



**3125 SOUTH KOLIN AVENUE**

**CHICAGO, ILLINOIS 60623**

**P: 773.254.3929**

**F: 773.254.3935**

## **Initial Pre-Start Checklist**

### Piping

- All pipes free of dents, burrs, etc.
- All pipes are level and in line with each other/all components

### Chain

- Chain was fed straight through the system with braided, non-twisting rope
- Chain was fed in correct direction to take advantage of new quiet puck design
- Chain was trimmed to correct length for sprocket positioning
- Chain was trimmed to correctly space the connector link to take the place of a puck
- Connector link is assembled and torqued to the correct torque
- No significant twist is visible in the chain in drive or turnaround unit



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#### Drive Unit

- Motor wired
- VFD setting updated
- Chain on the sprocket
- Compressed air line connected to the solenoid valve
- Solenoid valve wired
- Motor breather plug removed
- Oil level checked
- Housing clear of obstructions/foreign material
- Any high level sensors present are wired
- Tripping high level sensor causes system alarm/shutdown

#### Turnaround Unit

- Chain on the sprocket
- Tension set so that spring plate rests in green area of tension gauge  
(unless alternate position is required due to application)
- Sprocket is positioned with ample clearance to turn without hitting the  
front or back of the box
- Tension limit sensor wired & reset
- Tripping tension switch causes system alarm/shutdown
- Tension sensor trip brackets are centered around the tension switch
- Housing clear of obstructions/foreign material



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## Discharge Valves

- Compressed air line connected to the solenoid valve
- Solenoid valve wired
- Discharge valve responds in the correct direction to an open/close signal
- Air knives turn on while valve is open and off while valve is closed
- Rotary actuator air flow controllers are set so that the valve rotates quickly but does not slam open or closed
- Any high level sensors present are wired
- Tripping high level sensor causes system alarm/shutdown



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**Dry Run Checklist**

Speed:	20%	50%	75%	100%
Motor Load (A):				
Tension (in):				

Start Chain-Vey at 20% speed. Ramp through the follow set points, record motor load and tension, and verify the following:

**Piping**

- No excessive vibration/movement visible during operation
- No clicking present in joints between pipes or components
- No knocking felt when hand is placed on joints

**Drive Unit**

- Motor/sprocket is turning smoothly
- Chain is engaging and disengaging with sprocket smoothly in a level plane
- Air knives are functional
- Tripping high level sensor causes total system shutdown
- Chain twist is not excessive



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#### Turnaround Unit

- Sprocket is turning smoothly
- Chain is engaging and disengaging with sprocket smoothly in a level plane
- Tension set so that spring plate rests in green area of tension gauge (unless alternate position is required due to application)
- Tension sensor trip brackets are centered around the tension switch
- Tripping tension sensor causes total system shut down
- Sprocket is positioned with ample clearance to turn without hitting the front or back of the box
- Chain twist is not excessive

#### Discharge Valve

- Tripping high level sensor causes total system shutdown



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**Product Run Checklist**

Speed:	20%	50%	75%	100%	Production Operating Cond.
Product Fill:	50%	50%	50%	50%	Production Operating Cond.
Motor Load (A):					
Tension (in):					

Start Chain-Vey at 20% speed. Ramp through the follow set points, record motor load and tension, and verify the following:

**Drive Unit**

- Motor/sprocket is turning smoothly
- Chain is engaging and disengaging with sprocket smoothly in a level plane
- Pocket fill & speed of production operating conditions are not above 80%
- Carryover is not excessive

**Turnaround Unit**

- Sprocket is turning smoothly
- Chain is engaging and disengaging with sprocket smoothly in a level plane
- Tension is set so that spring plate rests in green area of tension gauge (unless alternate position is required due to application)



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- Tension sensor trip brackets are centered around the tension switch
- Sprocket is positioned with ample clearance to turn without hitting the front or back of the box

#### Discharge Valve

- Air knives adjusted to minimize carryover (typically 20-40% flow)