

MANUAL

BELT CONVEYOR BF-SERIES

Original instructions



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Declaration of conformity

Declaration of incorporation of partly completed machinery Directive 2006/42/EC Annex II 1B, with signature and date, is sent separately in the customer documentation.

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Introduction

The following instructions are available to provide a basis for operating a Rollco BF Belt Conveyor safely. The manual must be read before operating the conveyor. The safety instructions in this manual must be followed by each and every conveyor user.

Rollco AB therefore advises that all personnel read this manual accurately, follow the instructions herein and that this user manual is accessible for the maintenance and operating personnel at all times.

The usage of this manual should help to avoid dangers, reduce reparation times and breakdowns, and generally extend the life of your Rollco Conveyor.

Operations of this device are to be carried out by qualified staff. Appointed staff being capable to accomplish necessary operations and detecting and avoiding dangers due to their experience or by authorisation from device manager.

Usage in accordance with regulations

All care is duly taken when building a Rollco BF Conveyor. Nevertheless, threat to life or physical condition to the operator, third person, conveyor or other real value can occur.

The belt conveyor must only be operated when in proper condition and in accordance with this manual.

The belt conveyor is designed exclusively for the moving of products. Any use differing from this, e.g. moving of persons, is never an intended use. Any usage outside of the recommended ranges of load, widths, lengths and heights is not permitted without prior consent from Rollco.

Rollco AB cannot under any circumstances be held liable for resulting damages.

Purpose of this manual

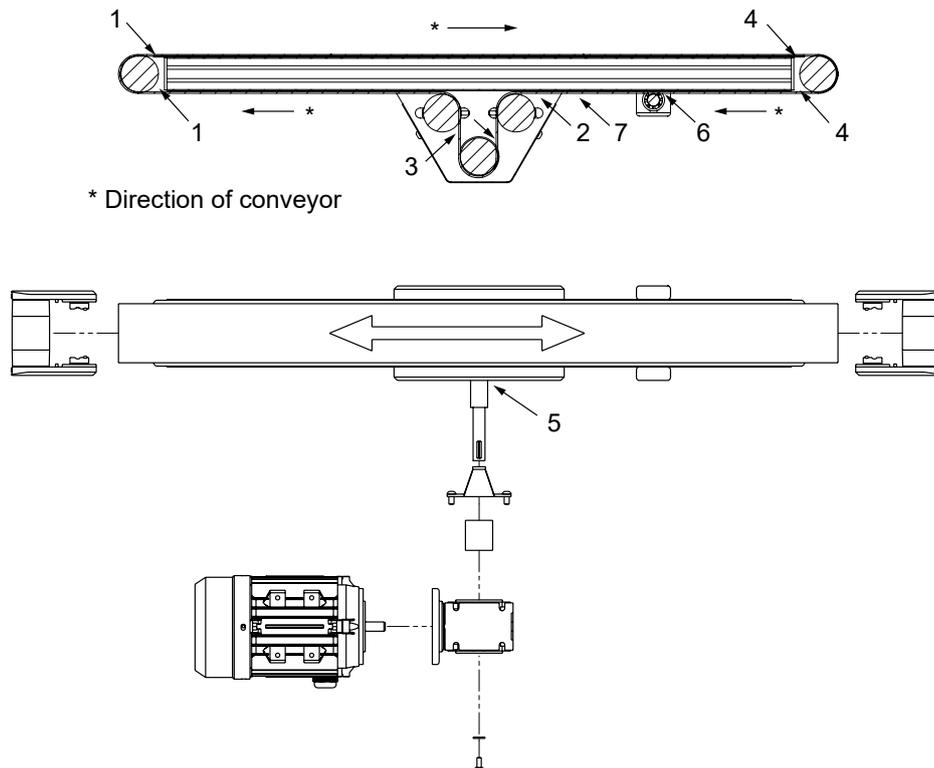
The purpose of this manual is to inform the consumer of how to safely implement, maintain and decommission their BF series conveyor.

Safety instructions



This manual provides a basis for operating your Rollco Belt Conveyor safely. Safety instructions inside this manual must be followed by all persons in contact with the Rollco Conveyor. Effective regulations and instructions for accident preventions of each and every site of operation must be followed. This manual must be stored easily accessible, close to the location of the belt conveyor.

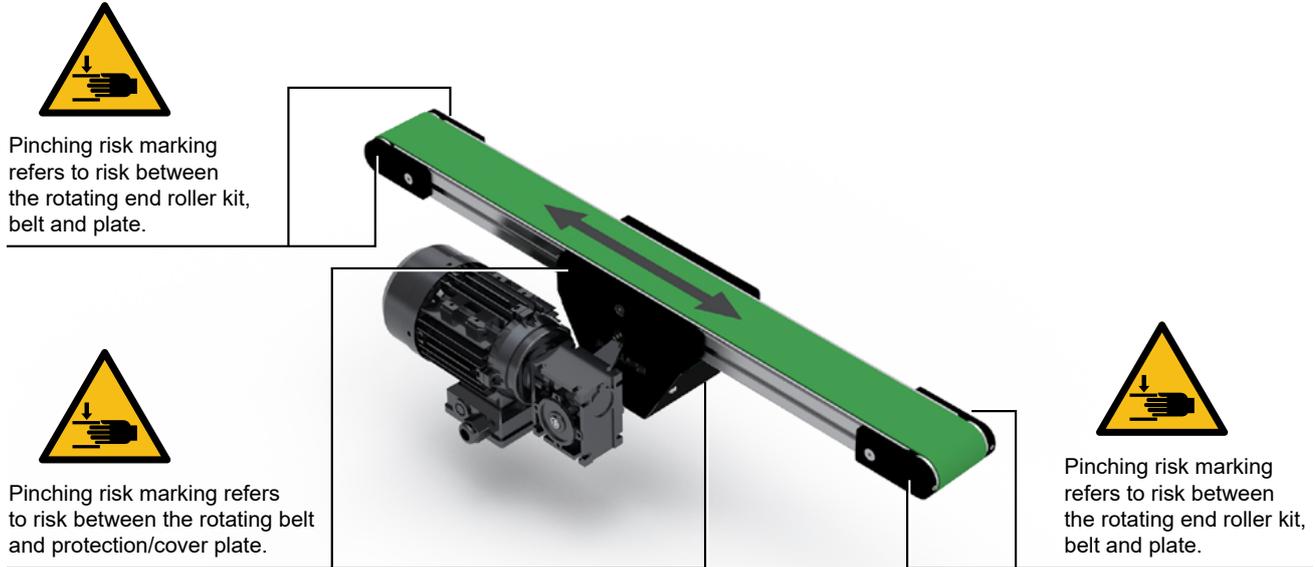
Danger zones



Even in the case of apparent low conveyor speed pinching hazards exist as follows.

