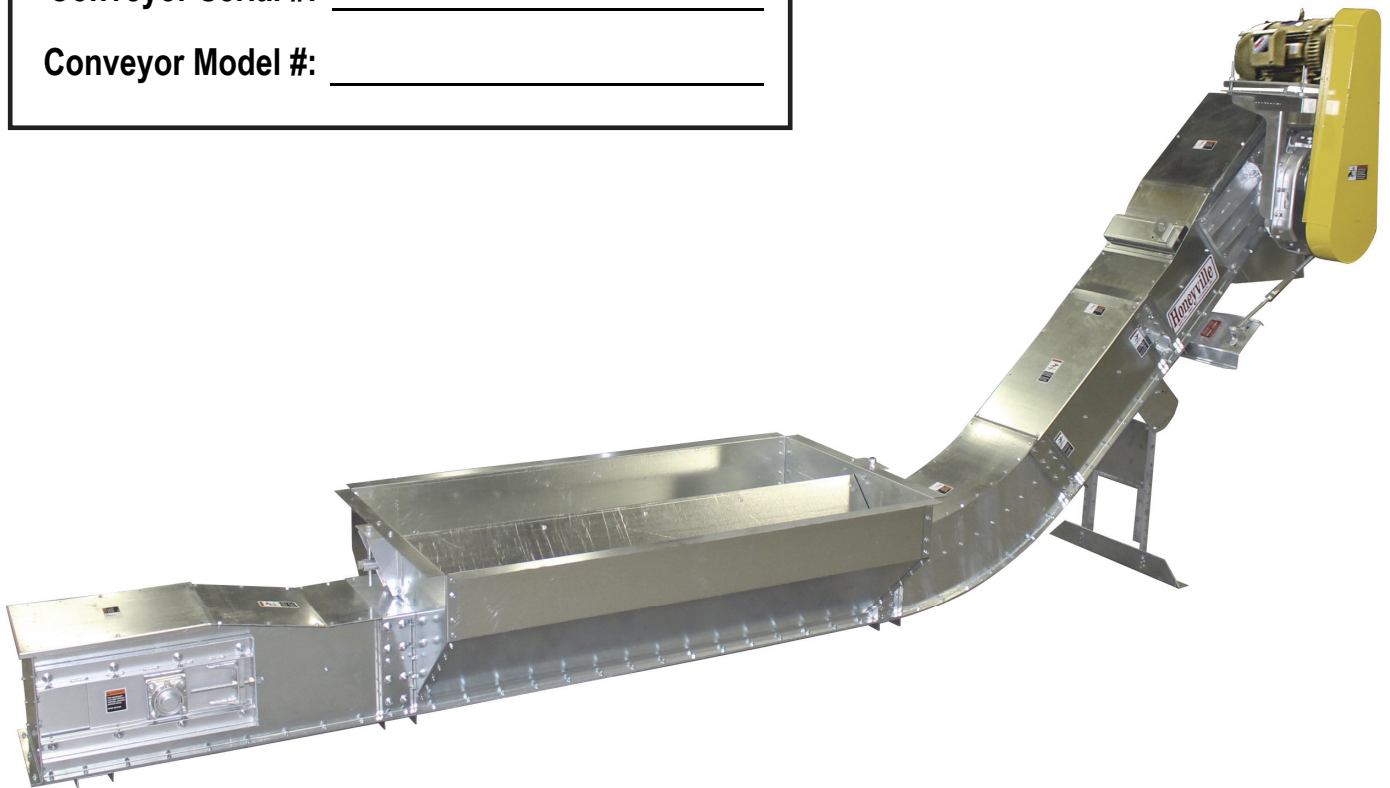




INCLINE DRAG CONVEYOR MANUAL

Dealer Name:	_____
Dealer Order #:	_____
Project Name:	_____
Honeyville Order #:	_____
Conveyor Serial #:	_____
Conveyor Model #:	_____



Honeyville Metal, Inc.
4200 S 900 W
Topeka, IN 46571

Phone (800) 593-8377
Fax (260) 593-2486
www.HoneyvilleMetal.com

**HONEYVILLE METAL, INC.
INCLINE DRAG CONVEYOR**

DEALER NAME:

MODEL:

