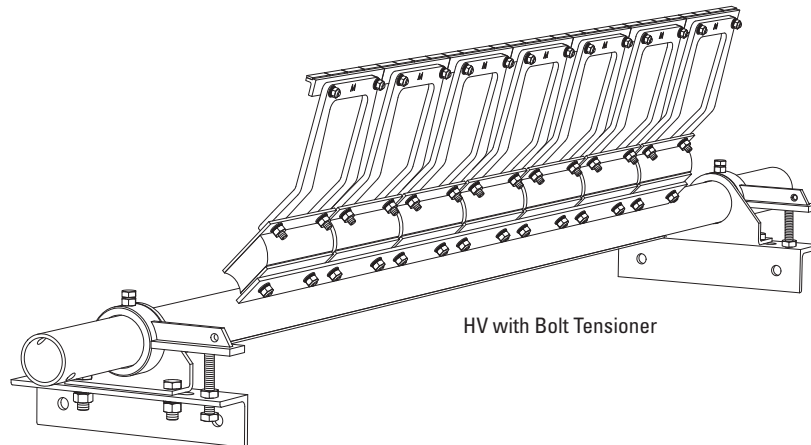
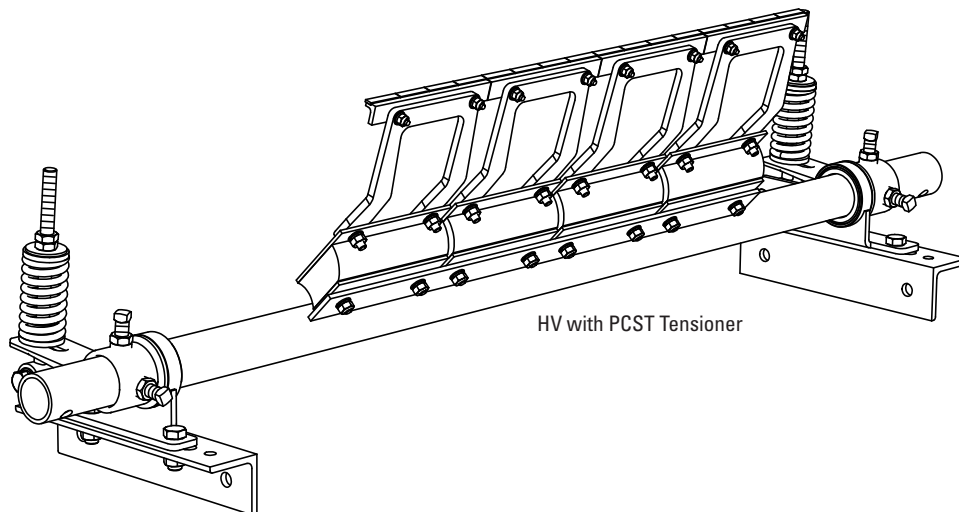


# H-Type<sup>®</sup> Primary Cleaner with V-Tips

## Installation, Operation and Maintenance Manual



HV with Bolt Tensioner



HV with PCST Tensioner

## H-Type® Primary Cleaner with V-Tips

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Purchase Date: \_\_\_\_\_

Purchased From: \_\_\_\_\_

Installation Date: \_\_\_\_\_

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

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# Section 1 – Important Information

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## 1.1 General Introduction

We at Flexco are very pleased that you have selected an H-Type® Primary Cleaner with V-Tips for your conveyor system.

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

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

If, however, you have any questions or problems that are not covered, please visit our web site or contact our Customer Service Department:

**Customer Service: 612-8818-2000**

**Visit [www.flexco.com](http://www.flexco.com) for other Flexco locations and products.**

Please read this manual thoroughly and pass it on to any others who will be directly responsible for installation, operation and maintenance of this cleaner. While we have tried to make the installation and service tasks as easy and simple as possible, **it does however require correct installation and regular inspections and adjustments to maintain top working condition.**

## 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 budget costs
- Increased service life for the belt cleaner and other conveyor components

## 1.3 Service Option

The H-Type Primary Cleaner with V-Tips is 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 Representative.

## Section 2 – Safety Considerations and Precautions

---

Before installing and operating the H-Type® Primary Cleaner with V-Tips, 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.

---

### 2.1 Stationary Conveyors

The following activities are performed on stationary conveyors:

- Installation
- Blade replacement
- Repairs
- Tension adjustments
- Cleaning

#### **DANGER**

It is imperative that Lockout/Tagout (LOTO) regulations, be followed before undertaking the preceding activities. Failure to use LOTO exposes workers to uncontrolled behavior of the belt cleaner 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

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 belt cleaners. Serious injuries can be avoided.

---

### 2.2 Operating Conveyors

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

- Inspection of the cleaning performance
- Dynamic troubleshooting

#### **DANGER**

Every belt cleaner is an in-running nip hazard. Never touch or prod an operating cleaner. Cleaner hazards cause instantaneous amputation and entrapment.

#### **WARNING**

Belt cleaners can become projectile hazards. Stay as far from the cleaner as practical and use safety eyewear and headgear. Missiles can inflict serious injury.

#### **WARNING**

Never adjust anything on an operating cleaner. Unforseeable belt projections and tears can catch on cleaners and cause violent movements of the cleaner structure. Flailing hardware can cause serious injury or death.

## Section 3 – Pre-installation Checks and Options

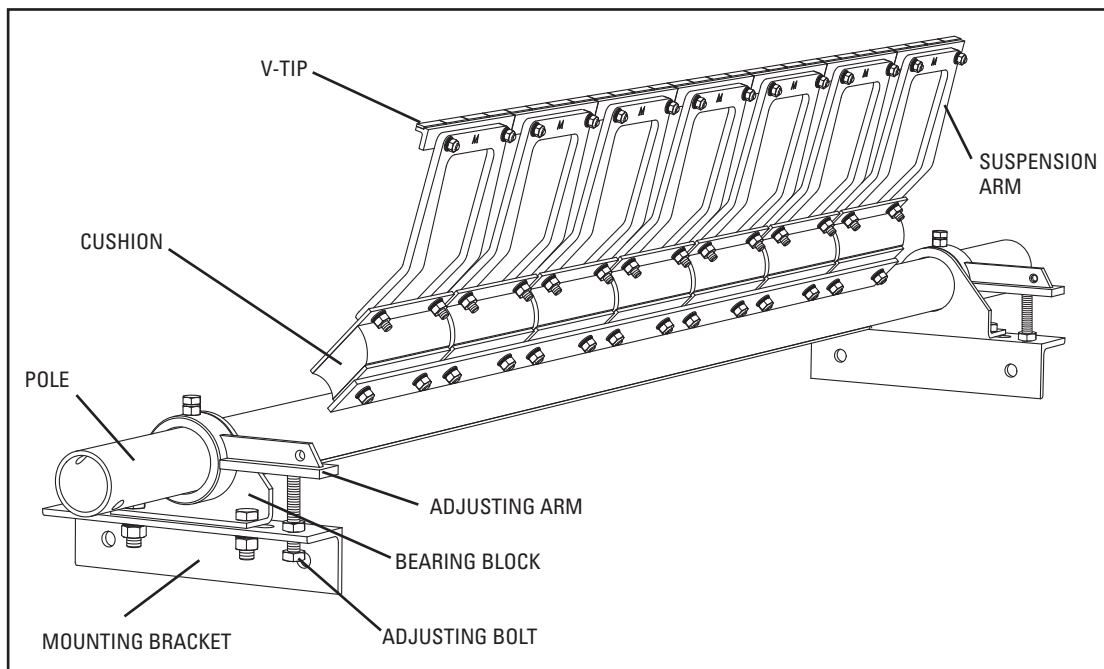
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### 3.1 Checklist

- Check that the cleaner size is correct for the beltline width
- Check the belt cleaner carton and make sure all the parts are included
- Review the “Tools Needed” list on the top of the installation instructions
- Check the conveyor site:
  - Will the cleaner be installed on a chute
  - Is the install on an open head pulley requiring mounting structure
  - Are there obstructions that may require cleaner location adjustments

## Section 4 – Installation Instructions

### 4.1 H-Type<sup>®</sup> Primary Cleaner with V-Tips



***Physically lock out and tag the conveyor at the power source before you begin cleaner installation.***

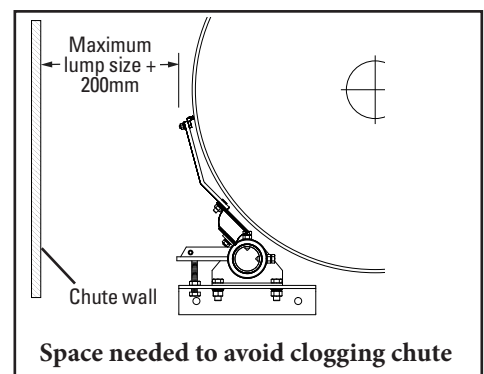
#### Before You Begin:

- Installation specs and instructions are based on the assumption that the conveyor is in its working position (angle). If the conveyor angle will be different, the cleaner should be installed per the final position.
- Choose instructions for chute mounting or open head mounting. For chute mounting it may be necessary to cut an access hole to allow for installation and inspections. (See dimensions in Step 7 under Chute Mounting.)
- Follow all safety precautions when using a cutting torch.
- If welding, protect all fastener threads from weld spatter.

V-Tip Size	Pulley Diameter + Belt and Lagging
SS	up to 499mm
S	500-799mm
M	800-999mm
L	1000-1199mm
LL	1200-1700mm

#### Tools Needed

- Tape Measure
- 19mm Wrench
- Ratchet With 19mm Socket
- Adjustable Wrench
- Cutting Torch and/or Welder
- (2) 150mm C-Clamps (For Temporary Positioning of Mounting Brackets)
- 600mm Level
- Marking Pen



## Section 4 – Installation Instructions

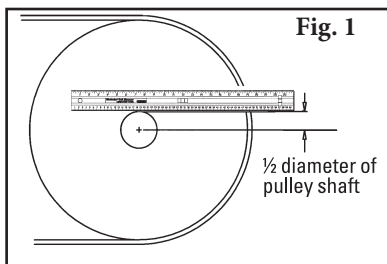
### 4.2a H-Type<sup>®</sup> Primary Cleaner with V-Tips

#### Chute Mounting

1. **Find X and Y measurements.** Find the X and Y measurement specifications for the pulley diameter. See charts on pages 14, 15 and 16. The pulley diameter measurement should include lagging and belt.

