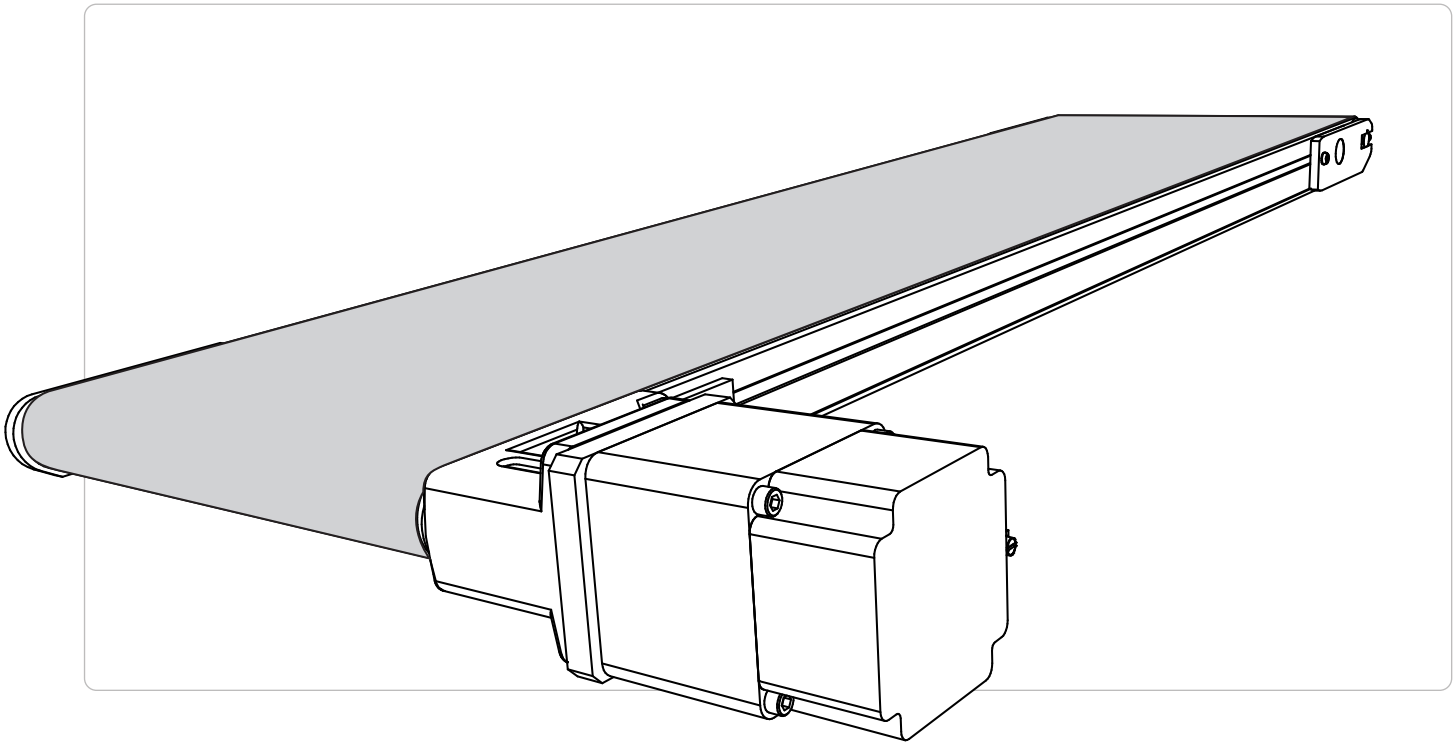
AS40 CONVEYOR MANUAL

Installation, Operation, Maintenance



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qcconveyors.com

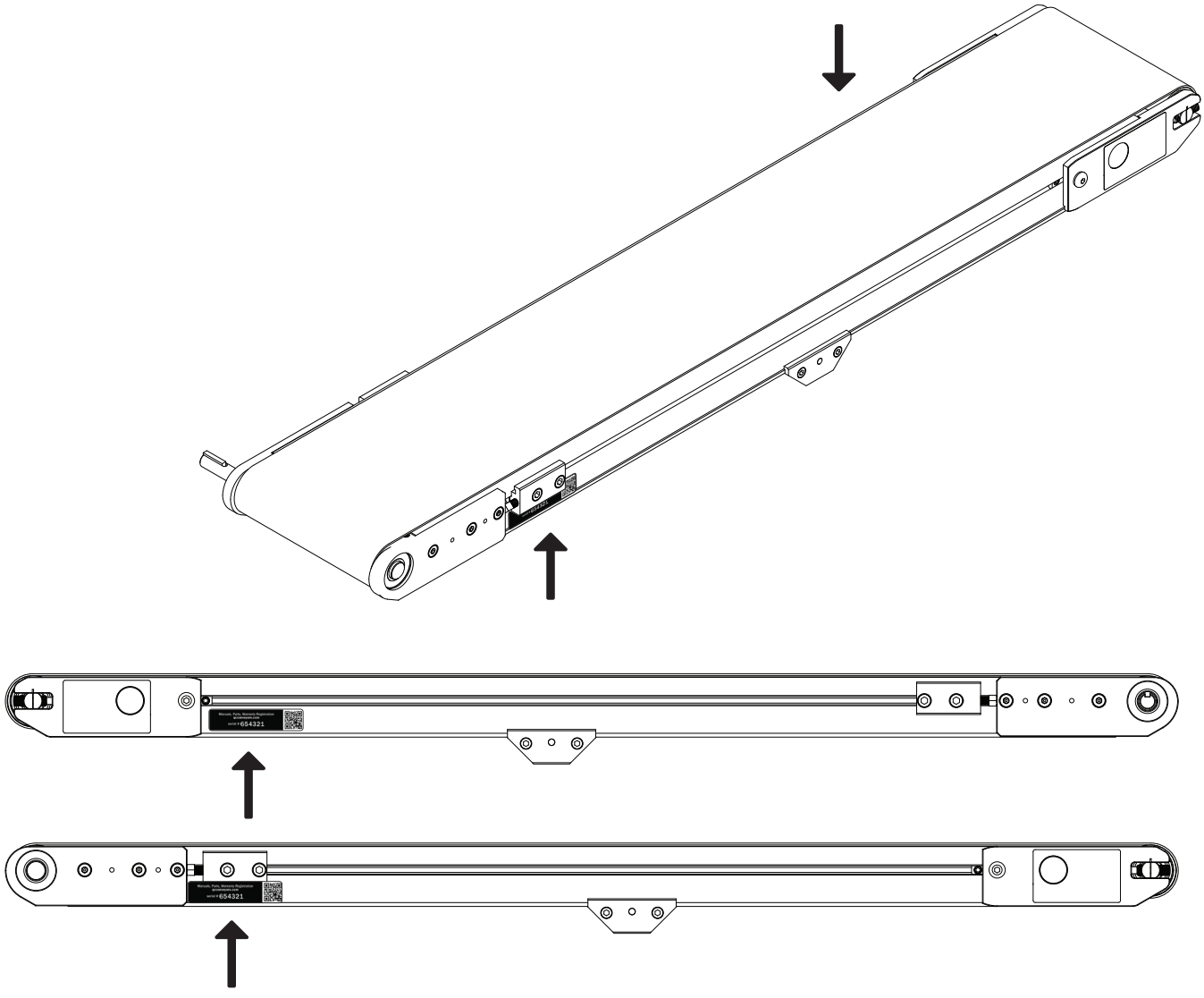
QC Conveyors
A **DURAVANT** COMPANY

Recommended Spare Parts List

Conveyor Spare Parts	Drawing Page
Tail Assembly	28
White Urethane Belt	24 – 25
Drive End Bearing Housing	26 – 27
Full Width Underside Idler	31
Stub Roller Underside Idlers	29 – 30
Pulley Assembly	26

To order parts, please visit qcconveyors.com/serial or call us at +1 (513) 753 – 6000

Locating the Serial Number



Warnings

CAUTION

When used improperly, the conveyor rollers can pinch or maim.

CAUTION

Lock out power before servicing the conveyor.

CAUTION

Do not use with the guards removed.

CAUTION

Read this manual before operating.

DANGER

Climbing, sitting, walking, or riding on the conveyor at any time could result in severe injury or death. KEEP OFF.

WARNING

Exposed, moving parts can cause severe injury. DISCONNECT POWER before removing the guards.

WARNING

The equipment may start without warning and can cause severe injury. KEEP AWAY.

WARNING

Servicing equipement that is moving or energized can cause severe injury. LOCK OUT POWER prior to performing maintenance.

Tools

REQUIRED TOOLS

Wrench set: 3mm – 13mm

Tape Measure

10" Adjustable Wrench

Screw Gun and T-30 Torx Bit

Wide, Flat Head Screw Driver

Set of Metric Allen Wrenches: 3mm, 4mm, 5mm ballhead

Bubble Level

OPTIONAL TOOLS

3/8" Drive Socket Wrench

QC Conveyors Bearing Removal Tool (Part# 1A0077A)

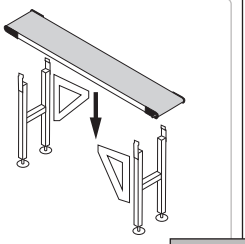
Electric chop saw with proper cutting blades

Aluminum and Steel Cutting Hack Saw, or Equivalent

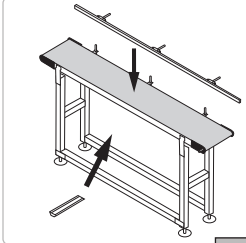
▷ Check Your Shipment

Before opening the shipment, visually inspect the outside of the crate/box for shipping damage. Carefully unpack the crate/box, inspecting for component damage which may have occurred inside the packing materials. Contact the carrier and QC Conveyors regarding any damage that may have occurred during shipment. Check the contents of your shipment against the supplied packing slip and inform QC Conveyors of any discrepancies.

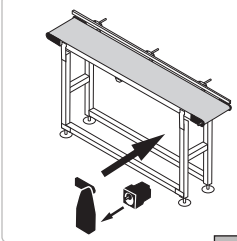
▷ General Sequence of Installation



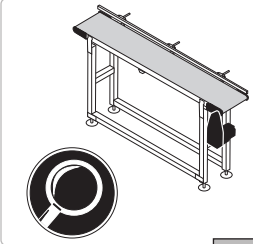
1. Mount conveyor to stands or mounting brackets; install angle brackets if appropriate. In applications with three stands, install angle braces only on outer-most stands.



2. Attach sides, guides or underside idlers to conveyor and adjust as needed.



3. Install drive motor and mounting package.

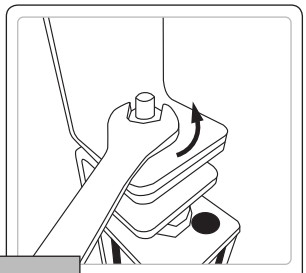


4. Lag conveyor to floor/ Engage caster locks and inspect conveyor before use.

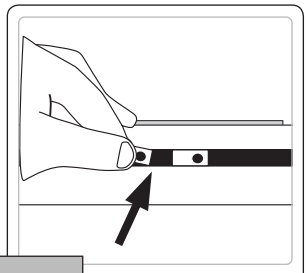
▷ Assistance

If you need assistance, please contact QC Conveyors customer service department Monday through Friday, 8am-5pm EST at (513) 753-6000. In addition, your local distributor has been trained at the factory and can provide support in many ways. You can also visit our website — qcconveyors.com — for additional information and technical documents.

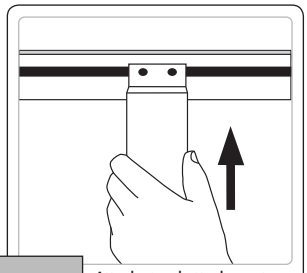
Stands should be placed as close to the conveyor's ends as possible. The standard, maximum distance between stands is 6', however there are a few exceptions to this rule. Conveyors up to 6" wide with a maximum total load of 20 lbs; conveyors 8 – 12" wide with a maximum total load of 25 lbs; or conveyors 18 –24" wide (no load limit) may have stands placed up to 10' apart.



1 Remove the nuts holding the stand attachment brackets to the top of the stand and remove the brackets.



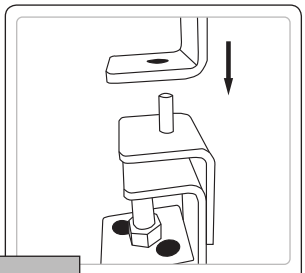
2 Insert drop in nuts into t-slot on conveyor frame



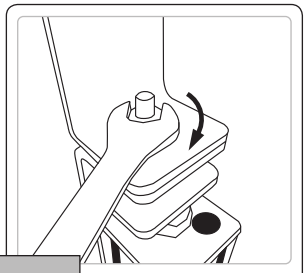
3 Attach stand attachment brackets to conveyor using a 5mm allen wrench.

For Conveyors 6" wide or less: flange should point outward; spacer must be installed between stand attachment bracket and conveyor frame.

For conveyors more than 6" wide: flange should point inward; no spacer is necessary

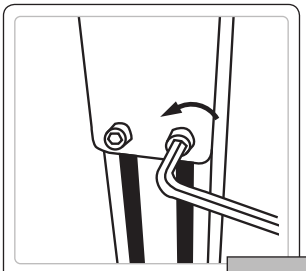


4 Place stand attachment brackets atop stands.

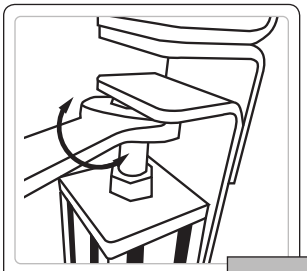


5 Replace nuts and tighten.

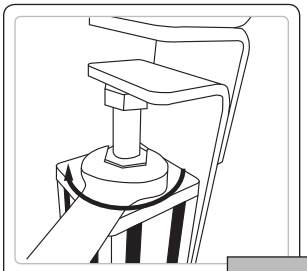
▷ Stand Height Adjustment



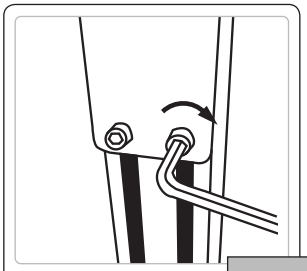
1 Loosen two lower screws in each stand bracket using a 5mm allen wrench.



