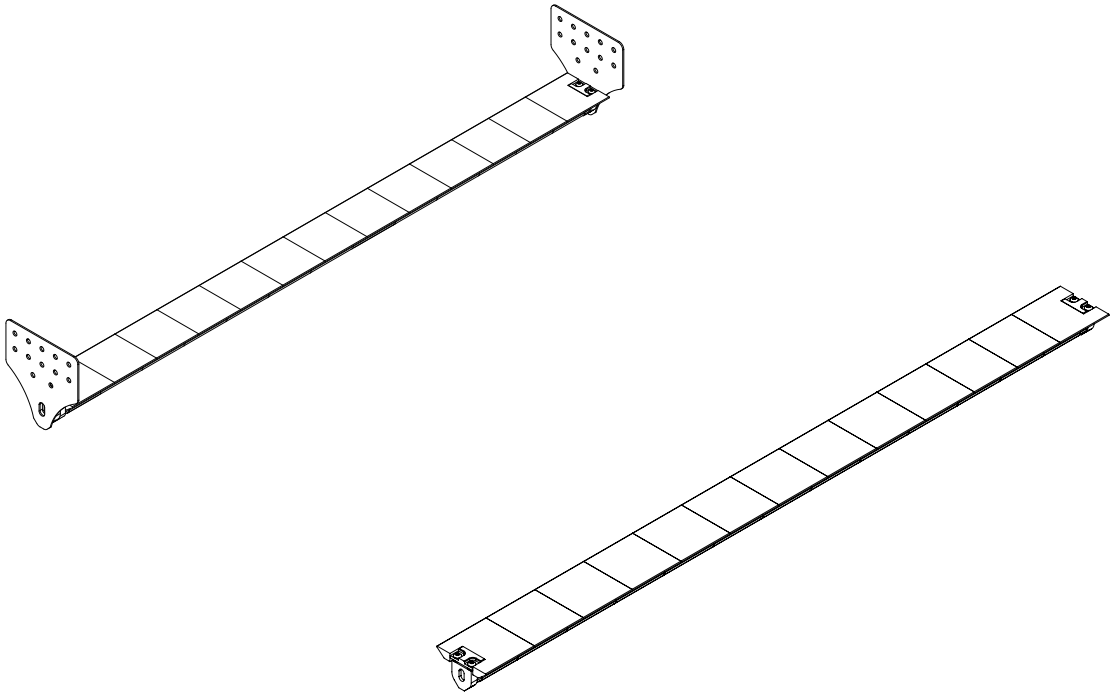
Midsize Segmented Transfer Plates

Installation, Operation & Maintenance Manual



Patents: www.flexco.com/patents

FLEXCO

Midsize Segmented Transfer Plates

Ordering Number: _____

Installation Date: _____

Purchase Date: _____

Purchased From: _____

This information will be helpful for any future inquiries or questions about replacement parts, specifications, or troubleshooting.

Table of Contents

Section 1 – Important Information

1.1 Introduction

We at Flexco are very pleased that you have selected the Midsized Segmented Transfer Plates for your conveyor system.

This manual will help you to understand the operation of this product and assist you in making it perform to its maximum efficiency over its lifetime of service.

It is essential for safe and efficient operation that the information and guidelines presented here be properly understood and implemented. This manual will provide safety precautions, installation instructions, maintenance procedures, and troubleshooting tips.

If you have any questions or problems that are not covered in this manual, please visit **www.flexco.com**.

This manual is intended to be read and used by trained maintenance personnel and conveyor operators who will be directly responsible for installation, operation, and maintenance of this product. It is imperative that this manual be read thoroughly and in its entirety. While we have tried to make the installation and service tasks as simple as possible, the Midsize STP does require correct installation and regular inspections and adjustments to maintain top performance.

1.2 User Benefits

Correct installation and regular maintenance will provide the following benefits for your operation:

- Reduced conveyor downtime
- Reduced man-hour labor
- Lower maintenance costs
- Increased service life for the Midsize Segmented Transfer Plates and other conveyor components

1.3 Service Option

The Midsize Segmented Transfer Plates are designed to be easily installed and serviced by your on-site personnel. However, if you would prefer complete turn-key factory service, please contact your local Flexco Field Engineer or your Flexco Distributor.

Section 2 – Safety Considerations and Precautions

2.1 Intended Use

This product is intended to provide a sliding conveying surface between a discharge roller and a receiving roller of a stationary conveyor system. It is also intended to reduce conveyed product loss between the rollers. The product is intended to fully cover gaps across the assembled segment width. Areas outside of the segment width or other gaps remaining due to conveyor structure / configuration, are to be guarded by the integrator of the product or the owner of the conveyor.

2.2 Stationary Conveyors

Before installing and operating Midsize Segmented Transfer Plates, it is important to review and understand the following safety information. There are set-up, maintenance, and operational activities involving both stationary and operating conveyors. Each case has a safety protocol.

The following activities are performed on stationary conveyors:

- Installation
- Tension adjustments
- Plastic segment replacement
- Cleaning
- Repairs

⚠ DANGER

It is imperative that OSHA Lockout/Tagout (LOTO) regulations, 29 CFR 1910.147, be followed before undertaking the preceding activities. Failure to use LOTO exposes workers to uncontrolled behavior of the Midsize Segmented Transfer Plates caused by movement of the conveyor belt. Severe injury or death can result.

Before working:

- Lockout/Tagout the conveyor power source
- Disengage any takeups
- Clear the conveyor belt or clamp securely in place

⚠ WARNING

Use Personal Protective Equipment (PPE):

- Safety eyewear
- Hardhats
- Safety footwear
- Gloves (especially when welding)
- This product is intended for indoor use only

Close quarters, springs, and heavy components create a worksite that compromises a worker's eyes, feet, and skull. PPE must be worn to control the foreseeable hazards associated with conveyor maintenance. Serious injuries can be avoided.

2.3 Operating Conveyors

There are two routine tasks that must be performed while the conveyor is running:

- Inspection of the Midsize STP performance
- Dynamic troubleshooting

⚠ DANGER

Every Midsize Segmented Transfer Plate is an in-running nip hazard. Never touch or prod an operating Midsize STP. Transfer plate hazards can cause instantaneous amputation and entrapment.

⚠ WARNING

Never adjust anything on an operating Transfer Plate. Unforeseeable belt projections and tears can catch on transfer plates and cause violent movements of the transfer plate segment or structure. Flailing hardware can cause serious injury or death.

⚠ WARNING

Transfer Plate segments can become projectile hazards. Stay as far from the transfer plate as practical and use safety eyewear and headgear. Projectiles can inflict serious injury.

2.4 Transport, Storage, Disposal Conditions of Incorporation - Residual Risk Remaining

This product is not intended to be interacted with by personnel while the conveyor is operating or while in a non-lock out state. Serious injury may occur. Only trained electro-mechanical maintenance staff and conveyor operators are to perform service and installation with the conveyor locked out. During conveyor operation, personnel must not be closer than the distances described in the "Target Interaction Groups" table of 2.4. Alternate conveyor system emergency stop curtains may be implemented within the Conveyor Operating distances shown of table 2.4 at the discretion and risk of the conveyor owner. This does not apply to the General Public or Children- under no circumstances are these two groups allowed near the operating conveyor and Midsize STP system.

All potential draw-in or entanglement hazards & other entanglement opportunities must be addressed in the final integrated system. Residual gaps around Midsize STP segments must be guarded by the system integrator. Risk assessment of the completed system where this product is incorporated must be evaluated. Missing segments must be immediately replaced. The conveyor must be locked out to perform segment replacement. There are no new hazards created as a result of welding this product to the conveyor structure.

