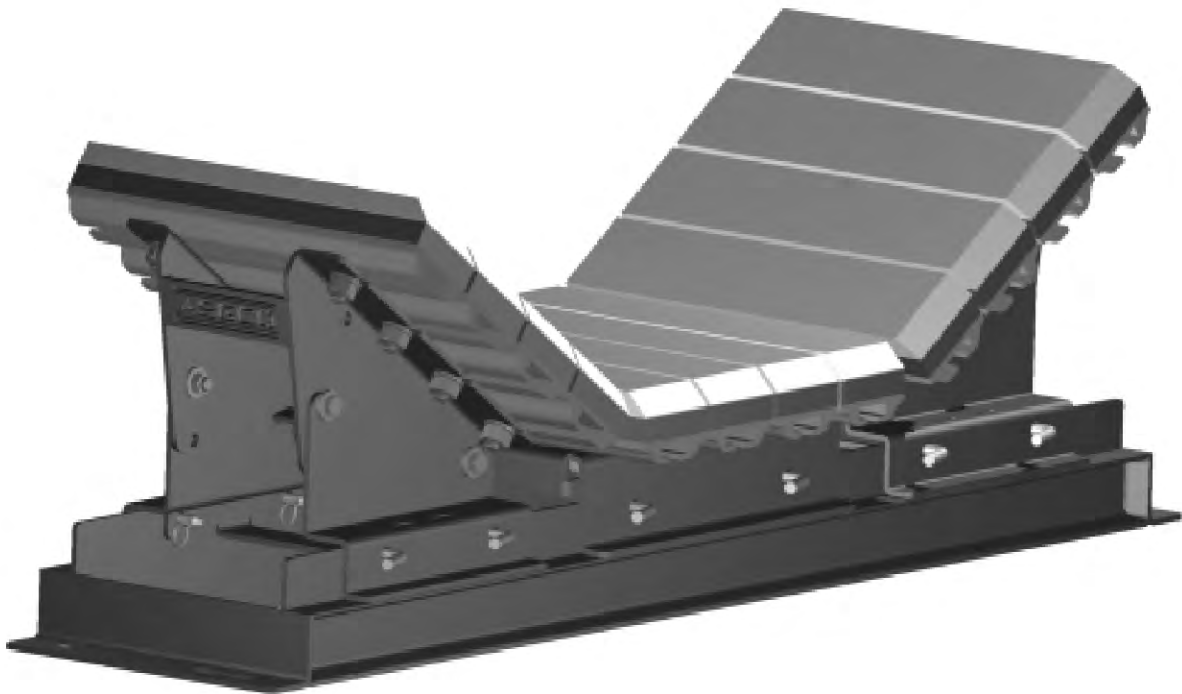




MODULAR IMPACT BEDS

INSTALLATION, OPERATION & MAINTENANCE INSTRUCTIONS



Check us out at
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Important Safety Notice

Always observe the basic rules of safety when working with any conveyor system. To avoid injury and equipment damage, be sure that all controls to the conveyor are locked out and the power source is disconnected at all times during installation.

Very Important:

Before burning or welding, remove all flammable materials located around and below your work area so that they cannot be ignited by hot sparks or slag. Post a fire watch if you cannot see all area affected by sparks or slag. Keep a fire extinguisher and a first-aid kit on hand at all times.

To avoid serious injury, be sure that all controls to the conveyor are locked out and the power source is disconnected at all times while working on the Modular Impact Beds or any part of the conveying system.

Never attempt any installation or service procedures with the power on.

Items Needed For Installation:

Carpenter's Square
Tape Measure
Torch or Drill With Bits
Bolts, Nuts, and Washers for bolting support frames to structure.
Wrenches

Modular Impact Bed Assembly:

ASGCO Modular Impact Beds are made up of four main components: Two Adjustable Troughing Wing Sections, Center Impact Section (or Center Roll Section), and the Base Frame.