- 1 At the beginning of the conveyor. Rollers and moving parts are partially exposed. Risk for being gripped and drawn in between belt, roller, slider plate, roller holders and or profile frame.
- 2 At the beginning of the centre drive (If relevant). Despite protection cover risk for being gripped and drawn in between belt, roller, slider plate, roller holders and or profile frame.
- 3 At the end of the centre drive (if relevant). Despite protection cover risk for being gripped and drawn in.
- 4 At the end of the conveyor. Rollers and moving parts are partially exposed. Risk for being gripped and drawn in between belt, roller, slider plate, roller holders and or profile frame.
- 5 The motor axle has a plastic protective cover. Moving parts are partially expose. Risk for being gripped and drawn in.
- 6 Under the conveyor band can hang low, especially with long lengths. Risk for being gripped and drawn in between underhang and conveyor. In some cases, support kits can be used to hold reduce the belt slacking however risk exists of being gripped and drawn in at these points also. The consumer must assess this risk in his/her assessment and protect the entire underside of the conveyor if necessary.
- 7 Risk of being gripped and drawn in between the belt and the protection plate that exists only on middle drive conveyors.

Hazard prevention



 Always disconnect voltage supply before assembling, disassembling, maintenance or removing blockages. While conveyor is in operation or supply voltage is connected, no operating or handling should occur at the forementioned locations!

 If there is a danger to the operation personnel while operating the device, despite all the actions, the operating company should cater for an appropriate covering of all danger zones!

 Beware that goods on the conveyor should be removed before maintenance. Goods on the conveyor can cause the conveyor to move and can result in risk to the operator both in forementioned areas and if goods were to fall off the conveyor. This is especially relevant in inclined conveyors if no motor with brake is mounted.

 The conveyor should always be securely anchored in position so no unexpected movement or tipping can occur during operation. If wheels are supplied these should in such cases be locked at all times and if still unstable be fixed in place by other methods.

 There is no stop, mechanical or otherwise, emergency or otherwise, included with or in the conveyor.

 **The conveyor is a partly complete machine. Responsibility lies with the consumer to complete the risk assessment for his/her application according to the machine directive.**

 Most belts are anti-statically equipped, please refer to the belt's technical documentation for your specific belt. Responsibility lies with the consumer to ensure full discharge is possible for the final installation.

Electrical safety

In cases where a motor and/or gear is supplied these are supplied as an accessory and will never be mounted. Rollco takes no responsibility for the electrical assembly or connecting of these accessories. Responsibility falls upon you as a consumer to ensure all electrical components, driving and controlling, start/stop, safety stops and similar elements are safe.

Always follow local active protocols of accident prevention and safety at your particular case of operation!
Also confirm to your own risk assessment and appropriate standards.

Electrical circuit points must always remain covered.

The correct function of protective conductor connections must be checked after assembly!

Installation may only be executed by authorized personnel!

Noise

Measured noise level is below 70dB(A).

Machine overview

Description

The conveyor consists of one belt tightened between two rollers on an aluminium frame and driven on a steel slider bed. In the case of a middle drive (BF**M) three central rollers are also present and said belt is tightened between these as well. Said rollers are loosely mounted in side mounts, and are held in suspension between belt and adjustable screws. One roller is powered by an electric motor either in the central or head position.



Usage

- The conveyor is designed to be used in an indoor environment; +10 to +30°C, 40-60% humidity. Varying temperatures and humidity can cause loosening and rusting.
- The conveyor is **not** ATEX approved.
- The conveyor is **not** FDA or EG 1935/2004 approved.

Model	Max width (mm)	Max length (mm)	Max distributed load (kg)
BF40E	400	4000	75
BF40M	400	6000	75
BF40EIK	400	4000	75
BF40MIK BF40MOK BF40MDK	400	4000	75
BF80E	1000	6000	150

Integration of the machine

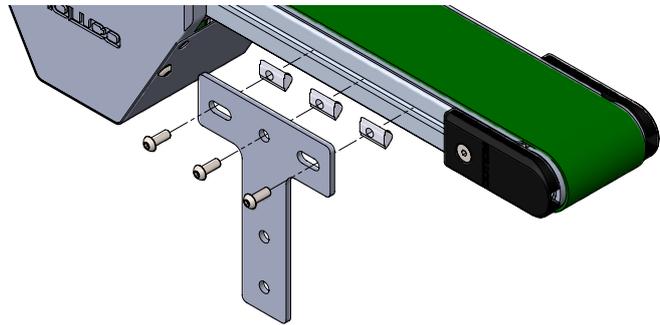
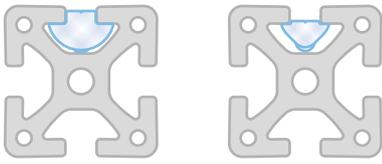
The optimal average working height for manual labour is approximately 95cm-120cm (according to AFS2012:2 Ergonomics for the Prevention of Musculoskeletal Disorders) for sit-down/stand-up workstations and should be taken into consideration under the design phase.

When designing or ordering a stand for the conveyor tipping risks should be taken into consideration. Conveyor should always be anchored securely to avoid risk of injury.

In the case of an operator, extra protection from pinching hazards must be added and avoidance of a machine determined work rate must be take into consideration.

Where risk of goods falling off the conveyor exists, conveyor guides and ends stops are needed and are available for purchase.

The profile tracks are the most secure anchoring points on the conveyor and are to be used when assembling stands to the conveyor frame or adding lifting points etc. Full compatibility is insured only when using Rollco stands and merchandise.



Drive

Rollco sometimes supplies motors, gears and even frequency converters at the request on the consumer. Rollco does not however assemble these to the conveyor or connect these electronically. Rollco claims no responsibility regarding the safety of said function or connections. The working on the drive rollers shaft can be made to accommodate many different types of motors and manufacturers. That said, Rollco has found that MS63/SB030 and MS71/SB050 motors/gears from Busck to be more than able to the required needs of the BF conveyor series and as a standard the series are worked to accommodate these motors/Gears.

These motors are of an IE3 Class in accordance with IEC 60034-30 and even fulfil international standards IEC 60034, AS1359, BS5000 and the CE directive. They are of the IP55 capsule class, protecting again dust deposits and water jets from any direction. The motor is insulated to class F but only exploits the temperature range for class B allowing a temperature reserve that increases lifetime and drive safety. The standard 3-phase motors are made for 230/400V +/-10%, 50Hz with 3 kW and 400/690 V +/-10% 50Hz from 4kW and above. Other motors are available. The motors can even be used for 60Hz as stated on the stamps.

