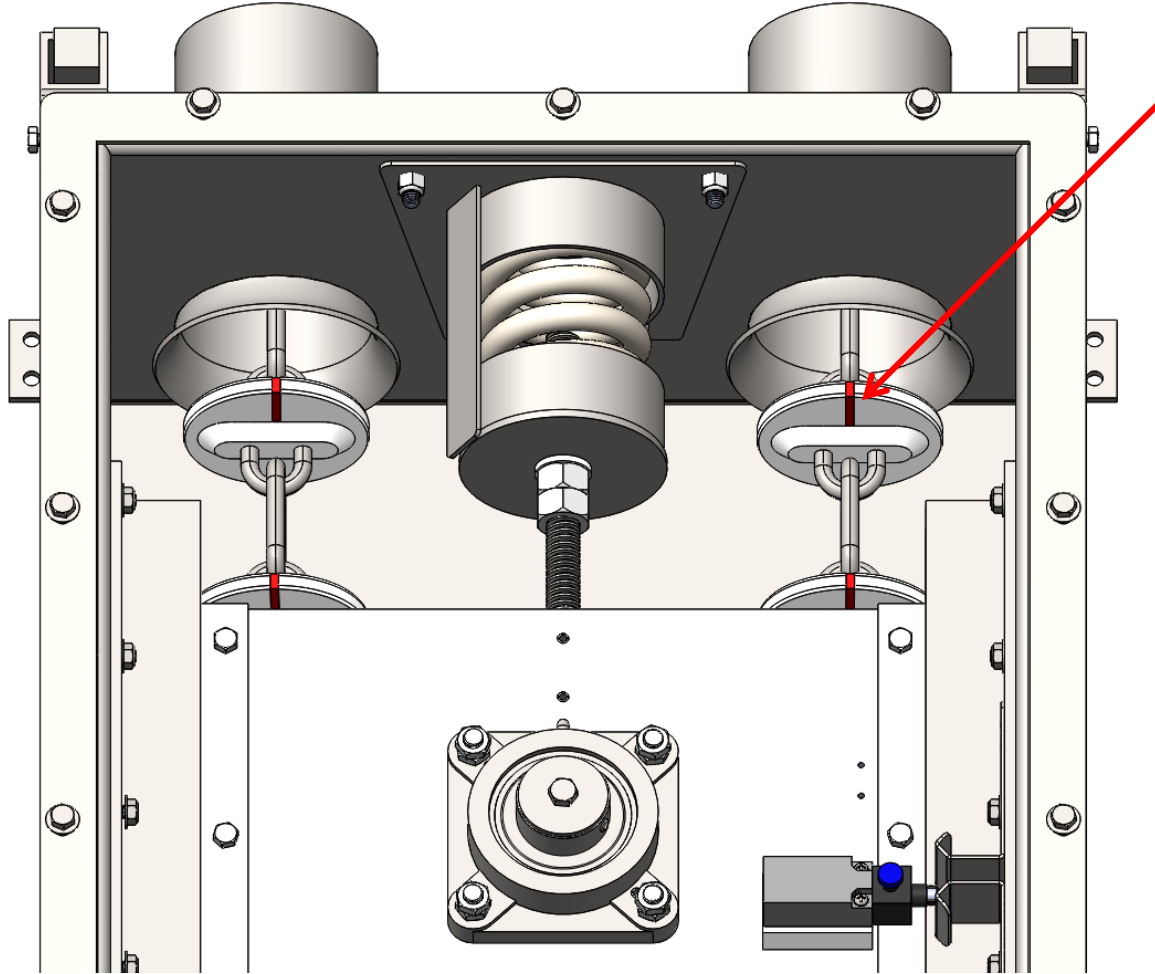


THE CHAIN SHOULD ENTER AND EXIT THE TURNAROUND AND DRIVE BOX WITH NO TWIST OR TILT IN THE LINKS. MINOR DEVIATION FROM TRUE 12 O'CLOCK POSITION IS ACCEPTABLE, BUT THE DISCS SHOULD RUN THROUGH THE CONVEYOR AS SHOWN BELOW. TO PROPERLY DIAGNOSE AND DEFINE A POSSIBLE TWIST, THE CONVEYOR SHOULD BE OBSERVED RUNNING AT A LOW SPEED FOR AT LEAST ONE FULL CYCLE.



A RED LINE HAS BEEN ADDED TO THE DISCS IN THE IMAGE TO BETTER HIGHLIGHT THE ORIENTATION OF THE DISCS.

IF THIS ORIENTATION ISN'T PRESENT IN AN INSTALLED LENGTH OF CHAIN & DISCS, THE CHAIN IS LIKELY TWISTED WITHIN THE SYSTEM.

THE FOLLOWING PAGES GIVE A FEW EXAMPLES OF TWISTED SYSTEMS AND THE PROBABLE SOLUTION TO UN-TWIST THEM.