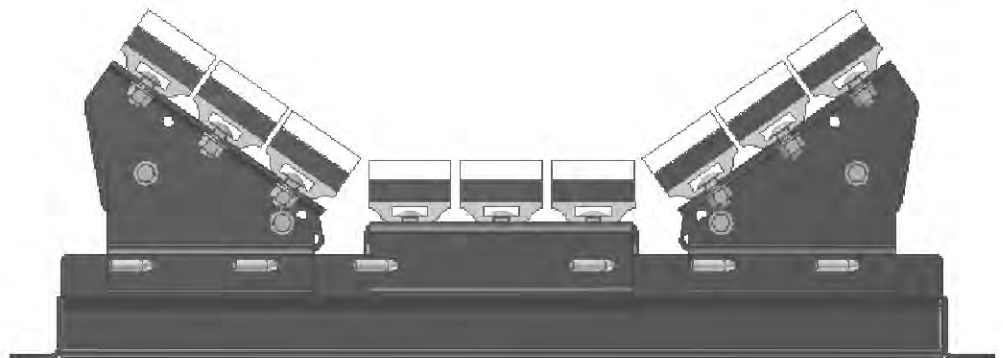


Figure 1.
Complete Modular Impact Bed

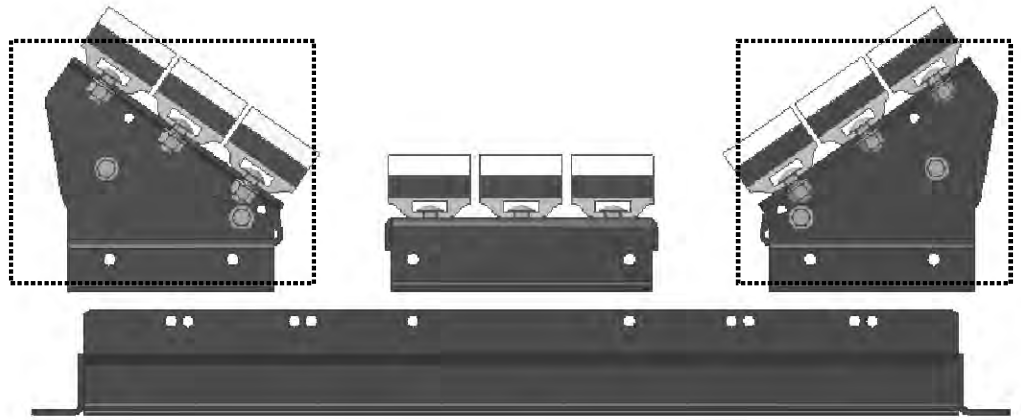


Figure 2.
Two Adjustable Troughing Wing Sections

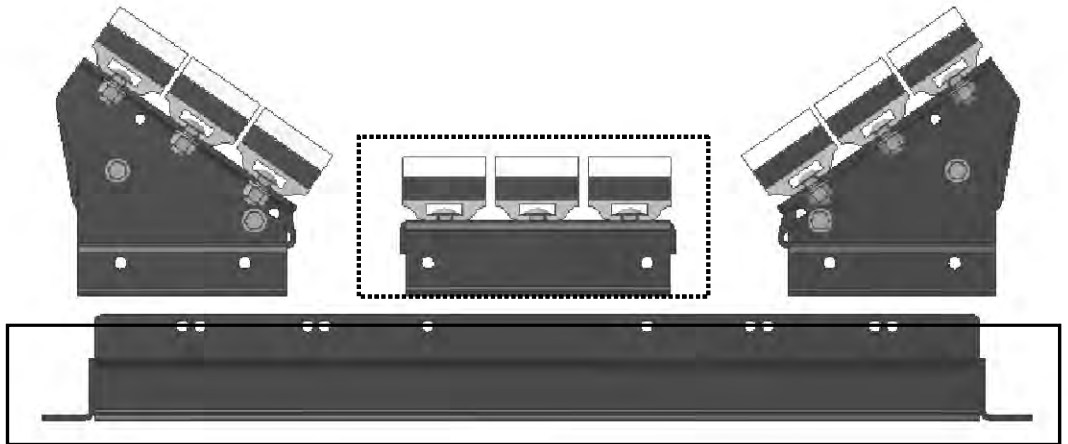


Figure 3.
Center Impact Section (Dashed Rectangle) and Base Frame (Solid Rectangle)

