

OWNER'S MANUAL



“ChuteMaster[®]” **Fiberglass Spiral Chute** **PORTEC INC.**

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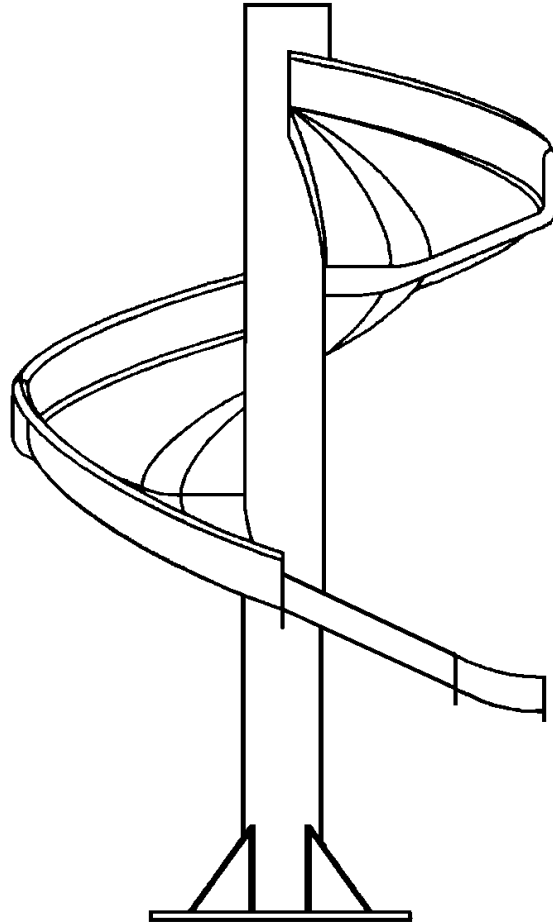
Chute Location: _____
Model Number: _____
Serial Number: _____

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General Description of the Chutemaster Spiral Chute

The Chutemaster is a fiberglass molded component spiral slide, designed to quickly and economically convey products to a lower level. The components are molded from high quality hand-laid fibers and resins coated with a scuff resistant gel-coat. The gel-coat and resins are designed to give years of service with proper use and application. Proper installation, maintenance,, and cleaning will assure that the Chutemaster will continue to provide satisfactory service.



ChuteMaster with straight exit slide and scoop

Installation

- A. Pre-assembled units

Units pre-assembled with a one-piece center pole must be mounted to a solid floor or surface. The steel base/pole assembly contains four leveling jack bolts and anchor bolt holes. The pole must be plumbed and the base anchored with 3/4 inch grade 5 or better bolts (not provided). Units with a multi-piece center pole must have the bottom piece (No. 1) mounted per one-piece center pole units. The upper units, in sequence, must be properly aligned with the lower flange of the upper profile matching the upper flange of the lower profile. The center pole of the upper unit fits over the sleeve of the lower center pole and fastens with 1/2 X 1 inch grade 5 bolts (provided). The profile flanges fasten together with 5/16 X 1-1/4 inch bolts, flat washers, lock washers and nuts (provided). The running surface edges must be aligned with the upper surface slightly higher (water fall effect) than the lower surface. The tolerance for this is 1/16 in. to 1/4 in. (1.6-6.3 mm).

B. Unassembled units

Model CM 51 chutes are the only units that are normally shipped unassembled. Models CM 18, 25 and 35 are shipped unassembled only at customer request. The assembly process is similar for models CM 51, CM 18, CM 25 & CM 35 in that all fiberglass components are mounted directly to a center pole.

B1. Model CM 51 assembly.

For ease of assembly, it is recommended that assembly of the fiberglass components to the center pole be done with the center pole in a horizontal position. Support the ends of the pole solidly on supports high enough for the fiberglass pieces to clear the floor. All fiberglass components have been pre-mounted at the factory and numbered accordingly. Fasten the fiberglass profile components to the center pole, starting with No. 1 at the bottom, using the 3/8-in. predrilled holes and 3/8in. X 1 in. bolts, lock and flat washers (provided). The profile flanges fasten together with 5/16in. X 1-1/4 inch bolts, flat washers, lock washers and nuts (provided), The running surface edges must be aligned with the upper surface slightly higher (waterfall effect) than the lower surface. The tolerance for this is 1/16in. to 1/4 in (1.6-6.3 mm).

