Field Manual

Side Guides

Installation Procedures, Maintenance, and Spare Parts

PN 890899 12/03

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Read these documents thoroughly before attempting to perform maintenance or repairs to the applicable Intelligrated conveyor system components or devices. Exercise extreme caution when working around moving and rotating conveyor equipment. Wear the proper clothing and safety equipment. DO NOT attempt to perform any maintenance until the equipment is de-energized, locked out and tagged out in accordance with established company procedures.

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Section G Installation Procedures

Section I Spare Parts

SECTION G:INSTALLATION PROCEDURES

Accepting Shipment

Immediately upon delivery, check that all equipment received agrees with the bill of lading or the carrier's freight bill.

Note	Do not sign the freight bill before checking the equipment for completeness and for damage.

Lost Shipments

Report lost shipments to the Manufacturer's Shipping Department.

Shortages or Errors

Before signing the freight bill, note any shortages or errors clearly on the freight bill. Report any shortages or errors to the Manufacturer's Customer Service Department in writing within ten (10) days after receipt of shipment.

Damaged Shipments

If shipping damage is evident upon receipt of the shipment, proceed as follows:

- Before signing the freight bill, note the extent of the damage clearly on the freight bill.
- Immediately contact the transportation carrier to request an inspection.
- Do not destroy the crating or packing materials until the carrier's agent has inspected them.
- If possible, take photographs of the damage in order to document negligence on the part of the carrier.

Returns

Unless authorized in writing by the Manufacturer, equipment furnished in accordance with the Manufacturer's Agreement is not returnable for any reason. Please note that a restocking charge may apply. When requesting a return authorization, be sure to include the following information:

- Job number
- Customer name
- Contact person's name
- Phone number of contact person
- Part number, select number and description for each item to be returned
- Quantity
- Reason for return
- Condition of material
- Color of material

After receiving the information, the Manufacturer will determine which items may be returned. If a request to return is approved, the Manufacturer's Customer Service Department will issue to the Purchaser (End User) a Return Goods Authorization (RGA) number. Be sure to mark the RGA number clearly and prominently on all packages returned. The Purchaser (End User) shall be liable for all freight charges.

Codes and Standards

The conveyor equipment is designed and manufactured to comply with the American National Standard Institute's "SAFETY STANDARDS FOR CONVEYORS AND RELATED EQUIPMENT" (ANSI/ASME B20.1) and with the National Electrical Code (ANSI/NFPA70).

The Purchaser (End User) shall be familiar with, and responsible for, compliance with all codes and regulations having jurisdiction regarding the installation, use, and maintenance of this equipment. Appropriate lock-out/tagout policy and procedures shall comply with the minimum safety requirements outlined in the American National Standard Institute's current publication (ANSI Z244.1).

Warning Signs

Warning signs and labels posted on or near the conveyor equipment shall not be removed, painted over, or altered at any time. All safety devices, warning lights, and alarms associated with the conveyor system should be regularly tested for proper operation and serviced as needed. If the original safety item(s) become defective or damaged, refer to the conveyor parts list(s) of bill(s)-of-materials for replacement part numbers.

Safety Features

- DO turn off conveyor power source(s) and affix appropriate lockout/tagout device(s) to operating controls before servicing the equipment. ONLY trained and qualified personnel who are aware of the safety hazards should perform equipment adjustments or required maintenance while the conveyor is in operation.
- DO observe all warning signs, lights, and alarms associated with the conveyor operation and maintenance, and be alert at all times to automatic operation(s) of adjacent equipment.
- DO use extreme caution near moving conveyor parts to avoid the hazard of hands, hair, and clothing being caught.
- DO NOT sit on, stand on, walk, ride, or cross (over or under) the conveyor at any time except where suitable catwalks, gates, or bridges are provided for personnel travel.
- DO NOT attempt to repair any equipment while the conveyor is running, replace any conveyor component without appropriate replacement parts, or modify the conveyor system without prior approval by the manufacturer.
- DO NOT operate the conveyor until all safety guards are securely in place, all tools and non-product materials are removed from or near the conveying surfaces, and all personnel are in safe positions.
- DO NOT remove or modify any safety devices provided on or with the conveyor.
- DO NOT clear jams or reach into any unit before first turning off the equipment power source(s) and affixing appropriate lockout/tagout device(s).

Parts Replacement

To minimize production downtime, selected conveyor spare parts should be stocked for replacement of defective components when required. Refer to the equipment bill(s)-of-materials where quantity requirements or code numbers are not indicated on the conveyor parts list. For added convenience, a list of selected spare parts for standard products is included in this manual (see Section I).

Factory Assistance

Contact Field Service for installation, operation, or maintenance assistance, or Customer One Protection (COP) for replacement parts.

Pre-Installation Set-up

For installation of the conveyor, *refer to the specific manual for each conveyor.* This manual discusses installation of side guides *only*.

Field Kits and Mounting Fasteners

The side guides may seem to require a large number of bolts because there are many holes where bolts would fit. However, most of those holes do not require bolts.

The field kit for each side guide contains the appropriate number of mounting fasteners. When you are sorting parts, refer to the Order Acknowledgement, which lists and describes the items (ship-level parts) included in the order for each conveyor. The Order Acknowledgement will direct you to the Field Kit Summary (FKS) when needed. The Field Kit Summary describes the necessary field kit, and lists the number of bolts, washers, etc., in each field kit.

Order Acknowledgement Manual

You may also wish to refer to our Order Acknowledgement Manual, which shows how to use the Order Acknowledgement, the Field Kit Summary, and the Shipping List Summary, along with the layout drawings and shipping labels, to help with the unloading and identification of parts for installation. The manual also includes a Guide to abbreviations used on the various documents, safety label information, and a brochure with a form for ordering new safety labels as needed.

Please note that for conveyor installation, you will need the specific conveyor product manual as well as the Order Acknowledgement, the Field Kit Summary, the Shipping List Summary, and layout drawings, in addition to the Order Acknowledgement Manual and this Side Guide Manual.

Introduction

Side guides are classified according to how they are mounted, as follows:

- Fixed side guides
- Adjustable side guides

Note	Always refer to the Order Acknowledgement and the Field Kit Summary for specific information about which hardware is to be used to mount a particular part. See the Order Acknowledgement Manual for more information.

Fixed Side Guides

Four types of fixed side guides (see Figure G - 1 and Figure G - 2) are available, as follows:

- 1 3/4” Angle Guide (Type A) - 1 3/4" high angle
- 2 5/8” Channel Guide (Type B) - 2 5/8" high channel
- 7” Channel Guide (Type C) - 7" high channel
- 10” Channel Guide (Type D) - 10" high channel

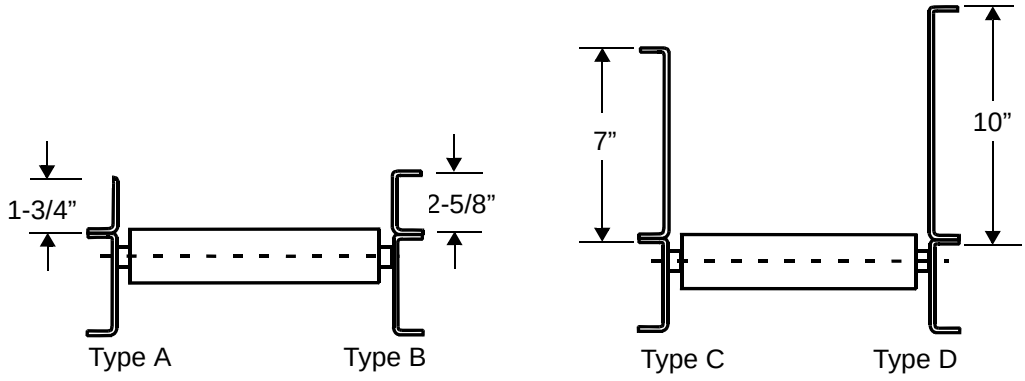


Figure G - 1 Types of Fixed Side Guides, shown attached to conveyors

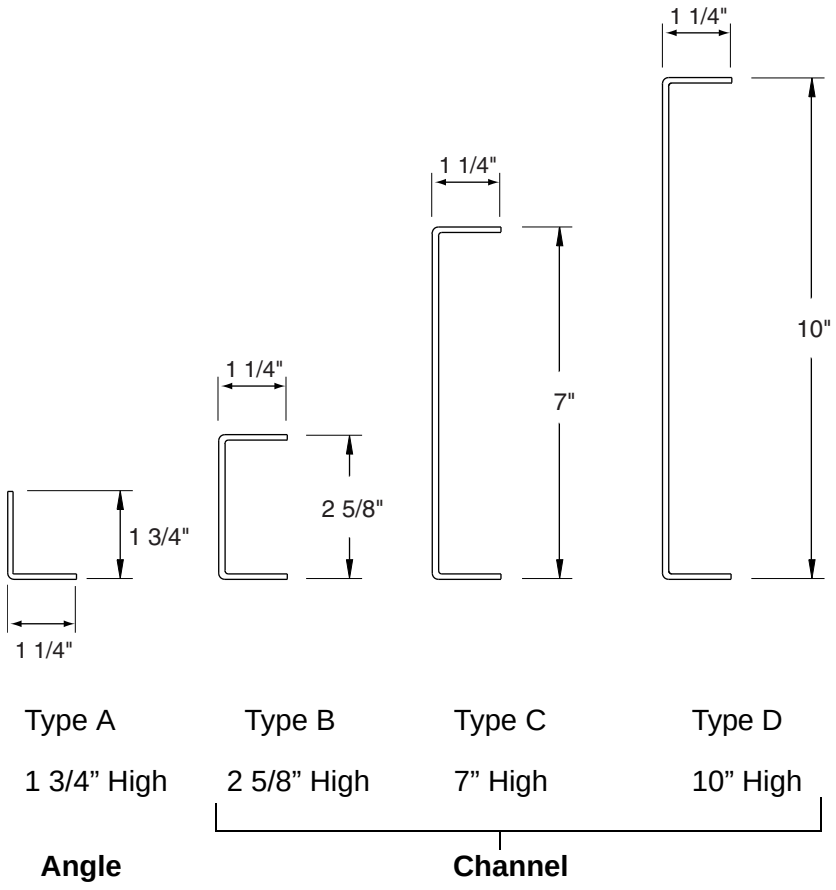


Figure G - 2 Types of Side Guides

Mounting Styles

Fixed side guides are mounted three ways:

- Direct mounting (Style A) - Side guide bolted directly to top flange of frame rail.
- Spaced mounting (Style B) - Hex spacer provides 11/16” gap between side guide and frame rail.
- Offset mounting (Style C) - Bracket provides 2” inset or outset of side guide.

With direct and spaced mounting side guides are located directly above the conveyor (see Figure G - 3). The side guide rail is flush with the inside of the conveyor side rail.

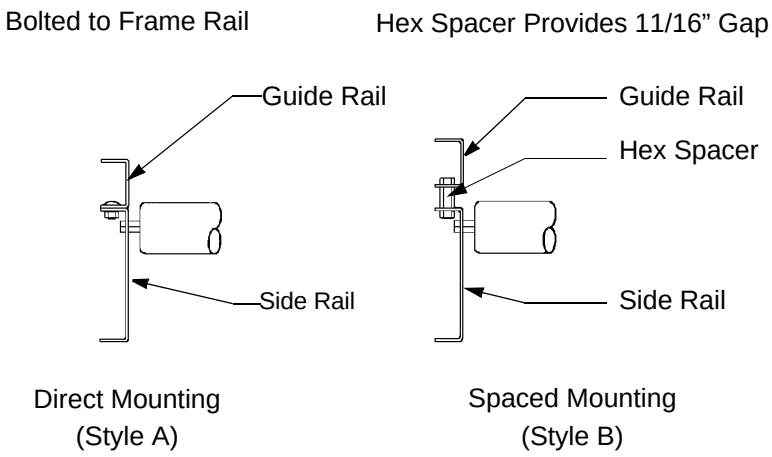


Figure G - 3 Direct Mounting and Spaced Mounting (2 5/8” channel guide shown)

With offset mounting, side guides are mounted to 3-inch brackets, which are mounted to the conveyor side rails. Offset mounting may be either set-in or set-out (see Figure G - 4).

- Set-in mounting positions the side guide 2 inches closer to the conveyor centerline than the side rail.
- Set-out mounting positions the side guide 2 inches farther from the conveyor centerline than the side rail.

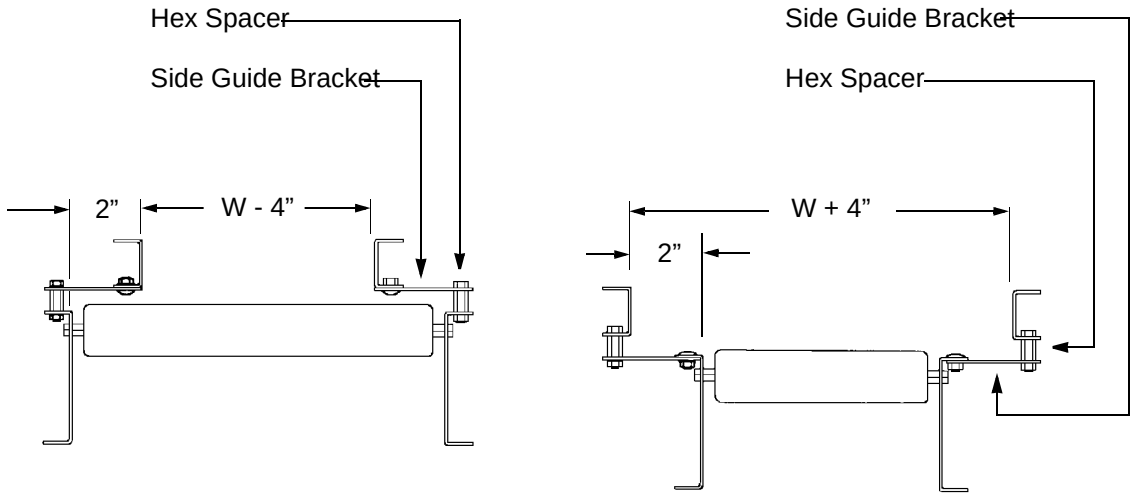


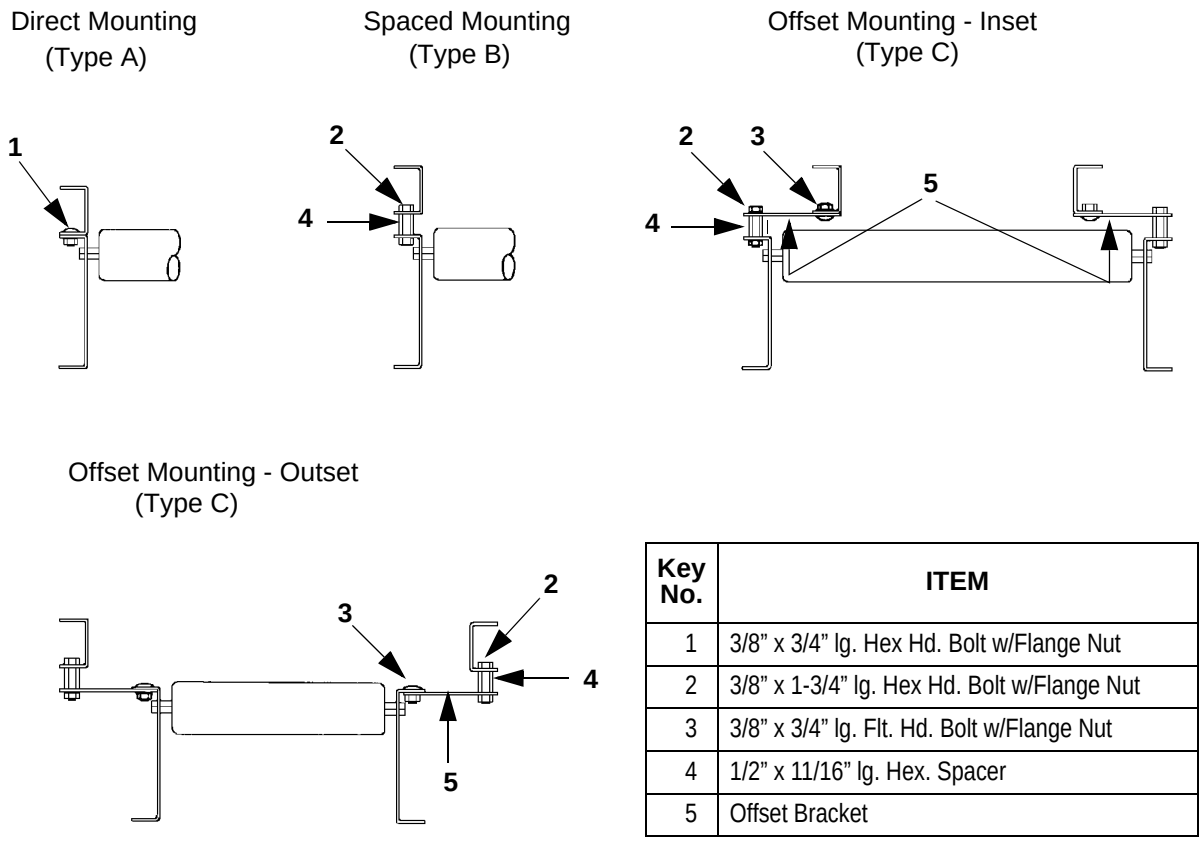
Figure G - 4 Offset Mounting (Style C), Set-in and Set-out (2 5/8” channel guide, shown)

Delivery Packaging

Straight fixed side guides (12’ - 0” lengths) and curved side guides (30°, 45°, 60°, and 90° arcs) are shipped in strapped bundles. Mounting components and fasteners are packed in hardware cartons. See Accepting Shipment, page 2.

Identifying Components and Fasteners

The fastener requirements for each 12’ side guide length (straight) are identified in Figure G - 5.



Key No.	ITEM
1	3/8” x 3/4” lg. Hex Hd. Bolt w/Flange Nut
2	3/8” x 1-3/4” lg. Hex Hd. Bolt w/Flange Nut
3	3/8” x 3/4” lg. Flt. Hd. Bolt w/Flange Nut
4	1/2” x 11/16” lg. Hex. Spacer
5	Offset Bracket

Figure G - 5 Fixed Side Guide Mounting Types, Identifying Fasteners

Installation Instructions (Generic)

To install fixed side guides:

1. Locate and place side guides.
2. Bolt side guides to top flanges of conveyor rail (see Figure G - 6).
3. Follow the Splice/Connection directions (next topic).

