



BB17-MC

Middle Conveyor

24" wide by 4' long conveyor dryer extension

ORIGINAL DOCUMENT

IMPORTANT INSTRUCTIONS

SAVE THESE INSTRUCTIONS FOR FUTURE REFERENCE

This manual covers assembly, operation and troubleshooting.

800-654-4205 – 1100 Jefferson Street – Pacific, MO 63069 USA

www.bbcind.com

Assembly Instructions

BEFORE BEGINNING:

- Please review all these instructions prior to assembly.
- The *Middle Conveyor* is packaged in 1 cartons for shipment.
- Please make sure all pieces have been received before attempting assembly.
- Note that portions of assembly procedure require 2 people.
- Unpack, identify, and inspect all parts. Report any missing or damaged items.
Cover a 4' x 14' area on the floor with towels, cardboard, carpet, etc. to protect the painted parts from being scratched during assembly. (Add 4' of length for each additional BB17-MC)
- **Tools Required:** One ½" wrench & needle nose pliers
- Parts List:

Label on Box	Qty	Contents
BB17-MC	1	Conveyor Bed
	2	Conveyor Leg
	1	Conveyor Leg Cross
	1	Conveyor Belt Extension
	12	Bolts for Conveyor Leg Assembly
	1	Cord
	6	Cord Routing Clip

NOTE: These Assembly Instructions show how to assemble one BB17-MC Middle Conveyor extension to a Conveyor Dryer. To add more BB17-MC Middle Conveyor extensions, apply the same steps in the following instructions.

CONVEYOR BED ASSEMBLY:

1. Remove (4x) bolts from BB17-LK carton & (4x) bolts from BB17-MC carton.
2. Place the Conveyor Drive Assembly on the covered floor. (See Figure 1)
3. Butt the Middle Conveyor Bed Assembly to the Drive Assembly. Be sure to place BB17-MC with Nut Inserts on the correct side of conveyor. (See Figure 1)
4. Butt the Conveyor Take-Up Assembly to the Middle Conveyor Bed Assembly. Be sure that the groove on each roller drum is on the same side of the bed.
5. Bolt the bed assembly together using (8x) bolts.

