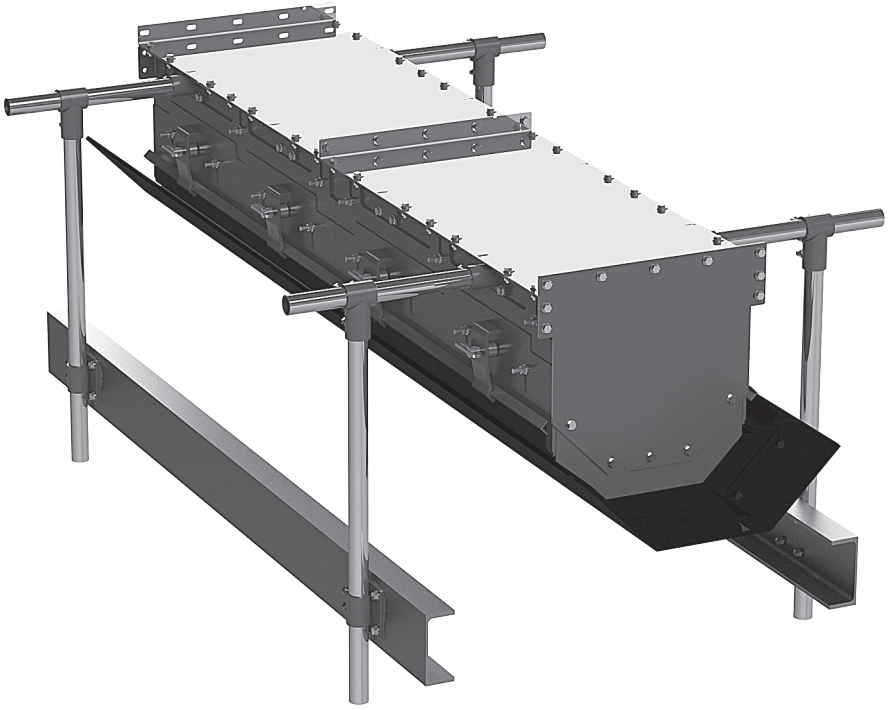
Standard Skirting System

Installation, Operation and Maintenance Manual



FLEXCO

Standard Skirting System

Serial Number: _____

Purchase Date: _____

Purchased From: _____

Installation Date: _____

Serial number information can be found on the Serial Number Label included in the Information Packet shipped with the skirting components.

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

Table of Contents

Section 1 - Important Information

1.1 General Introduction

We at Flexco are very pleased that you have selected our Standard Skirting System for your conveyor system.

This manual will help you to understand the installation, operation, and maintenance 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. In addition, please follow all standard approved safety guidelines when working on your conveyor.

If, however, you have any questions or problems that are not covered, please contact your field representative or our Customer Service Department:

Customer Service: 612-8818-2000

Visit 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 the Standard Skirting System. While we have tried to make the installation and service tasks as easy and simple as possible, this product does however require correct installation, regular inspection, and maintenance to maintain top working condition.

1.2 User Benefits

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

- Reduced airborne dust
- Reduced conveyor downtime
- Reduced man-hour labour
- Lower maintenance budget costs

1.3 Installation and Service Option

The Standard Skirting System 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 Engineer or your Flexco Distributor.

1.4 Skirting System Spec Sheet

Custom Skirting System Spec Sheet

CUSTOMER INFO:

Company Name: _____

Address: _____ Date: _____

_____ Phone #: _____

Contact Name: _____ e-Mail: _____

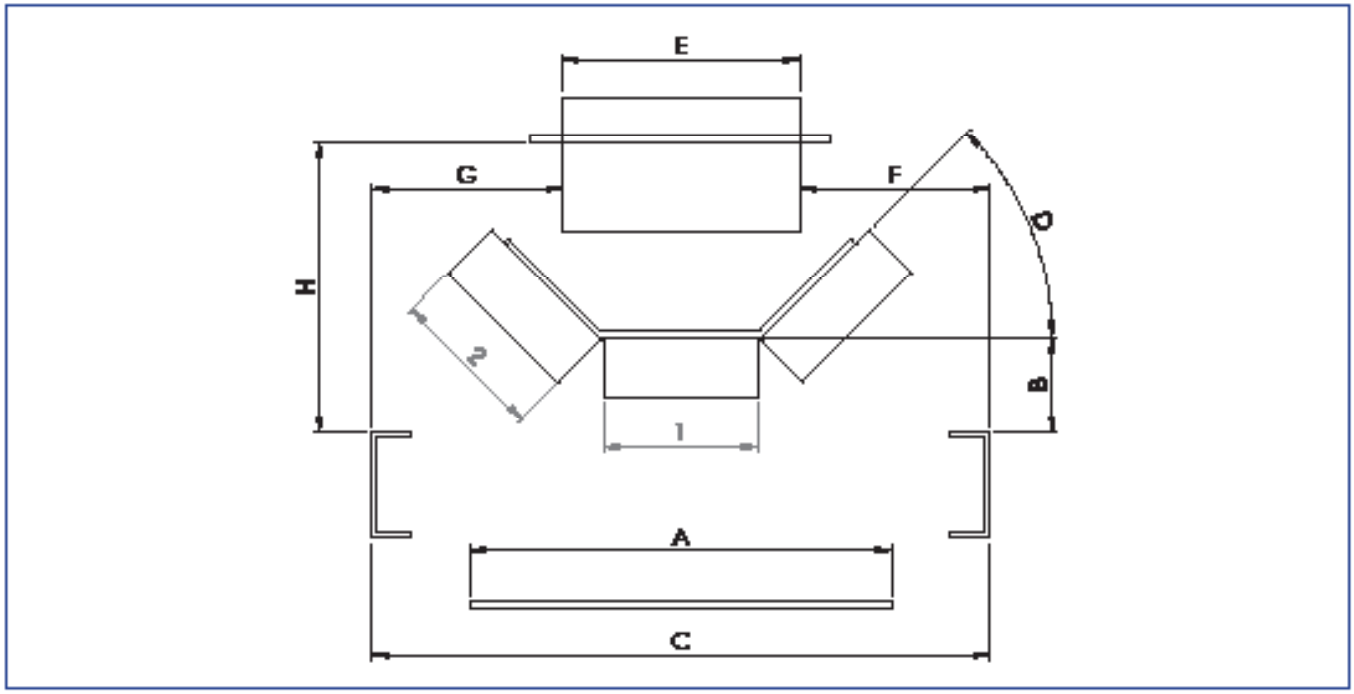
Title/Position: _____ PO #: _____

Conveyor Name: _____ Distributor: _____

DIMENSIONS:

Value	Units	Dim	Description
		A	Belt width
		B	Top of stringer to underside belt
		C	Outside of stringer dimensions
		D	Trough angle
		E	Widest inlet component
		F	Outside of Stringer to Component
		G	Outside of Stringer to Component
		H	Top of Stringer to Component Flange/Stiffener
		1	Idler Roll Length
		2	Idler Roll Length
			Material
			Material Density
			Belt speed / velocity
			Tonnage / Throughput
			Length of load-zone

Please return completed form to salesau@flexco.com.



Section 2 - Safety Considerations and Precautions

Before installing and operating the Standard Skirting System, 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
- Skirt Rubber Adjustments
- Cleaning

⚠ DANGER

It is imperative that all local regulations and codes related to working on conveyors including adherence to lock out/tag out (LOTO) procedures prior to undertaking any work on the conveyor or skirting system. Failure to adhere to safety standards including LOTO exposes workers to uncontrolled behavior of the Standard Skirting System caused by movement of the conveyor belt. Severe injury or death can result.

Before working:

- Lockout/Tagout the conveyor power source
- Clear the conveyor belt in the area to be skirted

⚠ WARNING

Close quarters and heavy components create a worksite that compromises a worker's safety. It is important to perform a proper job hazard assessment and determine the appropriate personal protective equipment to safely install and maintain equipment.

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 conveyor is an in-running nip hazard. Never touch or prod an operating Standard Skirting System. Conveyor hazards cause instantaneous amputation and entrapment.

⚠ WARNING

Conveyor chutes contain projectile hazards. Stay as far from the Standard Skirting System as practical and use safety eyewear and headgear. Projectiles launched from a conveyor can inflict serious injury.

Never adjust anything on an operating conveyor. Unforeseeable materials falling into the chute can cause violent movements of the Standard Skirting System structure. Falling hardware can cause serious injury or death.