Target Interaction Groups

Target Groups	Conveyor Training Level by Conveyor System Owner	Physical Access to Midsize Segmented Transfer Plates	Physical Proximity to Midsize Segmented Transfer Plates During Conveyor Operation
Maintenance Staff	Electro-Mechanical Safety	System Lockout ONLY	> 4 ft
Conveyor Operators	Operational Safety	System Lockout ONLY	> 6 ft
Conveyor Users	Usage Safety	None	> 6 ft
General Public	None	Prohibited	Prohibited
Children	None	Prohibited	Prohibited

Checklist

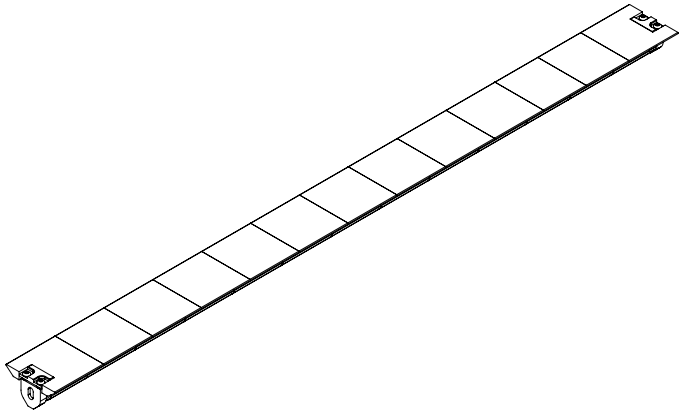
- Check that the Midsize Segmented Transfer Plate size is correct for the beltline width.
- Check the Midsize Segmented Transfer Plate carton and make sure all the parts are included.
- Familiarize yourself with the components.
- Inspect the belt and splice(s) for damage (tears, gouges, raised splices, etc.) that may interfere with Midsize Segmented Transfer Plates.
- Midsize Segmented Transfer Plates are not generally recommended for use on impression cover, textured or cleated belts.
- Determine the material flow or direction of the movement of the belt.
- Determine the type of conveyor you have (S-Curve, Straight, Center Drive, etc).
- Determine the application type (belt to belt, belt to chute, belt to slide, etc).
- Check the conveyor site:
  - Will the Midsize Segmented Transfer Plate be installed on a power turn?
  - Will the drive pulley of the 1st conveyor belt be level with the tail pulley of the 2nd conveyor belt?
  - Will the Midsize Segmented Transfer Plate be welded or fastened to the structure?
  - Is the install on an open head pulley requiring mounting structure?
  - Are there obstructions that may require Midsize Segmented Transfer Plate location adjustments?
  - Will the belt be reversing during regular operation?

CAUTION: All parts of the Midsize Segmented Transfer Plate must be firmly attached to the belt conveyor structure and be properly welded, bolted, or anchored in compliance with your company's policies, specifications, and any applicable legal or regulatory requirements prior to installation and use.

4.1 Installation Instructions for V4 Mounting Bracket

Parts Included in Transfer Plate Kit (Using V4 Bracket):

- Support Bar (1)
- Center Segments
- End Segments (2)
- Mounting Bracket Assemblies (2)
  - Inner Mount (2)
  - Outer Mount (2)
  - Shim (8)
  - Washer (12)
  - Button-Head Socket Cap Screw (2)



Tools Required for Installation:

- Tape Measure
- 1/8" Allen Wrench
- Rubber Mallet
- Marking Pen/Soap Stone
- Hand Held Band Saw or Hack Saw
- Welder
- Thread Locking Agent

Follow site lockout and tag out procedures prior to performing any work on the conveyor system.

Section 4 - Installation Instructions for V4 Mounting Bracket

Typical applications include 2.5" or 3" horizontal transfers where a welded connection is desired or required.

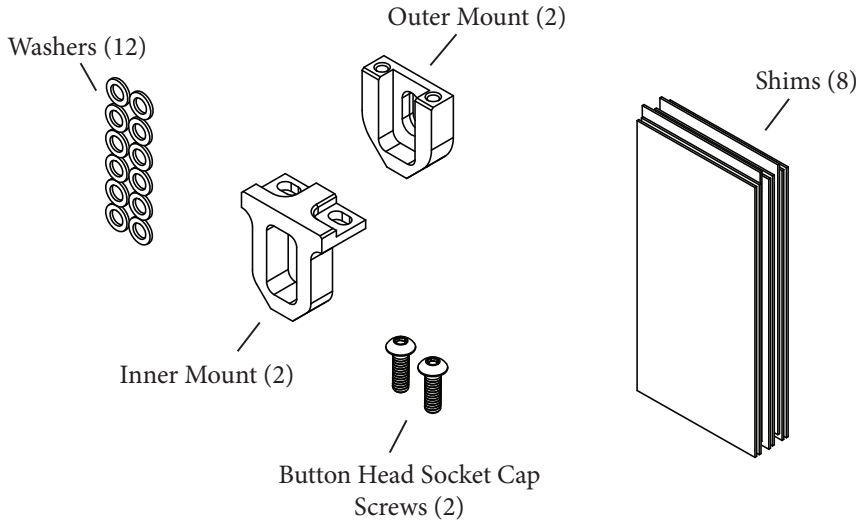
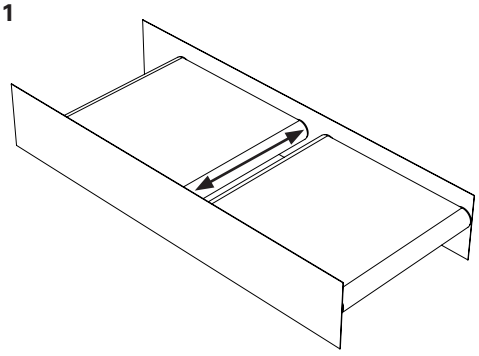


Fig. 1

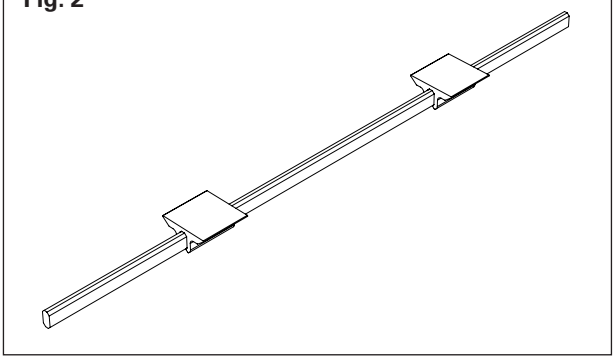


1. Measure internal width of the structure at the desired installation location **(Fig. 1)**.

- If structure is not available to attach mounting brackets, please add the necessary structure to allow for proper installation.

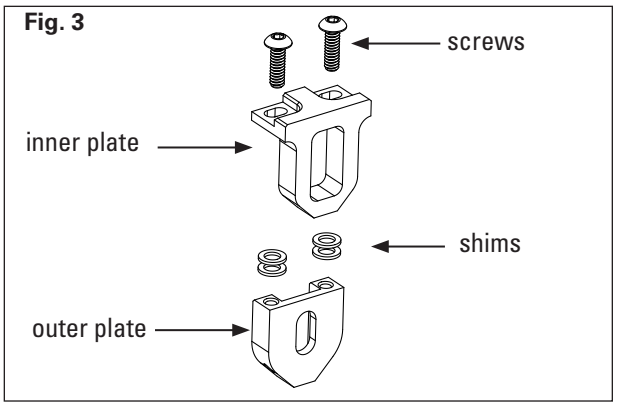
2. Cut the support bar 3/8" (9mm) less than the measured internal width of the structure. Deburr/file any sharp edges.

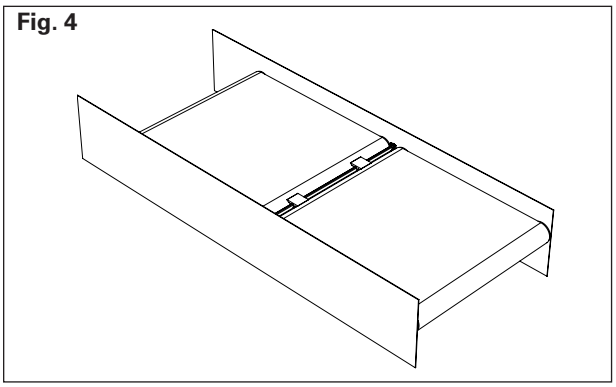
Fig. 2



3. Slide two segments onto the bar from each end and position each approximately 1/4" of the total bar length from the end **(Fig. 2)**.

