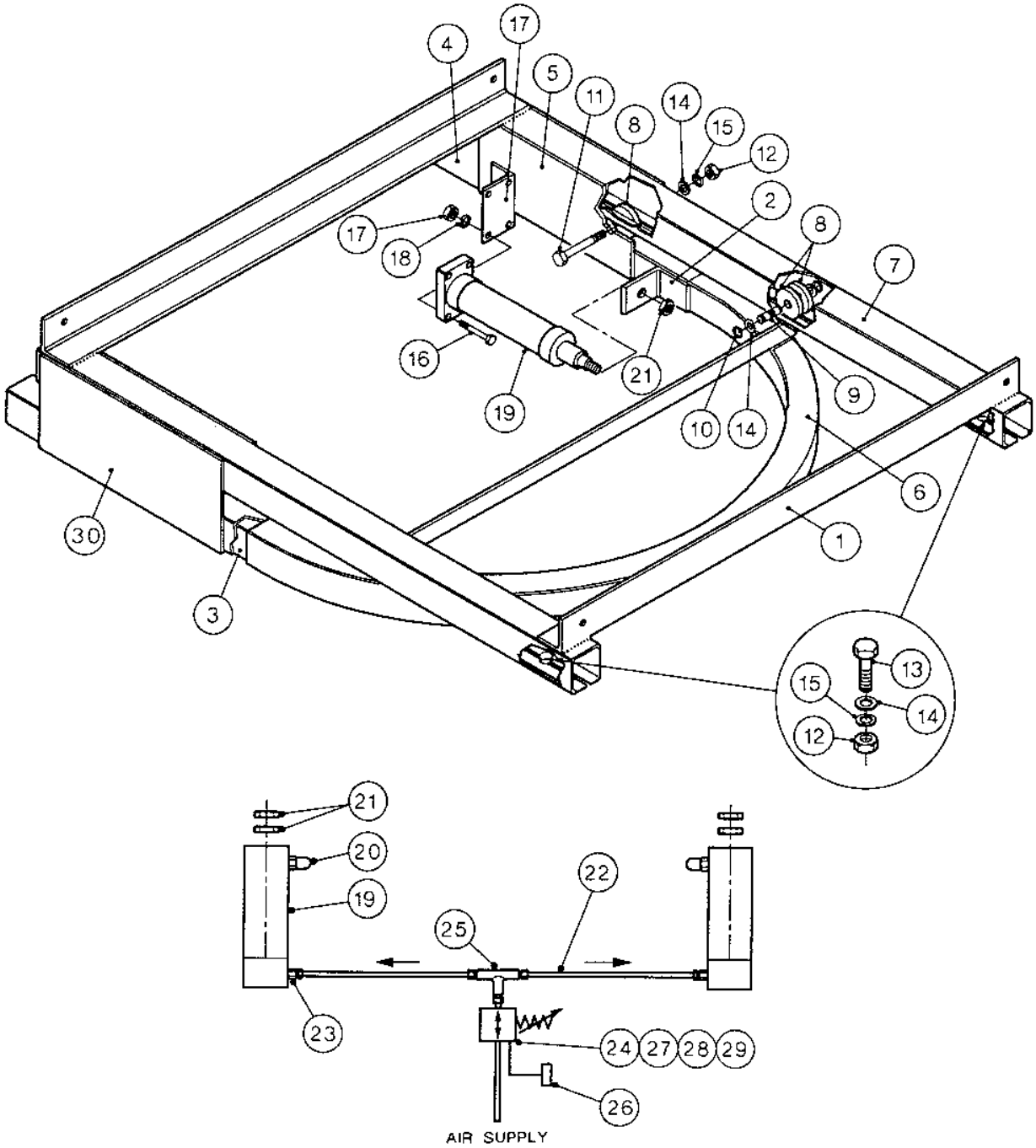
Item No.	Description	Part No.	Qty.	Remarks
1	Angle 50 x 50 x 6mm MS Black	0150X0		
2	Angle 75 x 50 x 6mm MS Black	0175X0		
3	550M Tension Tongue	722305	2	
4	550M Tension End	722306	2	
5	STS Tension Plate Standard	722307	4	
	Pneumatic Tensining Equipment	7226X0		See Page 4
6	550M Bend Hor. 180 x 610mm Plain	733001	1	
7	550M Track Untreated 6m	7504X0		
8	550M Roller P/S for Tension Unit	7666X7	6	
9	550M Knurled Pin inch S/Steel	7667X1	2	
10	Circlip inch Type 1500 Ref. 396E	CIR15396E	4	
11	Hex. Headed Bolt M12 x 90 Lg Plated	HBN12090P	2	
12	M12 Hex. Full Nut Plated	HNM12NUTP	4	
13	M12 x 25 Hex. Headed Screw Plated	HSM12025P	2	
14	M12 Flat Washer Form B Plated	WAM12FLBP	4	
15	M12 Spring Washer Plated	WAM12SPRP	2	
16	M8 x 25 Hex. Headed Screw Plated	HSM0825P	8	
17	M8 Nylon Insert Locknut Plated	HNM08NYLP	8	
18	M8 Spring Washer Plated	WAM08SPRP	8	

PARTS LIST

System: 275L/550M

Component: Tongue and Sleeve Pneumatic Tensioner

Drawing No. 720301



PARTS LIST

System: 275L/550M

Component: Tongue and Sleeve Pneumatic Tensioner (Continued)

Drawing No. 7226X0

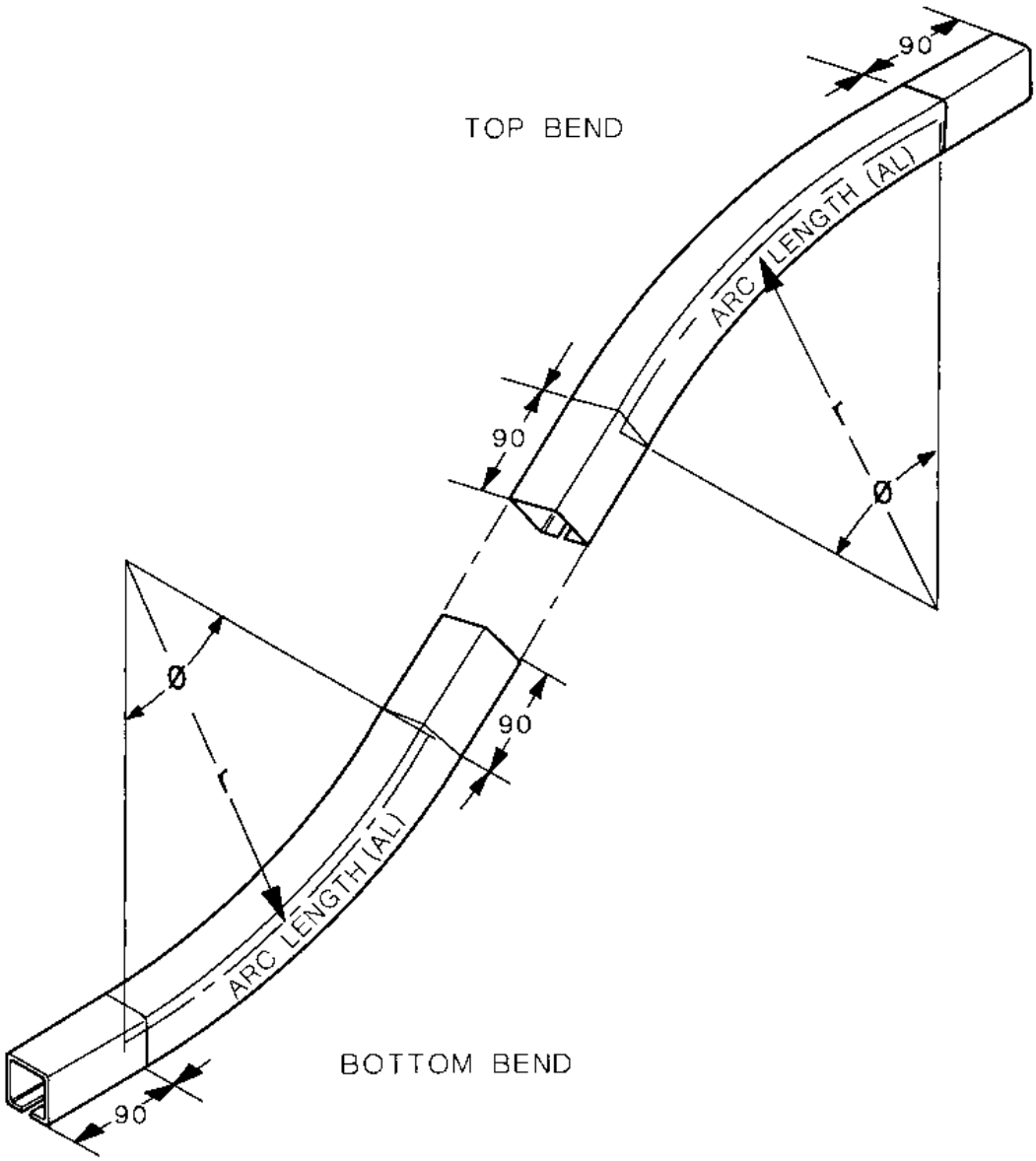
Item No.	Description	Part No.	Qty.	Remarks
19	Cylinder	7226X1	2	or equivalent
20	Plastic Silencer SD202 SLR1	7226X9	2	or equivalent
21	Lock Nuts	HN5/8BFLCP	4	
22	Nylon Tube 6 mm OD x 1 mm wall TN06	0664X0	1 m	
23	Straight Adaptor inch BSP/6 mm OD RM010612N	7226X6	3	push fit for tube
24	Pressure Regulator AR 35-2	7226X3	1	
25	Swivel Tee inch BSP/6 mm OD tube RM100612N	7226X5	1	push fit for tube
26	Pressure Gauge Compair AG2M10	7226X4	1	
27	Regulator Mounting Bracket AR307571	7226X7	1	
28	Regulator Mounting Ring AR05X51	7226X8	1	
29	Pop Rivet	PR4.8D013	2	
30	MS Black 4 mm	0504X0	-	

PARTS LIST

System: 275L/550M

Components: Bends Vertical

Drawing Nos. See Tables



PARTS LIST

System: 275L/550M

Components: Bends Vertical

Drawing Nos. See Tables

550M Vertical 15 deg. (ø) x 610mm rad. (r) Top. Drawing No. 742000

Item No.	Description	Part No.	Qty.	Remarks
1	550M Vertical 180 x 610mm Top Plain	742900		AL 167 mm
2	550M Track with Chamfer 90mm	750300	2	

550M Vertical 15 deg. (ø) x 610mm rad. (r) Bottom. Drawing No. 742001

1	550M Vertical 180 x 610mm Bottom Plain	742901		AL 167 mm
2	550M Track with Chamfer 90mm	750300	2	

550M Vertical 30 deg. (ø) x 610mm rad. (r) Top. Drawing No. 742100

1	550M Vertical 180 x 610mm Top Plain	742900		AL 335 mm
2	550M Track with Chamfer 90mm	750300	2	

550M Vertical 30 deg. (ø) x 610mm rad. (r) Bottom. Drawing No. 742101

1	550M Vertical 180 x 610mm Bottom Plain	742901		AL 335 mm
2	550M Track with Chamfer 90mm	750300	2	

550M Vertical 45 deg. (ø) x 610mm rad. (r) Top. Drawing No. 742200

1	550M Vertical 180 x 610mm Top Plain	742900		AL 502 mm
2	550M Track with Chamfer 90mm	750300	2	

550M Vertical 45 deg. (ø) x 610mm rad. (r).Bottom. Drawing No. 742201

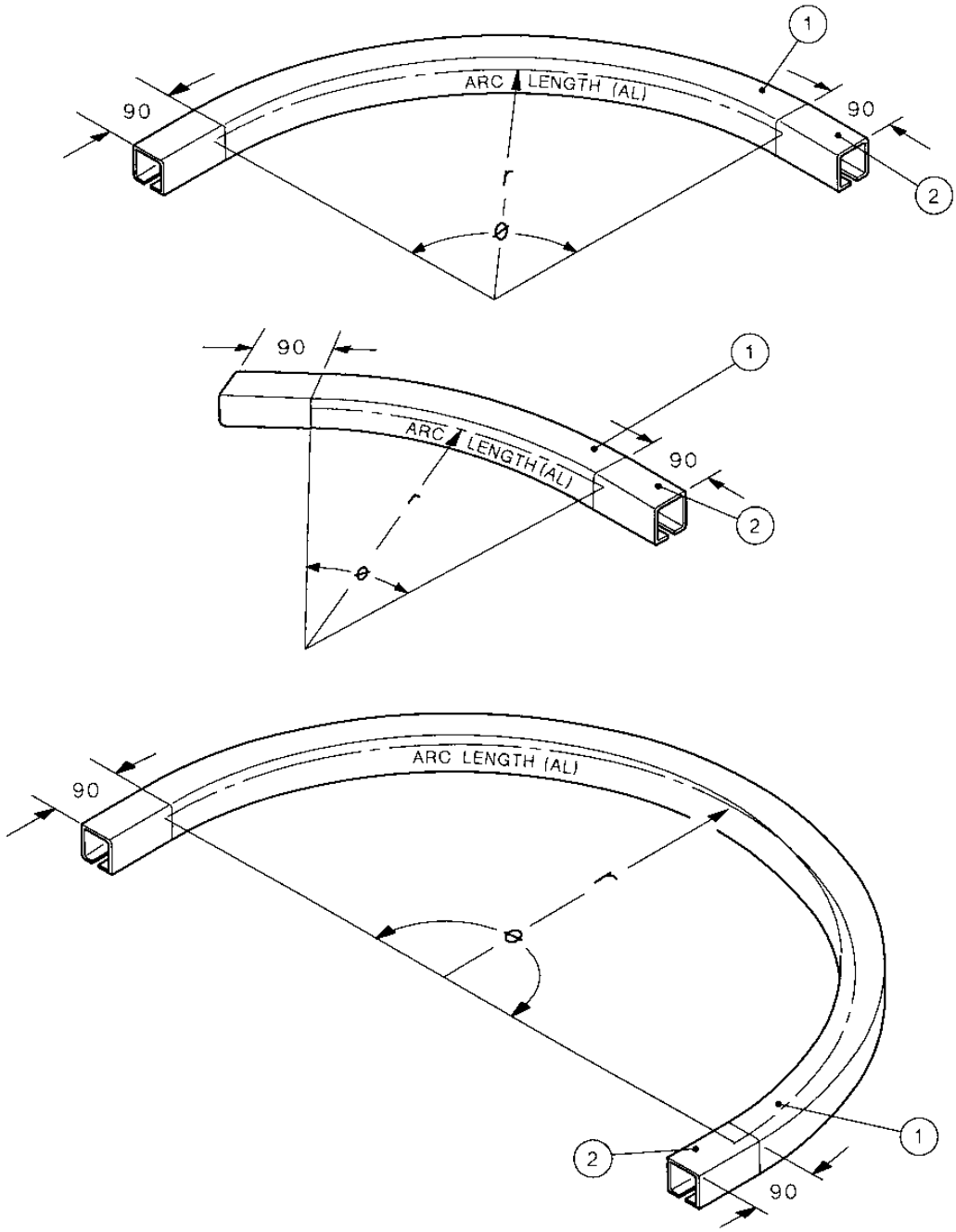
1	550M Vertical 180 x 610mm Bottom Plain	742901		AL 502 mm
2	550M Track with Chamfer 90mm	750300	2	