Section 3 - Pre-Installation Checks and Options

3.1 Checklist

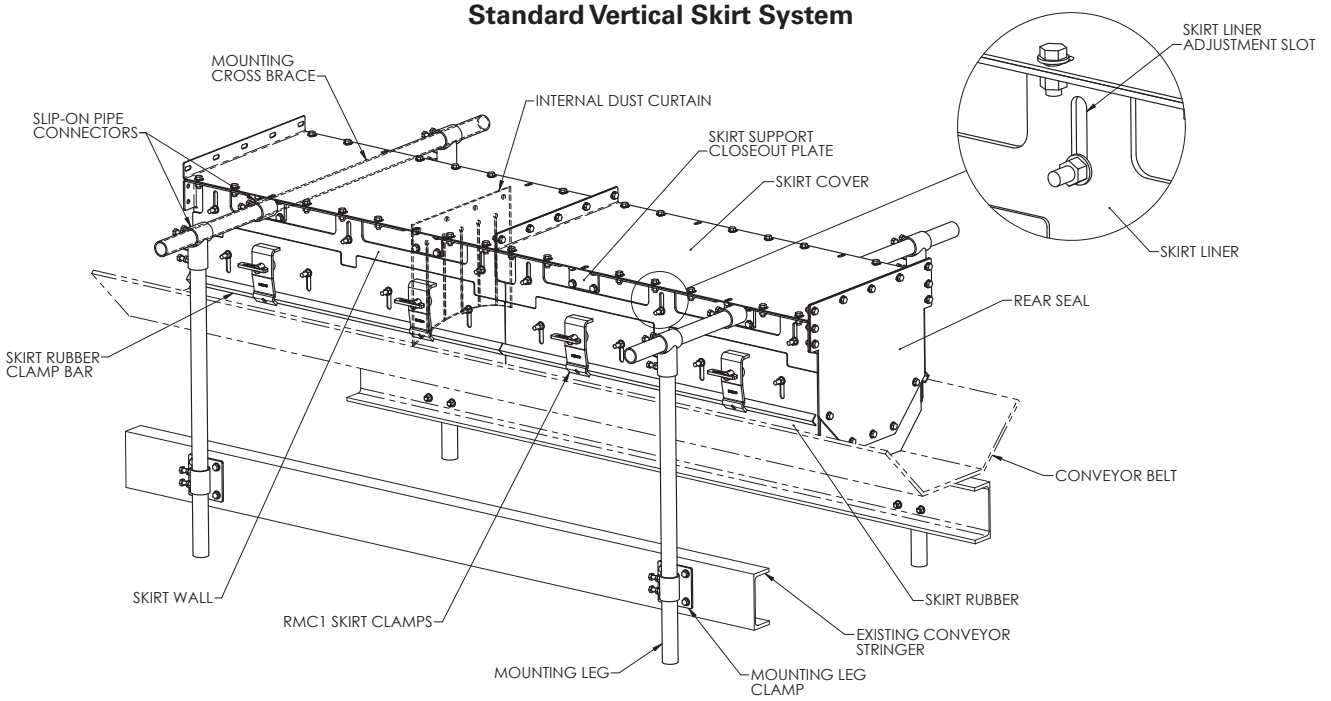
- Installation should only be done by qualified conveyor mechanics.
- Check the Standard Skirting System to be sure all the parts are included in the shipment.
- Check for properly tracked belts before installing Flexco's Standard Skirting System. An improperly tracked belt will result in potential disengagement of the tangential seal skirting rubber which will then result in potential damage to the skirting rubber.
- Skirting rubber durometer should be softer than that of the conveyor belt to avoid any potential of the skirting rubber damaging the conveyor belt.
- Prepare the conveyor site:
  - Inspect the conveyor structure for damage or misalignment. Make adjustments as necessary
  - Verify existing ancillary equipment will not be affected by the installation of the skirting system
  - Determine optimal skirt leg locations and prep areas for mounting
  - If existing equipment must be adjusted or re-located to assist in installing the skirting system, care should be taken to insure all affected equipment will remain fully functional after the installation of the skirting

Section 4 - Installation Instructions

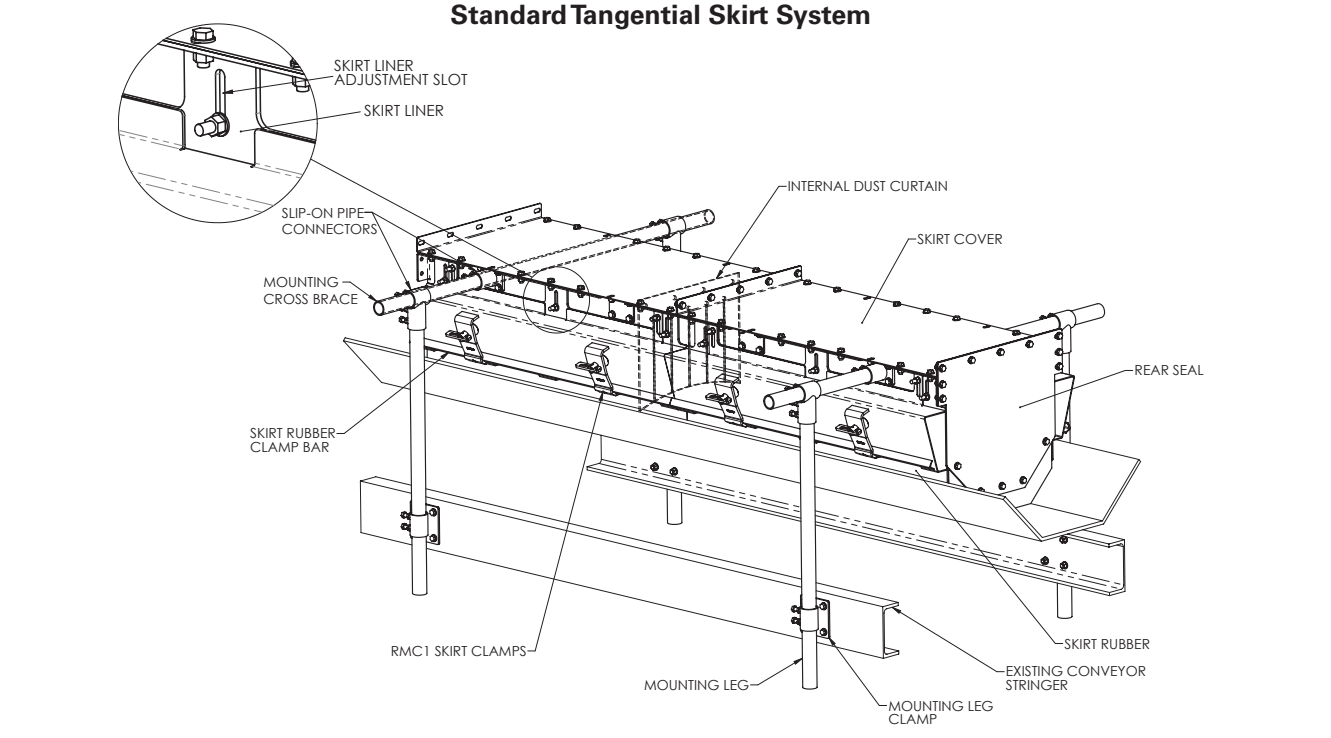
4.1 Standard Skirting Systems

CAUTION: Components may be heavy. Use safety approved lifting procedures.

Standard Vertical Skirt System



Standard Tangential Skirt System

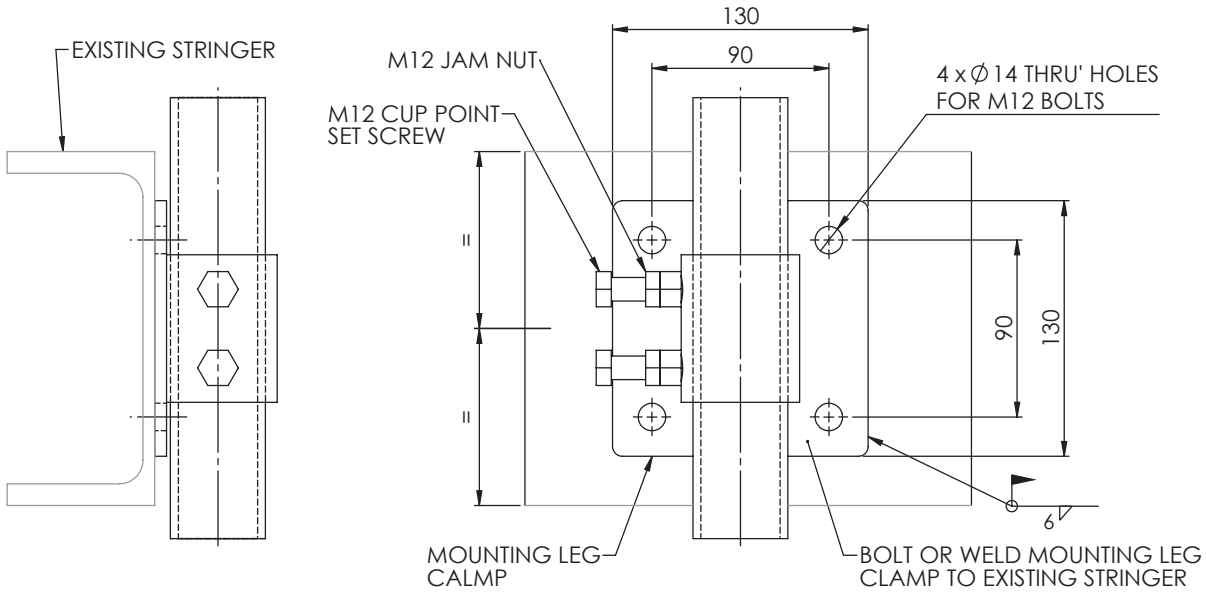


1. If applicable, remove existing conveyor belt skirting. Clearing existing stringer for mount leg clamps.
2. Determine locations for skirt legs and weld or bolt skirting mount leg clamps to stringer. Skirt walls have locations for mount cross brace every 600mm Cross brace spanners are available for infinite leg locations. Mount legs are required every 1200mm minimum to 2400 maximum.

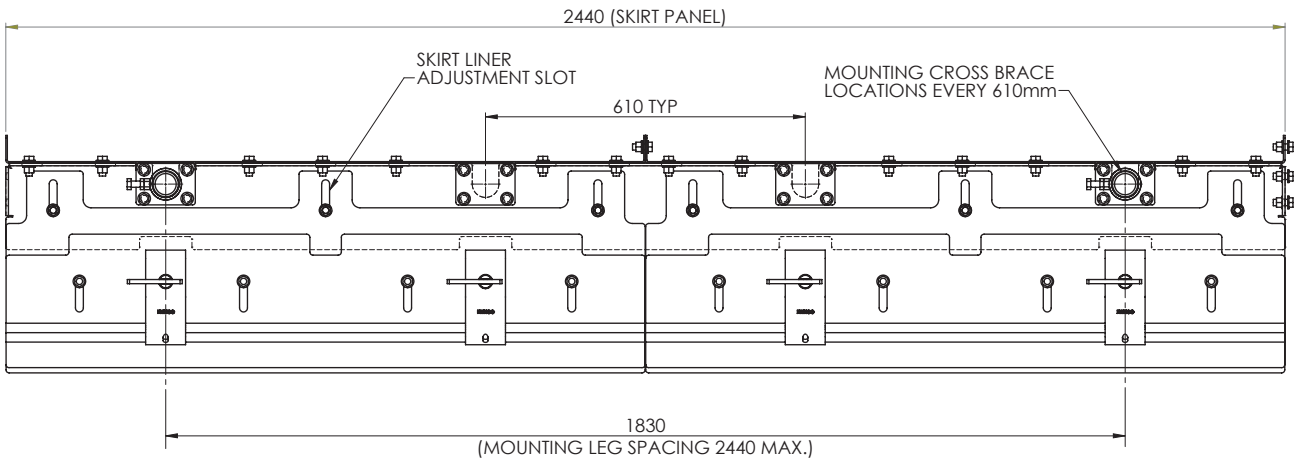
Section 4 - Installation Instructions

4.1 Standard Skirting Systems (cont.)

Mounting Leg Clamp Connection Detail



Vertical Leg Connection Detail



3. Connect mount cross brace assemblies to skirt walls, positioned over conveyor belt, hand-tightening all hardware.
4. Place slip-on pipe connectors from mount legs on mount cross braces and, if applicable, cross brace spanners.
5. Place cross brace spanner on mount cross braces (if applicable).
6. Place mount leg pipes onto mount leg clamps, tightening set screws and jam nuts.
7. Install the assembled skirt wall, mount cross braces, and cross brace spanner (if applicable) onto mount leg pipes.

