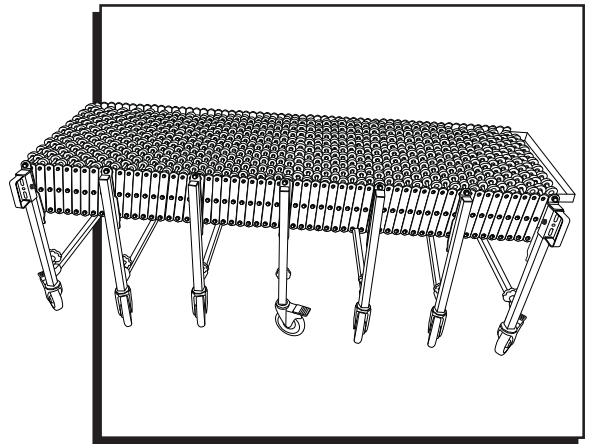


## EXPANDABLE CONVEYOR

T-D466 T-D467  
 T-D468 T-D469  
 T-D472 T-D473



### TOOLS NEEDED



1/2" (13 mm) Wrench



9/16" (14 mm) Wrench

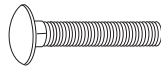


1/4" Allen Wrench

### PARTS



Conveyor  
Handle x 4



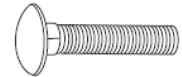
5/16" Bolt

T-D466 x 6  
 T-D467 x 8  
 T-D468 x 14  
 T-D469 x 14  
 T-D472 x 14  
 T-D473 x 14



5/16" Washer

T-D466 x 6  
 T-D467 x 8  
 T-D468 x 14  
 T-D469 x 14  
 T-D472 x 14  
 T-D473 x 14



3/8" Bolt x 4



5/16" Locknut

T-D466 x 6  
 T-D467 x 8  
 T-D468 x 14  
 T-D469 x 14  
 T-D472 x 14  
 T-D473 x 14

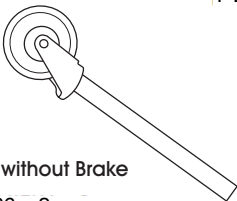


3/8" Serrated  
Flange Nut x 4



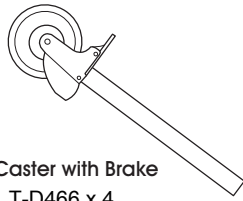
Leg Cap

T-D466 x 6  
 T-D467 x 8  
 T-D468 x 14  
 T-D469 x 14  
 T-D472 x 14  
 T-D473 x 14



Caster without Brake

T-D466 x 2  
 T-D467 x 4  
 T-D468 x 8  
 T-D469 x 8  
 T-D472 x 8  
 T-D473 x 8



Caster with Brake

T-D466 x 4  
 T-D467 x 4  
 T-D468 x 6  
 T-D469 x 6  
 T-D472 x 6  
 T-D473 x 6



Leg Support

T-D466 x 3  
 T-D467 x 4  
 T-D468 x 7  
 T-D469 x 7  
 T-D472 x 7  
 T-D473 x 7



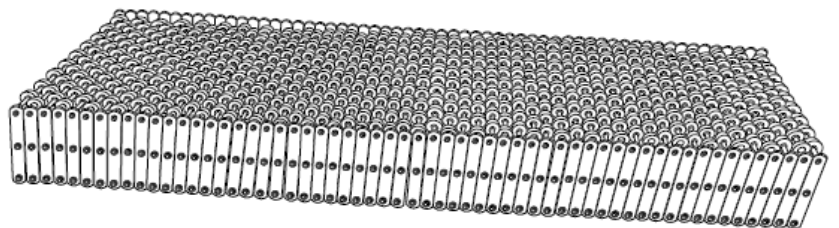
Height  
Adjustment Knob

T-D466 x 6  
 T-D467 x 8  
 T-D468 x 14  
 T-D469 x 14  
 T-D472 x 14  
 T-D473 x 14



Upper Leg

T-D466 x 6  
 T-D467 x 8  
 T-D468 x 14  
 T-D469 x 14  
 T-D472 x 14  
 T-D473 x 14