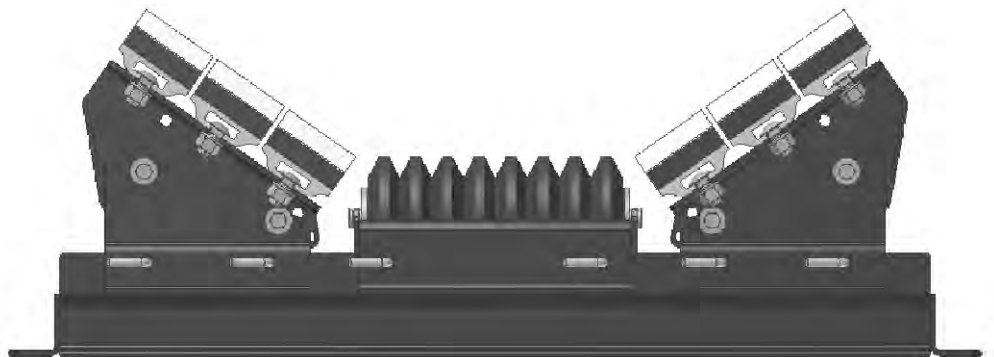


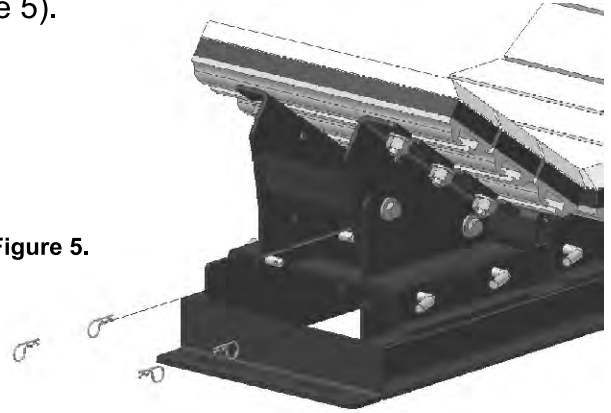
Figure 4.
Complete Modular Impact Bed with Center Impact Roll Section

Modular Section Removal:

The Adjustable Troughing Wing Sections and Center Impact Section (or Center Roll Section) of the Modular Impact Beds are easily removed for Impact Bar or Roller replacement and general system maintenance.

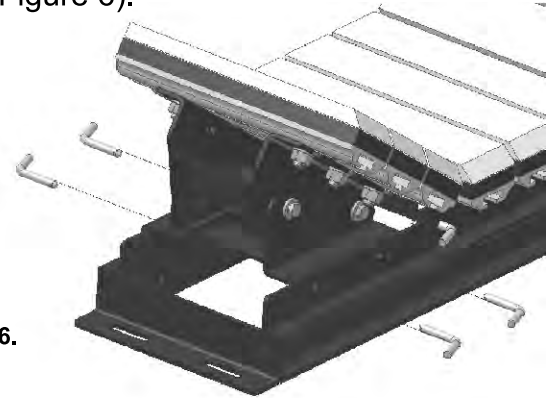
- 1.)** To remove the Adjustable Troughing Wing Sections, it is first necessary to remove the four hairpin cotter pins from the bent hitch pins (See Figure 5).

Figure 5.



- 2.)** Now pull the four bent hitch pins out from the side. The hitch pins hold the Adjustable Troughing Wing Sections from sliding on the Base Frame (See Figure 6).

Figure 6.



- 3.)** The Adjustable Troughing Wing Section can now be carefully slid off the Base Frame (see Figure 7).