Section 4 - Installation Instructions

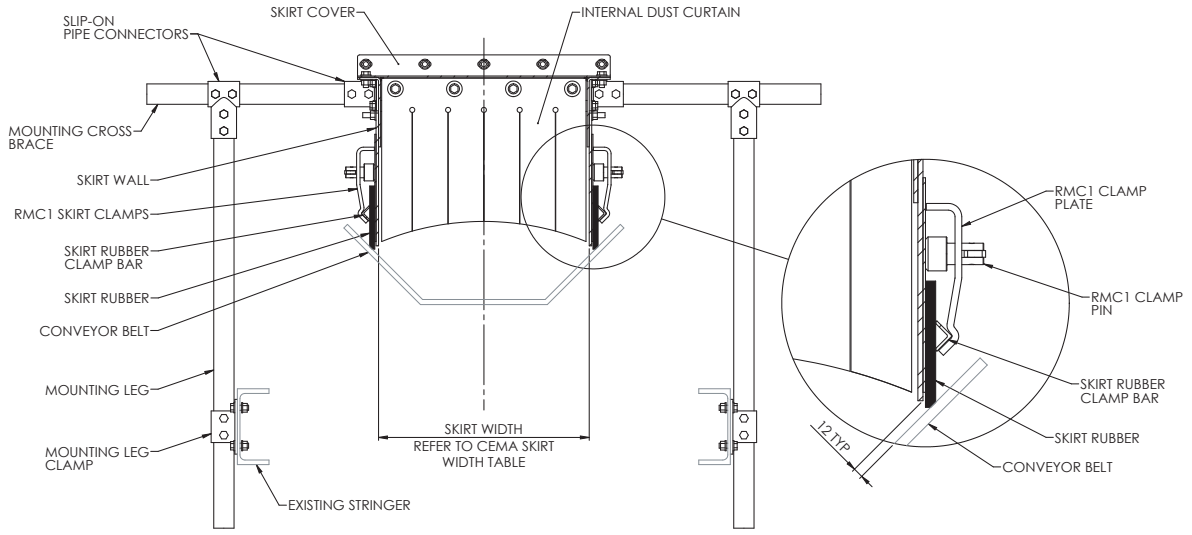
4.1 Standard Skirting Systems (cont.)

8. Set the skirt walls vertical, level to each other, set to the specified CEMA width (see the CEMA skirt width table for the dimension for specific belt widths), and centered on the conveyor belt.
9. Locate skirt liners 13mm away from the conveyor belt.
10. Loosely assemble skirt walls to each other, hand-tightening all hardware.
11. Loosen all skirt liners and lower them to be 3mm away from the conveyor belt. Tighten skirt liner hardware.

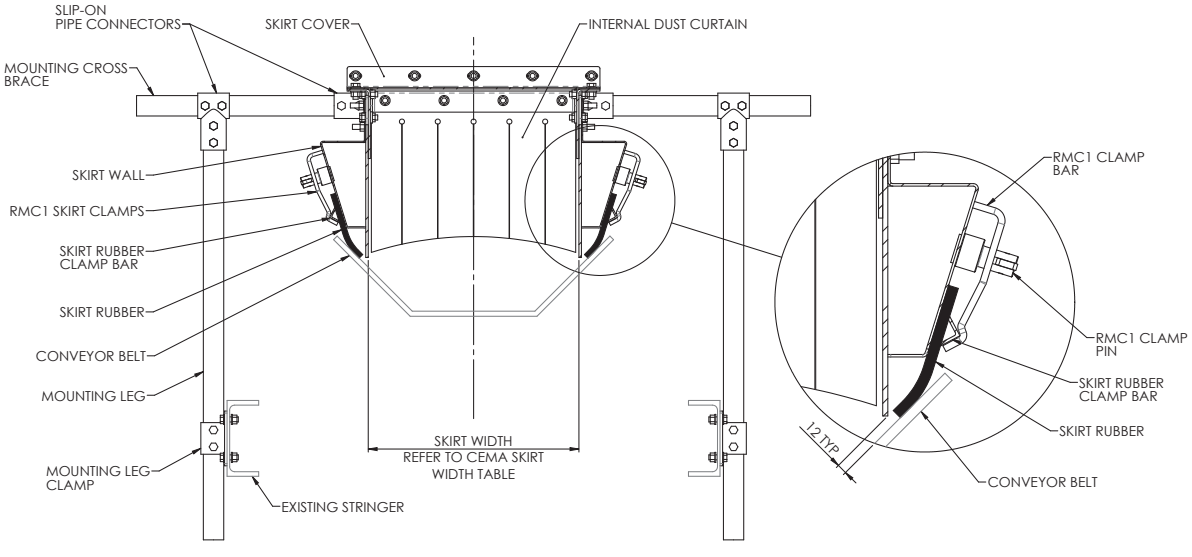
CEMA Skirt Width

Belt Width	Skirt Width
600mm	400mm
750mm	500mm
900mm	600mm
1050mm	700mm
1200mm	800mm
1350mm	900mm
1500mm	1000mm
1650mm	1100mm
1800mm	1200mm
2100mm	1400mm
2400mm	1600mm

Vertical Sealing Skirt Solution



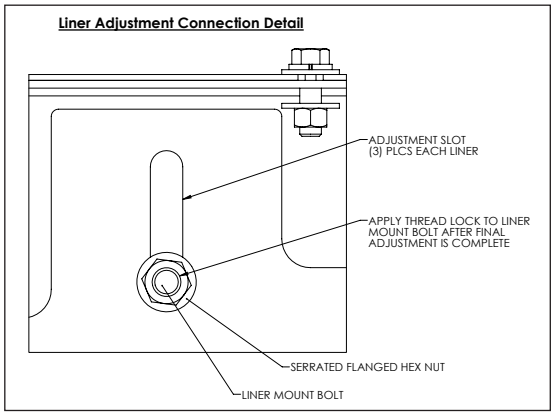
Tangentially Sealing Skirt Solution



Section 4 - Installation Instructions

4.1 Standard Skirting Systems (cont.)

12. Install the rear seal to tail skirt walls.
13. Modify the skirt covers for specific requirements (Dust collection/suppression/chute penetrations/fire suppression/etc).
14. Install interior dust curtains to skirt walls (if applicable).
15. Install the skirt covers.
16. Tighten all connections.
17. After all final adjustments have been made, threadlock, such as Loctite 242 blue, shall be applied to all liner adjustment connections. To do so, one at a time, loosen a nut so that threadlock can be applied to the nut engagement area, per its manufacturers recommendations. Then, tighten the nut to its proper torque, 100 n/m Repeat this process one nut at a time, for all remaining nuts.
18. Caulk all joints and gaps. Caulk not provided.
19. Position skirt rubber per the **6.5 Skirt Rubber Replacement** directions.



Flexco's Flex-Lok™

Skirting rubber is held in place with Flexco's Flex-Lok™ style skirt clamping system shown below featuring:

- A strong restraining bar that is held in place by clamp plates to allow easy adjustment of the skirt rubber conveniently from the sides of the conveyor.
- Anti-vibration clamp pins can be unlocked with a rubber hammer.
- A unique captive wedge mechanism that ensures no part gets lost.
- Easy to maintain – one person can reposition worn skirt rubber in minutes.

Section 5 - Pre-Operation Checklist and Testing

5.1 Pre-Op Checklist

- Check that all fasteners are tightened
- Check that the empty belt to skirt board clearance is 3mm minimum at the tail end and no more than 13mm at the discharge end; it is critical that the skirt liner clearance to the belt is constant or grows in the direction of belt travel.
- Check that skirting rubber is lying free on the conveyor belt and not binding the conveyor belt in any area
- Be sure that all installation materials and tools have been removed from the belt and conveyor area

5.2 Test Run the Conveyor

- Run the conveyor for at least 15 minutes and confirm that the skirt rubber is properly sealing the transfer point
- Adjust skirt rubber as needed
- Ensure rubber is laying free on the conveyor and not binding in any areas
- Confirm that the belt is tracking properly after any skirting adjustment

Section 6 - Maintenance

Flexco's Standard Skirting Systems are designed to operate with minimal maintenance. However, to maintain superior performance some service is required. When the Flexco's Standard Skirting System is installed, a regular maintenance program should be set up. This program will insure that the skirting solution operates at optimal efficiency. With a good maintenance program, problems can be identified and fixed before any damage is done to the conveyor belt, structures, or components.

All safety procedures for inspection of equipment (stationary or operating) must be observed. Flexco's Standard Skirting Solution operates over a moving conveyor belt. Only visual observations can be made while the conveyor belt is running. Tasks must be done by qualified individuals only when the conveyor belt is stopped and workers have observed the correct lockout and tag-out procedures.

6.1 New Installation Inspection

After the skirting solution has been in service for a few days a visual inspection should be made to ensure the skirting is performing properly. Make adjustments as needed.

6.2 Routine Visual Inspection (Every 2-4 weeks)

A visual inspection of the skirting solution can determine:

- If the skirt rubber is adequately keeping the chute area sealed
- If there is excessive material building up around the skirting area
- If there is damage to the skirting, conveyor belt, or other conveyor components

If any of the above conditions exist, the conveyor should be stopped for maintenance.