2 Adjust stand height using a 3/4" wrench to turn the bolt clockwise to lower or counter-clockwise to raise. Ensure conveyor is level.



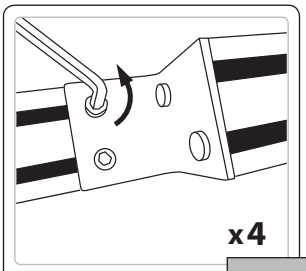
3 Tighten jam nut against top plate of stand.



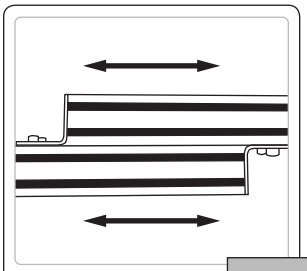
4 Tighten two lower screws in each stand bracket using a 5mm allen wrench.

▷ Installing Cross Ties

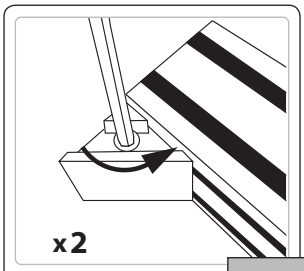
For applications using a single cross tie, the cross tie should be installed between the cross bars of the stands. For applications using two cross ties, the cross ties should be installed between the uprights of the stands. The installation process is the same for each.



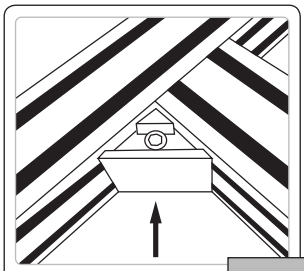
1 Using a 5mm allen wrench, loosen two socket head cap screws in each cross tie adjustment plate.



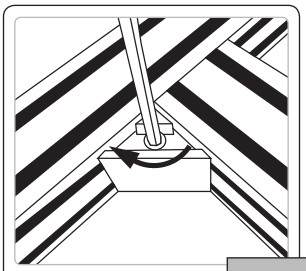
2 Slide adjustable cross tie pieces to fit between stands



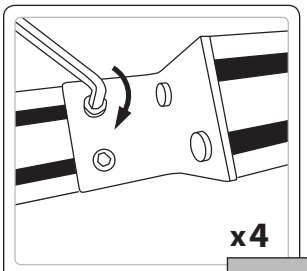
3 Loosen triangular Quick Clamp on each end of cross tie.



4 Ensuring the socket head cap screw is facing you, slide Quick Clamp into tee slot at desired mounting position.

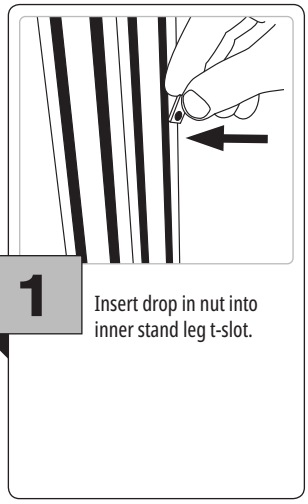


5 Using a 5mm allen wrench, tighten Quick Clamp.

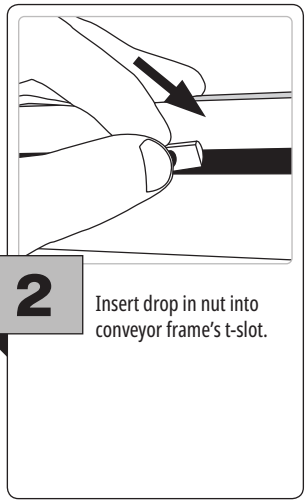


6 Using a 5mm allen wrench, tighten two socket head cap screws in each cross tie adjustment plate.

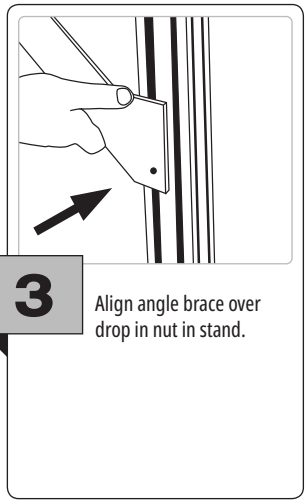
Warning: Use caution when moving a conveyor with casters. Moving conveyors with casters can create dynamic forces that could tip the conveyor. Injury is possible if the stands are not lagged to the floor, cross ties are not used, or angle braces are not present. Never place a conveyor in operation until all proper mounts are installed and secured.



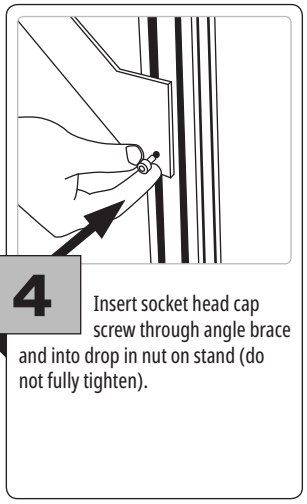
1 Insert drop in nut into inner stand leg t-slot.



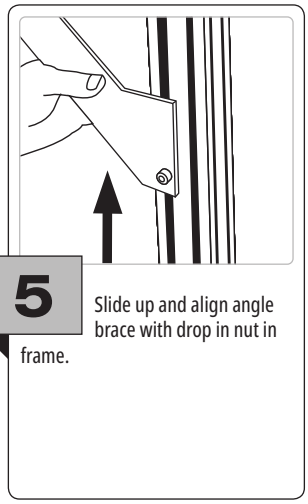
2 Insert drop in nut into conveyor frame's t-slot.



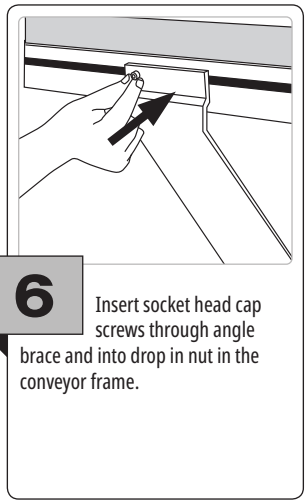
3 Align angle brace over drop in nut in stand.



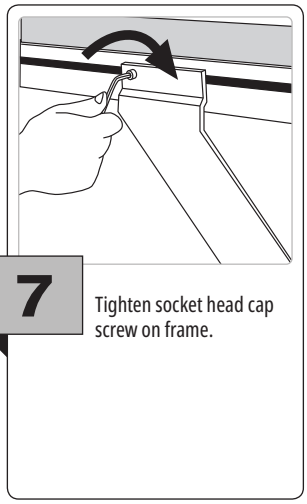
4 Insert socket head cap screw through angle brace and into drop in nut on stand (do not fully tighten).



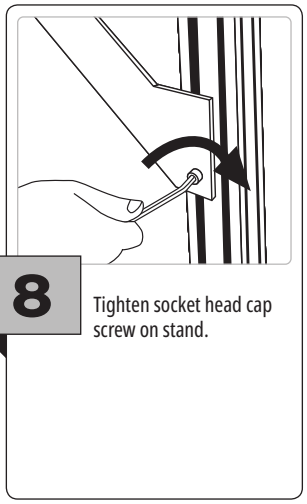
5 Slide up and align angle brace with drop in nut in frame.



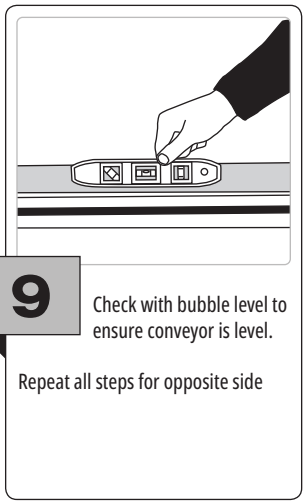
6 Insert socket head cap screws through angle brace and into drop in nut in the conveyor frame.



7 Tighten socket head cap screw on frame.



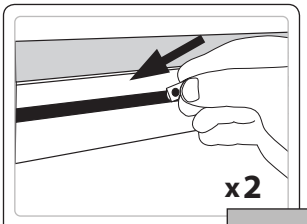
8 Tighten socket head cap screw on stand.



9 Check with bubble level to ensure conveyor is level.

Repeat all steps for opposite side

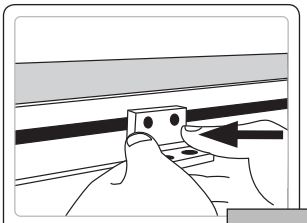
▷ Preparing T-Slot



1

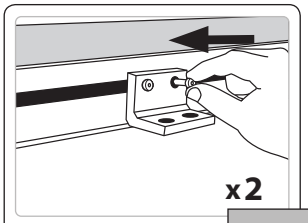
Insert drop in nuts into t-slot at the desired mount location.
Proceed to correct mount type below.

▷ Flush Mount



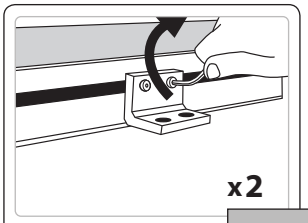
1

Align mount to drop in nuts.



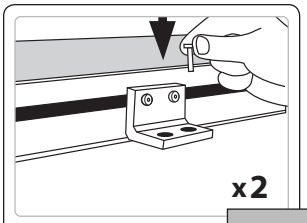
2

Insert socket head cap screws through mount and into drop in nut.



3

Tighten screws to secure mount to frame.

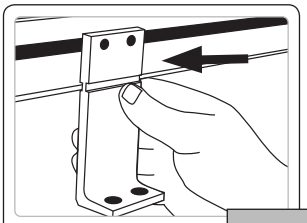


4

Insert screws (not provided) into desired mounting surface and tighten.

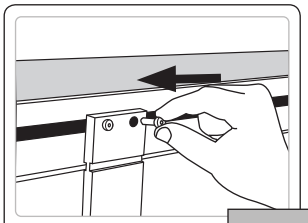
▷ Raised Mount

Mount's foot can be placed facing inward or outward depending on application.



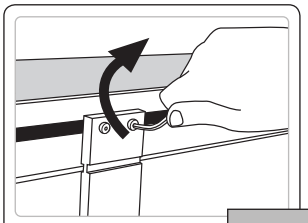
1

Align mount to drop in nuts.



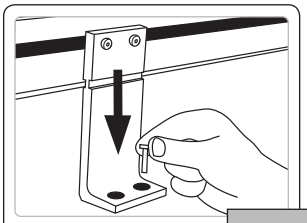
2

Insert socket head cap screws through mount and into drop in nut.



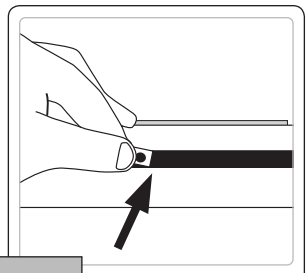
3

Tighten screws to secure mount to frame.

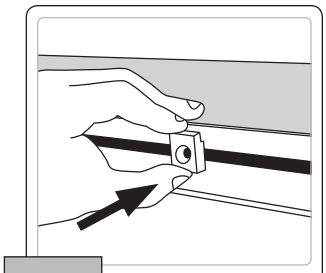


4

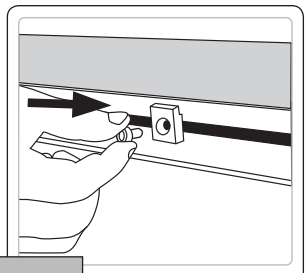
Insert screws (not provided) into desired mounting surface and tighten.



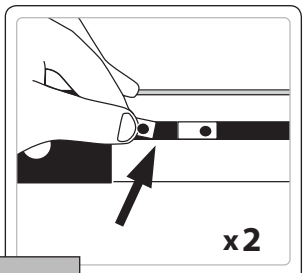
1 Insert drop in nuts into t-slot on frame.



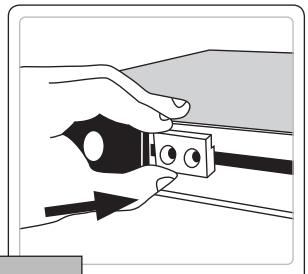
2 Align guide brackets with drop in nuts.



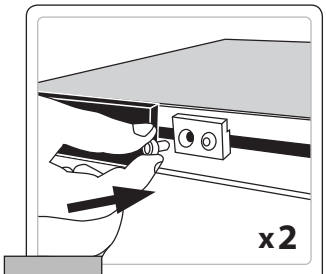
3 Insert socket head cap screw through guide clamp and into drop in nuts.



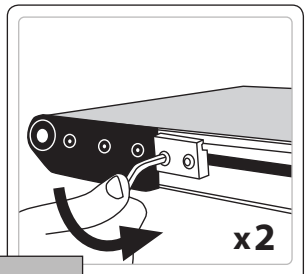
4 Insert two drop in nuts into t-slot at tail end of frame.



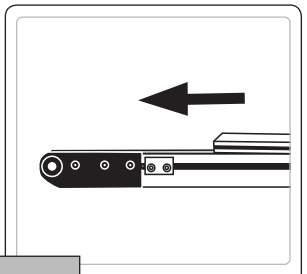
5 Align clamping block to drop in nuts.



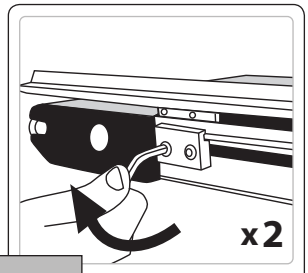
6 Insert screws through clamping block and into drop in nuts.



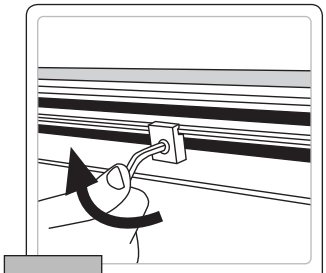
7 Loosen tracking block screws. (Do not remove)



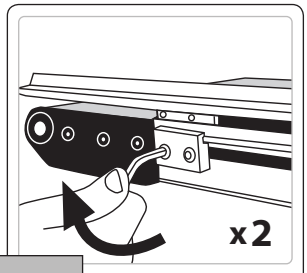
8 Slide guide rail in between clamps and frame until in place.