PARTS LIST

System: 275L/550M

Components: Bends Horizontal

Drawing Nos. See Tables



PARTS LIST

System: 275L/550M

Components: Bends Horizontal

Drawing Nos. See Tables

550M Bend Horizontal 15 deg. (ø) x 610mm rad. (r). Drawing No. 732100

Item No.	Description	Part No.	Qty.	Remarks
1	550M Bend Horizontal 180 x 610mm Plain	733001		AL 167 mm
2	550M Track with Chamfer 90mm	750300	2	

550M Bend Horizontal 30 deg. (ø) x 610mm rad. (r). Drawing No. 732200

1	550M Bend Horizontal 180 x 610mm Plain	733001		AL 335 mm
2	550M Track with Chamfer 90mm	750300	2	

550M Bend Horizontal 45 deg. (ø) x 610mm rad. (r). Drawing No. 732300

1	550M Bend Horizontal 180 x 610mm Plain	733001		AL 502 mm
2	550M Track with Chamfer 90mm	750300	2	

550M Bend Horizontal 90 deg. (ø) x 610mm rad. (r). Drawing No. 732600

1	550M Bend Horizontal 180 x 610mm Plain	733001		AL 1004 mm
2	550M Track with Chamfer 90mm	750300	2	

550M Bend Horiz. 180 deg. (ø) x 610mm rad. (r). Drawing No. 732800

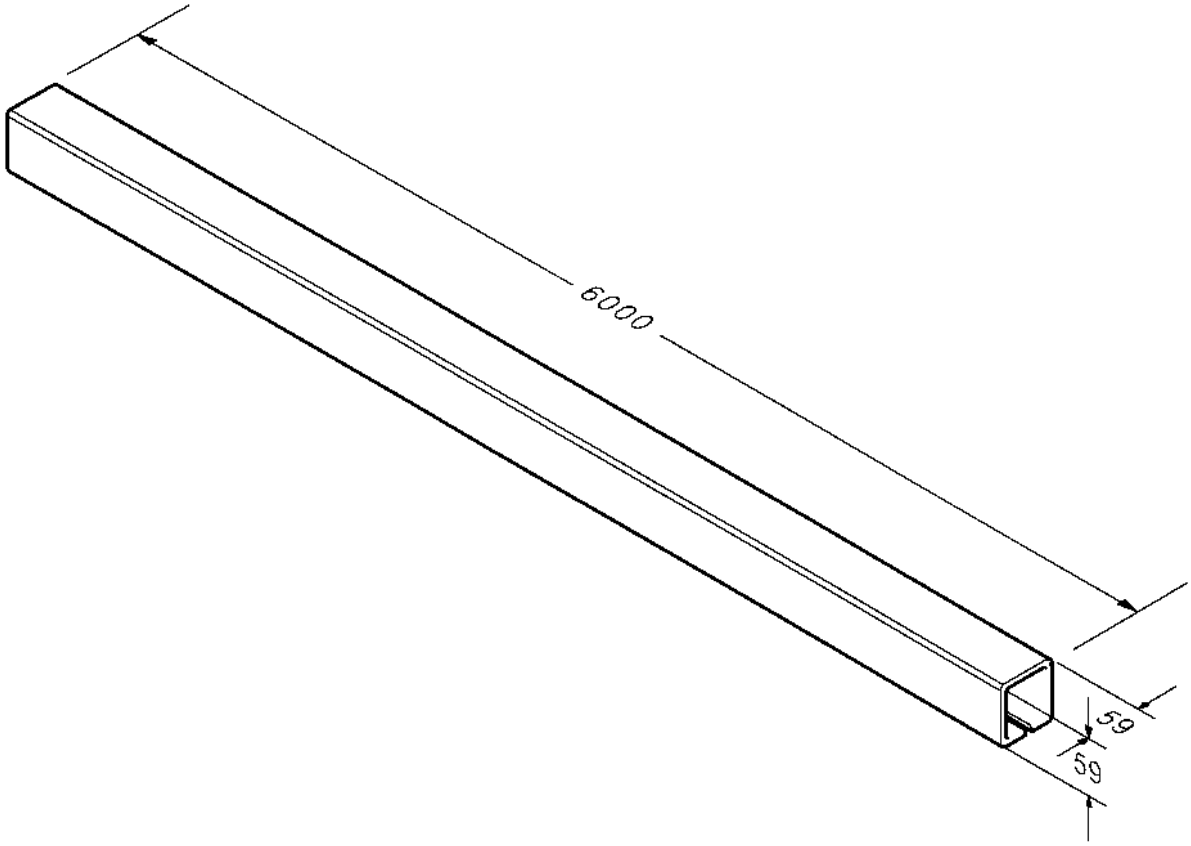
1	550M Bend Horizontal 180 x 610mm Plain	733001	1	AL 2009 mm
2	550M Track with Chamfer 90mm	750300	2	

PARTS LIST

System: 275L/550M

Component: Track with Chamfer

Drawing No. 750300



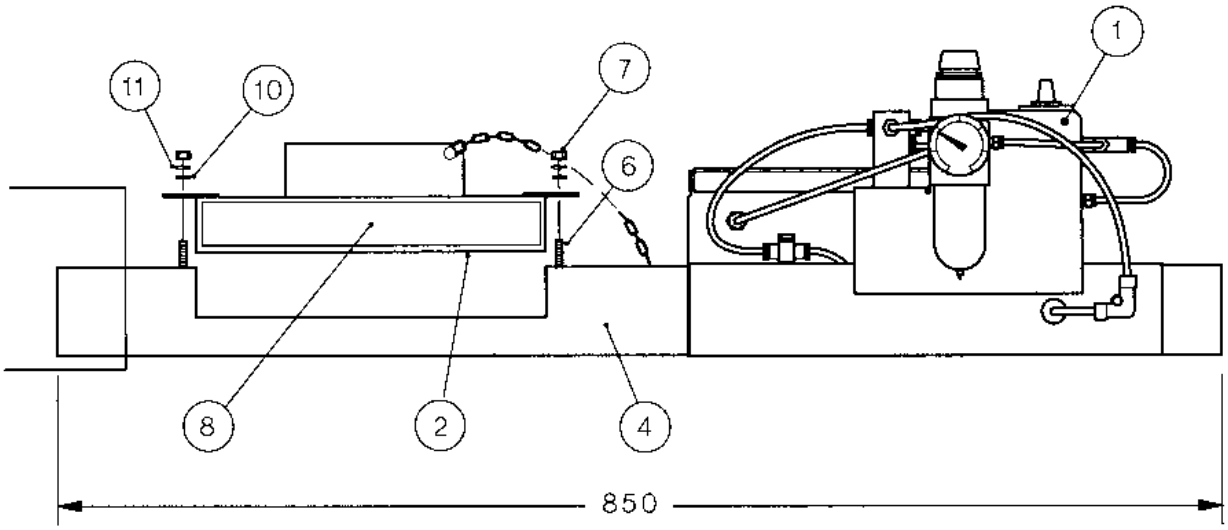
Item No.	Description	Part No.	Qty.	Remarks
1	550M Track Untreated 6M	7504X0	1	

PARTS LIST

System: 275L/550M

Component: Lister Lubricator and Inspection Station

Drawing No. 752407



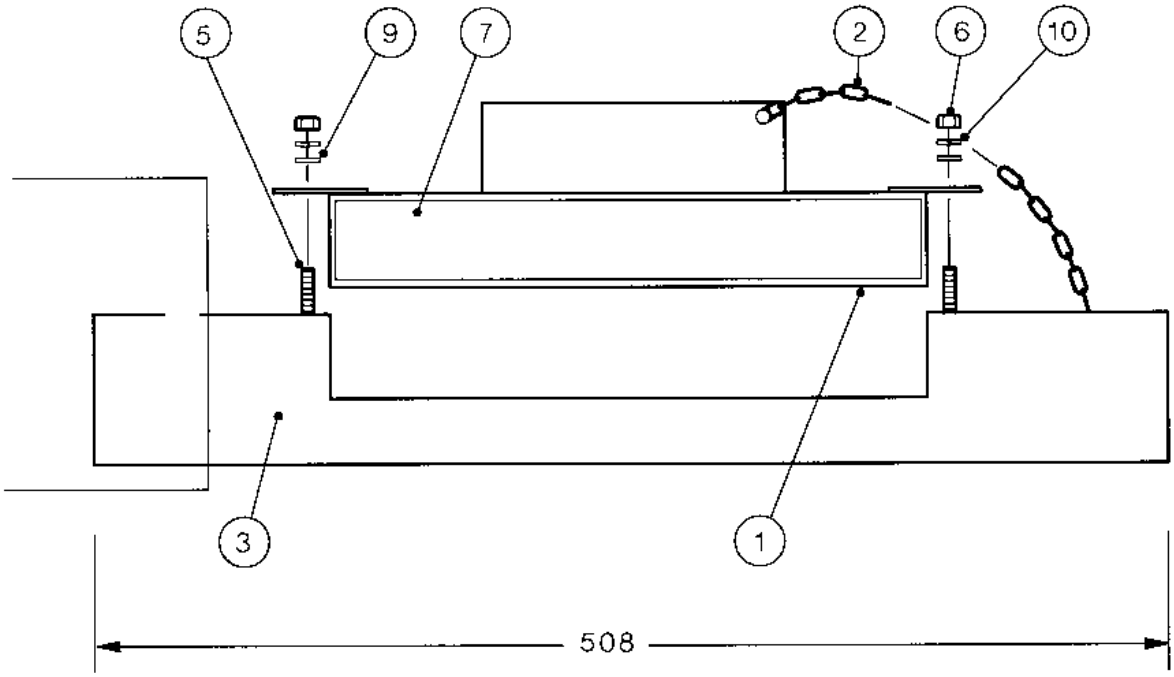
Item No.	Description	Part No.	Qty.	Remarks
1	Lister Lubricator Type DP Range	7524X2	1	
2	Track Untreated 6M	7504X0		
3	Chain Spacing (10G) Galv.	5703X0		
4	Track Untreated 6M	7504X0		
6	M6 x 20 Slotted C'sk. Headed Screw Plated	CSM06020P	2	
7	M6 Hex. Full Nut Plated	HNM06NUTP	4	
8	Inspection Machinery Warning	LABEL 1	2	
10	M6 Flat Washer Plated	WAM06FLTP	4	
11	M6 Spring Washer Plated	WAM06SPRP	4	

PARTS LIST

System: 275L/550M

Component: Inspection Station Plated

Drawing No. 751500



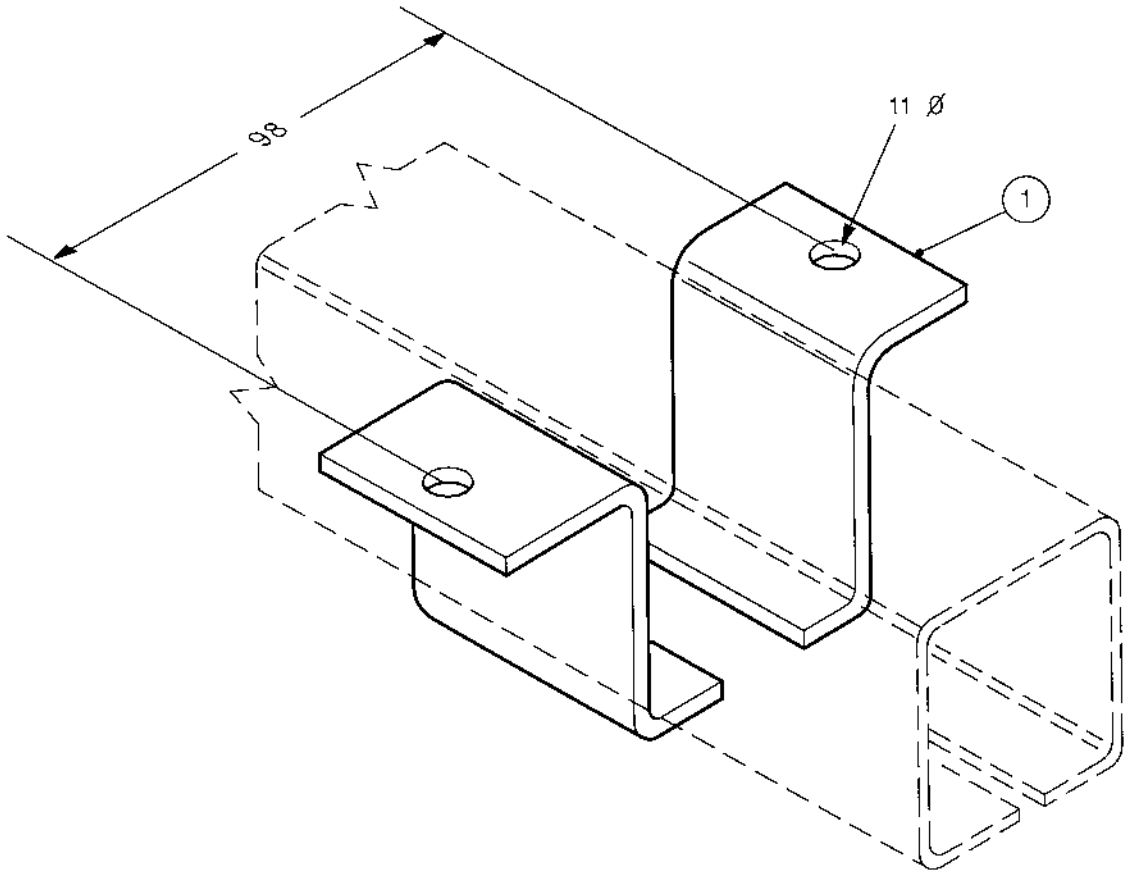
Item No.	Description	Part No.	Qty.	Remarks
1	550M Track Untreated 6M	7504X0		
2	Chain Spacing (10G) Galv.	5703X0		
3	550M Track Untreated 6M	7504X0		
5	M6 x 20 Slotted C'snk Headed Screw Plated	CSM06020P	2	
6	M6 Hex. Full Nut Plated	HNM06NUTP	2	
7	Inspection Machinery Warning	LABEL 1	2	
9	M6 Flat Washer Plated	WAM06FLTP	2	
10	M6 Spring Washer Plated	WAM06SPRP	2	

