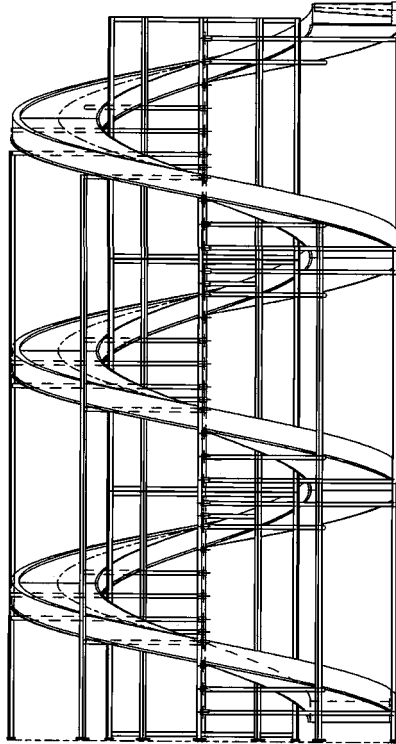


# **Spiral-Lift®**

## **Installation Manual**



**P.O. Box 589**  
**Cañon City, CO 81215-0589**  
**Telephone (719) 275-7471**  
**Fax (719) 269-3750**

© 1998 Portec, Inc.  
PS-294 05/05

# Table of Contents

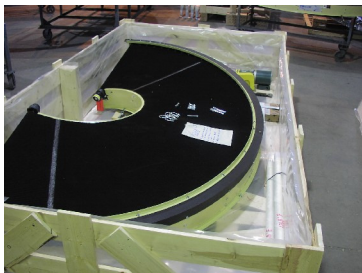
1. **Fabrication style #1**  
- Fully assembled stackable conveyor modules with belt installed and attached to center support structure. 3



2. **Fabrication style #2**  
- Stackable conveyor module sections without belts and attached to center support structure. 6



3. **Fabrication style #3**  
- Fully assembled conveyor modules with belt installed and separated from the center support structure. 11



4. **Fabrication style #4**  
- Conveyor module sections without belts and separated from the center support structure. 16

## 1. Fabrication Style #1

This style of Spiral-Lift requires the least amount of assembly. The modules are designed to stack on top of each other and quickly bolt together. Only the outside support legs and drive units must be attached. Installation procedures are as follows:

- A. **Unpack skids:** Remove the conveyor modules with center support structure attached from the shipping skids and identify each piece. The drive unit is secured on the skid with the conveyor. Fasteners and brackets are packed in a carton or bag and secured to the skid. Each Spiral-Lift conveyor includes an assembly drawing, which shows the quantity and sequence of modules, and internal and external support legs. Special assembly instructions (if any) are included on the assembly drawing. Each conveyor module is sequentially numbered with the lowest number closest to the floor. The numbers are stamped on the top end of the #1 vertical support arm of the center support structure. If the lowest end of the conveyor is more than a few feet from the floor, there may be a base support structure positioned below the first module. The base support structure is identified as the only module with feet.

**Note:** A large Spiral-Lift conveyor is normally made up of several individual conveyor modules. Each module has its own conveyor belt and drive unit. Each module or section is identified with a six digit job # on the upper inside of the cross member. If the Spiral-Lift has more than one module, the job # will be followed by a space and a module #. Module #1 is the lowest module in the Spiral-Lift. Module #2 is installed directly above Module #1.

- B. **Position module #1:** Move module #1 into position. Refer to the assembly drawing for locating the correct orientation. The leg #1 is stamped with a #1 on the side of the vertical leg of the center support structure.

**Note: For units with a base below module #1:** The base should be moved into position first and module #1 stacked on top of the base. Be sure that leg #1 of module #1 is positioned directly over leg #1 of the base. Attach module #1 to the base by bolting the square horizontal members of the center support structure together using 3/8" x 5" hex bolts (supplied).

**Note:** Some Spiral-Lift modules may require temporary bracing to keep balanced until it is secured to the floor or additional modules are installed above.

- C. **Level module #1:** Using the adjustable foot on the bottom of the unit, adjust the module until it is level.

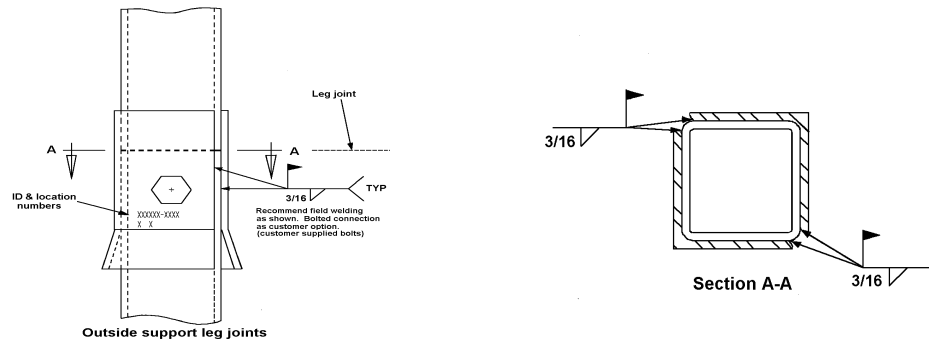


- D. **Stack module #2:** Lift module #2 and place its center support structure on top of the center support structure for module #1. Insure that leg #1 on module #2 is aligned directly above leg #1 on module #1. Use 3/8" x 5" hex bolts to connect together the square horizontal members of the center support structures on modules #1 and #2. Use 5/16" x 1" hex bolts to connect module #1 to module #2. Due to weld stresses, some clamping or prying may be required to achieve the best alignment.