This information is from Busck product catalogue edition 2020 and more information can be found at <https://www.busck.se/en>.

Using a frequency converter

Variable speeds can be achieved by using a frequency converter however this may affect the heating/cooling of the apparatus and reduce permissible torque. Noise and vibration behaviour may also be affected due to the output voltage of the converter. Max revolution is capped by the mechanical stress of the fan and the critical revolution speed of the ball bearings when working above nominal speeds. When installing a frequency converter, supplier's installation instructions regarding EMC must be followed.

Please refer to the appropriate design guide, fact sheet and programming guide supplied by Busck in the package. For more information about frequency converters, go to www.busck.se.



Transport



Rollers are not to be held when lifting.

Rotation of band and Rollers may occur if lifted inappropriately.

The conveyor will be packaged on an EUR-pallet or similar appropriate for lifting with a forklift, only to be driven by qualified personnel.

When removing from packaging, extreme care should be taken as belt and rollers are not fixed in position and rotation can occur.

If stand is supplied care should be taken when removed fastening straps as risk for tipping may occur. Some stands are only designed to stand fully stable when securely anchored.

In some cases, conveyors with stands are packaged upside down on for stability during transport. Care should be taken when unpacking and turning the conveyor and should not be attempted alone. Two people or more, or mechanical aid such as a forklift driven by authorized personnel should be used to prevent risk of injury.

Handling

The conveyor should be lifted from underneath using appropriate equipment, etc. a forklift by authorized and experienced personnel. We highly recommend being a minimum of two people when manual lifting is possible and holding securely to fixed points such as the conveyor frame and belt to avoid rotation of the band.

In the case of long conveyors lifting should occur at several points to reduce the damage that can occur due to the conveyor bending under its own weight.

Although great care has been taken to ensure no sharp or protruding edges are sharp and can cause bodily harm due care should be taken when opening the product.

Storage

The conveyor should be kept in a dry indoor environment, +10 to +30°C, 40-60% humidity. Varying temperatures and humidity can cause loosening and rusting.

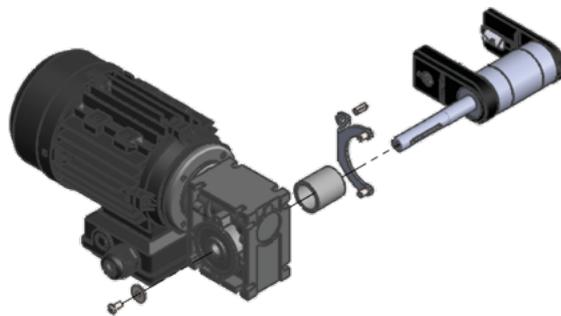
Installation

Maximum recommended incline 45%. Use profile tracks for attaching legs and accessories. Attaching feet to profiles supplied by Rollco can be achieved by threading directly into the profile end or by using appropriate foot plates. Wheels should always be locked before operation and the conveyor secured.



Mounting of motor/gear

This drawing shows the typical assembly of a Busck MS series motor onto the conveyor drive shaft.



Cabling and electrical connections

Always check that the nominal voltage matches your local supply voltage before initial operation of the conveyor!

The following applies only for Busck MS series motors. The terminal box on standard single speed motors normally contains six winding terminals and at least one earth terminal. In addition to the main winding and earthing terminals, the terminal box can also contain connections for thermistors, heating elements or other auxiliary devices. Suitable cable lugs must be used for the connection of all main cables. Cables for auxiliaries can be connected into their terminal blocks as such. Machines are intended for fixed installation only. If not otherwise specified, cable entry threads are metric. The IP-class of the cable gland must be at least the same as those at the terminal boxes. Unused cable entries must be closed with blanking elements according to the IP class of the terminal box. The degree of protection and diameter are specified in the documents relating to the cable gland.



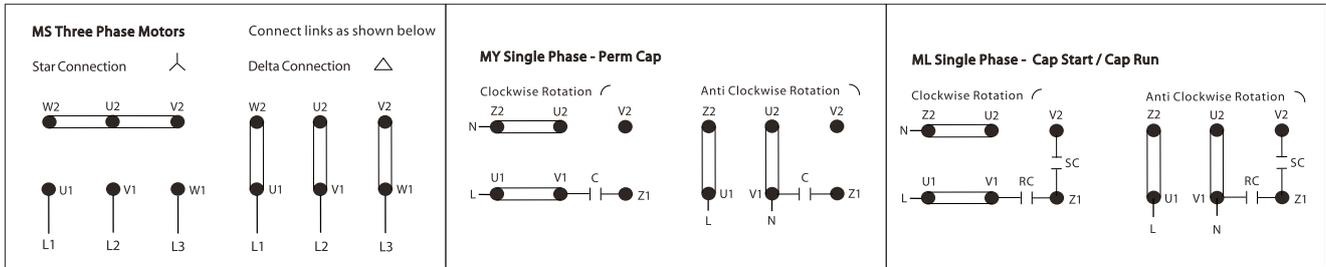
WARNING
 Use appropriate cable glands and seals in the cable entries according to the type and diameter of the cable. Earthing must be carried out according to local regulations before the machine is connected to the supply voltage. Ensure that the motor protection corresponds to the environment and weather conditions; for example, make sure that water cannot enter the motor or the terminal boxes. The seals of terminal boxes must be placed correctly in the slots provided, to ensure the correct IP class.

Connections for different starting methods

The terminal box on standard single speed motors normally contains six winding terminals and at least one earth terminal. This enables the use of DOL- or Y/D-starting. For two-speed and special motors, the supply connection must follow the instructions inside the terminal box or in the motor manual. The voltage and connection are stamped on the terminal box cover.

This information is from Busck product catalogue edition 2020 and more information can be found at <https://www.busck.se/en>.

Wiring diagram



Safety considerations

The machine is intended for installation and use by qualified personnel, familiar with health and safety requirements and national legislation. Safety equipment necessary for the prevention of accidents at the installation and operating site must be provided in accordance with local regulations.



WARNING
 Do not carry out work on motor, connection cables or accessories such as frequency converters, starters, brakes, thermistor cables or heating elements when voltage is applied.

Commissioning

Initial operation

Check that conveyor runs in the desired direction. The belts top side should always run towards the motor for best effect and tracking. The belt always comes pretensioned to 0,3% from Rollco and adjusted to run straight. Some tracking adjustment however will always be needed when the conveyor is assembled into your environment.

Belt tension

During continuous running belt tension and straightness of band must be checked weekly. If the tension is found lacking or the belt runs off centre, then adjustment and/or tensioning is needed. This should be done on the return/tail pulley ("tail-fix"). It is extremely important however not to tighten too hard and in doing so reduce the life expectancy of the bearings. Avoidance of over tensioning and regular cleaning of the conveyor thus avoiding pollution will increase the life expectancy of your Rollco BF series conveyor.