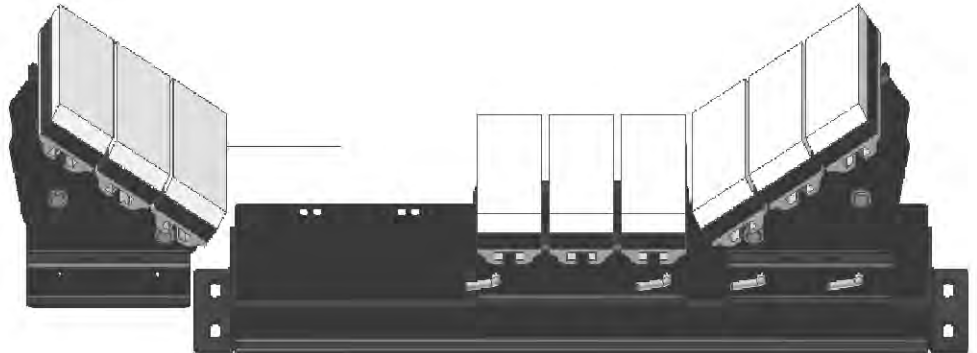


Figure 7.

- 4.)** Repeat Steps 1-3 to remove the second Adjustable Troughing Wing Section and the Center Impact Section (or Center Roll Section).

Troughing Angle Adjustment:

Modular Impact Beds can be adjusted to three distinct troughing angles, 20, 35 and 45 degrees. The wing sections can be adjusted for troughing angle by changing the locations of the four angle adjustment hex head bolts. There are three sets of adjustment holes on both the wing top and wing bottom weldments (see Figure 8).

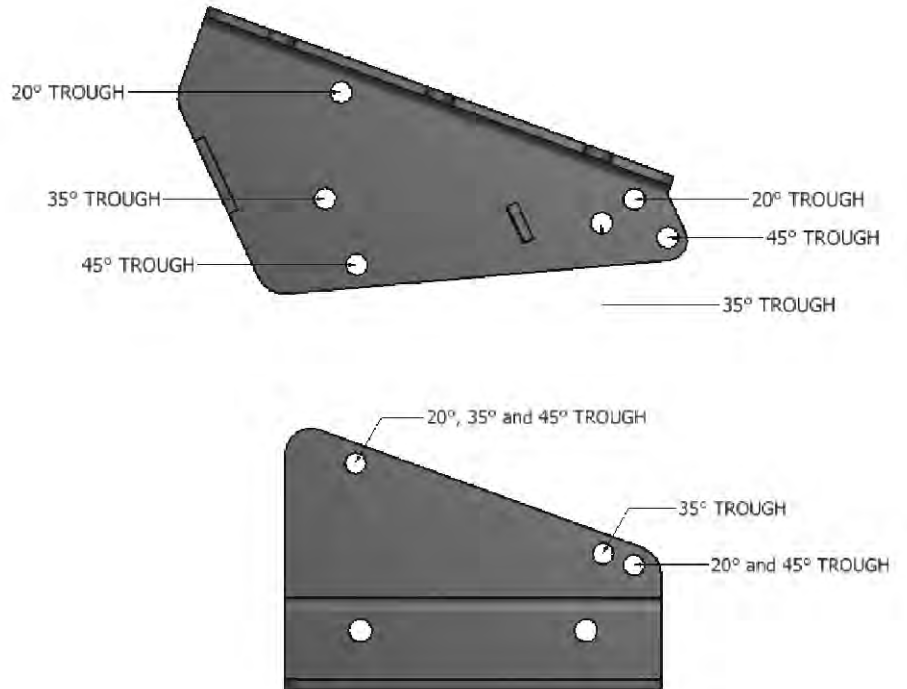


Figure 8

When adjusting to 35 or 45 degree troughing angles it is necessary to adjust the wing sections on the sliding track of the Modular Impact Bed Frame to the outermost holes and insert the four hitch pins (see Figure 9).