**Note:** Some Spiral-Lift conveyors have only one conveyor module.

- E. **Stack remaining modules:** Continue stacking modules in sequence until all remaining modules are in place and bolted together.
- F. **Attach to floor:** After insuring that the conveyor unit is level and positioned in the correct orientation with the adjoining conveyors, anchor the vertical legs of the center support structure to the floor.
- G. **Attach outside support legs:** Identify the positions of the outside support legs on the assembly drawing. Each leg has a position number stamped on the side of the leg just above the foot. If a support leg has two or more pieces, each is identified with an alpha character to indicate its position within that particular leg. For example, support leg #7a has a foot and is the lowest piece of support leg #7. Support leg #7b is positioned directly above support leg #7a. There are two methods of attaching the support legs to the spiral lift. The outside support legs will either attach to the horizontal support arms using a 3/8" x 4-1/2" hex bolt or the leg is bolted to the foot rail through a support angle that is welded to the vertical support leg with a 3/8" x 1" hex bolt.

**Note:** Units that are too tall to be fully assembled in the factory will require that the support angle be welded to the vertical leg and mounted to the foot rail in the field. As an alternative to welding, the support angle may be bolted to the support leg after drilling a hole through both the support angle and the support leg. Although multiple piece support legs may be bolted together, Portec recommends that they also be welded at the joints.



Note: The outside leg number is stamped on the leg just above the foot.

- H. **Anchor legs to floor:** After adjusting the adjustable support foot, the outside legs should be anchored to the floor.
- I. **Install drive units:** Assemble drive components as required. There are separate installation instructions for drive units, depending upon the mounting configuration.

Most drives are shipped secured to the shipping skid. The drive sprockets (if required) are pre-positioned on the drive shafts during the run-in period at the factory. After assembly, check the sprocket positions to assure proper alignment. Always install the drive cover over the exposed drive belt/chain and pulley/sprockets (If required).

**Note:** Drive mount assemblies are numbered with #1 being the lowest drive. Drive components are marked to match the drive mount assembly number.

## 2. Fabrication Style #2

This style of Spiral-Lift is similar to Style #1, except that the conveyor belt is not installed and the conveyor modules have been separated into two sections. They are designed to stack on top of each other and quickly bolt together. The conveyor belt and drive unit must be installed on each module and outside support legs attached. Installation procedures are as follows:

- A. **Unpack skids:** Remove the conveyor module sections with center support structure attached from the shipping skids and identify each piece. The drive unit and conveyor belt are secured on the skid with the conveyor. Fasteners and brackets are packed in a carton or bag and secured to the skid. Each Spiral-Lift conveyor includes an assembly drawing, which shows the quantity and sequence of the module, and internal and external support legs. Special assembly instructions (if any) are included on the assembly drawing. Each conveyor module section is sequentially numbered with the lowest number closest to the floor. The numbers are stamped on the top end of the #1 vertical support arm of the center support structure. If the lowest end of the conveyor is more than a few feet from the floor, there may be a base support structure positioned below the first module. The base support structure is identified as the only module with feet.

**Note:** A large Spiral-Lift conveyor is normally made up of several individual conveyor modules. Each module has its own conveyor belt and drive unit. A large module may be separated into two sections. Each module or section is identified with a six digit job # on the upper inside of the cross member. If the Spiral-Lift has more than one module or is separated into sections, the job # will be followed by a space and a module #. Module #1 is the lowest section in the Spiral-Lift. Module #2 is installed directly above module #1.

- B. **Remove the chain covers:** The chain covers and sideguards (if applicable) must be removed prior to stacking the units.
- C. **Position of module #1:** Move module #1 into position. Refer to the assembly drawing for locating the correct orientation. The # 1 leg will be stamped with a #1 on the side of the vertical leg on the center support structure.

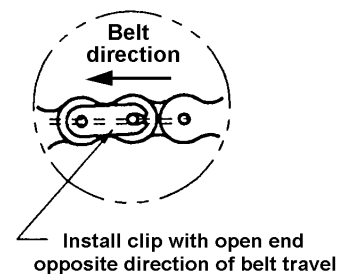
**Note: For units with a base below module #1:** The base should be moved into position first and module #1 stacked on top of the base. Be sure that leg #1 of module #1 is positioned directly over leg #1 of the base. Attach module #1 to the base by bolting the square horizontal members of the center support structure together using 3/8" x 5" hex bolts (supplied).