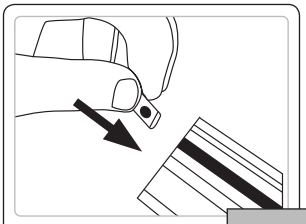
9 Tighten screws in clamping blocks.



10 Tighten screws in guide clamps.

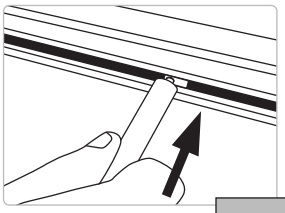


11 Re-tighten screws in tracking block.



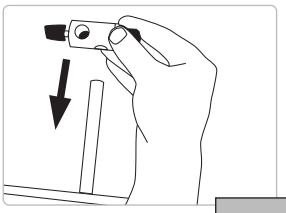
1

Insert drop in nuts into t-slot of guiderail and slide into position



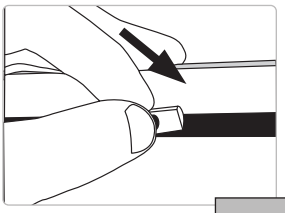
2

Loosely thread adjusting rod into nuts.



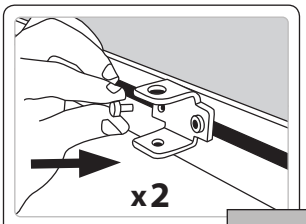
3

Place a cross block onto each guiderail and set aside.



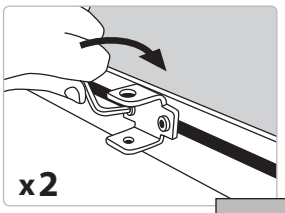
4

Insert drop in nuts into t-slot on frame.



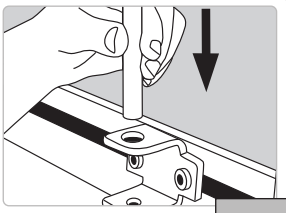
5

Align guide bracket, keeping the larger hole up, with drop in nuts and insert screws.



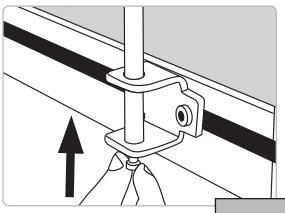
6

Tighten socket head cap screws.



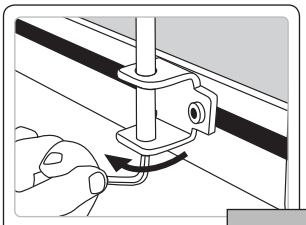
7

Insert a rod vertically through the larger hole on top of guide bracket.



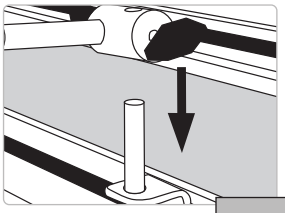
8

Secure rod from below with socket head cap screw.



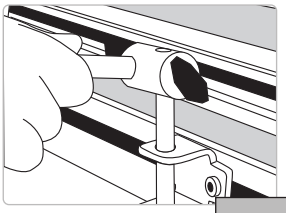
9

Tighten cap screw.



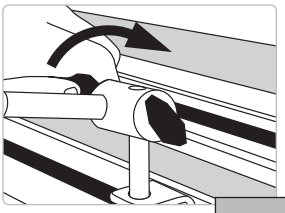
10

Slide guiderail assembly over vertical rods on frame.



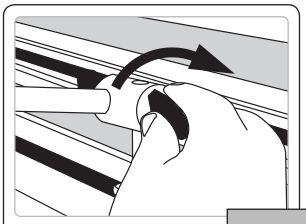
11

Adjust guides to desired width and tighten rods.



12

Tighten screw on cross block to secure rod.



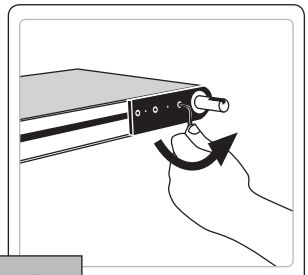
13

Adjust guide to desired height and tighten screw on crossblock to secure. (Guide should NOT touch belt)

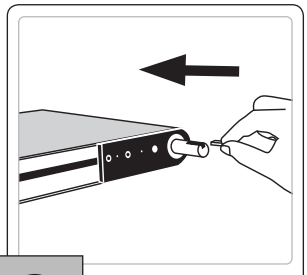
Conveyor may tip after motor is installed if feet are not properly lagged to floor, or if outriggers are not installed.

QC Conveyors recommends that all wiring be completed by a certified electrician to ensure correct installation. Refer to documentation contained in the motor's box for instructions on electrical connections.

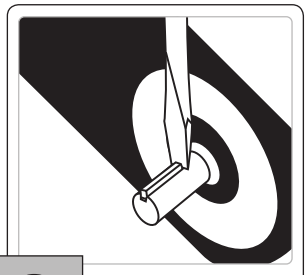
The Drive Package will ship separate from the conveyor with the speed reducer attached, and the speed reducer's coupler already attached to its shaft. For Standard Duty Drives the speed reducer and motor will ship installed on the drive mounting package.



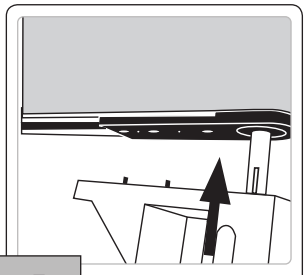
1 Remove and discard three cap head screws from drive side bearing block. (Leave bearing block in place)



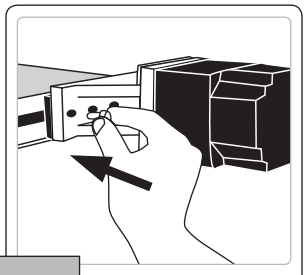
2 Install 4mm x 14mm key to shaft. (Shipped with mounting package)



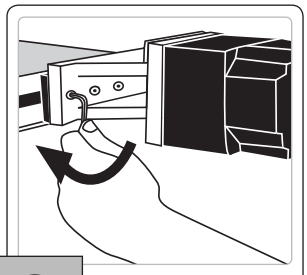
3 Using a flathead screwdriver, lightly strike just behind the key. This will stop it from sliding.



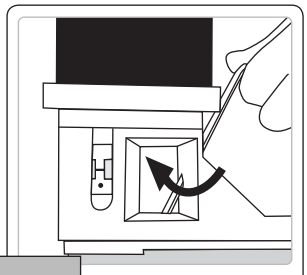
4 Align pins to bearing plate and slide mounting package over pulley's shaft against bearing plate.



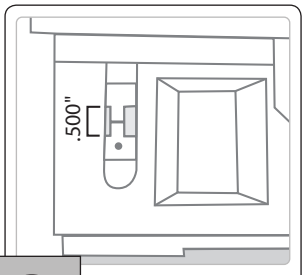
5 Insert three socket head cap screws.



6 Tighten two socket head cap screws.



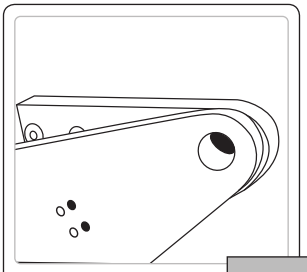
7 The third socket head cap screw will need to be tightened at an angle through access points using a ball head allen wrench.



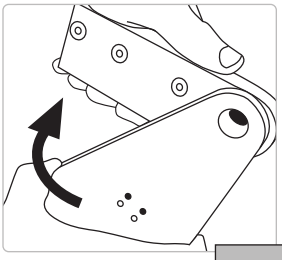
8 Ensure set screws on couplings are tight. (Belt may need to be rotated to reveal set screws in window)

ID Bore	Torque Value
12mm/Drive Pulley	58 – 62 in-lbs
18mm	44 in-lbs

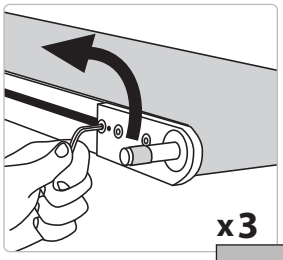
The Drive Package will ship separate from the conveyor. For Standard Duty Drives the speed reducer and motor will ship installed on the drive mounting package.



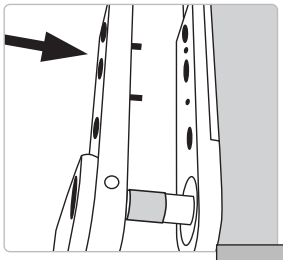
1 Loosen two set screws in drive mounting plate.



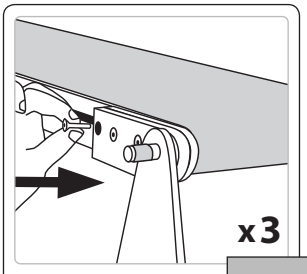
2 Rotate drive mounting plate into workable position.



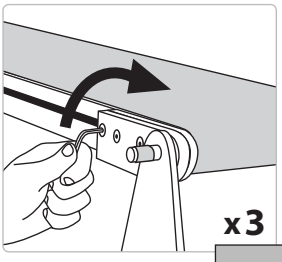
3 Remove and discard three socket head cap screws from drive side bearing plate. (Do not remove bearing plate)



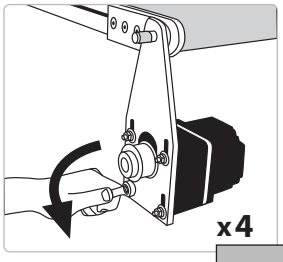
4 Align pins on mounting plate to holes on bearing plate and slide assembly over shaft.



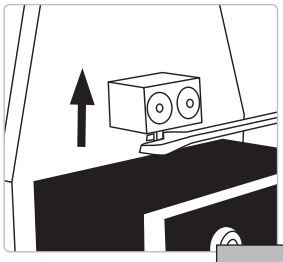
5 Install flat head screws into countersunk holes.



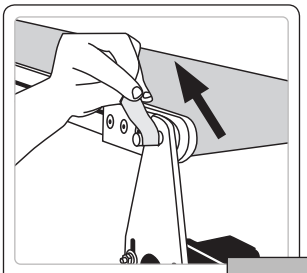
6 Tighten screws in countersunk holes.



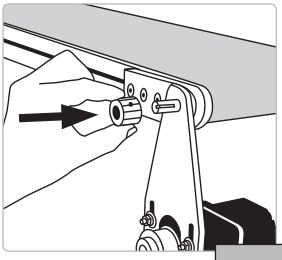
7 Loosen four hex nuts holding gearbox in position.



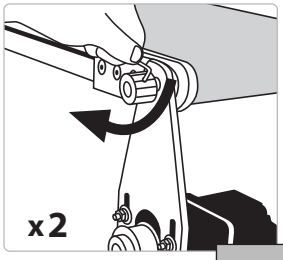
8 Tighten jacking screw to allow gearbox to move toward conveyor.



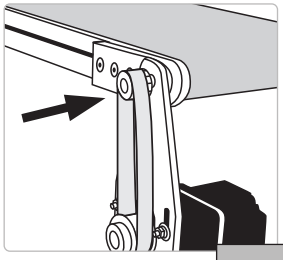
9 Remove tape holding key in place. (Do not remove Key)



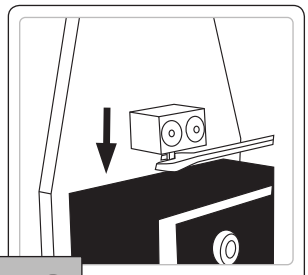
10 Slide top sprocket onto conveyor's output shaft and key.



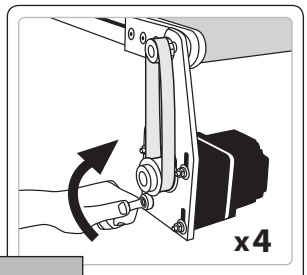
11 Tighten set screws to secure top sprocket.



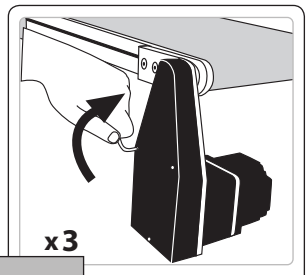
12 Install timing belt over sprockets.



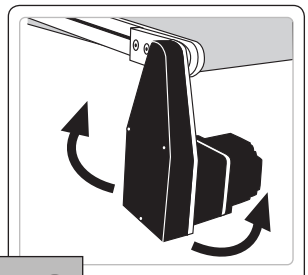
13 Run jacking screw out to create tension on belt. (Approximately 6lbs of force to deflect one span of belt .09")



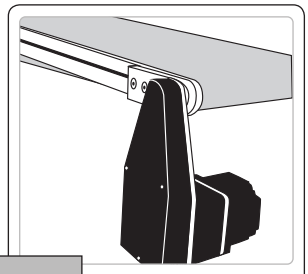
14 Retighten four hex nuts.



15 Replace guard and secure in place with socket head cap screws.

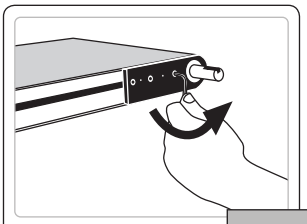


16 Rotate pivot drive into desired position for operation.

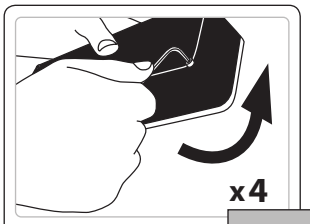


17 Retighten set screws to secure pivot drive in place.

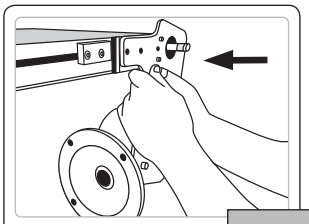
The Drive Package will ship separate from the conveyor. For Heavy Duty Drives, the motor is always shipped in its own box; the right angle speed reducer will be attached to the drive mounting package.



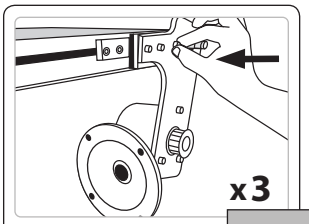
1 Remove and discard three socket head cap screws from drive side bearing plate. (Do not remove bearing plate)



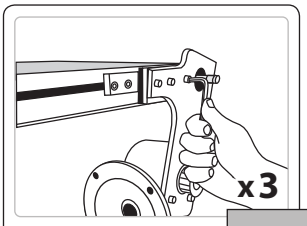
2 Remove four socket head cap screws from guard and remove guard.