SERIAL NO:

**HORIZONTAL
LENGTH:**

**DISCHARGE
HEIGHT:**

SPROCKETS:

PADDLE SIZE:

HEAD BEARINGS:

HEAD SHAFT:

HEAD HUB:

HEAD BUSHING:

TAIL BEARINGS:

TAIL SHAFT:

TAIL HUB:

TAIL BUSHING:

DRIVE INFORMATION:

HMI Supplied

Dealer/Customer Supplied

Model Reducer:

Reducer Sheave:

Motor Sheave:

Belts:

Motor:



WARNINGS AND SAFETY REMINDERS FOR SCREW, DRAG, AND BUCKET ELEVATOR CONVEYORS

CEMA Document: SC 2004-01

APPROVED FOR DISTRIBUTION BY THE SCREW CONVEYOR SECTION OF THE
CONVEYOR EQUIPMENT MANUFACTURERS ASSOCIATION ("CEMA")

Honeyville Metal, Inc. ("HMI") does not install conveyors. It is the responsibility of the contractor, installer, owner and user to install, maintain and operate the conveyor, components and, conveyor assemblies in such a manner as to comply with the Williams-Steiger Occupational Safety and Health Act and with all state and local laws and ordinances and the American National Standards Institute (ANSI) B20.1 Safety Code.

In order to avoid an unsafe or hazardous condition, the assemblies or parts must be installed and operated in accordance with the following minimum provisions.

1. Conveyors shall not be operated unless all covers and/or guards for the conveyor and drive unit are in place. If the conveyor is to be opened for inspection cleaning, maintenance or observation, the electric power to the motor driving the conveyor must be LOCKED OUT in such a manner that the conveyor cannot be restarted by anyone; however remote from the area, until conveyor cover or guards and drive guards have been properly replaced.
2. If the conveyor must have an open housing as a condition of its use and application, the entire conveyor is then to be guarded by a railing or fence in accordance with ANSI standard B20.1. (Request current edition and addenda)
3. Feed openings for shovel, front loaders or other manual or mechanical equipment shall be constructed in such a way that the conveyor opening is covered by a grating. If the nature of the material is such that a grating cannot be used, then the exposed section of the conveyor is to be guarded by a railing or fence and there shall be a warning sign posted.
4. Do not attempt any maintenance or repairs of the conveyor until power has been LOCKED OUT.
5. Always operate conveyor in accordance with these instructions and

those contained on the caution labels affixed to the equipment.

6. Do not place hands, feet, or any part of your body, in the conveyor.
7. Never walk on conveyor covers, grating or guards.
8. Do not use conveyor for any purpose other than that for which it was intended.
9. Do not poke or prod material into the conveyor with a bar or stick inserted through the openings.
10. Keep area around conveyor drive and control station free of debris and obstacles.
11. Eliminate all sources of stored energy (materials or devices that could cause conveyor components to move without power applied) before opening the conveyor.
12. Do not attempt to clear a jammed conveyor until power has been LOCKED OUT.
13. Do not attempt field modification of conveyor or components.
14. Conveyors are not normally manufactured or designed to handle materials that are hazardous to personnel. These materials which are hazardous include those that are explosive, flammable, toxic or otherwise dangerous to personnel. Conveyors may be designed to handle these materials. Conveyors are not manufactured or designed to comply with local, state or federal codes for unfired pressure vessels. If hazardous materials are to be conveyed or if the conveyor is to be subjected to internal or external pressure, manufacturer should be consulted prior to any modifications.

CEMA and HMI insist that disconnecting and locking out the power to the motor driving the unit provides the only real protection against injury. Secondary safety devices are available; however, the decision as to their need and the type required must be made by the owner-assembler as we have no information regarding plant wiring, plant environment, the interlocking of the

screw conveyor with other equipment, extent of plant automation, etc. Other devices should not be used as a substitute for locking out the power prior to removing guards or covers. We caution that use of the secondary devices may cause employees to develop a false sense of security and fail to lock out power before removing covers or guards. This could result in a serious injury should the secondary device fail or malfunction.

There are many kinds of electrical devices for interlocking of conveyors and conveyor systems such that if one conveyor in a system or process is stopped other equipment feeding it or following it can also be automatically stopped.