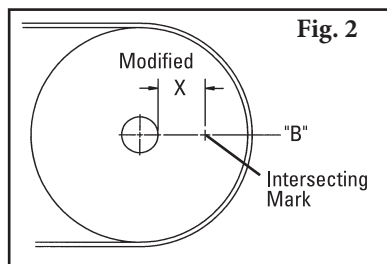
Pulley Diameter \_\_\_\_\_ mm; X = \_\_\_\_\_ mm; Y = \_\_\_\_\_ mm

Using the correct X and Y coordinates will position the cleaner at 15° below the horizontal plane on the head pulley.

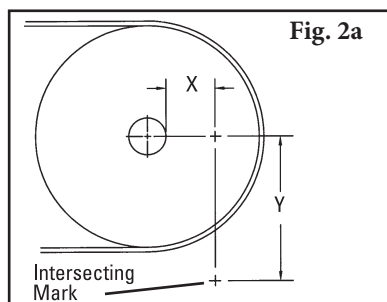


- 2a. **Measure head pulley shaft.** Determine the diameter of the pulley shaft and divide by 2.

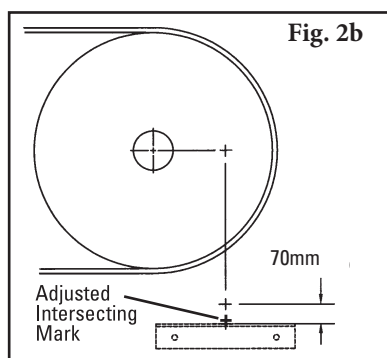
- 2b. **Put a level on top of the pulley shaft and draw a horizontal line A.** Measure down from Line A half the diameter of the pulley shaft and draw Line B parallel from the pulley shaft (Fig. 1).



- 3a. **Mark X dimension.** Subtract the above dimension (Step 2a) from the selected X dimension to establish the modified X dimension. With this new X dimension measure horizontally from the front of the pulley shaft forward on Line B and mark on the chute (Fig. 2).



- 3b. **Determine Y dimension.** From the horizontal X mark, drop a line vertically down to the selected Y dimension and draw an intersecting mark (Fig. 2a). This is the correct position of the centre of the pole.



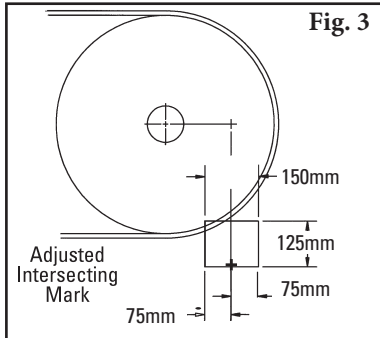
4. **Locate mounting bracket position (horizontal position).** To locate the position of the cleaner mounting bracket, add 70mm to the intersecting mark (Fig. 2b). This mark indicates the top centre of the mounting bracket.



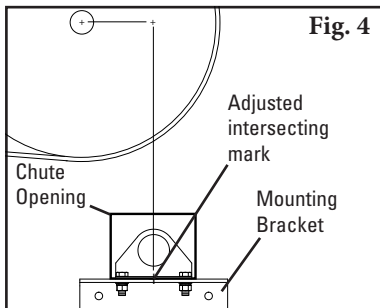
## Section 4 – Installation Instructions

### 4.2a H-Type<sup>®</sup> Primary Cleaner with V-Tips

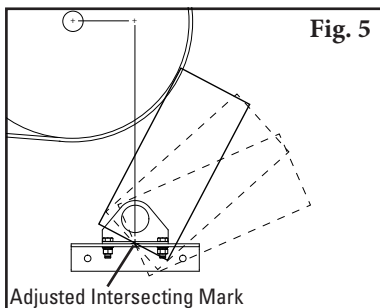
#### Chute Mounting (cont.)



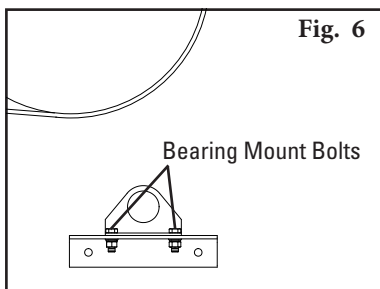
5. **Cut chute opening.** Using the adjusted intersecting mark (“+”) established in Step 4, layout and cut the required opening 125x150mm on the chute (Fig. 3). If access hole is required, see Step 7.



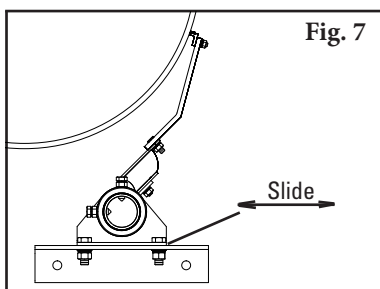
6. **Install the mounting brackets.** Centre the mounting bracket on the bottom of the opening. Bolt or weld in position (Fig 4). Repeat process on opposite side.



7. **Cutting the access hole.** Cut access hole, centreing the bottom edge on the adjusted intersecting mark (“+”) established in Step 4. Width of hole should be 175mm; height should be 325mm for extra small arms, 375mm for small arms, 420mm for medium arms, 450mm for large arms or 555mm for extra large arms. Access hole may be oriented within the range shown (Fig. 5), provided bottom edge is still centred as described above.



8. **Install the pole.** Remove the two bearing mount bolts from one of the bearing mounts (Fig. 6). (If chute mount, remove from the side with access hole.) Slide the pole across the pulley and into the bearing mount on other side and allow tips to hang down. Install the removed bearing mount on the pole and reattach to the mounting bracket. Do not tighten; leave finger tight.



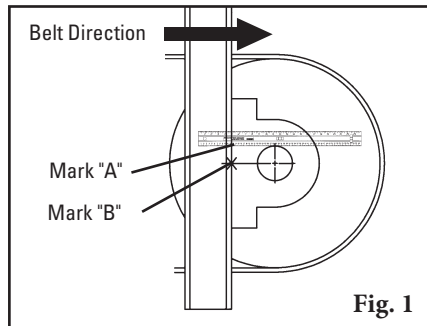
9. **Position the pole.** Rotate pole upward to bring tips into contact with head pulley (Fig. 7). Centre the tips across the belt. While applying light pressure on the centre tip, shift loosened bearing mount until tips are contacting belt evenly across full width. Lock cleaner into this position by tightening bearing mount bolts.

For step-by-step instructions on installing the spring tensioner, refer to page 13.

## Section 4 – Installation Instructions

### 4.2b H-Type® Primary Cleaner with V-Tips

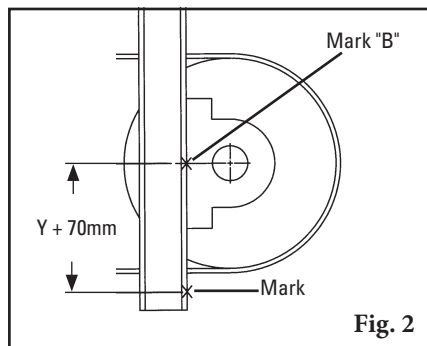
#### Open Head Mounting



1. **Find X and Y measurements.** Find the X and Y measurement specifications for the pulley diameter. See charts on pages 12 and 13. The pulley diameter measurement should include lagging and belt.

Pulley Diameter \_\_\_\_\_ mm X \_\_\_\_\_ mm Y \_\_\_\_\_ mm

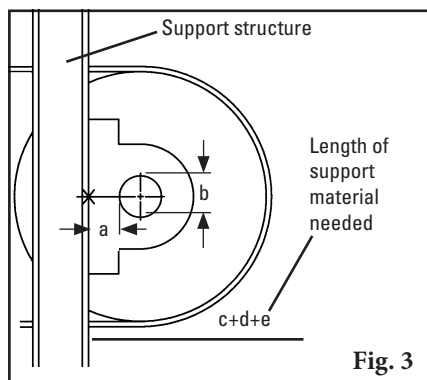
Using the correct X and Y coordinates will position the cleaner at 15° below the horizontal plane on the head pulley.



- 2a. **Locate Y location.** Determine the diameter of the pulley shaft and divide by 2.

- 2b. **Put a level on top of the pulley shaft and mark A at the structure.** Measure down from Mark A half the diameter of the pulley shaft and mark B, locating the shaft centreline (Fig. 1).

- 2c. **Measure down the given Y dimension plus 70mm and mark (Fig. 2).** This mark indicates the top location of support material to be added for installing the cleaner mounting brackets.



a) shaft to structure	_____	+
b) pulley shaft diameter _____ ÷ 2	_____	+
c) pulley shaft centre line to structure	= _____	+
d) add X measurement from chart	_____	+
centre of pole from structure	= _____	
e) add 175mm (half length of mounting bracket)	175mm	+
<b>length of support material needed</b>	= _____	

3. **Locate X location.**

- a.) Measure from the back of the pulley shaft to the support structure (Fig. 3).
- b.) Pulley shaft diameter divided by 2.
- c.) Add dimensions from a) and b). This dimension is the pulley shaft centreline to the support structure.
- d.) Add the given X dimension to c). The sum indicates the distance from the centre of the pole to the support structure.
- e.) Add 175mm (half the length of the mounting bracket). The sum is the total length of support material needed to correctly locate the mounting brackets.

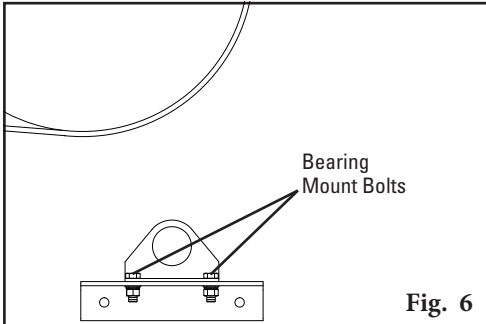
4. **Secure mounting support pieces to the support structure.** Weld support pieces to the support structure. 75x75mm angle works well for these support pieces.

5. **Prepare the support pieces for the cleaner mounting brackets.** Clamp the mounting bracket on the support piece. Mark and drill holes for mounting or weld.

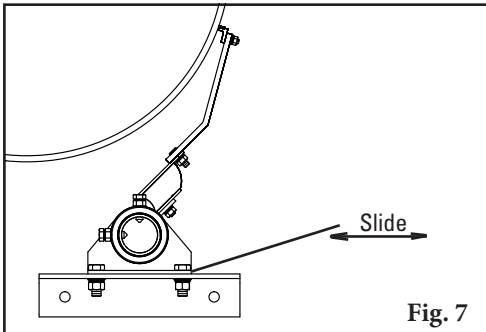
## Section 4 – Installation Instructions

### 4.2b H-Type<sup>®</sup> Primary Cleaner with V-Tips

#### Open Head Mounting (cont.)



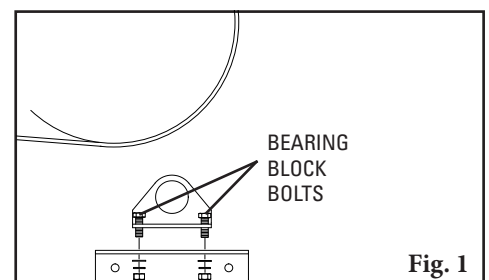
6. **Install the pole.** Remove the two bearing mount bolts from one of the bearing mounts (Fig. 6). (If chute mount, remove from the side with access hole.) Slide the pole across the pulley and into the bearing mount on other side and allow tips to hang down. Install the removed bearing mount on the pole and reattach to the mounting bracket. **NOTE:** Do not tighten; leave finger tight.