PARTS LIST

System: 275L/550M

Component: Track 'Z' Bracket Pair Plated

Drawing No. 751301



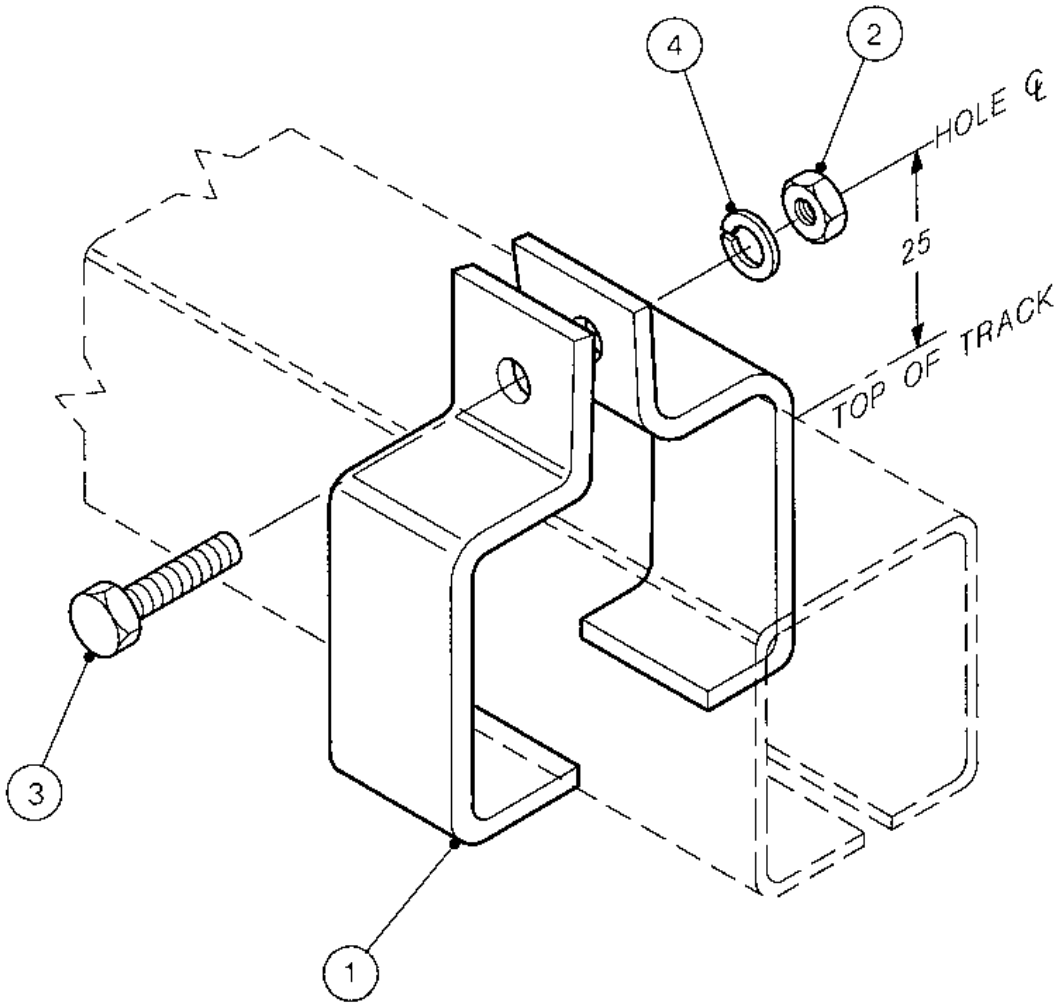
Item No.	Description	Part No.	Qty.	Remarks
1	Track 'Z' Bracket Single Plated	7513X0	2	

PARTS LIST

System: 275L/550M

Component: Track Hanger Bracket Pair Plated

Drawing No. 751001



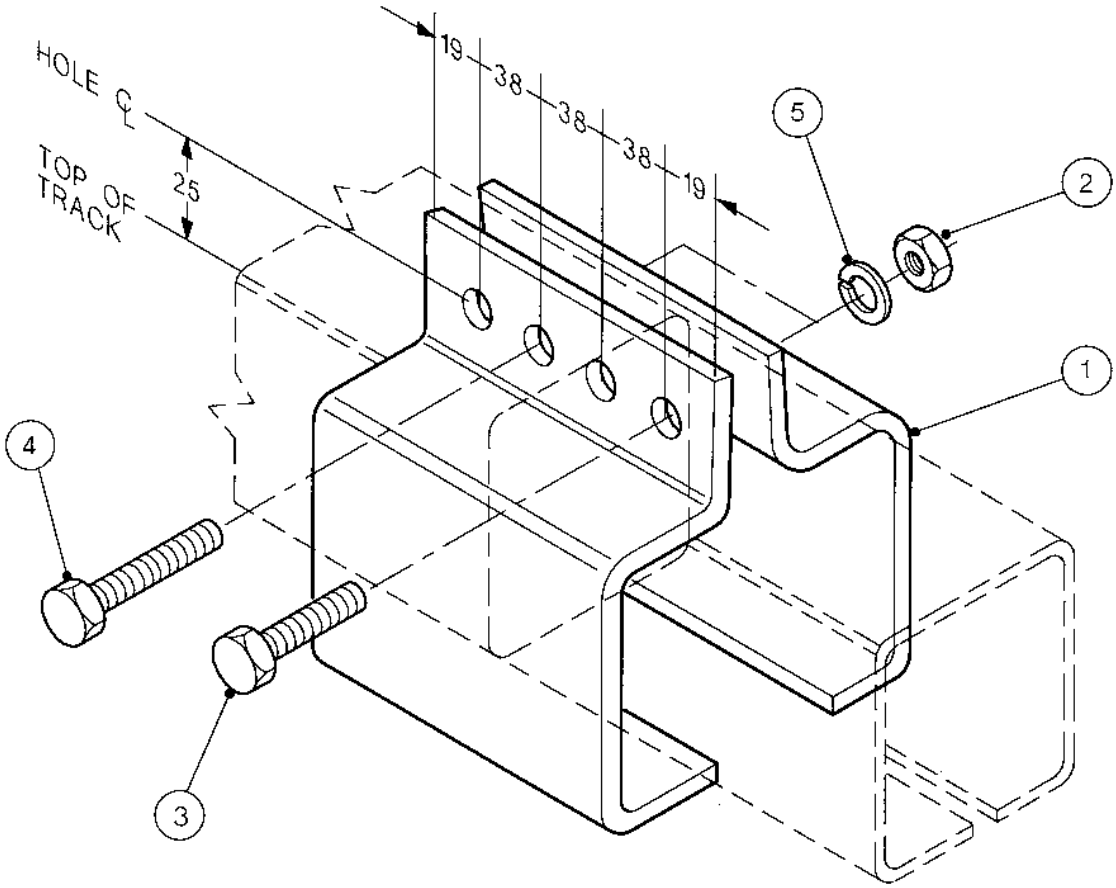
Item No.	Description	Part No.	Qty.	Remarks
1	Track Hanger Bracket Single Plated	7510X1	2	
2	M10 Hex. Full Nut Plated	HNM10NUTP	1	
3	M10 x 30 Hex. Headed Screw Plated	HSM10030P	1	
4	M10 Spring Washer Plated	WAM10SPRP	1	

PARTS LIST

System: 275L/550M

Component: Track Connector Pair Plated

Drawing No. 751201



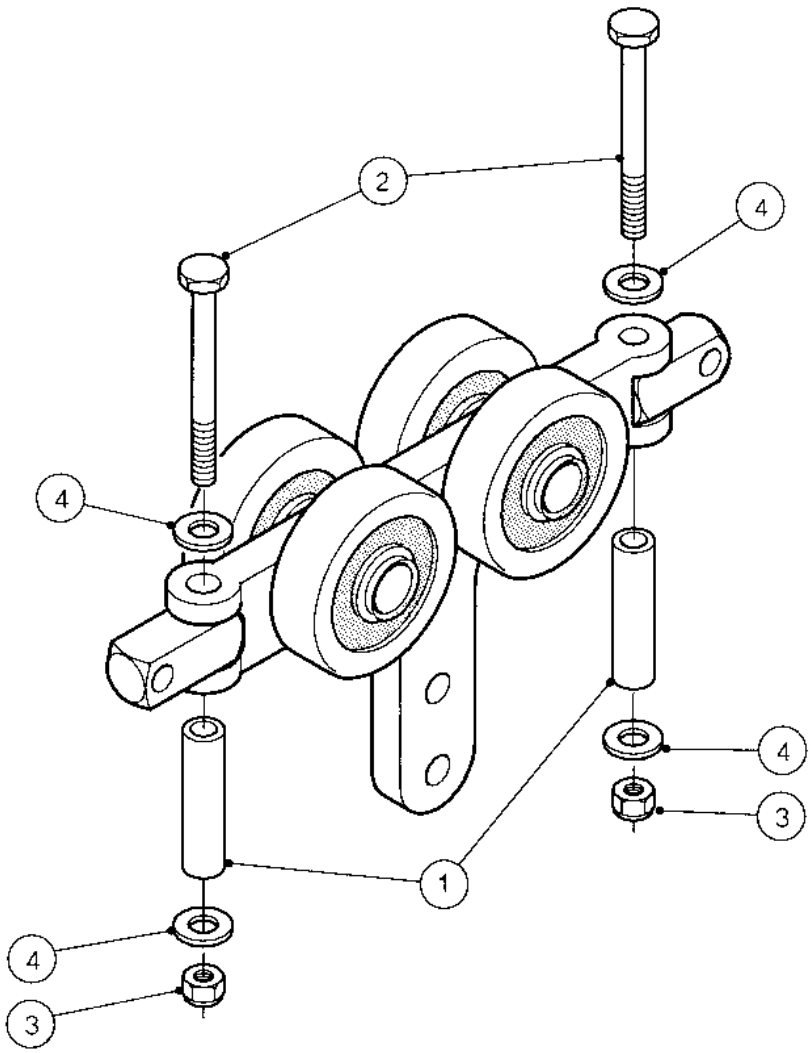
Item No.	Description	Part No.	Qty.	Remarks
1	Track Connector Single Plated	7512X1	2	
2	M10 Hex. Full Nut Plated	HNM10NUTP	4	
3	M10 x 25 Hex. Headed Screw Plated	HSM10025P	3	
4	M10 x 30 Hex. Headed Screw Plated	HSM10030P	1	
5	M10 Spring Washer Plated	WAM10SPRP	4	

PARTS LIST

System: 550M

Component: 4-wheel Load Link with Guide Roller

Drawing No. 769600



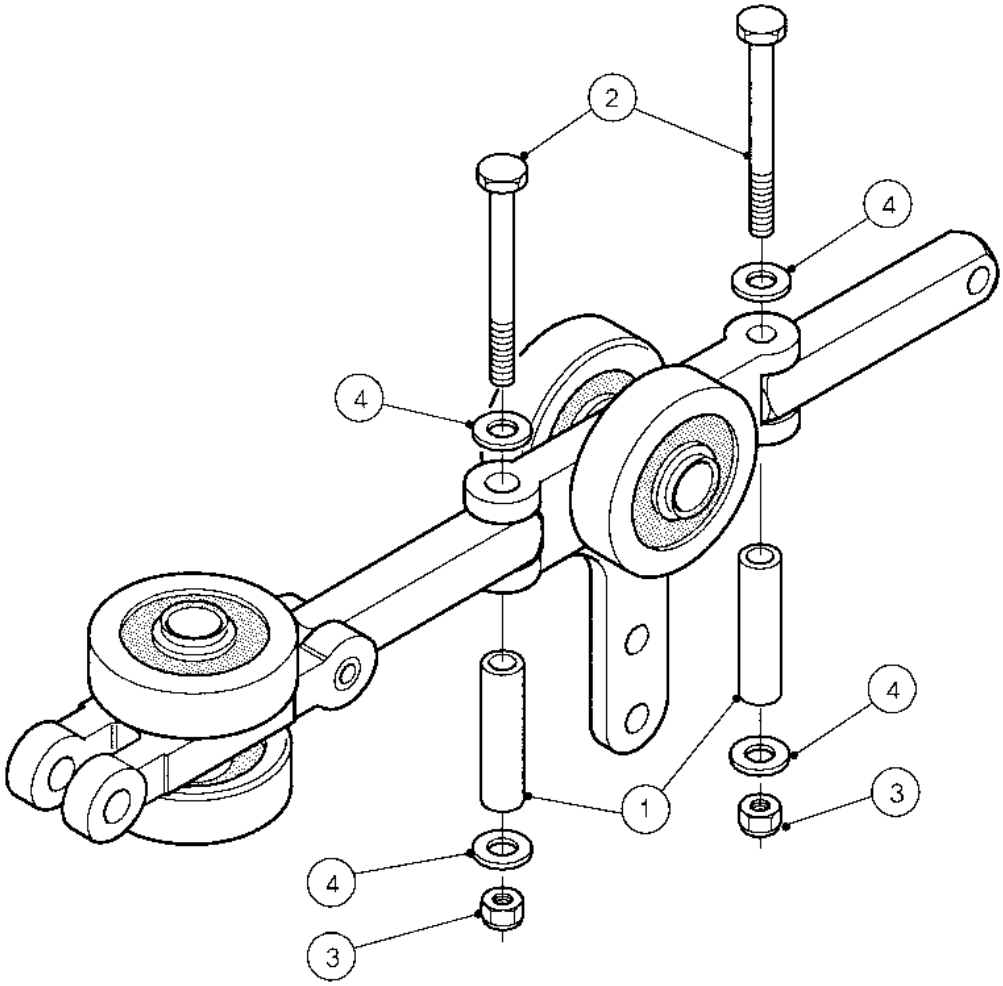
Item No.	Description	Part No.	Qty.	Remarks
1	Guide Roller Load Link 1 inch Long	7696X0	2	
2	x 2 UNF Hex. Headed Bolt Plated	HB1/4064P	2	
3	UNF Nylon Ins. Lock Nut Plated	HN1/4NYLP	2	
4	M6 Flat Washer Plated	WAM06FLTP	4	

