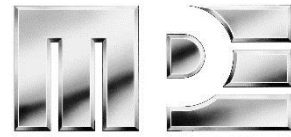


# CHAIN-VEY QUICK START GUIDE

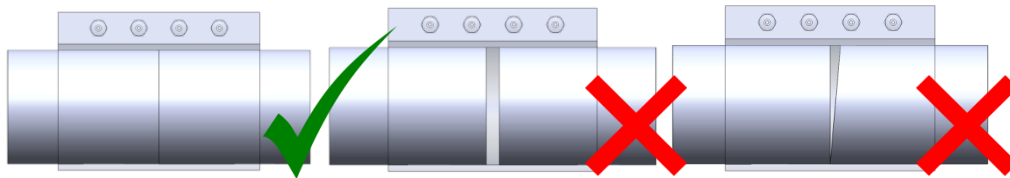


1. Mount turnaround unit, inlets, discharges, and drive box in desired locations. Ensure centerlines are aligned.
2. Install straight pipe sections, elbows, and floor & ceiling supports where needed.

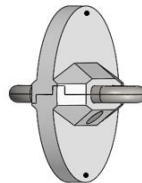


## BE SURE TO:

- Cut pipes square
- Deburr pipe edges
- Eliminate any gaps in connection points & tighten outer bolts first to ensure connection does not loosen
- Refer to manual detailed pipe cutting instructions

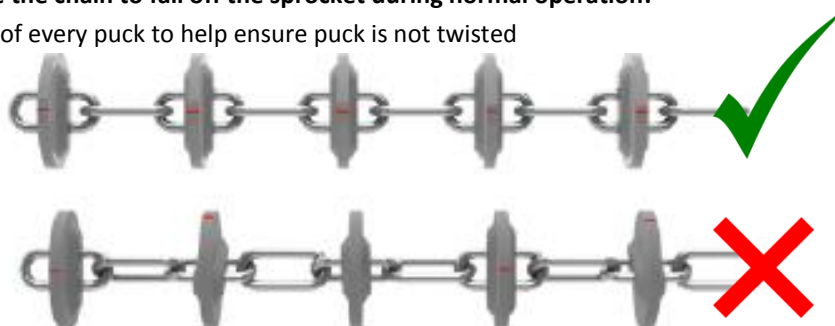


3. Install 1 support every 8 – 10 feet
  - Support drive boxes, discharge valves, and turnaround units individually
4. Run chain and puck through the system, and then trim excess chain length.
  - Trim chain by cutting links with pucks so that connection link fits puck pattern
  - In order to take advantage of Chain-Vey's new quiet puck design it is important to have the pucks facing in the right direction. The puck direction is indicative of the two punch marks on the front face of the puck. These marks will be facing in the direction that the conveyor is moving.



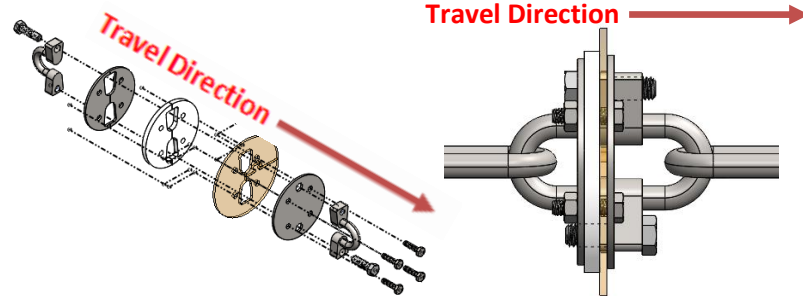
**Make sure that every puck enters the pipe in the exact orientation to avoid any twisting of the chain. Twisting will cause the chain to fall off the sprocket during normal operation.**

- Mark top of every puck to help ensure puck is not twisted

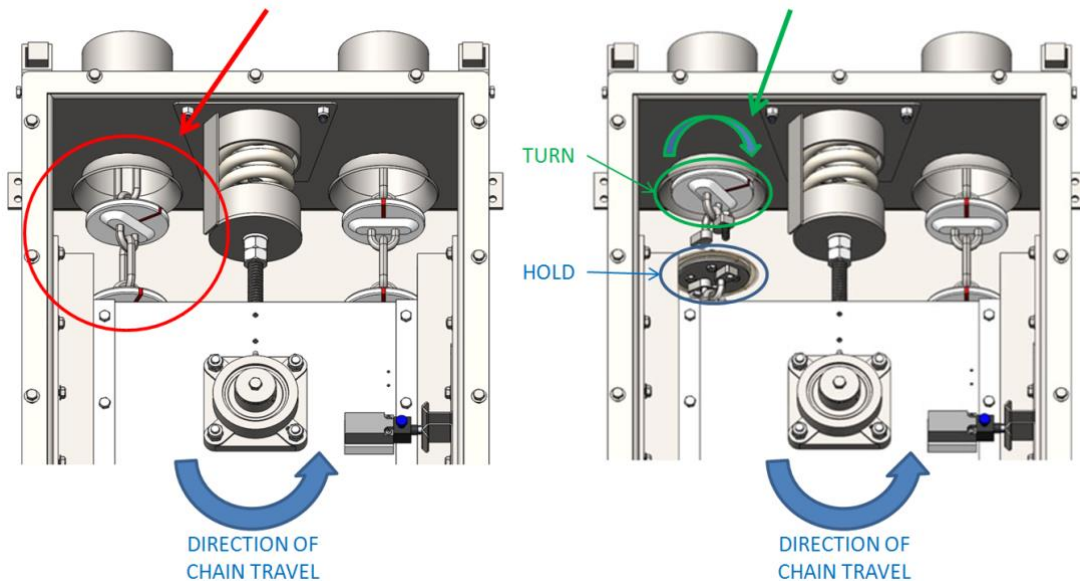


- Use a cable-puller, wire snake, or braided (not laid/twisted) rope to route through the conveying pipe. Connect the chain to the cable and pull or winch the chain through the tube.

5. Connect the two ends of chain with connection link.
  - Ensure that link is assembled so that travel direction is as shown in two diagrams below.
  - Avoid stripping the threads of the connector link. A stainless steel anti-seize lubricant is recommended.
  - Torque bolts to 270 in-lb (30 N-m)



6. Set spring tension to desired wire tension by adjusting nut position at turnaround unit
  - Do not over tension the system – the turnaround unit will have a length gauge for reference
7. Wire and plumb air to drive box, discharge boxes, etc.
  - To avoid issues it is usually best to have an MPE technician perform this step
8. Turn motors on and troubleshoot system
  - Run system at 10% speed for first several revolutions
  - If twisting is observed in the turnaround box, run the conveyor until the connector link is accessible on the inlet side. Un-bolt the connection and rotate the adjoining link 180° in the direction that twist is observed.



- After attempting to correct twist, run one full cycle at low speed to inspect for improvement
- If unable to correct twist after sever attempts it may be necessary to remove chain and rerun it to remove multiple or complex twisting