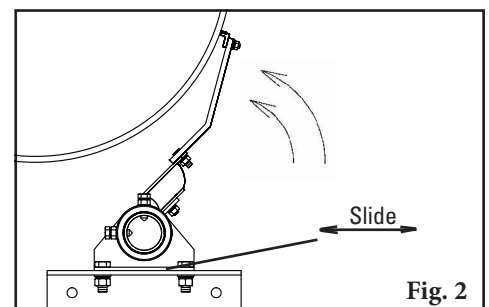
7. **Position the pole.** Rotate pole upward to bring tips into contact with head pulley (Fig. 7). Centre the tips across the belt. While applying light pressure on the centre tip, shift loosened bearing mount until tips are contacting belt evenly across full width. Lock cleaner into this position by tightening bearing mount bolts.

### 4.3 H-Type<sup>®</sup> Primary Cleaner with V-Tips - Bolt Tensioner

1. **Install the pole.** Remove the two bearing block bolts from one of the bearing blocks (Fig. 1). (If chute mount, remove from the side with access hole.) Slide the pole across the pulley and into the bearing block on other side and allow tips to hang down. Install the removed bearing block on the pole and reattach to the mounting bracket. Do not tighten; leave finger tight.



2. **Position the pole.** Rotate pole upward to bring tips into contact with head pulley (Fig. 2). Centre the tips across the belt. While applying light pressure on the centre tip, shift loosened bearing block until tips are contacting belt evenly across full width. Lock cleaner into this position by tightening bearing mount bolts.



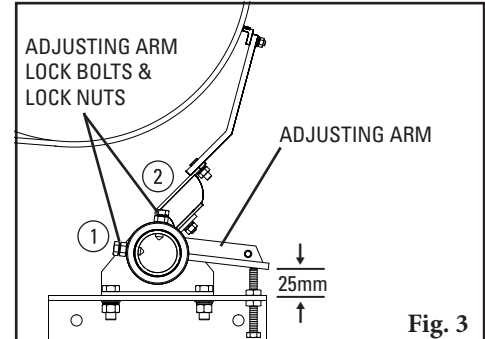
## Section 4 – Installation Instructions

### 4.3 H-Type<sup>®</sup> Primary Cleaner with V-Tips - Bolt Tensioner

#### 3. Install adjusting arms.

**Note:** If using optional spring tensioner, go to separate instructions included in packet.

- Screw adjusting bolts into the welded nut on each mounting bracket (about 25mm above the mounting bracket).
- With pole rotated up, so that all tips contact the head pulley, slide the adjusting arm onto pole, tight against bearing block, resting on the adjusting bolt, pointed away from the head pulley (Fig. 8). Tighten both adjusting arm lock bolts and lock nuts (in the order shown in Fig. 3). Repeat on opposite side.

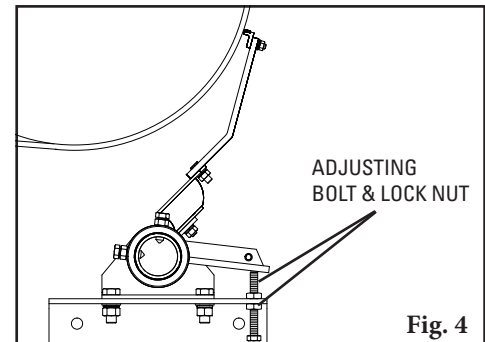


#### 4. Set tip tension.

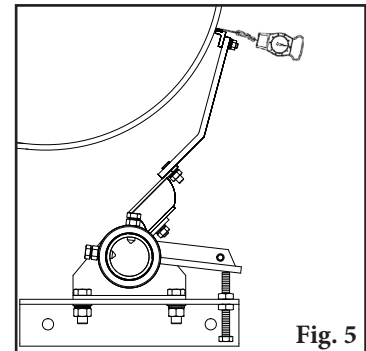
Apply the following tension:

V-Tips -- 1-1/2 turns

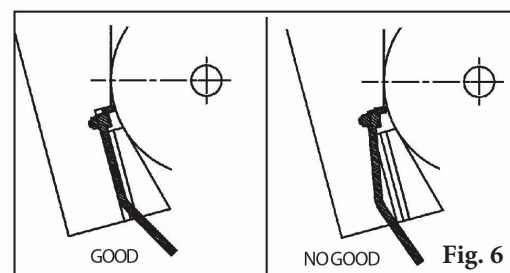
Lock both adjusting bolt lock nuts (Fig. 4).



- Check for correct tip tension.** Place a Tip Tension Gauge between the tip and the belt on the centre tip (or tips) (Fig. 5). While pulling in a straight motion, read the tension required to break contact between the tip and belt. 8kg is recommended. Also check tension on both outer tips. Make tension adjustments if needed.



- Check tip alignment with gauge provided.** Align the gauge against the head pulley and move down until the gauge contacts the top of the blade. The suspension arm should align with lines marked on gauge (Fig. 6). If the alignment is not correct, loosen both bearing block bolts and slide pole to gain correct alignment. Correct one side at a time. Tighten bolts and repeat Step 5.

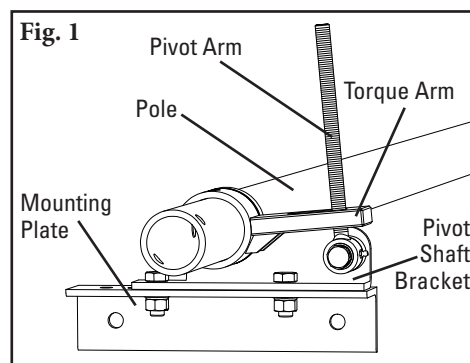


- Test run cleaner and inspect operation.** If vibration occurs or more cleaning efficiency is desired, increase tip tension by making a 1/2 turn on each adjustment bolt.

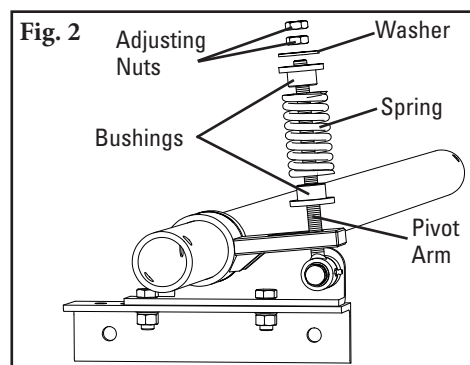
## Section 4 – Installation Instructions

### 4.4 H-Type<sup>®</sup> Primary Cleaner with PCST Tensioner

1. **Install the compression spring tensioner.** Remove the adjusting nuts, bushings and spring from the pivot rod. Insert the pivot arm through the slot in the torque arm. Slide the torque arm onto the pole end (be sure the rotation of the arm is correct to tension the blade).

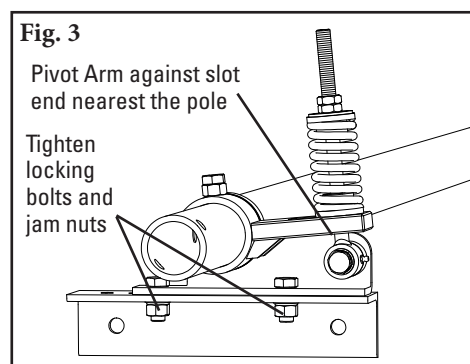


2. **Reassemble the spring assembly.** Slide the spring, washer and bushings onto the pivot arm and turn the two adjusting nuts so about 6mm of the pivot arm is exposed above the nuts (Fig. 2).



3. **Verify your “C” dimension** to insure the pole is in the correct position.

4. **Tension the blades to the belt.** Rotate the blades until they contact the belt. While holding the spring bushing flat on the torque arm, rotate the torque arm until the pivot arm is against the end of the slot nearest the pole. Tighten the locking bolts and jam nuts on the torque arm (Fig. 3). **NOTE:** The torque arm should be up against the mounting plate.



## Section 4 – Installation Instructions

### 4.4 H-Type<sup>®</sup> Primary Cleaner with PCST Tensioner

5. **Set the correct blade tension.** Refer to the charts below for the spring length required for the belt width. Lightly pull the pivot arm toward the end of the torque arm slot nearest the pole and turn the adjusting nuts until the required spring length is achieved (Fig. 4). Lock the top adjusting nut.

**HV Black Spring Length Chart**

Shaded are recommended

Belt Width	SS	S	M	L	LL
600	112	111	110	109	107
800	110	109	107	107	104
1000	108	106	105	104	100
1200	106	104	102	101	97
1400	105	102	100	98	93
1600	103	100	97	96	90
1800	101	97	95	93	—

**HV Gold Spring Length Chart**

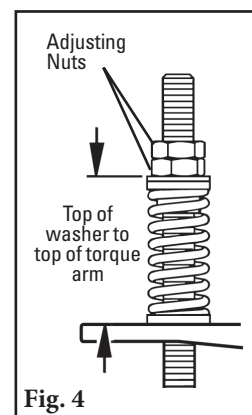
Shaded are recommended

Belt Width	SS	S	M	L	LL
1400	—	108	106	106	103
1600	108	106	105	104	100
1800	107	105	103	102	98
2000	106	104	102	100	96
2200	105	102	100	99	94
2400	104	101	99	97	—
2600	102	99	97	95	—
2800	101	98	95	94	—
3000	100	97	94	—	—
3200	99	95	92	—	—

**HV Silver Spring Length Chart**

Shaded are recommended

Belt Width	SS	S	M	L	LL
2200	—	—	158	157	154
2400	—	158	157	156	152
2600	—	157	156	155	151
2800	—	156	155	154	150
3000	158	155	154	152	148
3200	157	155	153	151	147



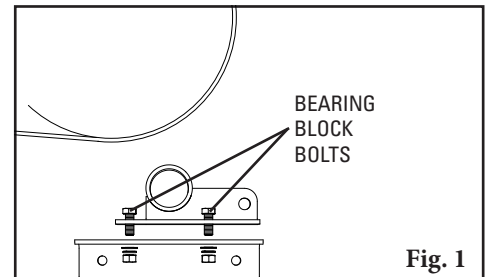
**Fig. 4**

**Test run the cleaner.** Run the conveyor for at least 15 minutes and inspect the cleaning performance. Check the spring length for proper tensioning. Make adjustments as necessary.