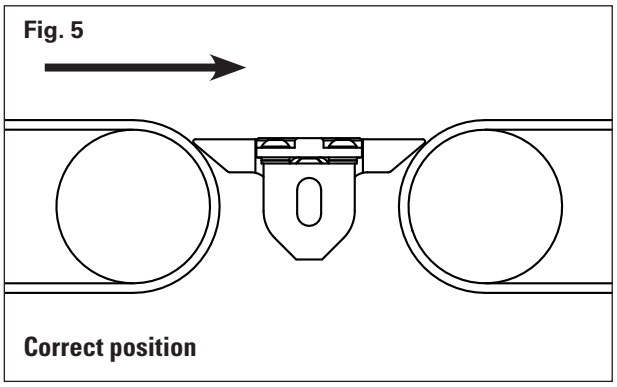
Section 4 - Installation Instructions for V4 Mounting Bracket

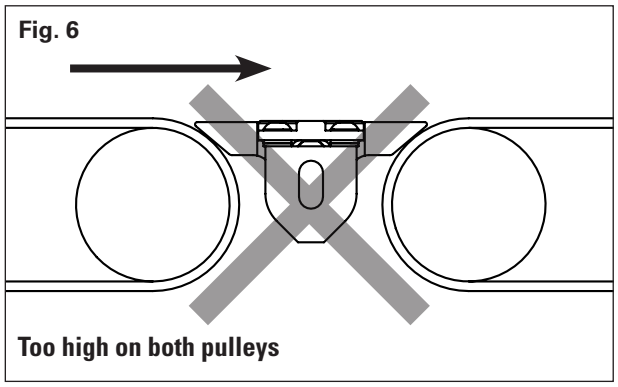




4. Place screws through slots on inner plate. Stack two shim washers on each screw. Using screws attach front plate to the back plate ensuring that the shim washers are in place. Align the edges of the front and back plates so that the vertical edges are parallel. Tighten screws. **(Fig. 3)**.

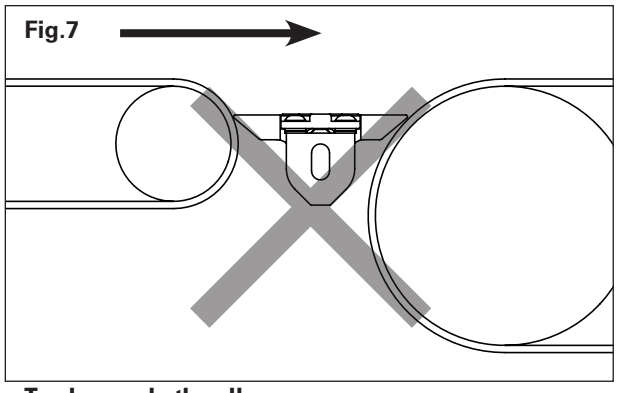
5. Slide one mounting bracket assembly onto each end of the bar. Position the support bar with segments and mounting brackets into the transfer gap. **(Fig. 4)**.





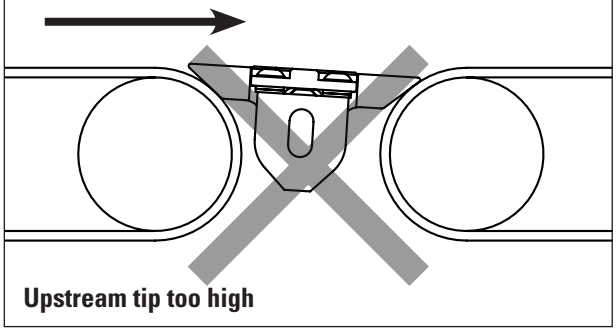
6. Horizontal positioning instructions:

- Locate the point on the top of each pulley where the belt is tangent to the OD of the pulley (where the belt starts to wrap around the pulley). Position the support bar such that the narrow tip of each segment is the same distance below the tangent point on each pulley. This will position the surface of the segment parallel with the belt surfaces. **(Fig. 5)**.
- When the bar is correctly positioned, the surface of the segments should sit approximately 1/8" below the product flow. The segment bevel should be tangent to the pulleys.



Section 4 - Installation Instructions for V4 Mounting Bracket

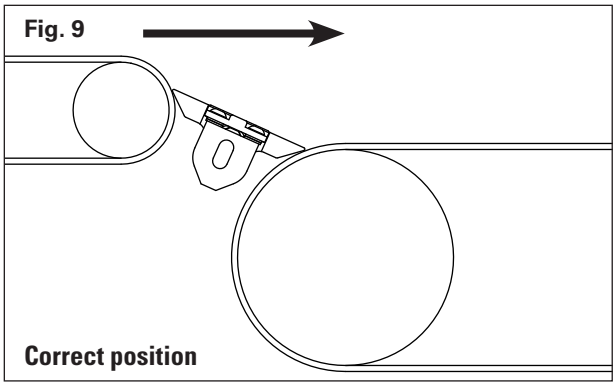
Fig. 8



Upstream tip too high

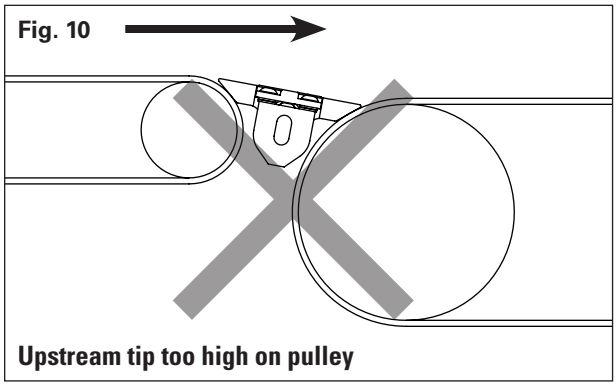
NOTE: The upstream tip of the segment pair should never be at or above the tangent point. This will result in damage to the conveyed product as well as to the guard segments **(Fig. 8)**.

Fig. 9



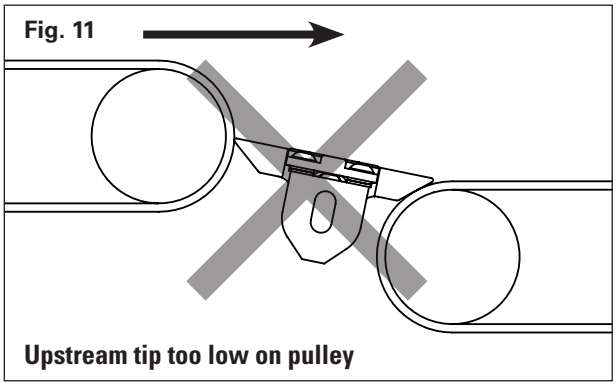
Correct position

Fig. 10



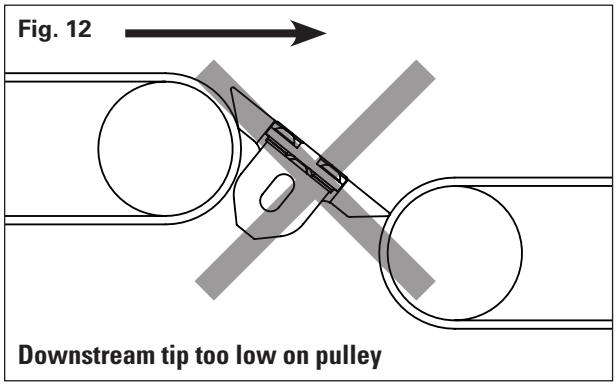
Upstream tip too high on pulley

Fig. 11



Upstream tip too low on pulley

Fig. 12



Downstream tip too low on pulley

Waterfall positioning instructions:

- Position the bar so that the upstream tip of the segments are approximately 1/8" below the product flow and the segment bevel should be tangent to the pulleys. Position the downstream tip at or near the tangent point on the lower pulley. The correct positioning of the upstream tip should take precedence over the positioning of the downstream tip **(Figures 5, 9)**.

NOTE: For installations where one or both of the belts have a profiled top cover, such as Longitudinal Rib (LR), Mini Rough Top (MRT), or Rough Top (RT) belting, the transfer assembly should be positioned with a 0.012" clearance (thickness of a business card) between the surface of the profiled belt and the under-side of segment.