**Caution: With certain conveyor models, the first frame section or completed module may unbalance the conveyor. Temporary bracing or installing the outside support legs may be necessary to stabilize the unit.**

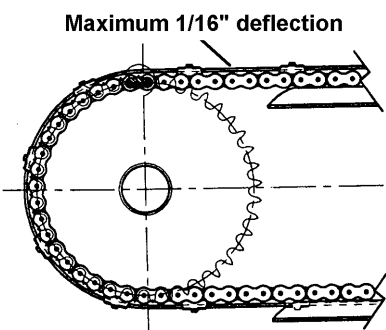
- D. **Level section #1:** Using the adjustable foot on the bottom of the unit, adjust the module until it is level.



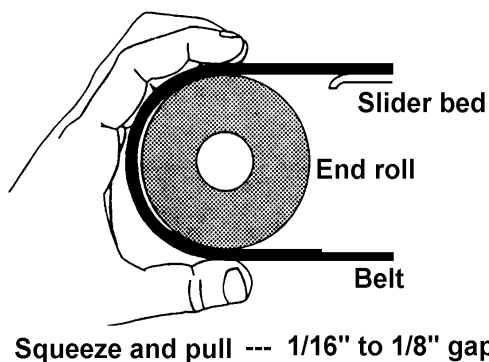
- E. **Stack module #2:** Lift module #2 and place its center support structure on top of the center support structure for module #1. Insure that leg #1 on module #2 is aligned directly above leg #1 on module #1. Use 3/8" x 5" hex bolts to connect together the square horizontal members of the center support structures on modules #1 and #2. Use 5/16" x 1" hex bolts to connect module #1 to module #2. Due to weld stresses, some clamping or prying may be required to achieve the best alignment.
- F. **Install conveyor belt:** Place the rolled up conveyor belt assembly on the completed module and pull the belt over the upper end roll. Make sure the belt chain is aligned with the end roll sprocket and begin threading the belt chain into the lower guide. Pull the belt through the guide and over the return rolls. Continue pulling the belt through the return side of the conveyor and around the lower end roll. Pull the belt up the topside of the conveyor until the belt splice is approximately in the center of the frame on the topside of the module. Connect the ends of the belt together by installing the lace pin. The lace pin should be looped back into the belt approximately 1" on each end of the lace seam. Install the connecting chain link with the open end of the clip opposite the direction of belt travel.



- G. **Adjust belt tension:** Adjust belt tension by adjusting the outside radius end roll bearings until the chain deflection is between 1/32"-1/16" when checked between the end roll sprocket and the end of the wear strip. This adjustment is for initial setup only. See the Spiral-Lift Owner's Manual for chain tension procedures after the initial setup.



Adjust the inside radius belt tension by moving the inside radius bearings out. Belt tension is correct on the inside radius when the belt is squeezed and pulled slightly around the end roll at the inside end and a 1/16"-1/8" gap between the belt and the end roll can be seen or felt.

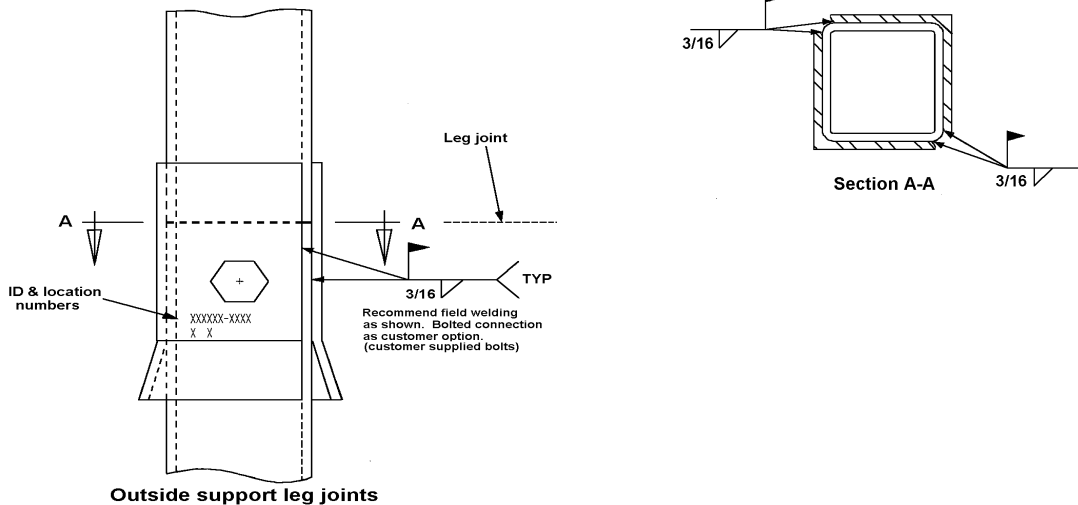


**Caution:** Due to the positive chain drive, tension does not have to be maintained on the belt itself. Over tightening the belt at the inside radius will result in premature belt failure.

- H. **Install chain cover:** Begin at on end of the assembled module and start installing the 8 x 20mm (or 5/16" x 3/4" self-tapping) bolts through the chain cover and into the frame. Due to welding stresses, and the spiral warp, clamps may be necessary to pull the cover into place. Tighten each bolt fully before installing the next bolt in sequence.