PARTS LIST

System: 550M Chain

Component: 4 inch P x 8 inch LL with Guide Roller

Drawing No. 769600



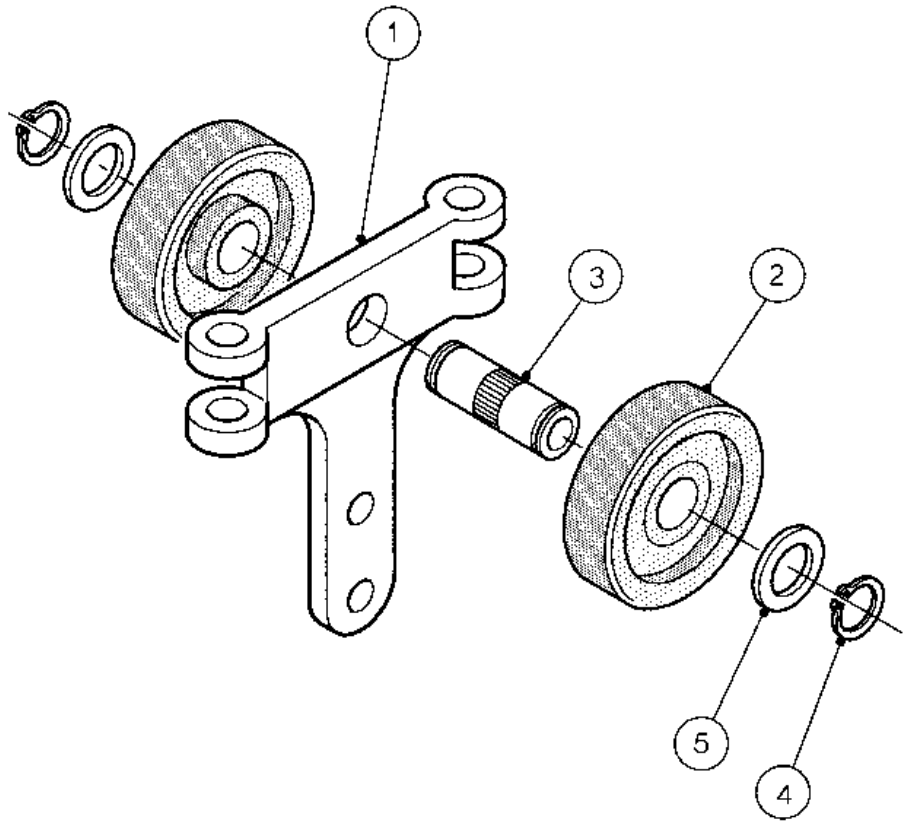
Item No.	Description	Part No.	Qty.	Remarks
1	Guide Roller Load Link 1 inch Long	7696X0	2	
2	x 2 UNF Hex. Headed Bolt Plated	HB1/4064P	2	
3	**Error!** UNF Nylon Ins. Lock Nut Plated	HN1/4NYLP	2	
4	M6 Flat Washer Plated	WAM06FLTP	4	

PARTS LIST

System: 550M

Component: Load Link Nylon Roller S/A

Drawing No. 765201



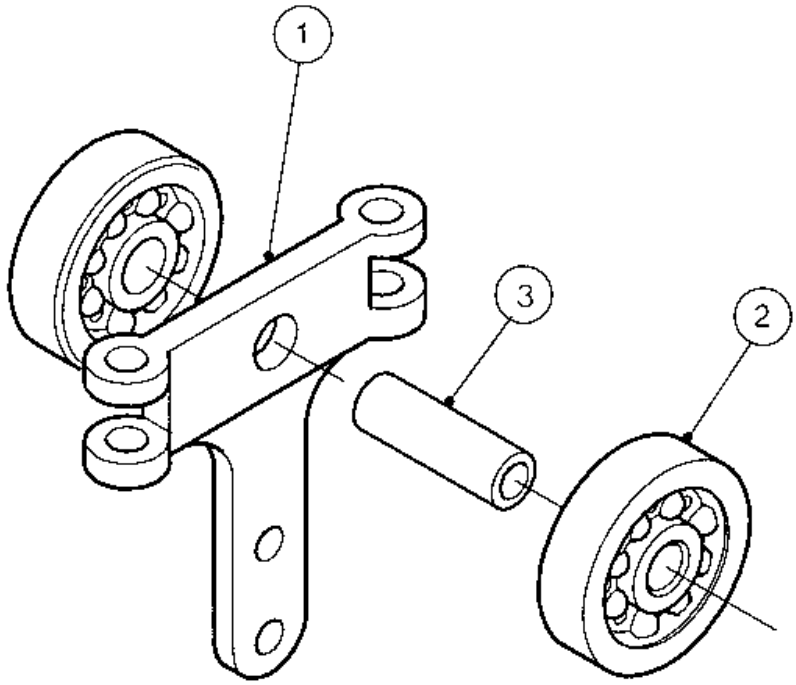
Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Roller Black Nylon inch	7666X1	2	
3	550M Knurled Pin inch S/Steel	7667X1	1	
4	Circlip inch Type 1500 Ref. 396E	CIR15396E	2	
5	inch Thin Flat Washer Plated	WA1/2FLTP	2	

PARTS LIST

System: 550M

Component: Load Link S/S Roller S/A

Drawing No. 765203



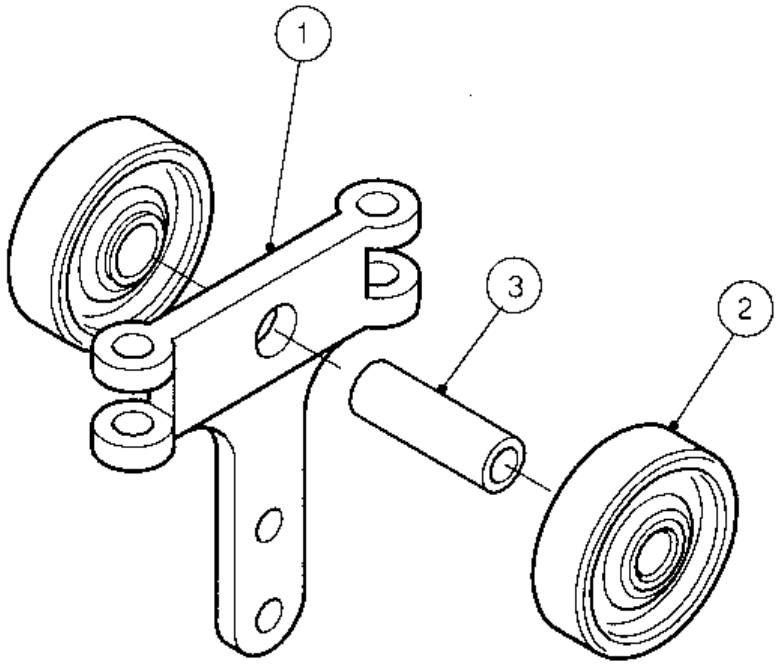
Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Roller R/Cage S/S CMC inch	7666X3	2	
3	550M Rivet Pin inch M/S	766700	1	

PARTS LIST

System: 550M

Component: Load Link P/S Roller S/A

Drawing No. 765202



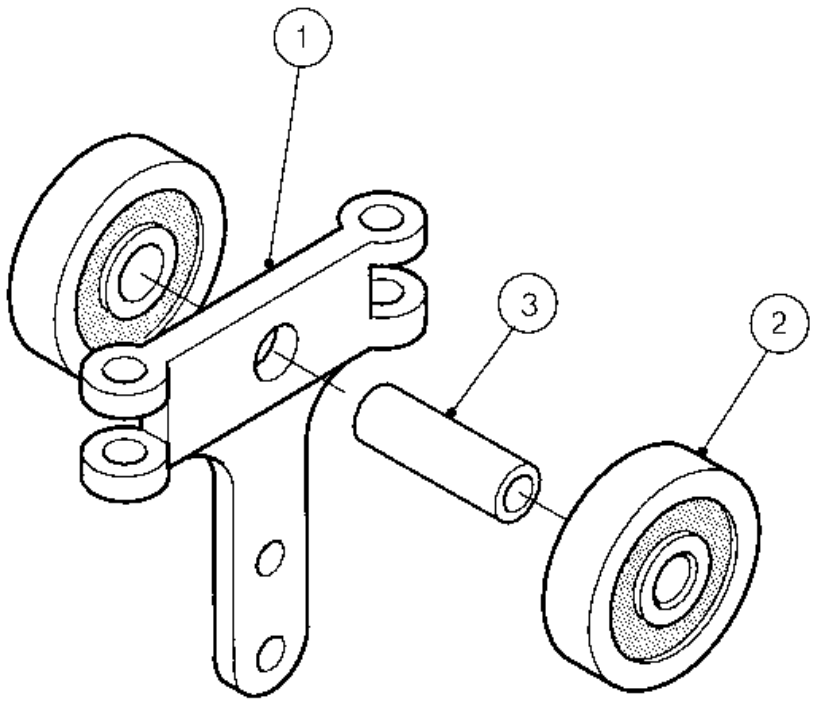
Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Roller P/S SG Type inch	7666X2	2	
3	550M Rivet Pin inch M/S	766700	1	

PARTS LIST

System: 550M

Component: Load Link F/S Roller S/A

Drawing No. 765204



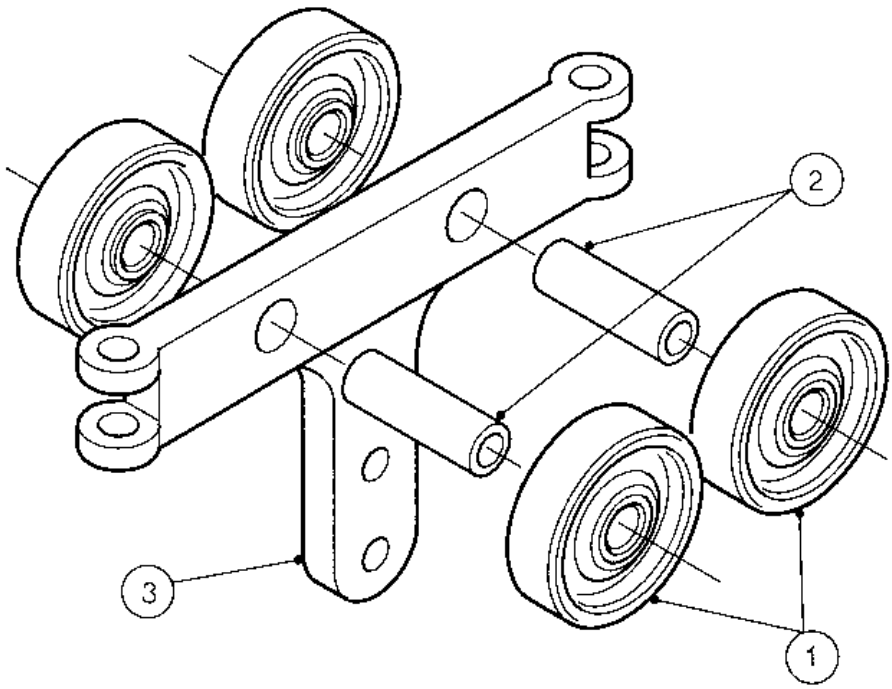
Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Roller Fl/Seal CMC inch	7666X4	2	
3	550M Rivet Pin inch M/S	766700	1	

PARTS LIST

System: 550M

Component: 4-wheel Load Link with P/S Roller

Drawing No. 769303



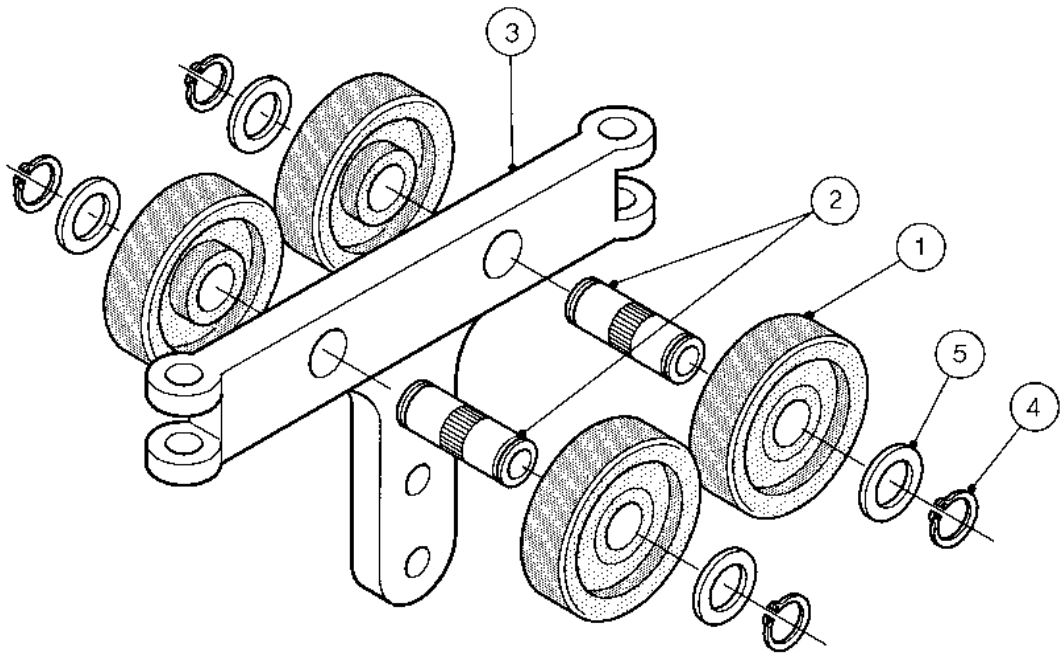
Item No.	Description	Part No.	Qty.	Remarks
1	550M Roller P/S SG Type inch	7666X2	4	
2	550M Rivet Pin inch M/S	766700	2	
3	4-wheel Load Link Machined and Plated	7693X0	1	

