



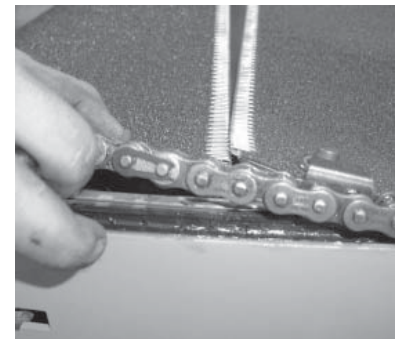
Instructions for Replacing Aluminum Upper Guide Assembly With Steel Upper Guide Assembly

Read all instructions carefully before removing existing aluminum upper guide assembly. The steel upper guide assembly is a permanent replacement to the aluminum upper guide assembly. See page three for options available to the installer of the steel upper guide assembly: A) Riveting; B) Self-Tapping Screws; 3) Welding.

1. Remove the outside radius sideguard(s), chain cover(s) and end caps.



2. Rotate the belt around the conveyor bed, until the seam of the belt is visible and easily accessible. Locate the master link for the chain (near the seam of the belt). Using needle nose pliers, remove the clip on the master link and the belt lacing pin. Fold the conveyor belt back to expose the entire upper chain guide assembly. On endless belts, fold the belt back toward inside radius and secure away from guide.



3. Mark the location of the end roll assembly bearings to assist with relocating to their original position upon reassembly. Remove the bearings and end roll assembly on the non-drive end.

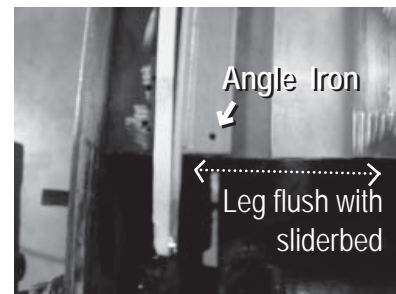
Safe practice requires that if the conveyor is to be opened for inspection, cleaning, maintenance or observation, the electric power to the motor driving the conveyor must be LOCKED OUT/TAGGED OUT in such a manner that the conveyor cannot be restarted by anyone; however remote from the area, until conveyor cover or guards and drive guards have been properly replaced.



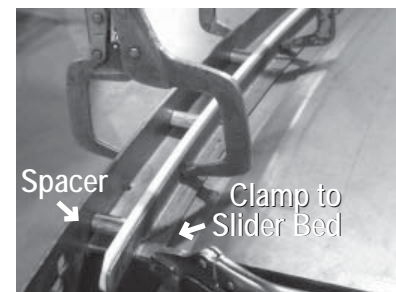
4. Replace the entire upper chain guide bracket by removing the upper horizontal guide strip and drilling out the pop rivet fasteners. This will disengage the bracket from the slider bed. Remove the aluminum upper chain guide assembly completely from the sliderbed. Ensure that all existing hardware is removed from the conveyor to prevent potential damage upon start-up.



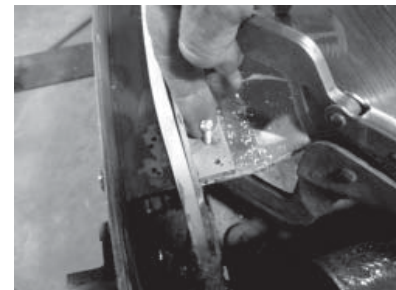
5. Place the angle iron so that the notched out horizontal leg is flush with one end of the sliderbed.



6. Using the metal spacers included with kit as a measurement guide, clamp the steel upper chain guide to the sliderbed. Spacing should be 1-7/16" from the inside of the outside radius frame to the outside radius of the rolled vertical leg of the angle iron.



7. Drill two 3/16" holes through the angle iron and sliderbed. The holes should be 1/2" and 1" from the end of the angle iron notch. Use two 10-24 x 5/8" bolts (Portec p/n 213133) with nylock nuts (Portec p/n 219017) and fasten the angle iron to the sliderbed.





Optional Methods For Installing Steel Upper Guide Assembly

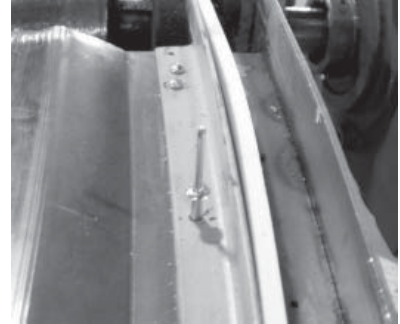
A. Rivet Installation Instructions

Use the spacers provided and clamp to ensure the 1-7/16" spacing (Step 6) until entire length of angle iron has been drilled and secured.