Section 4 - Installation Instructions for V4 Mounting Bracket

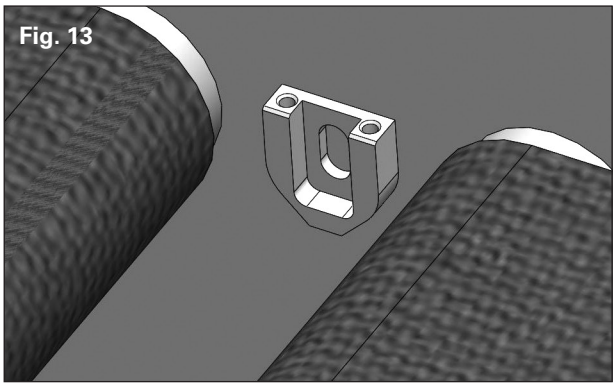


Fig. 13

7. Welding instructions:

- With the assembly in place, tack weld the outer plate onto the structure.

NOTE: Weld bead must be at least 1/4" from the top of the outer plate, as a weld bead may interfere with end segment installation (Fig. 13).

- Verify location after tack weld and adjust as needed.
- Remove the socket head screws from the mounting brackets and lift the assembly out of the transfer leaving only the back plates in place. Taking care not to lose them, ensure that the shim washers are removed with the assembly.
- Finish welding the back plates to the structure.

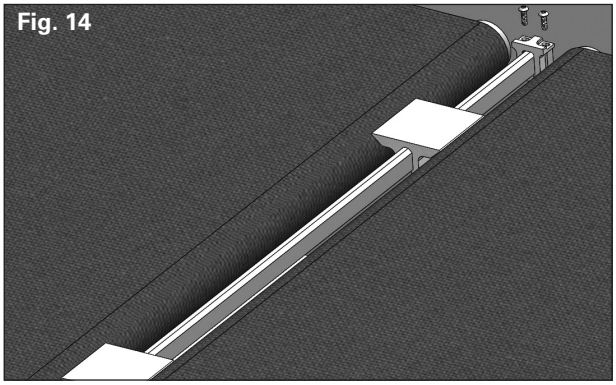


Fig. 14

8. Slide the front plates on the mounting bar, replace the shim washers on the screws and set the bar/segment assembly into position on the mounted outer plates. Tighten the two socket head screws at each mounting bracket to secure the system is in place. **(Fig. 14)**.

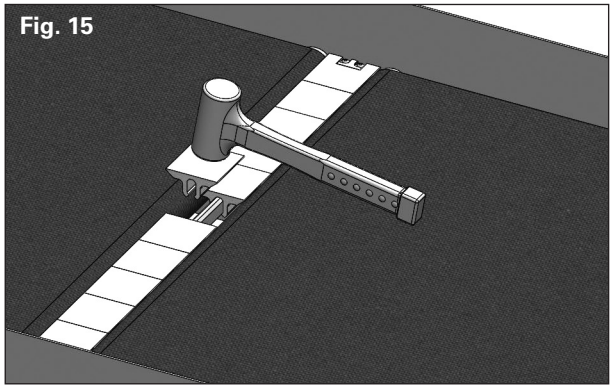
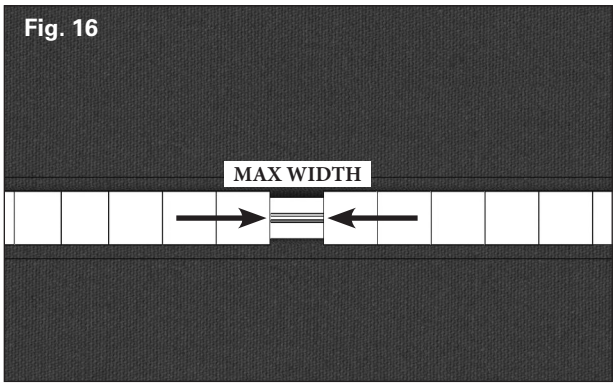


Fig. 15

9. Install as many of the remaining segments on the bar as will fit, with 1 end segment at each end. **(Fig. 15)**.

Fig. 16



10. From the center of the bar, push the segments toward the ends of the bar ensuring that they are tightly butted against each other. Measure the gap that remains between the center most segments to determine the size of the final segment set. **(Fig. 16)**.

- If MAX WIDTH is greater than 1.5" (38mm), use table saw to cut a final segment to 1/16"-1/8" (1.5-3mm) less than MAX WIDTH.
- If MAX WIDTH is less than 1.5" (38mm):

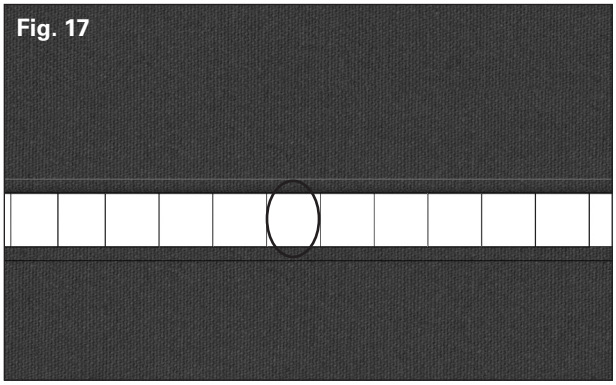
a. Remove one additional segment adjacent to gap.

b. Measure MAX WIDTH opening and divide by 2. (X / 2)

c. Using table saw, cut two final segment pairs 1/16"-1/8" (1.5-3mm) less than MAX WIDTH.

NOTE: Do not trim more than half 1-1/2" (38 mm) off a segment pair.

Fig. 17



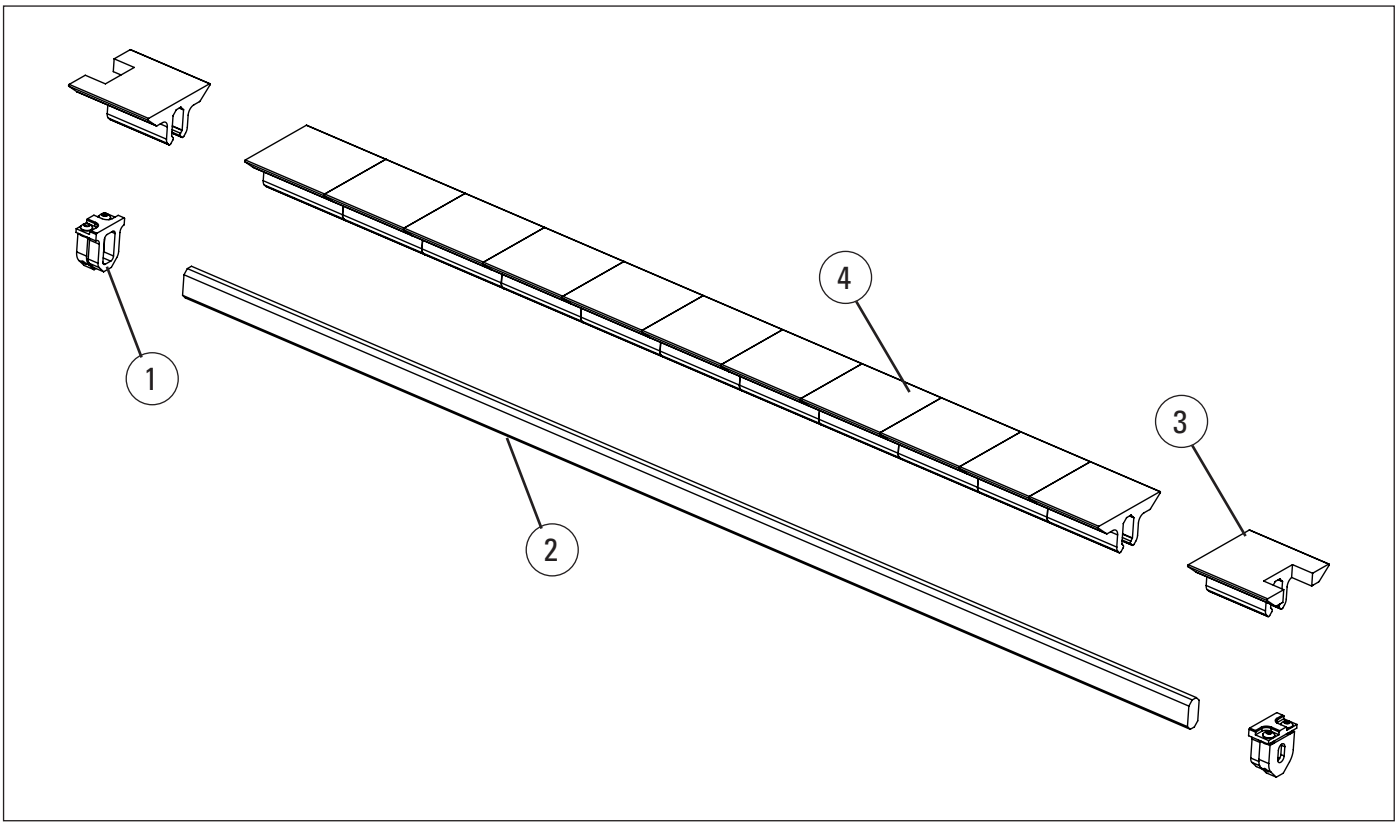
11. Install the last (trimmed) segments into the remaining gap **(Fig. 17).**

12. If support bar does not appear centered in the gap between pulleys, loosen the socket head screws and adjust the transfer. 1/8th inch (3mm) total adjustment is available.