PARTS LIST

System: 550M

Component: 4-wheel Load Link with Nylon Roller

Drawing No. 769302



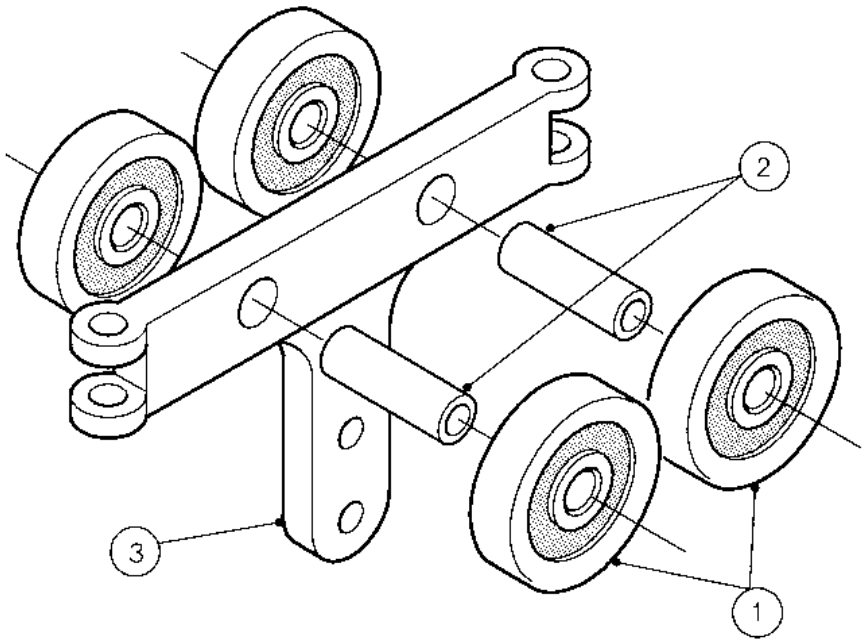
Item No.	Description	Part No.	Qty.	Remarks
1	550M Roller Black Nylon inch	7666X1	4	
2	550M Knurled Pin inch S/Steel	7667X1	2	
3	4-wheel Load Link Machined and Plated	7693X0	1	
4	Circlip inch Type 1500 Ref. 396E	CIR15396E	4	
5	inch Thin Flat Washer Plated	WA1/2FLTP	4	

PARTS LIST

System: 550M

Component: 4-wheel Load Link with F/S Roller

Drawing No. 769301



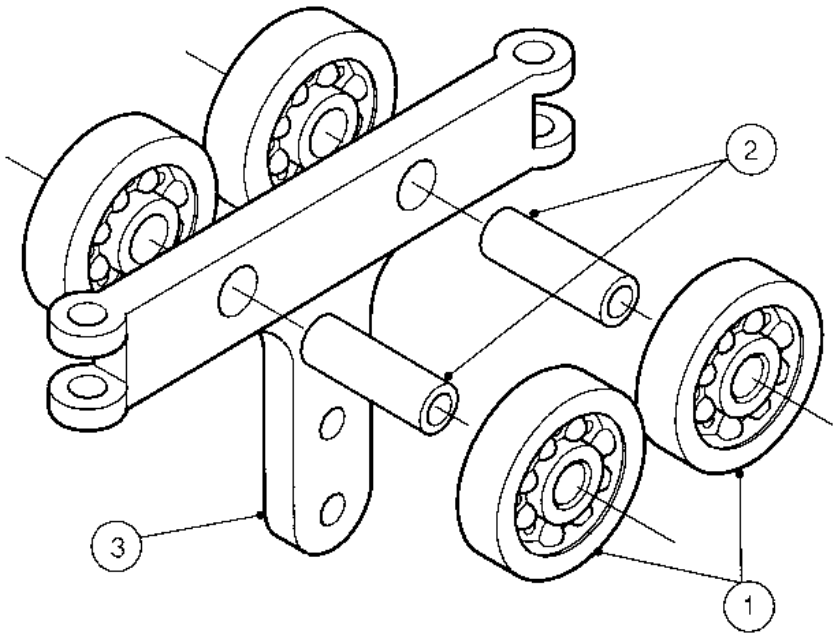
Item No.	Description	Part No.	Qty.	Remarks
1	550M Roller Fl/Seal CMC inch	7666X4	4	
2	550M Rivet Pin inch M/S	766700	2	
3	4-wheel Load Link Machined and Plated	7693X0	1	

PARTS LIST

System: 550M

Component: 4-wheel Load Link with S/S Roller

Drawing No. 769300



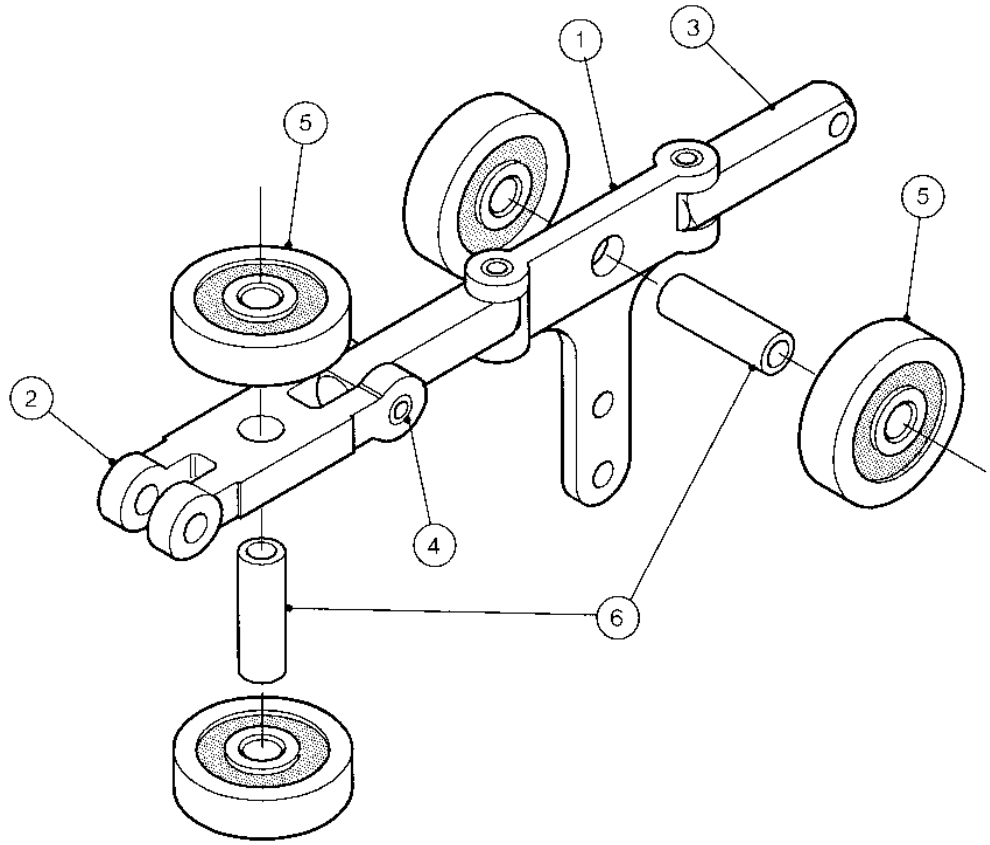
Item No.	Description	Part No.	Qty.	Remarks
1	550M Roller R/Cage S/S CMC inch	7666X3	4	
2	550M Rivet Pin inch M/S	766700	2	
3	4-wheel Load Link Machined and Plated	7693X0	1	

PARTS LIST

System: 550M Chain

Component: 4 inch P x 8 inch LL F/S Pitch

Drawing No. 764104



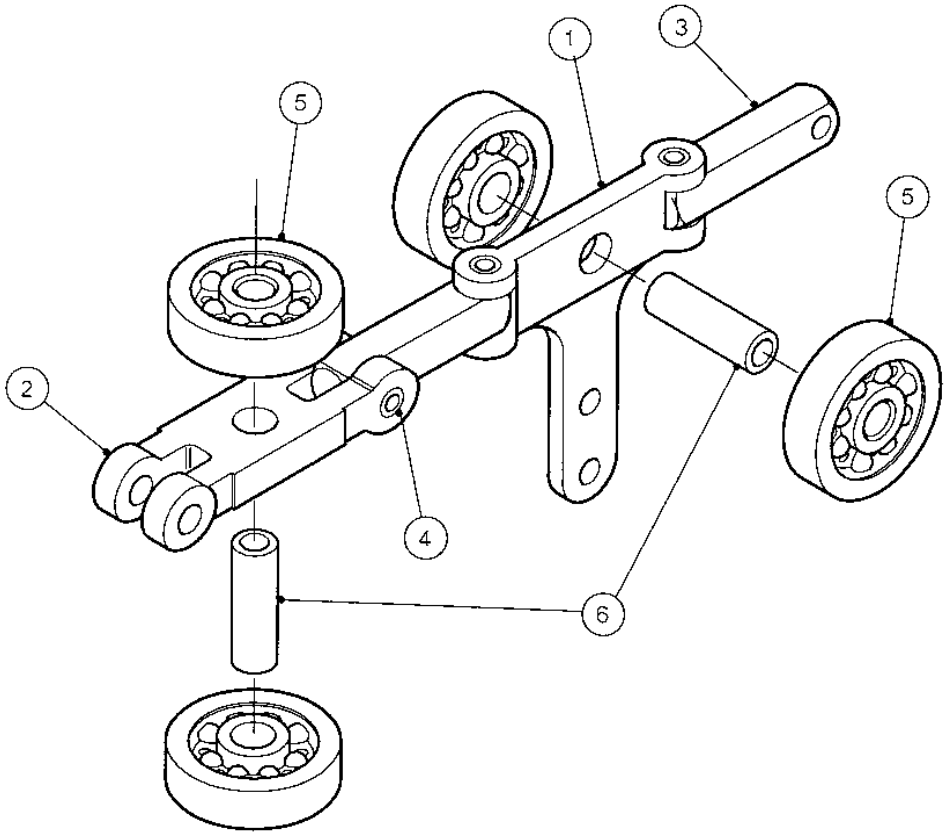
Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Plain Link Machined and Plated	765700	1	
3	550M Biplaner Block 1 inch Plated	766400	2	
4	550M Rivet Pin inch Plated	7665X1	4	
5	550M Roller Fl/Seal CMC inch	7666X4	4	
6	550M Rivet Pin inch M/S	766700	2	

PARTS LIST

System: 550M Chain

Component: 4 inch P x 8 inch LL S/S Pitch

Drawing No. 764103



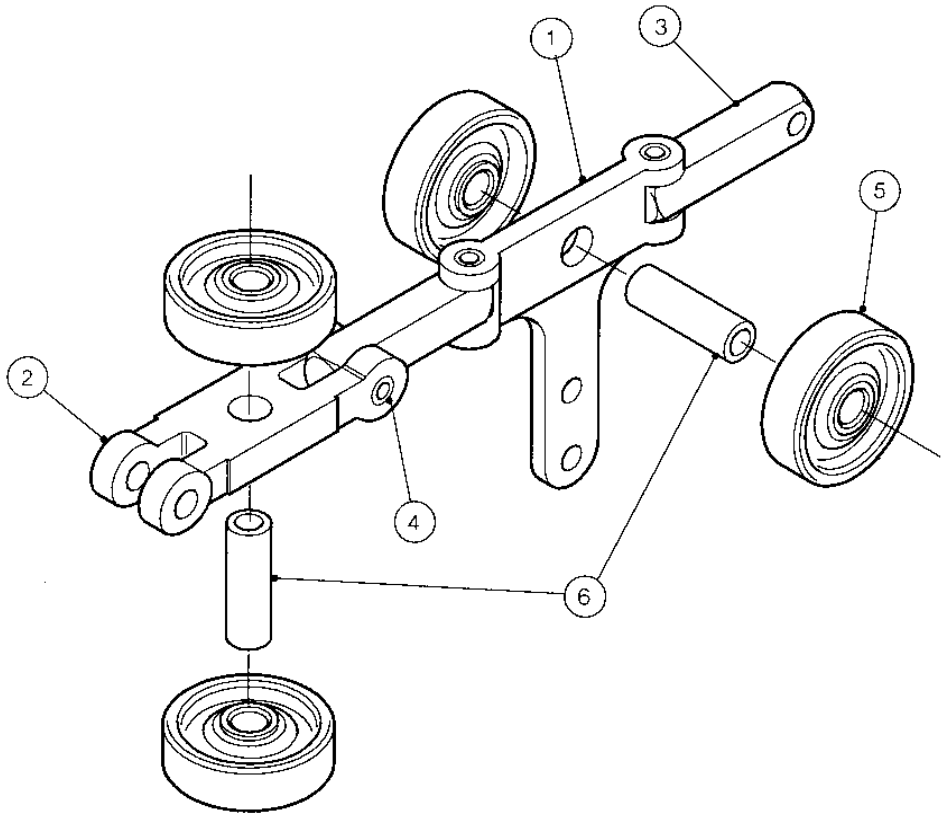
Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Plain Link Machined and Plated	765700	1	
3	550M Biplaner Block 1 inch Plated	766400	2	
4	550M Rivet Pin inch Plated	7665X1	4	
5	550M Roller R/Cage S/S CMC inch	7666X3	4	
6	550M Rivet Pin inch M/S	766700	2	