- I. **Stack remaining module sections:** Continue stacking module sections in sequence until all remaining sections are in place and bolted together. As two sections are connected to make a conveyor module, the belt assembly should be installed.
- J. **Attach to floor:** After insuring that the Spiral-Lift is level and positioned in the correct orientation with the adjoining conveyors, anchor the vertical legs of the center support structure to the floor.
- K. **Attach outside support legs:** Identify the positions of the outside support legs on the assembly drawing. Each leg has a position number stamped on the side of the leg just above the foot. If a support leg has two or more pieces, each is identified with an alpha character to indicate its position within that particular leg. For example, support leg #7a has a foot and is the lowest piece of support leg #7. Support leg #7b is positioned directly above support leg #7a. There are two methods of attaching the support legs to the spiral lift. The outside support legs will either attach to the horizontal support arms using a 3/8" x 4-1/2" hex bolt or the leg is bolted to the foot rail through a support angle that is welded to the vertical support leg with a 3/8" x 1" hex bolt.

**Note:** Units that are too tall to be fully assembled in the factory will require that the support angle be welded to the vertical leg and mounted to the foot rail in the field. As an alternative to welding, the support angle may be bolted to the support leg after drilling a hole through both the support angle and the support leg. Although multiple piece support legs may be bolted together, Portec recommends that they also be welded at the joints.





Note: The outside leg number is stamped on the leg just above the foot.

- L. **Anchor legs to floor:** After adjusting the adjustable support foot, the legs should be anchored to the floor.
- M. **Install drive units:** Assemble drive components as required. There are separate installation instructions for drive units, depending upon the mounting configuration.

Most drives are shipped bolted to the shipping skid. The drive sprockets (if required) are pre-positioned on the drive shafts during the run-in period at the factory. After assembly, check the sprocket positions to assure proper alignment. Always install the drive cover over the exposed drive belt/chain and pulley/sprockets (If required).

**Note:** Drive mounts will be numbered with #1 being the lowest drive. Drive components are marked to match the drive mount's number.

### 3. Fabrication Style #3

This style of Spiral-Lift has complete conveyor modules that are packed separately from the support structure. The individual conveyor modules are complete with the conveyor belt installed and adjusted. The center support structure should be assembled first and the conveyor modules placed on the horizontal arms. The drive units and outside support legs are added to finish the Spiral-Lift. Installation procedures are as follows:

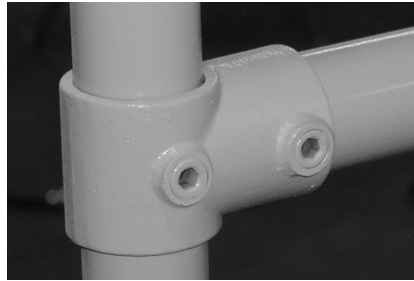
- A. **Unpack crates:** Remove the conveyor modules from the crates and identify each piece. The drive units are packed in the crate with the conveyor. Fasteners and brackets are packed in a carton or bag within the crate. Each Spiral-Lift conveyor has an assembly drawing in one of the crates, which shows the quantity and sequence of modules, and internal and external support legs. Special assembly instructions (if any) are included on the assembly drawing. Each conveyor module is sequentially numbered with the lowest number closest to the floor. The numbers are stamped on the top end of the #1 vertical support arm of the center support structure. If the lowest end of the conveyor is more than a few feet from the floor, there may be a base support structure positioned below the first module. The base support structure is identified as the only module with feet.

**Note:** A large Spiral-Lift conveyor is normally made up of several individual conveyor modules. Each module has its own conveyor belt and drive unit. Each module or section is identified with a six digit job # on the upper inside of the cross member. If the Spiral-Lift has more than one module, the job # will be followed by a space and a module #. Module #1 is the lowest module in the Spiral-Lift. Module #2 is installed directly above Module #1.

- B. **Position bottom center support structure: its feet can identify the bottom center support structure.** Move the bottom center support structure into position. Refer to the assembly drawing for locating the correct orientation. A "#1" will be stamped on top corner of the vertical leg that supports the lowest end of the Spiral-Lift.

**Note: For units with a base below module #1:** Move the base support structure into position first and then stack the support structure for module #1 on top of the base. Be sure that leg #1 of the support structure for module #1 is positioned directly over leg #1 of the base. Attach the two support structures by bolting the square horizontal members together using 3/8" x 5" hex bolts (supplied).

- C. **Attach lower horizontal support arms:** Attach the horizontal support arm that is labeled “A” to the vertical leg of the center support structure that is labeled “1”. Insure that the two alignment blocks are facing upward. Insert the horizontal support arm into a “Key Clamp” on the center post. Bolt the horizontal support arm to the vertical leg through the pre-drilled hole. Use a 3/8 x 4-1/2” bolt with hex nut, lock washer and flat washers. Insert the bolt first through the square vertical leg and then through the round horizontal support arm. Tighten the bolt and the setscrews in the key clamp. Install any additional horizontal support arms that are required on the lower center support structure.