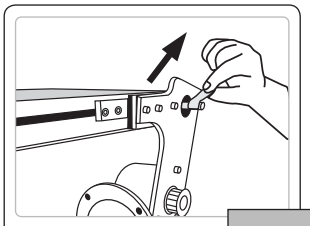
3 Mount drive package over drive mounting plate.



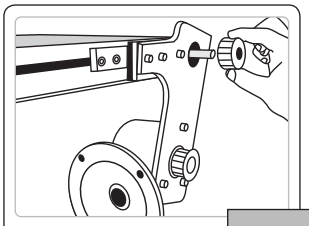
4 Align mounting holes and install three socket head screws.



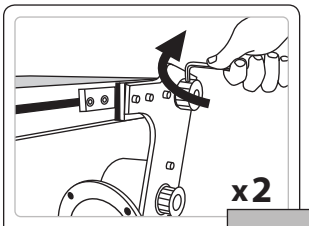
5 Tighten three socket head screws.



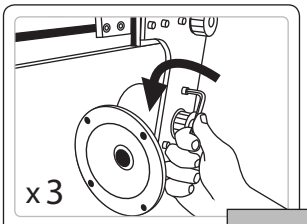
6 Remove nylon tape holding key in place. (Do not remove key)



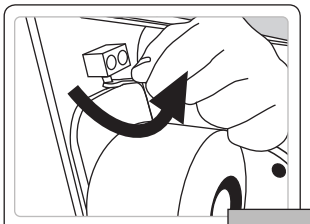
7 Slide top sprocket onto conveyor's output shaft and key.



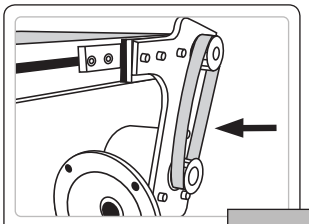
8 Tighten set screws to secure in place.



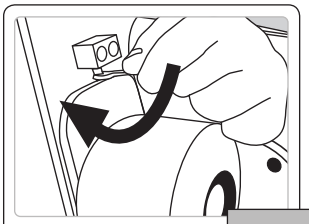
9 Loosen three socket head cap screws holding speed reducer in position.



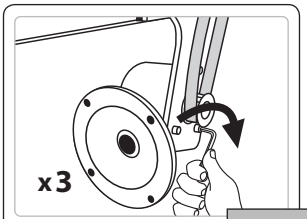
10 Tighten jacking screw so speed reducer can move toward conveyor.



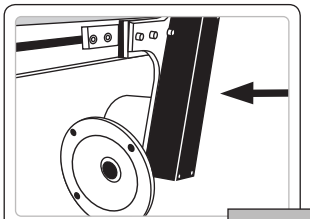
11 Install timing belt over sprockets.



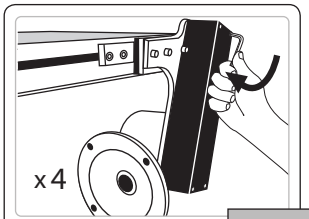
12 Run square head screw out, moving speed reducer away from conveyor and creating tension on belt.



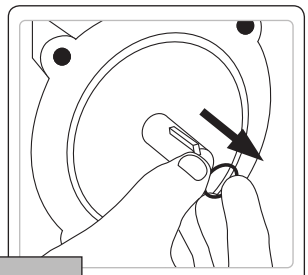
13 Retighten three socket head cap screws.



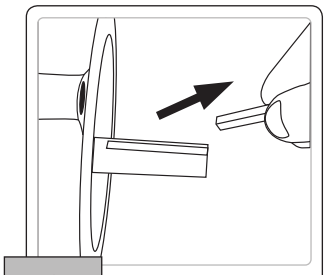
14 Replace guard.



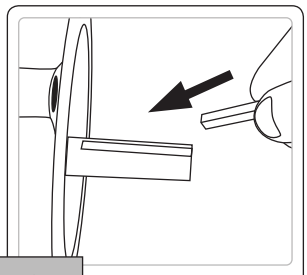
15 Insert and tighten four socket head cap screws.



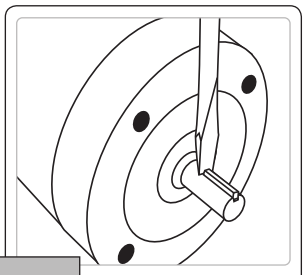
1 Remove ring holding key in place.



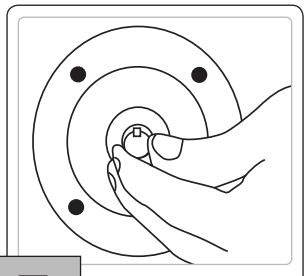
2 Remove and discard key that is included with motor.



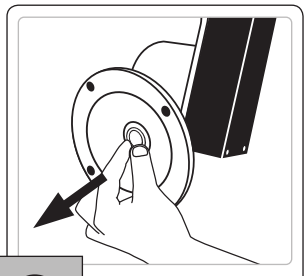
3 Install Leeson speed reducer key to keyway on motor.



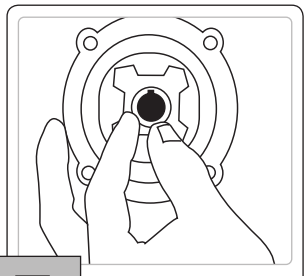
4 Lightly strike just behind the key with a screwdriver and hammer.



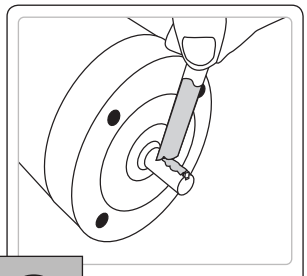
5 Rotate keyway on motor to 12 o'clock position.



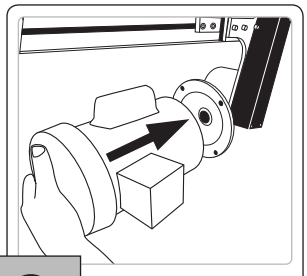
6 Remove plug from speed reducer.



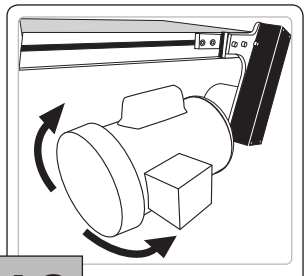
7 Rotate quill pin on speed reducer so that keyway is in 12 o'clock position.



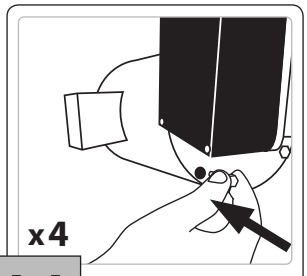
8 Apply anti-seize compound to speed reducer input quill and motor shaft.



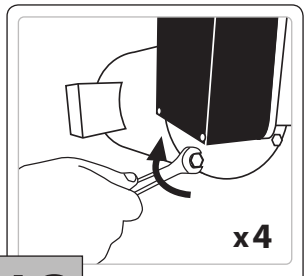
9 Install motor onto speed reducer.



10 Rotate motor so workbox is in desired position.



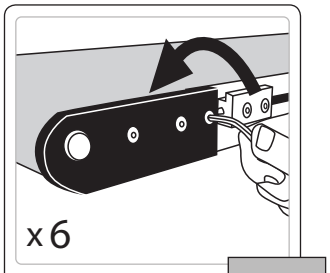
11 Install 4 hex head screws.



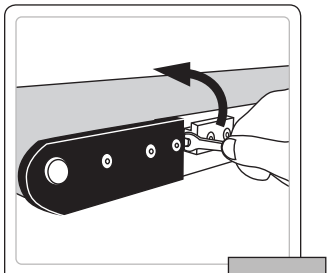
12 Tighten 4 hex head screws to secure.

▷ Belt Tracking at Drive End

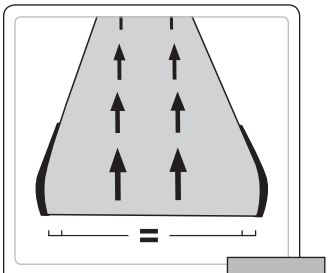
For best results, make adjustments to only one side.
The Drive End is tracked when the belt can make a full revolution without contacting either bearing plate.



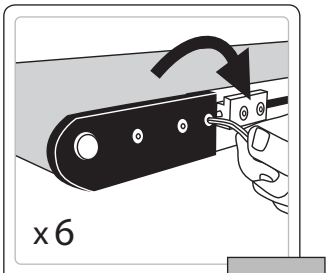
1 Loosen three driver assembly screws on each side of bearing block.



2 With conveyor running, rotate square head tracking screw toward drive pulley on side where belt is riding too close.



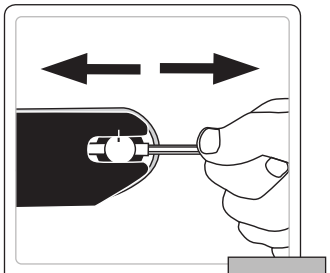
3 Let conveyor make several rotations to ensure belt is tracking properly.



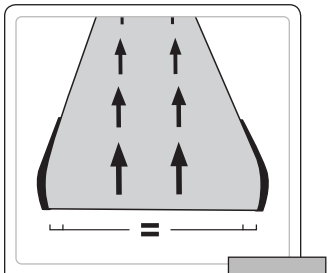
4 Re-tighten driver assembly screws.
(Three on each side)

▷ Belt Tracking at Tail End

Tail End is tracked when belt can make a full revolution without contacting either side of frame.



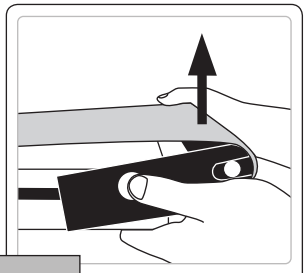
1 Rotate adjustment screw to move tail on side where belt is riding too close.



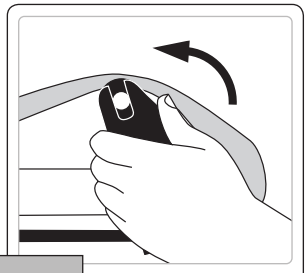
2 Let belt make several rotations to ensure proper tracking.

To see a video of this process, scan this code on your phone or tablet.
You may also visit ***https://qcconveyors.com/videos/as40-belt-tracking/***

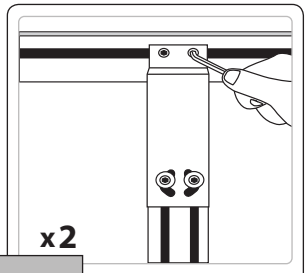
If stand brackets are not being used, skip steps 3 – 6.



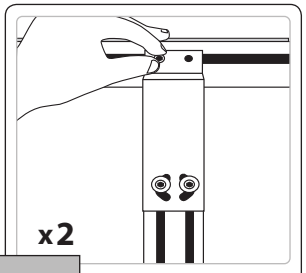
1 Simultaneously push in both buttons to disengage locking mechanism. (Frame end could have sharp edges)



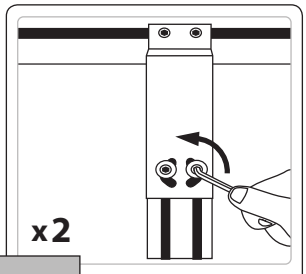
2 Rotate tension release tail assembly up and towards the drive end.



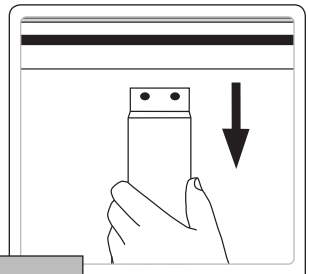
3 Loosen screws on mounts/brackets on opposite side of drive.



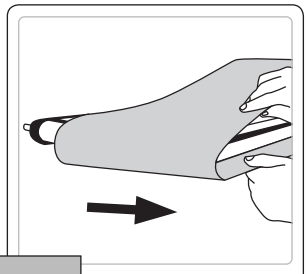
4 Remove screws from stand brackets or mounts. (If stand brackets are not used, proceed to step 7)



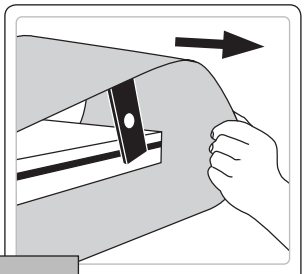
5 Loosen screws on stand. (Do not remove)



6 Slide stand bracket down for clearance.



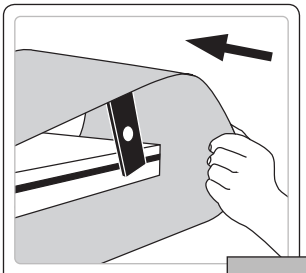
7 Slide belt sideways to clear drive pulley bearing plate.



8 Pull belt off of tension release tail.

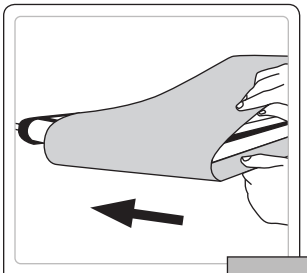
To see a video of this process, scan this code on your phone or tablet.
You may also visit ***https://qcconveyors.com/videos/as40-belt-change/***

If stand brackets are not being used, skip steps 3 – 6.



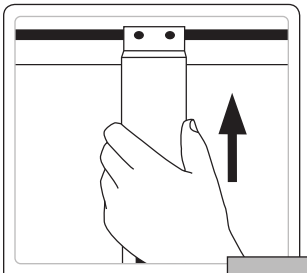
Starting at tail end, loop belt over frame and tension release tail assembly.

1



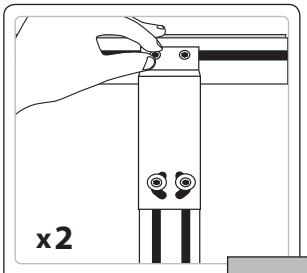
Loop belt around conveyor frame towards drive end.

2



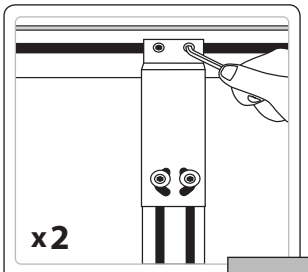
Slide frame bracket up to engage conveyor frame.