13. By adding or removing shims from the mounting brackets the transfer can be adjusted up or down a total of 1/16th inch (1.5mm). This should allow adequate adjustment for crowned pulleys or belt with a profiled top cover.

14. Once all adjustments are made, secure the screws with a thread locking agent.

Section 4 - Part Numbers for V4 Mounting Bracket



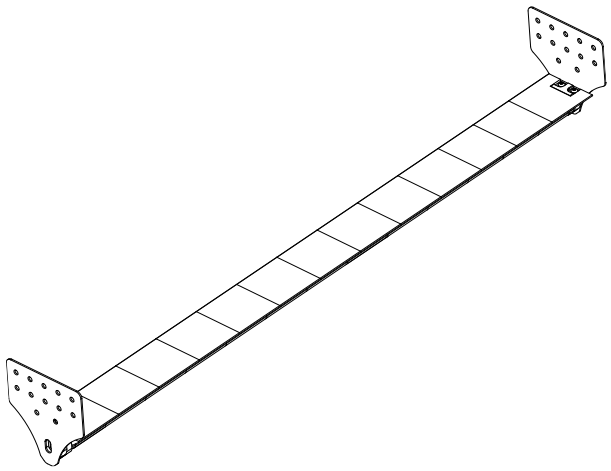
Item	Description	Item Code	Ordering Number
1	Mounting Bracket	56651	STP-MTG-KIT-V4
		56728	STP-MTG-KIT-V4-10PK
2	Support Bars	04341	HITCHGD-V1-SUPPORT-BAR-38IN
		04309	HITCHGD-V1-SUPPORT-BAR-44IN
		04342	HITCHGD-V1-SUPPORT-BAR-50IN
		04310	HITCHGD-V1-SUPPORT-BAR-62IN
		04974	HITCHGD-V1-SUPPORT-BAR-74IN
3	End Segments	56652	STP-SEG-V4-END-3YW
		56698	STP-SEG-V4-END-3YW-24PC
		120586	STP-SEG-V4-END-2.5YW
		120587	STP-SEG-V4-END-2.5YW-24PC
4	Center Segments	04269	HITCHGD-V1-CENTER-SEGMENT-3IN
		115554	HITCHGD-CENTER-SEGMENT-2.5IN

4.2 Installation Instructions for V4 Wide Flange Mounting Bracket

Typical applications include 2.5” or 3” horizontal transfers where a bolted connection is desired or required, and there is little or no access beneath the transfer.

Parts Included in Transfer Plate Kit (Using V4 Wide Flange Bracket):

- Support Bar (1)
- Center Segments
- End Segment (2)
- Mounting Bracket Assemblies (2)
  - Backplate (2)
  - Inner Mount (2)
  - Hex Head Screw (6)
  - Hex Protector (6)
  - Button Head Screw (6)
  - Flange Locknut (6)
  - Button-Head Socket Cap Screw (4)
  - Washer (12)
  - Grip Round Cap (6)
  - Shim (8)

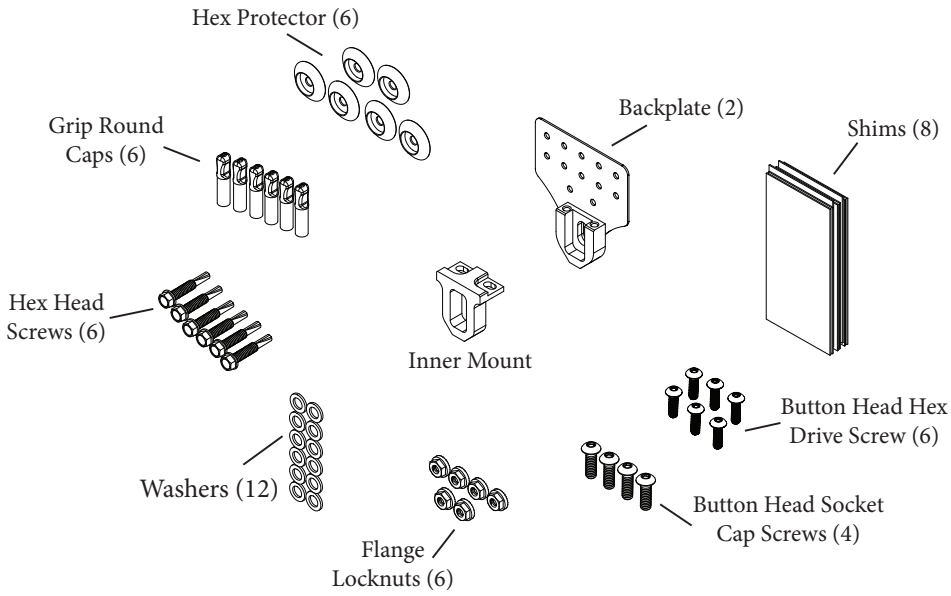


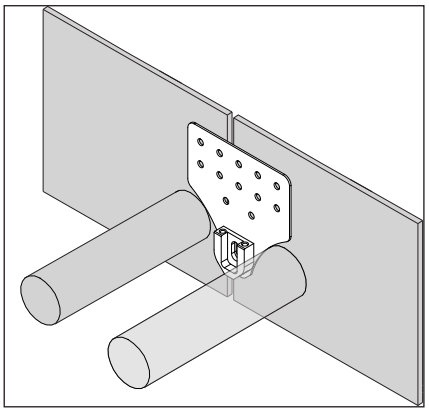
Tools Required for Installation:

- Tape Measure
- 1/8" Allen Wrench
- Rubber Mallet
- Marking Pen/Soap Stone
- Hand Held Band Saw or Hack Saw
- Thread Locking Agent

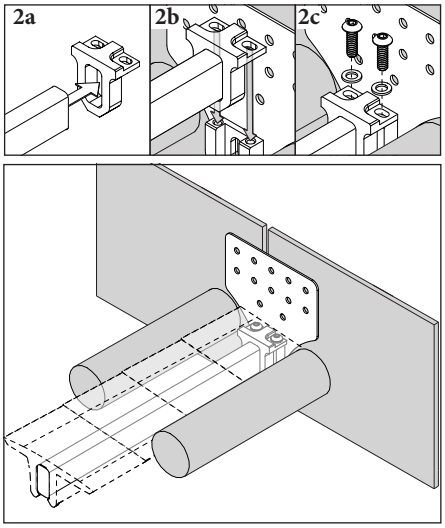
Follow site lockout and tag out procedures prior to performing any work on the conveyor system.

Section 4 - Installation Instructions for V4 Wide Flange Mounting Bracket





1. Identify horizontal transition and ensure area where the bracket will be installed is clear of obstructions. Measure the gap width and trim the support bar 3/8" (9mm) less than the measured internal width of the structure. Deburr/file any sharp edges.

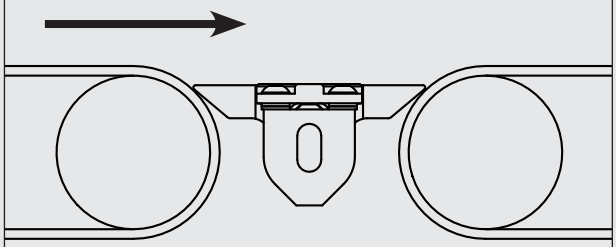


2. Install midsize STP segments along the length of the support bar, trimming segments as necessary. See steps 6-7 for trimming instructions Insert each end of the bar into a bracket. Place the full assembly into the gap, making sure everything is properly aligned between the belts. Ensure the two end segments are installed on the ends. End segments can be identified by their cutout.