PARTS LIST

System: 550M Chain

Component: 4 inch P x 8 inch LL P/S Pitch

Drawing No. 764102



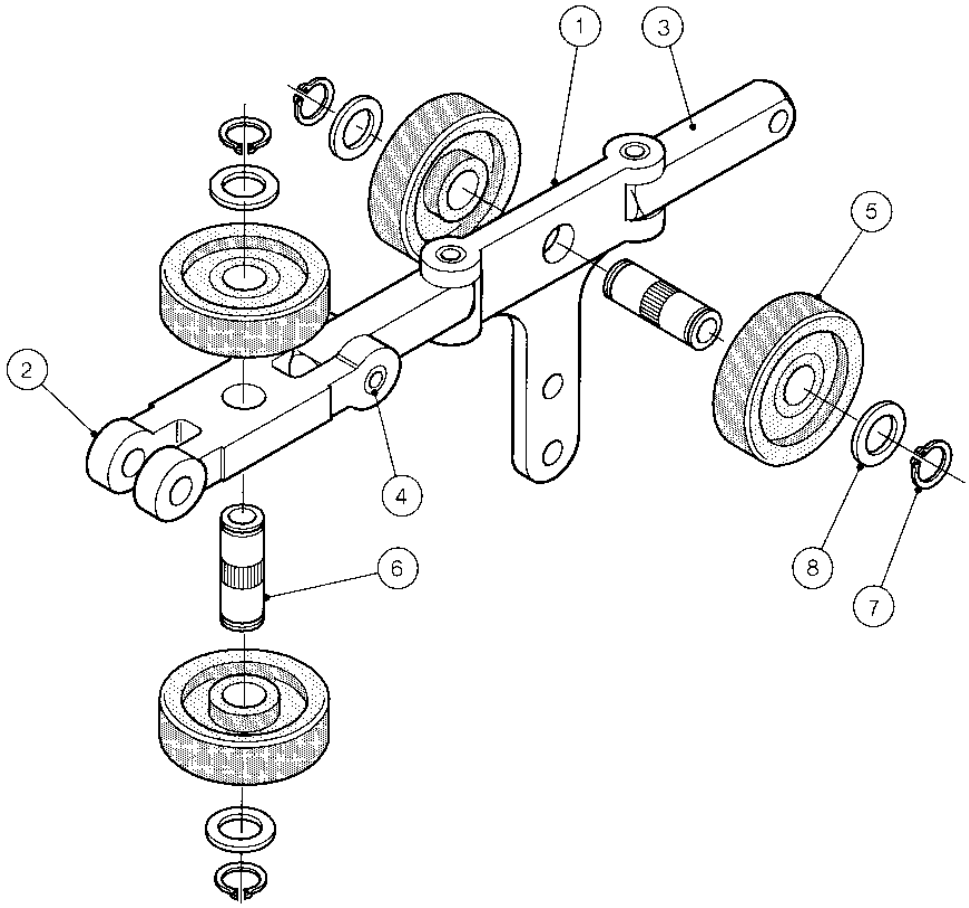
Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Plain Link Machined and Plated	765700	1	
3	550M Biplaner Block 1 inch Plated	766400	2	
4	550M Rivet Pin inch Plated	7665X1	4	
5	550M Roller P/S SG Type inch	7666X2	4	
6	550M Rivet Pin inch M/S	766700	2	

PARTS LIST

System: 550M Chain

Component: 4 inch P x 8 inch LL MDS Pitch

Drawing No. 764101



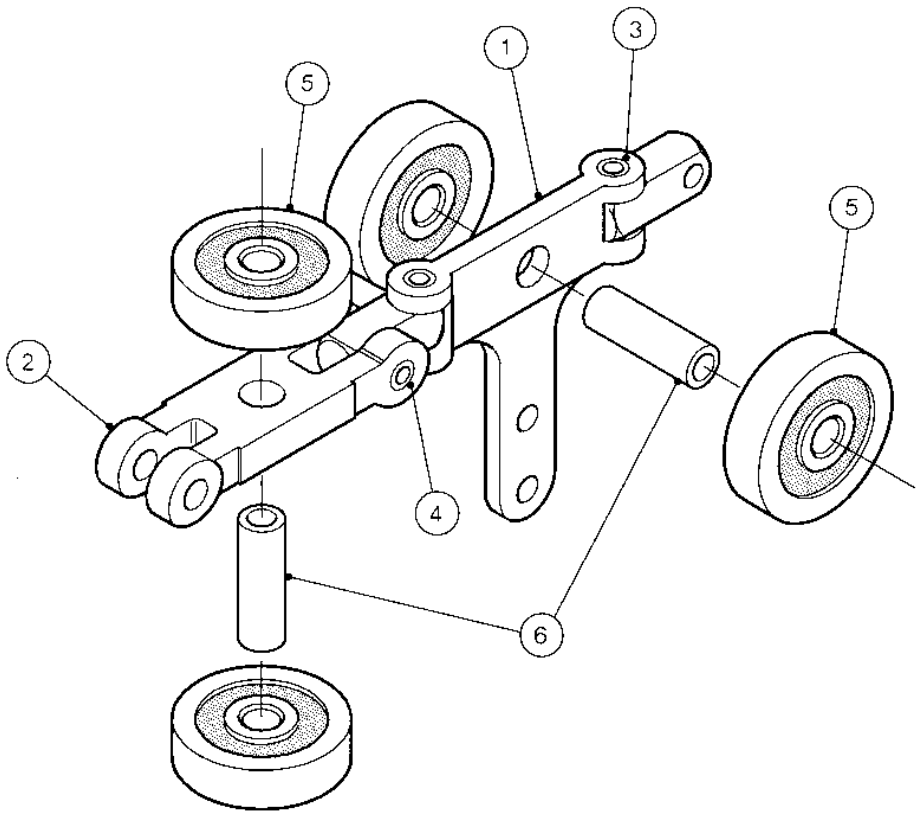
Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Plain Link Machined and Plated	765700	1	
3	550M Biplaner Block 1 inch Plated	766400	2	
4	550M Rivet Pin inch Plated	7665X1	4	
5	550M Roller Black Nylon 1 inch	7666X1	4	
6	550M Knurled Pin inch S/Steel	7667X1	2	
7	Circlip inch Type 1500 Ref. 396E	CIR15396E	4	
8	M12 Flat Washer Form B Plated	WAM12FLBP	4	

PARTS LIST

System: 550M Chain

Component: 3 inch P x 6 inch LL F/S Pitch

Drawing No. 763104



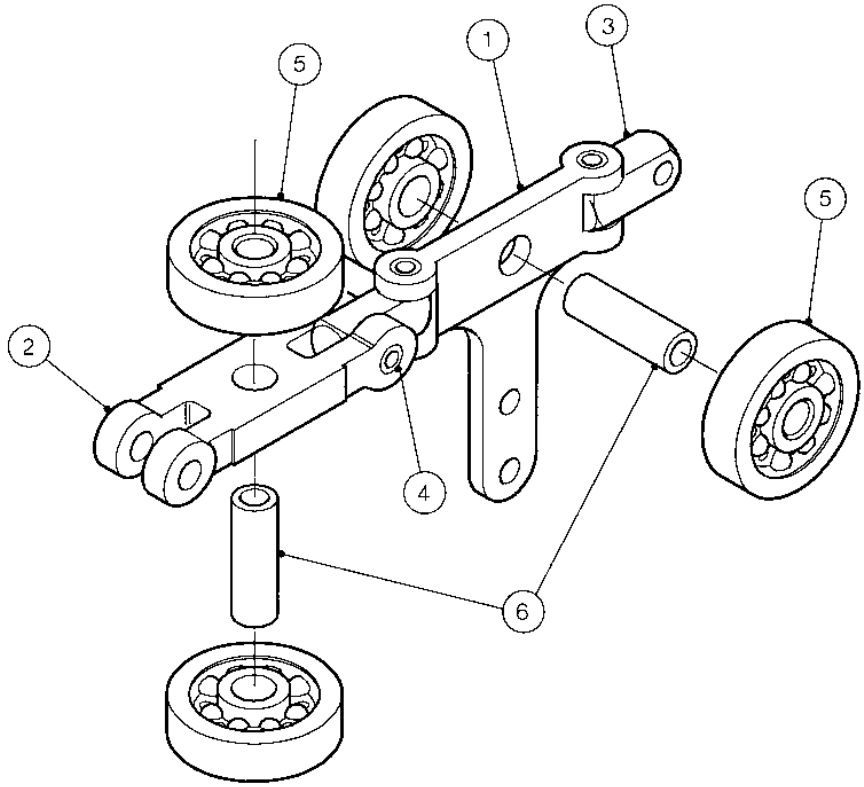
Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Plain Link Machined and Plated	765700	1	
3	550M Biplaner Block inch Plated	766300	2	
4	550M Rivet Pin inch Plated	7665X1	4	
5	550M Roller FL/Seal CMC inch	7666X4	4	
6	550M Rivet Pin inch M/S	766700	2	

PARTS LIST

System: 550M Chain

Component: 3 inch P x 6 inch LL S/S Pitch

Drawing No. 763103



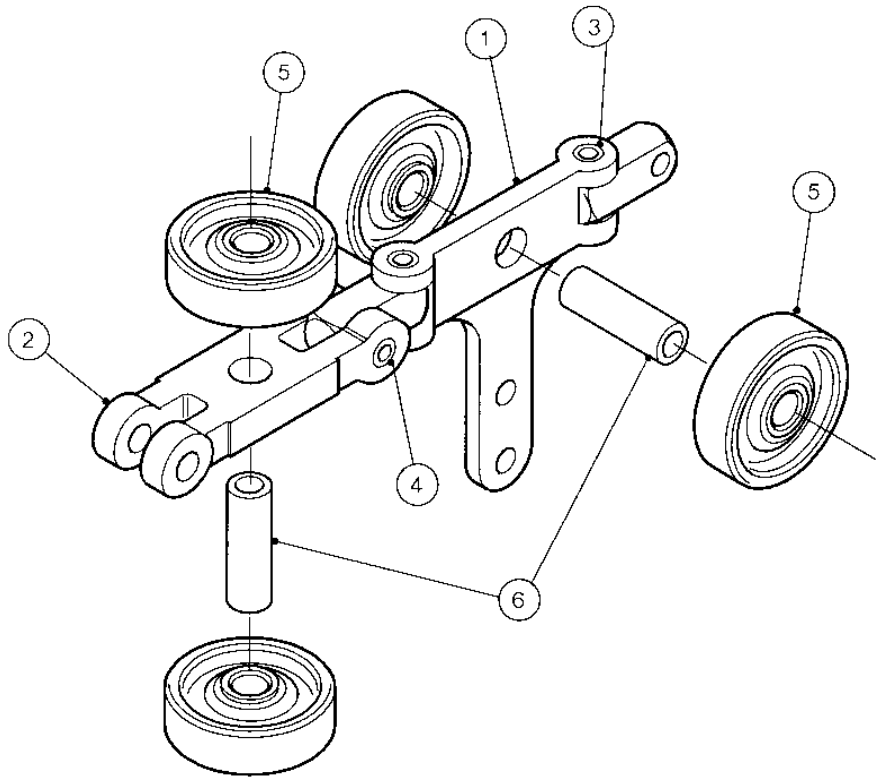
Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Plain Link Machined and Plated	765700	1	
3	550M Biplaner Block inch Plated	766300	2	
4	550M Rivet Pin inch Plated	7665X1	4	
5	550M Roller R/Cage S/S CMC inch	7666X3	4	
6	550M Rivet Pin inch M/S	766700	2	

PARTS LIST

System: 550M Chain

Component: 3 inch P x 6 inch LL P/S Pitch

Drawing No. 763102



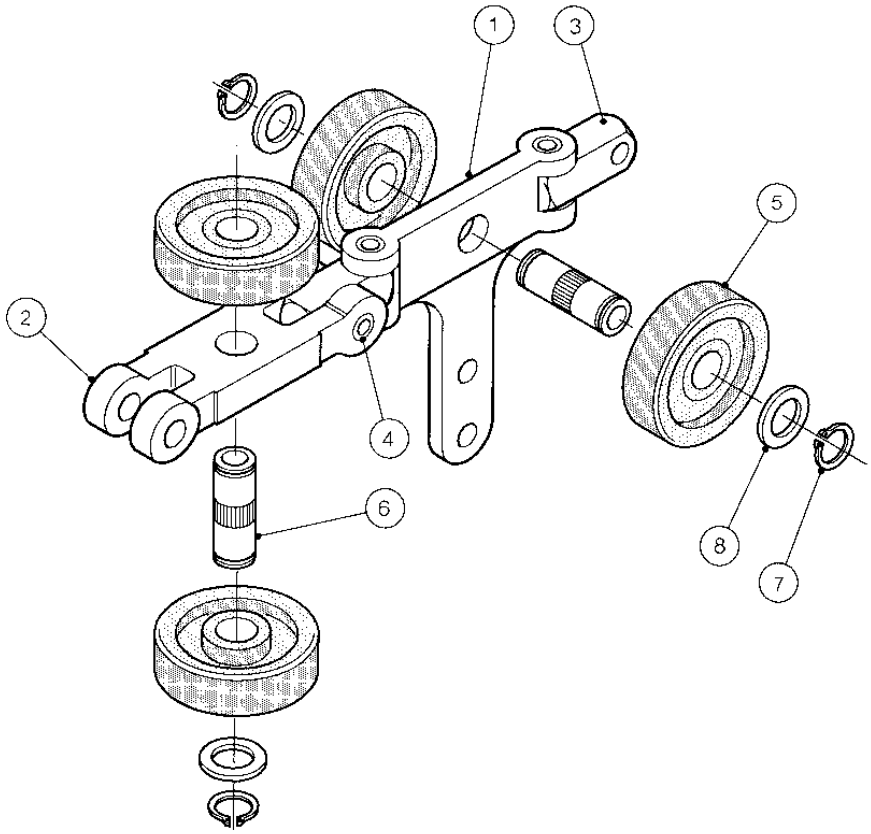
Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Plain Link Machined and Plated	765700	1	
3	550M Biplaner Block inch Plated	766300	2	
4	550M Rivet Pin inch Plated	7665X1	4	
5	550M Roller P/S SG Type inch	7666X2	4	
6	550M Rivet Pin inch M/S	766700	2	

PARTS LIST

System: 550M Chain

Component: 3 inch P x 6 inch LL MDS Pitch

Drawing No. 763101



Item No.	Description	Part No.	Qty.	Remarks
1	550M Load Link Machined and Plated	765300	1	
2	550M Plain Link Machined and Plated	765700	1	
3	550M Biplaner Block inch Plated	766300	2	
4	550M Rivet Pin inch Plated	7665X1	4	
5	550M Roller Black Nylon inch	7666X1	4	
6	550M Knurled Pin inch S/Steel	7667X1	2	
7	Circlip inch Type 1500 Ref. 396E	CIR15396E	4	
8	M12 Flat Washer Form B Plated	WAM12FLBP	4	

APPENDIX 1

Side Mounted STS Conveyor

Note : This section includes Part and Item Numbers for items specific to the STS conveyor when used in the Side Mounted Configuration. For Maintenance and Lubrication procedures, reference should be made to the relevant sections within the main manual.