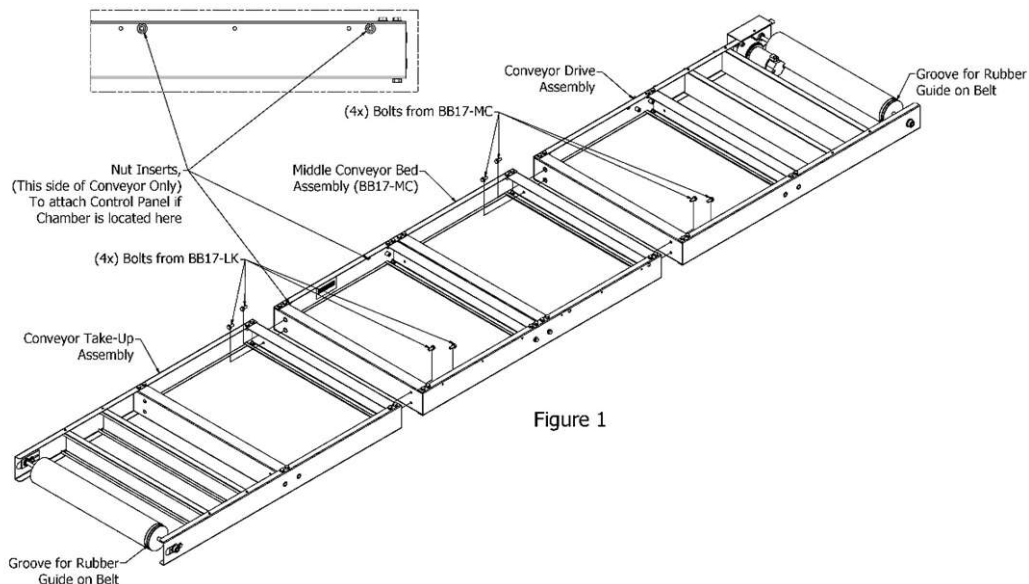


Figure 1

6. Fasten (6x) legs with (12x) bolts. Leave bolts loose. (See Figure 2)

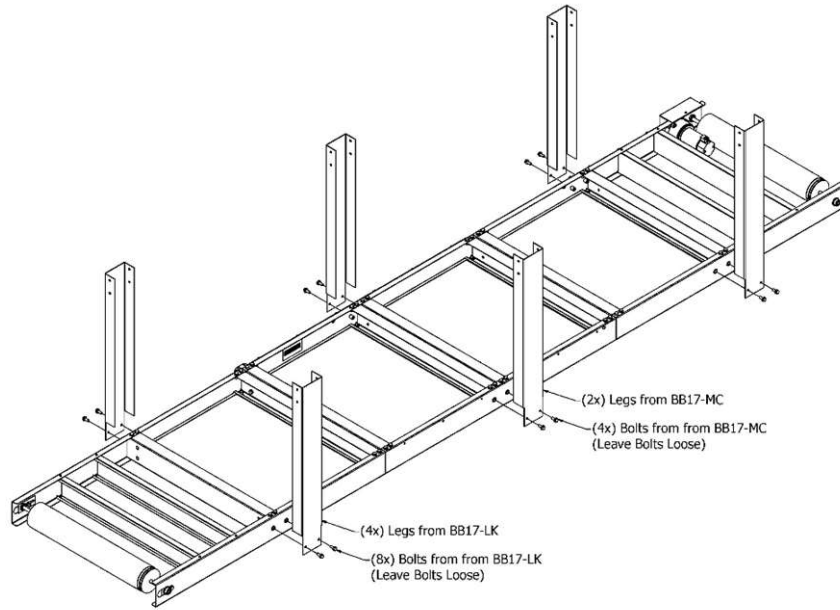


Figure 2

7. Install (3x) leg crosses to legs with (24x) bolts. (See Figure 3)

8. Tighten all bolts.

9. **Using two people** turn conveyor bed over onto its legs.