Section 4 - Installation Tips for V4 Wide Flange Mounting Bracket

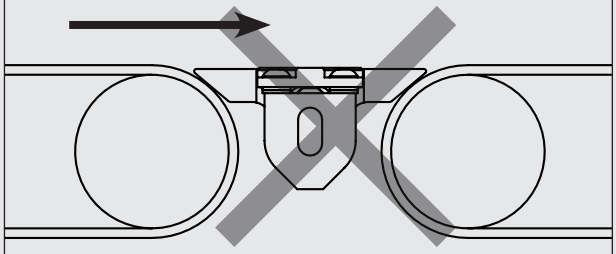
NOTE: Step 2 involves a critical part of the installation process and may require additional attention to detail. The following tips are designed to help streamline this step, ensuring accuracy and efficiency before proceeding to Step 3.

Fig. 1



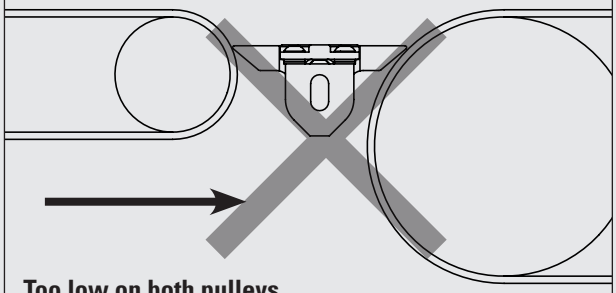
Correct position

Fig. 2



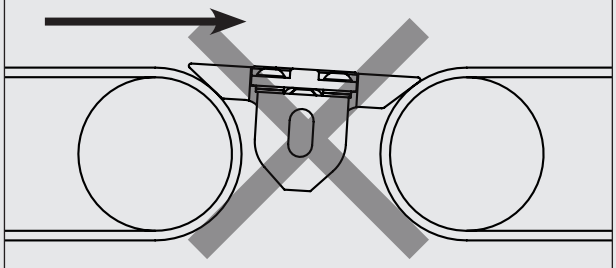
Too high on both pulleys

Fig.3



Too low on both pulleys

Fig. 4

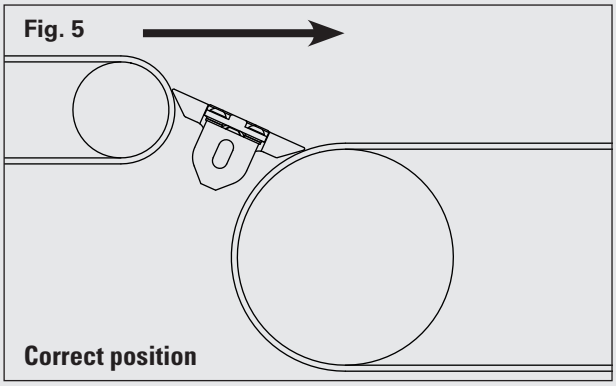


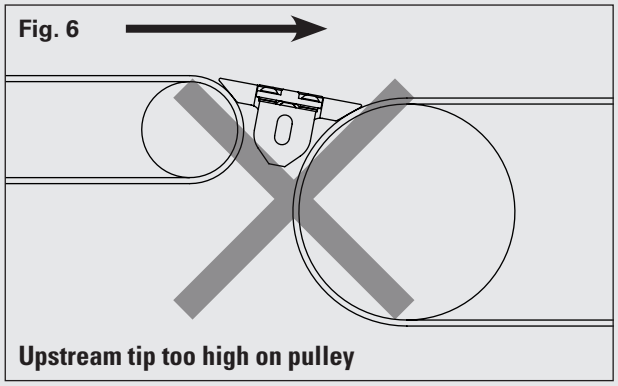
Upstream tip too high

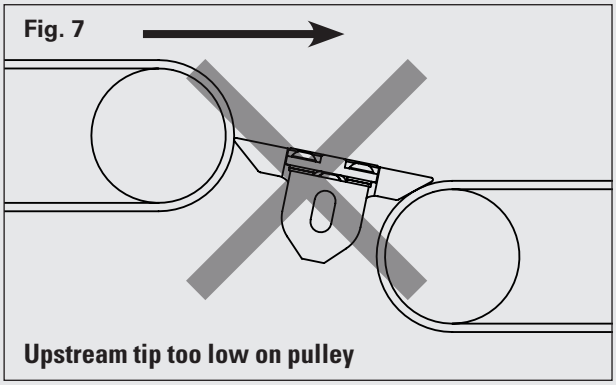
Horizontal positioning instructions:

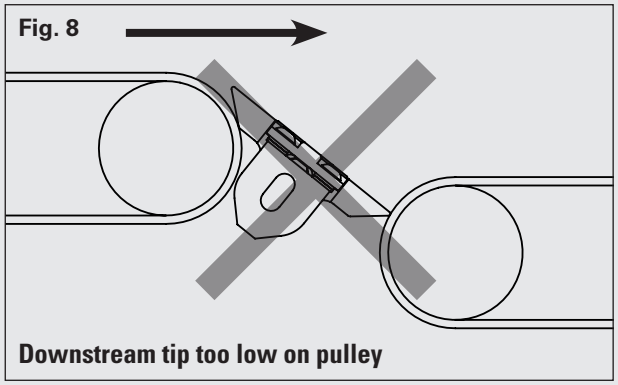
- Position the support bar such that the tip of each segment is the same distance below the top of each pulley. This will position the surface of the segment parallel with the belt surfaces. **(Fig. 1)**.
- When the bar is correctly positioned, the surface of the segment pairs should be approximately 1/8" below the product flow and the segment bevel should be tangent to the pulleys.
- The upstream tip of the segments should never be at or above the tangent point. This will result in damage to the conveyed product as well as to the guard segments **(Fig. 4)**.

Section 4 - Installation Tips for V4 Wide Flange Mounting Bracket





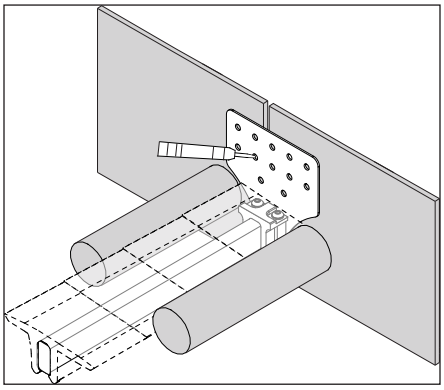




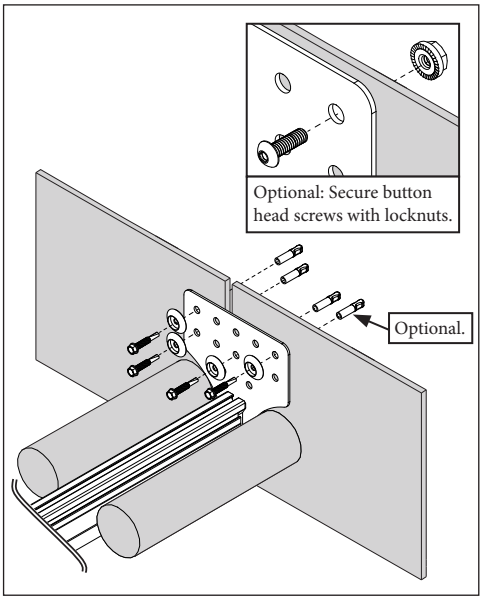
Waterfall positioning instructions:

- Position the bar so that the upstream tip of the segments are approximately 1/8" below the product flow and the segment bevel should be tangent to the pulleys. Position the downstream tip at or near the tangent point on the lower pulley. The correct positioning of the upstream tip should take precedence over the positioning of the downstream tip **(Fig. 5).**

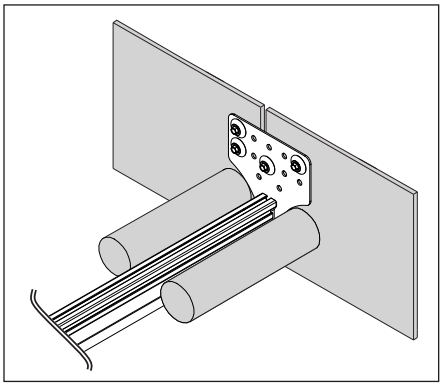
NOTE: For installations where one or both of the belts have a profiled top cover, such as Longitudinal Rib (LR), Mini Rough Top (MRT), or Rough Top (RT) belting, the transfer assembly should be positioned with a 0.012" clearance (thickness of a business card) between the surface of the profiled belt and the under-side of segment.