3



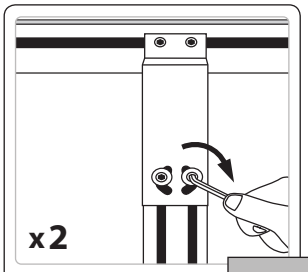
Insert screws through bracket or mount used and into frame's drop in nuts.

4



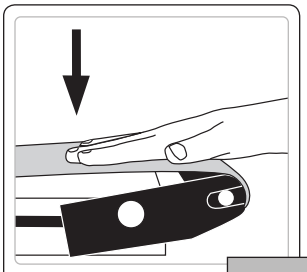
Tighten screws.

5



Tighten screws on stand.

6

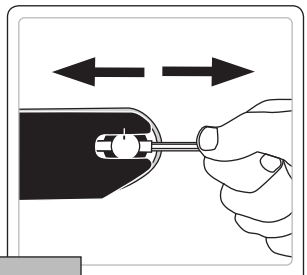


Rotate tension release tail assembly down and into the locked position. (Frame end could have sharp edges)

Conveyor is now ready to be tracked.
See belt tracking section of manual.

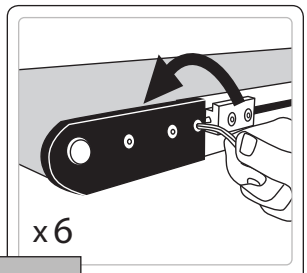
7

Belt Tension at Tail End

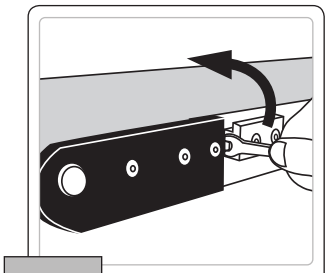


1 Adjust the set screws on the tail assembly so the tail pulley assembly moves direction needed. (Inward to relieve tension, outward to increase tension)
Adjust both screws the same amount

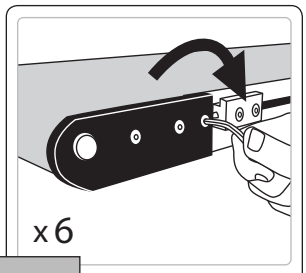
Belt Tension at Drive End



1 Loosen six driver assembly screws in bearing blocks about half a turn.

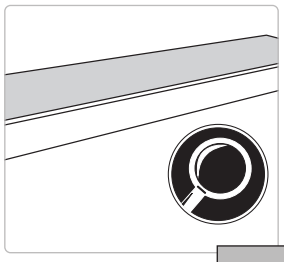


2 Extend the square head tracking screws on both sides of the conveyor until desired tension is achieved (extend screws the same amount).



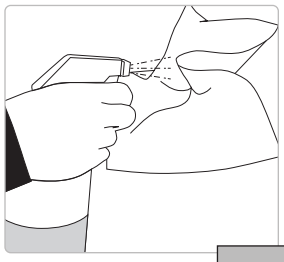
3 Retighten six driver assembly screws to lock assembly into position.

If additional belt tension is needed after following these steps, it is recommended that a new belt be installed.



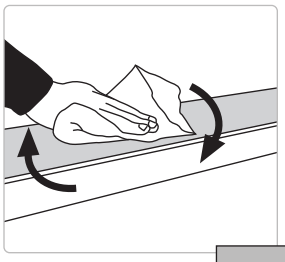
1

Inspect Belt for any fraying or tears and replace if needed.



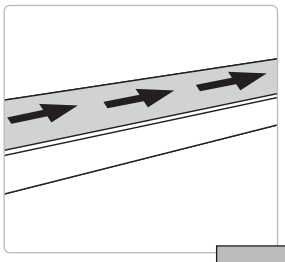
2

Spray proper cleaning solution on a clean rag.



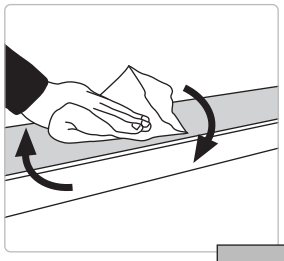
3

Wipe belt with rag.



4

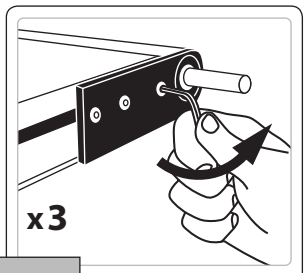
Cycle conveyor to reveal opposite side of belt.



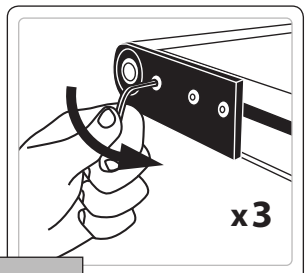
5

Wipe belt with rag.

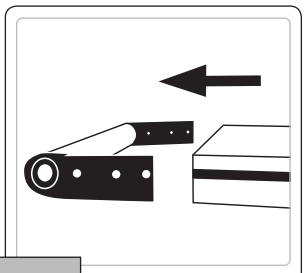
Remove belt and drive package. (Follow steps for your drive package in Drive Package section of this manual in reverse order)



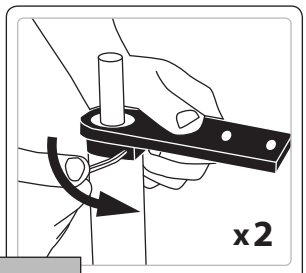
1 Loosen, but do not remove, three screws holding bearing plate on drive side.



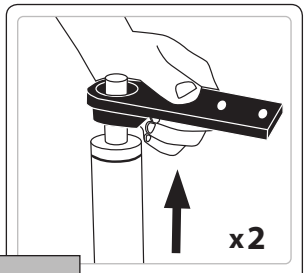
2 Loosen, but do not remove, three screws holding bearing plate on opposite side of pulley.



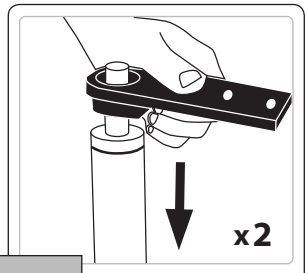
3 Slide bearing plates out of frame.



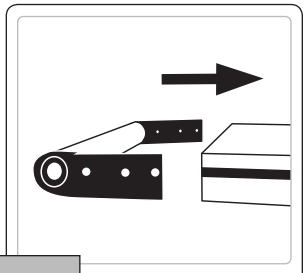
4 Loosen set screws in both bearing plates.



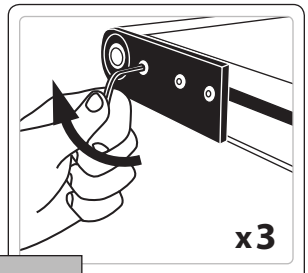
5 Remove both bearing plates from drive pulley.



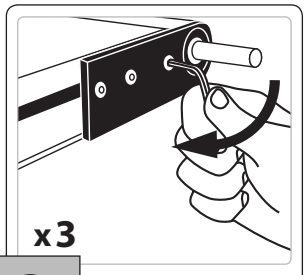
6 Install bearing plates onto new drive pulley.



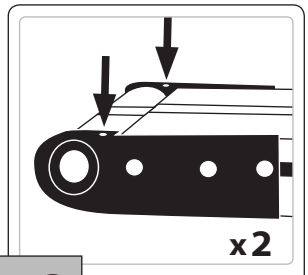
7 Slide pulley back into frame.



8 Install and tighten three set screws on one bearing plate.



9 Install final three screws on opposite bearing plate.



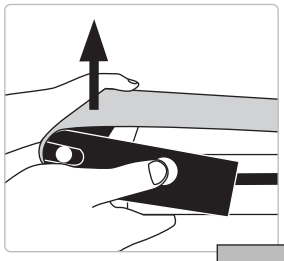
10 Align pulley's V-Guide with V-Guide in frame and tighten set screws on both bearing plates.

Re-install belt and drive package. (Follow steps for your drive package in Drive Package section of this manual)

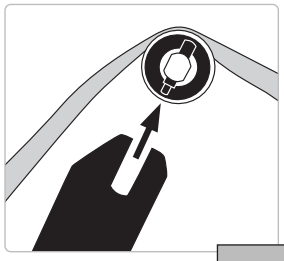
If tensioning adjustment is needed, refer to belt tensioning section of this manual.

If tracking adjustment is needed, refer to belt tracking section of this manual.

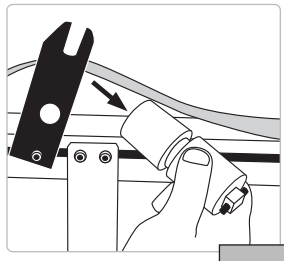
▷ Tail Pulley Replacement



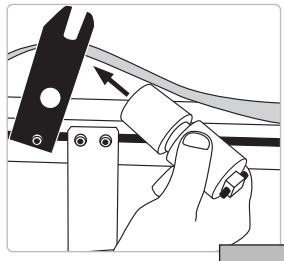
1 Press both tension release buttons and lift up simultaneously.



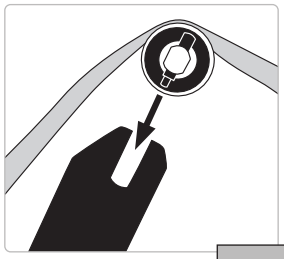
2 Lift idler pulley out of slot.



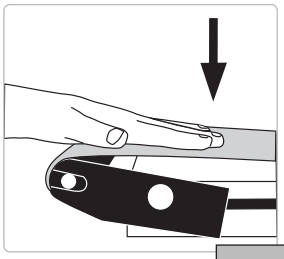
3 Remove Idler pulley from conveyor.



4 Replace with new idler pulley.



5 Making sure to keep dog point of set screw facing down, insert idler pulley back into slot.



6 Press Tension Release tail pulley down until it "Locks" into the locked position.

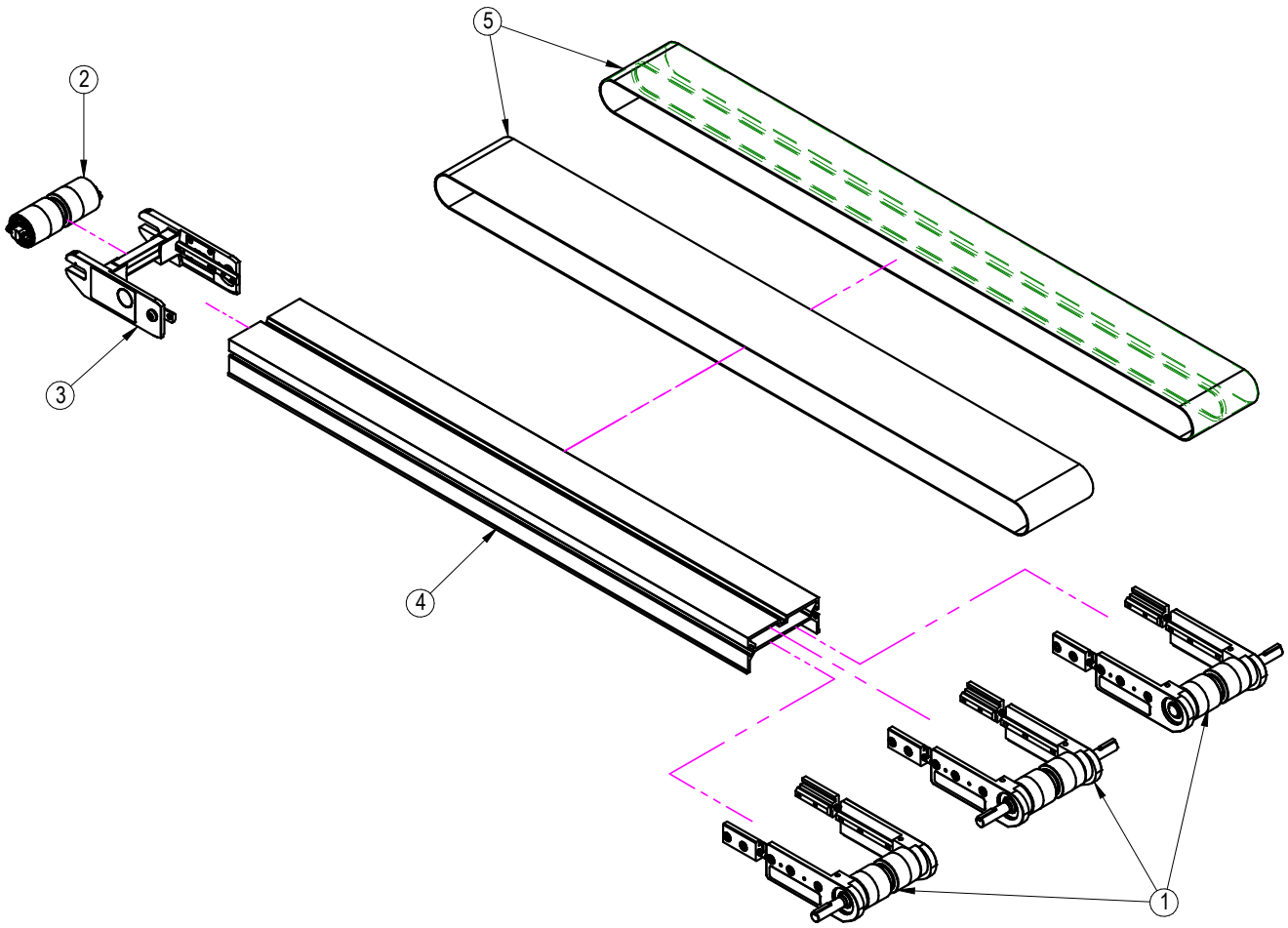
Re-tensioning and tracking of belt may be necessary. (Refer to tracking and tensioning sections of this manual.)

