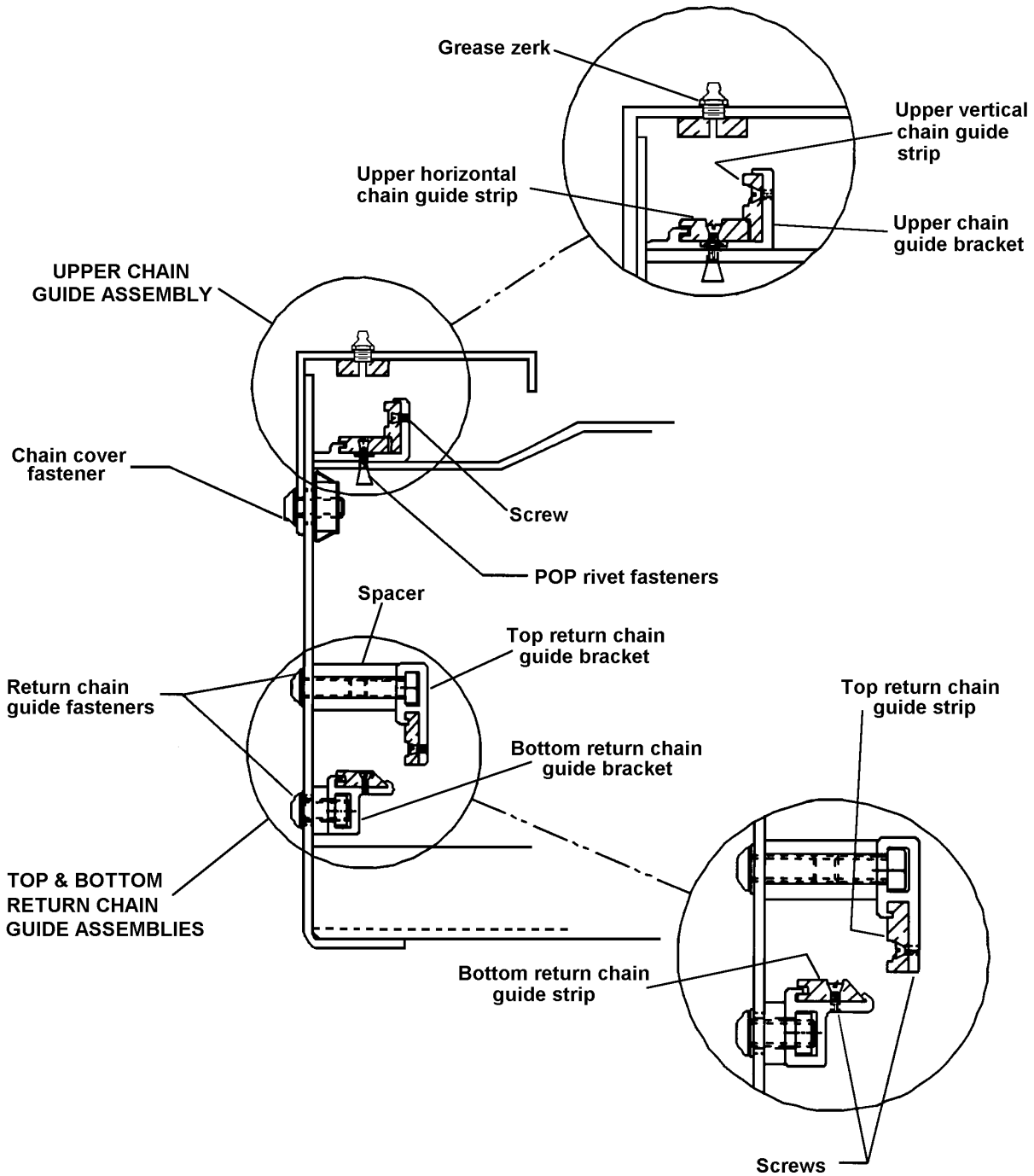


Installation Guidelines

Belt Chain Guide Replacement for Portec Sigma Curve Conveyor

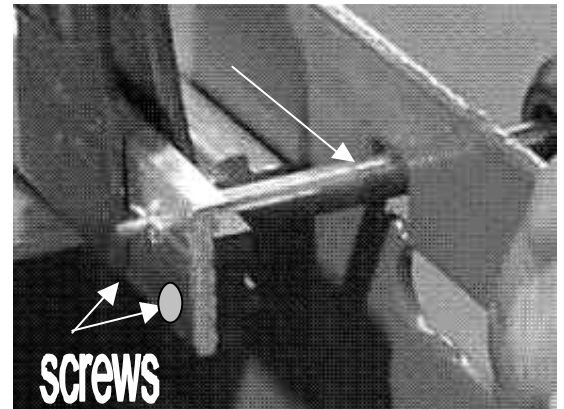
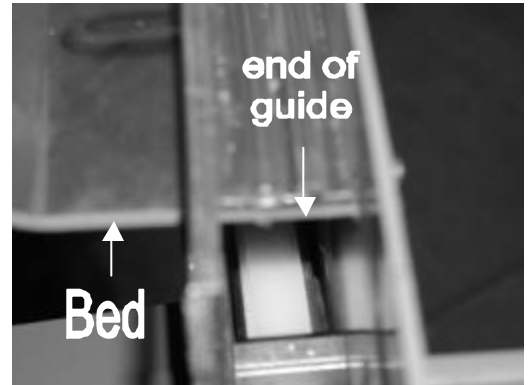