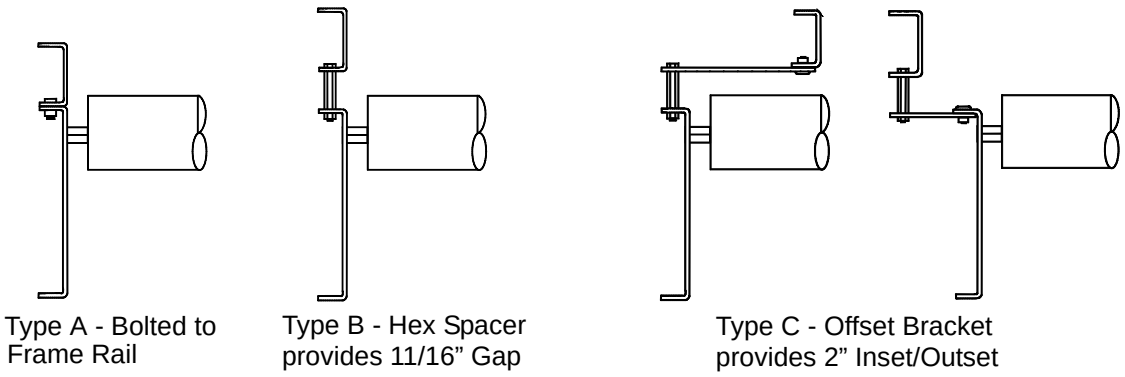


Figure G - 6 Types of Mountings

Splice/Connection

1. Overlap extension tabs of two adjoining side guides. Note that when two side guide rails are coupled, the tab of the side guide that comes first (in order of product travel) must overlap the other guide on the *inside* (belt or roller side). This allows the product to move smoothly past the overlap, not catching on the overlapping rail. See Figure G - 7.
2. For channel side guides, bolt together adjoining top flanges of the side guides. See Figure G - 7

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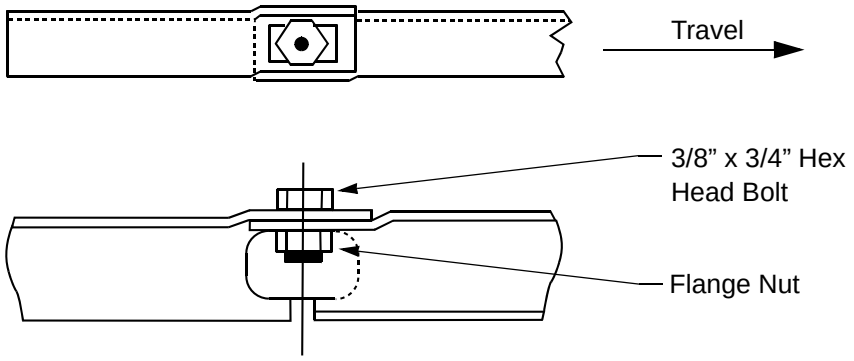


Figure G - 7 Adjoining Top Flanges Bolted Together

3. Bolt strap-coupling to the top flanges of the side guides when: a) side guide rails have been cut to fit; or b) side guides are curved rails.

   Sometimes the channels on the conveyor body require strap coupling; in that case, the same straps can be used for the body and the side guides. Position the straps at the bottom flange of the side guides, strapping both the conveyor body channels and the side guides.

Curves (including S-Curves)

Curved side guides are formed to a radius that matches the curved frame. It is necessary to "field-adjust" the radii of side guides that require offset mounting.

S-Curves

Straight side guides must be cut and spliced to two 90° curved side guides.

Junctions (Spurs)

Field cutting and fitting together of the straight and curved side guides is required.

Mounting Kits

Three side-guide mounting kits are available, as follows (see Table G 1):

- Style A – For direct mounting,
- Style B – For spaced mounting, and
- Style C – For offset mounting

Note: With certain side guides, the mounting kit is included. With others, the mounting kit must be ordered separately. Section J shows which side guides include mounting kits and which do not.

Table G 1: Side Guide Mounting Kits

Item	Mounting Kits & Part Numbers		
	Direct Mounting (Style A)	**Spaced Mounting (Style B)**	**Offset Mounting (Style C)**
	633990	**633991**	**633992**
Hex head bolt, 3/8-16 x 3/4	5	3	3
Flanged hex nut, 3/8-16	5	7	11
Flat washer, zinc plated, 3/8 USS	5	7	11
Hex head bolt, 3/8-16 x 1 1/2		4	4
Hex nut, 1/2-20 NF 11/16		4	4
Mounting Flat, 1 x 1/8 x 4 SCC		1	1
Carriage bolt, special, 3/8 x 11/16			4
Side guide bracket			4

Direct Mounting (Style A) Kit

The direct mounting kit (Style A, part number 633990) provides the hardware needed to mount one side guide. At each location use:

- One 3/8-16 x 3/4” hex head bolt
- One 3/8-16 flanged hex nut
- One 3/8” flat washer, USS zinc

To couple a side guide to an adjoining guide at the top flange (channel side guides and height transition side guides) use:

- One 3/8-16 x 3/4” hex head bolt
- One 3/8-16 flanged hex nut
- One 3/8” flat washer, USS zinc
- One flat, 1” x 1/8” x 4” (only when there is no overlapping tab)

For wheelface side guides, at each of the two mounting locations, use:

- One 3/8-16 x 1” hex head bolt
- One 3/8-16 flanged hex nut
- Three 3/8” flat washers; one washer is used to help secure the bolt (between the side guide flange and the bolt); two washers (totalling 1/4”) are used as spacers between the side guide bottom flange and the conveyor

Spaced Mounting (Style B) Kit

The spaced mounting kit (Style B, part number 633991) provides the hardware needed to mount one side guide. At each location use:

- One 3/8-16 x 1 1/2” hex head bolt
- One 11/16” hex spacer
- One 3/8-16 flanged hex nut
- One 3/8” flat washer, USS zinc
- One flat, 1” x 1/8” x 4” (height transition guides only)

To couple a side guide to an adjoining guide at the top flange (channel side guides and transition side guides) use:

- One 3/8-16 x 3/4” hex head bolt
- One 3/8-16 flanged hex nut
- One 3/8” flat washer, USS zinc
- One flat, 1” x 1/8” x 4” (only when there is no overlapping tab)

For wheelface side guides, at each of the two mounting locations, use:

- One 3/8-6 x 1 1/2” hex head bolt
- One 3/8-16 flanged hex nut
- One 1/2-20 x 11/16” hex spacer; this spacer is used between the side guide bottom flange and the conveyor
- One 3/8” flat washer

Offset (Style C) Mounting Kit

In offset mounting (see Figure G - 11 and Figure G - 12), the side guide is bolted to the bracket, and the bracket is bolted to the conveyor body. A hex nut is used as a spacer. When the guide is set in, the hex spacer is used between the bracket and the conveyor side rail; when the guide is set out, the hex spacer is used between the bracket and the side guide.

The offset mounting kit (Style C, part number 633992) provides the hardware needed to mount one side guide, either set in or set out.

In each mounting location, the items below are used to attach the bracket to the conveyor.

- One 1/2-20 x 11/16” hex spacer *(this spacer is used in this location only when the guide is **set in**; it is used where the bracket attaches to the guide when the guide is set out).*
- One 3/8-16 x 1 1/2” hex head bolt
- One 3/8-16 flanged hex nut
- One 3/8” flat washer, USS zinc

The bracket used in each of the mounting locations:

- One 3” side guide bracket

In each of the mounting locations, the items below are used to attach the bracket to the guide:

- One 1/2-20 x 11/16” hex spacer *(this spacer is used in this location only when the guide is **set out**; it is used where the bracket attaches to the conveyor body when the guide is set in).*
- One 3/8-16 x 11/16” special carriage bolt
- One 3/8-16 flanged hex nut
- One 3/8” flat washer

To couple the side guide with the adjoining guide at the bottom, use:

- One 1” x 1/8” x 4” flat, SCC
- Two 3/8-16 x 3/4” hex head bolts (one bolt for each end of flat)
- Two 3/8-16 flanged hex nuts
- Two 3/8” flat washers

To couple a side guide to an adjoining guide at the top flange (channel side guides) use:

- One 3/8-16 x 3/4” hex head bolt
- One 3/8-16 flanged hex nut
- One 3/8” flat washer, USS zinc
- One 1” x 1/8” x 4” flat (only when there is no overlapping tab)

Straight Angle Guides - (1 3/4")

Figure G - 8 shows the 1 3/4” angle side guide. (The 1 3/4” angle side guide is always plain-faced.)

Straight angle side guides are attached to the conveyor body at four places and are coupled to the adjoining side guide at the bottom of the guide.

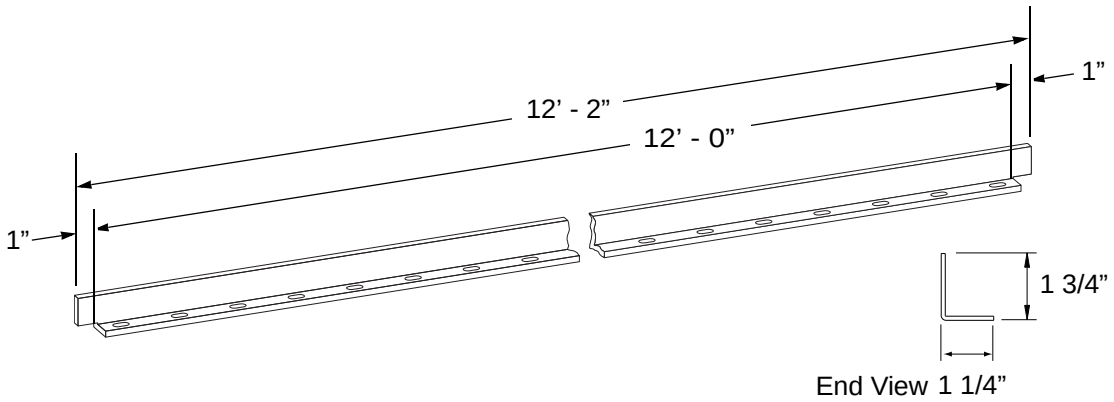


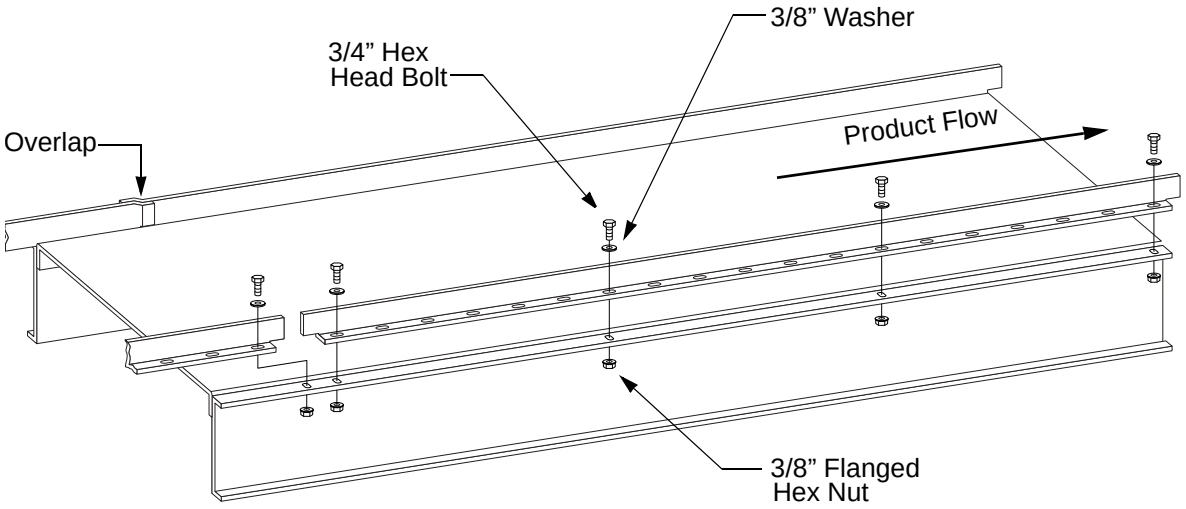
Figure G - 8 1 3/4” Angle Side Guide

Direct Mounting

The direct mounting kit (Style A, part number 633990) provides all the hardware needed to mount one plain 12’ straight 1 3/4” angle side guide.

- Bolt the side guide to the frame in four locations (see Figure G - 9).

CAUTION: Make certain that each section of side guide overlaps the adjoining downstream section on the inside (toward the center of the conveyor). Otherwise product may catch and become damaged or disoriented.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

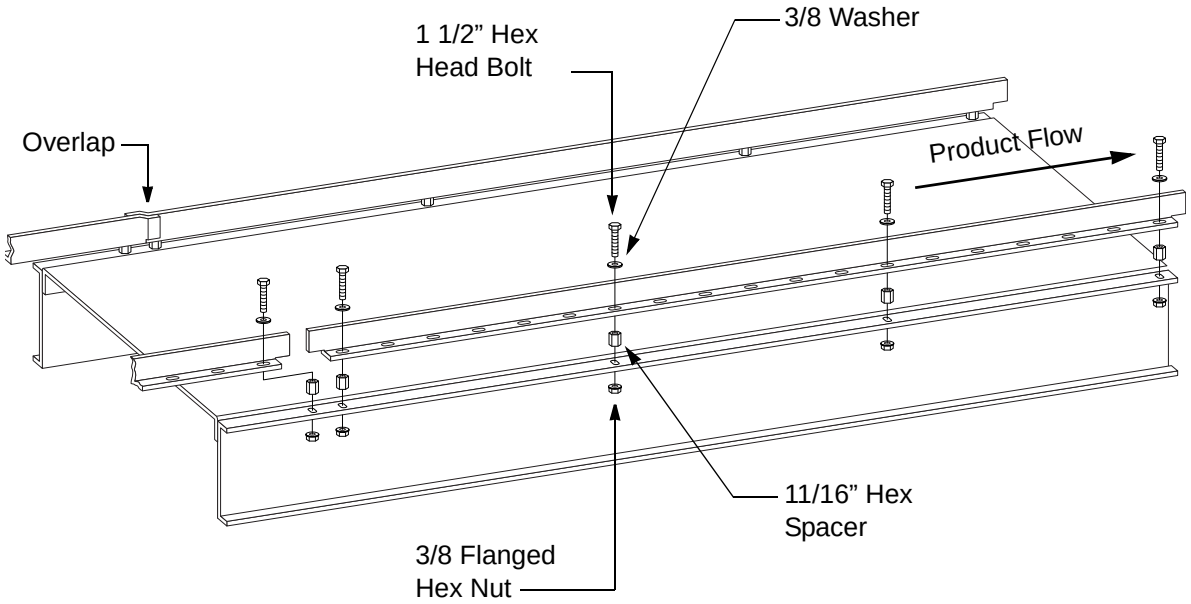
Figure G - 9 1 3/4” Angle Side Guide, Direct Mounting

Spaced Mounting

The spaced mounting kit (Style B, part number 633991) provides all the hardware needed to mount one plain 12’ straight 1 3/4” angle side guide.

- Bolt the side guide to the frame, with a spacer, in four locations (see Figure G - 10).

CAUTION: Make certain that each section of side guide overlaps the adjoining downstream section on the inside (toward the center of the conveyor). Otherwise product may catch and become damaged or disoriented.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

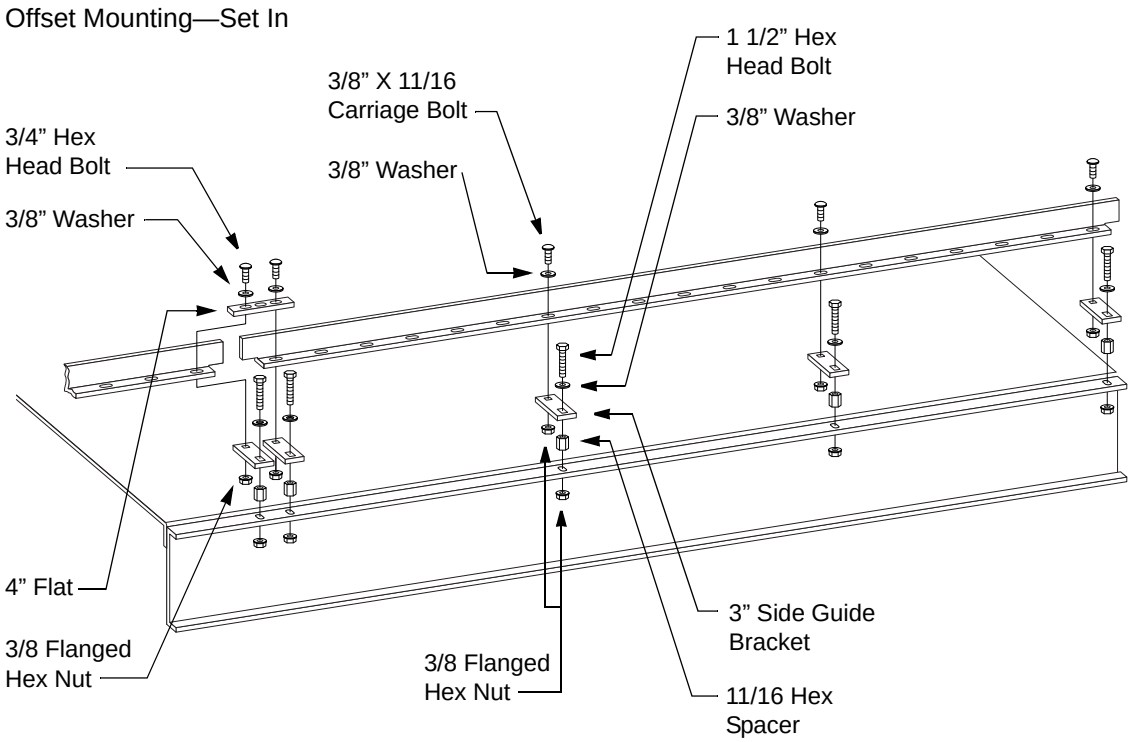
Figure G - 10 1 3/4” Angle Side Guide, Spaced Mounting

Offset Mounting

In offset mounting (see Figure G - 11 and Figure G - 12), the side guide is bolted to the bracket, and the bracket is bolted to the body. A hex nut is used for a spacer. When the guide is set in, the spacer is used where it attaches to the body; when the guide is set out, the spacer is used where the bracket attaches to the side guide.

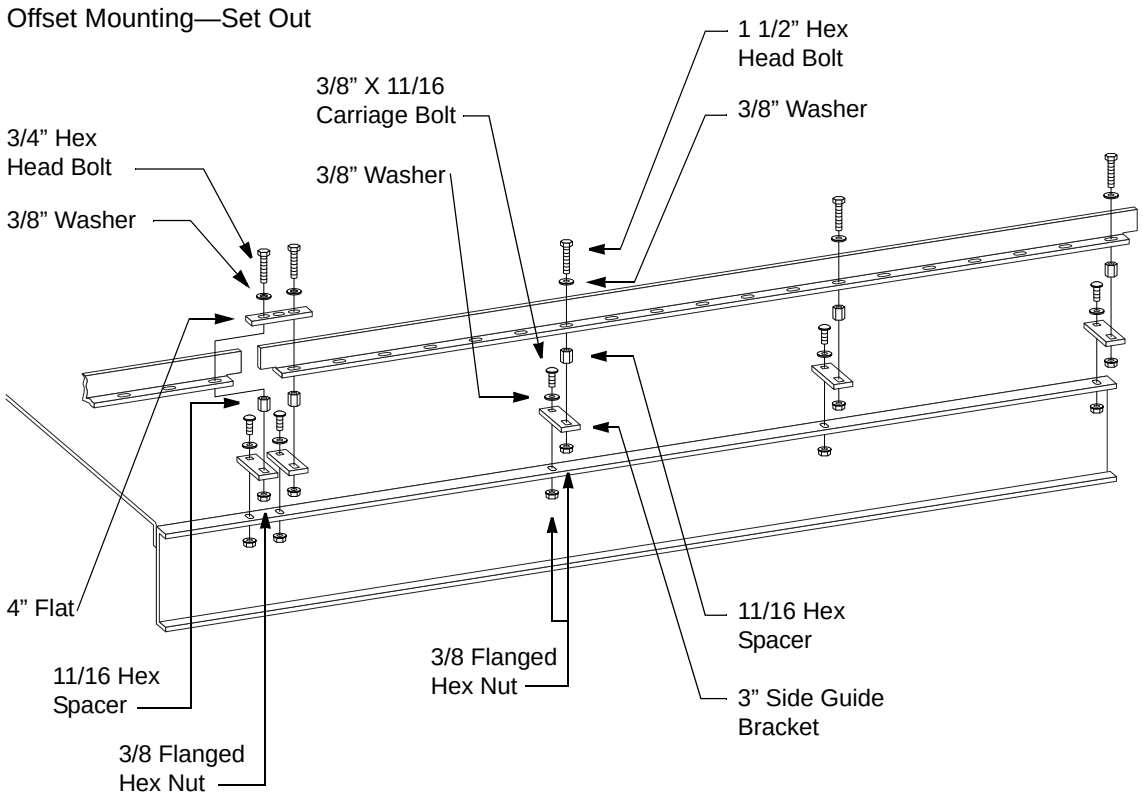
The offset mounting kit (Type C, part number 633992) provides all the hardware needed to mount one plain 12’ straight 1 3/4” angle side guide, either set in or set out.