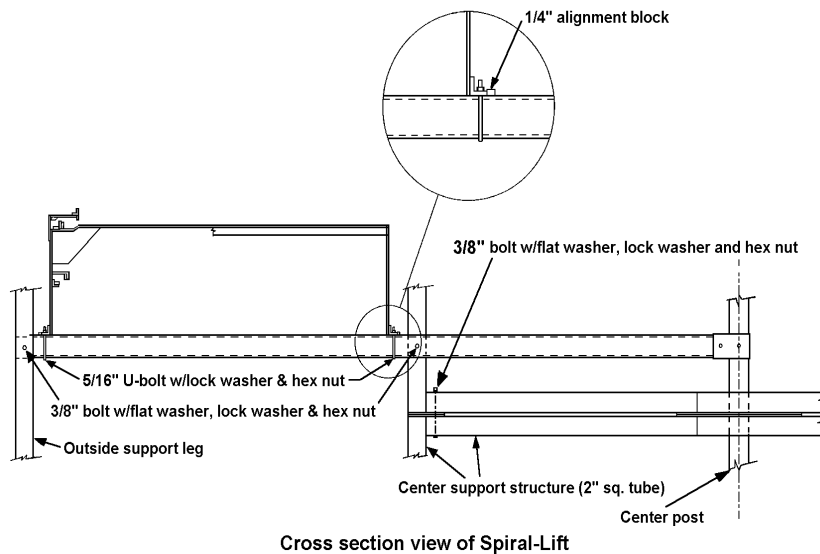


**Note:** The horizontal support arms are alphabetically marked with “A” being the lowest support arm. Refer to the assembly drawing provided with each unit.

- D. **Level bottom center support:** Using the adjustable foot on the bottom of the unit, adjust the module until it is level.



- E. **Install conveyor module #1:** Lift module #1 unto the horizontal support arms and attach with U-bolts. The U-bolts clamp around the horizontal support arms and are inserted into predrilled holes along the bottom angle of the inside and outside radius frame of the conveyor module. 1/4” alignment blocks are welded on top of the horizontal support arm to assist in positioning the module.



**Caution:** With certain conveyor models, the first module may unbalance the conveyor. Temporary bracing or installing the outside support legs may be necessary to stabilize the unit.

**Note:** Never lift a conveyor by the drive shaft extension.

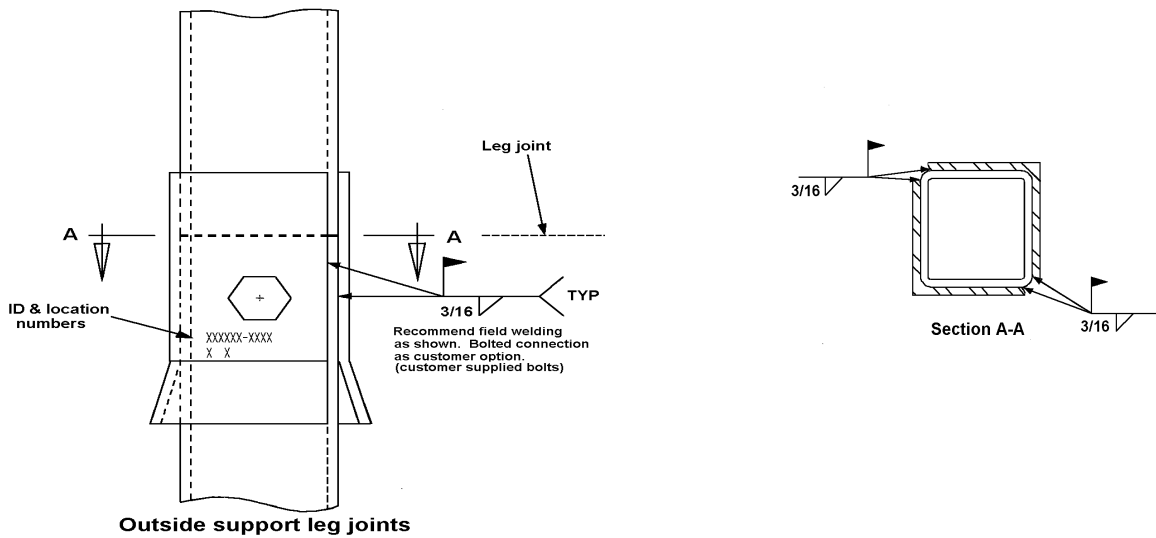
- F. **Add second center support structure:** Lift the second center support structure and place it on top of the bottom center support structure. Insure that leg #1 on the second unit is aligned directly above leg #1 on the bottom unit. Use a 3/8" x 5" hex bolts to connect together the square horizontal members of the center support structures on units #1 and #2. Add required horizontal support arms and install the second conveyor module. Use 5/16" x 1" hex bolts to connect the frames of conveyor module #1 to conveyor module #2. Steel tabs are provided on the ends of each conveyor frame to connect to the adjoining conveyor frame. Due to weld stresses, some clamping or prying may be required to achieve the best alignment.

**Note:** Some Spiral-Lift conveyors have only one conveyor module.

- G. **Stack remaining modules:** Continue stacking center support structures and conveyor modules in sequence until all remaining modules are in place and bolted together.
- H. **Attach to floor:** After insuring that the Spiral-Lift is level and positioned in the correct orientation with the adjoining conveyors, anchor the vertical legs of the center support structure to the floor.