▷ Troubleshooting

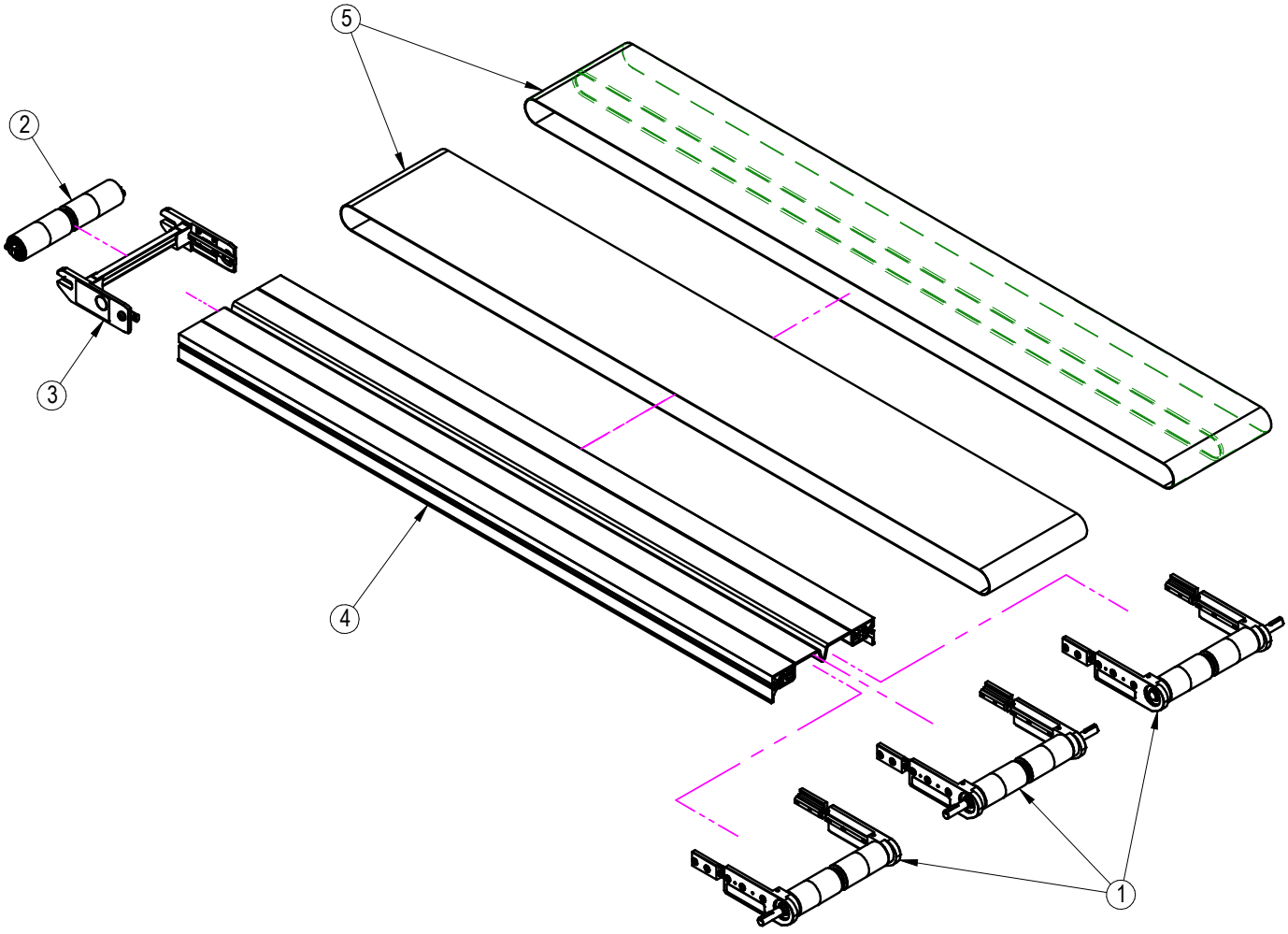
Symptom	Possible Cause	Corrective Action
Belt is slipping or stops under load	Demand is more than the conveyor is rated for	Verify conveyor capacity
	Lubrication between drive pulley and belt	Clean bottom of belt and drive pulley
	Tail pulley assembly not rotated into proper position	Refer to section on tensioning the belt (page 19)
Belt does not move without load	Timing belt under drive guard is not connected	Verify correct installation by referring to drive package section of this manual (pages 11 –15)
	Tail pulley assembly not tensioned properly	Refer to section on tensioning the belt (page 19)

Symptom	Possible Cause	Corrective Action
Belt will not track at drive end	Accumulation or belt wear	Refer to Belt Tracking section of this manual (page 16)
	Improper tension	Refer to Belt Tensioning section of this manual (page 19)
Belt is brittle, delaminating or is discolored	Belt is being attacked by chemicals or excessive heat	Contact factory to discuss belt application
	Belt life has expired	Replace belt
	Urethane belts can discolor when exposed to UV light	No corrective action
Motor is Hot	Motor can run with a skin temperature of 221°F	No corrective action
	Motor is not protected with overload protection and is drawing too much current	Install overload protection on motor
Speed reducer is getting hot	Speed reducer can run with skin temperature of 225°F	No corrective action
Speed reducer is leaking oil	Speed reducer's life has expired	Replace speed reducer
	Installation was performed incorrectly and input seal was damaged	Replace speed reducer
Bearing noise	Bearings are damaged or failing	Refer to Pulley Assembly Replacement section of this manual (page 21)
Belt is traveling reverse of desired direction	Motor or speed reducer not wired properly	Check wiring and correct per wiring instructions
Conveyor belt has prematurely worn out	Correct belt not selected for application	Contact factory to discuss belt application

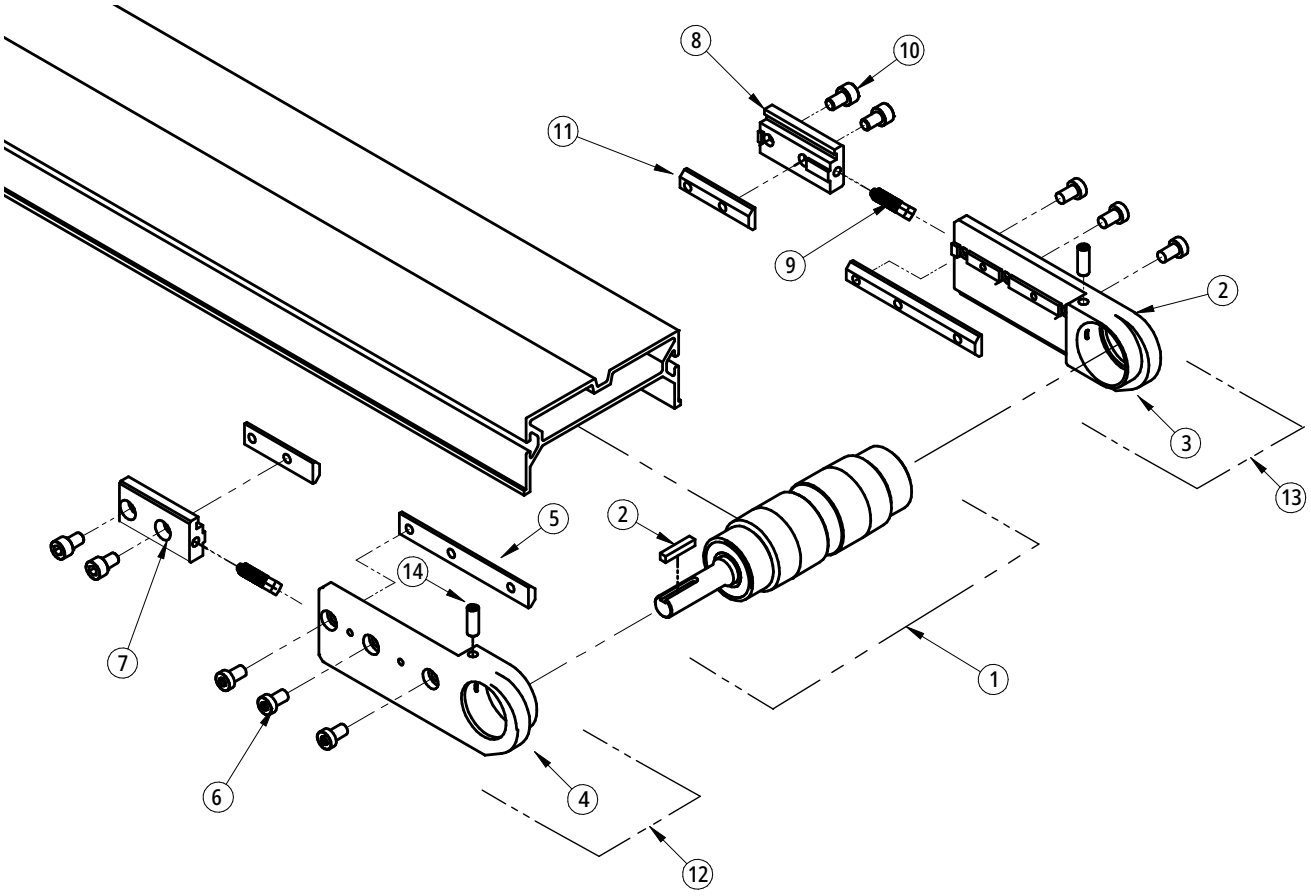
If you are unable to remedy the problem with these corrective actions, please contact QC Conveyors Customer Service at (513) 753-6000. Failure to correct the problem may lead to abnormal use of the conveyor, thereby voiding the warranty.



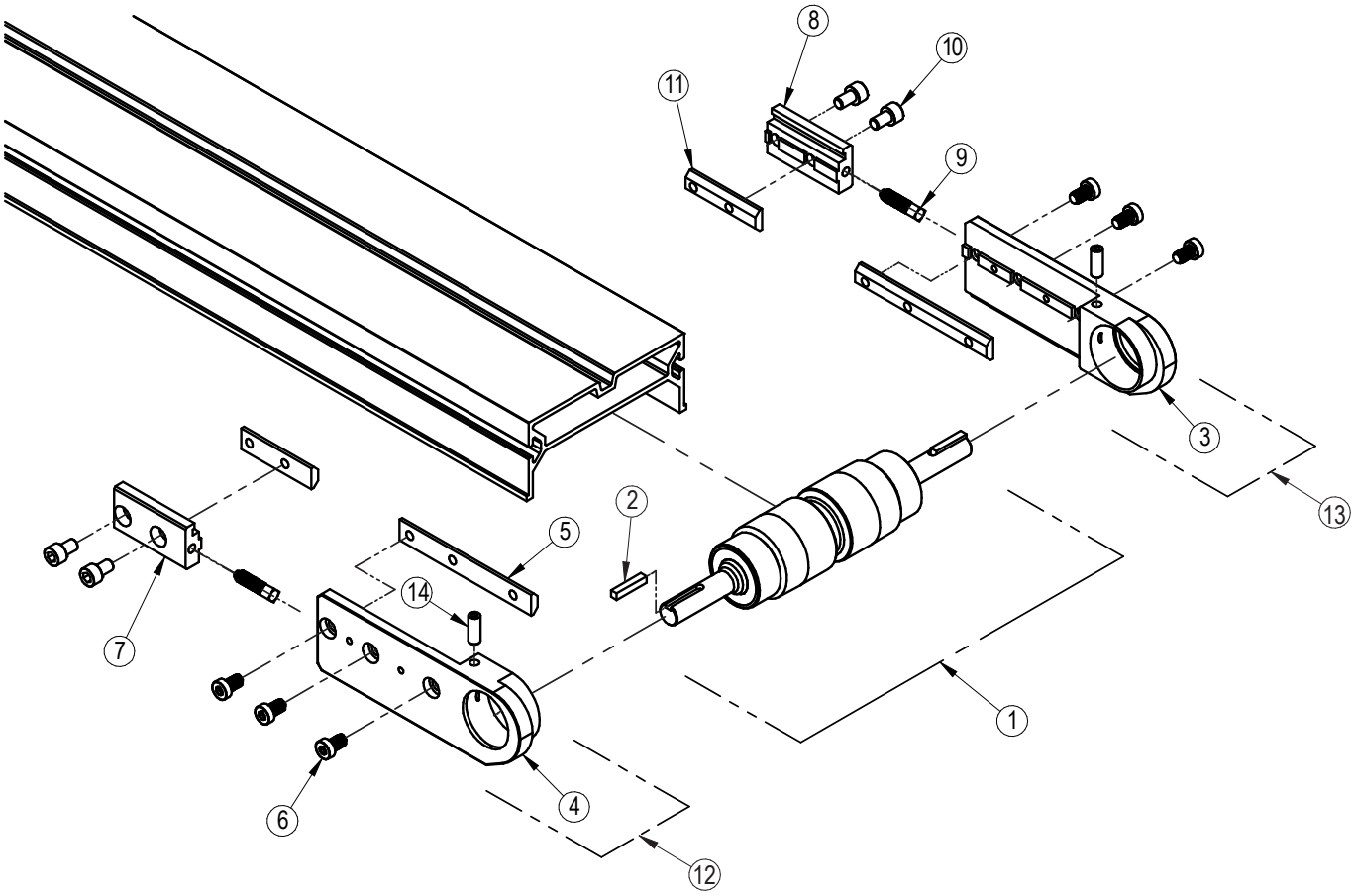
#	Part #	Description
1	1A0028C00WW	ASSY END DRIVE SINGLE OUTPUT LH
	1A0029C00WW	ASSY END DRIVE SINGLE OUTPUT RH
	1A0031C00WW	ASSY END DRIVE DUAL OUTPUT
2	1A0039B00WW	ASSY TAIL V-GUIDED
3	1A0038A00WW	ASSY TENSION RELEASE TAIL
4	1D0012ALLLL	SLIDER BED ALUMINUM EXTRUSION 2" WIDE
	1D0013ALLLL	SLIDER BED ALUMINUM EXTRUSION 3" WIDE
	1D0014ALLLL	SLIDER BED ALUMINUM EXTRUSION 4" WIDE
	1D0015ALLLL	SLIDER BED ALUMINUM EXTRUSION 5" WIDE
	1D0016ALLLL	SLIDER BED ALUMINUM EXTRUSION 6" WIDE
	1D0017ALLLL	SLIDER BED ALUMINUM EXTRUSION 8" WIDE
	1D0060ALLLL	SLIDER BED ALUMINUM EXTRUSION 10" WIDE
	1D0061ALLLL	SLIDER BED ALUMINUM EXTRUSION 12" WIDE
5	AE4-WW-LLL-MAE	BELT AUTOMATION SERIES END DRIVE STANDARD
	AE4-WW-LLL-MVE	BELT AUTOMATION SERIES END DRIVE V-GUIDED