Drill 3/16" holes through the sliderbed, using existing holes in the angle iron horizontal leg as a guide. Drill no more than three holes before starting to place the steel pop rivets that have the shorter mandrel (Portec p/n 190109) through the drilled holes. Continue to drill and rivet until reaching end of angle iron. Secure the last two holes with the same procedure as the starting end, Step 7 (Drill two 3/16" holes through the angle iron and sliderbed. The holes should be 1" and 1½" from the end of the angle iron notch. Use two 10-24 x 5/8" bolts with nylock nuts and fasten the angle iron to the sliderbed.)

Note: Mandrel break load for 3/16" steel rivets is 1150 lbs. Minimum and 1450 lbs. Maximum.

Go to step 8 to complete upper guide assembly installation.



B. Self-Tapping Screw Installation Instructions

Use the spacers provided and clamp to ensure the 1-7/16" spacing (Step 6) until entire length of angle iron has been drilled and secured.

Drill 11/64" holes through the sliderbed, using existing holes in the angle iron horizontal leg as a guide. Drill no more than three holes before securing with 10-24 x 3/4" self-tapping screws (included with kit). Continue to drill and tap until reaching end of angle iron. Secure the last two holes with the same procedure as the starting end, Step 7 (Drill two 3/16" holes through the angle iron and sliderbed. The holes should be ½" and 1" from the end of the angle iron notch. Use two 10-24 x 5/8" bolts with nylock nuts and fasten the angle iron to the sliderbed.)

Go to step 8 to complete upper guide assembly installation.



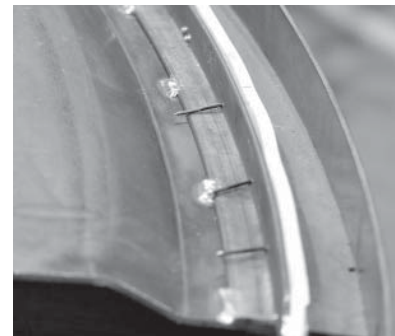
C. Welding Installation Instructions

Use the spacers provided and clamp to ensure the 1-7/16" spacing (Step 6) until entire length of angle iron has been stitch welded and secured.

Weld the end of the angle iron to the sliderbed and then weld 1" stitches every 6 - 8" to secure into position. After welding other end of the angle iron, go to Step 10 to complete upper guide assembly installation.

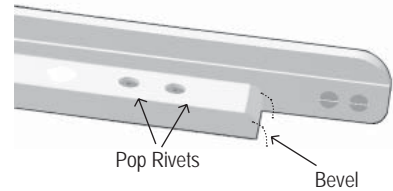
Note: Angle may tend to pull up at the outer most edge. Correct position as progress is made around the curve.

Go to step 8 to complete upper guide assembly installation.

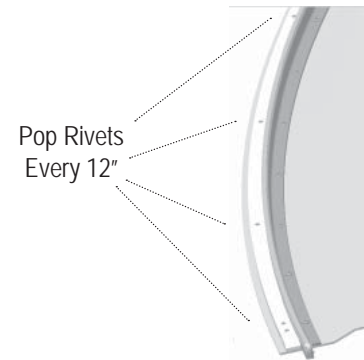




8. Take the horizontal HMW chain guide strip included in the assembly kit (13/16" wide x 3/8" thick) and taper/bevel the end with a file, knife or sander.



9. Position the horizontal guide strip tight against the vertical guide strip and flat against the conveyor sliderbed. Drill 3/16" holes through both the center of the guide strip and the conveyor sliderbed. Counter sink all holes 1/8" deep into the guide strip. Insert two pop rivets 1" and 1-1/2" from end of strip. Using the pop rivets with the longer mandrel (Portec p/n 190110), secure the horizontal guide to the sliderbed. Insert a pop rivet approximately every 12".



10. If more than one horizontal chain guide strip is required to complete installation, bevel the joint ends and place one pop rivet 1" from each end. To finish, cut the guide material flush with end of the sliderbed, bevel end and then secure the last two holes at the end of the sliderbed with the same procedure as the starting end.



11. Trim exposed nail points flush with steel vertical guide.





12. Re-install the end roll assembly and bearings.
 13. Lubricate guide by placing a 1/8" bead of Lubriplate Molith #2 grease (or an acceptable alternative*) in the groove of the upper vertical guide strip.
 14. Reposition the belt chain into the newly installed chain guide.
 15. Reassemble the belt chain using the connecting-link and the belt lacing pin.
 16. Check the alignment of the belt chain and sprockets to the new chain guide. Adjust the belt chain tension and sprockets position if necessary. Refer to the Owner's Manual or the Portec website for this process.
 17. Reinstall the end caps, chain cover(s) and the outside radius sideguard(s).
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3/16" Pop Rivets



Part Number 190109



Part Number 190110

**Portec recommends Lubriplate Mo-Lith No. 2 as a primary friction barrier lubricant. If it is not available, a lubricant of equivalent quality should be chosen. Call the plant or refer to the Portec website for a list of acceptable alternative lubricants.*