- I. **Attach outside support legs:** Identify the positions of the outside support legs on the assembly drawing. Each leg has a position number stamped on the side of the leg just above the foot. If a support leg has two or more pieces, each is identified with an alpha character to indicate its position within that particular leg. For example, support leg #7a has a foot and is the lowest piece of support leg #7. Support leg #7b is positioned directly above support leg #7a. There are two methods of attaching the support legs to the spiral lift. The outside support legs will either attach to the horizontal support arms using a 3/8" x 4-1/2" hex bolt or the leg is bolted to the foot rail through a support angle that is welded to the vertical support leg with a 3/8" x 1" hex bolt.

**Note:** Units that are too tall to be fully assembled in the factory will require that the support angle be welded to the vertical leg and mounted to the foot rail in the field. As an alternative to welding, the support angle may be bolted to the support leg after drilling a hole through both the support angle and the support leg. Although multiple piece support legs may be bolted together, Portec recommends that they also be welded at the joints.



Note: The outside leg number is stamped on the leg just above the foot.

- J. **Anchor legs to floor:** After adjusting the adjustable support foot, the legs should be anchored to the floor.
- K. **Install drive units:** Assemble drive components as required. There are separate installation instructions for drive units, depending upon the mounting configuration.

The drives are shipped within the wooden shipping crate. The drive sprockets (if required) are pre-positioned on the drive shafts during the run-in period at the factory. After assembly, check the sprocket positions to assure proper alignment. Always install the drive cover over the exposed drive belt/chain and pulley/sprockets (If required).

**Note:** Drive mounts will be numbered with #1 being the lowest drive. Drive components are marked to match the drive mount's number.

#### 4. Fabrication Style #4

This style of Spiral-Lift is completely disassembled. The conveyor modules are in two sections and are packed separately from the support structure. The center support structure should be assembled first and the conveyor module sections bolted together after being placed on the horizontal arms. The conveyor belt and drive unit must be installed on each completed conveyor module. The outside support legs are attached to finish the Spiral-Lift. Installation procedures are as follows:

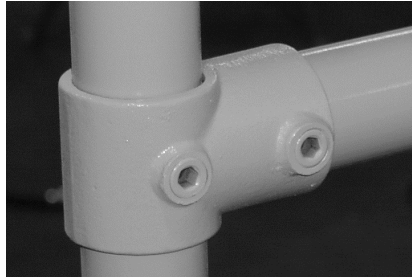
- A. **Unpack crates:** Remove the conveyor modules from the crates and identify each piece. The drive unit and conveyor belt are secured in the crate with the conveyor. Fasteners and brackets are packed in a carton or bag and secured in the crate. Each Spiral-Lift conveyor includes an assembly drawing, which shows the quantity and sequence of modules, and internal and external support legs. Special assembly instructions (if any) are included on the assembly drawing. Each support structure is sequentially numbered with the lowest number closest to the floor. The numbers are stamped on the top end of the #1 vertical support arm of the center support structure. If the lowest end of the conveyor is more than a few feet from the floor, there may be a base support structure positioned below the first module. The base support structure is identified as the only module with feet.

**Note:** A large Spiral-Lift conveyor is normally made up of several individual conveyor modules. Each module has its own conveyor belt and drive unit. A large module may be separated into two sections. Each module or section is identified with a six digit job# on the inside end of the cross member on the upper end of the frame. If the Spiral-Lift has more than one section, the job# will be followed by a space and a module #. Section #1 is the lowest section in the Spiral-Lift. Section #2 is installed directly above section #1. Section #1 and section #2 are combined to make module #1.

- B. **Position bottom center support structure: its feet can identify the bottom center support structure.** Move the bottom center support structure into position. Refer to the assembly drawing for locating the correct orientation. A "#1" will be stamped on top corner of the vertical leg that supports the lowest end of the Spiral-Lift.

**Note: For units with a base below module #1:** Move the base support structure into position first and then stack the support structure for module #1 on top of the base. Be sure that leg #1 of the support structure for module #1 is positioned directly over leg #1 of the base. Attach the two support structures by bolting the square horizontal members together using 3/8" x 5" hex bolts (supplied).

- C. **Attach lower horizontal support arms:** Attach the horizontal support arm that is labeled “A” to the vertical leg of the center support structure that is labeled “1”. Insure that the two alignment blocks are facing upward. Insert the horizontal support arm into a “Key Clamp” on the center post. Bolt the horizontal support arm to the vertical leg through the pre-drilled hole. Use a 3/8 x 4-1/2” bolt with hex nut, lock washer and flat washers. Insert the bolt first through the square vertical leg and then through the round horizontal support arm. Tighten the bolt and the setscrews in the key clamp. Install any additional horizontal support arms that are required on the lower center support structure.



**Note:** The horizontal support arms are alphabetically marked with “A” being the lowest support arm. Refer to the assembly drawing provided with each unit.