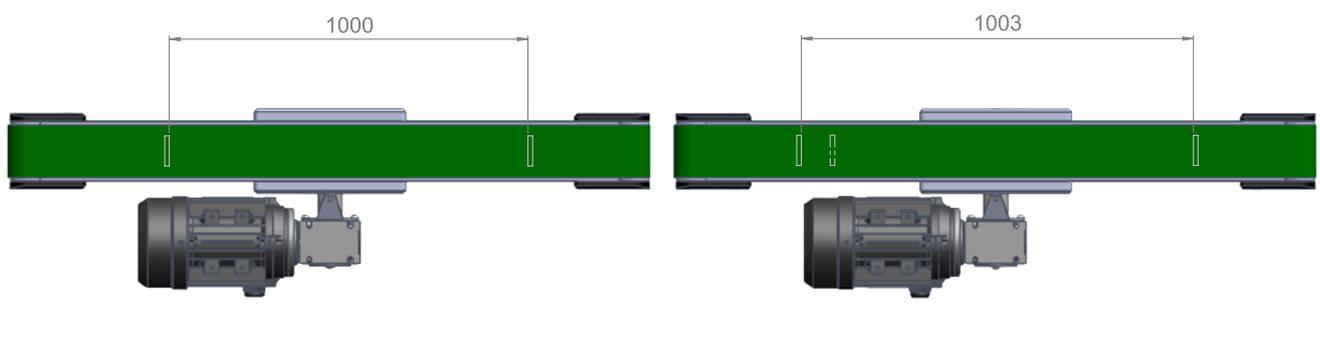
Belt tension is easily adjusted with open screws on the return/tail pulleys.

Adjustment of central support rollers in the middle drive kit (BF40M) is not recommended. These are pre-adjusted parallel to the drive roller prior to delivery. Contact Rollco for more information.

Adjusting belt tension

- The rollers should be in an axially parallel position to begin with.
- Release all tension at the return/tail pulley by screws the socket sets on both sides until all tension is absent.
- Mark on the belt two reference marks 1 meter apart etc. by using masking/electrical tape.
- Adjust now equally the two (right/left) socket screws returning tension to the conveyor.
- For 0,3% average recommended tension (can differ depending on type of belt, see relevant technical data sheet for more information) in relationship to the belt's length keep adjusting until the measurement between the two markings reads 1003 mm.
- Important is to adjust the two socket screws equally to preserve parallelity.
- Ideal tension is achieved.

Note! The 0,3% is a nominal value. All belts have unique recommended tensioning values due to differences in material and thickness. Refer to the belt technical documentation for more information.

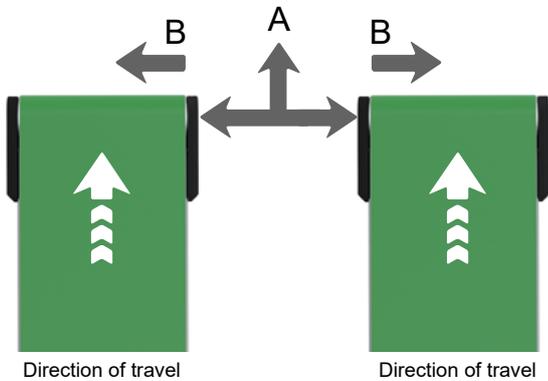


Adjusting belt run-off

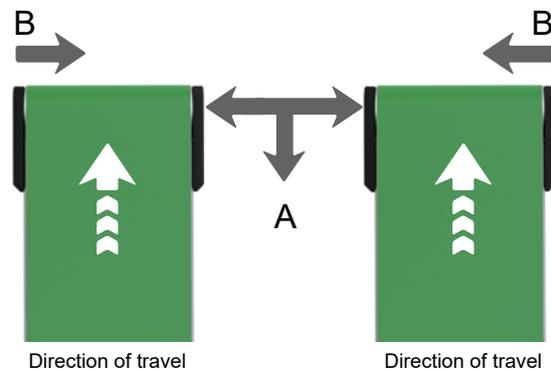


Most tracking problems in the conveyor occur due to miss alignment in the conveyor frame and/or stand. The first step should always be to ensure that the conveyor is mounted on a level, balanced and straight base.

1. The rollers should be in an axially parallel position to begin with.
2. Safety check the conveyor before starting the conveyor in the required direction.
3. It is important to preserve belt tension throughout entire process by adjusting equally and negatively. That is to say, tensioning the right-side socket screw of the conveyor half a turn needs to be compensated with a half turn release on the left side socket screw.
4. The belt will always move towards the loosened side and away from the tensioned side trying to find the point of lowest friction.
5. Tension and release by a maximum of half a turn on the socket screws and allow the conveyor to run several rotations before attempting further adjustments.



When the roller is tightened towards "A", the belt travels towards "B".



When the roller is loosened towards "A", the belt travels towards "B".

General maintenance instructions

Service point / To do	Service interval	Info	Response / Action
Bearing	Before 6 months or 1000h running time.	Check for wear.	Identify the problem and contact the supplier.
Electrical installation	Before 6 months or 1000h running time.	Visual check for damage.	Identify the problem and contact the supplier.
Conveyor belt tracking	Weekly or max 40h running time	Check the tracking and drive direction.	Adjust the belt with the belt tensioner. Use hex key.
Conveyor belt quality	Daily before operating	Visual check for damage.	Identify the problem and contact the supplier.
Screws / bolts, after the initial operation	1 month or max 160h running time after initial operation	Check the tightness.	Tighten the screw / bolt
Screws / bolts	Once annually or max 2000h running time	Check the tightness.	Tighten the screw / bolt

The BF40 mid drive has a protective cover over the drive kit. This offers protection to the pinching/crushing risks that exists about the drive/support rollers and the belt. This cover requires an Allen key to screw off. Removing the cover is only allowed when visual maintenance of the bearings is required. Always restore the protective cover after maintenance.



WARNING

Power must always be turned off during service or maintenance.

Changing components

Please refer to the included diagrams and drawings for help in changing components.



WARNING

When removing belt tension and belt, tail rollers become loose since they are not fastened into the end holders. Be especially careful with inclined conveyors as removed belt will result in rollers falling out if not held securely during removal.

Lubrication

The product is lifetime lubricated inside the bearings; no lubricating is necessary. If the lubrication should fail, then the bearings should be replaced.



WARNING

Be aware that leaking lubricants may cause skin irritation.

Motor maintenance instructions

**WARNING**

Voltage may be connected at standstills inside the terminal box for heating elements or direct winding heating. The capacitor in single-phase motors can retain a charge that appears across the motor terminals, even when the motor has reached standstills. A motor with frequency converter supply may energize even if the motor is at standstill.