PARTS LISTS

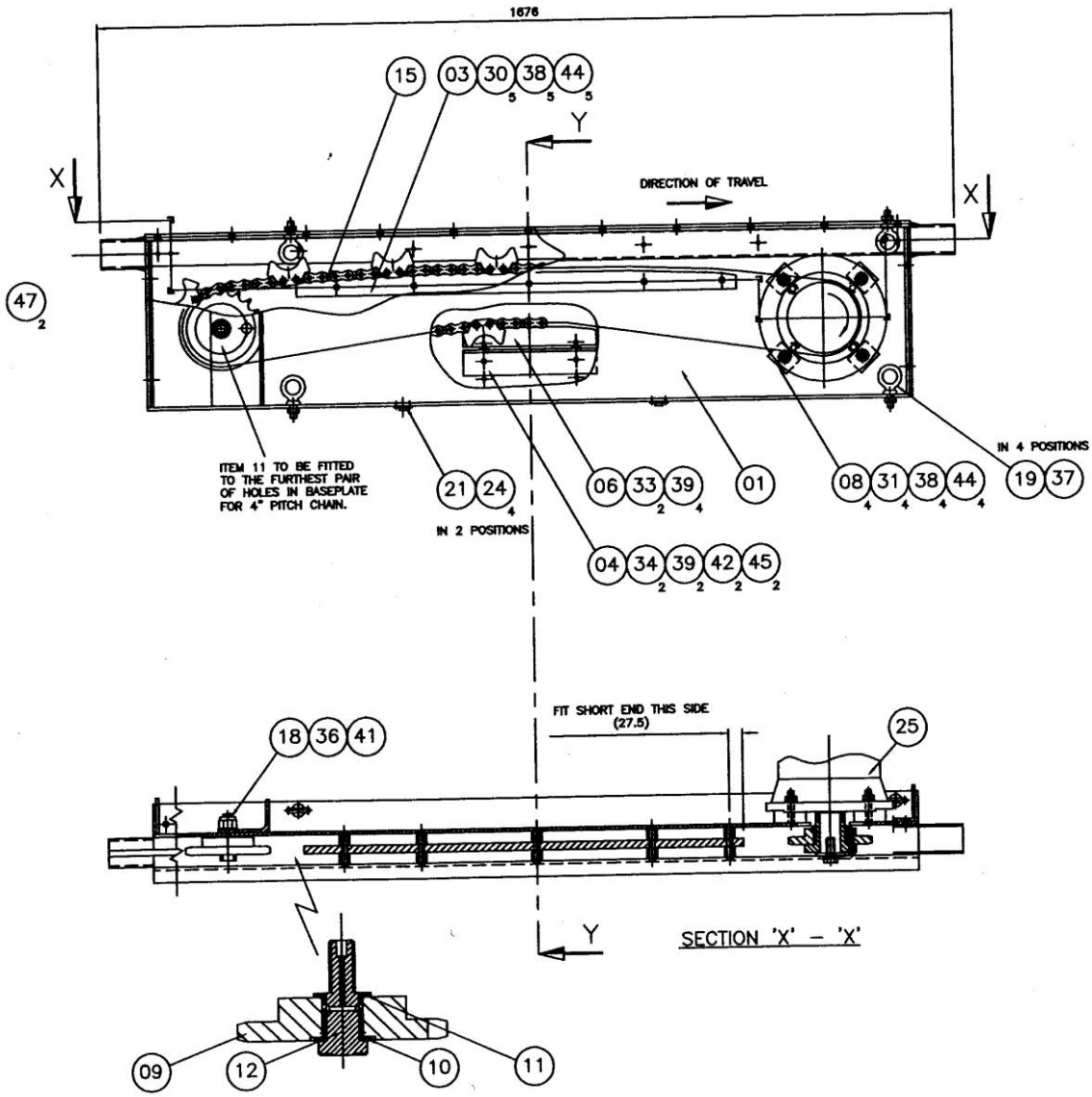
Description	Page Nº.
SIDE MOUNTED DRIVE UNIT	128
SSIDE MOUNTED TENSION UNIT - PNEUMATIC	132
SIDE MOUNTED CHAIN – SINGLE PIN TYPE	133
SIDE MOUNTED CHAIN – TWO PIN TYPE MEDIUM DUTY	134
SIDE MOUNTED CHAIN – TWO PIN TYPE HEAVY DUTY	135
SIDE MOUNTED TRACK HANGER	136
SIDE MOUNTED TRACK CONNECTOR	137

PARTS LIST

System: Medium Duty Side Mounted Conveyor

Component: Side Mounted Drive Unit

Part N°. 714204 / 714205



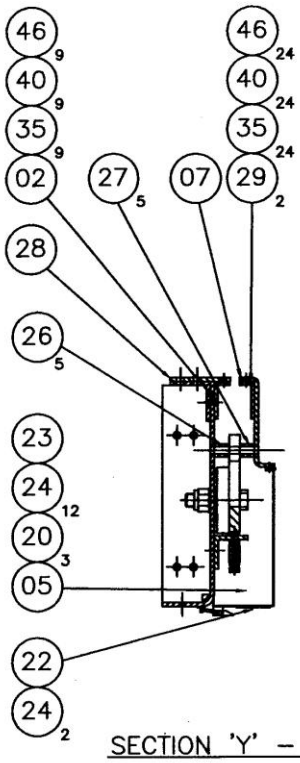
275L SIDE MOUNTED DRIVE UNIT G.A
(4" CHAIN PITCH & RF60/67 GEARBOX)

PARTS LIST

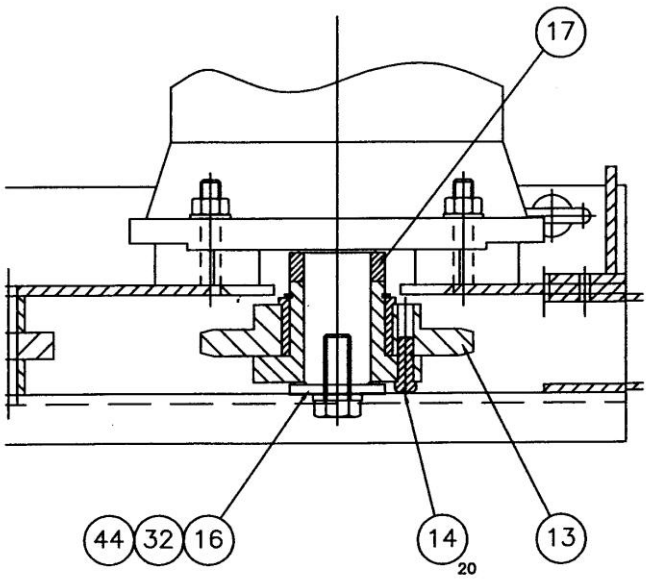
System: Medium Duty Side Mounted Conveyor

Component: Side Mounted Drive Unit

Part N°. 714204 / 714205



SECTION 'Y' – 'Y'



1 FITTED. 19 FOR SPARES (BAG UP & ATTACH TO MOTOR)

SCALE 1:2

PARTS LIST

System: Medium Duty Side Mounted Conveyor

Component: Side Mounted Drive Unit

Part N°. 714204 / 714205

Item N°.	Description	Part N°.	Qty.	Remarks
1	275L Side Base Plate	719998004	1	
2	Running Strip	719998009	1	
3	Guide Bar	7148X9	1	
4	Tension Blade Support	713100	1	
5	Drive Guard Detail	714206	1	
6	Tension Blade	7148X6	1	
7	Centre Track	719998005	1	
8	Packing Block	713300	4	
9	Idler Sprocket	7175X0	1	
10	Idler Bearing	717500	1	
11	Idler Bearing (Machined)	7175X1	1	
12	Idler Sprocket Spindle	7176X0	1	
13	Drive Parts Assembly 30mm – RF60	717003	1	
13	Drive Parts Assembly 35mm – RF67	719988003	1	
14	Shear Pin 5.5mm Groove	7148X4	20	Only 1 Fitted
15	Drive Chain 4” Pitch	716604	1	
16	Gearbox Retaining Plate	717900	1	
17	Spacer Collar	717406	1	
18	Idler Sprocket Fl/Flap Lub. BS1516	7176X1	1	
19	M12 Dynamo Lifting Eyebolts	7149X2	4	
20	Drive Guard Hinge (Piano) – 60mm Lg	7136X0	3	
21	Toggle Clip	TOGL.CLIP	2	
22	SG Standard Nameplate	1015X0	1	
23	Warning Label	LABEL3	1	
24	Pop Rivet Domed	PR3.2D9.1	22	
25	Geared Motor	-	1	
26	Drive Guide Bar Spacer 22.4mm	714807	5	
27	Drive Guide Bar Spacer 21.5mm	714906	5	

PARTS LIST

System: Medium Duty Side Mounted Conveyor

Component: Side Mounted Drive Unit
Part No. 714204 / 714205

Item Nº.	Description	Part No.	Qty.	Remarks
28	Drive Plate	719998006	1	
29	16 x 6 x 1500 Lg Polyacetal Strip	718888010	2	
30	M10 x 90 Hex. Headed Bolt Plated	HBM10090P	5	
31	M10 x 40 CSK Headed Screw	CSM10040P	4	
32	M10 x 40 Hex. Headed Screw Plated	HSM10040P	1	
33	M8 x 75 Hex. Headed Screw Plated	HSM08075P	2	
34	M8 x 25 Hex. Headed Screw Plated	HSM08025P	2	
35	M6 x 25 CSK Headed Screw	CSM06025P	2	
36	M20 Nyloc Nut	HNM20NYLP	1	
37	M12 Hex Ful Nut Plated	HNM12NUTP	4	
38	M10Hex Ful Nut Plated	HNM10NUTP	9	
39	M8Hex Ful Nut Plated	HNM08NUTP	6	
40	M6Hex Ful Nut Plated	HNM06NUTP	33	
41	M20 Flat Washer Plated	WAM12FLTP	1	
42	M8 Flat Washer Plated	WAM08FLTP	2	
44	M10 Spring Washer Plated	WAM10SPRP	10	
45	M8 Spring Washer Plated	WAM08SPRP	2	
46	M8 Spring Washer Plated	WAM06SPRP	33	
47	Track Untreated 90mm Long	7504X0	2	

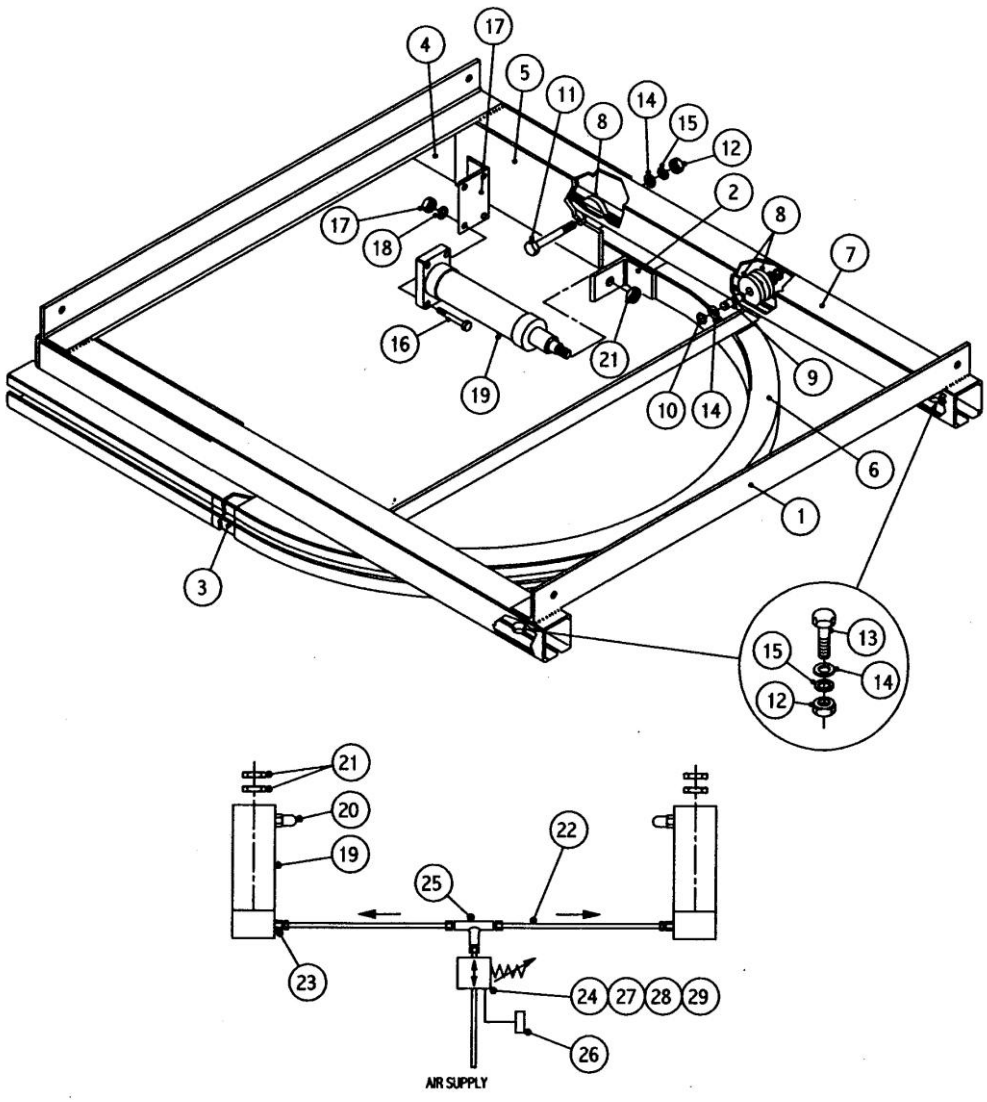
PARTS LIST

System: Medium Duty Side Mounted Conveyor

Component: Side Mount Tension Unit - Pneumatic

Part N°. 720302 – External Slot (Shown)

720303 – Internal Slot



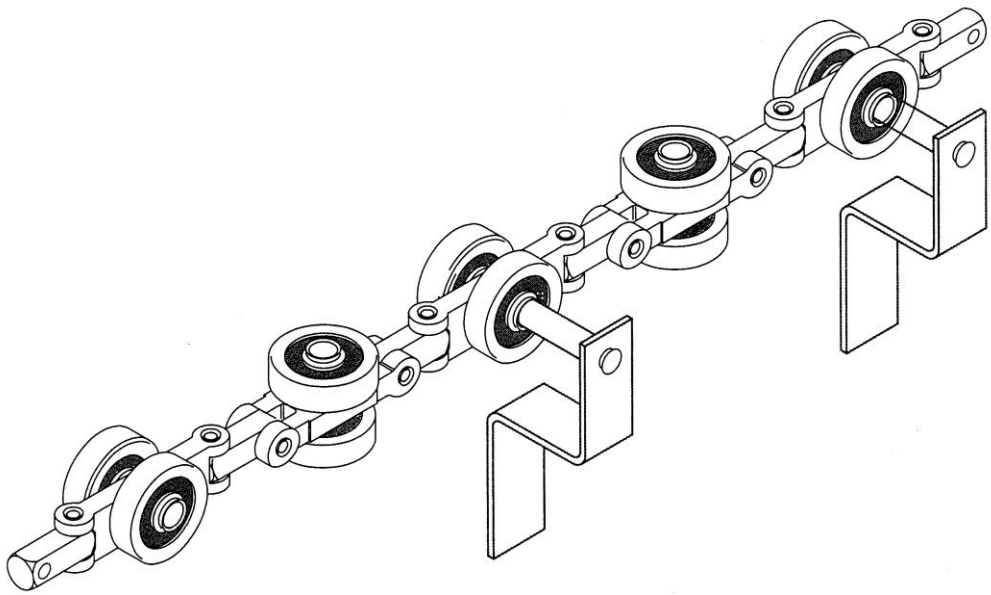
Refer to page 91 for item detail.