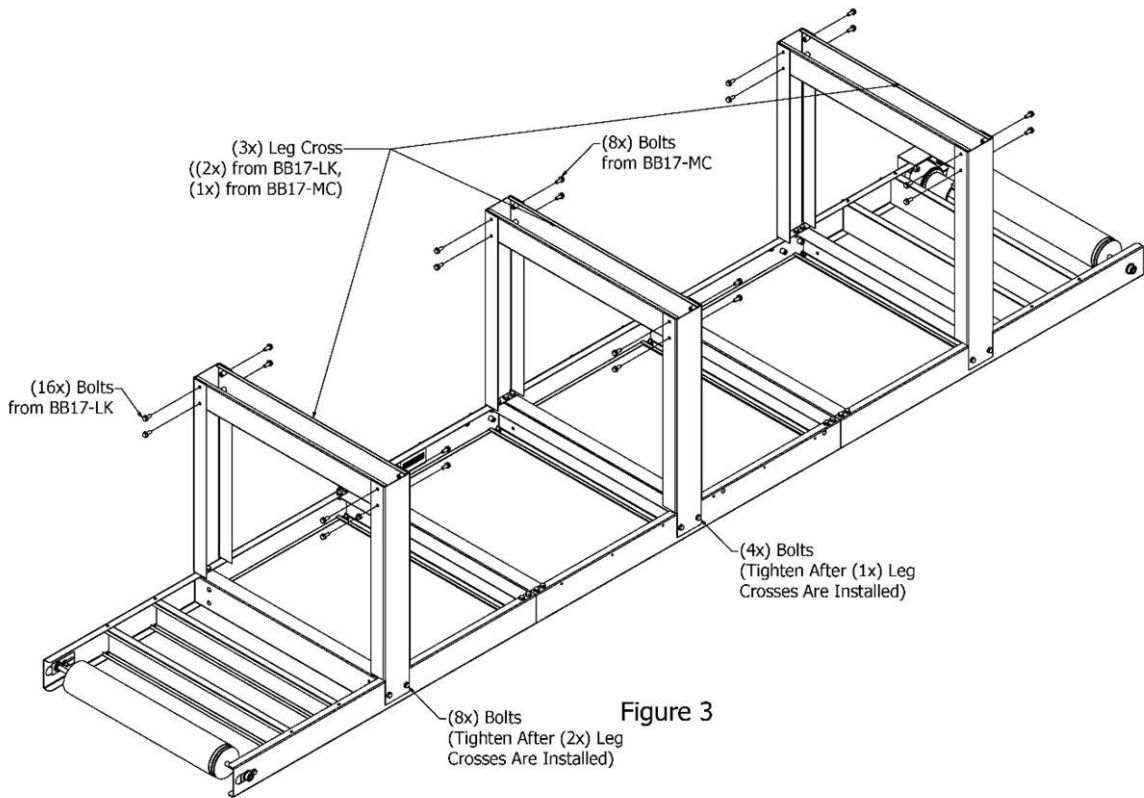


Figure 3

CONVEYOR BELT INSTALLATION:

1. Determine the side of the belts that will convey product. A rubber guide is stitched onto one edge of the belts. This guide is designed to ride in the roller drum grooves to provide Hassle-Free-Tracking. (See Figure 4)
2. Carefully remove the splice pins from the inside teeth of the splice connector by pulling gently with needle nose pliers. **DO NOT BEND**; these pins will be reinserted later.
3. Align the rubber guides of the multiple belts and reinsert all but one of the splice pins into the meshing teeth of the splice.
4. Lay the belt on the conveyor bed aligning the edge guide with the roller drum grooves.
5. Pull the ends of the belt together meshing the teeth of the splice while a **second person** reinserts the last splice pin (removed earlier) into the channel formed by the interlocked metal teeth. It may be easier to rotate the belt so that the splice is on top of the conveyor bed before inserting pin. Using needle nose pliers, fully insert the pin until it is centered.
6. **Adjust belt tension:** Loosen (2x) hex bolts at Take Up Roller (See Figure 4). Pull roller at groove end till you have sag of 1 – 1.5 inches below the cross-members as the belt travels under the conveyor bed. Tighten hex bolt.
7. Adjust opposite end of roller to same location and tighten hex bolt.