It is recommended that the custom fabricated entry slide be mounted after the pole is in the upright position. If this is not possible, attach the entry slide in the proper location to the pole using the hardware provided (same as the profile hardware).

Carefully raise the assembly into an upright position using the eye-hook at the top of the pole. **Do not attach any lifting devices to the fiberglass when lifting the assembly into place.**

Position the assembly in the correct orientation, plumb the pole (using the four leveling jack bolts in the base), and mount the assembly to the floor with 1/4in. grade 5 or better bolts (not provided).

Attach any custom exit components (exit transition, scoop, etc) to either the No. 1 profile or the center pole as required. Be sure that the upper end of the exit pieces are lower (1/16 to ¼ in.) (1.6-6.3 mm) than the bottom edge of the upper component.

Service and Maintenance

The fiberglass chutes are relatively maintenance free. However residue build-up from packaging dust, excess glues etc. will require periodic cleaning to assure that residue build-up does not interfere with product flow. Mineral-based cleaners (solvents, paint thinners, acetone etc.) are acceptable for cleaning. Household detergents are also acceptable, however harsh bleaches and abrasive cleaners will scratch the surface and increase the friction, thus impeding the product flow. Cleaning solutions must be applied with a soft cloth or disposable towel. **Scouring or scratch pads should not be used.** Applying Armor-All brand (or equivalent), silicone or Auto wax will increase product speed and is an acceptable option.

Vibrations from normal use may loosen the attachment bolts. After one month of operation, it is recommended that all fasteners be checked and re-tightened. Annually check the running surface alignment and retighten any loose fasteners

Applications and Use

Portec chutes are manufactured with a scuff resistant Gel-Coat to increase the life expectancy of the fiberglass. However extreme care should be taken to protect the surface from objects with sharp edges or abrasive surfaces. When conveying such objects it is recommended that they be placed in a plastic or other type protective container prior to entry onto the chute. The total weight conveyed should be limited to 50 pounds per foot (75 kg/m) on all models. If possible, it is recommended that the entry speed be controlled to lessen the force of initial impact against the side of the chute.

Safety Precautions

Prior to servicing or cleaning the chute be sure that the feeding conveyors have been shut off and locked or tagged out. The running surfaces are very slippery; fall restraint gear should be worn while working inside the chute. While the fiberglass components are relatively light, they may be awkward for one person to handle- ask for help when replacing components.

If flammable or mineral base cleaners are used to clean the surface, assure that there is good ventilation. Wait a sufficient period of time for all flammable fumes to dissipate prior to conveying any metallic materials to prevent flash from static sparks.



TERMS AND CONDITIONS

VALIDITY – Quotations shall be considered current if outstanding no more than thirty (30) days from date of quotation, unless otherwise stated on quotation.

FREIGHT POLICY – Shipments of products, unless otherwise stated, is EX WORKS PORTEC'S factory. Written claims for damage in shipment should be made against the carrier. Written claims for shortages should be made against the carrier, specifically if there is evidence of shipping carton/container damage and/or if according to the shipping records there is a discrepancy in numbers of containers shipped versus numbers received.

Only in a situation where the container(s) shipped have been received in good condition, checked for physical content, and signed for verification within three days of delivery, and if such shortage has been found, and if PORTEC is notified in writing within 10 days upon receipt of order, PORTEC will establish that there was or was not a shortage. If a shortage is determined, PORTEC will provide the customer with the product/parts at PORTEC'S expense and shall ship F.O.B. as stated in the freight policy. If no shortage is determined, or if others than PORTEC caused the shortage, the claim shall be deemed invalid and it shall be the responsibility of the customer to arrange payment to PORTEC to fill the requirements of the deficiency.