CAUTION: Make certain that each section of side guide overlaps the adjoining downstream section on the inside (toward the center of the conveyor). Otherwise product may catch and become damaged or disoriented.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 11 1 3/4” Angle Guide, Offset Mounting—Set In



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 12 1 3/4” Angle Guide, Offset Mounting—Set Out

Curved Angle Guides - (1 3/4")

Any curved side guide rail—90°, 60°, 45°, or 30°—can be mounted using the direct, spaced, or offset mounting style. Figure G - 13 shows a 1 3/4” angle side guide with a 90° curve.

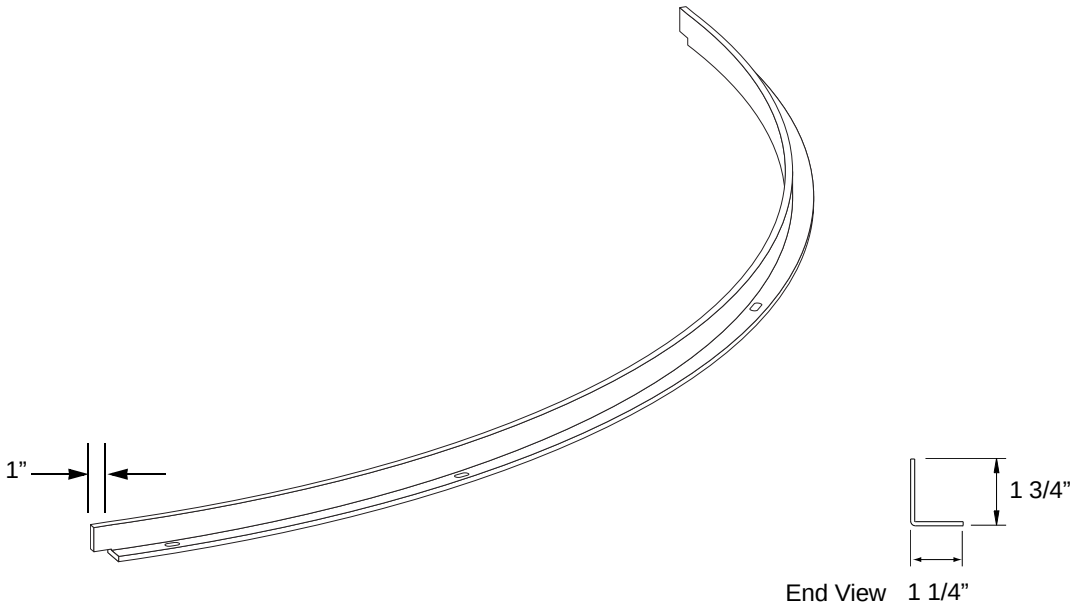


Figure G - 13 1 3/4” Angle Side Guide, 90° Curve

The direct mounting kit (Part No. 633990) provides the hardware for 1 3/4" angle side guide curves using direct mounting.

The spaced mounting kit (Part No. 633991) provides the hardware for 1 3/4" angle side guide curves using spaced mounting. (The 1 3/4" angle curve using spaced mounting is not shown; refer to Figure G - 10 for an example of spaced mounting.)

The offset mounting kit (Part No. 633992) provides the hardware for 1 3/4" angle side guide curves using offset mounting. (The 1 3/4" angle curve mounted using offset mounting is not shown; refer to Figure G - 11 and Figure G - 12 for examples of offset mounting.)

Mounting Curved Sections

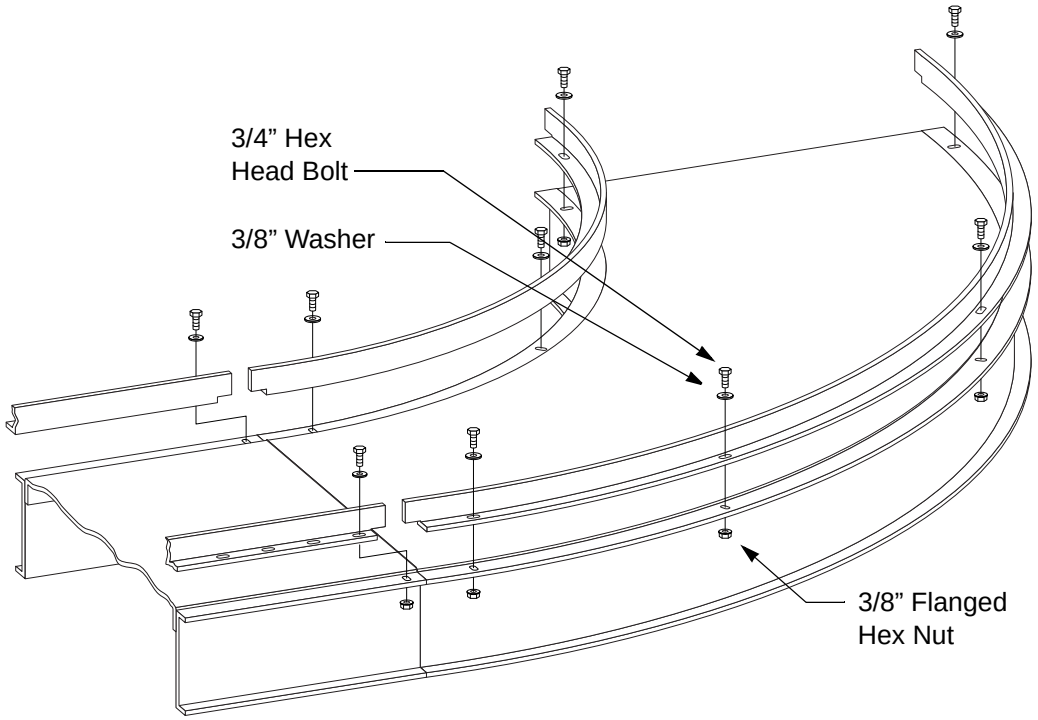
The angle of a curve affects the length of the guide rail; the length is also affected by such factors as:

- The width of the conveyor
- Whether the curve is a True Taper or a 2’ - 6” IR curve

The length of the side guide may affect the number of mounting points.

1. Bolt the outside of a 90° side guide to the frame in four locations.
2. Bolt the inside of a 90° side guide to the frame in three locations (see Figure G - 14).

CAUTION: Make certain that each section of side guide overlaps the adjoining downstream section on the inside (toward the center of the conveyor). Otherwise product may catch and become damaged or disoriented.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 14 1 3/4” Angle Side Guide, 90°Curve, Direct Mounting

Power Feeder Angle Guides - (1 3/4")

Side guides can be attached to incline, decline, and reversing power feeders.

CAUTION: It is important to observe proper mounting procedures so product does not catch where the edges of the side guides overlap. See Figure G - 15, Figure G - 16, and Figure G - 17 for information about proper overlap for incline, decline, and reversing power feeders.

Direct Mounting

The direct mounting kit (part number 633990) provides the hardware needed to mount side guides to power feeders using direct mounting.

1. Bolt the long side guide to the frame in three locations.
2. Bolt the short guide in two locations.

Spaced Mounting

The spaced mounting kit (part number 633991) provides the hardware needed to mount side guides to power feeders using spaced mounting.

1. Bolt the long side guide to the frame, with a spacer, in three locations.
2. Bolt the short guide in two locations.

Spaced mounting of power feeders is not shown; see Figure G - 10 for a 1 3/4" angle side guide mounted using spaced mounting.

Offset Mounting

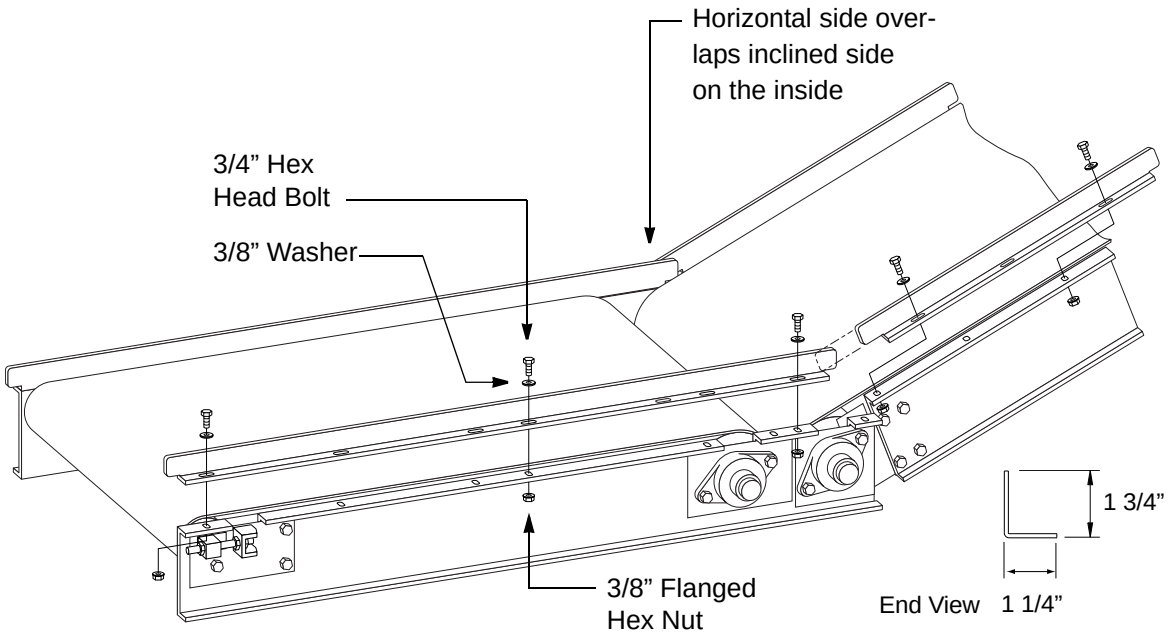
The offset mounting kit (part number 633992) provides the hardware needed to mount side guides to power feeders using offset mounting, either set in or set out.

1. Bolt the long rail of the power feeder side guide to the conveyor body at three places.
2. Bolt the short rail of the power feeder side guide to the conveyor body at two places.
3. Connect adjoining side guides at the bottoms of the guides, using a flat and the necessary bolts and washers.

Offset mounting of power feeders is not shown; see Figure G - 11 and Figure G - 12 for examples of 1 3/4" angle side guides mounted using offset mounting.

Inclined Power Feeders

CAUTION: Mount inclined power feeder side guides with the horizontal side guide overlapping the incline side guide on the inside so that products moving up the conveyor do not catch the overlapping rail (see Figure G - 15).

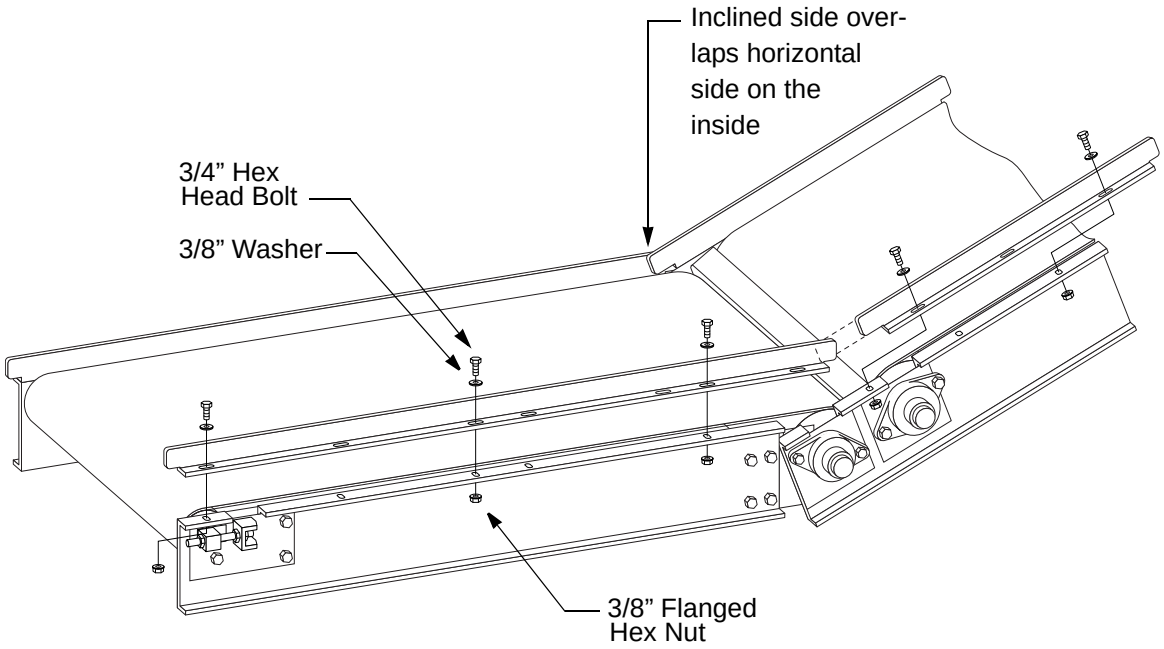


See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 15 Power Feeder, Inclined, with 1 3/4" Angle Side Guides; Direct Mounting

Declined Power Feeders

CAUTION: Mount declined power feeder side guides with the incline side guide overlapping the horizontal side guide on the inside so that products moving down the conveyor do not catch the overlapping rail (see Figure G - 16).

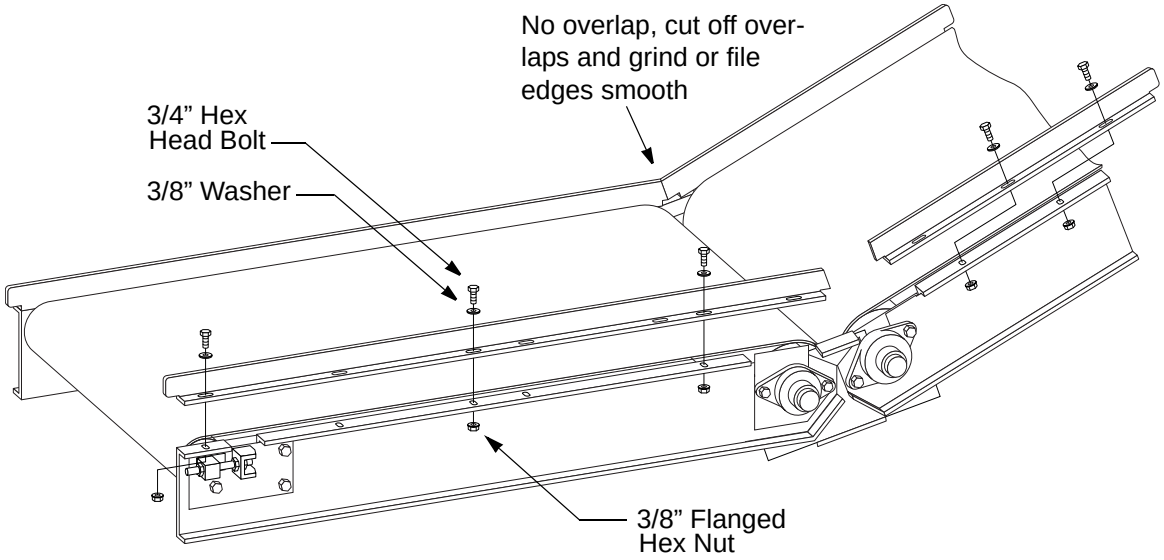


See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 16 Power Feeder, Declined, with 1 3/4" Angle Side Guides; Direct Mounting

Reversing Power Feeders

CAUTION: Mount reversing power feeder side guides with no overlaps where the horizontal side guides meet the inclined side guides. Cut off the overlaps and grind or file the edges smooth (see Figure G - 17).



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 17 Power Feeder, Reversing, with 1 3/4" Angle Side Guides; Direct Mounting

Upper Bend Angle Guides - (1 3/4")

The upper bend unit provides the curved transition between an inclined section and a horizontal section. The upper bend consists of two end rails and a center rail (see Figure G - 18). In the illustration, the rail at the right connects with a horizontal conveyor. The rail at the left connects with an inclined conveyor.

- Bolt each rail to the upper bend in two places. Notice that the end rails have overlap tabs; the center rail is longer and does not have overlap tabs.

CAUTION: Make certain that each section of side guide overlaps the adjoining downstream section on the inside (toward the center of the conveyor). Otherwise product may catch and become damaged or disoriented.

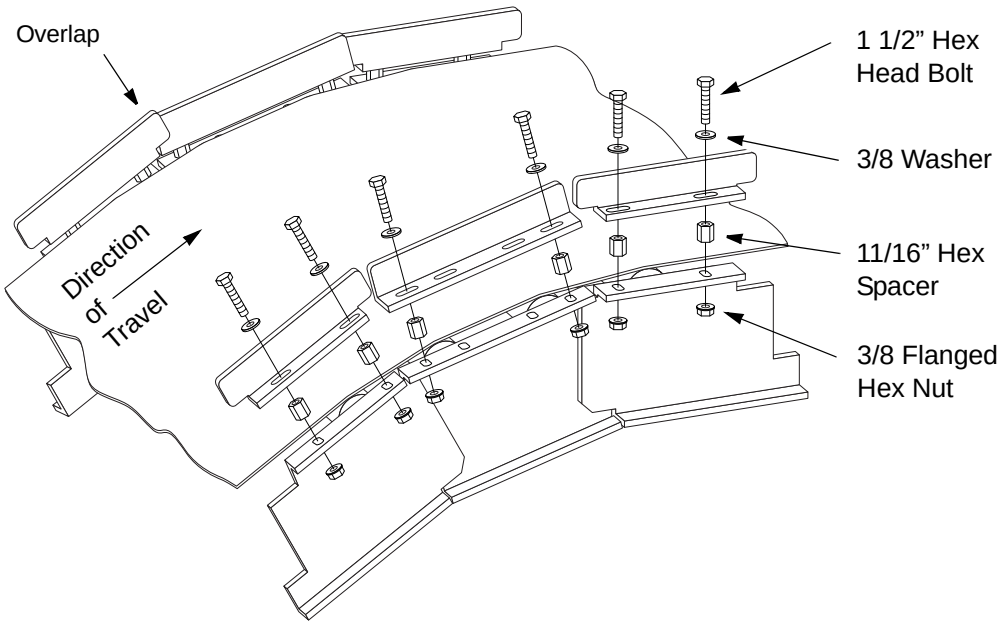


Figure G - 18 Upper Bend Unit with 1 3/4" Angle Side Guides, Spaced Mounting

Mounting Upper Bend Angle Guides

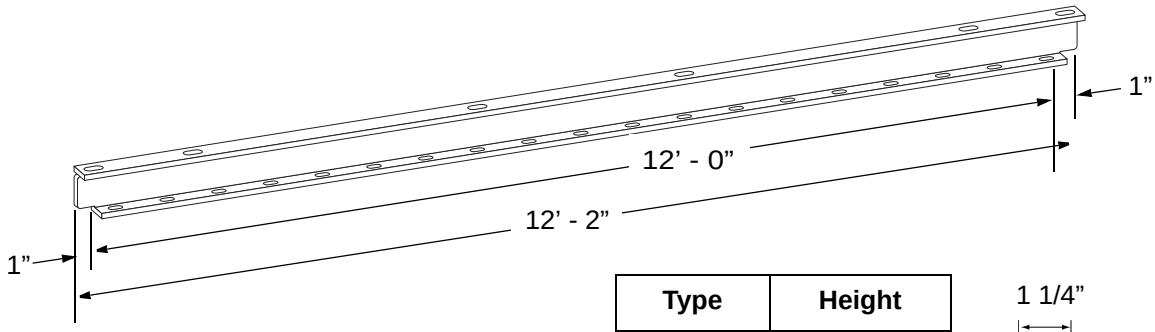
The hardware required to install upper bend angle side guides is included with the side guides. Figure G - 18 shows spaced mounting. See Figure G - 9, Figure G - 11 and Figure G - 12 for examples of direct and offset mounting.