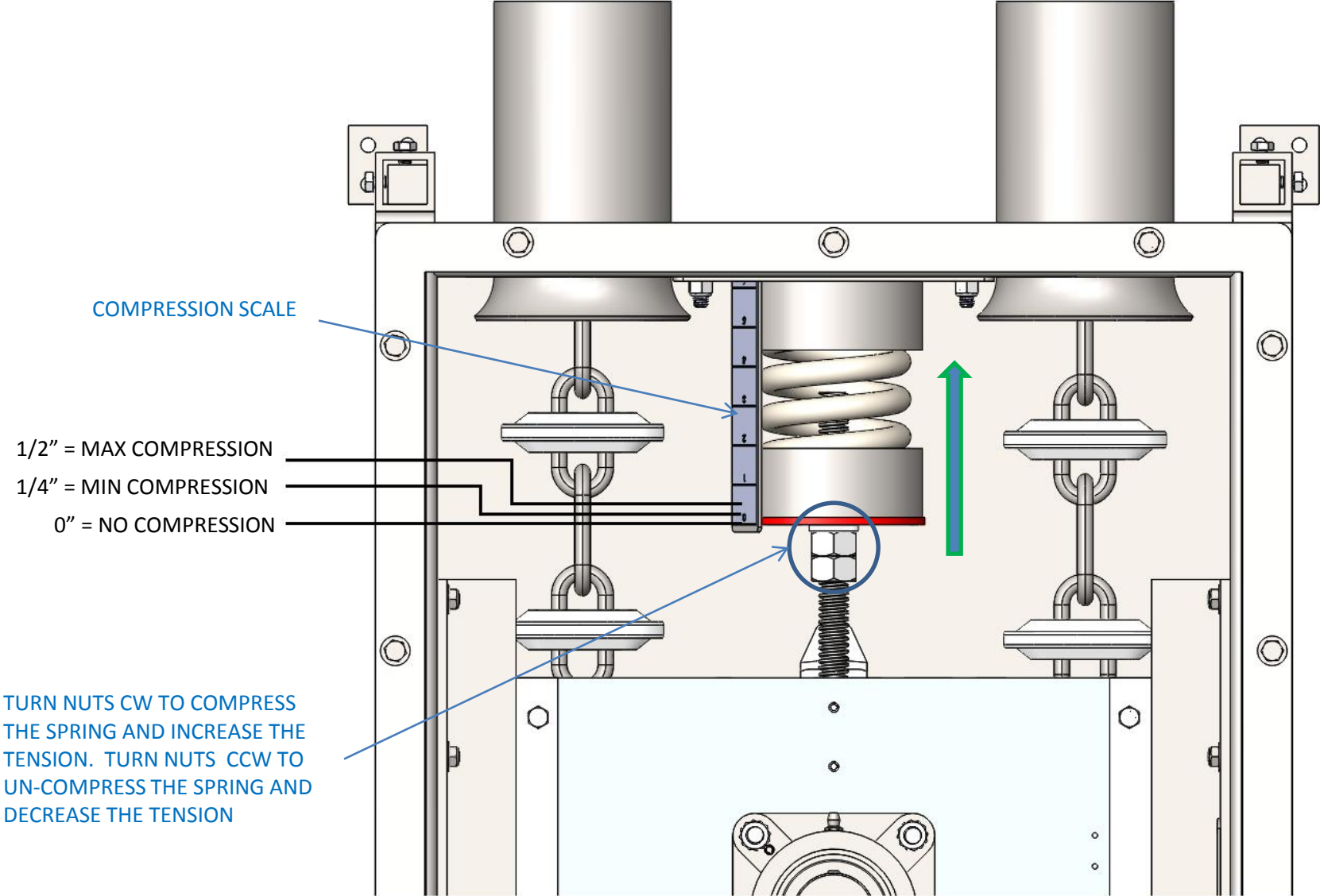
IT'S POSSIBLE FOR A SYSTEM TO HAVE HALF A TWIST, A FULL TWIST, OR MULTIPLE TWISTS, SO THE STEPS REQUIRED TO UN-TWIST THE CHAIN MAY BE MORE COMPLICATED THAN DEPICTED.

IT'S HIGHLY RECOMMENDED THAT THE CHAIN IS ORIGINALLY INSTALLED WITH CAREFUL PRECAUTIONS TAKEN TO AVOID A TWIST IN THE CHAIN.

PROPER TENSIONING IS ALSO IMPORTANT TO MANAGING TWISTS IN THE CHAIN. BEFORE DETERMINING IF A TWIST IS PRESENT OR ATTEMPTING TO CORRECT A TWIST, FIRST ENSURE THAT THE TENSION IS SET PROPERLY.

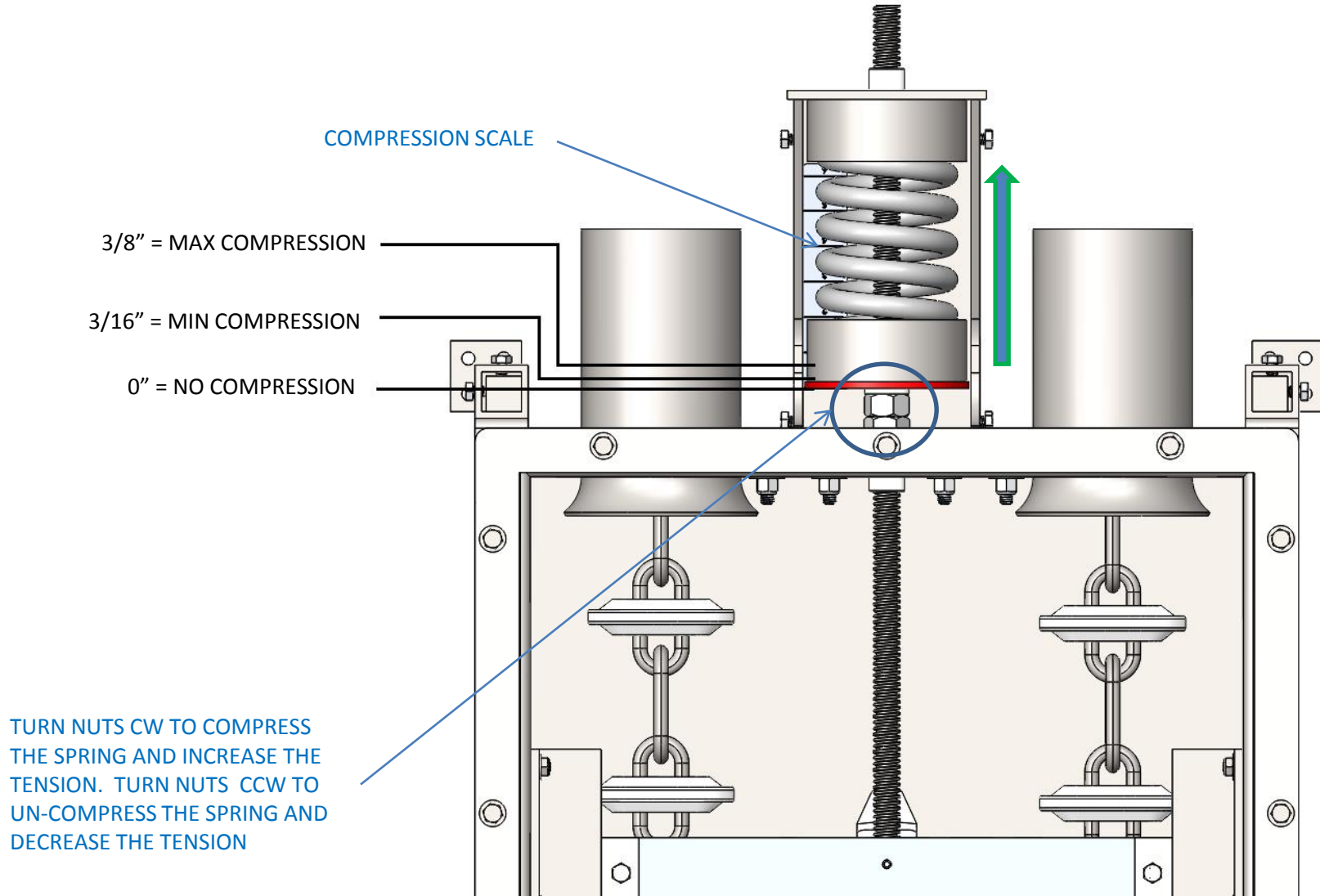
# INTERNAL TENSIONING CONFIGURATION

EACH SYSTEM IS UNIQUE, BUT TYPICALLY 1/4" TO 1/2" OF SPRING COMPRESSION IS APPROPRIATE FOR PROPER CHAIN TENSIONING. WHEN PROPERLY TENSIONED, THE CHAIN SHOULD ALLOW APPROXIMATELY 1/8" OF DEFLECTION WHEN TUGGED ON BY HAND.