PARTS LIST

System: Medium Duty Side Mounted Conveyor

Component: Side Mounted Chain – Light Duty

Part N°. 769998007



Chain Fitted with Semi Shielded Rollers.

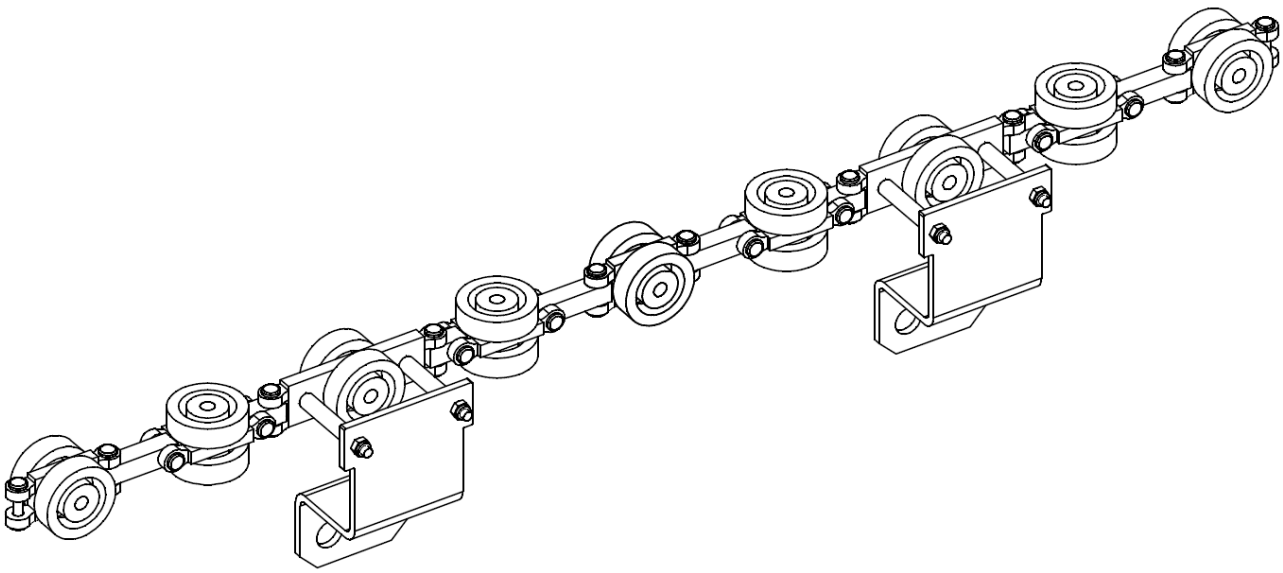
Hanger bracket assemblies fitted to chain using D1500-0070 Circlips – (Pt. N°.CIR150070A).

PARTS LIST

System: Medium Duty Side Mounted Conveyor

Component: Side Mounted Chain – Medium Duty

Part N°. 779903004



Chain Fitted with Semi Shielded Rollers.

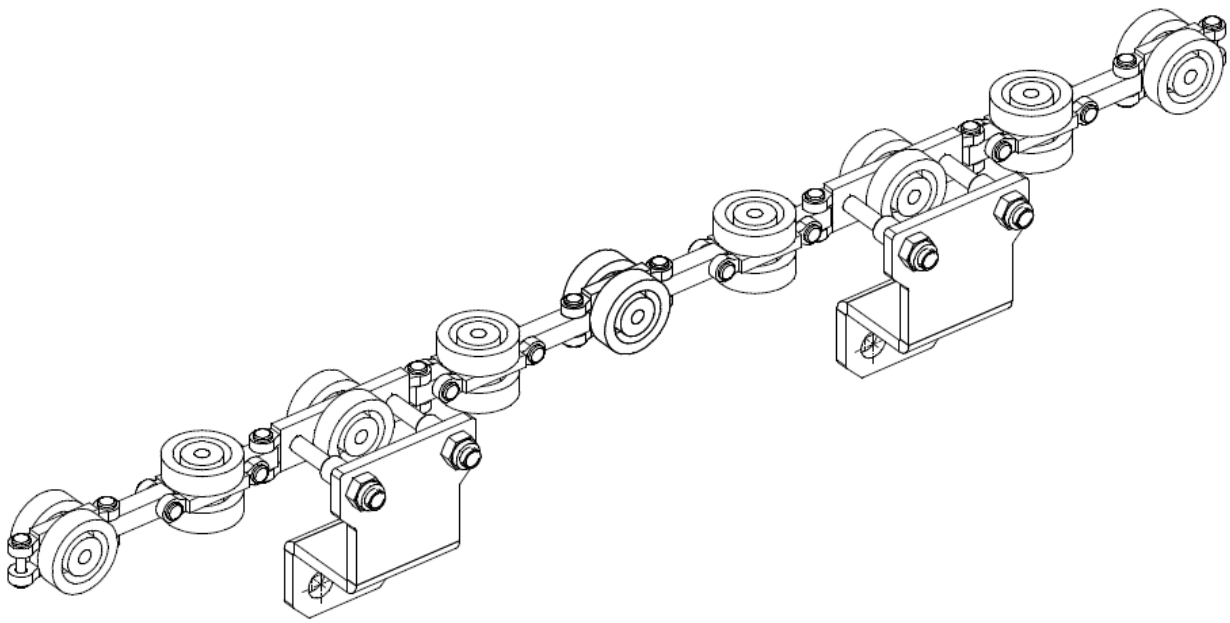
Hanger bracket assemblies fitted to chain using attachement bracket pin 1804-04A with M6 lock nuts

PARTS LIST

System: Medium Duty Side Mounted Conveyor

Component: Side Mounted Chain – Heavy Duty

Part N°. 1804-01



Chain Fitted with Semi Shielded Rollers.

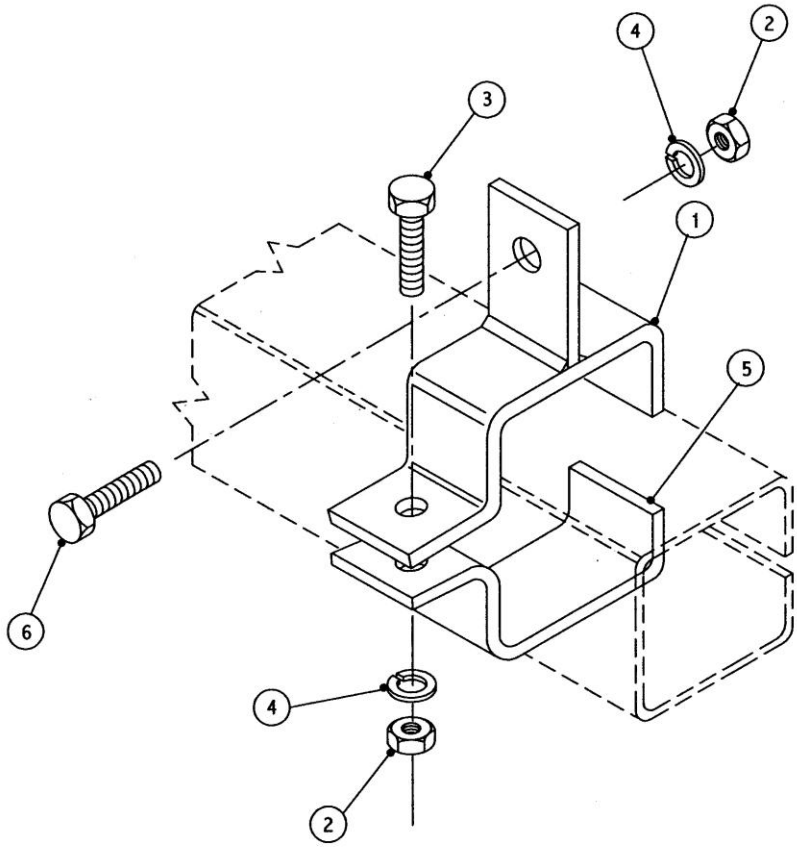
Hanger bracket assemblies fitted to chain using attachement bracket pin 1804-04A with M8 and M12 steel lock nuts.

PARTS LIST

System: Medium Duty Side Mounted Conveyor

Component: Side Mount Track Hanger Bracket Pair

Part N°. 759999018



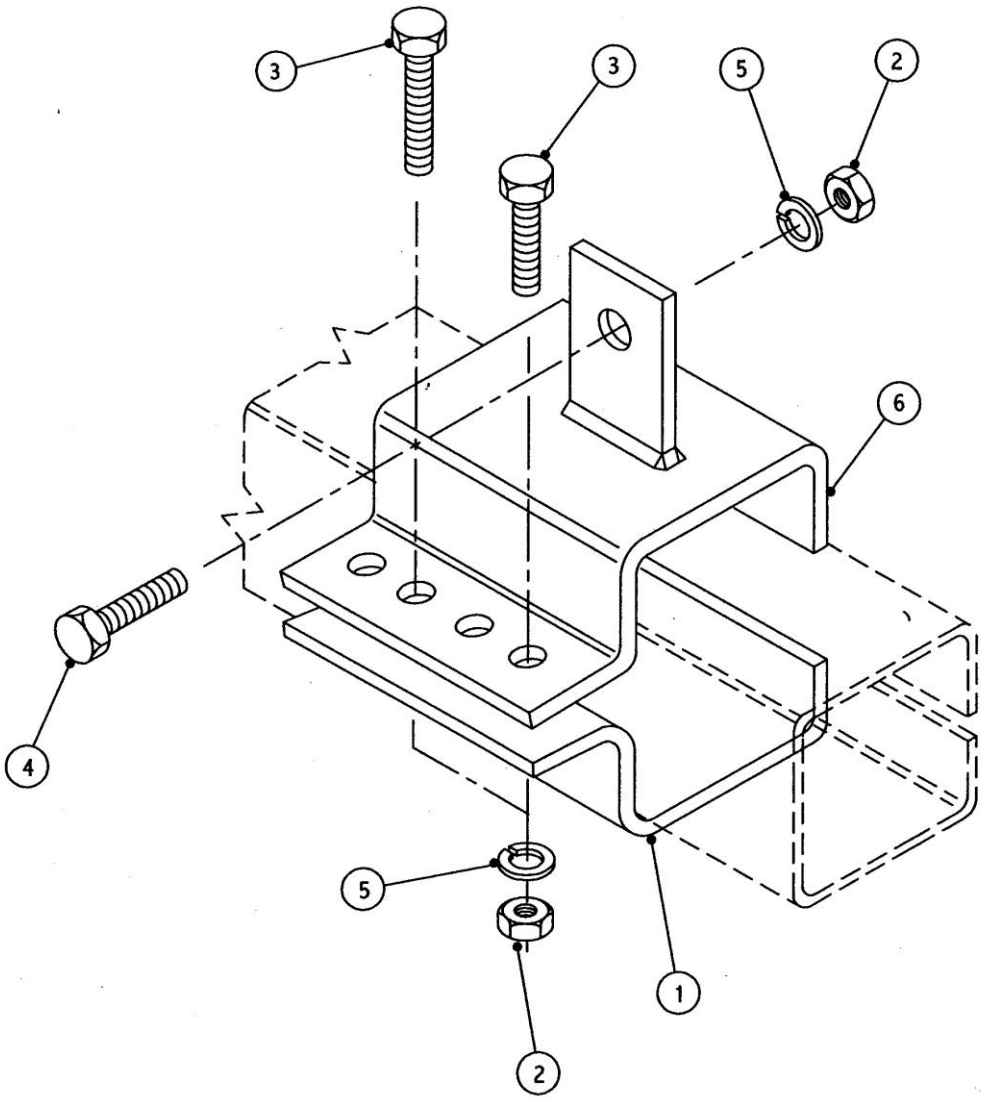
Item N°.	Description	Part N°.	Qty.	Remarks
1	Side Mount Track Hanger Bracket Single	751004	1	
2	M10 Hex. Full Nut Plated	HNM10NUTP	2	
3	M10 x 25 Hex. Headed Screw Plated	HSM10025P	1	
4	M10 Spring Washer Plated	WAM10SPRP	1	
5	Track Hanger Bracket Single	7510X1	1	
6	M10 x 30 Hex. Headed Screw Plated	HSM10030P	1	

PARTS LIST

System: Medium Duty Side Mounted Conveyor

Component: Side Mount Track Connector Pair

Part N°. 759999017



Item N°.	Description	Part N°.	Qty.	Remarks
1	Track Connector Single	7512X1	1	
2	M10 Hex. Full Nut Plated	HNM10NUTP	5	
3	M10 x 25 Hex. Headed Screw Plated	HSM10025P	4	
4	M10 x 30 Hex. Headed Screw Plated	HSM10030P	1	
5	M10 Spring Washer Plated	WAM10SPRP	4	
6	Side Mount Track Connector Single	759999016	1	

APPENDIX 2

EC Declaration of Conformity