Straight Channel Guides - (2 5/8", 7", 10")

The 2 5/8" channel guides, 7" channel guides, and 10" channel guides may be plain-faced or wheel-faced.

Channel side guides are attached to the conveyor body at four places. They are coupled to the adjoining side guide at the underside of the top flange and at the bottom of the guide (using a flat and the necessary bolts and washers).

Figure G - 19 shows a 2 5/8" channel side guide; the dimensions for 7” channel guide and 10” channel guide are also indicated.



Type	Height
B	2 5/8”
C	7”
D	10”

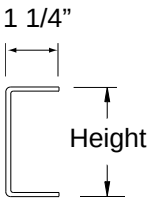


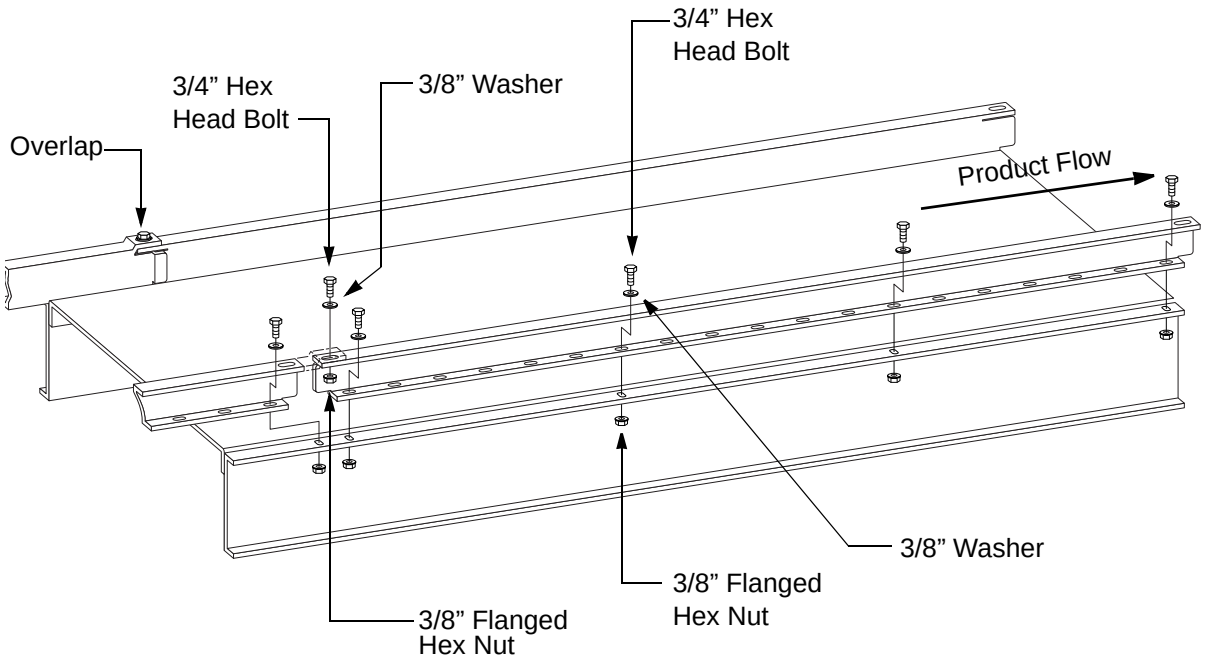
Figure G - 19 Channel Side Guide; 2 5/8" Channel

Direct Mounting

The direct mounting kit (Style A, part number 633990) provides all the hardware needed to mount one plain 12’ straight channel side guide.

- Bolt the side guide to the frame in four locations (see Figure G - 20).

CAUTION: Make certain that each section of side guide overlaps the adjoining downstream section on the inside (toward the center of the conveyor). Otherwise product may catch and become damaged or disoriented.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

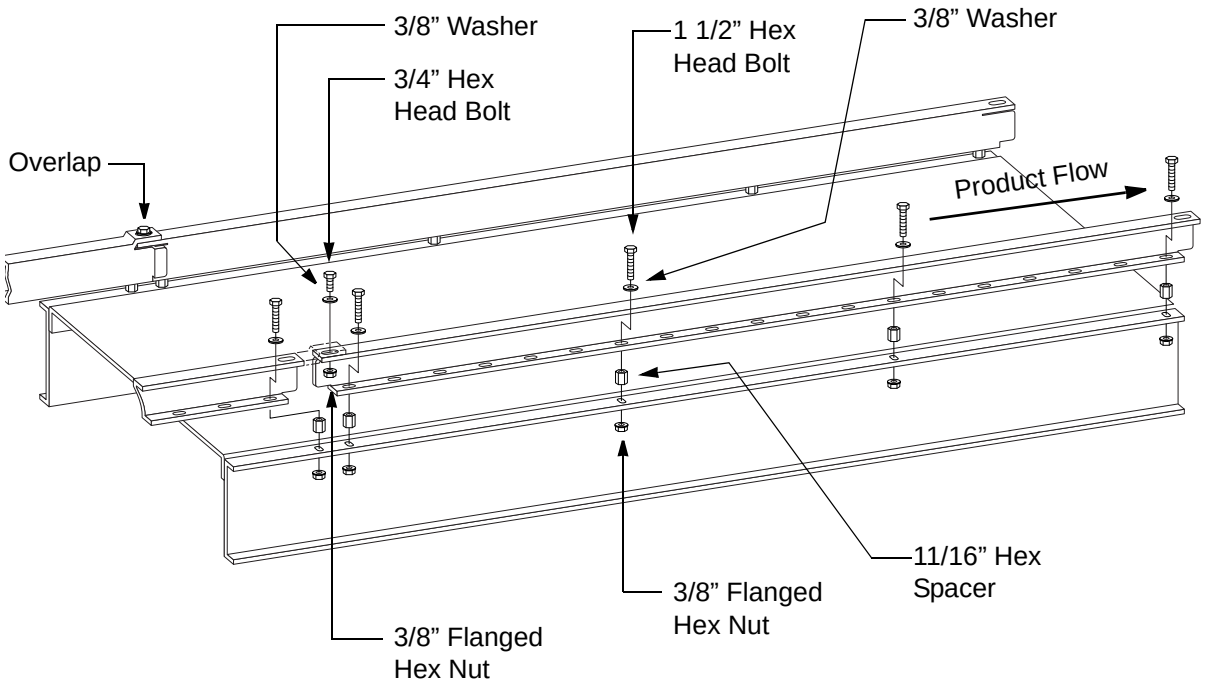
Figure G - 20 Channel Side Guides, 2 5/8" Channel Shown, Direct Mounting

Spaced Mounting

The spaced mounting kit (Style B, part number 633991) provides all the hardware needed to mount one plain 12’ straight channel side guide.

- Bolt the side guide to the frame, with a spacer, in four locations (see Figure G - 21).

CAUTION: Make certain that each section of side guide overlaps the adjoining downstream section on the inside (toward the center of the conveyor). Otherwise product may catch and become damaged or disoriented.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 21 Channel Side Guides, 2 5/8" Channel Shown, Spaced Mounting

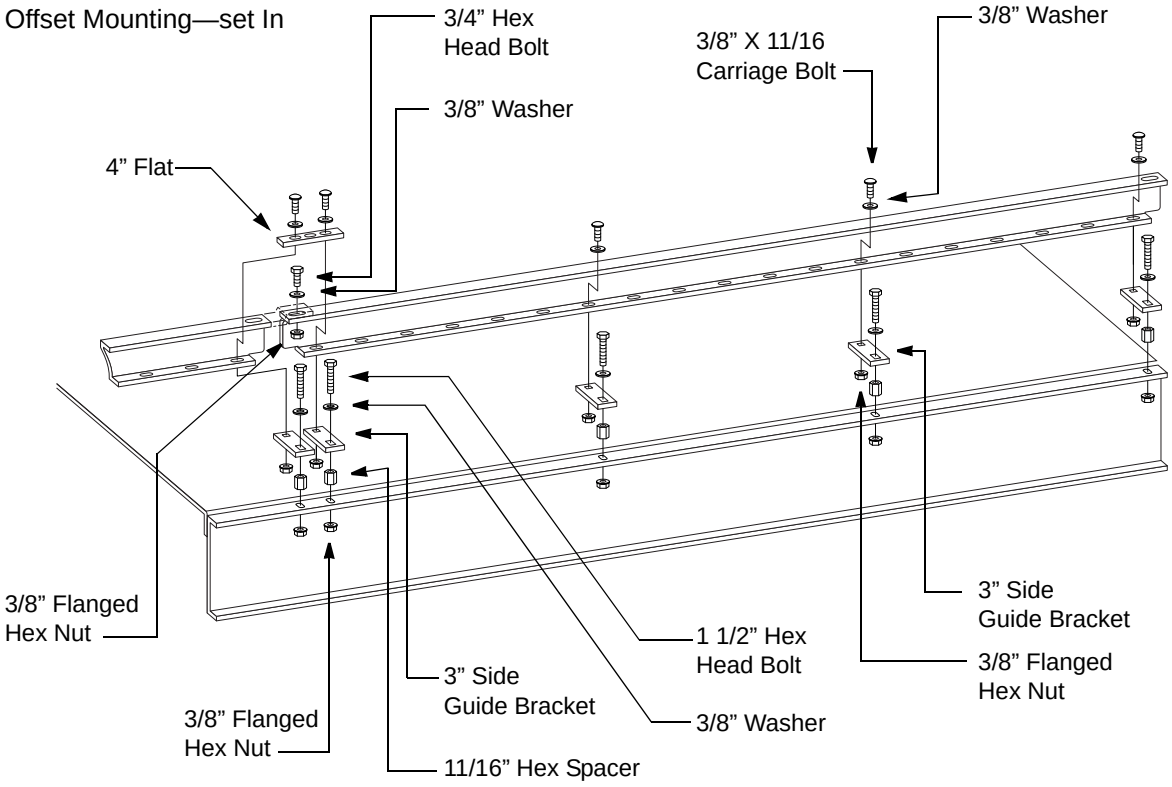
Offset Mounting

In offset mounting, the side guide is bolted to the bracket, and the bracket is bolted to the body. A hex nut is used for a spacer. When the guide is set in, the hex spacer is used where it attaches to the body; when the guide is set out, the hex spacer is used where the bracket attaches to the side guide.

The offset mounting kit (Style C, part number 633992) provides all the hardware needed to mount one plain 12’ straight channel side guide, either set in or set out.

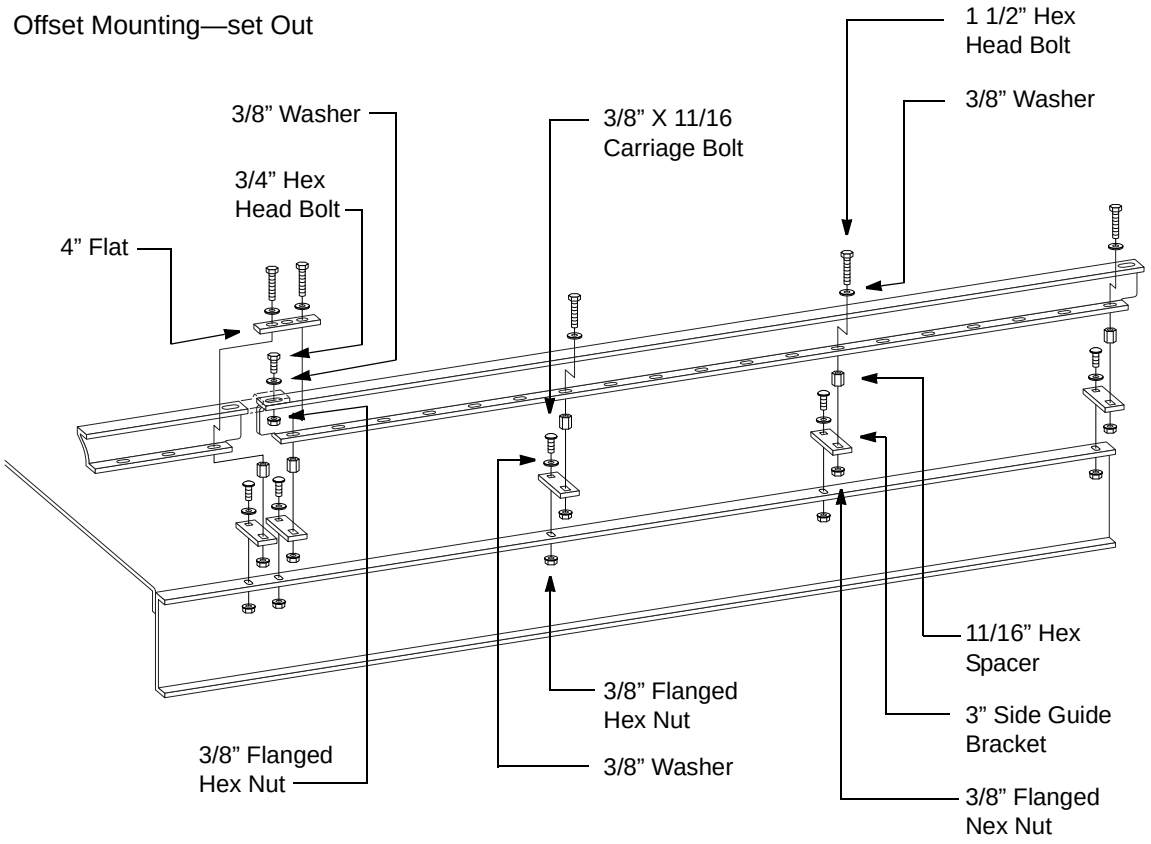
- Bolt the side guide to the frame in four locations (see Figure G - 22 and Figure G - 23).

CAUTION: Make certain that each section of side guide overlaps the adjoining downstream section on the inside (toward the center of the conveyor). Otherwise product may catch and become damaged or disoriented.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 22 Channel Side Guides (2 5/8" Shown) Offset Mounting - Set In

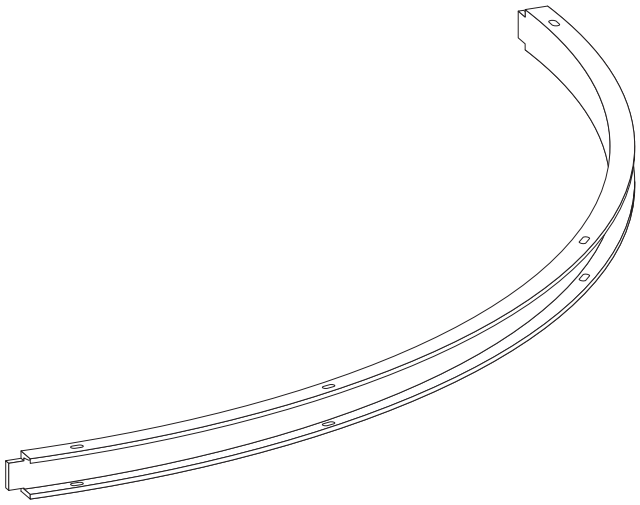


See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 23 Channel Side Guides (2 5/8" Shown) Offset Mounting - Set Out

Curved Channel Guides - (2 5/8", 7", 10")

Any curved side guide rail — 90°, 60°, 45°, or 30° — can be mounted using the direct, spaced, or offset mounting style. Figure G - 24 shows a 2 5/8” channel side guide with a 90° curve.



Type	Height
B	2 5/8”
C	7”
D	10”

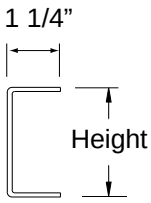


Figure G - 24 90° Curve Side Guide

The direct mounting kit (Part No. 633990) provides the hardware for channel side guide curves using direct mounting.

The spaced mounting kit (Part No. 633991) provides the hardware for channel side guide curves using spaced mounting. (The channel side guide curve using spaced mounting is not shown; refer to Figure G - 22 for an example of spaced mounting.)

The offset mounting kit (Part No. 633992) provides the hardware for channel side guide curves using offset mounting. (The channel side guide curve using offset mounting is not shown; refer to Figure G - 22 and Figure G - 23 for examples of offset mounting.)

Mounting Curved Channel Guides

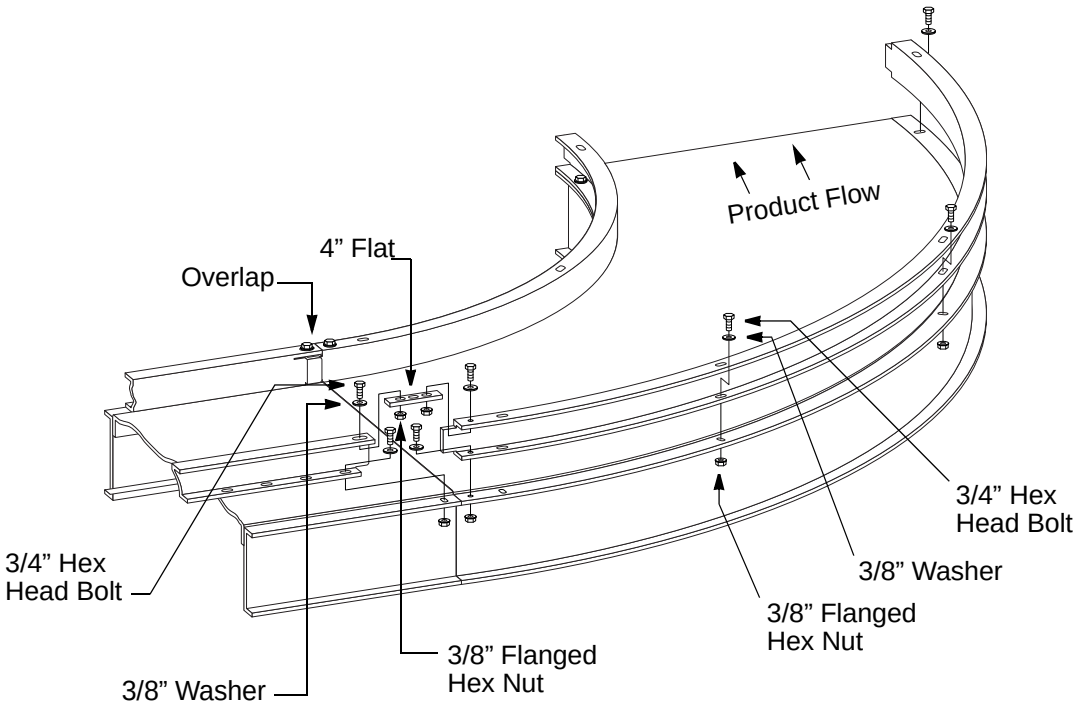
The angle of a curve affects the length of the guide rail; the length is also affected by such factors as:

- The width of the conveyor
- Whether the curve is a True Taper or a 2’ - 6” IR curve

The length of the side guide may affect the number of mounting locations.

1. Bolt the outside of a 90° side guide to the frame in four locations.
2. Bolt the inside of a 90° side guide to the frame in three locations (see Figure G - 25).

CAUTION: Make certain that each section of side guide overlaps the adjoining downstream section on the inside (toward the center of the conveyor). Otherwise product may catch and become damaged or disoriented.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 25 Channel Side Guide 90° Curve, 2 5/8" Channel Shown, Direct Mounting

Power Feeder Channel Guides - (2 5/8", 7", 10")

Side guides can be attached to incline, decline, and reversing power feeders.

CAUTION: It is important to observe proper mounting procedures so product does not catch where the edges of the side guides overlap. See Figure G - 26, Figure G - 27, and Figure G - 28 for information about proper overlap for incline, decline, and reversing power feeders.

Direct Mounting

The direct mounting kit (part number 633990) provides the hardware needed to mount one side guide to a power feeder.

1. Bolt the long side guide to the frame in three locations.
2. Bolt the short guide in two locations.

Direct mounting of power feeder side guides is not shown; see Figure G - 20 for a channel side guide mounted using direct mounting.

See Figure G - 26, Figure G - 27, and Figure G - 28 for information about proper overlap for incline, decline, and reversing power feeders.

Spaced Mounting

The spaced mounting kit (part number 633991) provides the hardware needed to mount one side guide to a power feeder.