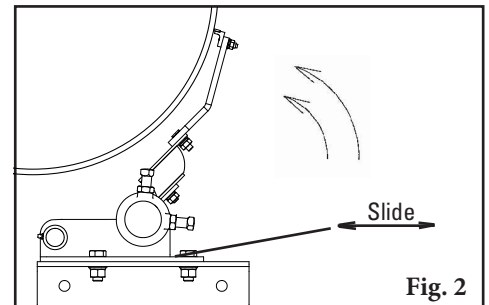
## Section 4 – Installation Instructions

### 4.5 H-Type<sup>®</sup> Primary Cleaner - Bolt Tension

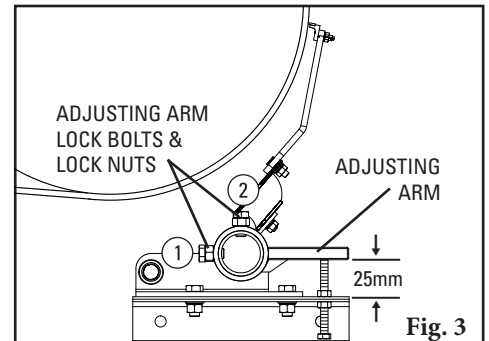
1. **Install the pole.** Remove the two bearing block bolts from one of the bearing blocks (Fig. 1). (If chute mount, remove from the side with access hole.) Slide the pole across the pulley and into the bearing block on other side and allow tips to hang down. Install the removed bearing block on the pole and reattach to the mounting bracket. Do not tighten; leave finger tight.



2. **Position the pole.** Rotate pole upward to bring tips into contact with head pulley (Fig. 2). Centre the tips across the belt. While applying light pressure on the centre tip, shift loosened bearing block until tips are contacting belt evenly across full width. Lock cleaner into this position by tightening bearing mount bolts.

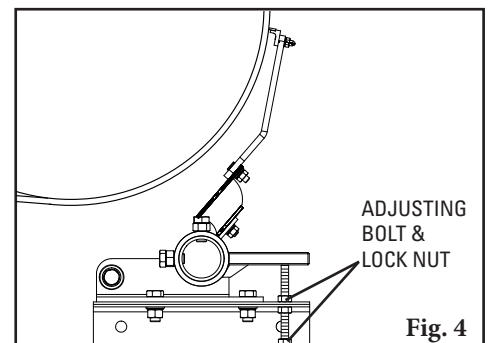


3. **Install adjusting arms.**
  - a. Screw adjusting bolts into the threaded mounting bracket (about 25mm above the mounting bracket).
  - b. With pole rotated up, so that all tips contact the head pulley, slide the adjusting arm onto pole, tight against bearing block, resting on the adjusting bolt, pointed away from the head pulley (Fig. 8). Tighten both adjusting arm lock bolts and lock nuts (in the order shown in Fig. 3). Repeat on opposite side.



4. **Set tip tension.**

Apply the following tension:  
V-Tips — 1-1/2 turns  
Lock both adjusting bolt lock nuts (Fig. 4).



## 4.5 H-Type® Primary Cleaner - Bolt Tension

- 
- Fig. 5**

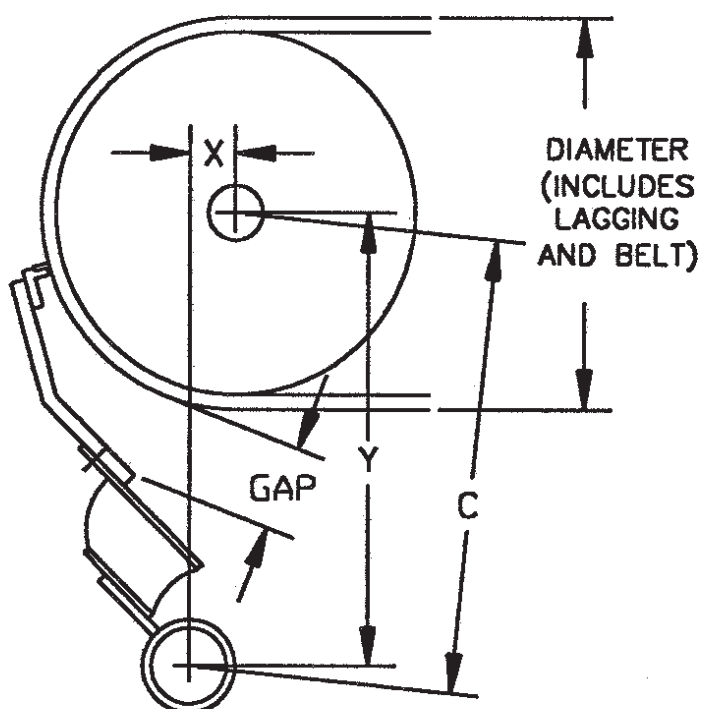
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- ## 16 H-Type® Primary Cleaner with V-Tips



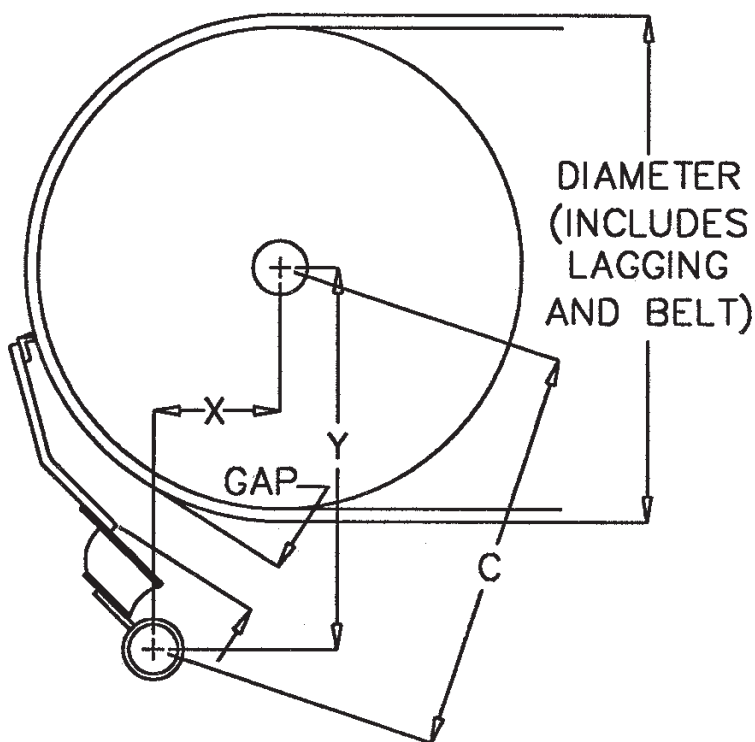
## Section 5 – Cleaner Pole Location Charts

### 5.1 Pole Location Charts



**Extra Small (SS) V-Arms  
for Head Pulley Diameters  
up to 499mm**

Diameter (Over Belt)	X	Y	C	Gap
250	28	292	294	56
275	40	295	298	51
300	52	299	303	46
325	64	302	309	43
350	76	305	315	39
375	88	308	321	36
400	100	312	327	33
425	113	315	334	30
450	125	318	342	28
475	137	321	349	25
500	149	325	357	23
525	161	328	365	22
550	173	331	373	20
575	185	334	382	18

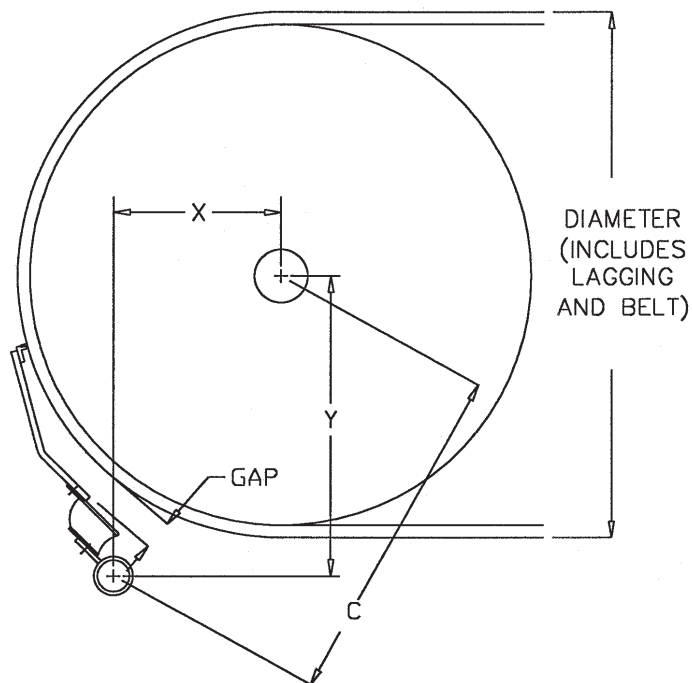


**Small (S) V-Arms  
for Head Pulley Diameters  
500-799mm**

Diameter (Over Belt)	X	Y	C	Gap
350	50	361	365	78
375	62	365	370	73
400	74	368	375	68
425	86	371	381	64
450	98	374	387	60
475	110	377	393	56
500	122	381	400	52
525	134	384	407	49
550	146	387	414	46
575	158	390	421	43
600	171	394	429	40
625	183	397	437	38
650	195	400	445	36
675	207	403	453	33
700	219	407	462	31
725	231	410	470	29
750	243	413	479	27
775	255	416	488	26
800	267	420	497	24
825	279	423	507	23
850	291	426	516	21
875	303	429	526	20
900	315	432	535	18

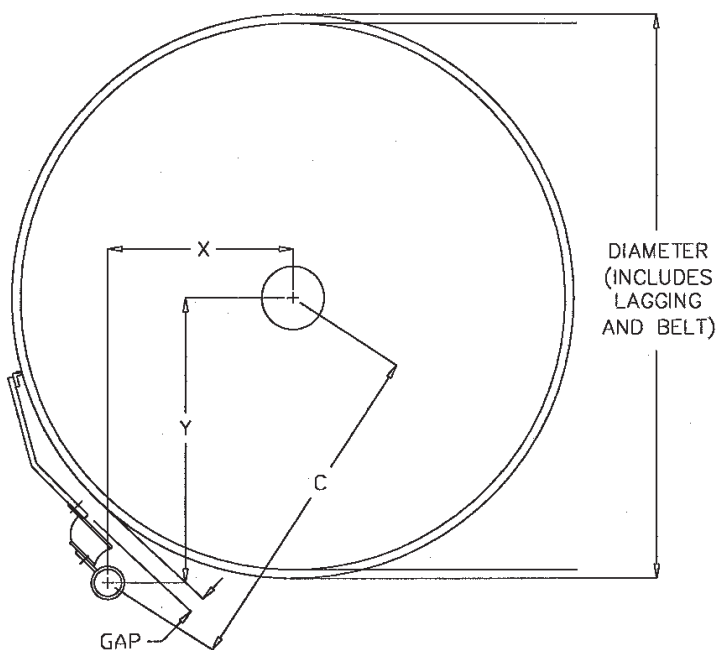
## Section 5 – Cleaner Pole Location Charts