3. Identify the bracket holes to be used for mounting and verify that there are no interferences behind the structure. Use a center punch to mark to holes and seat the drill bit.

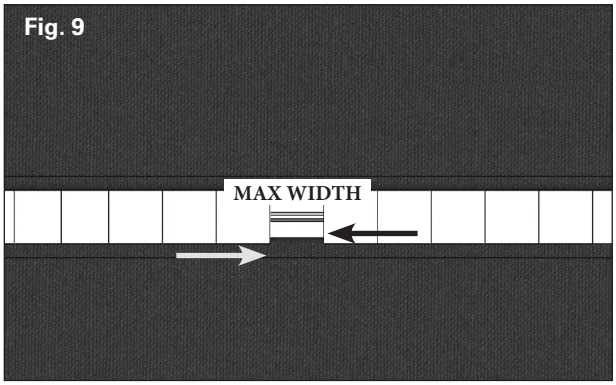


4. Drill the first hole with a 1/8" (3.2mm) drill bit. Fasten the bracket using at least two self-tapping screws and hex head protector washers. Grip round caps are optional. Repeat for additional holes and opposite bracket.



5. Once at least six fasteners (three on each side) are in place and final clearance between belt and segment is confirmed, tighten all fasteners until the bracket seats tight against the conveyor side wall.

Fig. 9



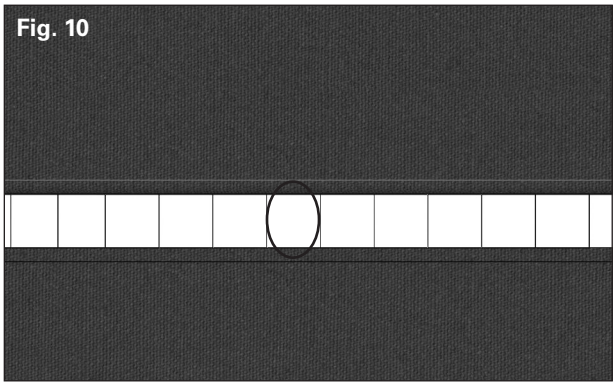
6. From the center of the bar, push the segments toward the ends of the bar ensuring that they are tightly butted against each other. Measure the gap that remains between the centermost segments to determine the size of the final segment set. **(Fig. 9)**.

NOTE: Ensure the end segments are installed at the end positions. End segments can be identified by their cutout.

- If MAX WIDTH is greater than 1.5" (38mm), use table saw to cut a final segment to 1/16"-1/8" (1.5-3mm) less than MAX WIDTH.
- If MAX WIDTH is less than 1.5" (38mm):
  a. Remove one additional segment adjacent to gap.
  b. Measure MAX WIDTH opening and divide by 2. (X / 2)
  c. Using table saw, cut two final segment pairs 1/16"-1/8" (1.5-3mm) less than MAX WIDTH.

NOTE: Do not trim more than half 1-1/2" (38mm) off a segment pair.

Fig. 10



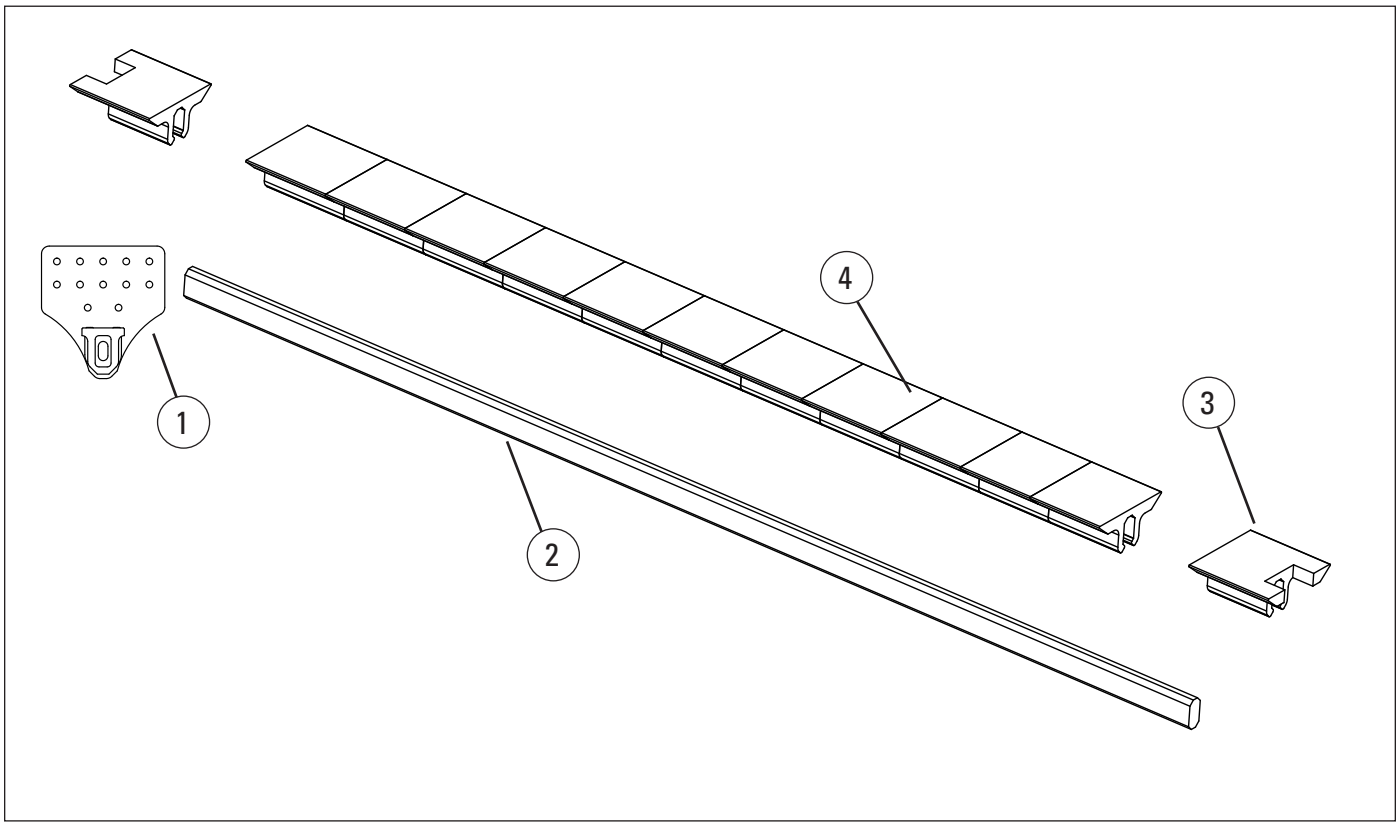
7. Install the last (trimmed) segments into the remaining gap **(Fig. 10).**

8. If support bar does not appear centered in the gap between pulleys, loosen the socket head screws and adjust the transfer. 1/8th inch (3mm) total adjustment is available.

9. By adding or removing shims from the mounting brackets the transfer can be adjusted up or down a total of 1/16th inch (1.5mm). This should allow adequate adjustment for crowned pulleys or belt with a profiled top cover.

10. Once all adjustments are made, secure the screws with a thread locking agent.

Section 4 - Part Numbers for V4 Wide Flange Mounting Bracket



Item	Description	Item Code	Ordering Number
1	Mounting Bracket	111565	STP-MTG-KIT-V4WF
		120585	STP-MTG-KIT-V4WF-10PK
2	Support Bars	04341	HITCHGD-V1-SUPPORT-BAR-38IN
		04309	HITCHGD-V1-SUPPORT-BAR-44IN
		04342	HITCHGD-V1-SUPPORT-BAR-50IN
		04310	HITCHGD-V1-SUPPORT-BAR-62IN
		04974	HITCHGD-V1-SUPPORT-BAR-74IN
3	End Segments	56652	STP-SEG-V4-END-3YW
		56698	STP-SEG-V4-END-3YW-24PC
		120586	STP-SEG-V4-END-2.5YW
		120587	STP-SEG-V4-END-2.5YW-24PC
4	Center Segments	04269	HITCHGD-V1-CENTER-SEGMENT-3IN
		115554	HITCHGD-CENTER-SEGMENT-2.5IN

Section 5 - Pre-Operation Checklist and Testing

5.1 Pre-Op Checklist

- Recheck that all fasteners are tightened properly.
- Check the Midsize STP location on the belt.
- Be sure that all installation materials and tools have been removed from the belt and the conveyor area.