6.3 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 skirting system can be made to perform the following tasks:

- Clean material buildup around the skirting system and conveyor structure
- Closely inspect each skirt liner for wear and damage, replace if needed
- Check the skirting system for damage
- Inspect all fasteners for tightness and wear; tighten or replace as needed
- Inspect skirt rubber and adjust or replace as needed
- When maintenance tasks are completed, test run the conveyor to ensure the skirting system is performing properly

6.4 Liner Replacement Instructions

When the conveyor is not in operation and properly locked and tagged-out, skirt liner replacement of the skirting system can be made by performing the following tasks:

- Remove skirt rubber per the **6.5 Skirt Rubber Replacement** directions
- Remove nuts that hold liner to be replaced in place
- Unfasten and remove skirt liner and, if applicable, tangential skirt piece from the stationary skirt piece
- If applicable, unbolt tangential skirt piece from old skirt liner and bolt it to new skirt liner
- Set in place new skirt liner and, if applicable, tangential skirt piece
- Fasten skirt liner and, if applicable, tangential skirt piece to stationary skirt piece
- Verify new skirt liner to belt clearance is 3mm minimum and adjust if necessary
- Reposition skirt rubber per the **6.5 Skirt Rubber Replacement** directions
- Test run conveyor and inspect belt to liner area for proper clearances

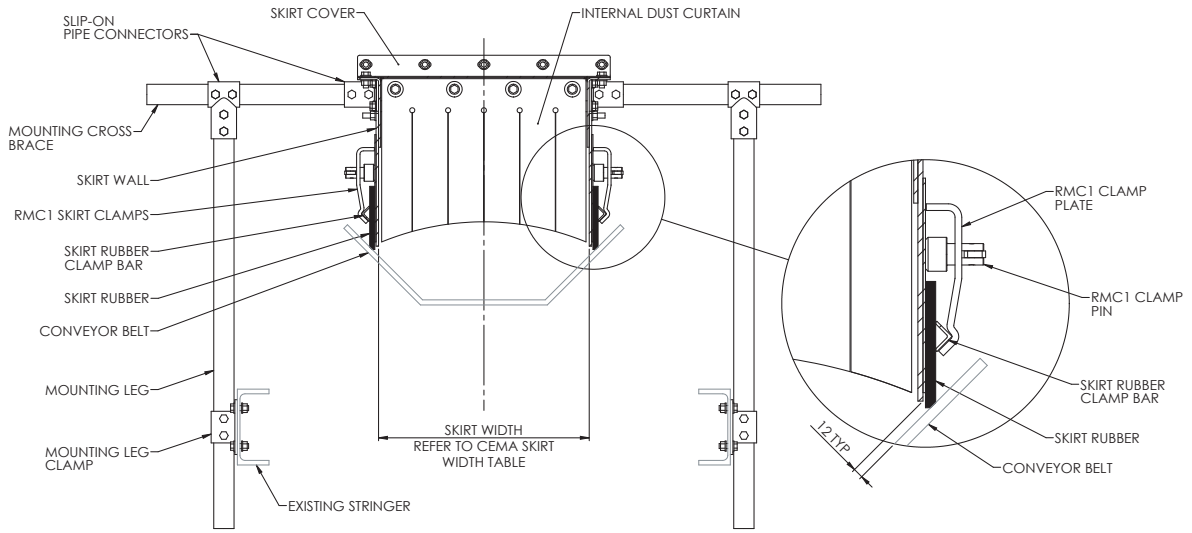
Section 6 - Maintenance

6.5 Skirt Rubber Replacement

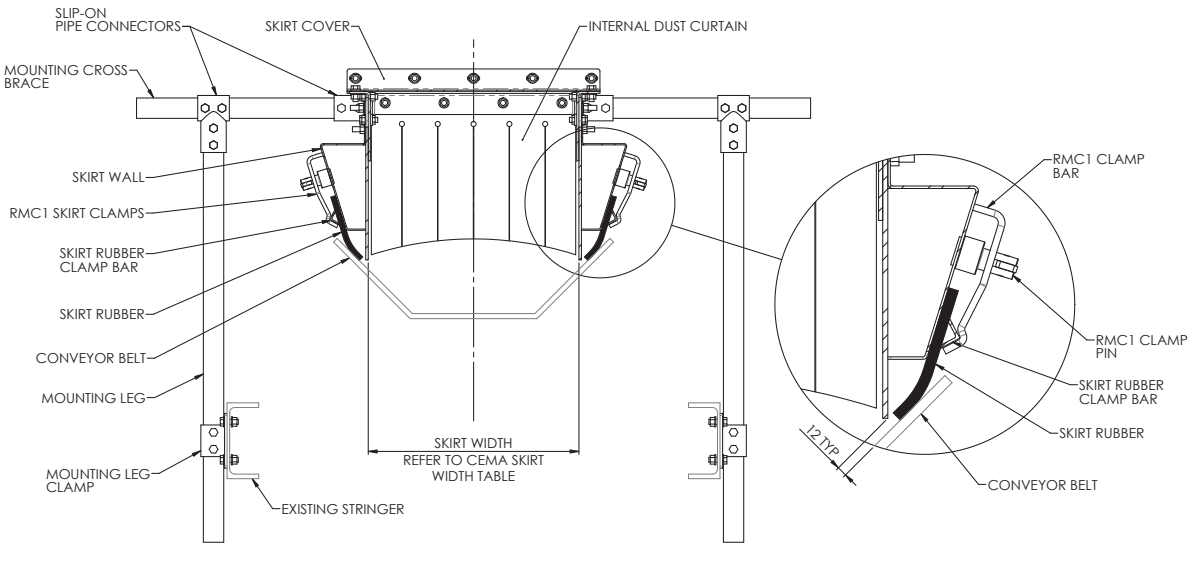
When the conveyor is not in operation and properly locked and tagged-out, the skirt rubber can be replaced by performing the following tasks:

- Use a hammer to loosen the RMC1 clamp pins
- Remove RMC1 clamp plates and rubber clamps bars
- Remove the old skirt rubber
- Position the new skirt rubber as shown in the following diagram:

Vertical Sealing Skirt Solution

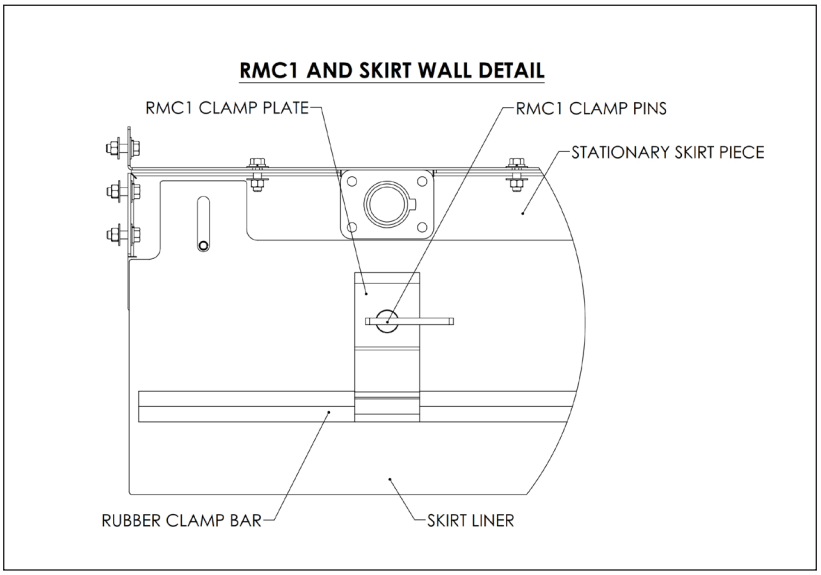


Tangentially Sealing Skirt Solution



6.5 Skirt Rubber Replacement (cont.)

- The skirt rubber should not go under the skirt boards
- Relocate RMC1 clamp plates and rubber clamp bars
- Use a hammer to tighten the RMC1 skirt clamps
- Ensure the skirt rubber is lying free on the top of belt and not pinched to the belt; pinched skirt rubber will adversely impact conveyor belt and skirting solution performance and wear
- Test run the conveyor and inspect conveyor belt and skirt rubber for proper sealing



Section 6 - Maintenance

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: _____

Section 6 - Maintenance

6.7 Standard Skirting System Maintenance Checklist

Site: _____ **Inspected by**: _____ **Date:** _____

Beltline Information:

Beltline Number: _____ Belt Condition: _____

Beltline Speed: _____ Belt Thickness: _____

Belt Width: ☐ 600mm (24") ☐ 750mm (30") ☐ 900mm (36") ☐ 1050mm (42") ☐ 1200mm (48") ☐ 1350mm (54") ☐ 1500mm (60") ☐ 1800mm (72") ☐ 2100mm (84") ☐ 2400mm (96")

Vertical distance between liner and belt:

Minimum Measured: _____ Maximum Measured: _____

Liner Life:

Date Liners Installed: _____ Date Liners Inspected: _____

Date Liners Installed: _____ Date Liners Inspected: _____

Overall Skirting Condition: ☐ Good ☐ Bent ☐ Rusted

Overall RBP1 Performance: (Rate the following 1 - 5, 1=very poor - 5= very good)

Appearance: ☐ Comments: _____

Location: ☐ Comments: _____

Maintenance: ☐ Comments: _____

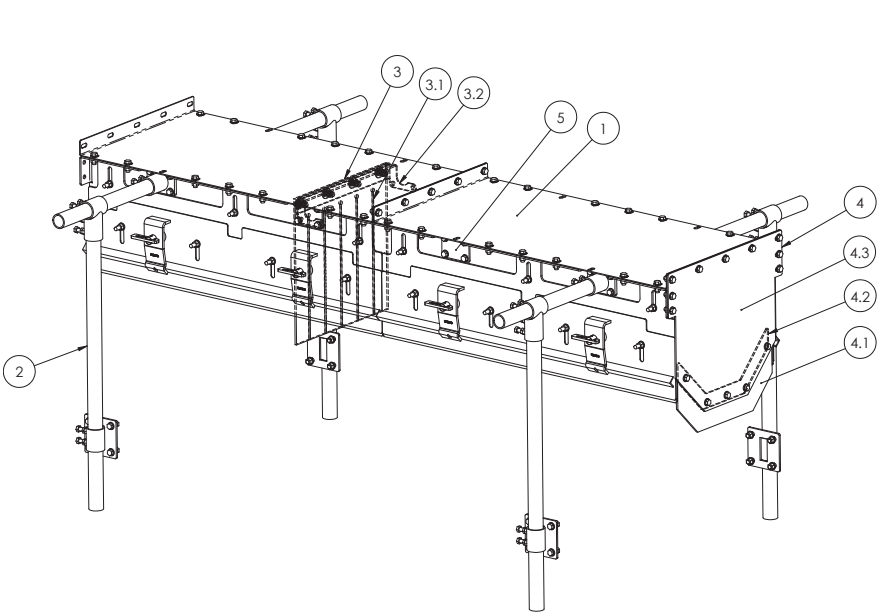
Performance: ☐ Comments: _____

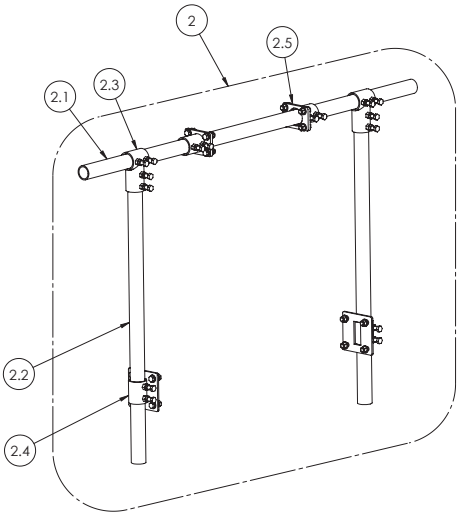
Other Comments: _____

Section 7 - Troubleshooting

Problem	Possible Cause	Possible Solutions
Skirt rubber is disengaging belt	Belt is mistracking	Correct tracking
		Install a Flexco Belt Tracker
	Skirt rubber is worn out and too short	Replace skirt rubber
Material is leaking out of skirting	Skirt rubber is not installed correctly	Install skirt rubber correctly
	Skirt rubber is worn out and too short	Replace skirt rubber
	Liner inserts are worn out	Replace liners
	Skirting is not set to the proper height off the belt	Set skirting to the proper height
Excessive dust is coming out of the end of the skirting	Internal dust curtains are missing	Install new dust curtains
	Material is impacting belt too severely in the load zone	Install Flexco Impact Beds
		Consider a Complete Flexco Engineering Chute system