### 5.1 Pole Location Charts (cont.)



**Medium (M) V-Arms  
for Head Pulley Diameters  
800-999mm**

Diameter (Over Belt)	X	Y	C	Gap
650	180	445	480	63
675	192	449	488	60
700	204	452	496	57
725	216	455	504	54
750	228	458	512	54
775	240	462	520	50
800	252	465	529	47
825	264	468	538	45
850	277	471	546	43
875	289	475	555	41
900	301	478	565	39
925	313	481	574	37
950	325	484	583	36
975	337	487	593	34
1000	349	491	602	32
1025	361	494	612	31
1050	373	497	622	29
1075	385	500	632	28
1100	397	504	641	27
1125	409	507	652	26

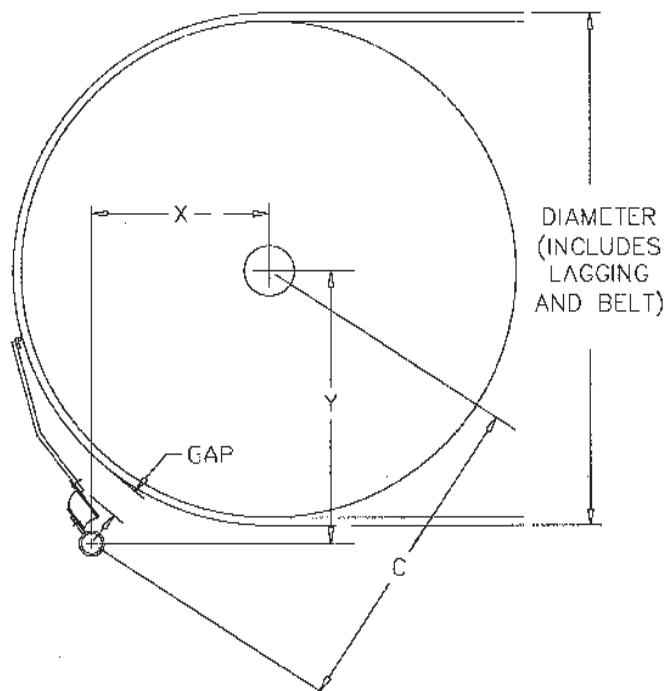


**Large (L) V-Arms  
for Head Pulley Diameters  
1000-1199mm**

Diameter (Over Belt)	X	Y	C	Gap
850	253	494	556	46
875	265	498	564	43
900	278	501	573	41
925	290	504	581	39
950	302	507	590	37
975	314	511	599	35
1000	326	514	608	33
1025	338	517	618	31
1050	350	520	627	29
1075	362	524	637	27
1100	374	527	646	26
1125	386	530	656	24
1150	398	533	666	22
1175	410	537	675	21
1200	422	540	685	20

## Section 5 – Cleaner Pole Location Charts

### 5.1 Pole Location Charts (cont.)



**Extra Large (XL) V-Arms  
for Head Pulley Diameters  
1200-1700mm**

Diameter (Over Belt)	X	Y	C	Gap
1200	414	650	771	79
1225	426	653	780	76
1250	438	657	789	74
1275	450	660	799	72
1300	462	663	808	70
1325	474	666	818	68
1350	486	670	827	66
1375	498	673	837	64
1400	510	676	847	62
1425	522	679	857	60
1450	534	683	867	59
1475	546	686	877	57
1500	558	689	887	55
1525	570	692	897	54
1550	583	695	907	52
1575	595	699	917	51
1600	607	702	928	49
1625	619	705	938	48
1650	631	708	949	47
1675	643	712	959	45
1700	655	715	970	44

## Section 6 – Pre-Operation Checklist and Testing

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### 6.1 Pre-Op Checklist

- Recheck that all fasteners are tightened properly.
- Add pole caps.
- Apply all supplied labels to the cleaner .
- Check the blade location on the belt.
- Be sure that all installation materials and tools have been removed from the belt and the conveyor area.

### 6.2 Test Run the Conveyor

- Run the conveyor for at least 15 minutes and inspect the cleaning performance.
- Check the tensioner spring for recommended length (proper tensioning).
- Make adjustments as necessary.

**NOTE:** Observing the cleaner when it is running and performing properly will help to detect problems or when adjustments are needed later.

## Section 7 – Maintenance

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Flexco belt cleaners are designed to operate with minimum maintenance. However, to maintain superior performance some service is required. When the cleaner is installed a regular maintenance program should be set up. This program will ensure that the cleaner operates at optimal efficiency and problems can be identified and fixed before the cleaner stops working.

All safety procedures for inspection of equipment (stationary or operating) must be observed. The H-Type® Primary Cleaner 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 by observing the correct lockout/tagout procedures.

### 7.1 New Installation Inspection

After the new cleaner has run for a few days a visual inspection should be made to ensure the cleaner is performing properly. Make adjustments as needed.

### 7.2 Routine Visual Inspection (every 2-4 weeks)

A visual inspection of the cleaner and belt can determine:

- If the spring length is the correct length for optimal tensioning.
- If the belt looks clean or if there are areas that are dirty.
- If the blade is worn out and needs to be replaced.
- If there is damage to the blade or other cleaner components.
- If fugitive material is built up on the cleaner or in the transfer area.
- If there is cover damage to the belt.
- If there is vibration or bouncing of the cleaner on the belt.
- If a snub pulley is used, a check should be made for material buildup on the pulley.

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

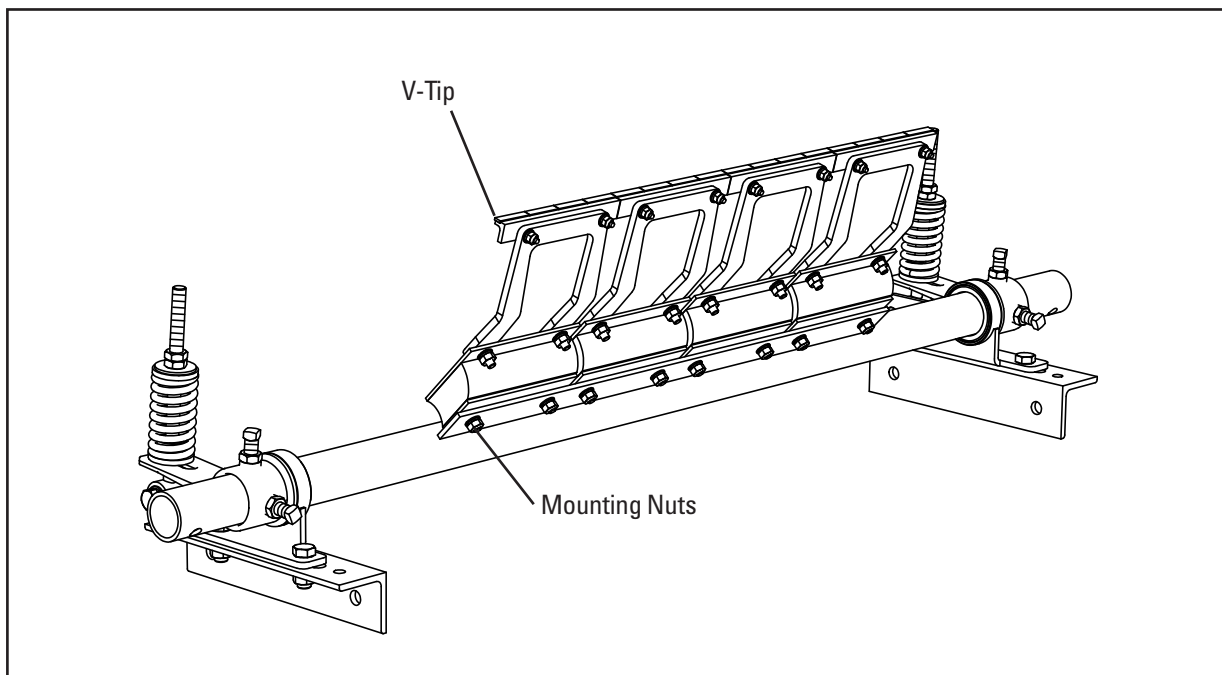
### 7.3 Routine Physical Inspection (every 6-8 weeks)

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

- Clean material buildup off the cleaner blade and pole.
- Closely inspect the blade for wear and any damage. Replace if needed.
- Check both blade pins for proper installation and condition. Replace if needed.
- Ensure full blade to belt contact.
- Inspect the cleaner pole for damage.
- Inspect all fasteners for tightness and wear. Tighten or replace as needed.
- Replace any worn or damaged components.
- Check the tension of the cleaner blade to the belt. Adjust the tension if necessary.
- When maintenance tasks are completed, test run the conveyor to ensure the cleaner is performing properly.

## Section 7 – Maintenance

### 7.4 Blade Replacement Instructions

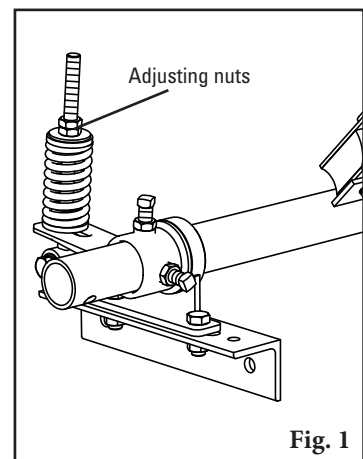


***Physically lock out and tag the conveyor at the power source before you begin cleaner installation.***

#### Tools Needed

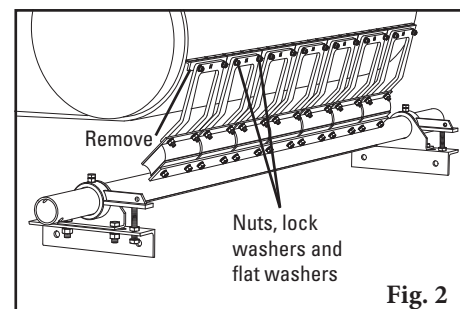
- Tape measure
- (2) 38mm wrenches or crescent wrenches
- (1) 17mm wrench
- Wire brush (for cleaning pole)
- Small putty knife (for cleaning pole)

1. **Remove the tension.** Loosen the adjusting nuts on the mounting bracket/PCST assembly to remove tension from the arm (Fig. 1). This releases the tension of the blade on the belt.