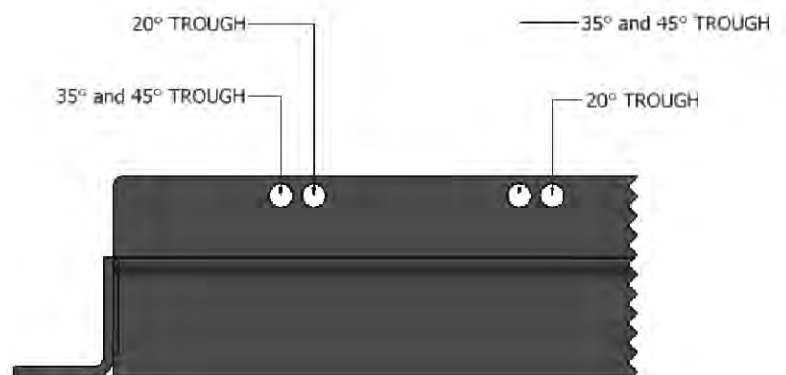


Figure 9

**Modular Impact Bed
Rules to Always
Follow:**

- 1.) Always have a Troughing Idler of the same degree of trough as that of the Modular Impact Bed, just before the Modular Impact Bed (see Figure 10).
- 2.) Modular Impact beds are designed to be 1/4" below the bottom surface of the belt as measured at the top of the center roll of the Troughing Idler just before and just after the Modular Impact Bed. It may be necessary to make shims to raise the troughing idlers before and after the Modular Impact Beds, to obtain the 1/4" of clearance (see Figure 11).
- 3.) Always have a Troughing Idler of the same degree of trough as that of the Modular Impact Bed, right after the Modular Impact Bed.

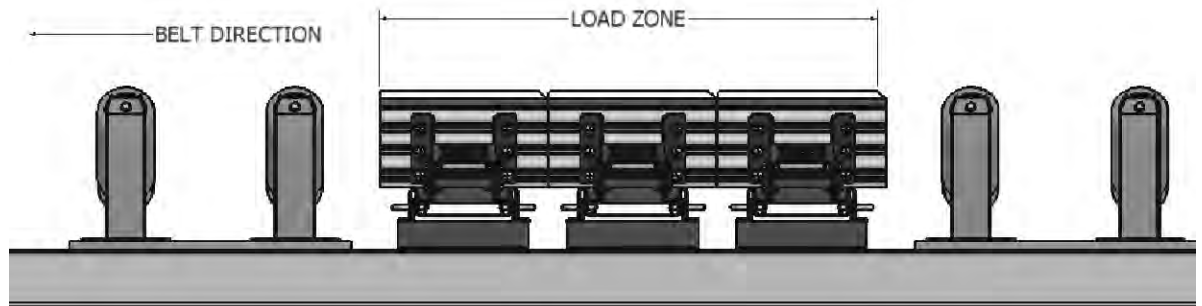


Figure 10.

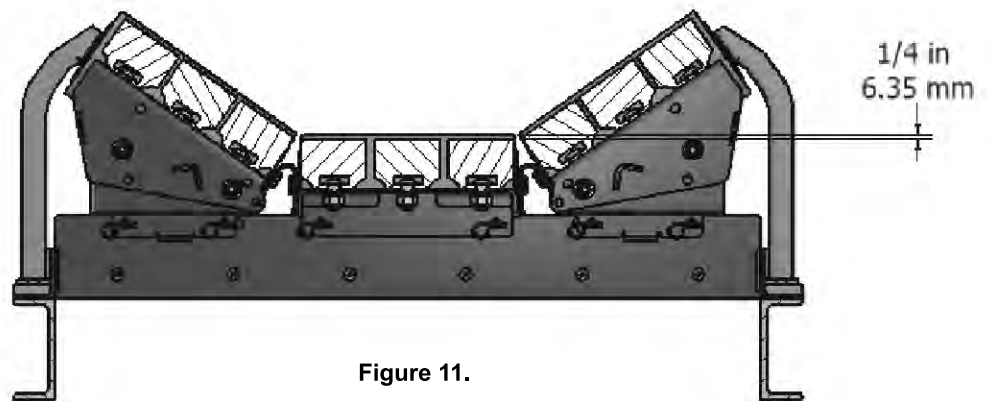


Figure 11.

Location Selection:

Modular Impact Beds are designed to be installed in the load zone / skirted zone area of a conveyor belt. Typically the Modular Impact Beds will begin approximately 4" from the closest existing troughing idler just prior to the load zone.