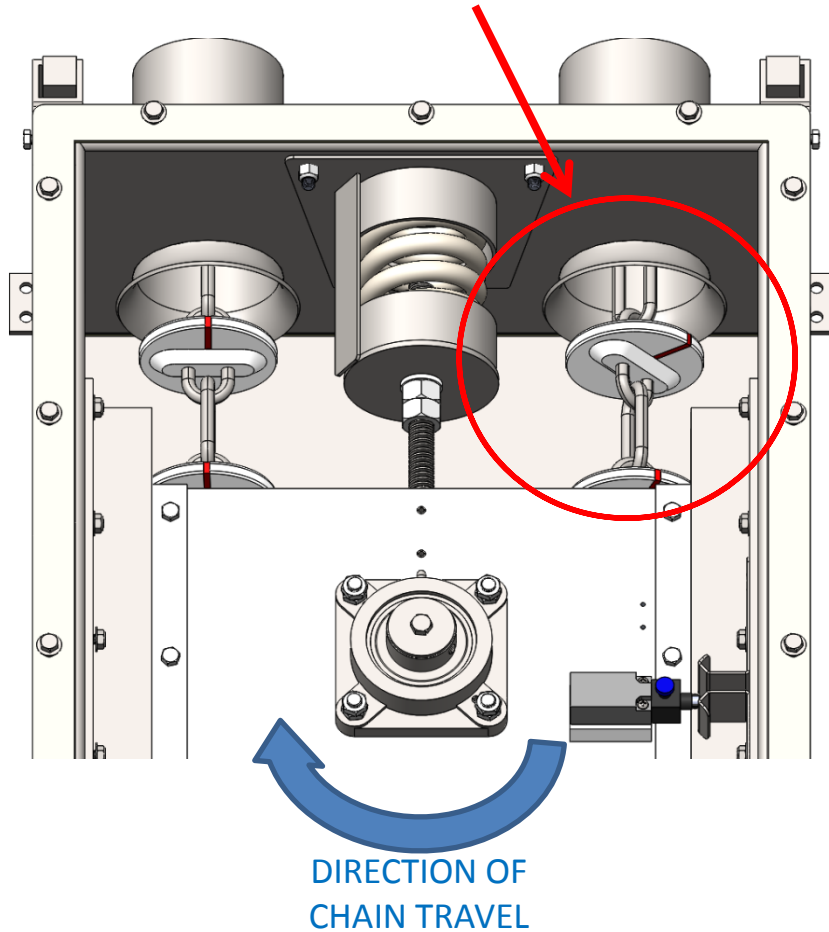


## EXTERNAL TENSIONING CONFIGURATION

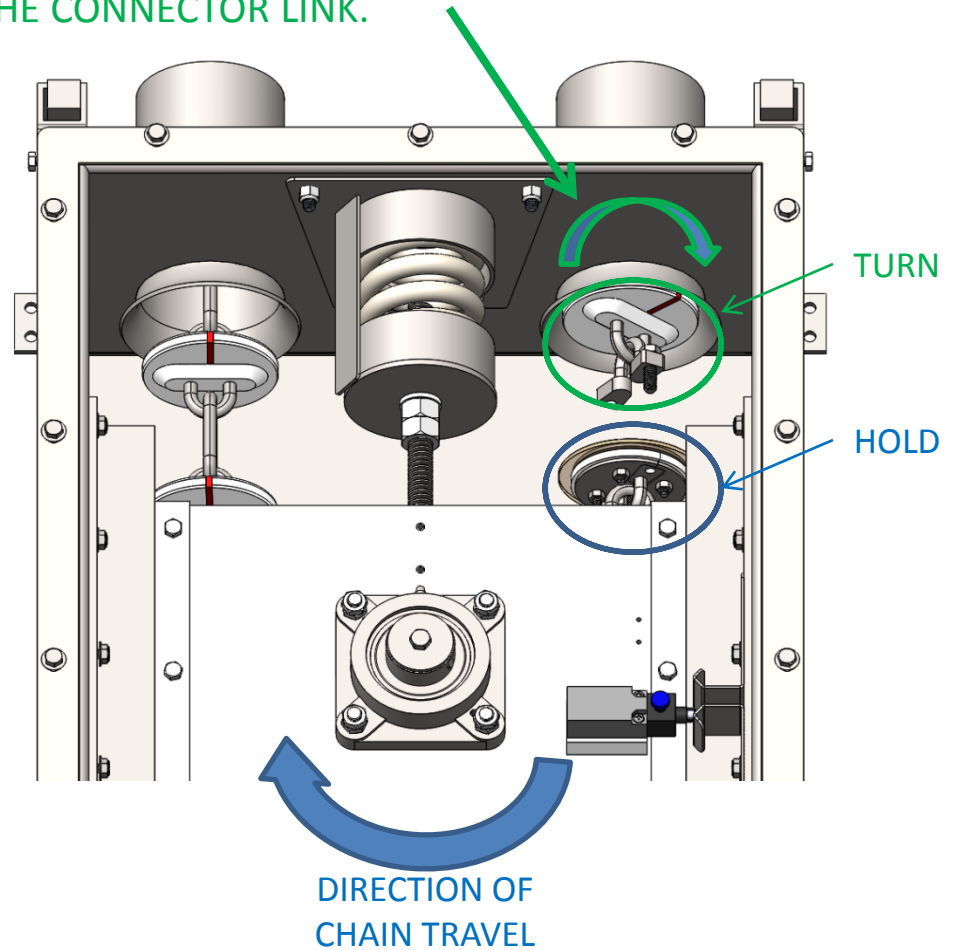
EACH SYSTEM IS UNIQUE, BUT TYPICALLY 3/16" TO 3/8" OF SPRING COMPRESSION IS APPROPRIATE FOR PROPER CHAIN TENSIONING. WHEN PROPERLY TENSIONED, THE CHAIN SHOULD ALLOW APPROXIMATELY 1/8" OF DEFLECTION WHEN TUGGED ON BY HAND.