1. Bolt the long side guide to the frame, with a spacer, in three locations.
2. Bolt the short guide in two locations.

See Figure G - 26, Figure G - 27, and Figure G - 28 for information about proper overlap for incline, decline, and reversing power feeders.

Offset Mounting

The spaced mounting kit (part number 633991) provides the hardware needed to mount one side guide to a power feeder.

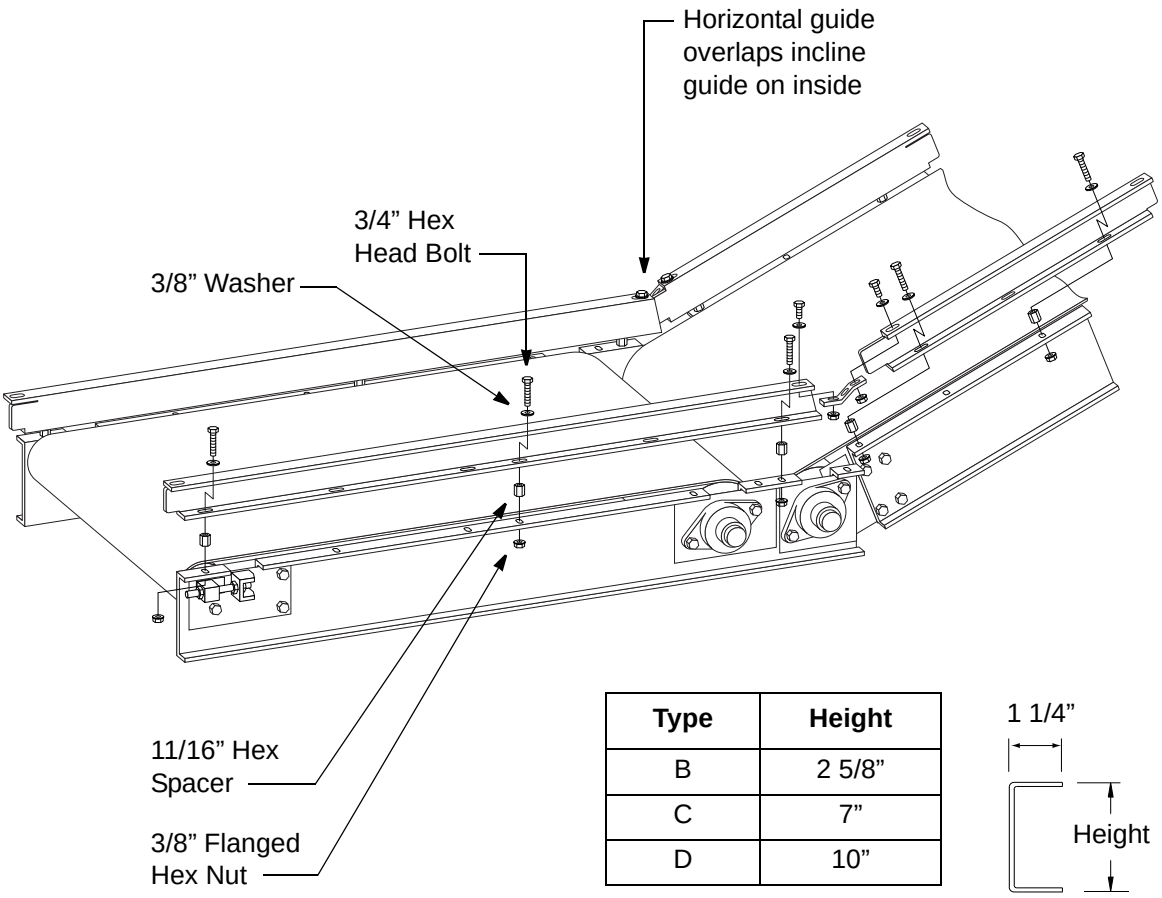
1. Bolt the long power feeder side guide rail to the conveyor body at three places.
2. Bolt the short power feeder side guide rail to the conveyor body at two places.

Offset mounting of power feeder side guides is not shown; see Figure G - 22 for a channel side guide mounted using direct mounting.

See Figure G - 26, Figure G - 27, and Figure G - 28 for information about proper overlap for incline, decline, and reversing power feeders.

Inclined Power Feeders

CAUTION: Mount inclined power feeder side guides with the horizontal side guide overlapping the incline side guide on the inside so that products moving up the conveyor do not catch the overlapping rail (see Figure G - 26).



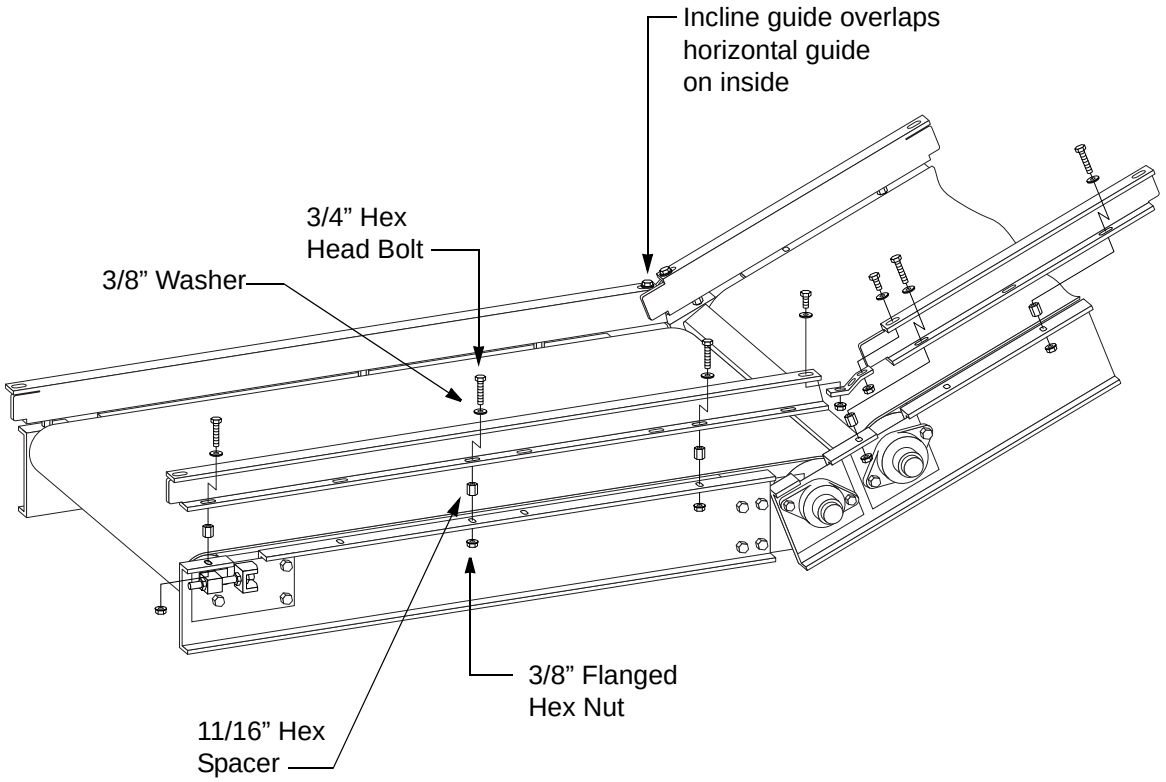
Type	Height
B	2 5/8”
C	7”
D	10”

See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 26 Power Feeder, Inclined, with 2 5/8" Channel Side Guides; Spaced Mounting

Declined Power Feeders

CAUTION: Mount declined power feeder side guides with the incline side guide overlapping the horizontal side guide on the inside so that products moving down the conveyor do not catch the overlapping rail (see Figure G - 27).

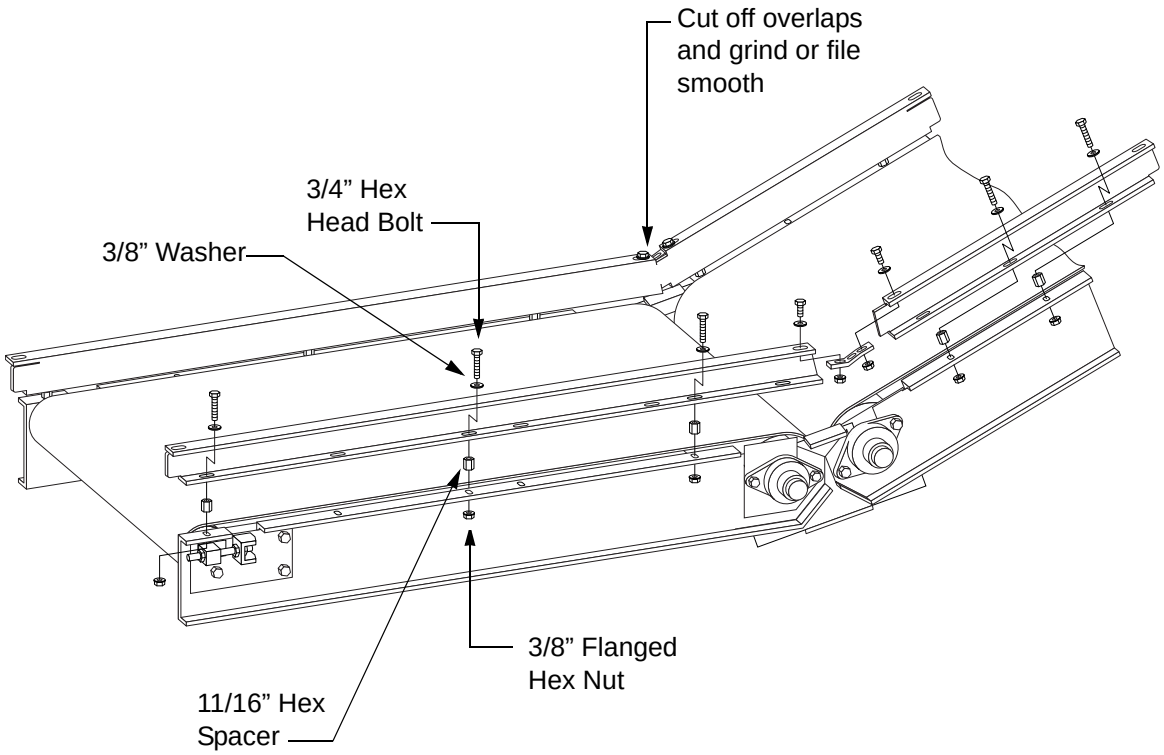


See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 27 Power Feeder, Declined, with 2 5/8" Channel Side Guides; Spaced Mounting

Reversing Power Feeders

CAUTION: Mount reversing power feeder side guides with no overlaps where the horizontal side guides meet the inclined side guides; the overlaps are cut off and the edges are ground or filed smooth (see Figure G - 28).



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 28 Power Feeder, Reversing, with 2 5/8" Channel Side Guides; Spaced Mounting

Upper Bend Channel Guides - (2 5/8", 7", 10")

The upper bend unit provides the curved transition between an inclined section and a horizontal section. The upper bend consists of two end rails and a center rail. Figure G - 29 shows an upper bend unit with 2 5/8" channel side guides. In the illustration, the rail at the right connects with a horizontal conveyor. The rail at the left connects with an inclined conveyor.

- Bolt each rail to the upper bend in two places. Notice that the end rails have overlap tabs; the center rail is longer and does not have overlap tabs.

CAUTION: Make certain that each section of side guide overlaps the adjoining downstream section on the inside (toward the center of the conveyor). Otherwise product may catch and become damaged or disoriented.

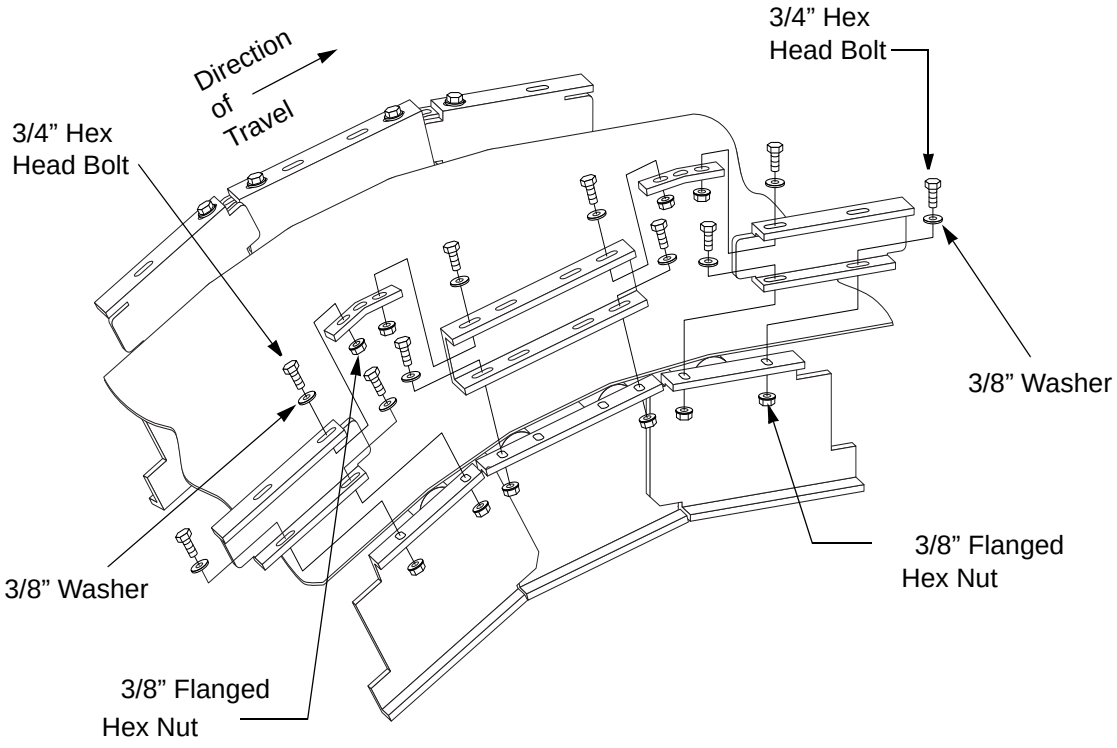


Figure G - 29 Upper Bend Unit with Channel Side Guides, Direct Mounting

Mounting Upper Bend Channel Guides

The hardware required to install upper bend channel side guides is included with the side guides. Figure G - 29 shows direct mounting. See Figure G - 21, Figure G - 22 and Figure G - 23 for examples of spaced and offset mounting.

Wheel-Face Channel Guides - (2 5/8", 7", 10")

Wheel-face channel side guides feature skate wheels that project out a fraction of an inch from the face of the rail. The wheels provide a very low friction surface against which product can move. Wheel-face channel side guides are available in 2 5/8" channel, 7" channel and 10" channel.

CAUTION: Make certain that each section of side guide overlaps the adjoining downstream section on the inside (toward the center of the conveyor). Otherwise product may catch and become damaged or disoriented.

Direct Mounting

The Direct Mounting (Style A) kit, part number 633990, provides all the hardware needed to mount one 6’ - 0” wheelface side guide.

- Bolt the side guide to the frame in two locations. See “Straight Channel Guides - (2 5/8", 7", 10")” and “Curved Channel Guides - (2 5/8", 7", 10")” for additional information.

Note: In order to accommodate the skate wheel bolt heads between the side guide and the conveyor, the wheelface “bolt-to-frame” style does not mount the guide *directly* to the frame, but requires a spacer to allow offset for the skate wheel bolt heads.

Spaced Mounting

The Spaced Mounting (Style B) kit, part number 633991, provides the hardware needed to mount one 6’ - 0” wheelface side guide.

- Bolt the side guide to the frame in two locations. See “Straight Channel Guides - (2 5/8", 7", 10")” and “Curved Channel Guides - (2 5/8", 7", 10")” for additional information.

Offset Mounting

In offset mounting, the side guide is bolted to the bracket, and the bracket is bolted to the body. A hex nut is used for a spacer. When the guide is set in, the hex spacer is used where it attaches to the body; when the guide is set out, the hex spacer is used where the bracket attaches to the side guide.

The Offset Mounting (Style C) kit, part number 633992, provides the hardware needed to mount one 6’ - 0” wheelface side guide, either set in or set out.

1. Bolt the side guides to the conveyor body at two places.
2. Attach adjoining side guides at the underside of the top flange.
3. Connect adjoining side guides at the bottom of the guide, using a flat and the necessary bolts and washers. See “Straight Channel Guides - (2 5/8", 7", 10")” and “Curved Channel Guides - (2 5/8", 7", 10")” for additional information.

Figure G - 30 shows the 10" high wheel-face side guide. This side guide is also known by the abbreviation WFD (wheel-face 10" channel).

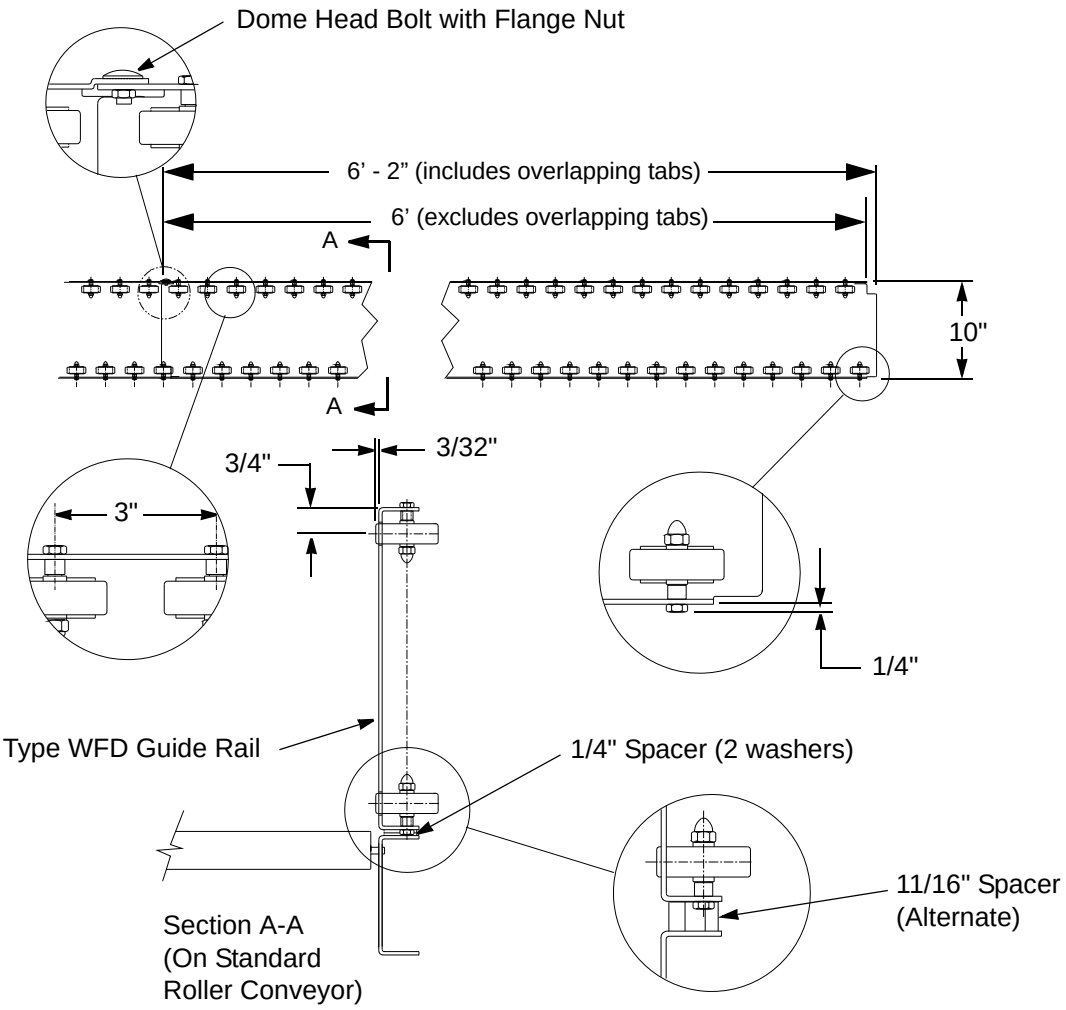


Figure G - 30 10" Wheel-Faced Side Guide

UHMW-Face Guides - (2 5/8", 7", 10")

UHMW (Ultra High Molecular Weight) polyethylene is a smooth-sided white material that reduces friction on straight conveyors. UHMW-face side guides come in three heights, 2 5/8" channel, 7" channel, and 10" channel. 2 5/8" channel is shown in Figure G - 31.