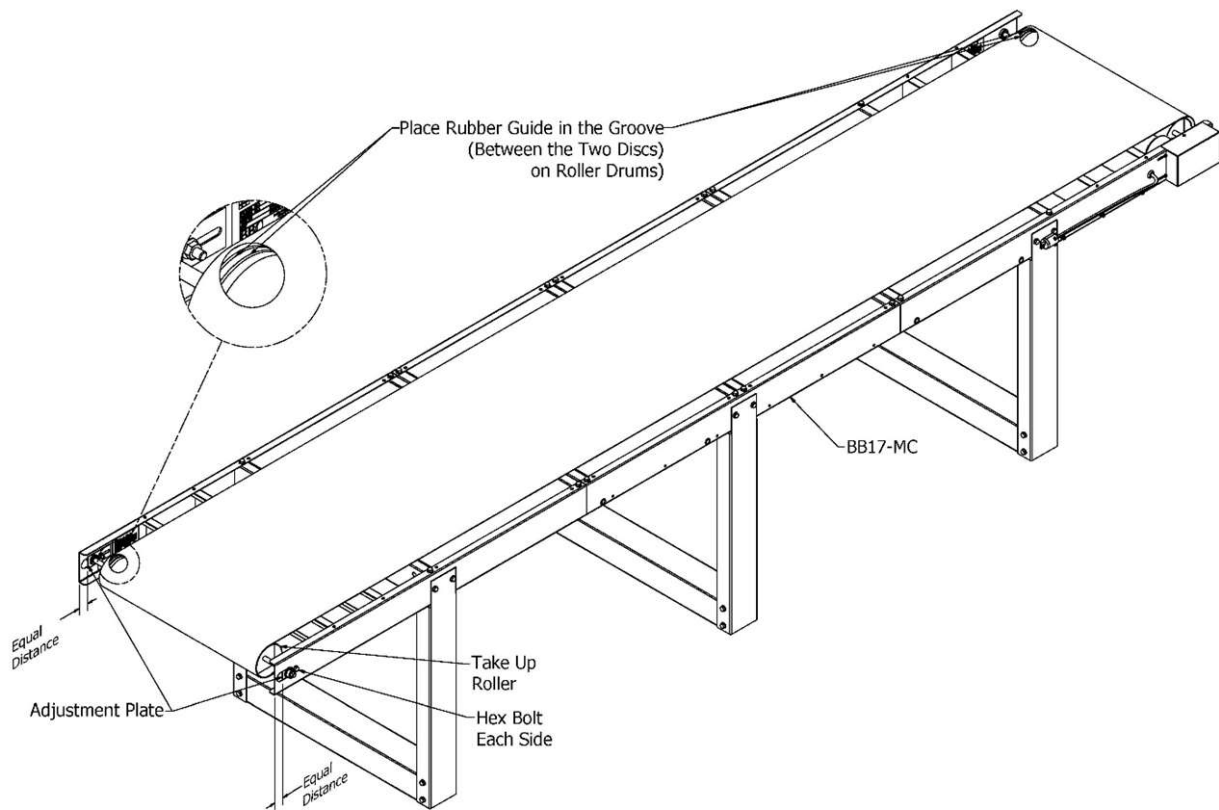
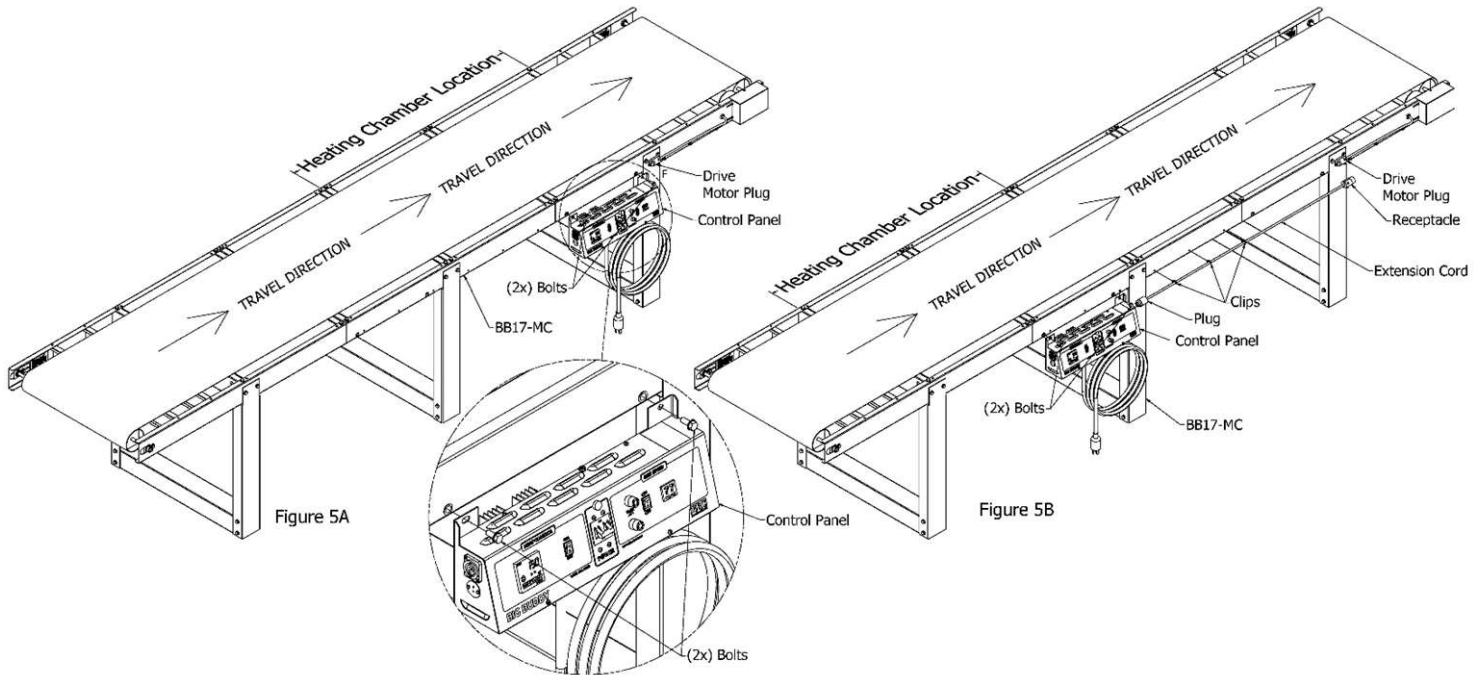