**Fig. 1**

2. **Remove the worn tips.** Remove the nuts on each tip and remove the tips from the cushion (Fig. 2). Clean all fugitive material from the pole. **NOTE:** If tips are hard to remove use a screwdriver or hammer to loosen it and then remove.



**Fig. 2**

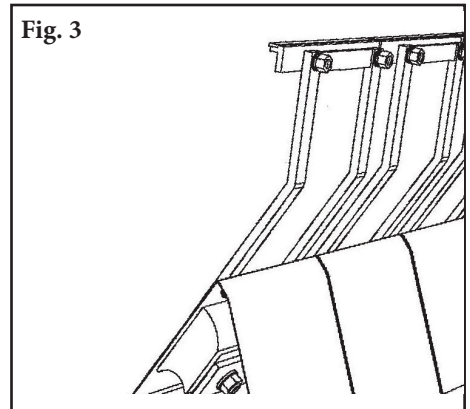
## Section 7 – Maintenance

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### 7.4 Blade Replacement Instructions (cont.)

3. **Install the new tips.** Locate each tip onto each suspension arm, then install the hardware to fasten the tip to the suspension arm (Fig. 3).

**Test run the cleaner.** Run the conveyor for at least 15 minutes and inspect the cleaning performance. Check the spring length for proper tensioning. Make adjustments as necessary.



## Section 7 – Maintenance

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### 7.5 Maintenance Log

Conveyor Name/No. \_\_\_\_\_

Date: \_\_\_\_\_ Work done by: \_\_\_\_\_ Service Quote #: \_\_\_\_\_

Activity: \_\_\_\_\_

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Date: \_\_\_\_\_ Work done by: \_\_\_\_\_ Service Quote #: \_\_\_\_\_

Activity: \_\_\_\_\_

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Date: \_\_\_\_\_ Work done by: \_\_\_\_\_ Service Quote #: \_\_\_\_\_

Activity: \_\_\_\_\_

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Date: \_\_\_\_\_ Work done by: \_\_\_\_\_ Service Quote #: \_\_\_\_\_

Activity: \_\_\_\_\_

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Date: \_\_\_\_\_ Work done by: \_\_\_\_\_ Service Quote #: \_\_\_\_\_

Activity: \_\_\_\_\_

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Date: \_\_\_\_\_ Work done by: \_\_\_\_\_ Service Quote #: \_\_\_\_\_

Activity: \_\_\_\_\_

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Date: \_\_\_\_\_ Work done by: \_\_\_\_\_ Service Quote #: \_\_\_\_\_

Activity: \_\_\_\_\_

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Date: \_\_\_\_\_ Work done by: \_\_\_\_\_ Service Quote #: \_\_\_\_\_

Activity: \_\_\_\_\_

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## Section 7 – Maintenance

### 7.6 Cleaner Maintenance Checklist

Site: \_\_\_\_\_ Inspected by: \_\_\_\_\_ Date: \_\_\_\_\_

Belt Cleaner: \_\_\_\_\_ Serial Number: \_\_\_\_\_

#### Beltline Information:

Beltline Number: \_\_\_\_\_ Belt Condition: \_\_\_\_\_

Belt Width: ☐ 450mm ☐ 600mm ☐ 750mm ☐ 900mm ☐ 1050mm ☐ 1200mm ☐ 1350mm ☐ 1500mm ☐ 1800mm  
(18") (24") (30") (36") (42") (48") (54") (60") (72")

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: \_\_\_\_\_

#### Blade Life:

Date blade installed: \_\_\_\_\_ Date blade inspected: \_\_\_\_\_ Estimated blade life: \_\_\_\_\_

Is blade making complete contact with belt? ☐ Yes ☐ No

Blade wear: Left \_\_\_\_\_ Middle \_\_\_\_\_ Right \_\_\_\_\_

Blade condition: ☐ Good ☐ Grooved ☐ Smiled ☐ Not contacting belt ☐ Damaged

Measurement of spring: Required \_\_\_\_\_ Currently \_\_\_\_\_

Was Cleaner Adjusted: ☐ Yes ☐ No

Pole Condition: ☐ Good ☐ Bent ☐ Worn

Lagging: ☐ Side Lag ☐ Ceramic ☐ Rubber ☐ Other ☐ None

Condition of lagging: ☐ Good ☐ Bad ☐ Other \_\_\_\_\_

Cleaner's Overall Performance: \_\_\_\_\_ (Rate the following 1 - 5, 1= very poor - 5 = very good)

Appearance: ☐ Comments: \_\_\_\_\_

Location: ☐ Comments: \_\_\_\_\_

Maintenance: ☐ Comments: \_\_\_\_\_

Performance: ☐ Comments: \_\_\_\_\_

Other comments \_\_\_\_\_

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## Section 8 – Troubleshooting

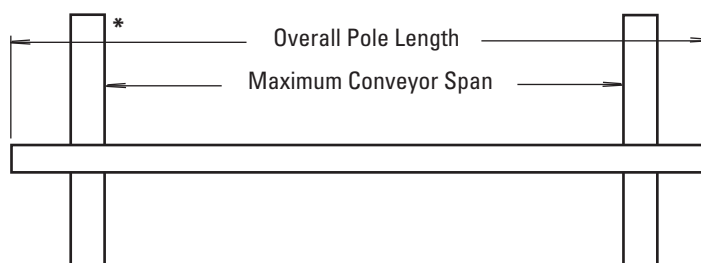
Problem	Possible Cause	Possible Solutions
Poor cleaning performance	Cleaner under-tensioned	Adjust to correct tension – see spring length chart
	Cleaner over-tensioned	Adjust to correct tension – see spring length chart
	Cleaner installed in wrong location	Verify "C" dimension, relocate to correct dimension
	Cleaner blade worn or damaged	Replace cleaner blade
Rapid Blade Wear	Tension on cleaner too high/low	Adjust to correct tension – see spring length chart
	Cleaner not located correctly	Check cleaner location for correct dimensions
	Blade attack angle incorrect	Check cleaner location for correct dimensions
	Material too abrasive for blade	Option: switch to alternate cleaner with metal blades
	Mechanical splice damaging blade	Repair, skive or replace splice
Centre wear on blade (smile effect)	Blade wider than material path	Replace blade with width to match material path
	Tension on cleaner too high/low	Adjust to correct tension – see spring length chart
Unusual wear or damage to blade	Mechanical splice damaging blade	Repair, skive or replace splice
	Belt damaged or ripped	Repair or replace belt
	Cleaner not correctly located	Verify "C" dimension, relocate to correct dimension
	Damage to pulley or pulley lagging	Repair or replace pulley
Vibration or noise	Cleaner not located correctly	Verify "C" dimension, relocate to correct dimension
	Blade attack angle incorrect	Verify "C" dimension, relocate to correct dimension
	Cleaner running on empty belt	Use a spray pole when the belt is empty
	Cleaner tension too high/low	Adjust to correct tension or slight adjust to diminish
	Cleaner locking bolts not secure	Check and tighten all bolts and nuts
	Cleaner not square to head pulley	Verify "C" dimension, relocate to correct dimension
	Material buildup in chute	Clean up build-up on cleaner and in chute
Cleaner being pushed away from pulley	Cleaner tension not set correctly	Ensure correct tension/increase tension slightly
	Sticky material is overburdening cleaner	Increase tension; replace with cleaner with metal tips; replace with larger size cleaner
	Cleaner not set up correctly	Confirm location dimensions are equal on both sides

## Section 9 – Specs and CAD Drawings

### 9.1 Specifications and Guidelines

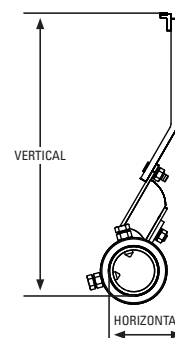
#### Pole Length Specifications\*

Description	Belt Width	Pole Length	Maximum Conveyor Span
	mm	mm	mm
<b>H-Type Pole Standard</b> 60 mm Pole Diameter	450	1250	1000
	600	1350	1100
	750	1500	1250
	900	1650	1400
	1050	1800	1550
	1200	1950	1700
<b>H-Type Pole Standard</b> 73 mm Pole Diameter	1500	2350	2100
	1600	2450	2200
<b>H-Type Pole Heavy-Duty</b> 73 mm Pole Diameter Braced and Gusseted	1800	2650	2400
	2100	2950	2700
	2400	3250	3000
	2600	3450	3200
	3000	3850	3600



#### Clearance Guidelines for Installation

Suspension Arm Size	Horizontal Clearance Required		Vertical Clearance Required	
	mm	in.	mm	in.
SS	175	7	325	12 13/16
S	175	7	375	14 3/4
M	175	7	420	16 9/16
L	175	7	450	17 3/4
LL	175	7	555	21 7/8



#### Specifications:

- Maximum Belt Speed ..... 5m/s
- Temperature Rating ..... -35°C to 204°C
- Usable Blade Wear Length ..... 9mm
- Blade Material ..... Long Life Tungsten Carbide (for vulcanized belts only)
- Available for Belt Widths ..... 450 to 1200mm.

Other sizes available upon request.

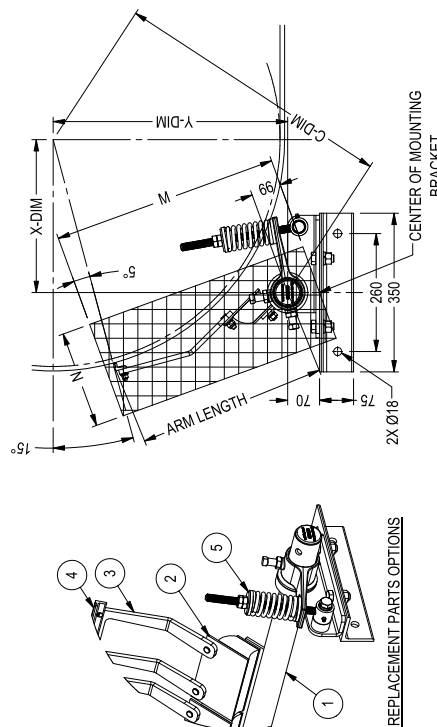
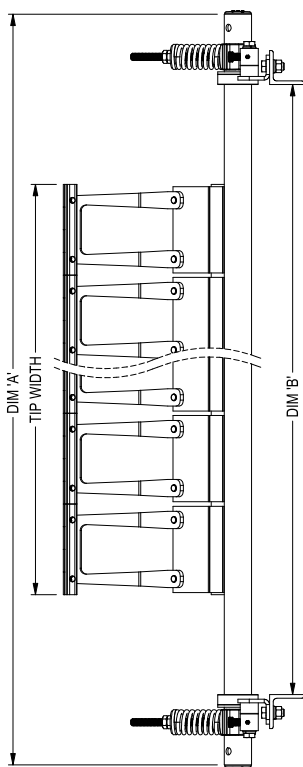
- \* CEMA Cleaner Rating ..... Class 4

# Section 9 – Specs and CAD Drawings

## 9.2 CAD Drawing - Primary Cleaner with V-Tips for Belts up to 1600mm

### GENERAL NOTES:

1. ONLY USE GENUINE FLEXCO REPLACEMENT PARTS. CONTACT YOUR LOCAL DISTRIBUTOR FOR MORE INFORMATION.
2. REFER TO FLEXCO INSTALLATION AND OPERATION MANUAL FOR COMPLETE INSTALLATION INSTRUCTIONS.
3. PANEL CUT DIMENSIONS ARE RECOMMENDATION ONLY, FINAL POSITION AND SIZING TO BE DETERMINED BY DESIGNER.
4. REFER FLEXCO INSTRUCTION MANUAL FOR X, Y, C DIMENSIONS OR CONSULT FLEXCO REPRESENTATIVE FOR CALCULATION.
5. RECOMMENDED TIP ATTACK ANGLE 0° TO 15° AS SHOWN. OTHER IS AT THE DISCRETION OF THE DESIGN ENGINEER AND NOT APPROVED BY FLEXCO ENGINEERING.