UHMW-face guides can be mounted onto a conveyor using any of the three mounting methods: direct, spaced, or offset.

Direct Mounting

The direct mounting kit (Style A, part number 633990) provides all the hardware needed to mount one UHMW 12’ side guide (see Figure G - 31).

- Bolt the side guide to the frame in four locations.

Spaced Mounting

The spaced mounting kit (Style B, part number 633991) provides all the hardware needed to mount one UHMW 12’ side guide (not shown; see Figure G - 21 for an example of spaced mounting.)

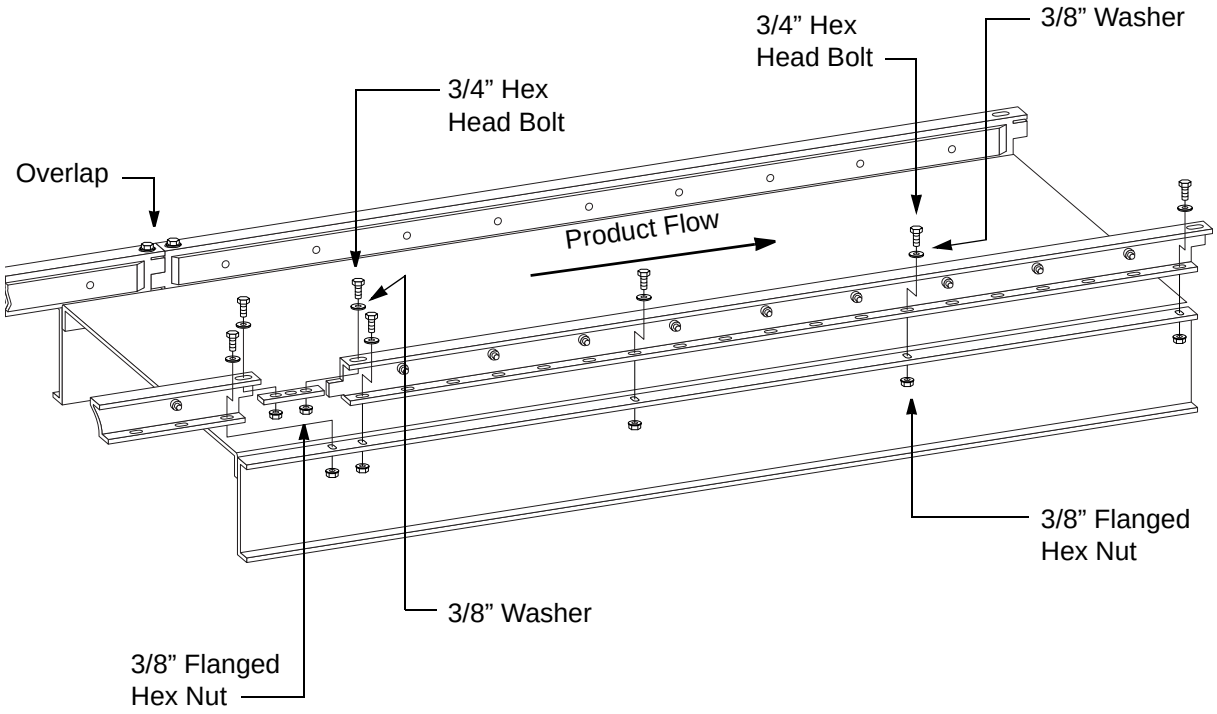
- Bolt the side guide to the frame, with a spacer, in four locations.

Offset Mounting

In offset mounting, the side guide is bolted to the bracket, and the bracket is bolted to the body. A hex nut is used for a spacer. When the guide is set in, the hex spacer is used where it attaches to the body; when the guide is set out, the hex spacer is used where the bracket attaches to the side guide.

The offset mounting kit (Style C, part number 633992) provides all the hardware needed to mount one UHMW 12’ side guide, either set in or set out (not shown; see Figure G - 22 and Figure G - 23 for examples of offset mounting).

1. Bolt the side guides to the conveyor body at four places.
2. Connect adjoining side guides at the underside of the top flange.
3. Connect adjoining side guides at the bottom of the guide, using a flat and the necessary bolts and washers.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 31 UHMW-Face Side Guide, 2 5/8" Channel, Direct Mounting

Junction Guides - (2 5/8", 7", 10")

Junction side guides facilitate the movement of product past the point where conveyors join. They may be 30° or 45°, plain-face or wheel-face.

Plain-face junction side guides are used when wheels are not needed for smooth movement of the product onto the “new” conveyor. Figure G - 32 shows a 30° plainface junction.

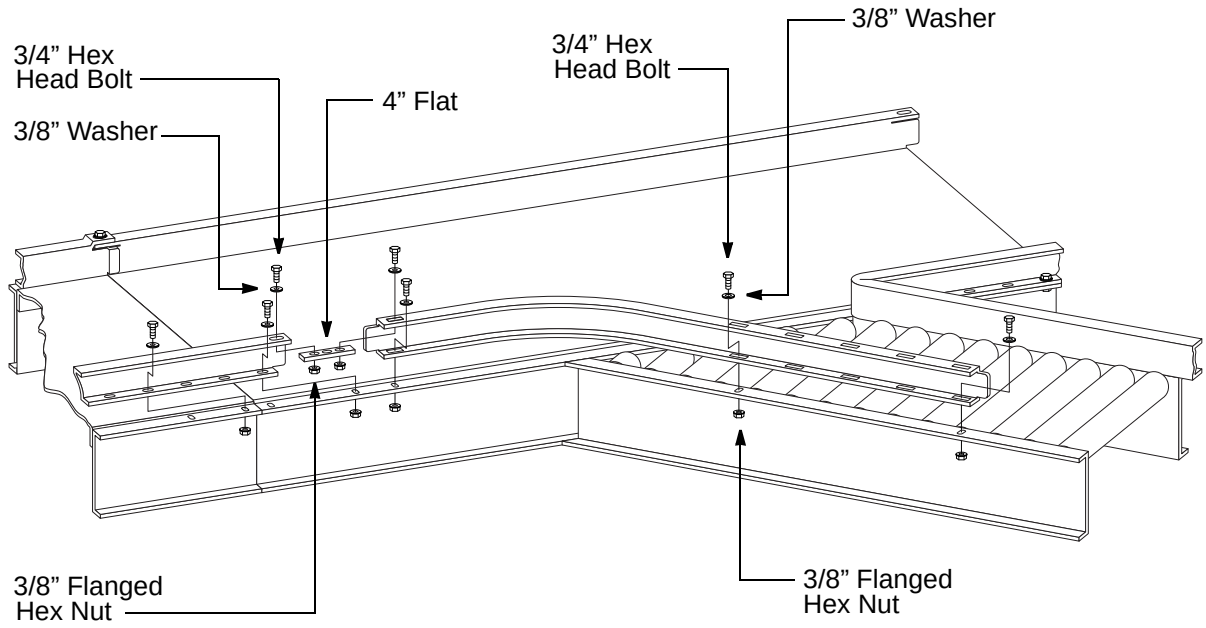
Wheel face junction side guides are used when needed to help the product move smoothly past the curve onto the “new” conveyor. Figure G - 33 shows a 45° wheelface junction.

Junction side guides are normally mounted using direct mounting or spaced mounting.

Direct Mounting

The Direct Mounting (Style A) kit, part number 633990, provides all the hardware needed to mount one junction side guide (see Figure G - 32).

- Bolt the side guide to the frame in 3 locations.



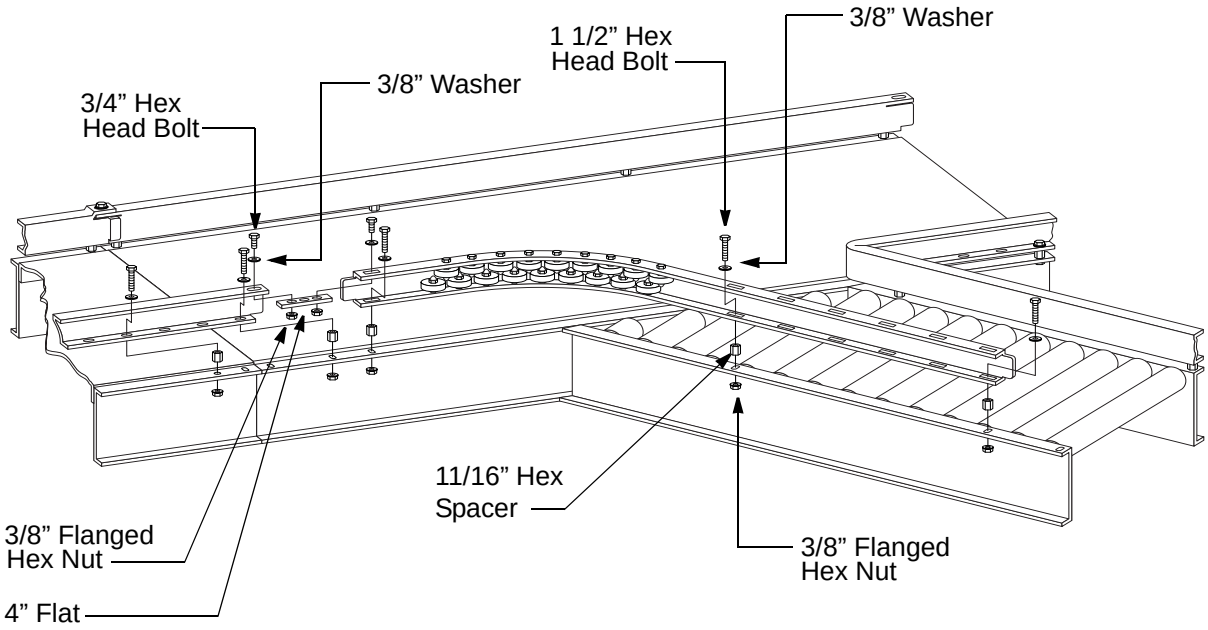
See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 32 30° Junction, Plainface, 2 5/8" Channel Side Guide, Direct Mounting

Spaced Mounting

Figure Figure G - 33 shows a junction using spaced mounting.

The Spaced Mounting (Style B) kit, part number 633991, provides all the hardware needed to mount a junction side guide in a spaced mounting style (see Figure G - 33). The side guide is bolted to the frame, with a spacer, in 3 locations.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 33 45° Junction, Wheelface, 2 5/8" Channel Side Guide, Spaced Mounting

Height Transition Guides

Height transition side guides slope from one height at one end to another height at the other end. These guides are available in three types, HBC (2 5/8” to 7”), HBD (2 5/8” to 10”), and HCD (7” to 10”). Each type may be mounted using direct, spaced, or offset mounting. Nine combinations of height transition type and mounting type are possible. The following three examples provide sufficient guidance for all nine combinations.

- Figure G - 34 shows type HBC (2 5/8” to 7”) using direct mounting
- Figure G - 35 shows type HBD (2 5/8” to 10”) using spaced mounting
- Figure G - 36 and Figure G - 37 show type HCD (7” to 10”) using offset mounting

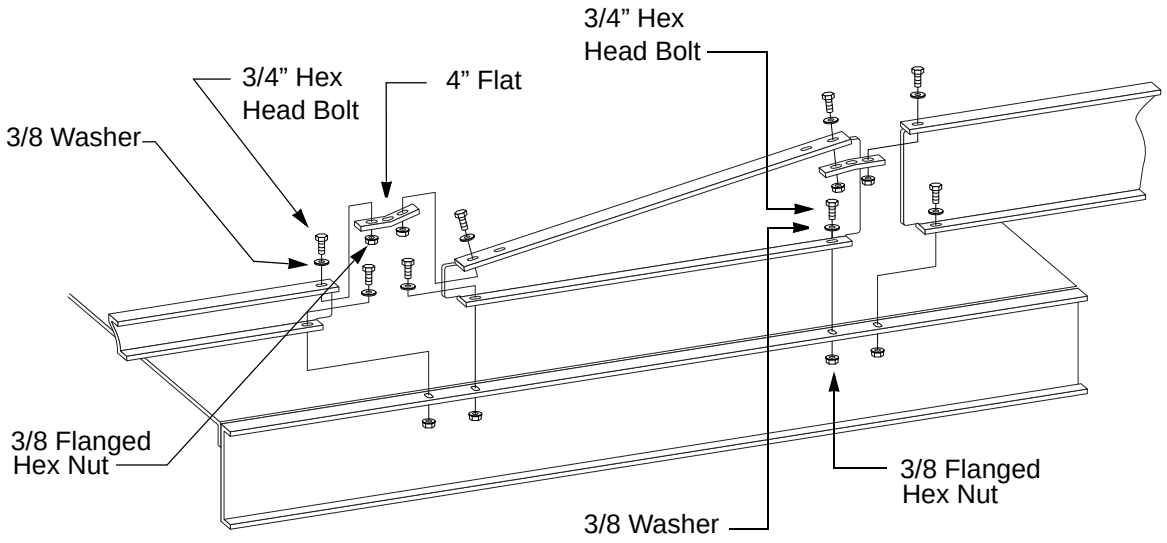
Type HBC – 2 5/8” to 7”

Figure G - 34 shows an HBC side guide mounted (direct mounting) on one side of a conveyor. The height transition guide is coupled to a B height (2 5/8” high) guide at the lower end and a C height (7” high) guide at the higher end.

Mounting HBC – Direct Mounting

The direct mounting kit (Style A, part number 633990) provides all the hardware needed to mount one height transition side guide (see Figure G - 34).

- Bolt the side guide to the frame at each end, as shown in Figure G - 34.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 34 Height Transition Side Guide, 2 5/8” to 7” (Type HBC), with Direct Mounting

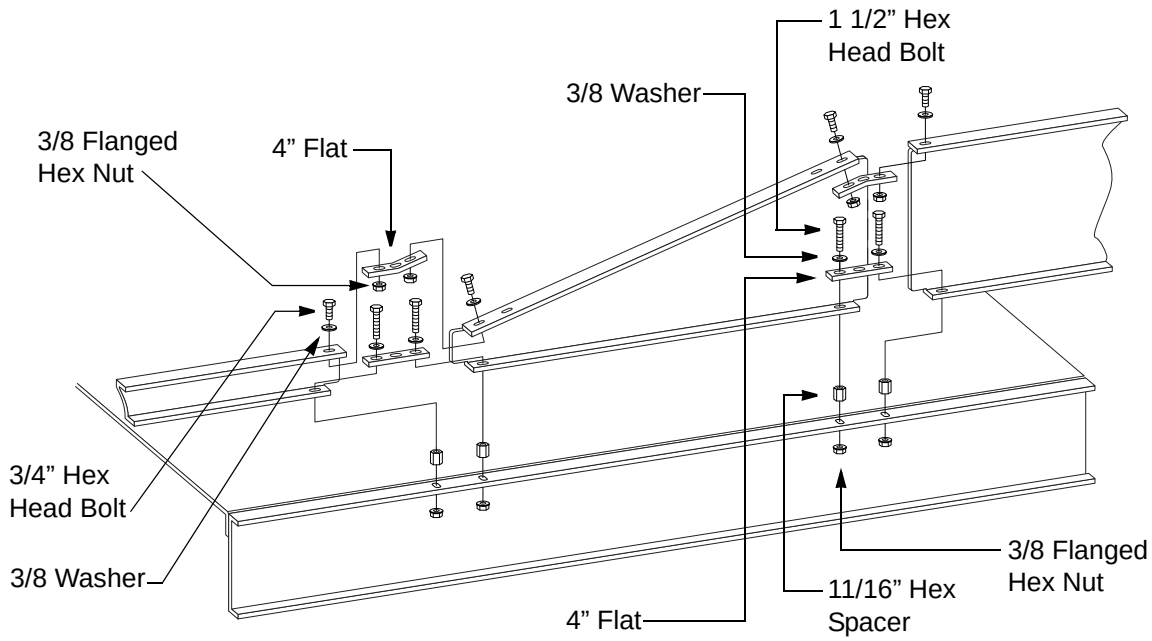
Type HBD – 2 5/8” to 10”

Figure G - 35 shows an HBD side guide mounted (spaced mounting) on one side of a conveyor. The height transition guide is coupled to a B height (2 5/8” high) guide at the lower end and a D height (10” high) guide at the higher end.

Mounting HBD – Spaced Mounting

The spaced mounting kit (Style B, part number 633991) provides all the hardware needed to mount one height transition side guide (see Figure G - 35).

- Bolt the side guide to the frame, with a spacer, in two locations (each end), as shown in Figure G - 35.



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 35 Height Transition Side Guide, 2 5/8” to 10” (Type HBD), using Spaced Mounting

Type HCD – 7” to 10”

Figure G - 36 shows an HCD side guide mounted (offset mounting, set in) on one side of a conveyor. The height transition guide is coupled to a C height (7” high) guide at the lower end and a D height (10” high) guide at the higher end.

Mounting HCD – Offset Mounting

All height transition side guides are attached to the conveyor body at two places (each end). At these locations, each transition guide is also coupled to the adjoining side guide at the bottom of the guide. In addition, the height transition guide is coupled to the adjoining guide at the underside of the top flange.

The offset mounting kit (Style C, part number 633992) provides all the hardware needed to mount a height transition side guide, either set in or set out (see Figure G - 36).

- Bolt the side guide to the frame in two locations, at each end, as shown in Figure G - 36 and Figure G - 37.