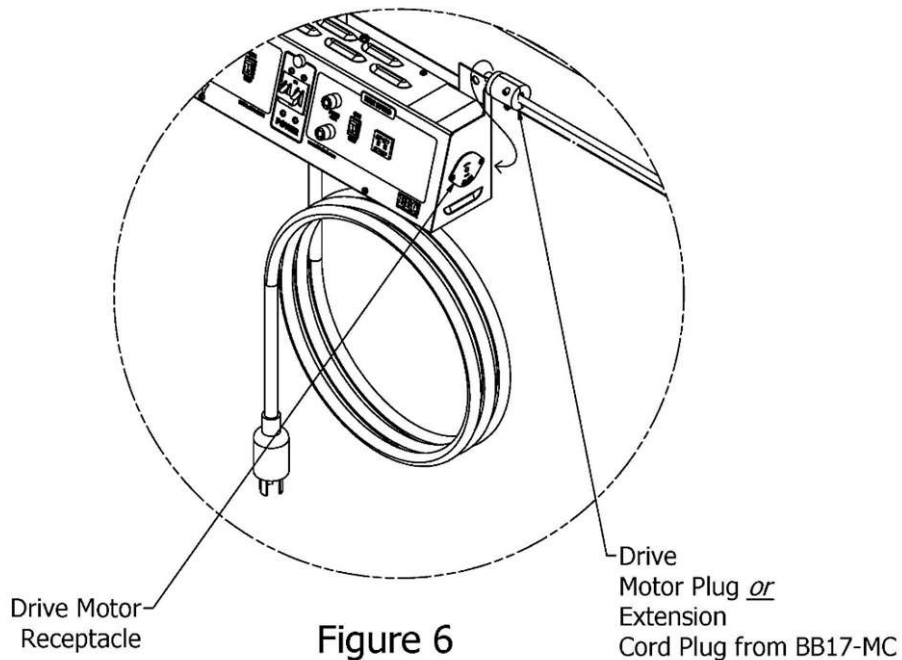
Figure 4

CONTROL PANEL INSTALLATION:

1. Determine the location of the Heating Chamber before moving onto the next step.
2. The Control Panel must be located in the same proximity to the Heating Chamber as shown in Figures 5A and 5B.
3. Use the remaining (2x) bolts from BB17-LK carton to fasten the control panel to the conveyor assembly. (See Figure 5A or 5B)



4. If placing Heating Chamber in Figure 5B location, use the Extension Cord from BB17-MC. Twist plug and receptacle to lock in place.
5. Insert drive motor plug or extension cord plug into drive motor receptacle. Twist plug to lock in place. (See Figure 6)



ATTACHING HEATING CHAMBER:

1. **Using two people** set the chamber onto the conveyor bed. (See Figure 7A or 7B) The Heating Chamber cord must be on the same side of the Conveyor Bed as the Control Panel.
2. The Heating Chamber has openings on the underside rails that fit over the hex-head bolts. The chamber should rest flatly on the conveyor bed.