Section 8 - Replacement Parts List

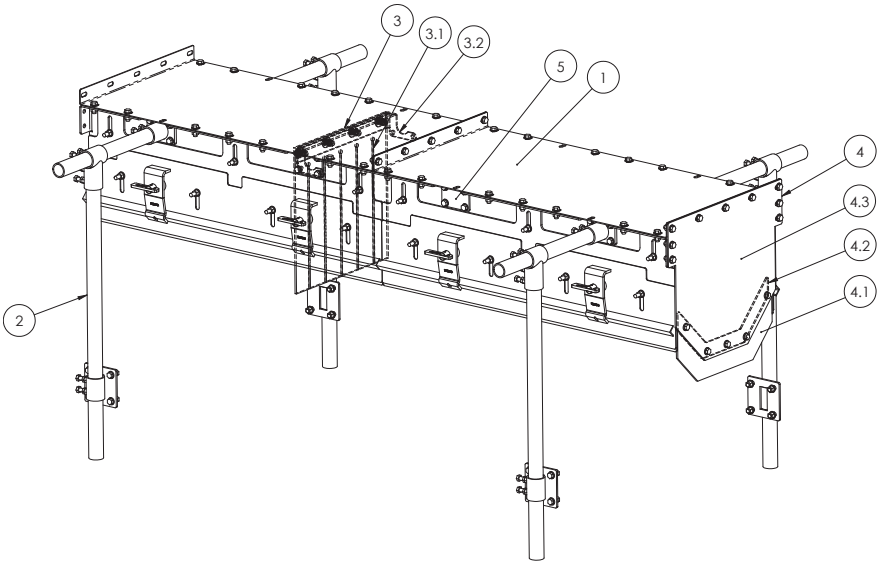


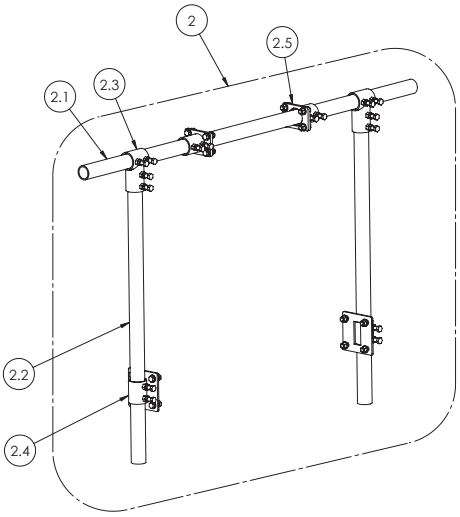


Replacement Parts

				MILD STEEL		STAINLESS STEEL		ALUMINUM	
REF	DESCRIPTION	BELT WIDTH	LENGTH mm	ITEM CODE	WT. KG.	ITEM CODE	WT. KG.	ITEM CODE	WT. KG.
1	Skirt Cover	600		66314	15.3	66326	15.6	66338	5.3
		750		66315	18.4	66327	18.8	66339	6.3
		900		66316	21.5	66328	22/0	66340	7.4
		1050		66317	24.6	66329	25.1	66341	8.4
		1200		66318	27.6	66330	28.3	66342	9.5
		1350		66319	30.7	66331	31.4	66343	10.6
		1500		66320	33.8	66332	34.6	66344	11.6
		1600		66321	35.7	66333	36.5	66345	12.3
		1800		66322	40.0	66334	40.9	66346	13.8
		2000		66323	43.7	66335	44.7	66347	15.0
		2200		66324	48.0	66336	49.1	66348	16.5
		2400		66325	52.4	66337	53.5	66349	18/0
2	Leg Assembly	600		66350	19.9	66362	22.6		
		750		66351	20.5	66363	23.4		
		900		66352	21.2	66364	24.3		
		1050		66353	24.0	66365	27.8		
		1200		66354	24.7	66366	28.7		
		1350		66355	25.5	66367	29.8		
		1500		66356	26.2	66368	30.6		
		1600		66357	29.3	66369	34.5		
		1800		66358	30.1	66370	35.6		
		2000		66359	31.0	66371	36.7		
		2200		66360	31.9	66372	37.8		
2.1	Cross Brace	600	1150	66380	5.0	66391	6.3		
		750	1300	66381	5.7	66392	7.2		
		900	1450	66382	6.3	66393	8.0		
		1050	1600	66383	7.0	66394	8.8		
		1200	1750	66384	7.6	66395	9.7		
		1350	1950	66385	8.5	66396	10.8		
		1500	2100	66386	9.2	66397	11.6		
		1600	2300	66387	10.1	66398	12.7		
		1800	2500	66388	10.9	66399	13.8		
		2000	2700	66389	11.8	66400	14.9		
		2200	2900	66390	12.7	66401	16.0		

Section 8 - Replacement Parts List con't.

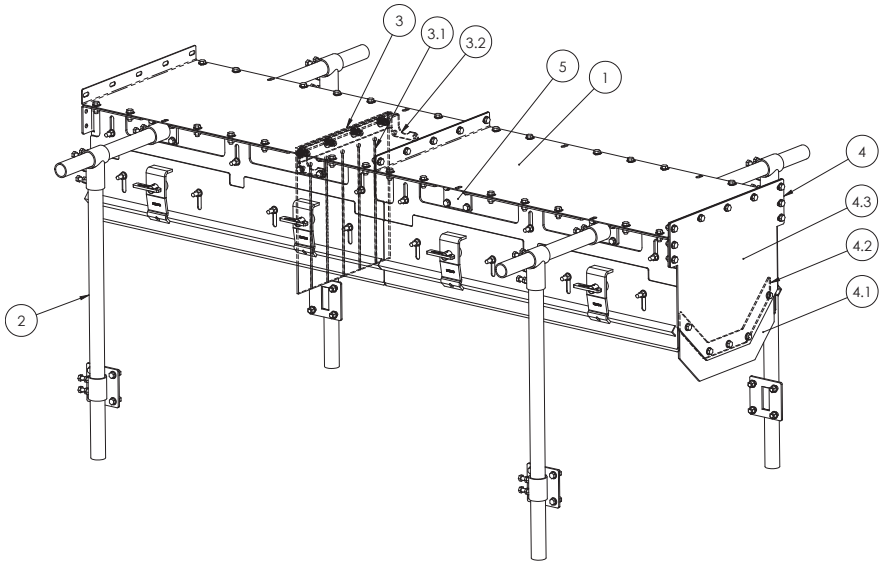




Replacement Parts

				MILD STEEL		STAINLESS STEEL		ALUMINUM	
REF	DESCRIPTION	BELT WIDTH	LENGTH mm	ITEM CODE	WT. KG.	ITEM CODE	WT. KG.	ITEM CODE	WT. KG.
2.2	Mounting Leg		750	66402	3.3	66972	4.1		
			1000	66403	4.4	66973	5.5		
			1250	66404	5.5	66974	6.9		
2.3	Tee Support Clamp			66378	1.3	66379	1.2		
2.4	Leg Support Clamp			66376	1.6	66377	1.5		
2.5	Support Clamp			66374	1.3	66375	1.3		
3	Dust Curtain Assembly	600		66405	3.0	66416	3.0		
		750		66406	3.2	66417	3.8		
		900		66407	4.4	66418	4.4		
		1050		66408	5.1	66419	5.1		
		1200		66409	5.7	66420	5.8		
		1350		66410	6.5	66421	6.5		
		1500		66411	7.2	66422	7.3		
		1600		66412	7.7	66423	7.7		
		1800		66413	8.6	66424	8.7		
		2000		66414	9.5	66425	9.6		
		2200		66415	10.5	66426	10.6		
3.1	Dust Curtain Rubber	600		66449	1.1				
		750		66450	1.4				
		900		66451	1.7				
		1050		66452	2.0				
		1200		66453	2.3				
		1350		66454	2.6				
		1500		66455	2.9				
		1600		66456	3.1				
		1800		66457	3.5				
		2000		66458	3.9				
		2200		66459	4.3				

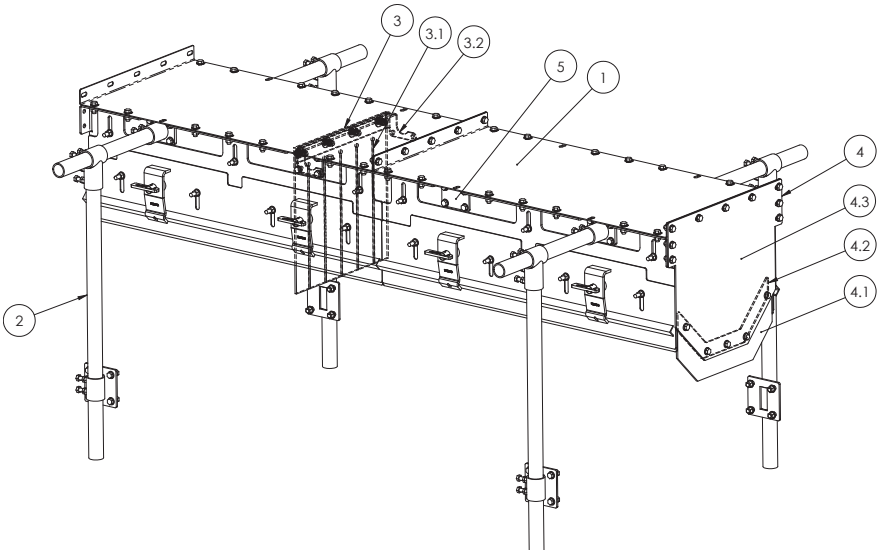
Section 8 - Replacement Parts List con't.