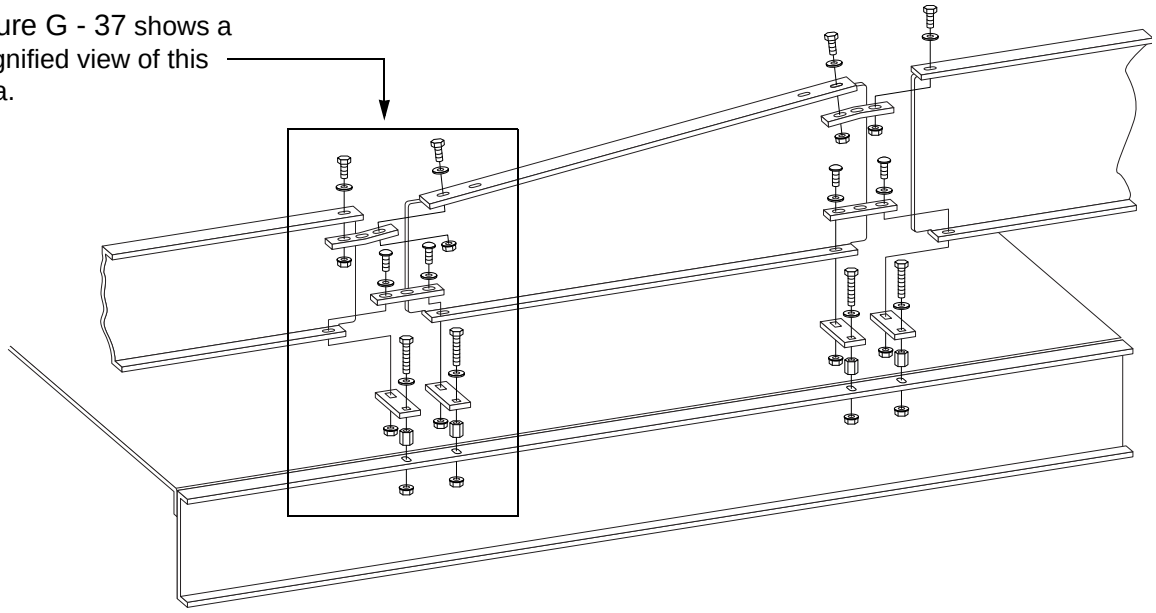
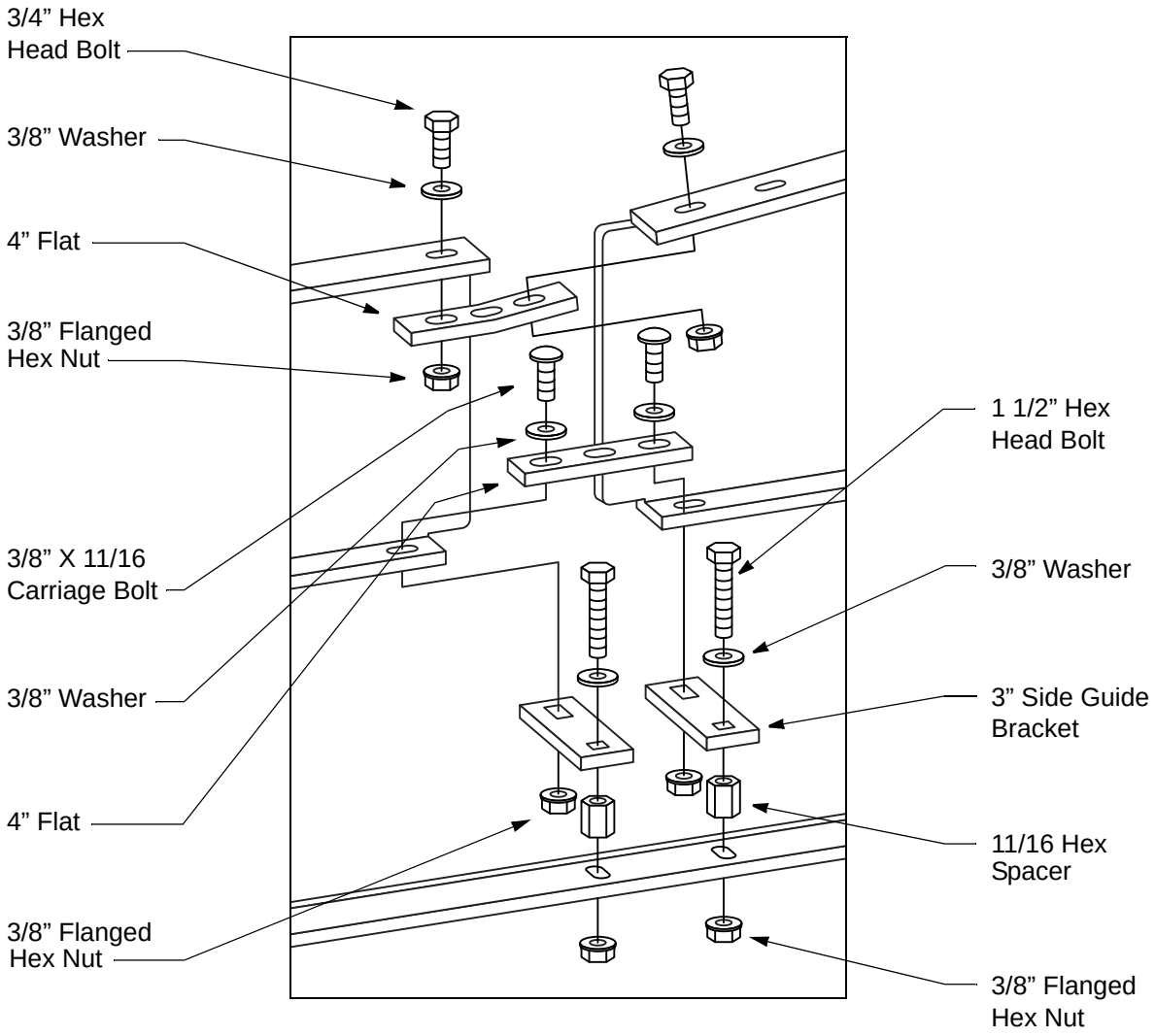


Figure G - 36 Height Transition Side Guide, 7” to 10” (Type HCD), Offset Mounting (Set In)



See “Mounting Kits” and following topics for part descriptions and additional instructions.

Figure G - 37 Height Transition Side Guide, Offset Mounting, Magnified View

Adjustable Side Guides

General

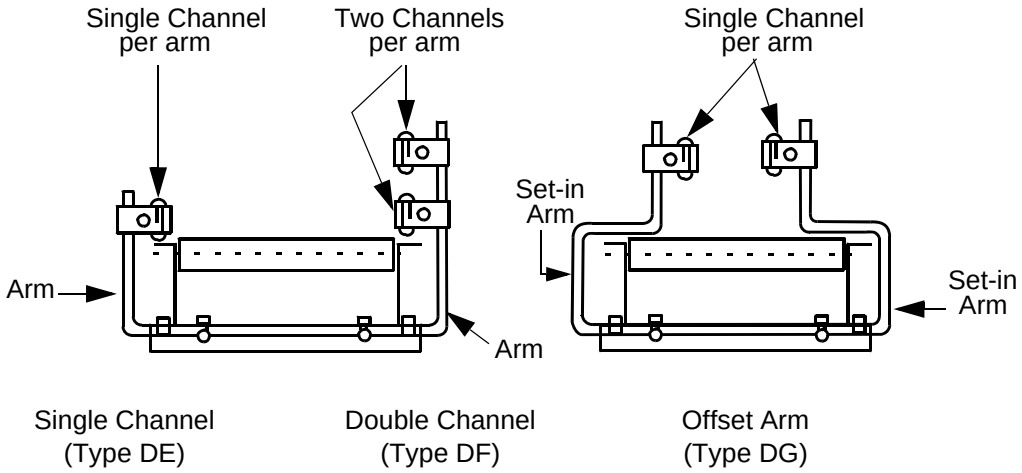
Adjustable side guides are sometimes used when:

- Products must be kept near the center of the conveyor
- Products must be visible when viewed from the side
- Product height or width changes periodically
- Products are slightly wider than the conveyor belt
- Products pass through straight sections but are too wide for curved sections

Adjustable Side Guide Types

Adjustable side guide channels are 1 5/8” high. They are mounted on arms and can be adjusted. The three types of adjustable side guides are listed below. See Figure G - 38.

- Single channel (Type DE) – One 1 5/8” high channel set on an adjustable arm *(SGE in some abbreviations)*
- Double channel (Type DF) – Two 1 5/8” high channels set on an adjustable arm *(SGF in some abbreviations)*
- Offset Arm (Type DG) – One 1 5/8” high channel set on an adjustable set-in arm (SGG in some abbreviations)



* To more effectively show the set-in arms, the guides on both sides of the conveyor are shown as Type DG.

Figure G - 38 Adjustable Side Guides

Side Guide Heights and Widths

Table G 2 and Figure G - 39 indicate mounting arm height requirements. The dimensions are determined by the height of the conveyor channels (H), which is greater at terminal ends than at intermediate sections.

Table G 2: Adjustable Side Guide Heights

	Dimension H	**Single Channel** **Dimension A**	**Double Channel** **Dimension B**	**Offset Arm** **Dimension C**
Intermediate Section	5”	20 1/4”	27 1/4”	7”
Terminal Ends	10”	22 3/4”	29 3/4”	11 1/2”

Table G 3 and Figure G - 39 identify the range of *possible widths between adjustable side guides.* The arms may be placed to fit closer to the conveyor body or further away. For example, when using a single channel the width between the side guides (W_{SG}) may range from 1” (M) *less than* the conveyor body width (W) to 8” (M) *more than* the conveyor body width (W). Note that when using offset arm guides (Type DG), W_{SG} is always *less than* W; it is never greater.

Table G 3: Adjustable Side Guide Widths

	Dimension H	**Single Channel** **Dimension A**	**Double Channel** **Dimension B**	**Offset Arm** **Dimension C**
Dimension M	Maximum	(+) 8”	(+) 8”	(-) 1 1/2”
	Minimum	(-) 1”	(-) 1”	(-) 9 1/2”
Width Between Side Guides (W_{SG}) = W (Conveyor Body Width) Plus or Minus M				

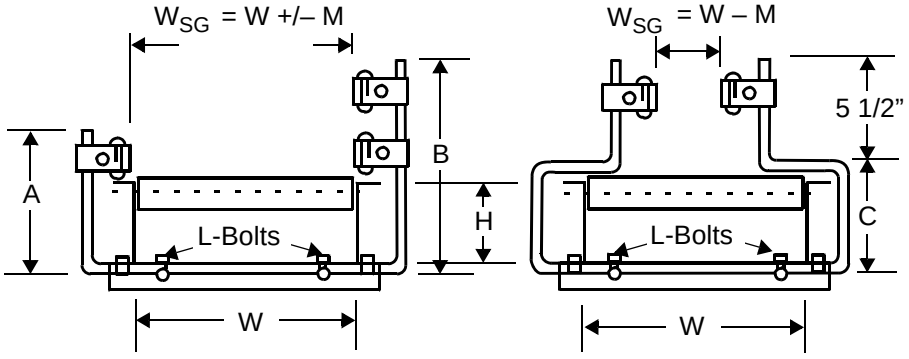


Figure G - 39 Adjustable Side Guide Dimensions

Support Rod and Clamp Assembly

To install adjustable side guides:

1. Locate mounting angles and attach to bottom flange of conveyor frame rail. See Figure G - 40.

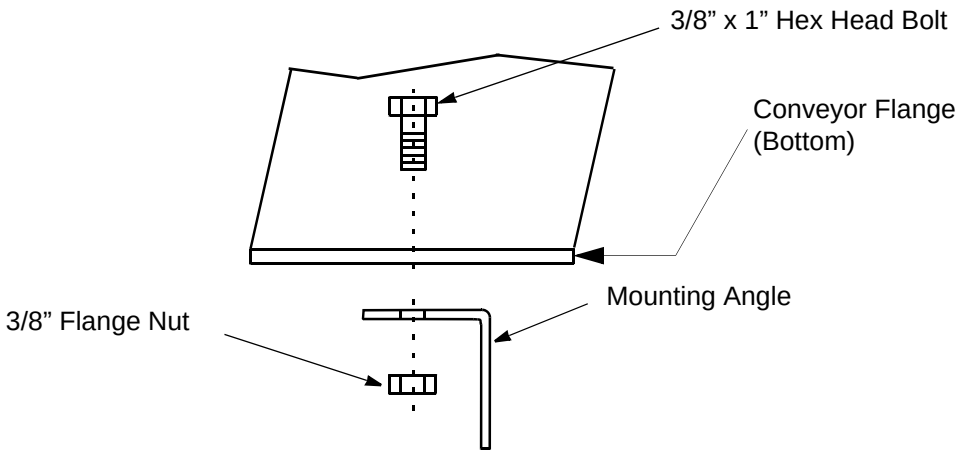


Figure G - 40 Mounting Angle Attached to Bottom Flanges

2. Assemble and secure the rod to the mounting angle at the required width (see Figure G - 41). Slip the clamp over the support rod and tighten bolt (a) at required height.
3. Attach the side guide to the clamp and tighten bolt (b) as shown in Figure G - 41.

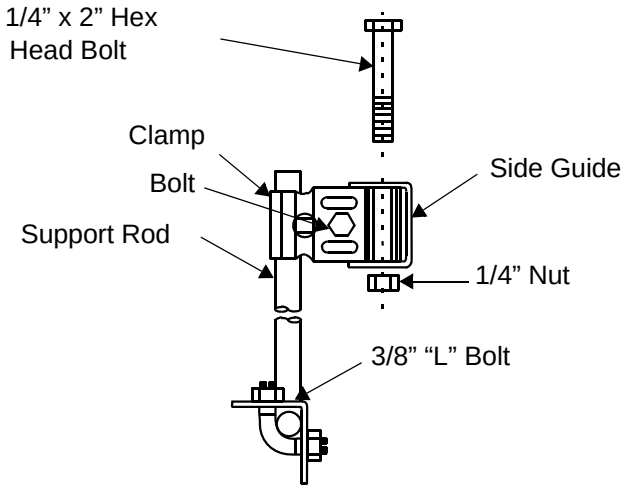


Figure G - 41 Rod Secured to Mounting Angle, Clamp Over Support Rod, Bolt Tightened

4. Follow the Splice/Connection directions below.

Splice/Connection

1. Overlap extension tabs of two adjoining rails (see Figure G - 42).
2. Bolt top flanges.

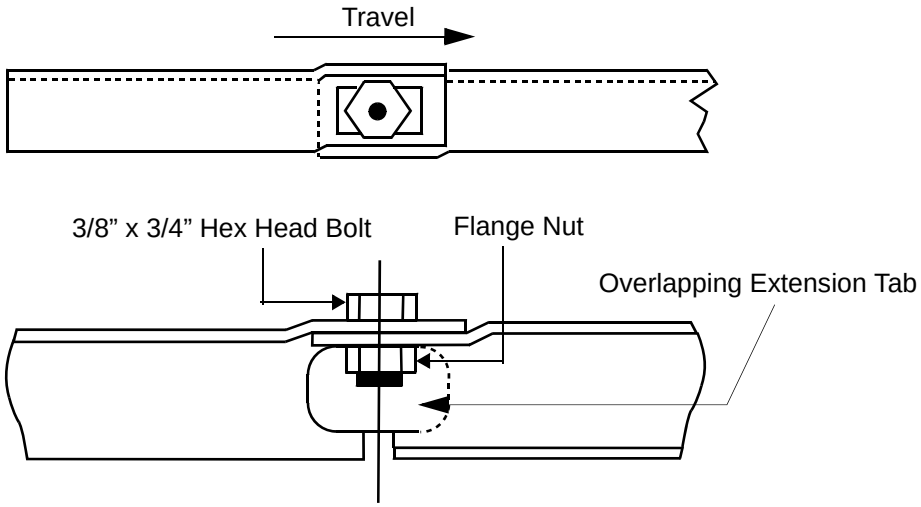


Figure G - 42 Adjoining Side Guide Hardware

Mounting Straight Adjustable Side Guides

Straight sections of adjustable side guides are 20’ long. They have a tab at each end so sections can be joined. Side guide sections must be field adjusted at power feeders, at upper bends, and near curves.

Place supports at 5’ to 6’ intervals (see Figure G - 43) along straight conveyor runs. It is not necessary to place supports in exactly the same position along each 20’ section; just be sure to place them at intervals no greater than 5’ to 6’ along the entire conveyor run. Final supports are placed at the end of a conveyor regardless of the distance between the final supports and the previous supports.

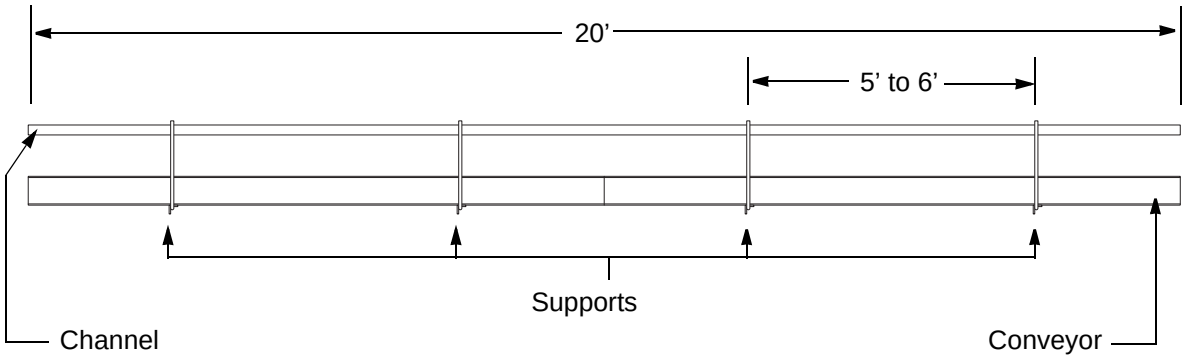


Figure G - 43 Support Spacing

Single Channel

1. Assemble the side guides and mounting hardware as shown below.
2. Adjust the channels so they stabilize the tallest products, yet do not allow the shortest products to pass underneath. Loosen the clamps to adjust the channels vertically. Loosen the “L” bolts to adjust the support rods horizontally.

Figure G - 44 shows a single channel adjustable side guide. A portion of the conveyor is removed to reveal one of the angle crossmembers bolted to the underside of the conveyor.

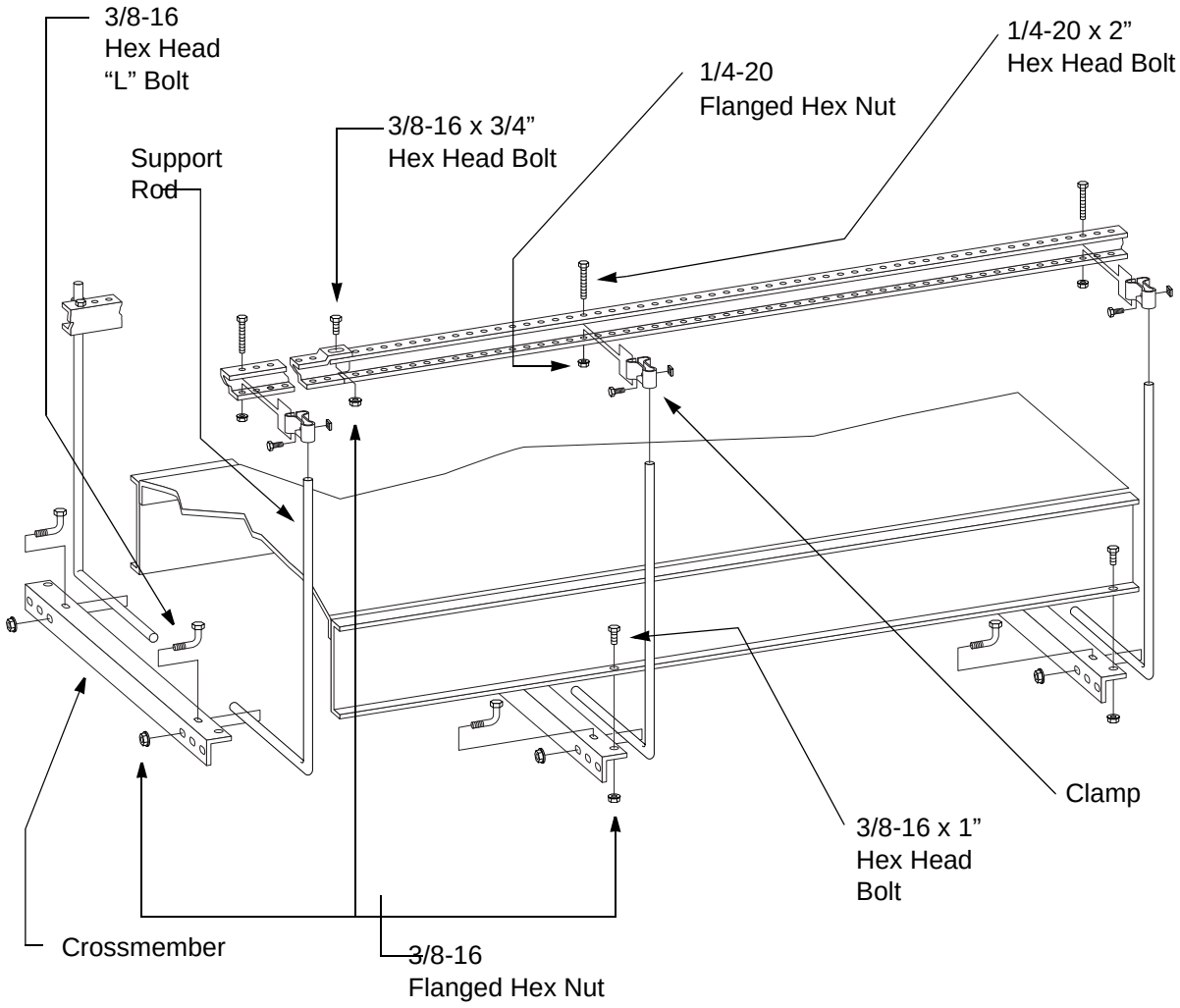


Figure G - 44 Single Channel Adjustable Side Guide (Exploded View)

Double Channel

1. Assemble the side guides and mounting hardware as shown below.
2. Adjust the upper channels so they stabilize tall products. Adjust the lower channels so short products do not pass underneath. Loosen the clamps to adjust the channels vertically. Loosen the “L” bolts to adjust the support rods horizontally.