Motor inspection

1. Inspect the motor at regular intervals, at least once a year. The frequency of checks depends on, for example, the humidity level of the ambient air and on the local weather conditions. This can initially be determined experimentally and must then be strictly adhered to.
2. Keep the motor clean and ensure free ventilation airflow. If the motor is used in a dusty environment, the ventilation system must be regularly checked and cleaned.
3. Check the condition of shaft seals (e.g. V-ring or radial seal) and replace if necessary.
4. Check the condition of connections and mounting and assembly bolts.
5. Check the bearing condition by listening for any unusual noise, vibration measurement, bearing temperature, inspection of spent grease or bearing monitor. Pay special attention to bearings when their calculated rated lifetime is coming to an end.

When signs of wear are noticed, dismantle the motor, check the parts, and replace if necessary. When bearings are changed, replacement bearings must be of the same type as those originally fitted. The shaft seals must be replaced with seals of the same quality and characteristics as the originals when changing bearings. In the case of the IP 55 motor and when the motor has been delivered with a plug closed, it is advisable to periodically open the drain plugs in order to ensure that the way out for condensation is not blocked and allows condensation to escape from the motor. This operation must be done when the motor is at a standstill and has been made safe to work on.

Information above is from Busck. Contact Busck for further details.

Motor lubrication

For information on motor lubrication please refer to supplier's documentation.

Cleaning

Power must be removed before cleaning the conveyor.

Rollers and internal parts should not be cleaned with liquids or detergents since this can result in rusting.

Please refer to the belt product sheet for appropriate cleanings methods for your specific belt type / material.

Decommissioning

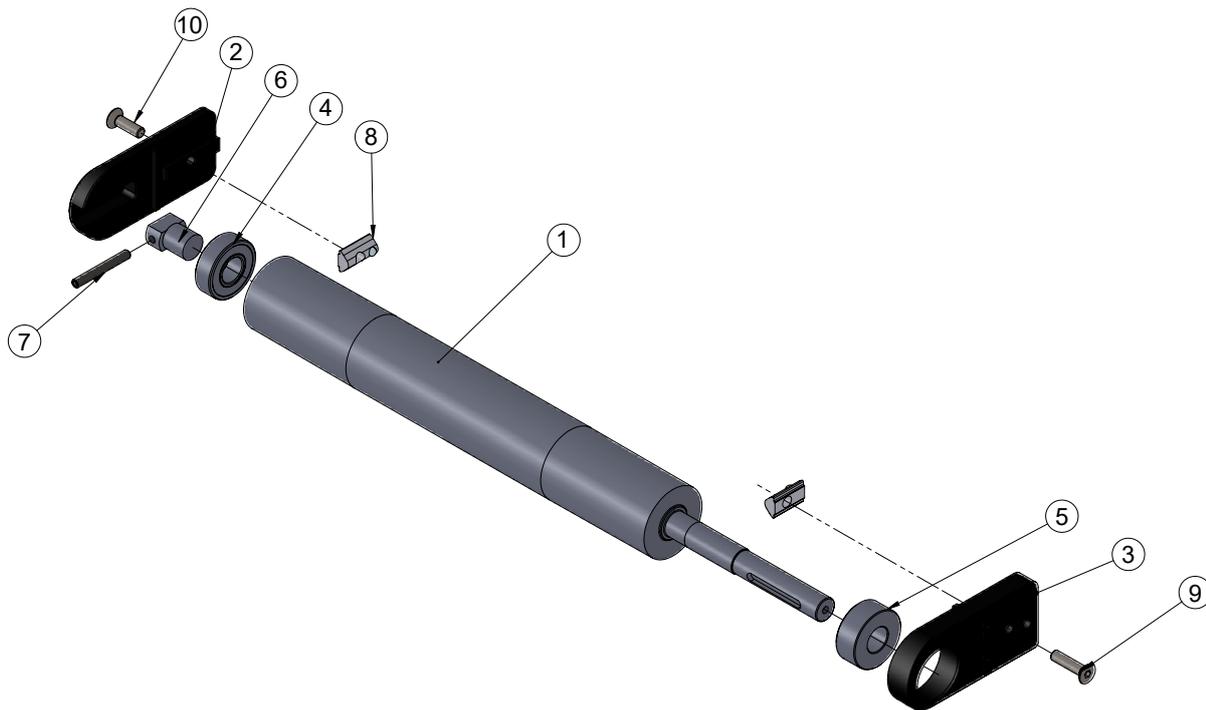
The Rollco BF series conveyor should always be disassembled into its single parts and then sorted by material type. Appropriate depollution according to material type for non-recyclable components. It should never be recycled as an entire unit. If unsure as to the correct procedure, please contact Rollco and we will dispose of unit in the correct manner.

Drawings

The following drawings will assist you in finding all the appropriate parts included in your BF series conveyor. The drawings Mon. Art. nr refers to Rollco's article number with which you can order spare parts. Only parts supplied by Rollco guarantee compatibility.

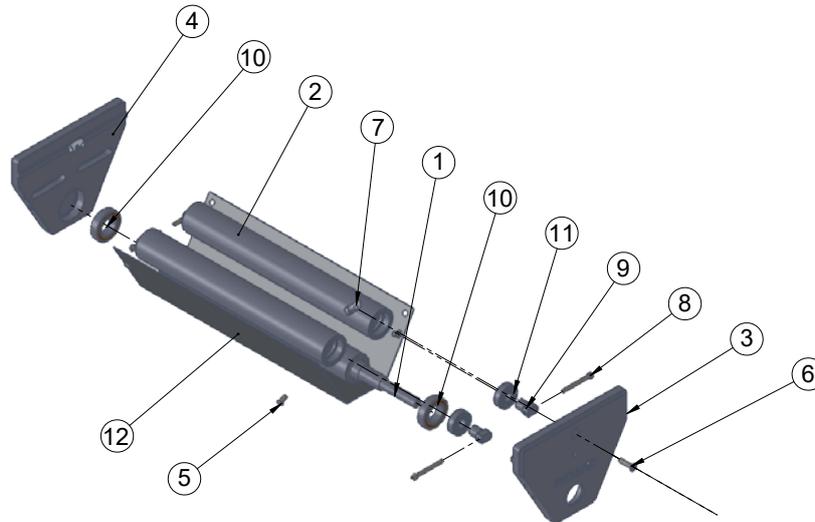
If problems occur, please contact Rollco AB at +46 42 15 00 40.