Replacement Parts

			MILD STEEL		STAINLESS STEEL		ALUMINUM	
REF	DESCRIPTION	BELT WIDTH	ITEM CODE	WT. KG.	ITEM CODE	WT. KG.	ITEM CODE	WT. KG.
3.2	Dust Curtain Bracket	600	66427	1.9	66438			
		750	66428	2.3	66439			
		900	66429	2.6	66440			
		1050	66430	3.1	66441			
		1200	66431	3.4	66442			
		1350	66432	3.8	66443			
		1500	66433	4.3	66444			
		1600	66434	4.6	66445			
		1800	66435	5.1	66446			
		2000	66436	5.6	66447			
		2200	66437	6.2	66448			
			350mm h x 35°		**350mm h x 35°**			
4	Rear Seal Assembly	600	66460	8.5	66504	8.7		
		750	66461	10.7	66505	10.9		
		900	66462	12.9	66506	13.1		
		1050	66463	15.2	66507	15.5		
		1200	66464	17.6	66508	17.9		
		1350	66465	20.1	66509	20.4		
		1500	66466	22.8	66510	23.2		
		1600	66467	24.5	66511	24.9		
		1800	66468	28.5	66512	29.0		
		2000	66469	31.9	66513	32.5		
		2200	66470	36.1	66514	36.7		
			350mm h x 45°		**350mm h x 45°**			
4	Rear Seal Assembly	600	66548	8.9	66592	9.2		
		750	66549	11.2	66593	11.5		
		900	66550	13.6	66594	14.0		
		1050	66551	16.2	66595	16.7		
		1200	66552	18.8	66596	19.3		
		1350	66553	21.7	66597	22.2		
		1500	66554	24.9	66598	25.4		
		1600	66555	27.0	66599	27.5		
		1800	66556	31.7	66600	32.3		
		2000	66557	35.6	66601	36.3		
		2200	66558	40.7	66602	41.4		

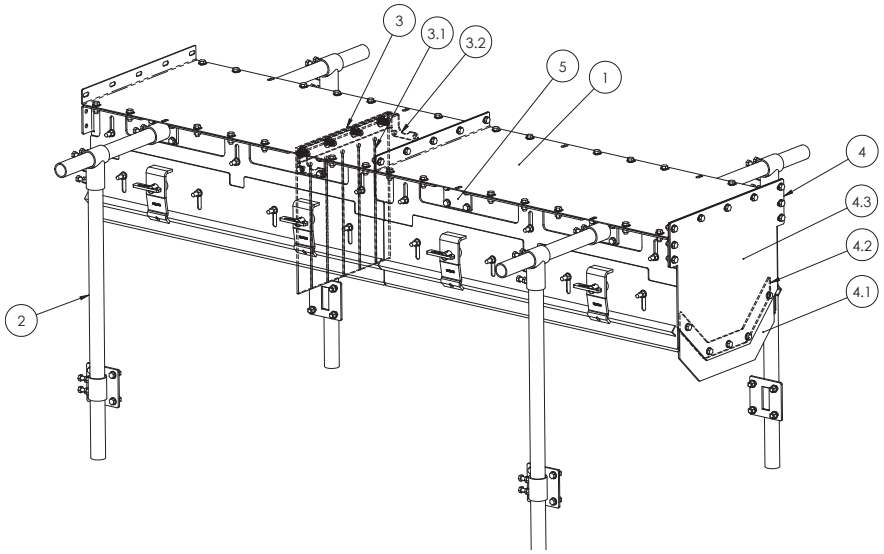
Section 8 - Replacement Parts List con't.



Replacement Parts

REF	DESCRIPTION	BELT WIDTH	MILD STEEL ITEM CODE	MILD STEEL WT. KG.	STAINLESS STEEL ITEM CODE	STAINLESS STEEL WT. KG.	ALUMINUM ITEM CODE	ALUMINUM WT. KG.
			400mm h x 35°		**400mm h x 35°**			
4	Rear Seal Assembly	600	66471	9.4	66515	9.6		
		750	66472	11.7	66516	11.9		
		900	66473	14.1	66517	14.4		
		1050	66474	16.6	66518	16.9		
		1200	66475	19.2	66519	19.5		
		1350	66476	21.9	66520	22.3		
		1500	66477	24.8	66521	25.3		
		1600	66478	26.6	66522	27.1		
		1800	66479	30.9	66523	31.5		
		2000	66480	34.5	66524	35.1		
		2200	66481	39.0	66525	39.7		
			400mm h x 45°		**400mm h x 45°**			
4	Rear Seal Assembly	600	66559	9.7	66603	10.0		
		750	66560	12.2	66604	12.6		
		900	66561	14.8	66605	15.3		
		1050	66562	17.6	66606	18.1		
		1200	66563	20.4	66607	20.9		
		1350	66564	23.5	66608	24.1		
		1500	66565	26.9	66609	27.5		
		1600	66566	29.1	66610	29.7		
		1800	66567	34.1	66611	34.7		
		2000	66568	38.3	66612	39.0		
		2200	66569	43.6	66613	44.4		
			450mm h x 35°		**450mm h x 35°**			
4	Rear Seal Assembly	600	66482	10.2	66526	10.4		
		750	66483	12.7	66527	13.0		
		900	66484	15.3	66528	5.6		
		1050	66485	18	66529	18.4		
		1200	66486	20.8	66530	21.2		
		1350	66487	23.7	66531	24.1		
		1500	66488	26.8	66532	27.3		
		1600	66489	28.7	66533	29.3		
		1800	66490	33.3	66534	33.9		
		2000	66491	37.1	66535	37.8		
		2200	66492	41.9	66536	42.7		

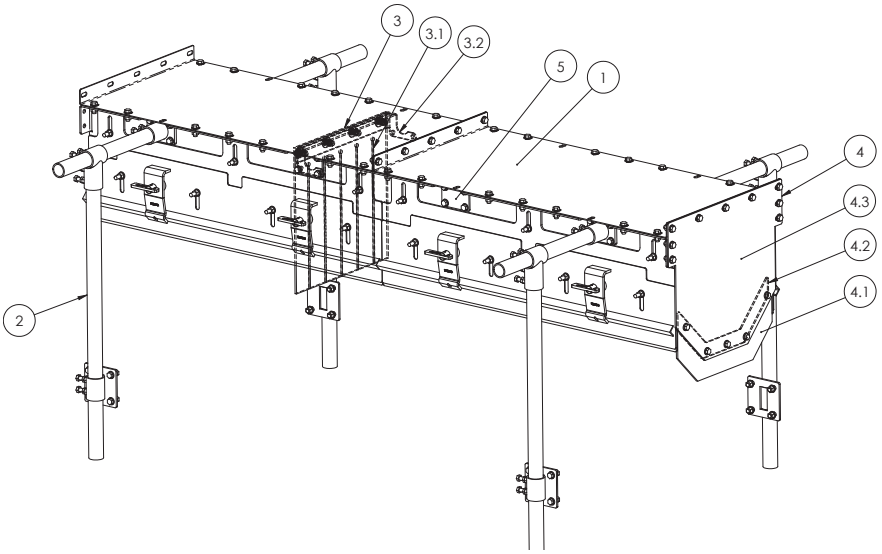
Section 8 - Replacement Parts List con't.



Replacement Parts

REF	DESCRIPTION	BELT WIDTH	MILD STEEL ITEM CODE	MILD STEEL WT. KG.	STAINLESS STEEL ITEM CODE	STAINLESS STEEL WT. KG.	ALUMINUM ITEM CODE	ALUMINUM WT. KG.
			450mm h x 45˚		**450mm h x 45˚**			
4	Rear Seal Assembly	600	66570	10.5	66614	10.8		
		750	66571	13.2	66615	13.6		
		900	66572	16.1	66616	16.5		
		1050	66573	19.1	66617	19.6		
		1200	66574	22.0	66618	22.6		
		1350	66575	25.3	66619	25.9		
		1500	66576	29.0	66620	29.5		
		1600	66577	31.2	66621	31.8		
		1800	66578	36.5	66622	37.2		
		2000	66579	40.9	66623	41.7		
		2200	66580	46.5	66624	47.4		
			500mm h x 35˚		**500mm h x 35˚**			
4	Rear Seal Assembly	600	66493	11.1	66537	11.3		
		750	66494	13.8	66538	14.0		
		900	66495	16.6	66539	16.9		
		1050	66496	19.5	66540	19.8		
		1200	66497	22.4	66541	22.8		
		1350	66498	25.5	66542	26.0		
		1500	66499	28.8	66543	29.4		
		1600	66500	30.9	66544	31.4		
		1800	66501	35.7	66545	36.4		
		2000	66502	39.8	66546	40.5		
		2200	66503	44.8	66547	45.6		
			500mm h x 45˚		**500mm h x 45˚**			
4	Rear Seal Assembly	600	66581	11.3	66625	11.7		
		750	66582	14.2	66626	14.7		
		900	66583	17.3	66627	17.8		
		1050	66584	20.5	66628	21.0		
		1200	66585	23.6	66629	24.2		
		1350	66586	27.1	66630	27.8		
		1500	66587	31.0	66631	31.6		
		1600	66588	33.4	66632	34.0		
		1800	66589	38.9	66633	39.6		
		2000	66590	43.6	66634	44.4		
		2200	66591	49.4	66635	50.3		

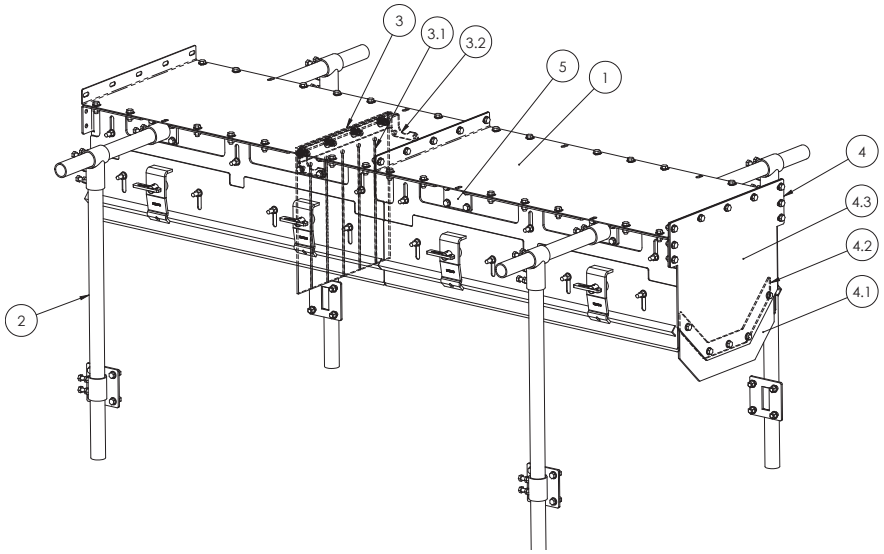
Section 8 - Replacement Parts List con't.