REPLACEMENT PARTS OPTIONS

ORDERING INFORMATION AND DIMENSIONS													
Belt Width mm	Arm Size in	Steel			Stainless Steel			Tip Width	Tip Count	Dim 'A'	Dim 'B'		
		Order Code	Item Code	Mass	Order Code	Item Code	Mass				Min.	Max.	
450	SS	HV450SS-PCST	63936	40.0	HV450SS-PCST-S/S	63978	41.2	400	2	1250	500	1000	
	S	HV450S-PCST	63937	40.6	HV450S-PCST-S/S	63979	41.9						
	M	HV450M-PCST	63938	41.1	HV450M-PCST-S/S	63980	42.3						
	LL	HV450LL-PCST	63939	48.1	HV450LL-PCST-S/S	63981	49.5						
600	SS	HV600SS-PCST	63940	48.9	HV600SS-PCST-S/S	63982	50.5	600	3	1350	700	1100	
	S	HV600S-PCST	63941	49.6	HV600S-PCST-S/S	63983	51.2						
	M	HV600M-PCST	63942	49.2	HV600M-PCST-S/S	63984	50.6						
	LL	HV600LL-PCST	63943	50.1	HV600LL-PCST-S/S	63985	51.6						
750	SS	HV750SS-PCST	63944	50.7	HV750SS-PCST-S/S	63986	52.3	600	3	1500	700	1250	
	S	HV750S-PCST	63945	57.6	HV750S-PCST-S/S	63987	59.3						
	M	HV750M-PCST	63946	58.7	HV750M-PCST-S/S	63988	60.6						
	LL	HV750LL-PCST	63947	59.6	HV750LL-PCST-S/S	63989	61.6						
900	SS	HV900SS-PCST	63948	60.1	HV900SS-PCST-S/S	63990	62.2	800	4	1650	900	1400	
	S	HV900S-PCST	63949	66.0	HV900S-PCST-S/S	63991	67.9						
	M	HV900M-PCST	63950	67.4	HV900M-PCST-S/S	63992	69.6						
	LL	HV900LL-PCST	63951	68.5	HV900LL-PCST-S/S	63993	70.8						
1050	SS	HV1050SS-PCST	63952	69.2	HV1050SS-PCST-S/S	63994	71.6	1000	5	1800	1100	1550	
	S	HV1050S-PCST	63953	74.3	HV1050S-PCST-S/S	63995	76.6						
	M	HV1050M-PCST	63954	76.1	HV1050M-PCST-S/S	63996	78.6						
	LL	HV1050LL-PCST	63955	77.3	HV1050LL-PCST-S/S	63997	80.0						
1200	SS	HV1200SS-PCST	63956	78.2	HV1200SS-PCST-S/S	63998	81.0	1200	6	1950	1300	1700	
	S	HV1200S-PCST	63957	92.4	HV1200S-PCST-S/S	63999	95.7						
	M	HV1200M-PCST	63958	93.4	HV1200M-PCST-S/S	64000	96.9						
	LL	HV1200LL-PCST	63959	96.3	HV1200LL-PCST-S/S	64001	100.7						
1500	SS	HV1500SS-PCST	63960	101.0	HV1500SS-PCST-S/S	64002	104.7	1400	7	2350	1500	2100	
	S	HV1500S-PCST	63961	102.2	HV1500S-PCST-S/S	64003	106.1						
	M	HV1500M-PCST	63962	105.5	HV1500M-PCST-S/S	64004	110.3						
	LL	HV1500LL-PCST	63963	108.5	HV1500LL-PCST-S/S	64005	113.3						
OPTIONAL AND REPLACEMENT PARTS													
Item No.	Description	STEEL		STAINLESS STEEL		H-TYPE CLEANER ARM LENGTH							
		Order Code	Item Code	Order Code	Item Code	Cushion	Arm	060	073				
1	H-Type Pole Standard 60mm Pole Diameter	HP450	73027	HP450SS	75373	HSA / HVC-S/S	SSS	230	236				
		HP600	73029	HP600SS	75374		S	278	284				
		HP750	73031	HP750SS	75375		M	385	391				
		HP900	73033	HP900SS	75376		L	415	421				
		HP1050	73035	HP1050SS	75377		LL	523	529				
	H-Type Pole Standard 73mm Pole Diameter	HP1200	73037	HP1200SS	75378	HSHD / HSHD-S/S	SSS	232	238				
		HP1500	73066	HP1500SS	75379		S	280	285				
		HP1600	73739	HP1600SS	75380		M	339	345				
		HSA	73486	HVC-SS	73494		L	387	393				
		HSHD	73483	HSHD-SS	76467		LL	417	423				
2	Cushion												
3	H-Type Suspension Arms	Pulley Dia.				H-Type Panel Cutout							
		Up To 499	SS	HS48SS	73047	Arm Size	'N'	'M'					
		500 To 799	S	HS48S	73048	SS	SS	355					
		800 To 999	M	HS48M	73049	S	S	415					
4	Cleaner Tips	1000 to 1199	L	HS48L	73063	HS48L-S/S	73773	M	175				
		1200 to 1700	LL	HS48LL	73064	HS48LL-S/S	74033	L	465				
		1700 to 1900	LL	HS48LL	73064	HV78-S/S	74033	L	500				
		1900 to 2100	LL	HS48LL	73064	HVPT-S/S	73631	LL	605				
5	Compression Spring Tensioner PCST	Pole Size				H-Type Panel Cutout							
		ø60mm	Black	62747	H60CSK-B-S/S	62748							
		ø60mm	Gold	62741	H60CSK-G-S/S	62742							
		ø60mm	Black	62749	H73CSK-B-S/S	62750							
6	Compression Spring Tensioner PCST	ø73mm	Gold	62743	H73CSK-G-S/S	62744							
		ø73mm	Silver	62745	H73CSK-S-S/S	62746							
		ø73mm	Black	62747	H60CSK-B-S/S	62748							
		ø73mm	Gold	62749	H73CSK-G-S/S	62750							

## 9.2 CAD Drawing - Primary Cleaner with V-Tips for Belts over 1800mm

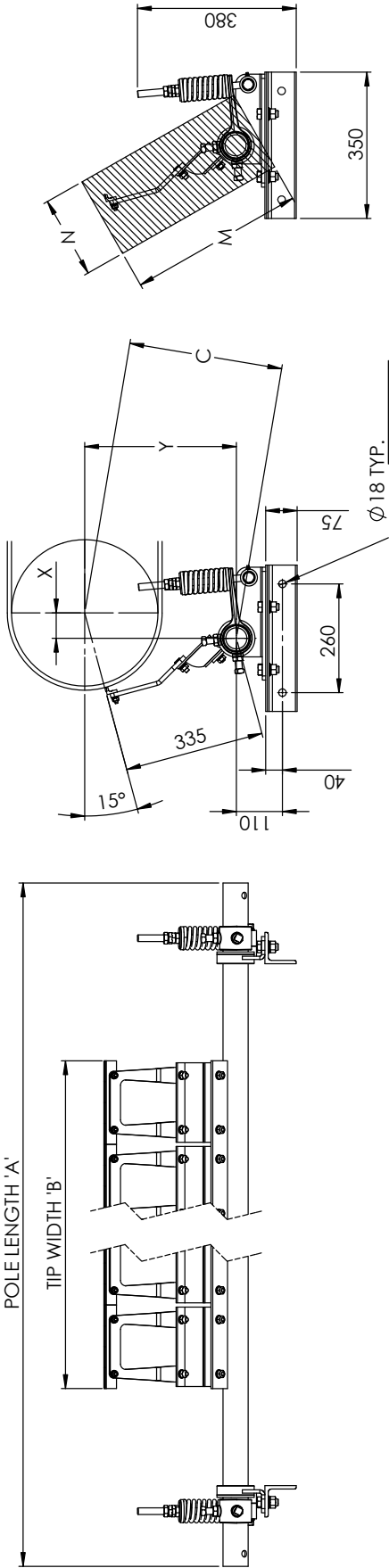
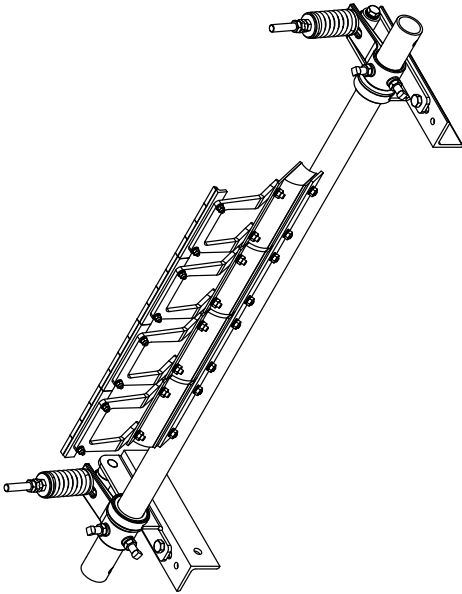
## REPLACEMENT PARTS OPTIONS