BF 40E Drive fix



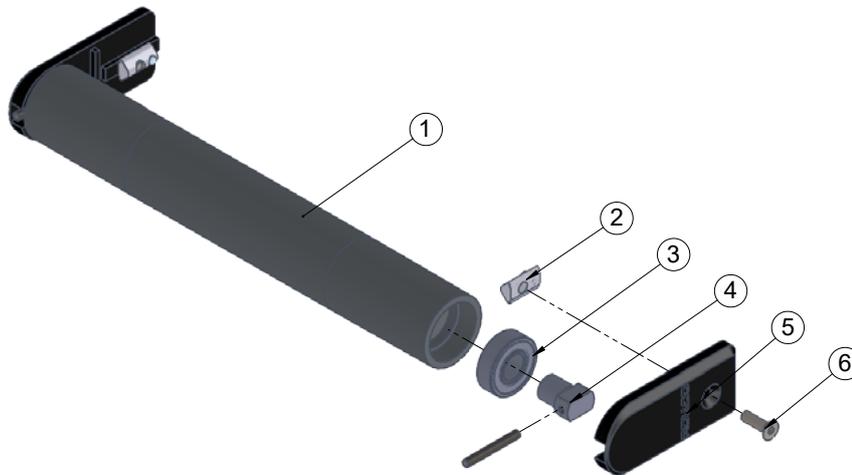
NO.	PART NUMBER	DESCRIPTION	Mon Art nr	QTY.
1	7100-00597	ROLLER BF40EDrive W=XXXX	-	1
2	7100-00016	END HOLDER BF40E	1001840	1
3	7100-00017	BF40E Endholder, Drive	1001841	1
4	0000-00024	Ball bearing 6202-2RS	1002440	1
5	0000-00035	Ball Bearing 2202-2RS	1002441	1
6	7100-00035	BELT TENSIONER BF40	1001842	1
7	Screw socket set C M05x40 fzb	Screw Socket set C M5X40 A2K	1002329	1
8	7000-00256	SV2102V T-Nut M8. Ball-Type, Push-In	3100950	2
9	DIN 7991 - M6 x 25 --- 18.7N	Screw MF6S M6x25 A2K DIN7991	1002336	1
10	DIN 7991 - M6 x 20 --- 13.7N	Screw MF6S M6x20 A2K DIN7991	1002335	1

BF 40M Drive fix



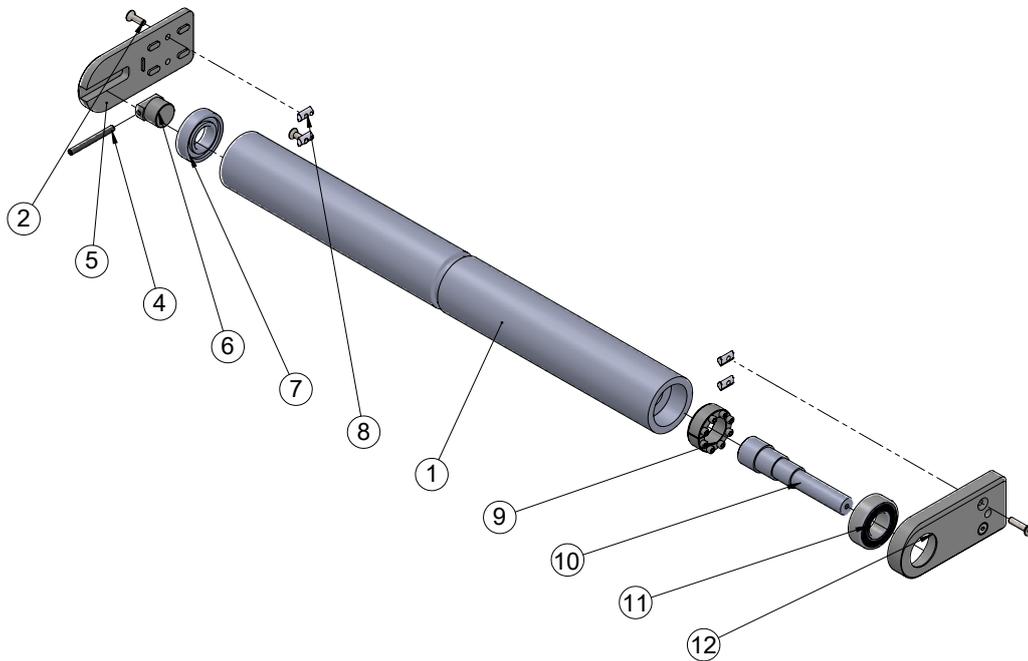
NO.	PART NUMBER	DESCRIPTION	Mon Art nr	QTY.
1	7100-00546	ROLLER BF40M Drive W=XXX	-	1
2	7100-00545	ROLLER BF40M Support W=XXX	-	2
3	7100-00074	END HOLDER BF40M Drive	1001847	1
4	7100-00073	END HOLDER BF40M Neutral	1001848	1
5	ISO 7380 - M6 x 12 - 12N	PS1250 Screw K6S M6x12	1002270	4
6	DIN 7991 - M6 x 25 --- 18.7N	Screw MF6S M6x25 A2K DIN7991	1002336	2
7	7000-00256	SV2102V T-Nut M8. Ball-Type, Push-In	3100950	2
8	ISO 4762 M5 x 50 - 50N	Screw MRT M5x50 ytb	1002334	4
9	7100-01821	Belt Tensioner, BF40M	1023333	4
10	0000-00034	Ball Bearing 6005-2RS	1002435	2
11	0000-00024	Ball bearing 6202-2RS	1002440	4
12	7100-00555	COVER PLATE BF40M W=XXX	-	1

BF 40E & 40M Tail fix



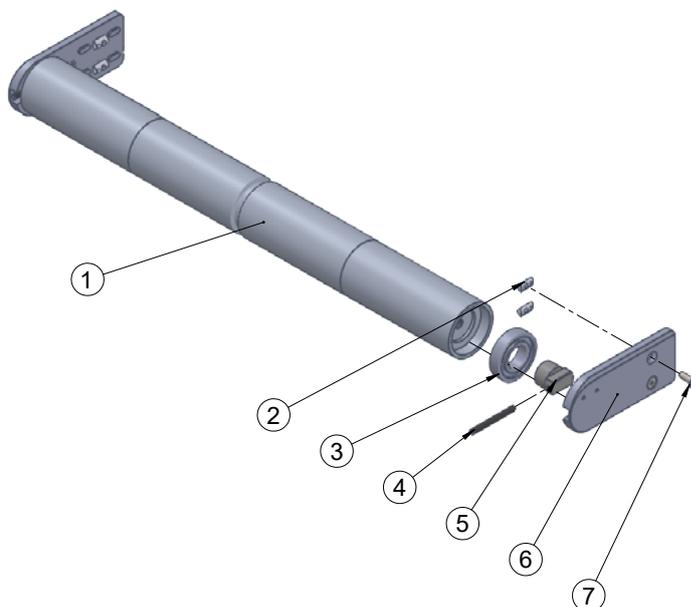
NO.	PART NUMBER	DESCRIPTION	Mon Art nr	QTY.
1	7100-00590	Roller BF40E-M W=XXX	-	1
2	7000-00256	SV2102V T-Nut M8. Ball-Type, Push-In	3100950	2
3	7000-00256	Ball bearing 6202-2RS	1002440	2
4	7100-00035	Belt Tensioner	1001842	2
5	7100-00016	Endholder, Neutral	1001840	2
6	DIN 7991 - M6 x 20 --- 13.7N	Screw MF6S M6x20 A2K DIN7991	1002335	2
7	Screw socket set C M05x40 fzb	Screw Socket set C M5X40 A2K	1002329	2