Installation:

- 1.)** Remove the existing Troughing Idlers where the Modular Impact Beds will be installed.
- 2.)** Measure approximately 4" from the side of the troughing idler which will be just before the Modular Impact Bed. This line will be the start of the Impact Bars (see Figure 12). Measure 9" from this line to mark the center line of the first Modular Impact Bed.
- 3.)** Square across the conveyor frame to mark the opposite side of the frame for the centerline mark.
- 4.)** Layout the location of the mounting holes on the conveyor frame by marking $2 \frac{3}{8}$ " - $4 \frac{1}{2}$ " from each side of centerline. Drill or torch $11/16$ " - diameter holes in the conveyor frame for mounting the Modular Impact Beds, using four bolts to secure.
- 5.)** Modular Impact Beds are designed to be spaced at 18" centers along the load zone / skirt zone of the conveying system.
- 6.)** The last Modular Impact Bed should be followed by the next troughing idler approximately 4" away from the Impact Bars (see Figure 12).

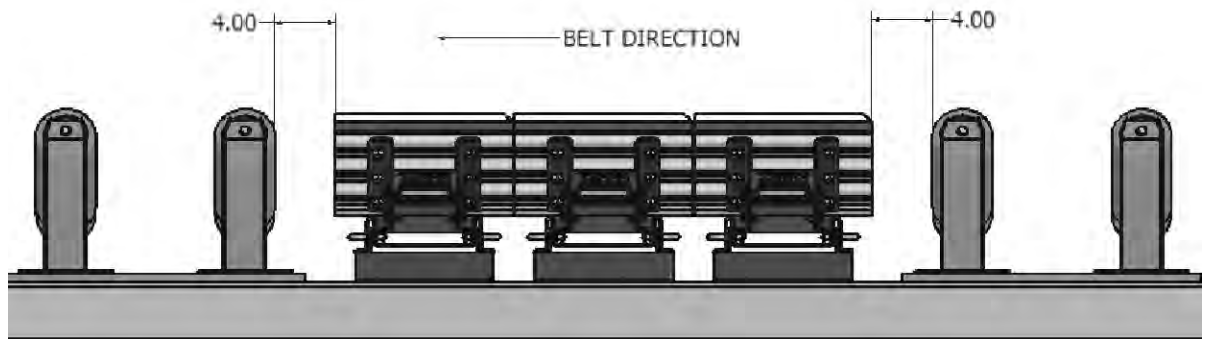


Figure 12.

MAINTENANCE

Modular Impact Beds maintenance is typically limited to visual inspection for loose nuts and bolts, an occasional inspection to determine the wear of the Impact Bars and the condition of the center roll if equipped.

The wear of the Impact Bars will normally be concentrated near the center of the Impact Zone. The ends of the bars will not be as worn because the roller before and after the Modular Impact Bed will prevent the belt from contacting the bars as heavily.

To inspect for the wear the center of the bed must be measured by reaching to the center of the bed and using a tape measure between the Impact Bars. Measure the thickness of the innermost bar of the bed.

The Impact Bars should be replaced when the remaining thickness of the white UHMW is approximately at 1/4".

Modular Impact Beds with Center Roll Sections should be checked visually and by hand to verify the roller is still spinning freely on its bearings. A frozen or worn roller should be replaced immediately.

Information

Component	Description	Part Number
Modular Impact Replacement	Rail 3" x 4" X 18", Impact Bar	ASG-IBRAIL-RU-1-18
Carriage Bolt	5/8" - 11, Carriage Bolt	AS-BOLT-5/8X2-CAR-G5
Flat Washer	5/8", Flat Washer	ASG-FW-5/8
Lock Washer	5/8", Lock Washer	ASG-LW-5/8
Hex Head Nut	5/8" - 11 - G5, Hex Head Nut	ASG-NUT-5/8G5
Complete Modular bed Frame	Modular Impact Bed Frame	MIB-FRAME-BW-ADJ [BW] = Belt Width
Bent Hitch Pin	Modular Hitch Pin with Cotter Pin	ASG-MOD-HP

Call your ASGCO Distributor for any questions or replacement parts