Replacement Parts

REF	DESCRIPTION	BELT WIDTH	MILD STEEL ITEM CODE	MILD STEEL WT. KG.	STAINLESS STEEL ITEM CODE	STAINLESS STEEL WT. KG.	ALUMINUM ITEM CODE	ALUMINUM WT. KG.
			35°					
4.1	Rear Seal Rubber	600	66900	0.4				
		750	66901	0.5				
		900	66902	0.7				
		1050	66903	0.8				
		1200	66904	0.9				
		1350	66905	1.0				
		1500	66906	1.1				
		1600	66907	1.2				
		1800	66908	1.3				
		2000	66909	1.4				
		2200	66910	1.6				
			45°					
4.1	Rear Seal Rubber	600	66911	0.5				
		750	66912	0.6				
		900	66913	0.7				
		1050	66914	0.8				
		1200	66915	0.9				
		1350	66916	1.1				
		1500	66917	1.2				
		1600	66918	1.3				
		1800	66919	1.4				
		2000	66920	1.6				
		2200	66921	1.7				
			35°		35°			
4.2	Rear Seal Retainer	600	66856	0.8	66878	0.8		
		750	66857	1.0	66879	1.0		
		900	66858	1.2	66880	1.3		
		1050	66859	1.5	66881	1.5		
		1200	66860	1.7	66882	1.7		
		1350	66861	1.9	66883	1.9		
		1500	66862	2.1	66884	2.1		
		1600	66863	2.2	66885	2.3		
		1800	66864	2.5	66886	2.6		
		2000	66865	2.8	66887	2.8		
		2200	66866	3.1	66888	3.1		

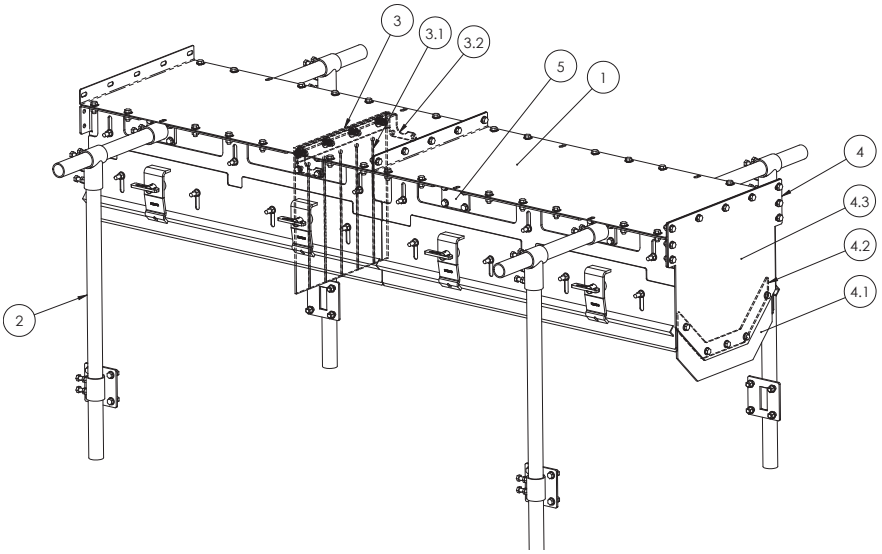
Section 8 - Replacement Parts List con't.



Replacement Parts

REF	DESCRIPTION	BELT WIDTH	MILD STEEL ITEM CODE	MILD STEEL WT. KG.	STAINLESS STEEL ITEM CODE	STAINLESS STEEL WT. KG.	ALUMINUM ITEM CODE	ALUMINUM WT. KG.
			45°		**45°**			
4.2	Rear Seal Retainer	600	66867	0.9	66889	0.9		
		750	66868	1.1	66890	1.2		
		900	66869	1.4	66891	1.4		
		1050	66870	1.6	66892	1.6		
		1200	66871	1.8	66893	1.9		
		1350	66872	2.1	66894	2.1		
		1500	66873	2.3	66895	2.3		
		1600	66874	2.4	66896	2.5		
		1800	66875	2.8	66897	2.8		
		2000	66876	3.0	66898	3.1		
		2200	66877	3.4	66899	3.4		
			350mm h x 35°		**350mm h x 35°**			
4.3	Rear Seal Plate	600	66636	6.8	66680	6.9		
		750	66637	8.6	66681	8.7		
		900	66638	10.5	66682	10.7		
		1050	66639	12.4	66683	12.7		
		1200	66640	14.5	66684	14.8		
		1350	66641	16.7	66685	17.0		
		1500	66642	18.9	66686	19.3		
		1600	66643	20.4	66687	20.8		
		1800	66644	23.9	66688	24.4		
		2000	66645	27.0	66689	27.5		
		2200	66646	30.7	66690	31.3		
			350mm h x 45°		**350mm h x 45°**			
4.3	Rear Seal Plate	600	66724	7.1	66768	7.2		
		750	66725	9.0	66769	9.2		
		900	66726	11.1	66770	11.4		
		1050	66727	13.4	66771	13.7		
		1200	66728	15.6	66772	15.9		
		1350	66729	18.2	66773	18.5		
		1500	66730	20.8	66774	21.2		
		1600	66731	22.6	66775	23.0		
		1800	66732	26.8	66776	27.3		
		2000	66733	30.4	66777	31.0		
		2200	66734	34.9	66778	35.6		

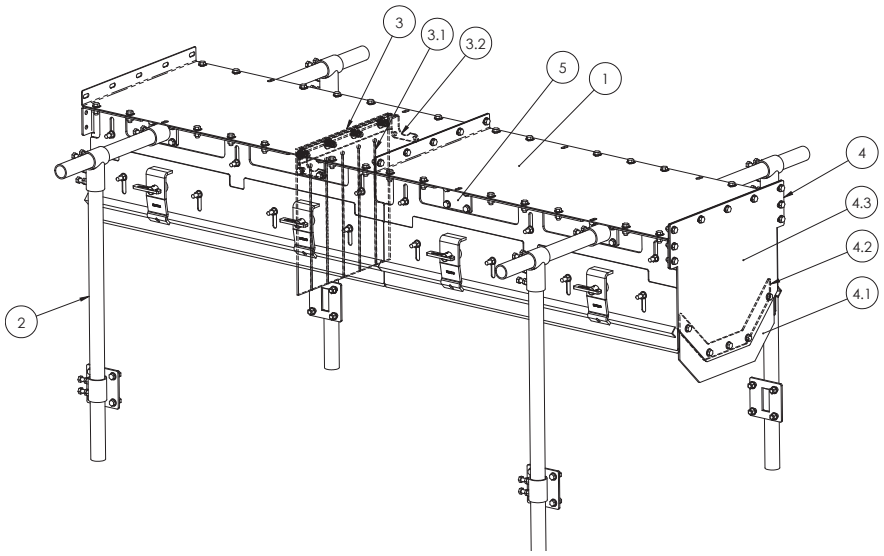
Section 8 - Replacement Parts List con't.



Replacement Parts

REF	DESCRIPTION	BELT WIDTH	MILD STEEL ITEM CODE	MILD STEEL WT. KG.	STAINLESS STEEL ITEM CODE	STAINLESS STEEL WT. KG.	ALUMINUM ITEM CODE	ALUMINUM WT. KG.
			400mm h x 35°		**400mm h x 35°**			
4.3	Rear Seal Plate	600	66647	7.6	66691	7.8		
		750	66648	9.6	66692	9.8		
		900	66649	11.7	66693	11.9		
		1050	66650	13.9	66694	14.1		
		1200	66651	16.1	66695	16.4		
		1350	66652	18.5	66696	18.8		
		1500	66653	21.0	66697	21.3		
		1600	66654	22.5	66698	23.0		
		1800	66655	26.4	66699	26.9		
		2000	66656	29.6	66700	30.2		
		2200	66657	33.6	66701	34.2		
			400mm h x 45°		**400mm h x 45°**			
4.3	Rear Seal Plate	600	66735	7.9	66779	8.1		
		750	66736	10.1	66780	10.3		
		900	66737	12.4	66781	12.6		
		1050	66738	14.8	66782	15.1		
		1200	66739	17.3	66783	17.6		
		1350	66740	20.0	66784	20.4		
		1500	66741	22.8	66785	23.2		
		1600	66742	24.7	66786	25.2		
		1800	66743	29.2	66787	29.8		
		2000	66744	33.0	66788	33.6		
		2200	66745	37.8	66789	38.5		
			450mm h x 35°		**450mm h x 35°**			
4.3	Rear Seal Plate	600	66658	8.5	66702	8.6		
		750	66659	10.6	66703	10.8		
		900	66660	12.9	66704	13.2		
		1050	66661	15.3	66705	15.6		
		1200	66662	17.7	66706	18.0		
		1350	66663	20.3	66707	20.7		
		1500	66664	23	66708	23.4		
		1600	66665	24.7	66709	25.1		
		1800	66666	28.8	66710	29.3		
		2000	66667	32.2	66711	32.8		
		2200	66668	36.5	66712	37.2		

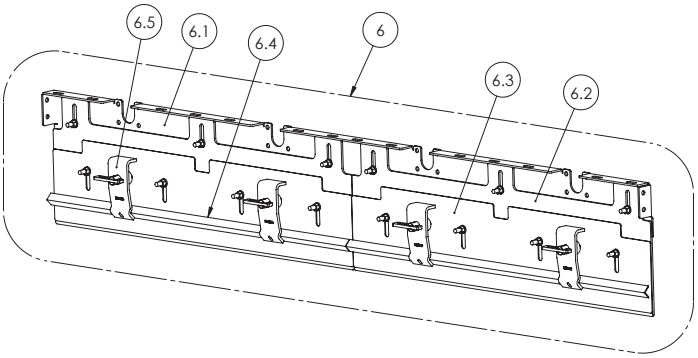
Section 8 - Replacement Parts List con't.