Figure G - 45 shows a double channel side guide. A portion of the conveyor is removed to reveal one of the angle crossmembers bolted to the underside of the conveyor.

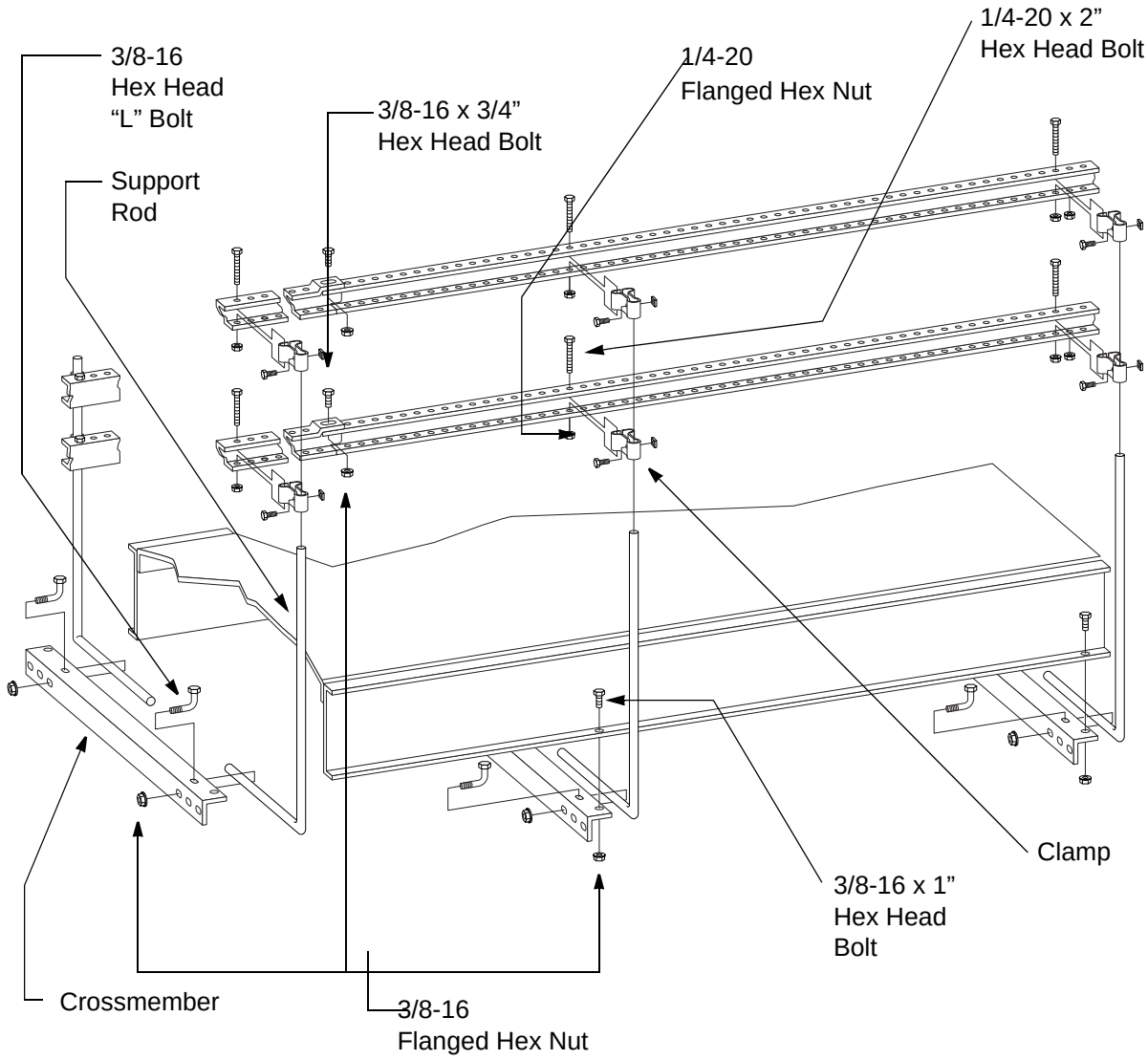


Figure G - 45 – Double Channel Adjustable Side Guide (Exploded View)

Set-in Arm

1. Assemble the side guides and mounting hardware as shown below.
2. Adjust the channels so they stabilize the tallest products, yet do not allow the shortest products to pass underneath. Loosen the clamps to adjust the channels vertically. Loosen the “L” bolts to adjust the support rods horizontally.

Figure G - 46 shows an set-in arm adjustable side guide. A portion of the conveyor is removed to reveal one of the angle crossmembers bolted to the underside of the conveyor.

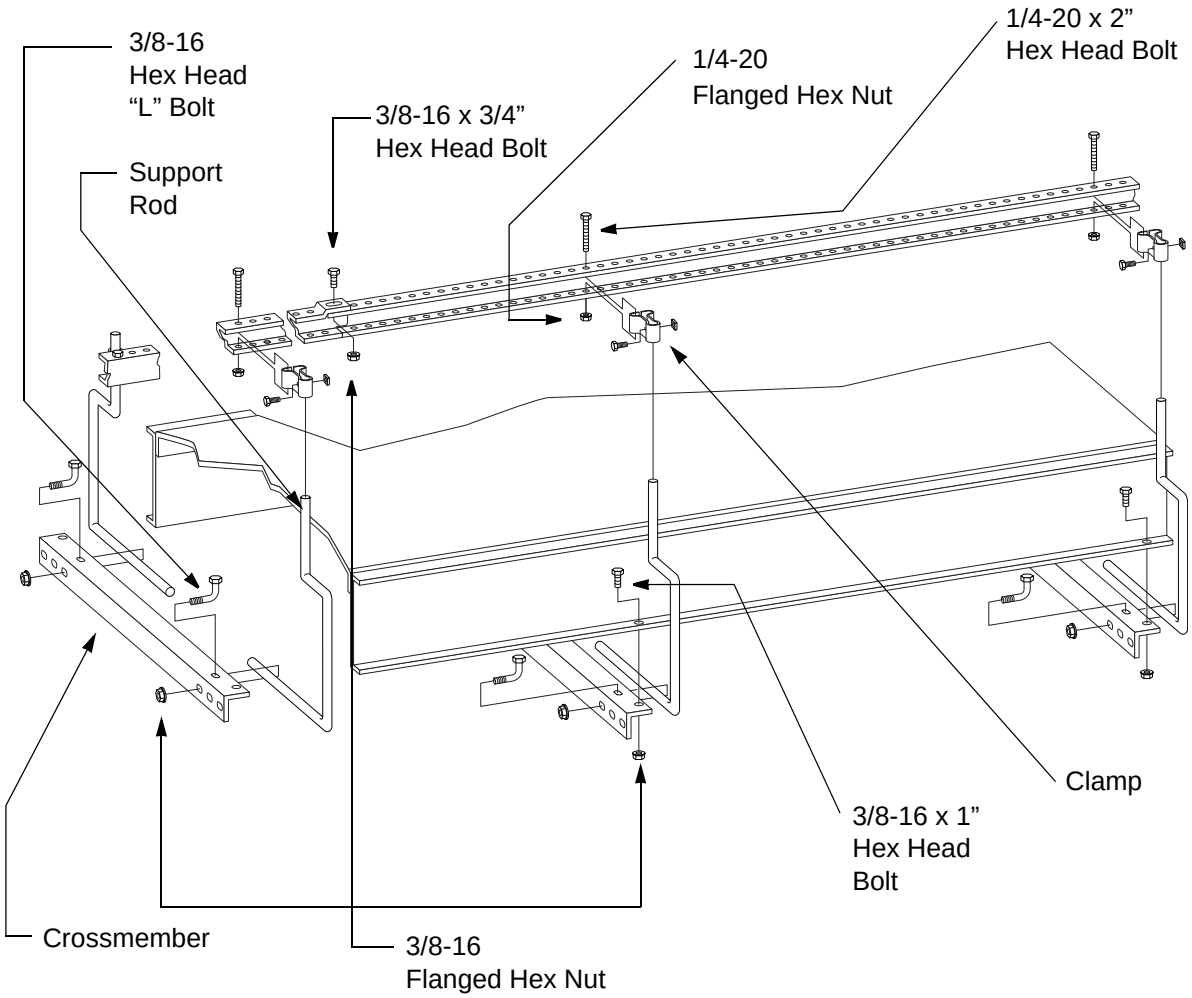


Figure G - 46 Set-in Arm Adjustable Side Guide (Exploded View)

Mounting Curved Adjustable Side Guides

Curved sections of adjustable side guides are 30°, 45°, 60° or 90°. The standard inside radius is 2’-6” with an outside radius that varies with conveyor width. True taper curves have varying inside and outside radii.

Two supports are used in curves (see Figure G - 47). The angle crossmembers securing the supports are mounted parallel to a radial line dividing the curve in half. Note that the crossmembers are parallel to the radial line (and to each other) but do not lie along radial lines themselves.

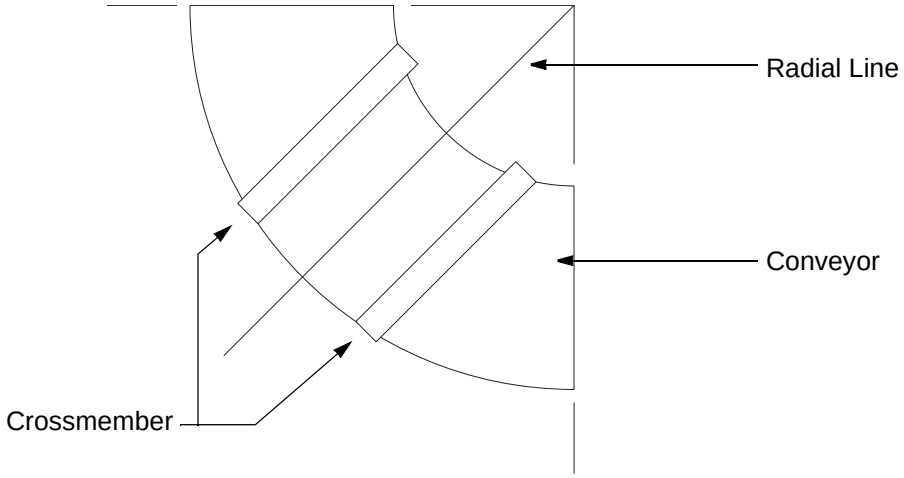


Figure G - 47 – Support Position in Curves

The preformed side guide curves may not match the radius required for side guides when using offset arms. It may be necessary to field-adjust curves in this case.

Sections of straight side guide channels must be cut to length and connected to curved sections to create S-curves.

Curves

1. Assemble the side guides and mounting hardware as shown below.
2. Adjust the channels so they stabilize the tallest products, yet do not allow the shortest products to pass underneath. Loosen the clamps to adjust the channels vertically. Loosen the “L” bolts to adjust the support rods horizontally.

Figure G - 48 shows a curved adjustable side guide. A portion of the conveyor is removed to reveal one of the angle crossmembers bolted to the underside of the conveyor.

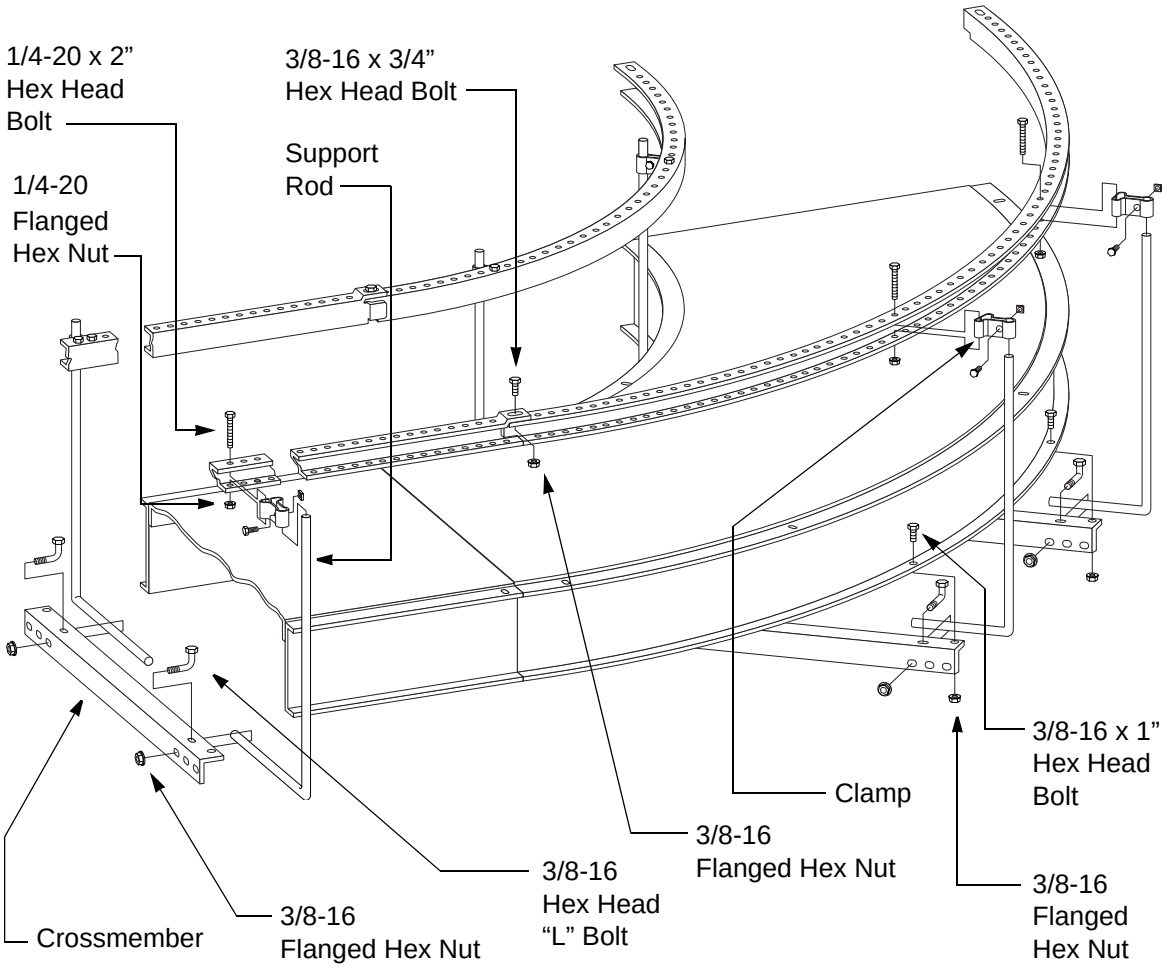


Figure G - 48 Curved Adjustable Side Guide

Junctions

Field cutting and fitting of straight and curved side guides is required.

Adjustable Side Guides for Power Feeders

While most side guides on power feeders are fixed, occasionally adjustable guides are needed. If adjustable side guides are used, the standard 20’ rails must be cut to fit before installation.

SECTION H:MAINTENANCE

Side Guides

Side guides require minimal maintenance. In your regular inspections check bolts and tighten as needed.

Check skatewheels on wheelface guides, especially if you notice that a wheel is not spinning freely. Replace as needed. See Section I, Spare Parts.

Maintenance in the Event of Jams

If box jams occur, look for rough edges on the side guides and grind burrs as needed.

Check for incorrect overlap of adjoining side guides. Note that when two side guides are coupled, the tab of the side guide that comes first (in order of product travel) must overlap the other guide on the *inside* (belt or roller side). This allows the product to move smoothly past the overlap, not catching on the overlapping piece. If the overlap is incorrect, remove the side guides and re-mount correctly.

Jams may result in bent side guides. Fix bent guides so they are upright, allowing smooth movement of products.

Paint and smooth any chipped paint. Replace guides that cannot be fixed.

General

The following paragraphs apply generally to all conveyors but do not take into account the characteristics of specific conveyors. Always refer to the Maintenance Section of the conveyor manual for specific conveyor information.

Recommended service checks and equipment maintenance are outlined below for typical, intermittent-duty conveyor applications. Additional maintenance and servicing schedule adjustments may be required for continuous-duty operation or extreme environmental conditions.

All newly installed equipment should be frequently inspected and serviced as needed during the first 40 hours of operation; thereafter, an appropriate maintenance program should be established and followed (see “Scheduled Maintenance”, on page H - 2,).

Maintaining separate service log sheets on each type of conveyor is recommended for plants operating more than one shift. Each log sheet should show dates, detailed inspection service information, and the name or initials of person(s) performing the equipment inspection or service for future reference.

WARNING: Before performing maintenance on a conveyor, make certain that the conveyor’s power disconnect is locked in the OPEN position and tagged to prevent accidental or unexpected application of power. Do not perform maintenance while the conveyor is running unless specifically instructed to do so in your conveyor manual.

Note: Other than checking the chain tension, it is NOT necessary to have the conveyor turned ON in order to perform any of the work described in the Maintenance section of your product manual. Maintenance must be performed only by qualified personnel who are trained in normal and emergency operations of the conveyor and who are knowledgeable of all safety devices, their locations, and functions.

Before restarting a conveyor:

- Remove all foreign objects from the conveyor.
- Be sure that all guards and safety devices are properly installed and working.
- Make sure that all persons are clear of the conveyor and are aware that the conveyor is about to be restarted.

Scheduled Maintenance

Intervals indicated for performing maintenance should be considered for 8-hour-per-day operation. A specific application may subject the equipment to conditions that would require more frequent maintenance. This may best be determined by performing maintenance more frequently when the conveyor is first put into operation, and then lengthening the intervals based on experience.

Table H 1: Scheduled Maintenance

	Components	Item Check									
		Lubrication	Oil Level	Tension	Wear	Alignment	Fasteners	Set Screws	Proper Position	Physical Condition	Operation
Weekly	General Structure						X			X	X
	Safety Guards/Devices								X	X	X

SECTION I: SPARE PARTS

Introduction

For side guides, skate wheels (for wheelface side guides) are the only spare part that need to be available.

Keeping replacement parts on hand is necessary for a solid preventative maintenance program and to minimize the chances for extended DOWN TIME.

Skatewheels

Wheelface Side Guides, Straight and Curved Sections

The skatewheels are found in all of the wheelface side guides, listed here:

- Type B (2 5/8” high channel) 6’ - 0” long straight
- Type B (2 5/8” high channel) 30° junction
- Type B (2 5/8” high channel) 45° junction
- Type C (7” high channel) 6’ - 0” long straight
- Type C (7” high channel) 30° junction
- Type C (7” high channel) 45° junction
- Type D (10” high channel) 6’ - 0” long straight
- Type D (10” high channel) 30° junction
- Type D (10” high channel) 45° junction

Figure I - 1 shows the skatewheels set into a Type C (7” high channel) side guide.

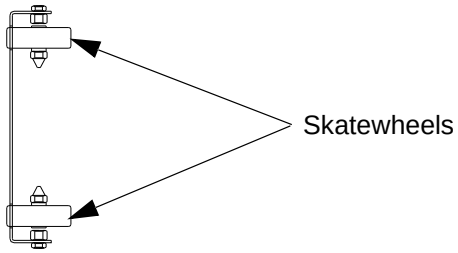


Figure I - 1 Skatewheels as Shown on Type C (7” channel) Wheelface Side Guide

Table I 1: – Skatewheels and Fasteners

PART DESCRIPTION	PART NUMBER
1.938 x 1/4” B SKTWHL YLW ZNC RC	1000422