

# Chain Cross Transfer Maintenance & Service

This section will describe service procedures for major mechanical elements of a chain cross transfer.

## ⚠ WARNING ⚠

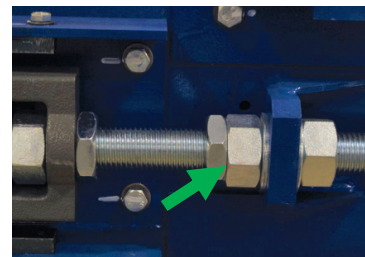
- Only qualified and trained personnel should perform the disassembly and assembly of electrical and mechanical components.
- Before attempting any maintenance on this equipment all involved personnel should follow plant internal regulations along with any state, federal, or province regulations. Do not begin any repair procedure until the proper shutdown procedures and the appropriate power lockout procedures have been applied.

## Chain Tension Adjustment

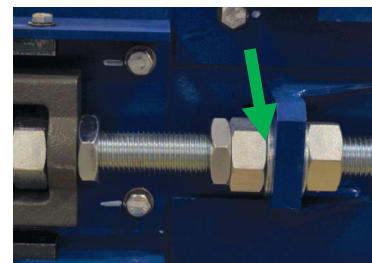
- 1 Remove and lock out power to the Cross Transfer using your plant's procedures.



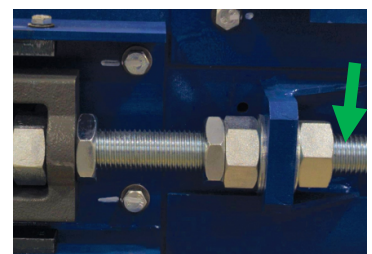
- 2 Loosen the locking nut on both sides of the Cross Transfer Take-Up.



- 3 Loosen the inside nut evenly on both sides of the Cross Transfer Take-Up until the chain is at the required tension.



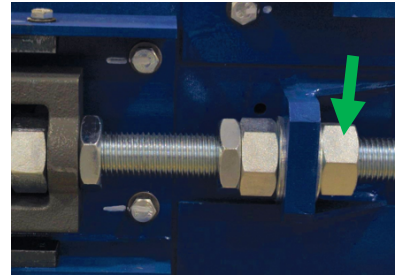
- 4 Tighten the outside nut evenly on both sides of the Cross Transfer Take-Up.



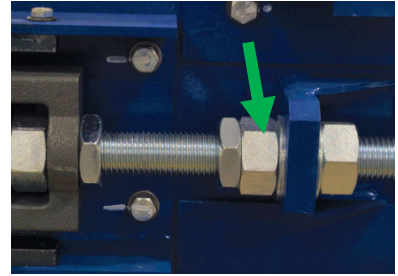
LOOSENING THE CHAIN

CHAIN CROSS TRANSFER – MAINTENANCE & SERVICE

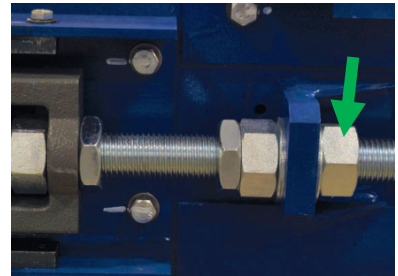
- 5 Loosen the outside nut evenly on both sides of the Cross-Conveyor Take-Up.



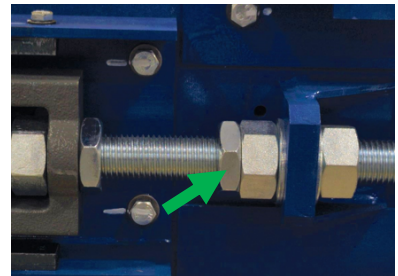
- 6 Tighten the inside nut evenly on both sides of the Cross-Conveyor Take-Up until the belt is at the required tension.



- 7 Tighten the outside nut evenly on both sides of the Cross Transfer Take-Up.



- 8 Tighten the locking nut on both sides of the Cross-Conveyor Take-Up after both the inside and outside nuts are both tight and the chain is properly tensioned.



- 9 Restore power to the system and test for proper operation.