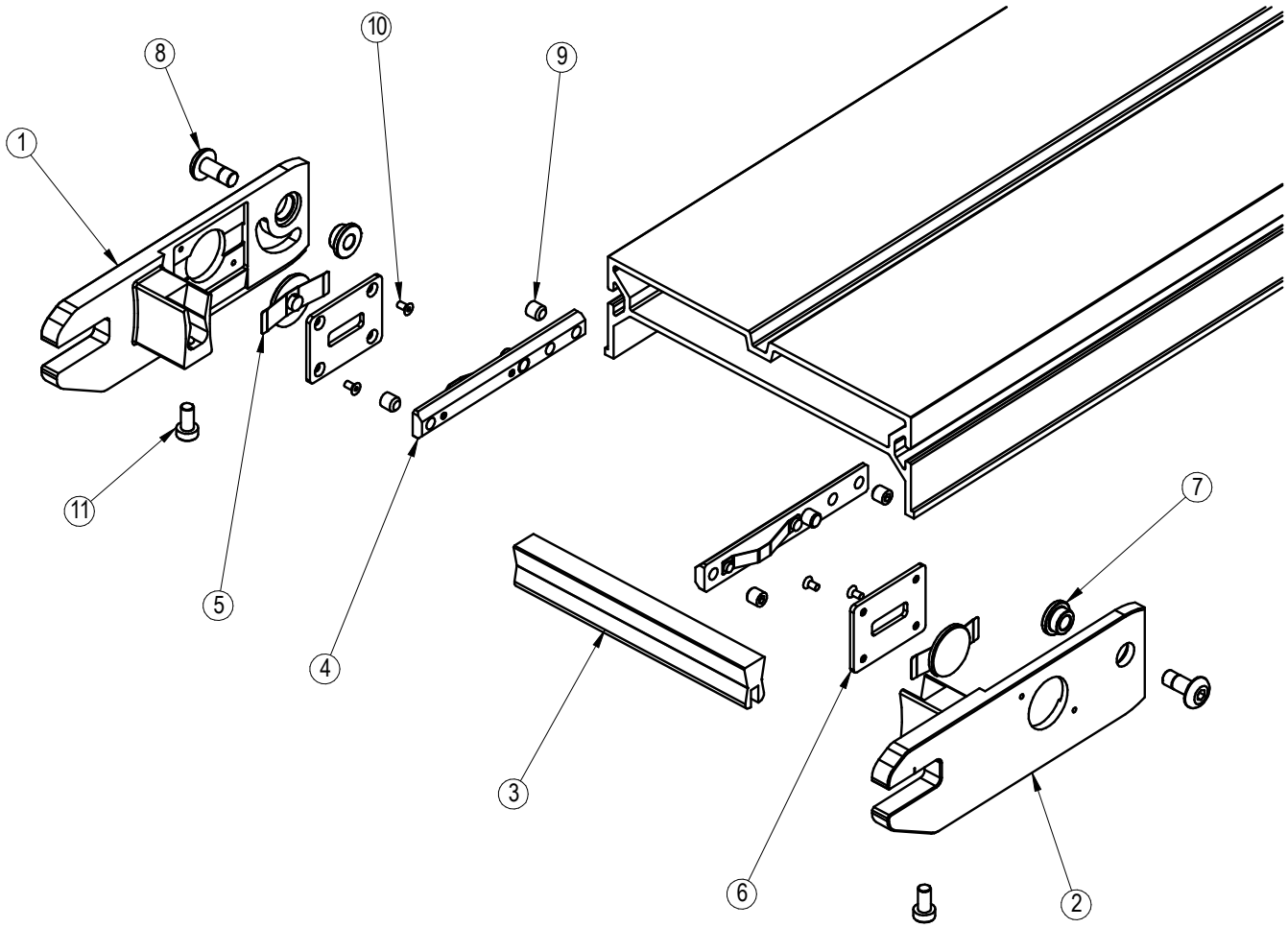
#	Part #	Description
1	1A0028C00WW	ASSY END DRIVE SINGLE OUTPUT LH
	1A0029C00WW	ASSY END DRIVE SINGLE OUTPUT RH
	1A0031C00WW	ASSY END DRIVE DUAL OUTPUT
2	1A0039B00WW	ASSY TAIL V-GUIDED
3	1A0038A00WW	ASSY TENSION RELEASE TAIL
4	1A0071A-WW-LLL	ASSY MULTI-PIECE FRAME
5	AE4-WW-LLL-MAE	BELT AUTOMATION SERIES END DRIVE STANDARD
	AE4-WW-LLL-MVE	BELT AUTOMATION SERIES END DRIVE V-GUIDED



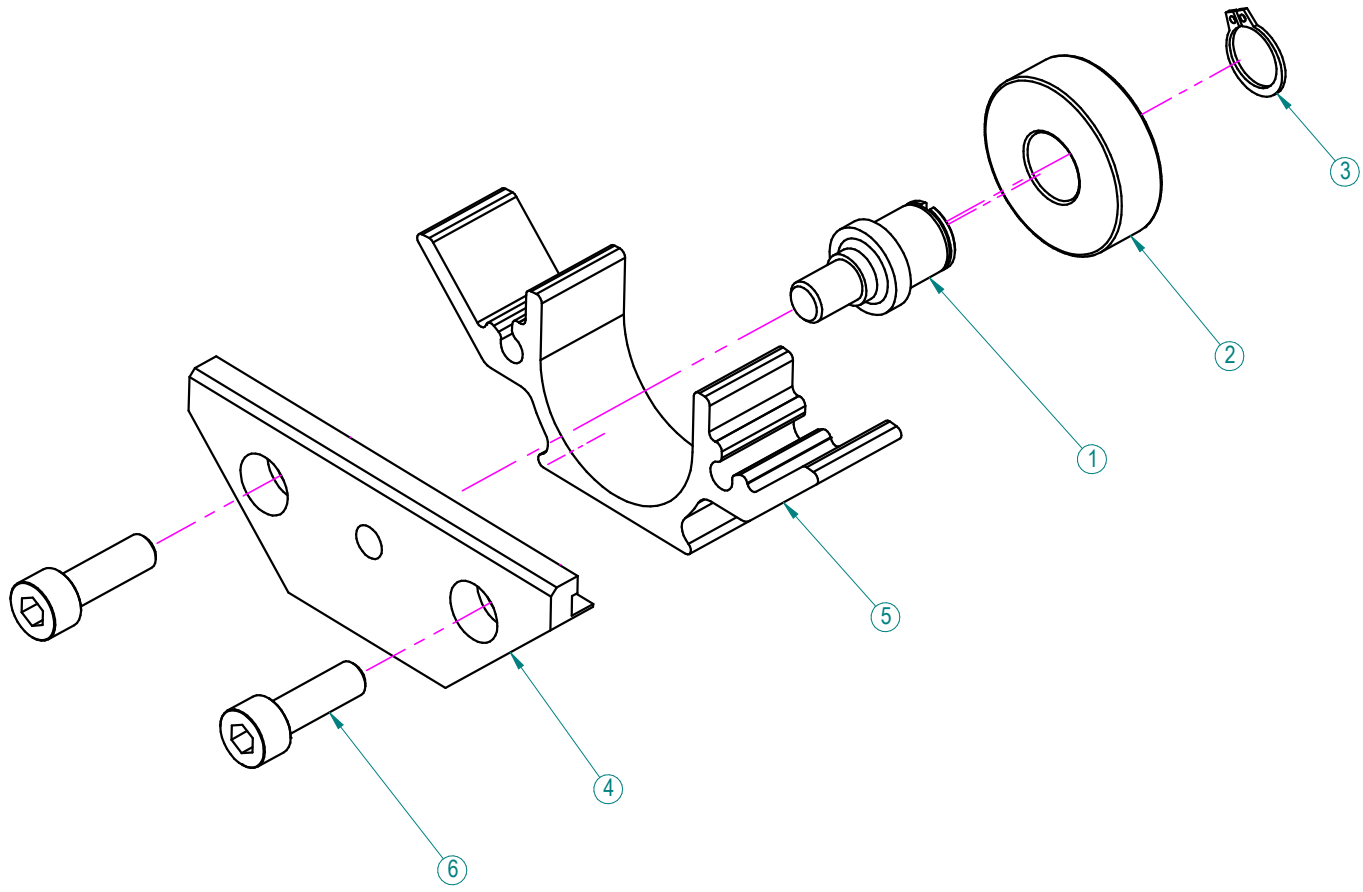
#	Part #	Description
1	1A0099C00WW	AS40 SINGLE OUTPUT DRIVE PULLEY ASSEMBLY WITH BEARINGS
2	1D0084A	KEY 4MM X 4MM SQ. X 21MM LG.
3	1D0065B	DRIVE BEARING HOUSING RH
4	1D0064B	DRIVE BEARING HOUSING LH
5	1D0080A	ANCHOR BAR BEARING HOUSING
6	SLHCS-M6X100X010-BX	SCREW SOCKET LOW HEAD CAP M6x1.0 10MM LG.
7	1D0125A	BLOCK JACKING LH DRIVE END
8	1D0126A	BLOCK JACKING RH DRIVE END
9	1D0116A	SCREW JACKING SQ. HEAD M6x1.0 20MM LG.
10	SHCS-M06X100X010-ZP	SCREW SOCKET HEAD CAP M6x1.0 10MM LG.
11	1D0124A	ANCHOR BAR JACKING BLOCK
12	1A0102C	ASSY BEARING PLATE LH
13	1A0103C	ASSY BEARING PLATE RH
14	SHCS-M06X100X016-ZP	SCREW SOCKET HEAD SET M6x1.0 16MM LG.



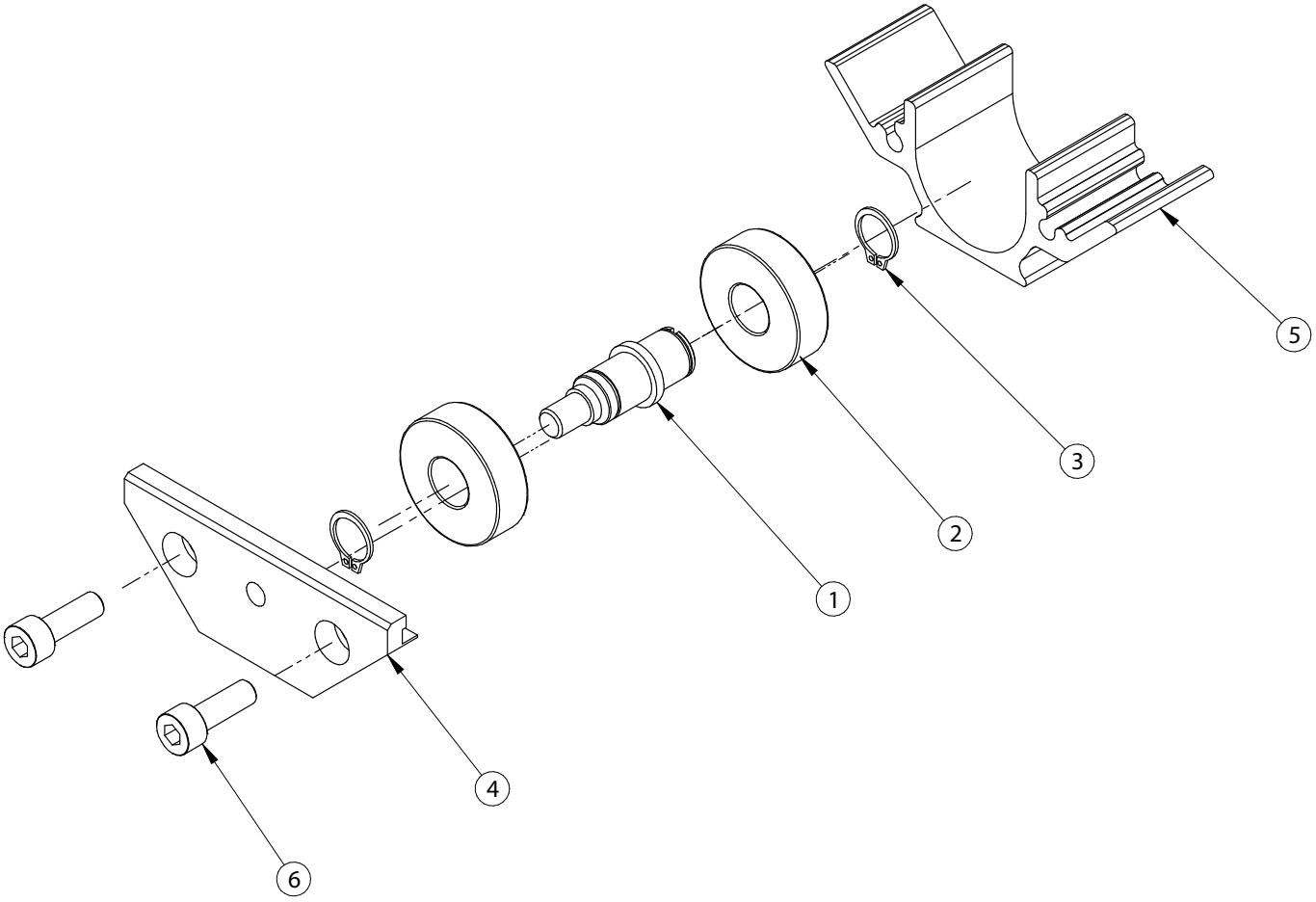
#	Part #	Description
1	1A0100C00WW	AS40 DRIVE PULLEY DUAL OUTPUT ASSEMBLY WITH BEARINGS
2	1D0084A	KEY 4MM X 4MM SQ. X 21MM LG.
3	1D0065B	DRIVE BEARING HOUSING RH
4	1D0064B	DRIVE BEARING HOUSING LH
5	1D0080A	ANCHOR BAR BEARING HOUSING
6	SLHCS-M6X100X010-BX	SCREW SOCKET LOW HEAD CAP M6x1.0 10MM LG.
7	1D0125A	BLOCK JACKING LH DRIVE END
8	1D0126A	BLOCK JACKING RH DRIVE END
9	1D0116A	SCREW JACKING SQ. HEAD M6x1.0 20MM LG.
10	SHCS-M06X100X010-ZP	SCREW SOCKET HEAD CAP M6x1.0 10MM LG.
11	1D0124A	ANCHOR BAR JACKING BLOCK
12	1A0102C	ASSY BEARING PLATE LH
13	1A0103C	ASSY BEARING PLATE RH
14	SHSS-M06X100X016-ZP	SOCKET HEAD SCREW M6X1.0X16MM LG