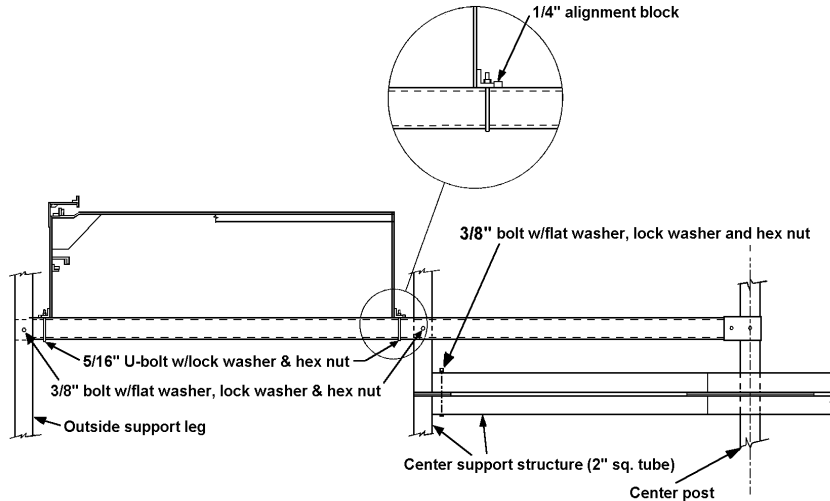
- D. **Level bottom center support:** Using the adjustable foot on the bottom of the unit, adjust the module until it is level.



- E. **Remove the chain covers:** The chain covers and sideguards (if applicable) must be removed to allow for the sections to be installed.
- F. **Install section #1:** Lift section #1 onto the horizontal support arms and attach with U-bolts. The U-bolts clamp around the horizontal support arms and are inserted into predrilled holes along the bottom angle of the inside and outside radius frame of the module section. 1/4” alignment blocks are welded on top of the horizontal support arm to assist in positioning the module section.

**Note: Never lift a conveyor by the drive shaft extension.**

- G. **Install section #2:** Lift section #2 onto the horizontal support arms and attach with U-bolts as previously done on section #1. Bolt section #2 together with section #1 using the 5/16" x 1" hex bolts supplied in the predrilled holes in the cross members and cross ribs.

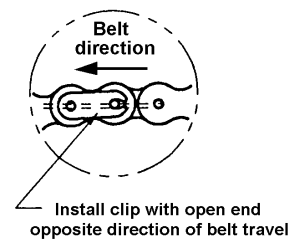


Cross section view of Spiral-Lift

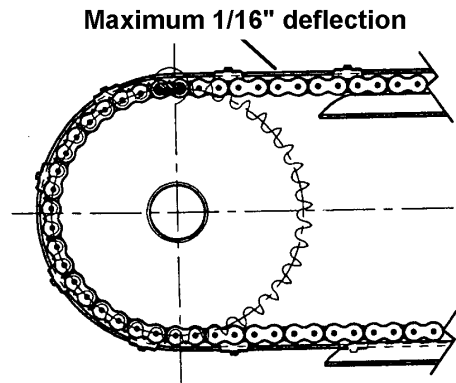
**Caution: With certain conveyor models, the first module or section may unbalance the conveyor. Temporary bracing or installing the outside support legs may be necessary to stabilize the unit.**

**Note:** Some Spiral-Lift conveyors have only one conveyor module.

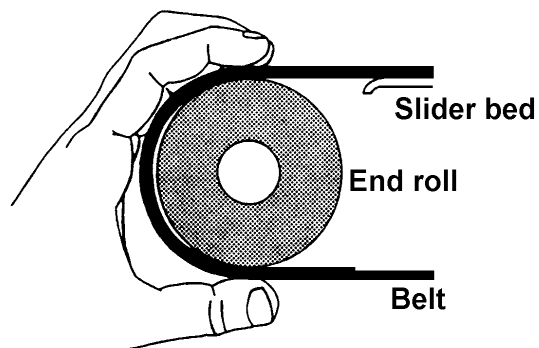
- H. **Install conveyor belt:** Place the rolled up conveyor belt assembly on the completed module and pull the belt over the upper end roll. Make sure the belt chain is aligned with the end roll sprocket and begin threading the belt chain into the lower guide. Pull the belt through the guide and over the return rolls. Continue pulling the belt through the return side of the conveyor and around the lower end roll. Pull the belt up the topside of the conveyor until the belt splice is approximately in the center of the frame on the topside of the module. Connect the ends of the belt together by installing the lace pin. The lace pin should be looped back into the belt approximately 1" on each end of the lace seam. Install the connecting chain link with the open end of the clip opposite the direction of belt travel.



- I. **Adjust belt tension:** Adjust belt tension by adjusting the outside radius end roll bearings until the chain deflection is between 1/32"-1/16" when checked between the end roll sprocket and the end of the wear strip. This adjustment is for initial setup only. See the Spiral-Lift Owner's Manual for chain tension procedures after the initial setup.



Adjust the inside radius belt tension by moving the inside radius bearings out. Belt tension is correct on the inside radius when the belt is squeezed and pulled slightly around the end roll at the inside end and a 1/16"-1/8" gap between the belt and the end roll can be seen or felt.