IF THE CHAIN ENTERS THE TURNAROUND WITH THE DISCS TILTED TOWARDS THE 3 O'CLOCK POSITION...



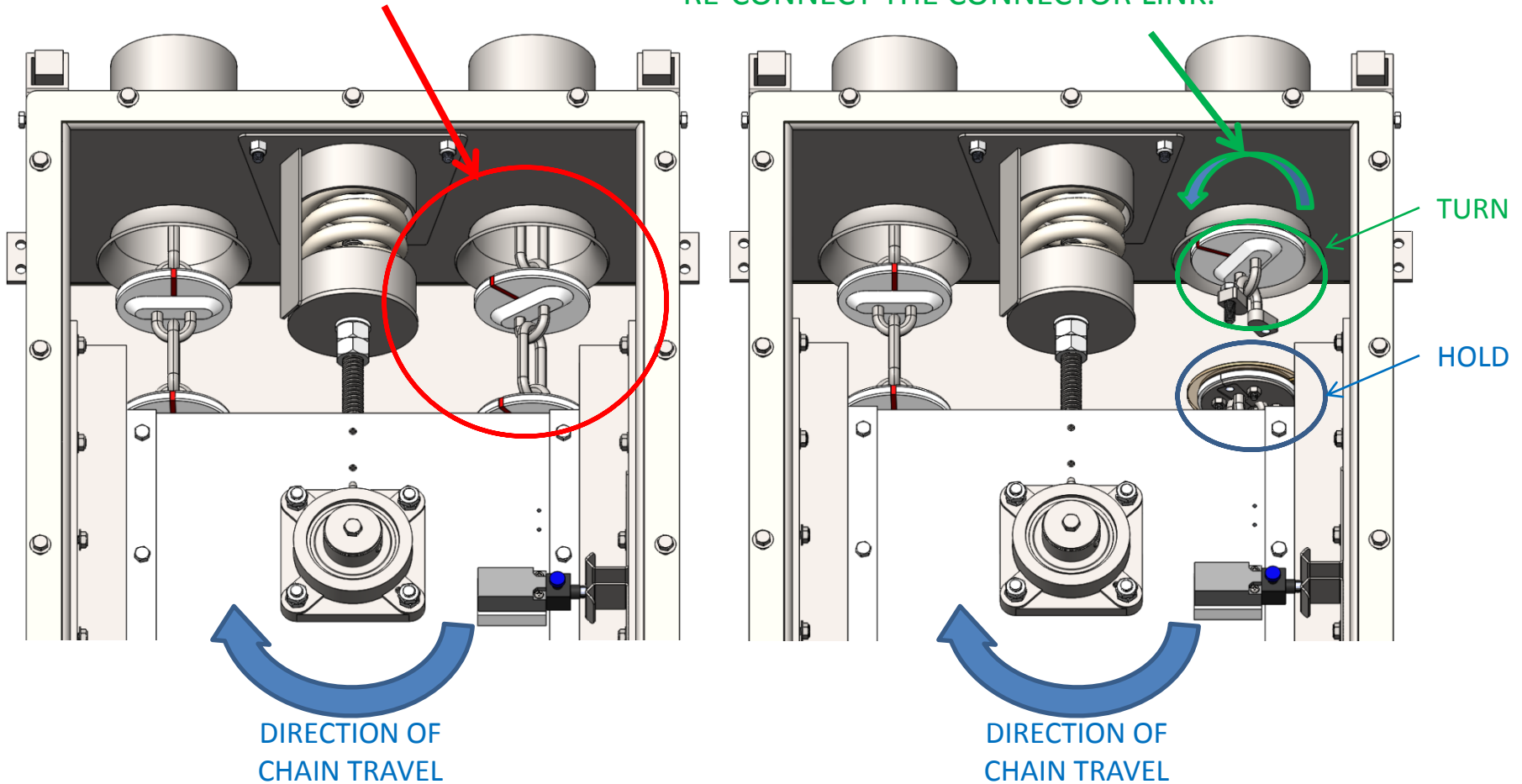
RUN THE CONVEYOR UNTIL THE CONNECTOR LINK IS ACCESSIBLE. UN-BOLT THE CONNECTION AND HOLD THE CONNECTOR LINK IN ITS CURRENT ORIENTATION. ROTATE THE ADJOINING LINK 180° CLOCKWISE AND RE-CONNECT THE CONNECTOR LINK.



AFTER ANY ATTEMPT TO CORRECT A CHAIN TWIST, THE CONVEYOR SHOULD BE RUN ONE FULL CYCLE AT A LOW SPEED TO INSPECT FOR ANY IMPROVEMENT OR ADVERSE CHANGES.

IF THE CHAIN ENTERS THE TURNAROUND WITH THE DISCS TILTED TOWARDS THE 9 O'CLOCK POSITION...