BF 80E Drive fix



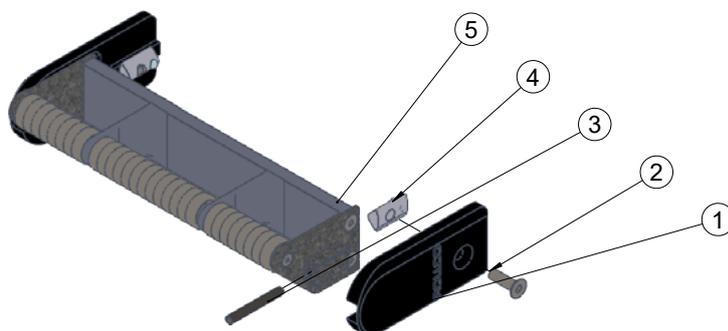
NO.	PART NUMBER	DESCRIPTION	Mon Art nr	QTY.
1	7100-00374	ROLLER BF80E Drive W=XXX KnX	-	1
2	Screw	MF6S 10.9 M8X25 DIN7991 A2K	1002070	2
3	Screw	MF6S 10.9 M8X35 DIN7991 A2K	1002126	2
4	0000-00262	SK6SS 45H M8X80 ISO4029	1002383	1
5	7100-00143	Endholder neutral	1001908	1
6	7100-00146	Belt tensioner BF80E	1001910	1
7	0000-00065	Ball Bearing 6207-2RS	1002444	1
8	7000-00256	SV2102V T-Nut M8. Ball-Type, Push-In	3100950	4
9	7100-00148	Locking device KBS52-40x62	1002418	1
10	7100-00149	BF80Eshaft drive BF80E	1001906	1
11	7100-00145	COMPONENT Ball Bearing 2207-2RS	1002443	1
12	7100-00142	80EEndHolder. Drive	1001909	1

BF 80E Tail fix



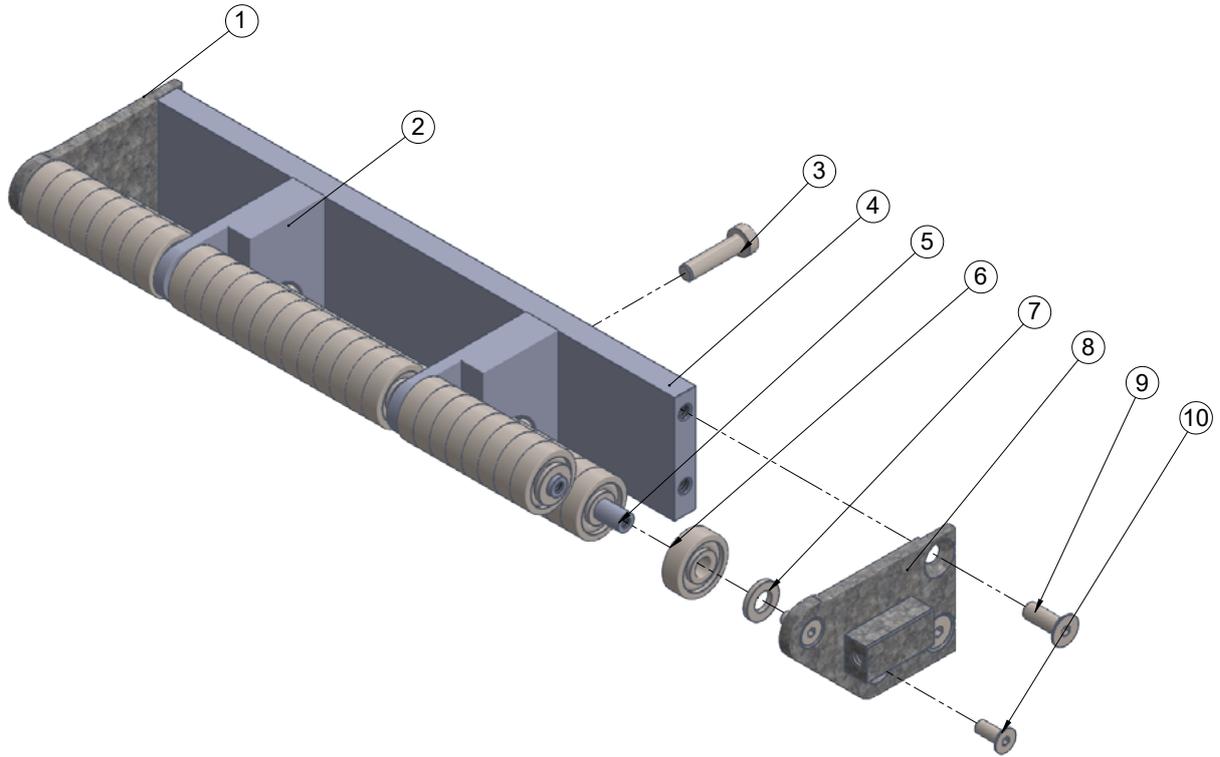
NO.	PART NUMBER	DESCRIPTION	Mon Art nr	QTY.
1	7100-00375	Roller BF80E End W=XXXX (KnX)	-	1
2	7000-00256	SV2102V T-Nut M8. Ball-Type, Push-In	3100950	4
3	0000-00065	Ball Bearing 6207-2RS	1002444	2
4	0000-00262	SK6SS 45H M8X80 ISO4029	1002383	2
5	7100-00146	Belt tensioner BF80E	1001910	2
6	7100-01229	BF80EZEndHolder. Neutral	1001908	2
7	Screw	MF6S 10.9 M8X25 DIN7991 A2K	1002070	4