Installation Guidelines

Belt Chain Guide Replacement for Portec Sigma Curve Conveyor

Upper Chain Guide(s) Replacement

1. Remove the outside radius sideguard(s), chain cover(s) and end caps.
2. Move the belt chain connecting-link to the top of the conveyor bed. Remove the connecting-link and the belt lacing pin. Fold the conveyor belt back to expose the entire upper chain guide assembly
3. Remove the end roll assembly on one end. Mark the location of the end roll assembly bearings to assist with relocating them to their original position upon reassembly.
4. Remove the 6-32 x 1/2" flat-head screws at both ends of the upper vertical chain guide strip and/or the upper horizontal chain guide strip.
5. Slide the worn or damaged guide(s) from the upper chain guide bracket.
6. To replace the entire upper chain guide bracket, remove the upper horizontal guide strip and drill out the pop rivet fasteners to remove the bracket from the slider bed. Line up the end of the new upper chain guide bracket with the end of the slider bed. Clamp it into place, then drill and insert new 1/8" steel pop rivets to secure the bracket to the slider bed.
7. Slide the new upper vertical chain guide strip into the upper chain guide bracket with the grooved side exposed. Clamp the end flush with the end of the vertical portion of the guide.
8. Drill two 7/64" holes and then tap for 6-32 x 1/2" screws within 3/4" from the end.

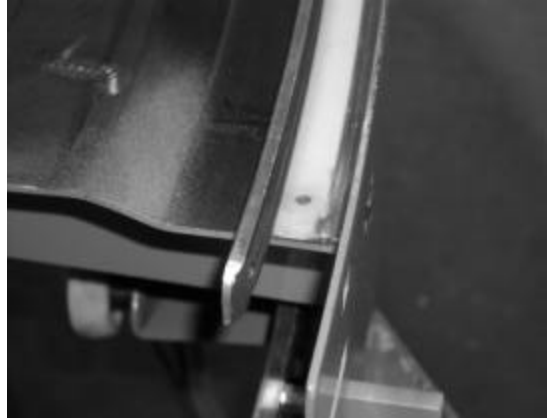
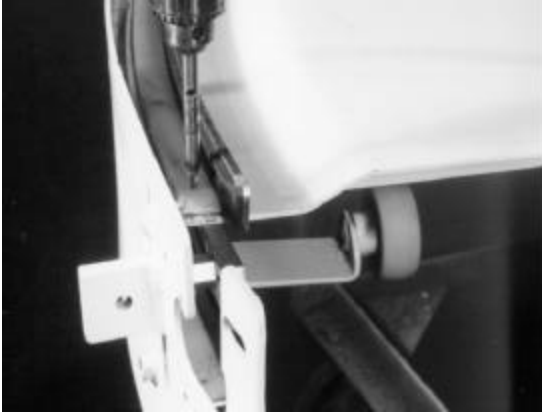


9. Use the square hole in the frame to drill the holes and access screws.
10. On the other end of the turn, pull the slack out of the vertical chain guide strip so that it will lay flat against the guide. Clamp the strip so that it will not move. Cut the strip off flush with the guide and secure that end the same as the initial end.

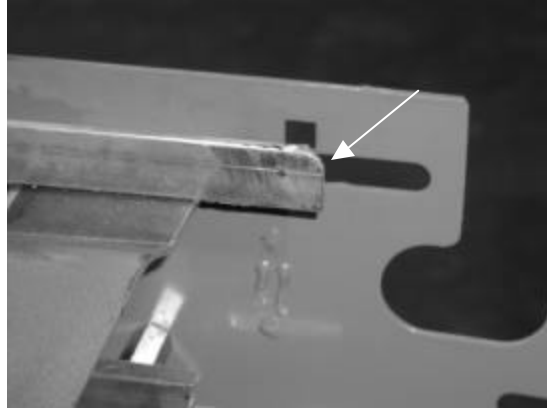
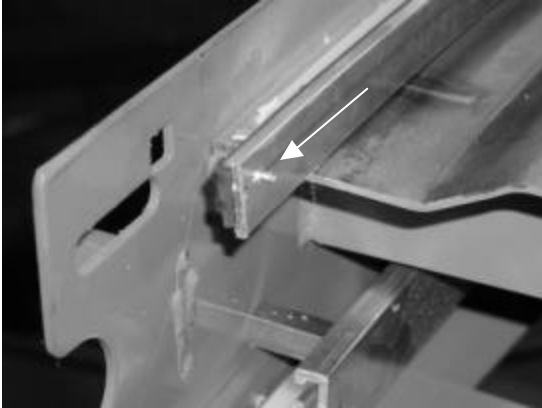
Installation Guidelines