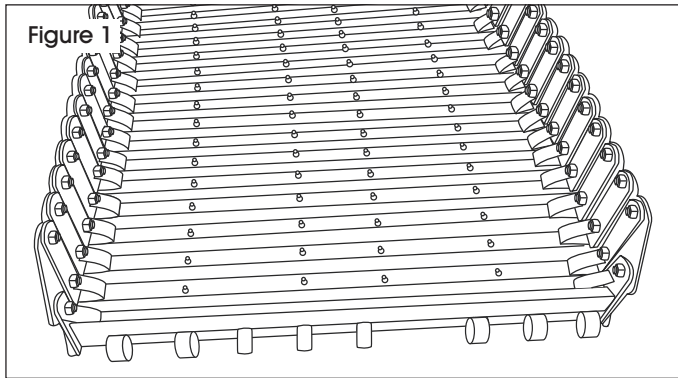


Conveyor x 1

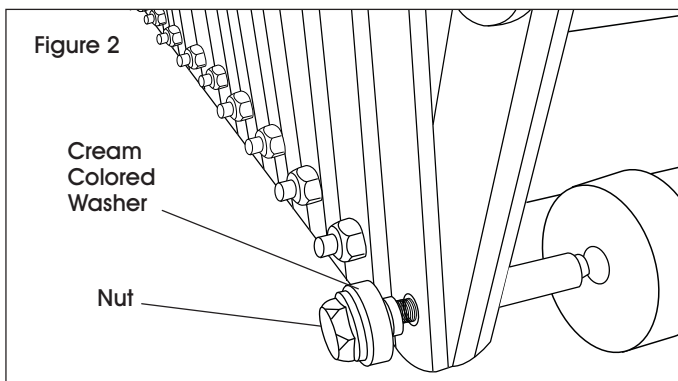
# ASSEMBLY

1. Unpack and place the conveyor on the ground with the roller wheels facing down. (See Figure 1)

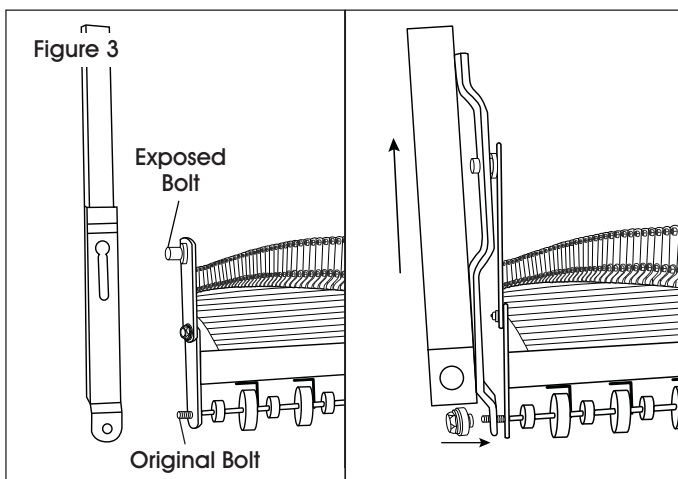
 **NOTE:** Requires at least two people.