Knife fix



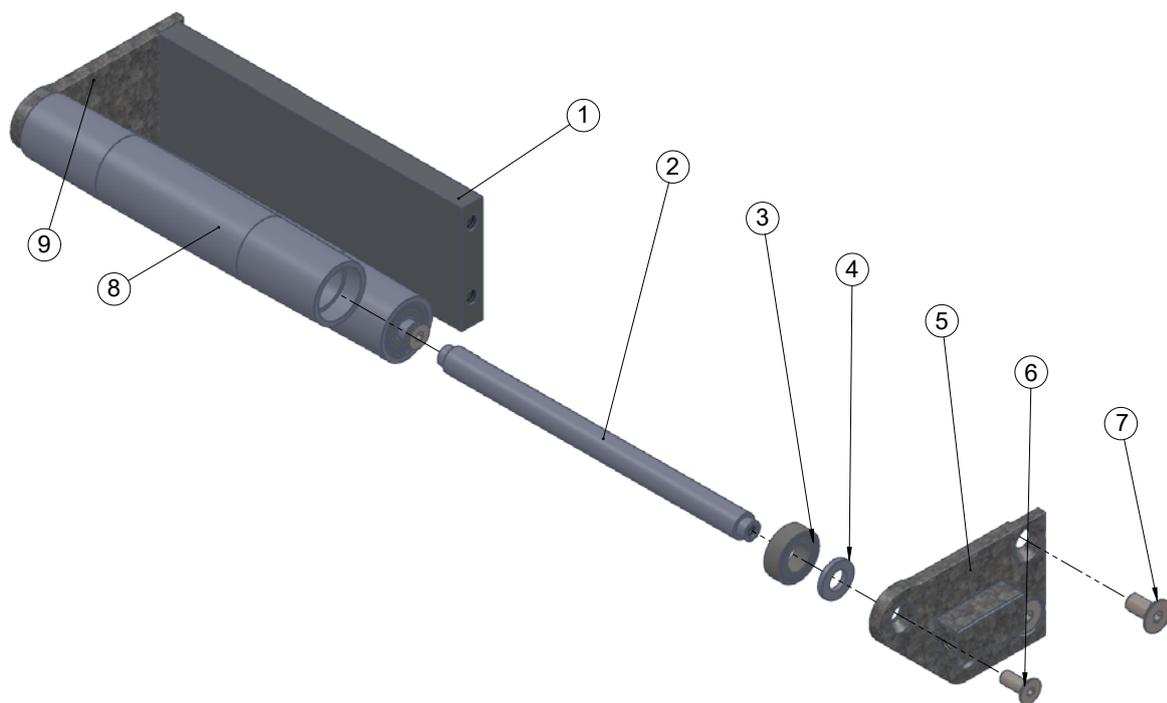
NO.	PART NUMBER	DESCRIPTION	Mon Art nr	QTY.
1	7100-00016	Endholder, Neutral	1001840	2
2	Screw	MF6S 10.9 M6X20 DIN7991 A2K	1002335	2
3	0000-00261	SK6SS 45H M5X40 ISO4029 A2K	1002329	2
4	7000-00256	SV2102V T-Nut M8. Ball-Type, Push-In	3100950	2
5	7100-00089	40E-Knife Edge Kit W=200	1015494	1

Knife kit 1



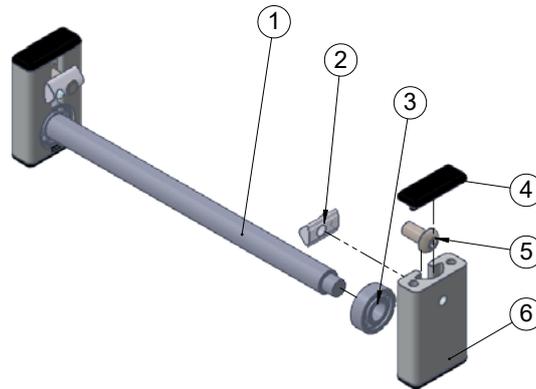
NO.	PART NUMBER	DESCRIPTION	Mon Art nr	QTY.
1	7100-00085	BF40EEndholder Knife Right	1015255	1
2	7100-00087	40E-Holder Knife Mid	1015256	2
3	Screw	MC6LS 8.8 M5X20 DIN7984 A2K	1002197	4
4	7100-00088	40E-Holder Knife Back W=xxx	-	1
5	2200-00101	W6-M4-M4 W=xxx	-	2
6	0000-00025	Ball Bearing 626-8 ZZ	1015314	58
7	Washer	BRB 6,4X12X1,6 DIN125 A2K	1002119	2
8	7100-00086	BF40EEndholder Knife Left	1015254	1
9	Screw	MF6S 10.9 M5X14 DIN7991 A2K	1002066	4
10	Screw	MF6S 10.9 M4X10 DIN7991 A2K	1002063	4

Knife kit 2



NO.	PART NUMBER	DESCRIPTION	Mon Art nr	QTY.
1	7100-00845	KNIFE EDGE Back BF40 W=XXX	-	1
2	7100-00846	KNIFE EDGE Shaft W8-M4-M4 W=XXX	-	2
3	0000-00026	Ball Bearing 628/8 2RS1	1010484	4
4	Washer	BRB 6,4X12X1,6 DIN125 A2K	1002119	4
5	7100-00086	BF40EEndholder Knife Left	1015254	1
6	Screw	MF6S 10.9 M4X10 DIN7991 A2K	1002063	4
7	Screw	MF6S 10.9 M5X14 DIN7991 A2K	1002066	4
8	7100-00847	ROLLER BF40 W=XXX Ø20 Knife	-	2
9	7100-00085	BF40Endholder Knife Right	1015255	1

Support kit



NO.	PART NUMBER	DESCRIPTION	Mon Art nr	QTY.
1	7100-00835	SUPPORT KIT Shaft BF W=400 W14 Ø10/Ø10		1
2	7000-00256	SV2102V T-Nut M8. Ball-Type, Push-In	3100950	2
3	0000-00074	W6000-2RS Ball Bearing	1002437	2
4	7003-00273	SZ0030S Profile Cap 16x40	3101026	4
5	ISO 7380 - M8 x 16 - 16N	PS1325 Screw K6S M8x16	1002284	2
6	7100-00834	SUPPORT KIT Holder 40x16	1005523	2

Troubleshooting

Belt is still but drive roller rotates	Check conveyor is not overloaded.
	Check belt tension.
Belt runs off to the side	Check that the conveyor is mounted level.
	Check that support is supplied close to the conveyor ends, middle, and where extra weight exists etc. middle drive kit.
	Follow belt tensioning/tracking instructions.

Annexes

- Attachment 1 List of spare parts / specifications
- Attachment 2 Belt product data sheet
- Attachment 3 Technical data sheet from Busck (optional)
- Attachment 4 Product drawing (optional)
- Attachment 5 Declaration of incorporation of partly completed machinery

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