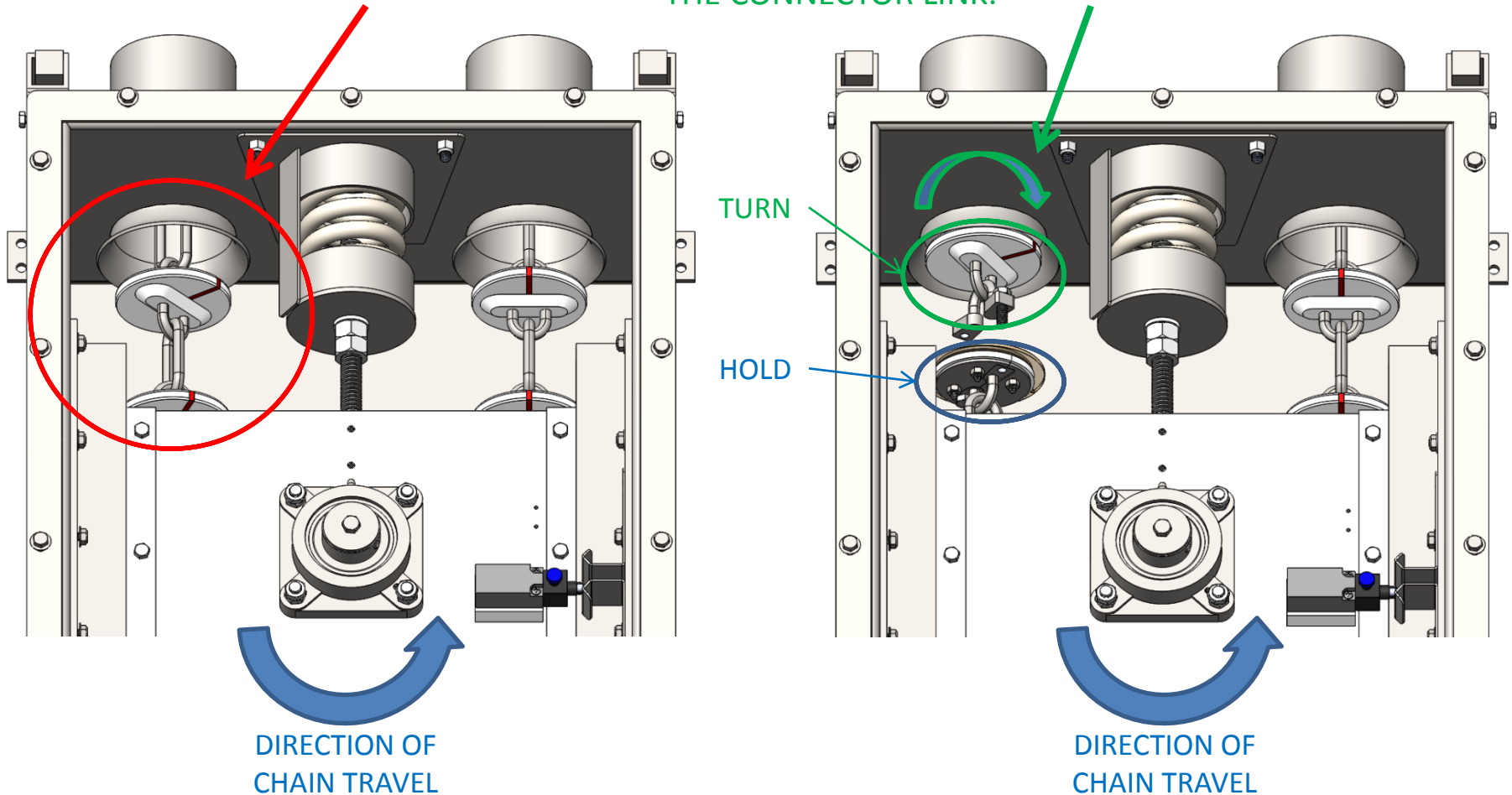
RUN THE CONVEYOR UNTIL THE CONNECTOR LINK IS ACCESSIBLE. UN-BOLT THE CONNECTION AND HOLD THE CONNECTOR LINK IN ITS CURRENT ORIENTATION. ROTATE THE ADJOINING LINK 180° COUNTER-CLOCKWISE AND RE-CONNECT THE CONNECTOR LINK.