Electrical controls, machinery guards, railings, walkways, arrangement of installation, training of personnel, etc., are necessary ingredients for a safe working place. It is the responsibility of the contractor, installer, owner and user to supplement the materials and services furnished with these necessary items to make the conveyor installation comply with the law and accepted standards.

Conveyor inlet and discharge openings are designed to connect to other equipment or machinery so that the flow of material into and out of the conveyor is completely enclosed.

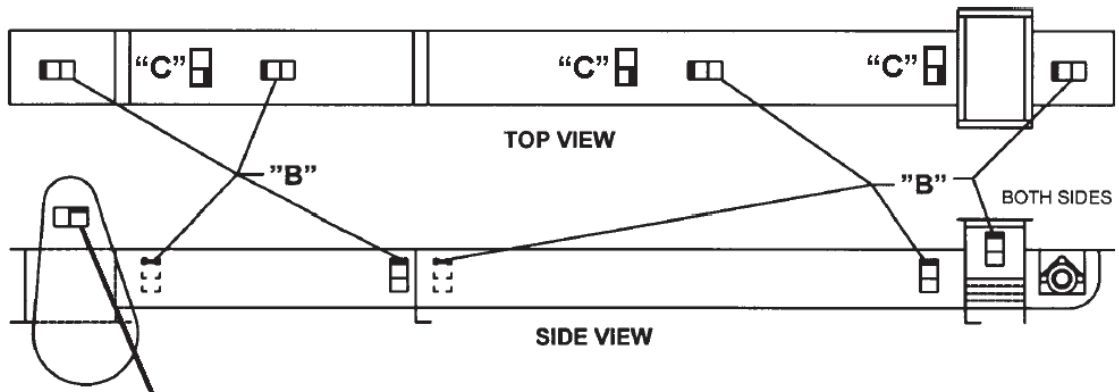
One or more warning labels should be visible on conveyor housings, conveyor covers and elevator housings. If the labels attached to the equipment become illegible, please order replacement warning labels from HMI or CEMA.

CEMA has produced an audio-visual presentation entitled "Safe Operation of Screw Conveyors, Drag Conveyors, and Bucket Elevators." CEMA and HMI encourage the acquisition and use of this source of safety information to supplement your safety program.

NOTICE: This document is provided by CEMA as a service to the industry in the interest of promoting safety. It is advisory only and it is not a substitute for a thorough safety program. Users should consult with qualified engineers and other safety professionals. CEMA makes no representations or warranties, either expressed or implied, and the users of this document assume full responsibility for the safe design and operation of equipment.

CEMA Safety Label Placement Guidelines

Equipment: Drag Conveyor





"A"

To be placed on removable guards to warn that operation of the machinery with guards removed would expose chains, belts, gears, shafts, pulleys, couplings, etc. which create hazards

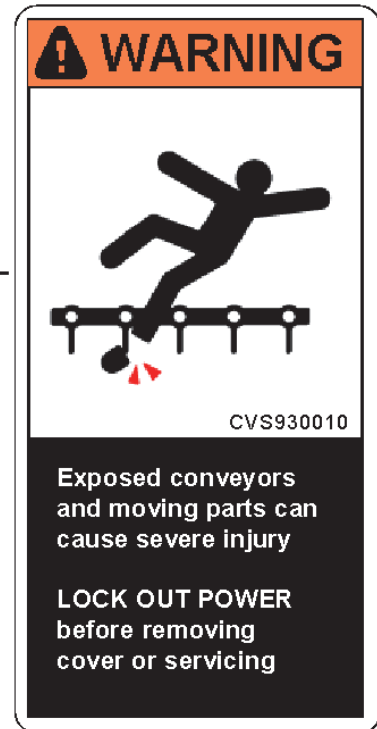


"C"

USE LABEL "A" ON BELT GUARD
USE LABEL "B" ON ENDS OF TROUGH, MIDDLE OF COVERS AND AT INLET OPENING.
USE LABEL "C": ON TOP OF COVERS

 NEAR SIDE
 FAR SIDE

To be placed on inlets and discharges, troughs, covers, and inspection doors of screw conveyors to provide warning against exposed moving parts while in operation.