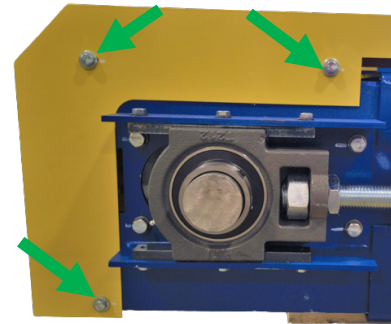


## Replacing the Chain

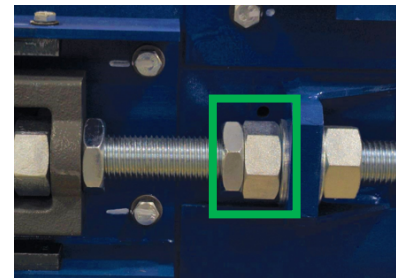
- 1 Remove and lock out power to the Cross Transfer using your plant's procedures.



- 2 Remove the guards for the Chain.



- 3 Undo the hexagonal head nuts on the tension unit to slacken the Chain.



- 4 Open the connecting link of the chain.



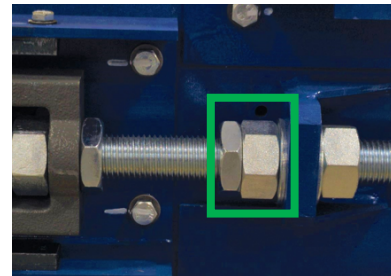
- 5 Replace the Chain and check the number of chain link before installation it.



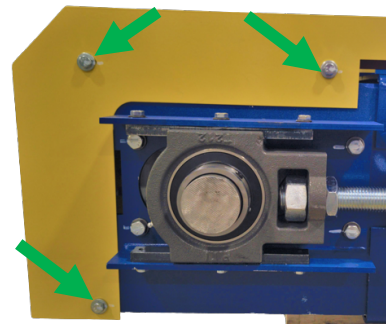
- 6 Refit the connecting link to join the chain.



- 7 Tighten the hexagonal head nuts to tension the Uni-Chain until the chain can be deflected by the thickness of a finger.



- 8 Return the guards for the Chain and secure the bolts.



- 9 Restore power to the system and test for proper operation.



## Replacing a Cardan Shaft

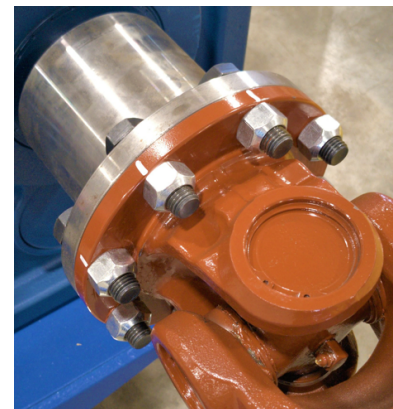
- 1 Remove and lock out power to the Cross Transfer using your plant's procedures.



- 2 Undo the M8 bolts securing the guard over the cardan shaft.



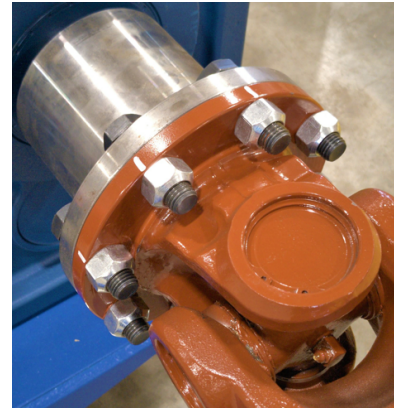
- 3 Remove the bolts securing the cardan shaft to the companion flanges on both ends.



- 4 Remove and replace the cardan shaft.



- 5 Return and tighten the bolts securing the cardan shaft to the companion flanges on both ends.



- 6 Replace and tighten the M8 bolts securing the guard over the cardan shaft.



- 7 Restore power to the system and test for proper operation.



## Replacing the Gearmotor

- 1 Remove and lock out power to the Cross Transfer using your plant's procedures.



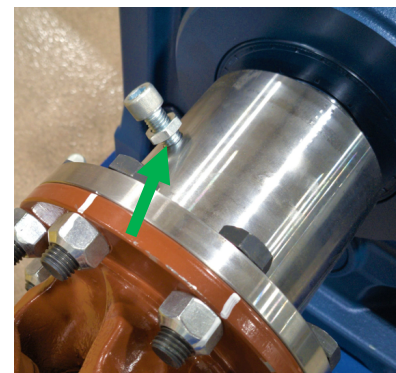
- 2 Disconnect the gearmotor cabling.