5.2 Test Run the Conveyor

- Run the conveyor for at least 15 minutes and inspect the Midsize STP performance.
- If performance is inadequate, stop the belt and adjust the Midsize STP using steps 12-14 of installation instructions procedure.
- Return to step 5.1 if any adjustments have occurred.

NOTE: Observing the Midsize STP when the conveyor belt is running and performing properly will help detect problems in the future.

Section 6 – Maintenance

Flexco Midsize STPs are designed to operate with minimum maintenance. However, to maintain superior performance, some service is required. When the Midsize STP is installed, a regular maintenance program should be set up. This program will ensure that the Midsize STP operates at optimal efficiency and problems can be identified and fixed before the Midsize STP suffers any damage or stops working as expected.

All safety procedures for inspection of equipment (stationary or operating) must be observed. The Midsize STP operates at the discharge end of the conveyor and is in direct contact with the moving belt. Only visual observations can be made while the belt is running. Service tasks can be done only with the conveyor stopped and the correct lockout/tagout procedures observed.

6.1 New Installation Inspection

After the new Midsize STP has run for a few days, a visual inspection must be made to ensure the Midsize STP is performing properly. Make adjustments as needed. To ensure optimal Midsize STP performance, keep segments free of product buildup (stickers, plastic bags, debris, etc).

6.2 Routine Visual Inspection (every 2-4 weeks)

A visual inspection of the Midsize STP and belt can determine:

- If the belt looks damaged or if there are areas that are eroding.
- If a plastic segment is worn out and needs to be replaced.
- If there is damage to the Midsize STP or other transfer plate components.
- If fugitive material is caught or built up on the segments.
- If there is cover damage to the belt.
- If any worn or damaged components need replacing.
- If there is vibration or bouncing of the STP segments on the belt.

If any of the above conditions exist, a determination should be made on when the conveyor can be stopped for Midsize STP maintenance.

6.3 Routine Physical Inspection (every 6-8 weeks)

When the conveyor is not in operation and is properly locked and tagged out, conduct a physical inspection of the Midsize STP to perform the following tasks:

- Clean material buildup off of the STP segments and bar.
- Closely inspect the segments for wear and damage. Replace if needed.
- Ensure proper segment-to-belt contact.
- Inspect the Midsize STP bar and outer brackets for damage.
- Inspect all fasteners for tightness and wear. Tighten or replace as needed.
- Replace any worn or damaged components.
- When maintenance tasks are completed, test run the conveyor to ensure the Midsize STP is performing properly.

6.4 Cleaning Instructions

Midsize STP plastic segments need to be cleaned of any material stuck to or adhered to the top surface of the segment. If the plastic shows sign of damage or severe erosion, replace the segment.

6.5 STP Wear Inspection

NOTE: Belt type, belt speed, material being conveyed, installation, and other application factors will affect segment wear. Visual inspection of missing segments or fasteners is necessary.

6.6 Disassembly

Disassemble the Midsize Segmented Transfer Plates by unbolting the brackets from the conveyor structure. Separate the components of the bracket(s) and remove the bar from the brackets. Remove the bar and segments from the conveyor structure and pop or slide the segments off of the bar. Follow all local laws and regulations during disposal.

6.6 Maintenance Log

Conveyor Name/No. _____

Date: _____ Work done by: _____ Service Quote #: _____

Activity:_____

Date: _____ Work done by: _____ Service Quote #: _____

Activity:_____

Date: _____ Work done by: _____ Service Quote #: _____

Activity:_____

Date: _____ Work done by: _____ Service Quote #: _____

Activity:_____

Date: _____ Work done by: _____ Service Quote #: _____

Activity:_____

Date: _____ Work done by: _____ Service Quote #: _____

Activity:_____

Date: _____ Work done by: _____ Service Quote #: _____

Activity:_____

Date: _____ Work done by: _____ Service Quote #: _____

Activity:_____

6.7 Midsize STP Maintenance Checklist

Transfer Plate Size: _____ **Ordering Number:** _____

Conveyor Information:

Conveyor Number:_____ Belt Condition: _____

Belt Width: ☐ 12" (300mm) ☐ 18" (450mm) ☐ 24" (600mm) ☐ 30" (750mm) ☐ 36" (900mm) ☐ 42" (1050mm) ☐ 48" (1200mm) ☐ 54" (1350mm) ☐ 60" (1500mm)

Head Pulley Diameter (Belt & Lagging): _____

Belt Speed:_____fpm Belt Thickness: _____

Belt Splice:_____ Condition of Splice:_____ Number of splices:_____ ☐ Skived ☐ Unskived

Material conveyed: _____

Days per week run:_____ Hours per day run:_____

Segment Life:

Date plastic transfer segment installed:_____ Date plastic transfer segment inspected:_____

Estimated plastic transfer segment life:_____

Is segment making proper contact with belt? ☐ Yes ☐ No

Transfer plate condition: ☐ Good ☐ Grooved ☐ Smiled ☐ Not contacting belt ☐ Damaged

Was Midsize STP Adjusted: ☐ Yes ☐ No

Bar Condition: ☐ Good ☐ Bent ☐ Worn

Lagging: ☐ Slide lag ☐ Ceramic ☐ Rubber ☐ Other ☐ None

Condition of lagging: ☐ Good ☐ Bad ☐ Other_____

MIdsize STP Overall Performance: (Rate the following 1 - 5, 1 = very poor - 5 = very good)

Appearance: ☐ Comments: _____

Location: ☐ Comments: _____

Maintenance: ☐ Comments: _____

Performance: ☐ Comments: _____

Other Comments: _____

_____

_____

_____

_____

_____

Section 7 - Troubleshooting

Problem	Possible Cause	Possible Solutions
Missing plastic segments on transfer plate	If a segment is missing, it may mean that foreign object debris got caught between the surface of the belt and the segment.	Replace with a new segment of same size and length
	Damage to belt	Repair the belt
	Improper installation	Transfer plates with a gap between segments and belt as opposed to light contact on both the leading and trailing tips which they are designed for.
	Repeated use of damaged or dislodged segments	Replace with new segments of same size and length
Transfer Plate assembly flexes with movement of belt	High points on belt	Transfer plate was designed to flex with the belt movement
	Roller has uneven wear	Transfer plate was designed to tolerate system wear
	Missing screws from mounting bracket assembly	Install missing fasteners and add removable thread locker
	Pulley out of round	Remove and replace out of round pulley
Mounting screws missing	Not enough removable thread locker added during installation	Replace fastener and add removable thread locker
Excessive Vibration or noise of the Midsize Segmented Transfer Plates	Installation is too tight to the belt	Add shims to mounting bracket to decrease tension between plastic segments and belt
	Installation of Midsize Segmented Transfer Plates was not done with cardboard shims	Add shims to mounting bracket to decrease tension between plastic segments and belt
	Belt fastener hitting transfer plate	High splice profile – does not damage belt or Midsize STP. A bias splice will minimize this effect.
Uneven transfer plate segment position	Mismatch component selection	The transfer plate support bar must be replaced with a correct 1.25" bar
Transfer plates are misaligned	Power turn separation is mismatched with adjacent conveyor	Transfer plate on power turn needs to be installed with a slight angle such that it can accommodate the power turn tapered roller and the adjacent conveyor roller
	Power turn gap to height conveyor is mismatched	Transfer plate on power turn needs to be installed with a slight angle such that it can accommodate the power turn tapered roller and the adjacent conveyor roller
Too high or too low transfer installation	Not enough shims added during installation	Add shims between backing plate and front plate to raise transfer plate
	Too many shims added during installation	Remove shims between backing plate and front plate to lower transfer plate

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