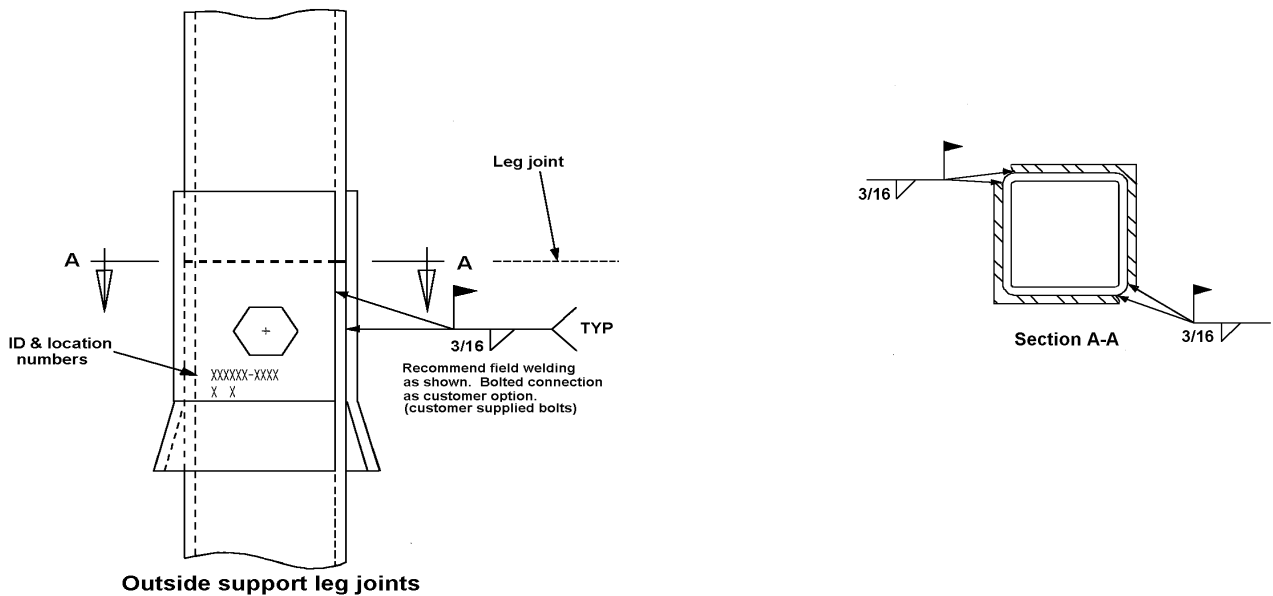
Squeeze and pull --- 1/16" to 1/8" gap

**Caution:** Due to the positive chain drive, tension does not have to be maintained on the belt itself. Over tightening the belt at the inside radius will result in premature belt failure.

- J. **Install chain cover:** Begin at on end of the assembled module and start installing the 8 x 20 mm (or 5/16" x 3/4" self-tapping) bolts through the chain cover and into the frame. Due to welding stresses, and the spiral warp, clamps may be necessary to pull the cover into place. Tighten each bolt fully before installing the next bolt in sequence.

- K. **Stack remaining module sections:** Continue stacking center support structures and conveyor module sections in sequence until all remaining modules are in place and bolted together. As two sections are connected to make a conveyor module, the belt assembly should be installed.
- L. **Attach to floor:** After insuring that the Spiral-Lift is level and positioned in the correct orientation with the adjoining conveyors, anchor the vertical legs of the center support structure to the floor.
- M. **Attach outside support legs:** Identify the positions of the outside support legs on the assembly drawing. Each leg has a position number stamped on the side of the leg just above the foot. If a support leg has two or more pieces, each is identified with an alpha character to indicate its position within that particular leg. For example, support leg #7a has a foot and is the lowest piece of support leg #7. Support leg #7b is positioned directly above support leg #7a. There are two methods of attaching the support legs to the spiral lift. The outside support legs will either attach to the horizontal support arms using a 3/8" x 4-1/2" hex bolt or the leg is bolted to the foot rail through a support angle that is welded to the vertical support leg with a 3/8" x 1" hex bolt.

**Note:** Units that are too tall to be fully assembled in the factory will require that the support angle be welded to the vertical leg and mounted to the foot rail in the field. As an alternative to welding, the support angle may be bolted to the support leg after drilling a hole through both the support angle and the support leg. Although multiple piece support legs may be bolted together, Portec recommends that they also be welded at the joints.





Note: The outside leg number is stamped on the leg just above the foot.

- O. **Anchor legs to floor:** After adjusting the adjustable support foot, the legs should be anchored to the floor.
- P. **Install drive units:** Assemble drive components as required. There are separate installation instructions for drive units, depending upon the mounting configuration.

The drives are shipped within the wooden shipping crate. The drive sprockets (if required) are pre-positioned on the drive shafts during the run-in period at the factory. After assembly, check the sprocket positions to assure proper alignment. Always install the drive cover over the exposed drive belt/chain and pulley/sprockets (If required).

**Note:** Drive mounts will be numbered with #1 being the lowest drive. Drive components are marked to match the drive mount's number.