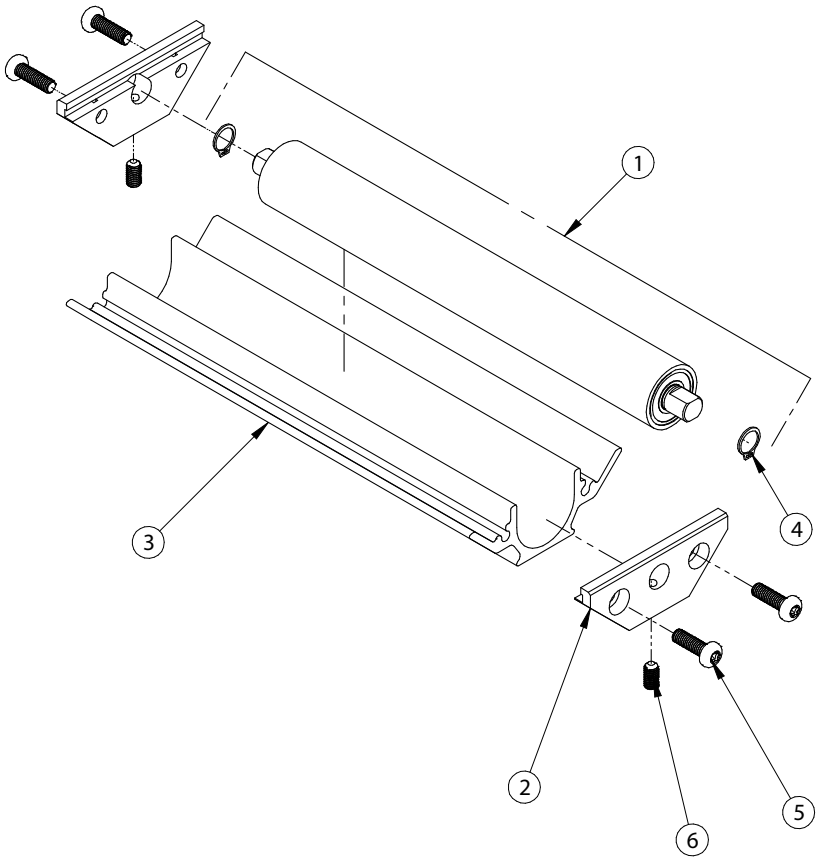
#	Part #	Description
1	1D0182A	TAIL PLATE RH
2	1D0181A	TAIL PLATE LH
3	1D0172A00WW	TAIL STIFFENER
4	1A0072A	ASSY ANCHOR BAR/TIE SPRING/DOWEL PIN
5	1D0164A	TAIL BUTTON
6	1D0165A	BUTTON RETAINING PLATE
7	1D0168A	BUSHING
8	1D0225A	BUTTON HEAD SHOULDER SCREW
9	SHSS-M06X100X006-ZP	SCREW SOCKET HEAD SET M6x1.0 6mm LG.
10	FHCS-MO2.5X045X005-BX	SCREW SOCKET FLAT HEAD M2.5x0.45 5mm LG.
11	SLHCS-M05X080X010-ZP	SCREW SOCKET LOW HEAD CAP M5x0.8 10mm LG.
12	WSHF-M06X12X16-ZP	WASHER FLAT M6



#	Part #	Description
	1A0040A	2" – 6" WIDE STUB UNDERSIDE IDLER ASSEMBLY
1	1D0152A	SHAFT STUB UNDERSIDE IDLER 2"-6"
2	43-0050-51	BEARING UNDERSIDE IDLER STUB
3	43-0050-52	RETAINING RING
4	1D0151A	CLAMP UNDERSIDE IDLER STUB
5	1D0148A	GUARD UNDERSIDE IDLER STUB 2"-6"
6	SHCS-MO5X080X016-ZP	SCREW SOCKET HEAD CAP M5x0.8 16mm LG.



#	Part #	Description
	1A0041A	8" – 24" WIDE STUB UNDERSIDE IDLER ASSEMBLY
1	1D0152A	SHAFT STUB UNDERSIDE IDLER 8"-24"
2	43-0050-51	BEARING UNDERSIDE IDLER STUB
3	1D0315A	RETAINING RING
4	1D0151A	CLAMP UNDERSIDE IDLER STUB
5	1D0149A	GUARD UNDERSIDE IDLER STUB 8"-24"
6	PHCS-M05X080X016-ZP-ST	SCREW, PAN HEAD TORX - M5 X 80 X 16MM



#	Part #	Description
	1A0042A00WW	FULL WIDTH UNDERSIDE IDLER ASSEMBLY — FULL ASSEMBLY
1	1A0033A00WW	ROLLER ASSY FULL WIDTH UNDERSIDE IDLER
2	1DO2O8A	CLAMP UNDERSIDE IDLER FULL WIDTH
3	1D0155A00WW	GUARD UNDERSIDE IDLER FULL WIDTH
4	1D0315A	RETAINING RING
5	SHCS-MO5X080X016-ZP	SCREW SOCKET HEAD CAP M5x0.8 16mm LG.
6	SHCS-M05X080X10-BX	SCREW SOCKET HEAD SET M5x0.8 10mm LG.

▷ Warranty Information

QC Conveyors warrants that our conveyors are free from defects in materials and workmanship and fit for the ordinary purposes for which such goods are used, under normal installation, use and service for ten (10) years* from date of purchase or 21,000 hours* of running use, whichever is sooner. QC Conveyors will replace any defective part within the warranty period, without charge, provided:

- The Purchaser gives QC Conveyors prompt written notice of the defect, including the date of purchase and original purchase order number.
- The Purchaser will then be given a return goods authorization number (RGA#) which must be displayed on all labels and packing slips returned with merchandise. (See Return Policy section)
- The Purchaser pays for delivery of the defective part to QC Conveyors for inspection and verification of the defect.
- The Purchaser shall pay any costs of installing the replacement part.

This warranty is limited to the replacement of defective parts. **QC Conveyors WILL NOT BE LIABLE FOR ANY DAMAGES CAUSED BY ANY DEFECT IN THIS UNIT.** This warranty shall not apply if any failure of this unit or its parts is caused by unreasonable use, lack of maintenance, improper maintenance and/or repairs, incorrect adjustments, exposure to corrosive or abrasive material, damage causing moisture, or any modification or alteration affecting the operation of the unit which is not authorized by QC Conveyors in writing. This warranty shall not apply to the following items that are covered by their manufacturer's warranty, subject to any limitation contained in those warranties.

- Bearings
- Motors
- Reducers
- Controllers
- Casters
- Belts (Unless otherwise agreed to in writing)

CAUTION: Any attempt to repair such items may actually void the manufacturer's warranty. Any description of this unit is only to identify it and is not a warranty that the unit fits the description. Any warranties implied by law are limited in duration to the ten (10) year term of this warranty. EXCEPT AS SET FORTH HEREIN, QC Conveyors MAKES NO OTHER WARRANTIES, WHETHER EXPRESS, IMPLIED, OR STATUTORY, INCLUDING MERCHANTABILITY FOR FITNESS OR ANY PARTICULAR PURPOSE.

*Warranty is five years/10,500 hours without registration at **qcconveyors.com/serial.**

▷ Lost or Damaged Goods

Shipments should be inspected immediately upon receipt for lost or damaged goods. Any loss or damage should be noted on the carriers receipt (or bill of lading) at the time of acceptance. If items are perceived to be lost or damaged after the shipment has been accepted, it becomes more difficult to file a claim with the carrier if the receipt does not indicate such loss or damage. Do not, at any time, request the carrier to return any items or shipment to QC Conveyors without previous authorization from our company for such a return. Please notify QC Conveyors as soon as any loss or damage is discovered and request the department that handles the lost or damaged goods. You will need to know a complete description of all lost or damaged items. If replacement items are needed, a purchase order made out to QC Conveyors will need to be supplied. QC Conveyors will then contact the carrier's local agent and request that an inspection of the items be performed. This is absolutely necessary. Unless an inspection is performed, the carrier will not entertain any claim for loss or damage. After the inspection has been completed, the carrier will notify QC Conveyors. If the carrier takes responsibility for the claim, a credit will be issued to you for the replacement item(s), including freight charges from QC Conveyors, where applicable. If the carrier does not take responsibility for the claim, a representative of QC Conveyors will contact you.

▷ Limited Restocking Policy — Products Available for Limited Restocking

We take great pride in our intentionally engineered conveyor systems built for use by you and your customers. Please review the below chart of products available for limited restocking and then review the appropriate policy that applies to the issue at hand.

Product Line	Restock Fee/Cancellation Charge
Automation Series: AS40, AS40-CD, AS40-Z, CB80 Conveyor Systems/Parts	25% Restock Fee/Cancellation Charge
Industrial Series: IS125, IS125-FT, IS175-ID, IS300, IS400 Conveyor Systems/Parts	25% Restock Fee/Cancellation Charge
HydroClean Series: HC200 Conveyor Systems/Parts	30% Restock Fee/Cancellation Charge
Flextrac Series: Alpine, Modular Plastic Chain, Gripper Elevator (Wedge) Conveyor Systems/Parts	50% Restock Fee/Cancellation Charge
Custom OEM Product Lines	25% Restock Fee/Cancellation Charge
PF Series	20% Restock Fee/Cancellation Charge
Custom Engineered/Special Conveyors, Belts or Parts; Discontinued Product Lines	Non-Returnable

Prior to Shipping — Order Cancellation/Order Revision Policy

If it becomes necessary to cancel or revise an order prior to the order being shipped, QC Conveyors reserves the right to evaluate each order independently prior to authorizing cancellation/revision; restocking / cancellation fees may apply. A restocking charge will be invoiced if an order has been assembled prior to its cancellation or revision. We will not restock custom components (items that are not stocked at QC Conveyors) and those items will be invoiced to the purchaser at list price. If the order contains other-than-stock items, an evaluation will be made based on the status of the order. Additional charges may be included in addition to the restocking fee, if any of the following conditions are met:

(1) The order contains any items that are considered to be non-stock items and these items have already been produced or are in process by QC Conveyors or one of its suppliers.

(2) The order contains any items that require special handling or assembly and these processes have been completed.

Limited Restocking Policy

Restocking must meet the following criteria prior to an RGA (Restock Goods Authorization) number being issued:

(1) Items must be eligible for restock.

(2) Items must have been purchased within 60 Days (based on invoice date).

(3) Items must be unopened, undamaged and in resalable condition.

RGA Process — Restocking Goods Authorization

Contact QC Conveyors — Email customerservice@qcconveyors.com or call Customer Service at 513–753–6000

Information Needed for RGA

(1) Name of Purchaser (Company QC Conveyors invoiced, may be the distributor, if applicable)

(2) Name of the Customer and/or end user of the item(s).

(3) Invoice Number - Include any/all purchase order numbers related to the item(s) in question.

(4) Contact Information - Phone numbers and names of contacts involved.

(5) Item Number(s) & Quantities - Complete part numbers /quantities of all items involved in the RGA.

(6) Reason - Complete description as to the reason for the return and the actions that need to be taken.
If the item is to be replaced, a new purchase order number must be supplied by the Purchaser along with complete shipping and billing instructions. These replacements will be treated as separate orders by QC Conveyors and evaluated for possible credit only after returned items are received and evaluated.

Process Once RGA is Approved

(1) QC Conveyors Will Email RGA Number — Once all the above information is provided, we will begin processing your RGA. Once authorization has been approved, you will be emailed the RGA number to use when returning the item(s). RGA numbers will not be given verbally over the phone.

(2) Items Must Be Received 30 Days from RGA Issue Date — Upon receipt of your RGA number, you are required to return the item(s) within 30 days of receipt of RGA number email. After 30 days, the Return Authorization will be void if item(s) are not received by QC Conveyors. All shipping charges and freight insurance charges of restocked goods will be the responsibility of the Purchaser.

(3) Returned Items Must Have RGA Number Listed on Packaging — The RGA number must be clearly marked on the outside of all packages and noted on any paperwork, packing slips, or delivery receipts. If there is no RGA number visible on the package, the package may be refused and sent back at the Purchaser's expense. Parts received in damaged condition due to inadequate packaging are not eligible for credit or warranty consideration.

(4) QC Conveyors Will Evaluate RGA and Credit If Applicable — After receipt of returned goods, QC Conveyors will evaluate the item(s) for credit and take the appropriate action. Items outside of Warranty Issues must be on the Limited Restocking List, must be returned in new, undamaged, resalable condition and must be received within 30 days of RGA Number being assigned. Credit will be issued to the purchaser less restocking fee and any additional fees (evaluation, disassembly, cleaning, disposal, and reissuing of components into inventory). Please allow 30 days for credits to be issued. Full purchase credit will only be issued for defective or damaged initial shipping issues.

qcconveyors.com/serial

Manuals, Videos, Replacement Parts

Register today to double your warranty to 10 Years

QC Conveyors come standard with a 5 Year manufacturer's warranty, but if you register online we'll double that to 10 Years, giving you the longest warranty in the conveyor industry.

Register today at qcconveyors.com/serial!

While You're There, You'll Have Access to

- All the installation and maintenance manuals for your product
- Product-specific videos to guide you through routine maintenance tasks
- A complete list of replacement parts along with the original bill of materials and exploded views to help you find exactly the right part
- Easy replacement part quoting

Registration also entitles you to all the benefits of our Conveyor Configurator, where you can configure and quote conveyor systems with help from our engineering-based configuration tools to ensure your conveyor and components will work together perfectly in your application.

Date of Installation _____

Serial Number _____

Date	Service Performed

Date of Installation _____

Serial Number _____

Date	Service Performed

SERVICE RECORD

▷ Serial Number _____ Date of Installation _____

Date	Service Performed

▷ Serial Number _____ Date of Installation _____

Date	Service Performed