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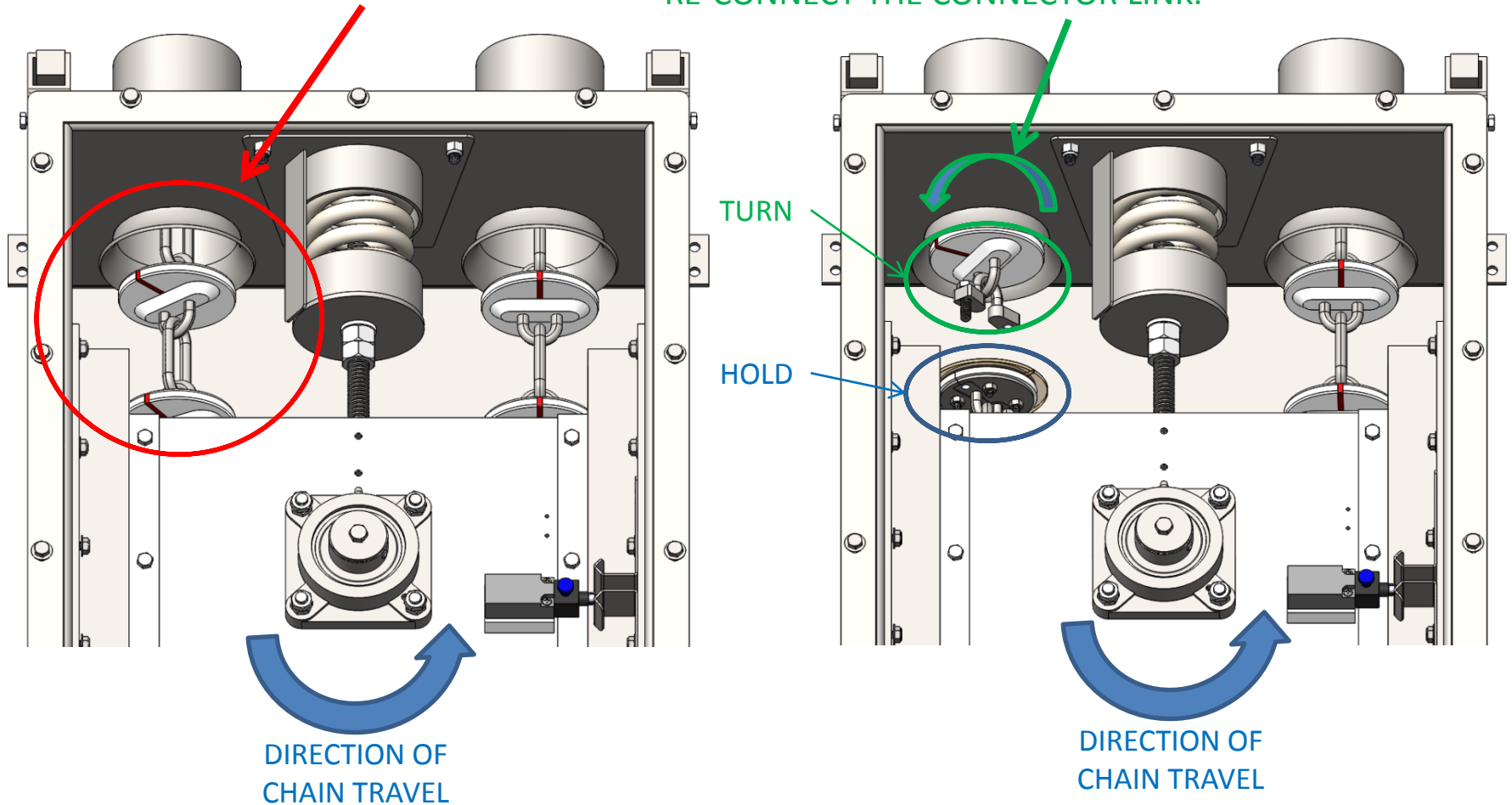
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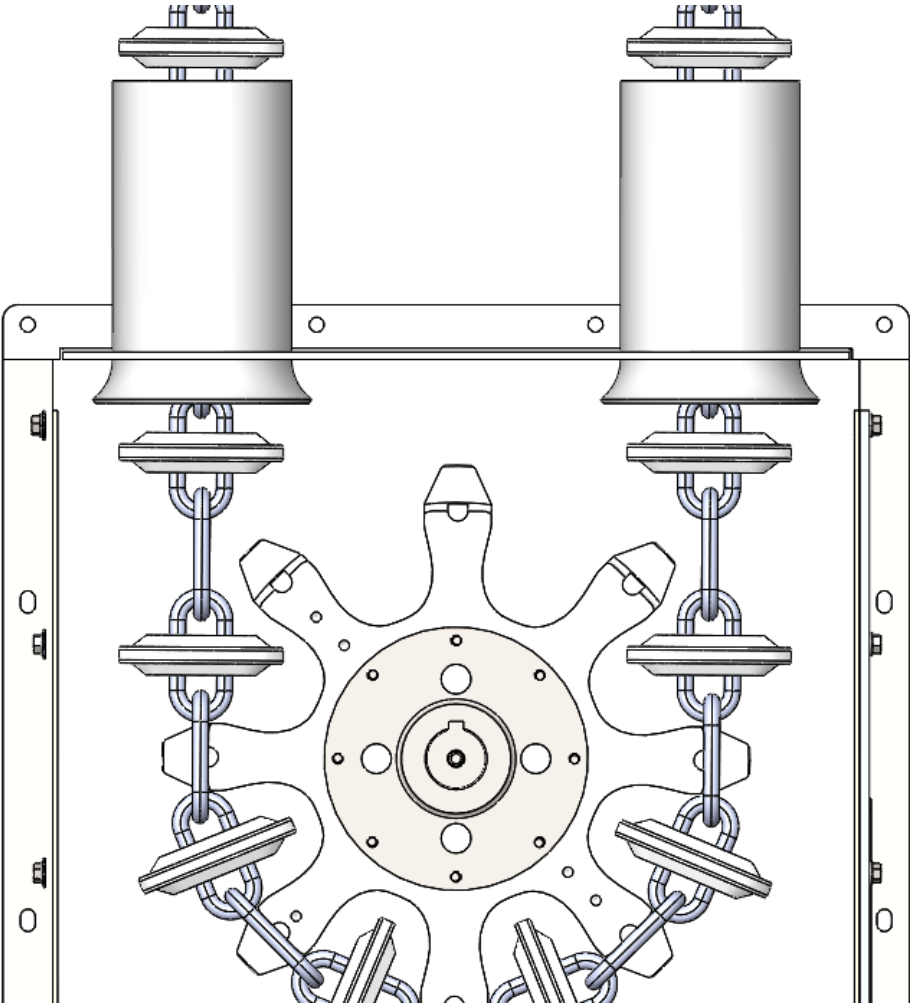
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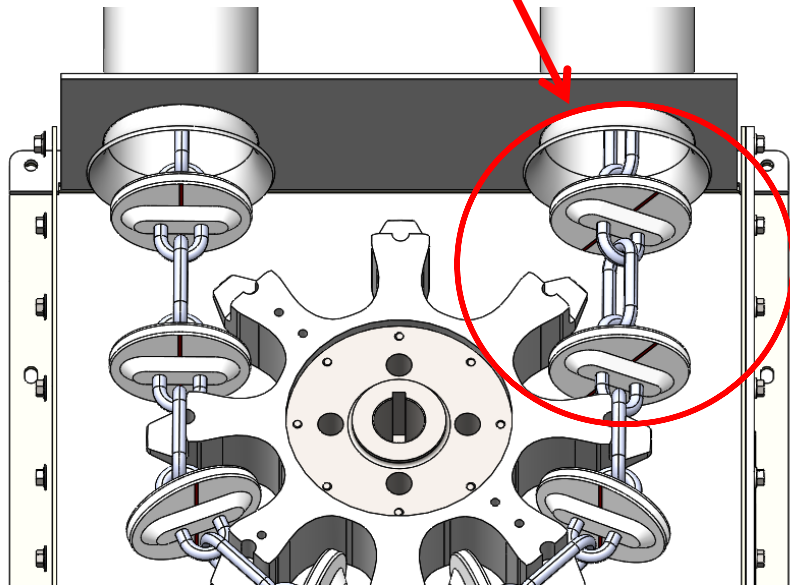


AFTER ANY ATTEMPT TO CORRECT A CHAIN TWIST, THE CONVEYOR SHOULD BE RUN ONE FULL CYCLE AT A LOW SPEED TO INSPECT FOR ANY IMPROVEMENT OR ADVERSE CHANGES.

It's important to also inspect twist at the drive unit. Twist in the chain is independent between both the product and return side piping. Adjusting only one side will not affect the other. In some cases where the drive unit isn't easily accessible, it is easier to run the system in reverse for one full cycle inspecting for twist at the turnaround. If the system isn't capable of running in reverse, the drive transition or bottom cover must be removed to access the chain.