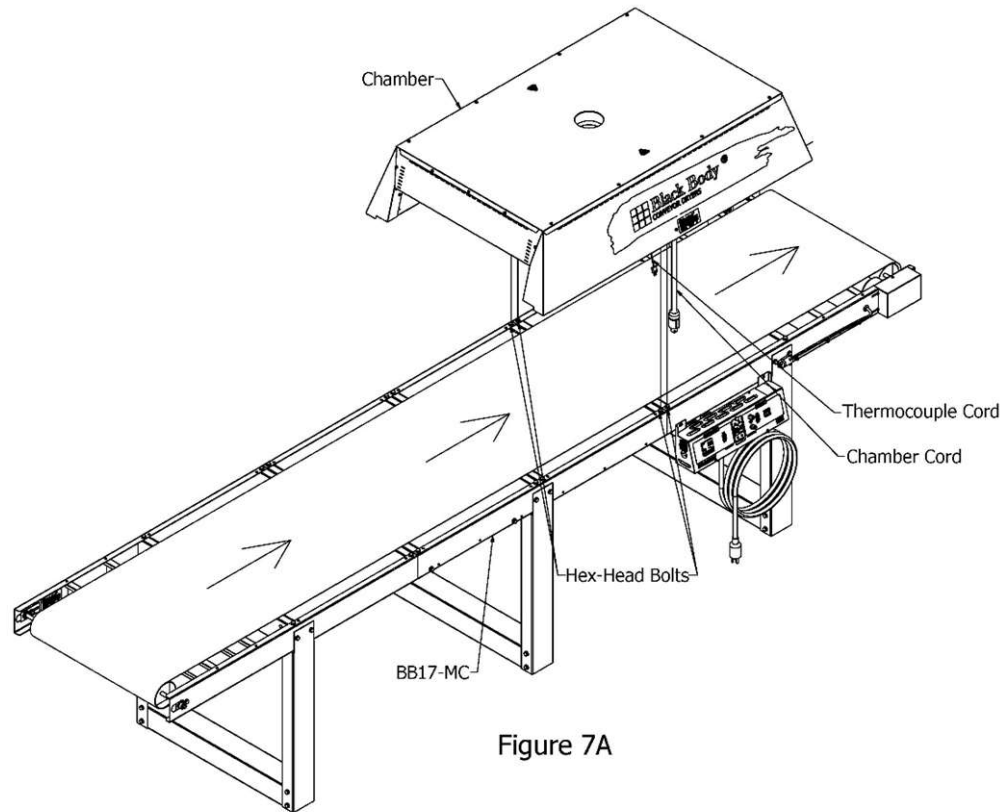


Figure 7A

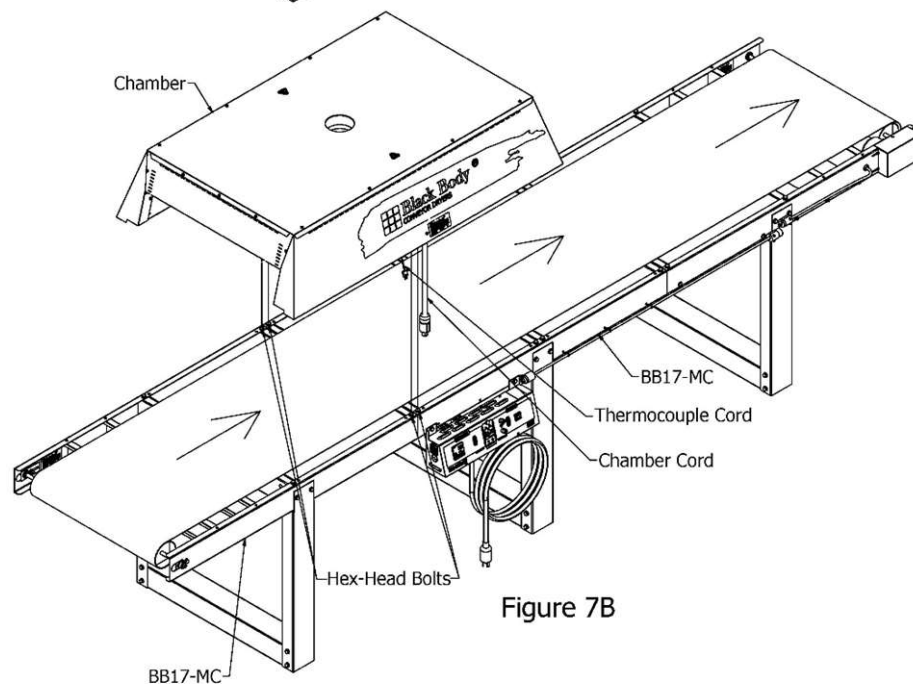
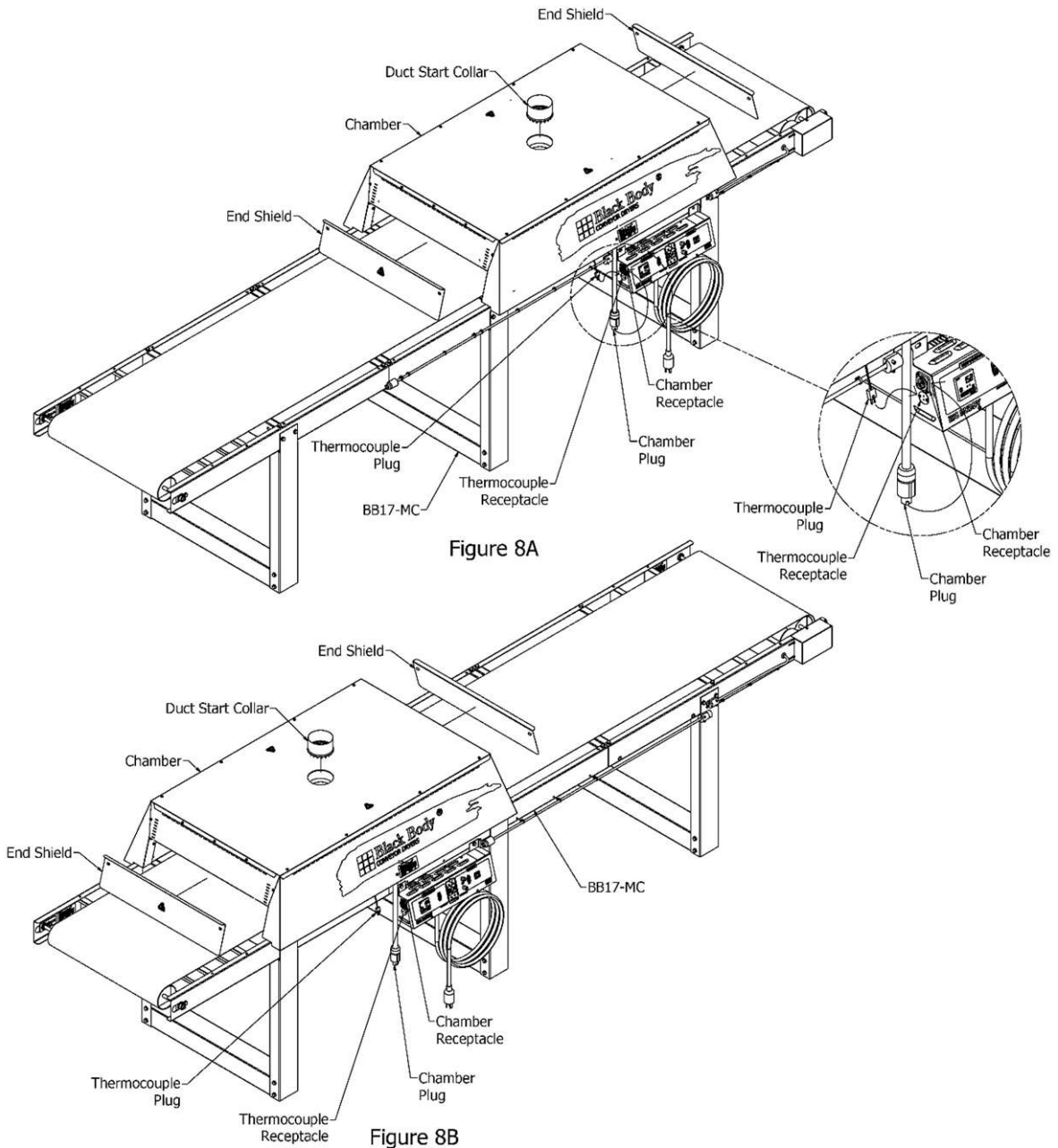


Figure 7B

3. Insert the Duct Start Collar into the hole in the top of the Heating Chamber. Once in position, bend the tabs at the base of the collar outward to secure it in place. **Note:** The chamber will function properly with only the duct start collar installed. Installing a 2-3 foot section of 4" diameter ductwork on the start collar will improve the capture of heat and vapors created during the curing process. Installing the 4" diameter ductwork will also make the top of the Heating Chamber cooler.
4. Place End Shields at desired height on the entrance and exit of the Heating Chamber.
5. Plug the Heating Chamber cord into the receptacle on the Control Panel. (See Magnified View, Figure 8)
6. Plug the Thermocouple cord into the receptacle on the Control Panel. (See Magnified View, Figure 8)



See Conveyor Dryer Instruction Manual for Procedure, Maintenance, and Troubleshooting.