2. Unscrew nut and cream colored washer closest to the floor. (See Figure 2)

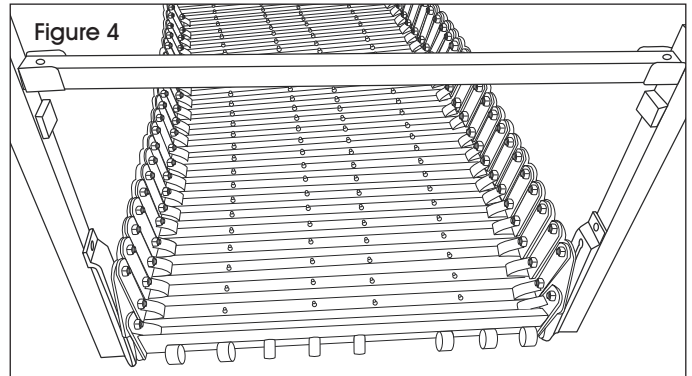


3. Insert the upper leg into exposed bolt and pull up to align bottom hole to the original bolt hole. (See Figure 3)

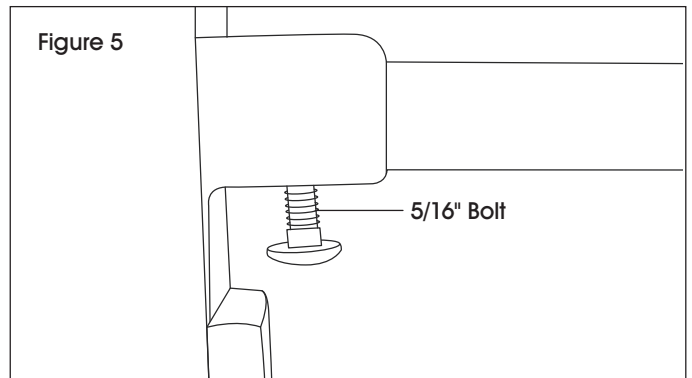


4. Once aligned with original bolt, tighten the previously removed cream washer and nut.
5. Repeat steps 3 and 4 for opposite leg.

6. Place leg support between the two upper legs. (See Figure 4)



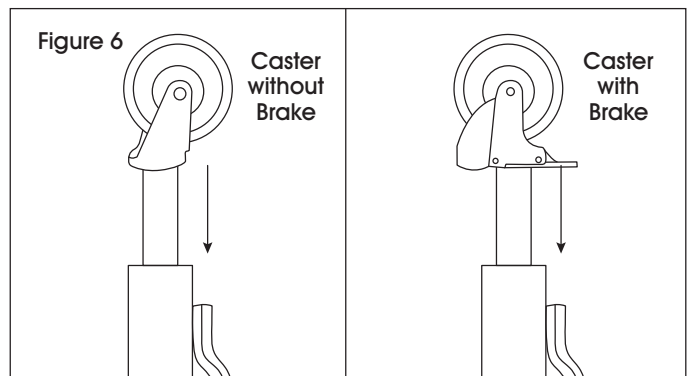
7. Insert the 5/16" bolt with the top of the bolt facing down. (See Figure 5)



8. Tighten the 5/16" washer and 5/16" locknut to secure the bolt using a wrench.
9. Insert casters into the upper leg. (See Figure 6)

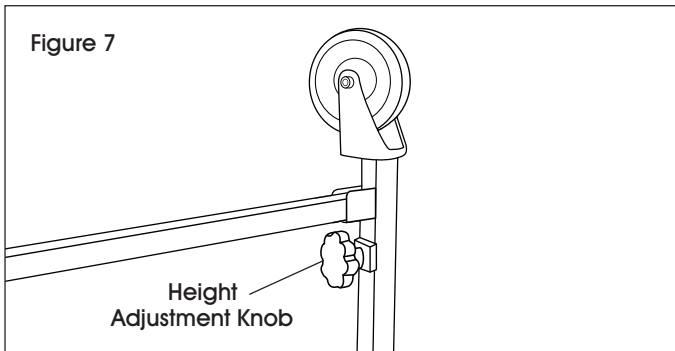
 **NOTE:** The casters with brakes go on legs at the ends and in the middle of the conveyor.

 **NOTE:** H-6873 casters with brakes go on legs only at ends of conveyor.



## ASSEMBLY CONTINUED

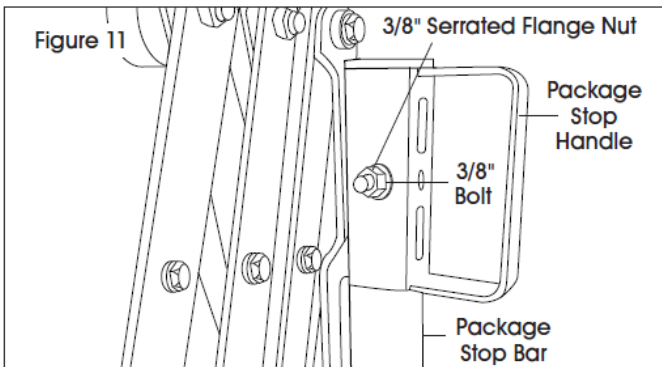
10. Hand tighten the height adjustment knob to secure the casters. (See Figure 7)



11. Repeat steps 2 through 10 for all leg sets.  
12. Once all legs and casters have been assembled, flip conveyor upright so casters are on the ground.