PRICE ACCEPTANCE – The prices quoted herein are based on the quantities specified. Any change in quantities may affect quoted price. All orders are subject to acceptance at PORTEC'S factory. Any expense incurred by PORTEC as a result of cancellation or the making of any change will be included in PORTEC'S invoice unless prior waiver of such expense is obtained from PORTEC.

SHIPMENTS – Quoted Shipment dates are subject to change, without liability for delays beyond PORTEC'S control.

TERMS OF PAYMENT – Invoices are payable net cash 30 days, unless otherwise noted. There will be an interest charge of 1-1/2% per month for all payments received after 35 days. International (**except Canada**) orders are shipped against confirmed irrevocable letters of credit. All payments shall be in U.S. dollars. If the financial responsibility of a purchaser becomes impaired or is unsatisfactory, or if credit is not established, PORTEC reserves the right to request payment in advance or satisfactory guarantee that invoices will be paid promptly when due.

QUALITY ASSURANCE – All of its manufactured products are subject to PORTEC'S Warranty for material and workmanship.

GENERAL – Terms, conditions, and product specifications are subject to change without further obligation to PORTEC.

LIMITED WARRANTY ON NEW EQUIPMENT – PORTEC provides a Limited Warranty that warrants the material and workmanship of its manufactured products, with exceptions noted, for a period for 60 months beginning one month from the date of shipment from PORTEC'S factory, according to recorded serial numbers.

Within the stated warranty period, any material or workmanship showing defects will be repaired or replaced, provided PORTEC is given written notice within 30 days after failure, and a willingness is expressed to submit the product to PORTEC, and

if PORTEC authorizes the return of the product, and the product is returned. This warranty does not cover against normal wear of parts or materials. Warranty parts are supplied via EX WORKS PORTEC'S factory and unless PORTEC makes express agreement, the purchaser shall bear the expense of installation. PORTEC reserves the right at any time to supervise or install any part of replacement, or supervise adjustment incident to satisfactory operation of equipment. *A possible Warranty PO for parts and/or service may be required prior to shipping parts or exercising warranty labor.*

ITEMS IDENTIFIED AS COMPONENT AND REPLACEMENT PARTS – PORTEC parts will be warranted for a period of one (1) year from the date of shipment from the PORTEC Factory. This warranty on parts will cover only defects in workmanship or material. *The warranty does not cover the costs of the installation of such parts unless authorized by the designated PORTEC representative.*

Unauthorized returns, modifications, additions or variations, from procedures and information contained in PORTEC'S Owner's Manuals, and Product Data bulletins, or any misuse, negligence, accident, product jam, or loading beyond rated capacity invalidates this warranty.

EXCEPTIONS:

1. Because of varying operating conditions, all belting supplied will necessarily be subject to manufacturers', warranty rather than that of PORTEC.

2. Some OEM equipment including motors and gear reducers will be subject to the manufacturer's warranty, not PORTEC'S. PORTEC Customer & Product Support will provide assistance in contacting the proper manufacturer's representative. If a replacement is provided from PORTEC stock, a Possible Warranty PO must be provided. If the warranty is deemed invalid and PORTEC is not reimbursed for the warranty claim, the PO will be exercised.

3. PORTEC further reserves the right to void its warranty where final destination and specific application are withheld; product is improperly installed or maintained by others; product is modified without the consent from the designated PORTEC service representative; product is improperly protected against hazards and adverse environmental conditions during storage prior to or during installation; and/or product is used for applications/conditions other than indicated upon placement of order.

The foregoing warranty is exclusive and in lieu of all other warranties whether written, oral, or implied (including any warranty of merchantability or fitness for any purpose). Under no circumstances shall PORTEC be liable for incidental or consequential damages. The foregoing warranty cannot be changed except by written authorization signed by an authorized PORTEC representative, and no attempt to repair or promise to repair or improve PORTEC products by any other representative of PORTEC shall change or extend said warranty in any manner whatsoever.