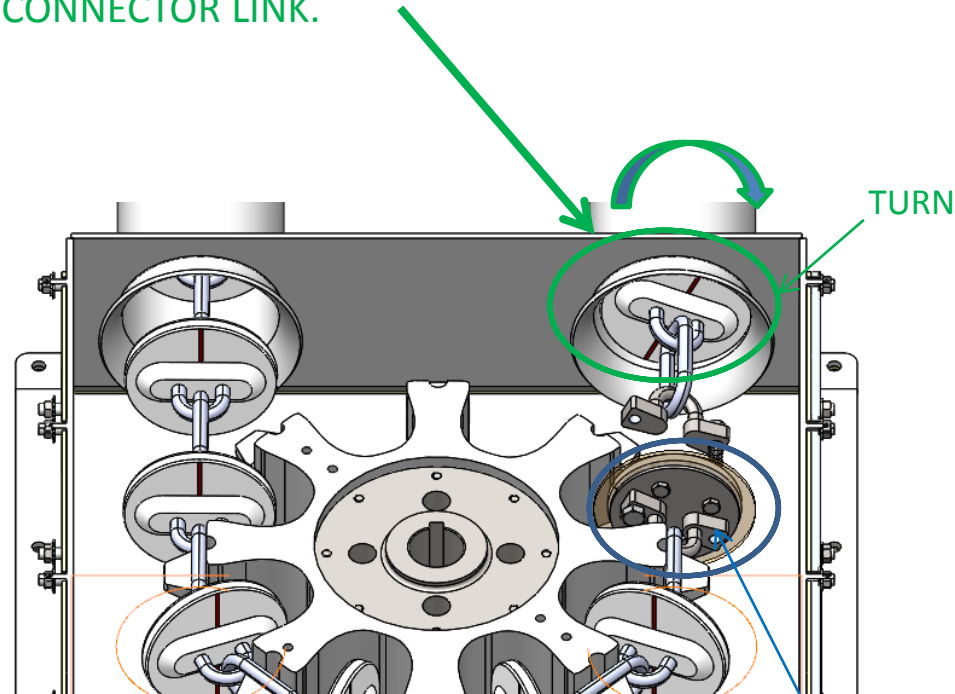


IF THE CHAIN ENTERS THE DRIVE UNIT WITH THE DISCS TILTED TOWARDS THE 3 O'CLOCK POSITION...



DIRECTION OF  
CHAIN TRAVEL

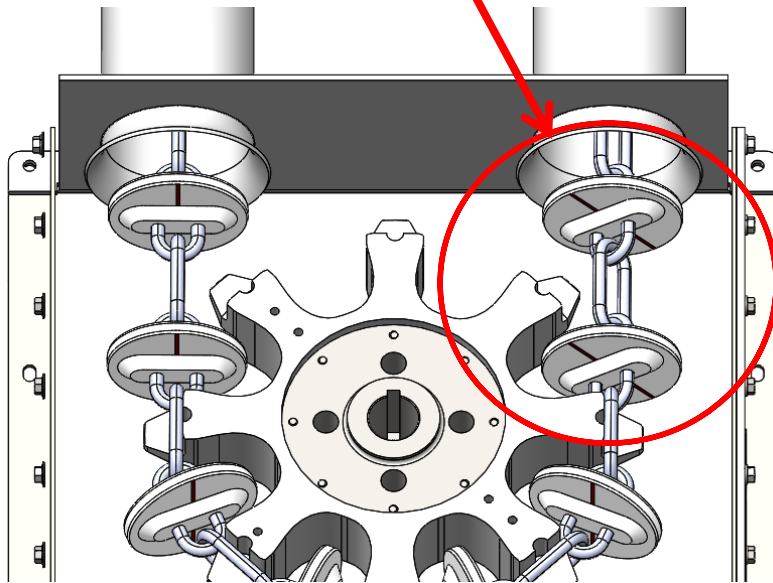
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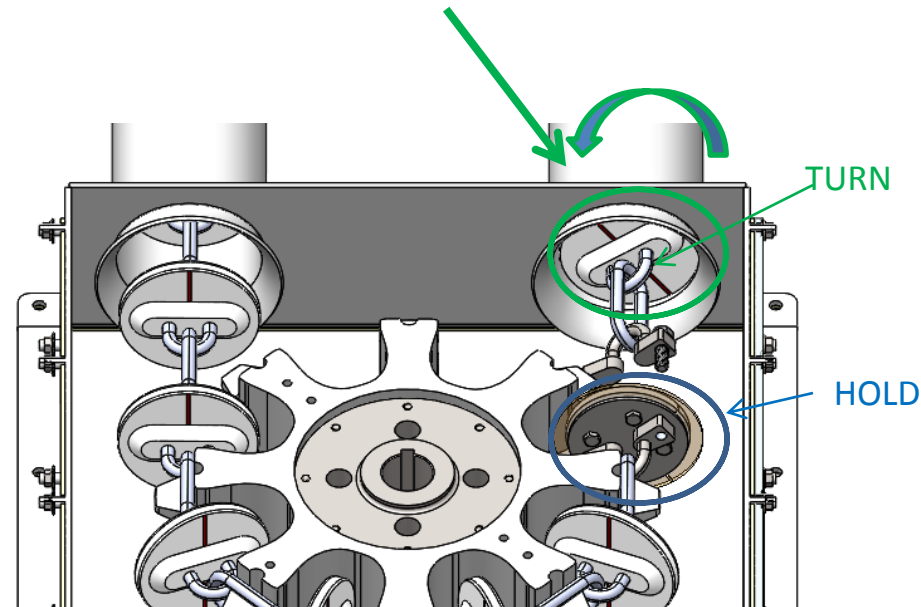
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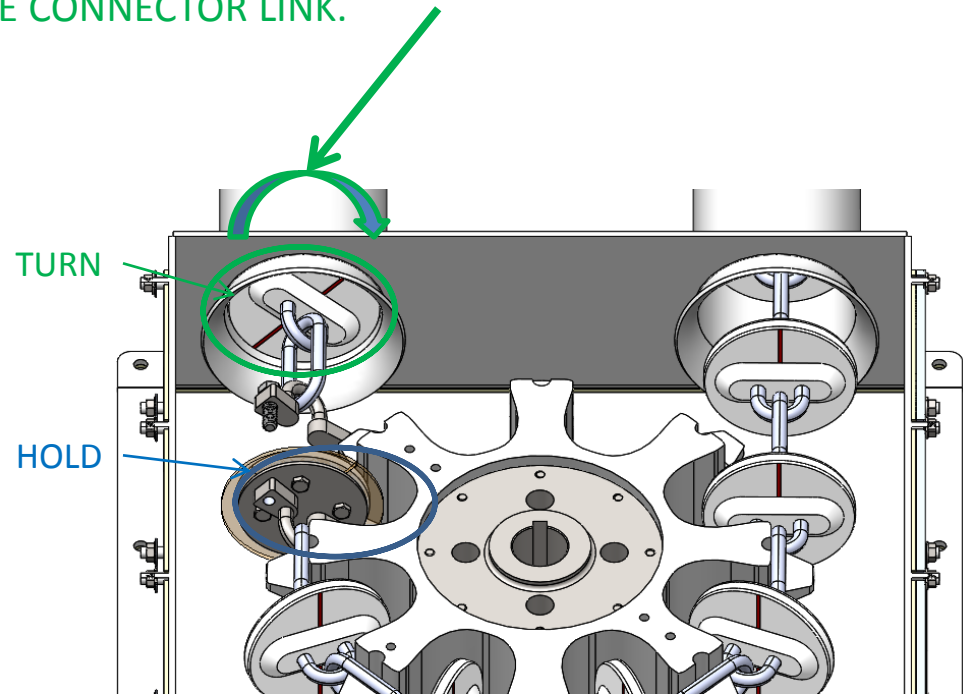
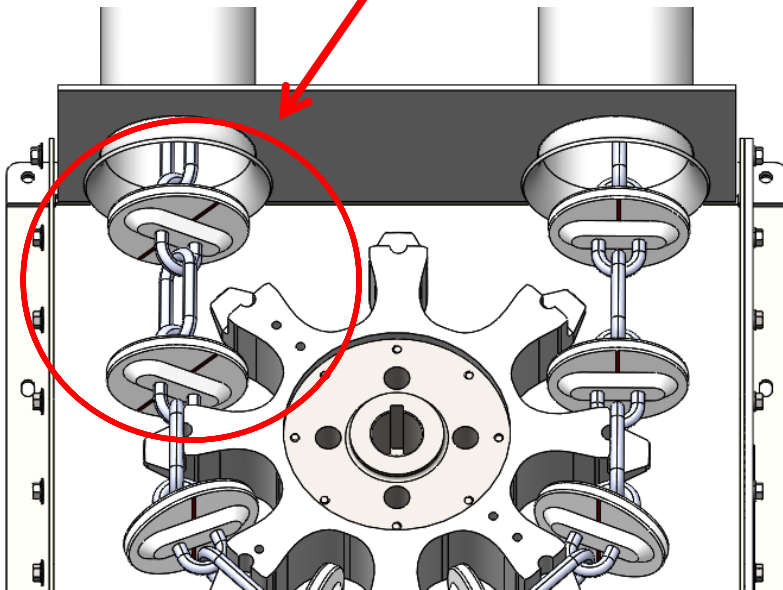