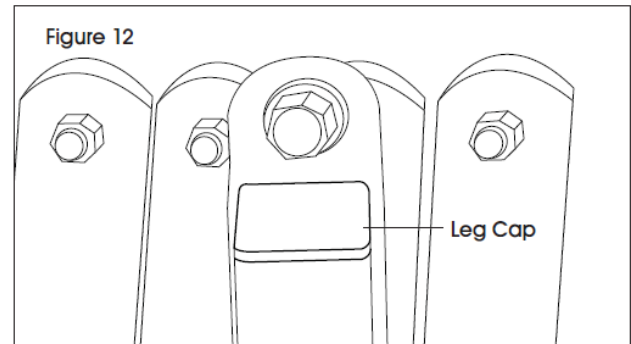
 **NOTE: Requires at least two people.**

13. Align handle on package stop bar to the end of the conveyor. Secure by placing the 3/8" bolt through the leg hole and tightening the 3/8" serrated flange nut with a wrench. Repeat this on opposite side. (See Figure 11)



14. Secure conveyor handles at opposite end with 3/8" bolt. Tighten the serrated flange nut with a wrench.

15. Secure leg caps on top of the legs of the conveyor. (See Figure 12)



## OPERATION

1. The legs are adjustable from 28½" to 41½". For proper gravity flow, a 5/16" decline per expanded foot is recommended. This may vary with carton weight or your specific applications.
2. To expand the conveyor:
  - a. Unlock the casters.
  - b. Grasp the handles on each side at both ends of the conveyor and pull until the conveyor is properly expanded.
  - c. Lock casters and begin use.
3. To set leg elevation for your application:
  - a. With the conveyor expanded, unscrew the height adjustment knobs on the first leg set on the infeed end and lift up on the conveyor to height needed. Tighten height adjustment knobs.
  - b. Do the same on the last leg set on the discharge end.
  - c. Adjust all legs in between to obtain proper gravity flow.
  - d. Close conveyor and check for slopes and valleys between the legs and readjust if needed.
4. Load capacity – 200 lbs. per linear foot.

## SAFETY



**CAUTION!** Move conveyor only by grasping the handles located on each side at both ends of the conveyor.



**CAUTION!** When expanding or compacting your conveyor; keep hands, clothing and other items clear of the side bars.



**WARNING!** Do not exceed the conveyor load capacity, as it may result in possible operator injury or conveyor damage.



**CAUTION!** Avoid wearing excessively loose clothing when working with moving equipment.



**CAUTION!** Keep long hair pulled up to prevent it from becoming caught in moving parts.



**NOTE:** Broken or worn parts must be immediately replaced.



**NOTE:** Conveyors must only be serviced by properly trained and qualified technicians.

## MAINTENANCE SCHEDULE

Your conveyor is designed to be virtually maintenance free. We do recommend that you regularly inspect the unit to ensure proper operation of mechanical and safety systems.

### DAILY:

- Keep your conveyor free of dirt, debris and grease accumulation.
- Inspect leg elevations and adjust, as necessary, to ensure smooth product flow.
- Look for mechanical damage or worn components and replace as necessary.

### MONTHLY:

- Check to ensure that all bolts and nuts are moderately tight.



**CAUTION!** Do not over torque as this may cause frame distortion and prevent the system from properly flexing.

**Required tools to maintain your conveyor include:**  
Two each of these size wrenches: 1/2" and 9/16".

## TROUBLESHOOTING

OPERATING ISSUE	POSSIBLE CAUSE	RECOMMENDATIONS
<p>Conveyor does not open or roll smoothly.</p>	<p>Casters are locked or clogged with debris.</p> <p>Bolts and nuts have been over tightened.</p> <p>Conveyor has suffered physical damage.</p>	<p>Check casters and unlock or clear as necessary.</p> <p>Check bolt tension.</p> <p>Check unit and replace damaged parts.</p>
<p>Product stops on conveyor or does not flow smoothly.</p>	<p>Leg elevations are out of height adjustment.</p> <p>Skate wheels are jammed.</p> <p>Conveyor has suffered physical damage.</p>	<p>Readjust legs. (See Page 4, Step 3.)</p> <p>Check and clear debris as necessary.</p> <p>Check unit and replace damaged parts.</p>