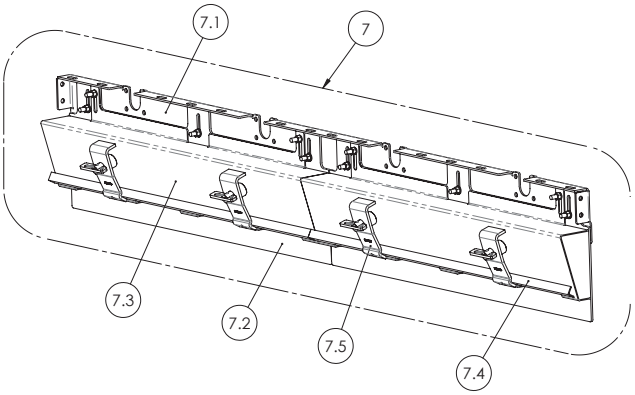


Replacement Parts

REF	DESCRIPTION	BELT WIDTH	MILD STEEL ITEM CODE	MILD STEEL WT. KG.	STAINLESS STEEL ITEM CODE	STAINLESS STEEL WT. KG.	ALUMINUM ITEM CODE	ALUMINUM WT. KG.
			450mm h x 45°		**450mm h x 45°**			
4.3	Rear Seal Plate	600	66746	8.7	66790	8.9		
		750	66747	11.1	66791	11.3		
		900	66748	13.6	66792	13.9		
		1050	66749	16.2	66793	16.5		
		1200	66750	18.9	66794	19.2		
		1350	66751	21.8	66795	22.2		
		1500	66752	24.8	66796	25.3		
		1600	66753	26.8	66797	27.4		
		1800	66754	31.6	66798	32.2		
		2000	66755	35.6	66799	36.3		
		2200	66756	40.7	66800	41.5		
			500mm h x 35°		**500mm h x 35°**			
4.3	Rear Seal Plate	600	66669	9.3	66713	9.5		
		750	66670	11.7	66714	11.9		
		900	66671	14.1	66715	14.4		
		1050	66672	16.7	66716	17.0		
		1200	66673	19.3	66717	19.7		
		1350	66674	22.1	66718	22.5		
		1500	66675	25.0	66719	25.4		
		1600	66676	26.8	66720	27.3		
		1800	66677	31.2	66721	31.8		
		2000	66678	34.9	66722	35.5		
		2200	66679	39.4	66723	40.2		
			500mm h x 45°		**500mm h x 45°**			
4.3	Rear Seal Plate	600	66757	9.6	66801	9.8		
		750	66758	12.1	66802	12.4		
		900	66759	14.8	66803	15.1		
		1050	66760	17.7	66804	18.0		
		1200	66761	20.5	66805	20.9		
		1350	66762	23.6	66806	24.1		
		1500	66763	26.8	66807	27.3		
		1600	66764	29.0	66808	29.5		
		1800	66765	34.0	66809	34.6		
		2000	66766	38.3	66810	39.0		
		2200	66767	43.6	66811	44.5		
5	Skirt Support Closeout Plate		66966	0.3	66967		66968	

Section 8 - Replacement Parts List con't.





REF	DESCRIPTION	WALL HEIGHT	MILD STEEL BISALLOY ITEM CODE	MILD STEEL BISALLOY WT. KG.	MILD STEEL GR350 ITEM CODE	MILD STEEL GR350 WT. KG.	STAINLESS STEEL BISALLOY ITEM CODE	STAINLESS STEEL BISALLOY WT. KG.	STAINLESS STEEL GR350 ITEM CODE	STAINLESS STEEL GR350 WT. KG.
6	1200mm Straight Skirt Wall	350	66280	36.5	66288	36.5	66977	36.6	66981	36.6
		400	66281	39.3	66289	39.3	66978	39.5	66982	39.5
		450	66282	42.2	66290	42.2	66979	42.4	66983	42.4
		500	66283	45.1	66291	45.1	66980	45.3	66984	45.3
	2400mm Straight Skirt Wall	350	66284	72.6	66292	72.6	66985	73.0	66989	73.0
		400	66285	78.4	66293	78.4	66986	78.7	66990	78.7
		450	66286	84.1	66294	84.1	66987	84.5	66991	84.5
		500	66287	89.8	66295	89.8	66988	90.2	66992	90.2

REF	DESCRIPTION	WALL HEIGHT	MILD STEEL ITEM CODE	MILD STEEL WT. KG.	STAINLESS STEEL ITEM CODE	STAINLESS STEEL WT. KG.
6.1	1200mm Skirt Top Plate		66296	9.6	66297	9.7
	2400mm Skirt Top Plate		66298	18.8	66299	19.2
6.2	1200mm Straight BIS450 Liner	350	66306	16.2		
		400	66307	19.1		
		450	66308	22.0		
		500	66309	24.8		
	1200 Straight Mild Steel Gr.350 Liner	350	66310	16.2		
		400	66311	19.1		
		450	66312	22.0		
		500	66313	24.8		
6.3	1200mm Straight Clamp Plate		66971	7.3		
6.4	1200mm Rubber Clamp Bar		75835	1.4		
6.5	RMC1 Skirt Clamp		RMC1-BPP	1.0		

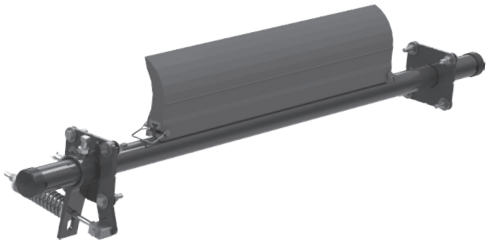
REF	DESCRIPTION	WALL HEIGHT	MILD STEEL BISALLOY ITEM CODE	MILD STEEL BISALLOY WT. KG.	MILD STEEL GR350 ITEM CODE	MILD STEEL GR350 WT. KG.	STAINLESS STEEL BISALLOY ITEM CODE	STAINLESS STEEL BISALLOY WT. KG.	STAINLESS STEEL GR350 ITEM CODE	STAINLESS STEEL GR350 WT. KG.
7	1200mm Tangential Skirt Wall	400	66268	42.5	66274	42.5	66812	42.7	66818	42.7
		450	66269	45.4	66275	45.4	66813	45.6	66819	45.6
		500	66270	48.3	66276	48.3	66814	48.4	66820	48.4
	2400mm Tangential Skirt Wall	400	66271	84.7	66277	84.7	66815	85.1	66821	85.1
		450	66272	90.5	66278	90.5	66816	90.8	66822	90.8
		500	66273	96.2	66279	96.2	66817	96.6	66823	96.6

REF	DESCRIPTION	WALL HEIGHT	MILD STEEL ITEM CODE	MILD STEEL WT. KG.	STAINLESS STEEL ITEM CODE	STAINLESS STEEL WT. KG.
7.1	1200mm Skirt Top Plate		66296	9.6	66297	9.7
	2400mm Skirt Top Plate		66298	18.8	66299	19.5
7.2	1200 Tangential BIS450 Liner	400	66300	19.0		
		450	66301	21.9		
		500	66302	24.8		
	1200 Straight Mild Steel Gr.350 Liner	400	66303	19.0		
		450	66304	21.9		
		500	66305	24.8		
7.3	1200mm Tangential Clamp Plate		66970	10.2		
7.4	1200mm Rubber Clamp Bar		75835	1.4		
7.5	RMC1 Skirt Clamp		RMC1-BPP	1.0		

Section 9 - Other Flexco Products

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

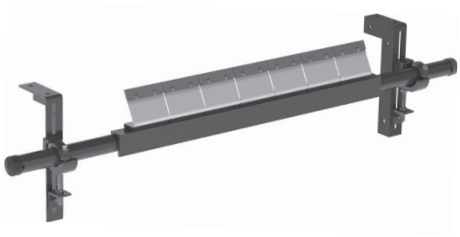


- Patented ConShear™ blade renews its cleaning edge as it wears
- Visual Tension Check™ for optimal blade tensioning and simple retensioning
- Quick and easy one-piin blade replacement Material Path Option™ for optimal cleaning and reduced maintenance

Flex-Lok™ Skirt Clamps

- Eliminates transfer zone spillage
- Interlocking design for easy installation and one person maintenance
- Unique wedge pin holds rubber securely in place and is easy to adjust
- Available in various models and in stainless steel

Rockline® EZS2 Secondary Cleaner

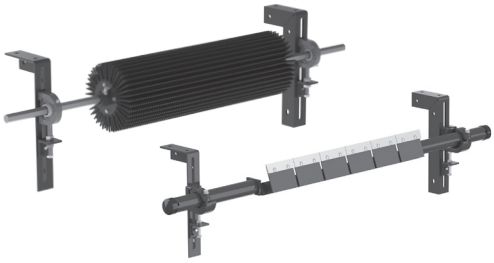


- Long-wearing tungsten carbide blades for superior cleaning efficiency
- Patented PowerFlex™ cushions independently tension each blade to the belt for consistent, constant cleaning power
- Easy to install, simple to service
- Works with Flexco mechanical belt splices

PT Max™ Belt Trainer

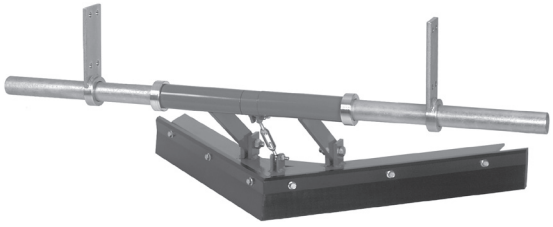
- Patented “pivot & tilt” design for superior training action
- Dual sensor rollers on each side to minimize belt damage
- Pivot point guaranteed not to seize or freeze up
- Available for topside and return side belts

Flexco Specialty Belt Cleaners



- “Limited space” cleaners for tight conveyor applications
- High Temp 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 Plows



- 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

The Flexco Vision

To become the leader in maximising
belt conveyor productivity for our customers worldwide
through superior service and innovation.

Visit **www.flexco.com** for other Flexco locations and products, or to find an authorised distributor.