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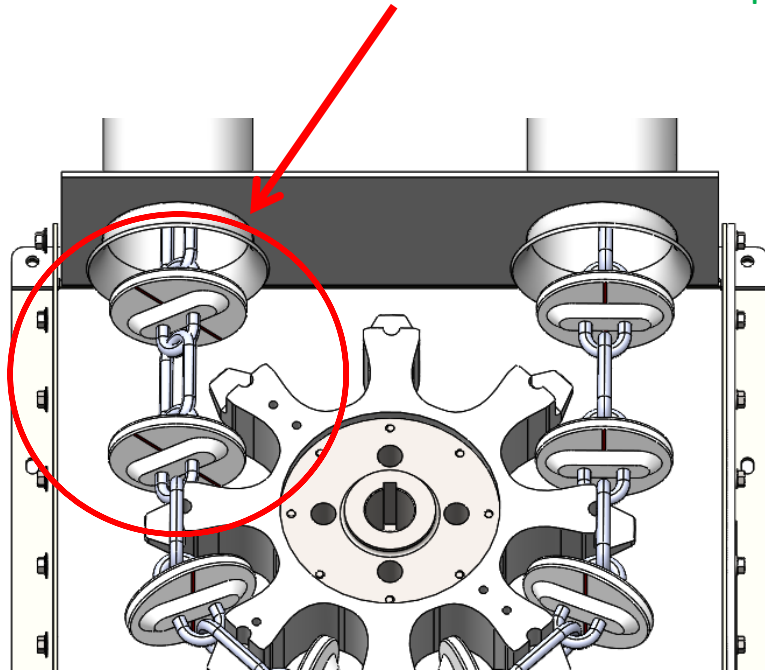
DIRECTION OF CHAIN TRAVEL



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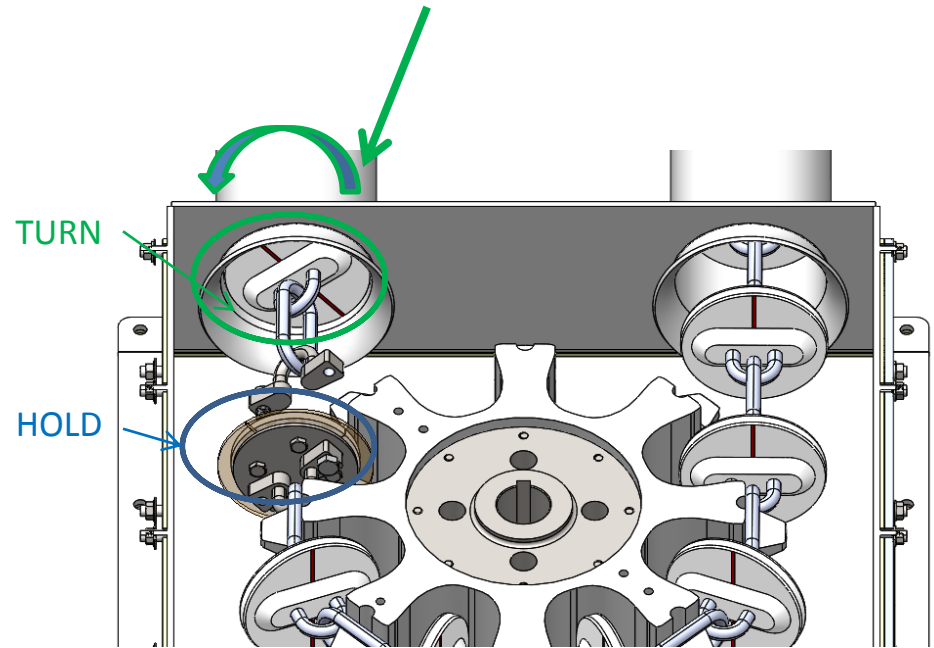
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TURN

HOLD



DIRECTION OF  
CHAIN TRAVEL

AFTER ANY ATTEMPT TO CORRECT A CHAIN TWIST, THE CONVEYOR SHOULD BE RUN ONE FULL CYCLE AT A LOW SPEED TO INSPECT FOR ANY IMPROVEMENT OR ADVERSE CHANGES.

IF YOU ARE UNABLE TO CORRECT A TWIST AFTER SEVERAL ATTEMPTS, IT MAY BE NECESSARY TO REMOVE THE CHAIN AND RERUN IT THROUGH THE PIPE. IT'S POSSIBLE THAT THERE ARE MULTIPLE TWISTS, OR A COMPLEX TWIST, THAT CANNOT BE CORRECTED BY ANY EASY METHOD. IF RERUNNING THE CHAIN IS THE DETERMINED SOLUTION, REVIEW OUR STANDARD INSTALLATION MANUAL OR CONTACT AN MPE REPRESENTATIVE FOR TIPS FOR AVOIDING TWIST DURING INSTALLATION RATHER THAN POST INSTALLATION.