- 3 Undo the M8 bolts securing the guards over both cardan shafts.

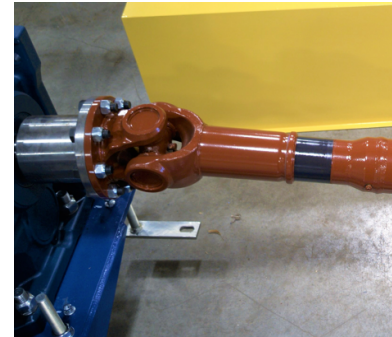


- 4 Loosen the lock nuts and set screws from the companion flanges at the gearmotor ends for both cardan shafts.

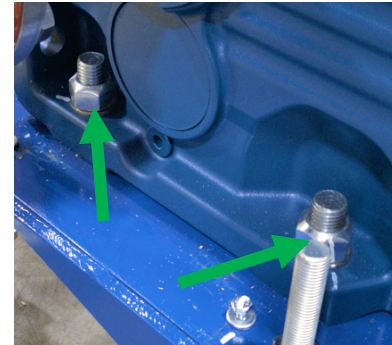


- 5 Pull the cardan shafts away from the gearmotor to free the companion flange from the gearmotor shaft.

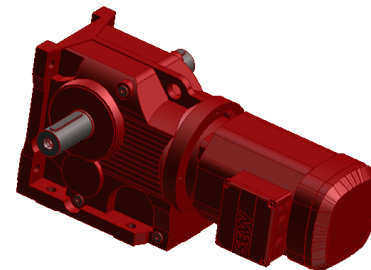
*Note: Retain the shaft key for reuse if in good condition.*



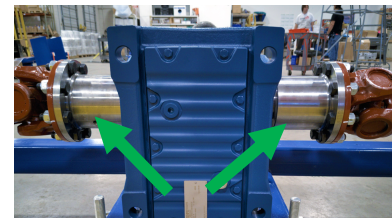
- 6 Remove the M24 bolts (4) securing the gearmotor to the base plate.



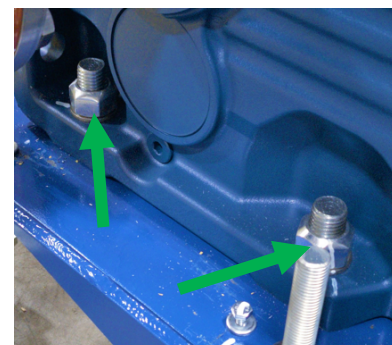
- 7 Replace the original gearmotor with the new one.



- 8 Set the companion flange on the gearmotor shaft with the shaft key for both sides.

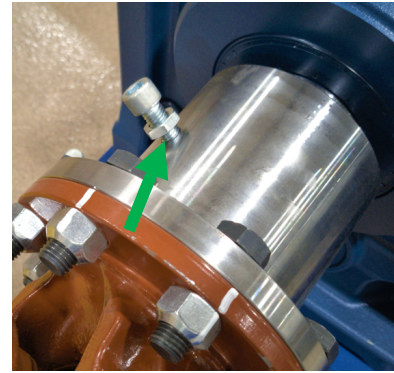


- 9 Hand-tighten the M24 bolts (4) at the gearmotor base.

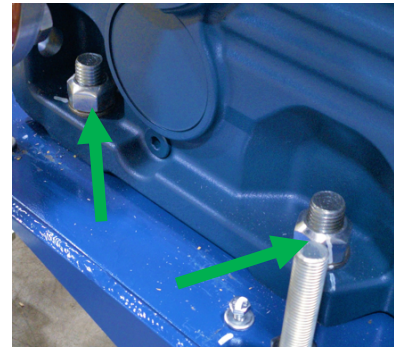




- 10** Tighten the set screws and lock nuts for the companion flanges at the gearmotor ends for both cardan shafts.



- 11** Torque the M24 bolts (4) securing the gearmotor to the base plate.



- 12** Place the cardan shaft guards on and tighten the M8 bolts.



- 13** Reconnect the gearmotor cables, restore power to the system, and test for proper operation.