Section 9 – Specs and CAD Drawings

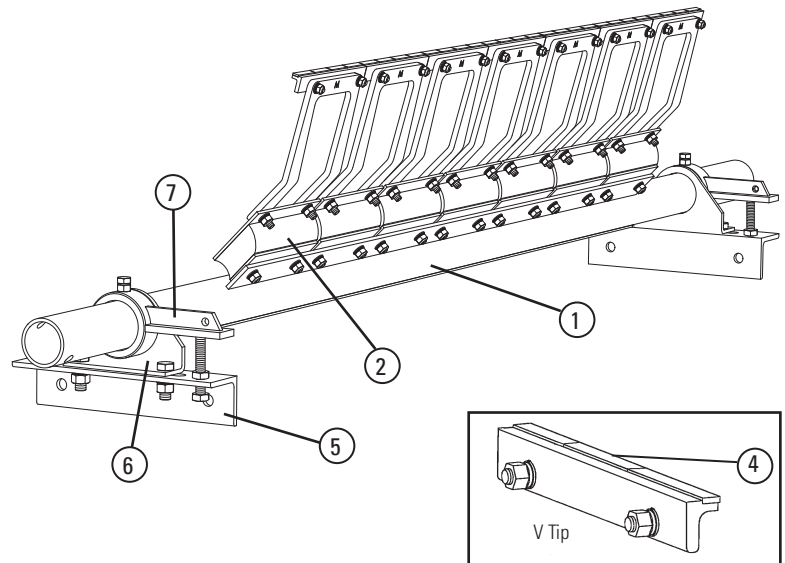
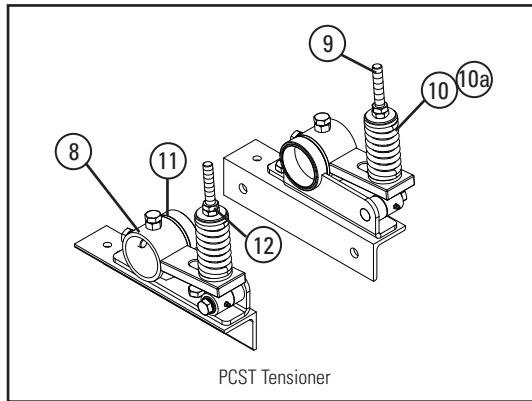
9.2 CAD Drawing - H-Type® Primary Cleaner with PCST Tensioner

BELT WIDTH M	AR SIZE	MILD STEEL		STAINLESS STEEL	
		ORDER NO.	ITEM CODE	ORDER NO.	ITEM CODE
450	SS	HV450SS-PCST	63934	HV450SS-PCST-S/S	63978
	S	HV450S-PCST	63937	HV450S-PCST-S/S	63979
	M	HV450M-PCST	63938	HV450M-PCST-S/S	63980
	L	HV450L-PCST	63939	HV450L-PCST-S/S	63981
600	S	HV600S-PCST	63940	HV600S-PCST-S/S	63982
	M	HV600M-PCST	63941	HV600M-PCST-S/S	63983
	SS	HV600SS-PCST	63942	HV600SS-PCST-S/S	63984
	L	HV600L-PCST	63943	HV600L-PCST-S/S	63985
750	S	HV750S-PCST	63944	HV750S-PCST-S/S	63986
	M	HV750M-PCST	63945	HV750M-PCST-S/S	63987
	SS	HV750SS-PCST	63946	HV750SS-PCST-S/S	63988
	L	HV750L-PCST	63947	HV750L-PCST-S/S	63989
900	S	HV900S-PCST	63948	HV900S-PCST-S/S	63990
	M	HV900M-PCST	63949	HV900M-PCST-S/S	63991
	SS	HV900SS-PCST	63950	HV900SS-PCST-S/S	63992
	L	HV900L-PCST	63951	HV900L-PCST-S/S	63993
1050	S	HV1050S-PCST	63952	HV1050S-PCST-S/S	63994
	M	HV1050M-PCST	63953	HV1050M-PCST-S/S	63995
	SS	HV1050SS-PCST	63954	HV1050SS-PCST-S/S	63996
	L	HV1050L-PCST	63955	HV1050L-PCST-S/S	63997
1200	S	HV1200S-PCST	63956	HV1200S-PCST-S/S	63998
	M	HV1200M-PCST	63957	HV1200M-PCST-S/S	63999
	SS	HV1200SS-PCST	63958	HV1200SS-PCST-S/S	64000
	L	HV1200L-PCST	63959	HV1200L-PCST-S/S	64001
1500	S	HV1500S-PCST	63960	HV1500S-PCST-S/S	64002
	M	HV1500M-PCST	63961	HV1500M-PCST-S/S	64003
	SS	HV1500SS-PCST	63962	HV1500SS-PCST-S/S	64004
	L	HV1500L-PCST	63963	HV1500L-PCST-S/S	64005

\*\*FOR LARGER SIZES PLEASE CONTACT FLEXCO



## Section 10 – Replacement Parts List



REPLACEMENT PARTS				POWDER COATED			STAINLESS STEEL	
REF	DESCRIPTION	BELT WIDTH	POLE LENGTH	ORDERING NUMBER	ITEM CODE	WT. KGS.	ORDERING NUMBER	ITEM CODE
1	H-Type Pole Standard-60 mm Pole Diameter	450	1250	HP450	73027	10.0	HP450-S/S	75373
		600	1350	HP600	73029	11.0	HP600-S/S	75374
		750	1500	HP750	73031	13.0	HP750-S/S	75375
		900	1650	HP900	73033	15.0	HP900-S/S	75376
		1050	1800	HP1050	73035	20.0	HP1050-S/S	75377
	H-Type Pole Standard-73 mm Pole Diameter	1200	1950	HP1200	73037	22.0	HP1200-S/S	75378
		1500	2350	HP1500	73066	24.0	HP1500-S/S	75379
	H-Type Pole Heavy-Duty-73 mm Pole Diameter Braced and Gussetted	1600	2450	HP1600	73739	27.0	HP1600-S/S	75380
		1800	2650	HPHD1800	74601	34.0	HPHD1800-S/S	A2063
		2100	2950	HPHD2100	74547	39.0	HPHD2100-S/S	A1783
		2400	3250	HPHD2400	74548	43.5	HPHD2400-S/S	A2958
2	Cushion			HSA	73486	2.0	HVC-S/S	73494
	Heavy-Duty Cushion			HSHD	73483	2.0	HSHS-S/S	76467
-	H Polyshield (Not shown)			HPS8	73050	1.0	HSTSS	74771
4	V-Tip			HSA200	73489	0.5	HVT8-S/S	75419
							HVPT-S/S	73631
SIDE MOUNTING ASSEMBLY COMPONENTS- TO SUIT 60 mm								
5	H Mounting Bracket			HDMRK	74582	2.0	HDMRK-S/S	76245
6	H Bearing			HBRK	73068	1.5	HBRK-S/S	75422
7	H Adjusting Arm			HARK	73069	1.5	HARK-S/S	75423
8	Torque Arm Kit			ESTAK-EST	76406	2.0	ESTAK-EST-S/S	78849
9	Acme Pivot Rod Kit			ACME-PRK	62496	1.5	ACME-PRK	62496
10	Spring Bush Kit - Black and Gold			HCSSB-B/G	62589	0.1	HCSSB-B/G	62589
11	Pole Bearing Bush			HCB-60	62513	0.1	HCB-60	62513
12	Acme Nut			ACME-N	62591	0.1	ACME-N	62591
SIDE MOUNTING ASSEMBLY COMPONENTS- TO SUIT 73 mm								
5	H Mounting Bracket			HDMRK	74582	3.0	HDMRK-S/S	76245
6	H Bearing			HBRKX	74549	2.0	HBRKX-S/S	76246
7	H Adjusting Arm			HDARK	74550	2.0	HDARK-S/S	76247
8	Torque Arm Kit			HCSTAK	62494	2.0	HCSTAK-S/S	62495
9	Acme Pivot Rod Kit			ACME-PRK	62496	1.5	ACME-PRK	62496
10	Spring Bush Kit - Black and Gold			HCSSB-B/G	62589	0.1	HCSSB-B/G	62589
10a	Spring Bush Kit - Silver			HCSSB-S	62590	0.1	HCSSB-S	62590
11	Pole Bearing Bush			HCB-73	62514	0.1	HCB-73	62514
12	Acme Nut			ACME-N	62591	0.1	ACME-N	62591

Shaded items are made to order. Call for lead time.









## Section 11 – Other Flexco Conveyor Products

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Flexco provides many conveyor products that help your conveyors to run more efficiently and safely. These components solve typical conveyor problems and improve productivity. Here is a quick overview on just a few of them:

### Rockline® EZP1 Primary Cleaner



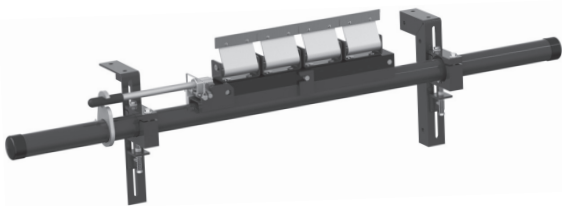
- Patented ConShear™ blade renews its cleaning edge as it wears
- Visual Tension Check™ for optimal blade tensioning and simple retensioning
- Quick and easy one-pin blade replacement Material Path Option™ for optimal cleaning and reduced maintenance

### Flexco Slider/Impact Beds



- Adjusting troughing angles for easy installation and adjustability
- Long-wearing UHMW for sealing the load zone
- Offered in both Light & Medium duty designs to affordably fit your application

### MHS SAC Secondary Cleaner



- Long-wearing tungsten carbide blades for superior cleaning efficiency
- Patented PowerFlex™ cushions, the proven design found on our industry-leading MHS Secondary Cleaner
- Service Advantage Cartridge can be easily removed and replaced, even in the dirtiest conditions
- Works with Flexco mechanical belt splices

### PT Max™ Belt Trainer



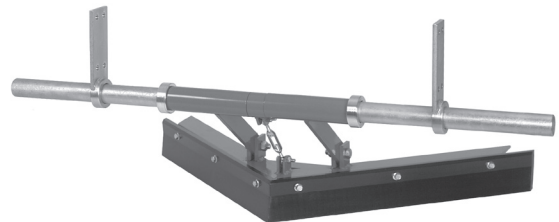
- Patented “pivot & tilt” design for superior training action
- Dual sensor rollers on each side to minimise belt damage
- Pivot point guaranteed not to freeze or seize up
- Available for topside and return side belts

### Flexco Specialty Belt Cleaners



- “Limited space” cleaners for tight conveyor applications
- Cleaners for severe, high heat applications
- A rubber fingered cleaner for chevron and raised rib belts
- Multiple cleaner styles in stainless steel for corrosive applications

### Belt Ploughs



- A belt cleaner for the tail pulley
- Exclusive blade design quickly spirals debris off the belt
- Economical and easy to service
- Available in vee or diagonal models

Visit [www.flexco.com](http://www.flexco.com) for other Flexco locations and products, or to find an authorised distributor.

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