Belt Chain Guide Replacement for Portec Sigma Curve Conveyor

11. Begin inserting the horizontal white UHMW into the upper chain guide bracket until it is flush with the slider bed on the other end of the conveyor. Cut the strip off flush with the slider bed at the initial end of the conveyor.
12. Drill/countersink, tap and insert a 6-32 x 1/2" flat-head screw in the center and about 3/4" from each end of the UHMW. Taper the ends of the UHMW with a file.



13. Grind off the excess screw threads on the vertical part of the guide. Round off both ends of the vertical part of the guide.



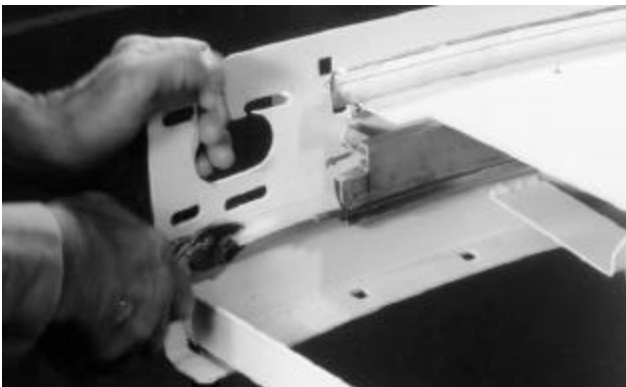
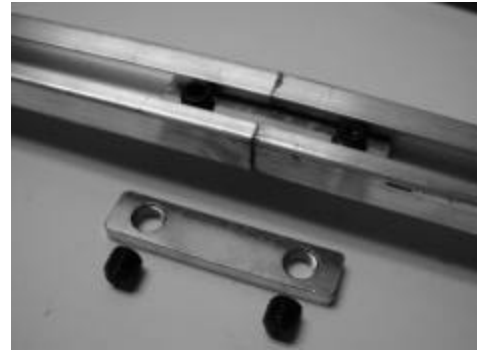
14. **Note:** It is not necessary to remove both guides if only one guide is replaced. When installing the upper horizontal guide, make sure not to drill into one of the rivets that attach the upper chain guide bracket to the slider bed.

Installation Guidelines

Belt Chain Guide Replacement for Portec Sigma Curve Conveyor

Top and Bottom Return Chain Guide(s) Replacement

1. Completely remove belt chain from return chain guide brackets.
2. The top return chain guide bracket including the chain guide strip must be replaced as a unit. Remove the upper row of fasteners along the lower side of the outside radius frame to disconnect the existing top return guide bracket. Slide the top return guide bracket out of one end of the conveyor.
3. The bottom return chain guide bracket including the guide strip can be replaced as a unit or just the guide strip itself can be replaced.
4. To replace the complete bottom return chain guide bracket, remove the lower row of fasteners along the lower side of the outside radius frame to disconnect the existing bottom return guide bracket. Slide the bottom return guide bracket out of one end of the conveyor. Remove all fasteners from the bracket, including the spacers, as they will be used to install the new guide bracket.
5. If the new bottom return chain guide bracket is shipped in two or more pieces, connect the brackets together using the supplied T-slot nut and set screws. Slide the new bottom return chain guide bracket into position under the conveyor. Install the fasteners and tighten.
6. To replace the bottom return chain guide strip only, remove the 6-32 x 1/2" flat-head screws at both ends of the bottom return chain guide.
7. Slide the worn or damaged guide strip out of the bottom return chain guide bracket.
8. Slide the new guide strip into the bottom return chain guide bracket and cut off excess so that guide strip is flush at both ends.
9. Install one 6-32 X 1/2" flat-head screw at each end.



10. Slightly bend the ends of the bottom return chain guide and bracket down to ease the entry and exit of the chain.
11. If the new top return chain guide bracket is shipped in two or more pieces, connect the brackets together using the supplied T-slot nut and set screws. Slide the new top return chain guide bracket into position under the conveyor. Install the fasteners and tighten.

Installation Guidelines

Belt Chain Guide Replacement for Portec Sigma Curve Conveyor

12. Reinstall the belt chain into return chain guide brackets.
13. Reinstall the end roll assembly.
14. Reassemble the belt chain using the connecting-link and the belt lacing pin.
15. Check the alignment of the belt chain and sprockets to the new chain guides. Adjust the sprocket position if necessary.
16. Replace the chain cover(s) and outside radius sideguard(s). Move the end caps close to the end roll without touching the conveyor belt.
17. **Note:** For conveyors with endless belts—The belt does not need to be completely removed to replace the chain guides. Follow the above procedures except that the belt does not have a laced belt seam.