"B"



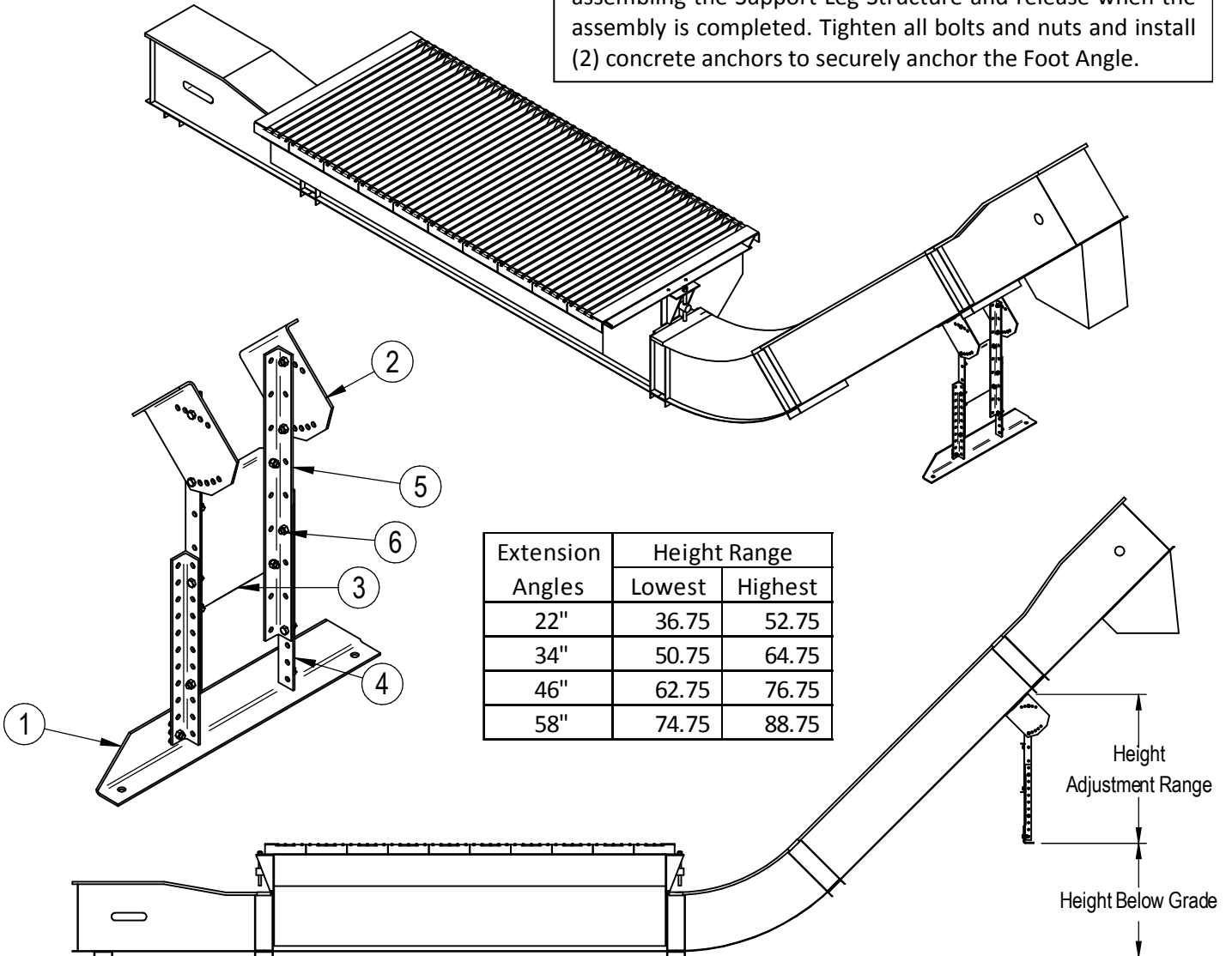
Note: Labels alone do not substitute for a thorough in-plant safety training program centered on the hazards associated with operating your installed equipment. Contact CEMA (www.cemanet.org) or Honeyville Metal, Inc. for replacement labels.

Honeyville Incline Drag Conveyor

The Adjustable Support Leg Structure is designed to accommodate Incline Drag Conveyors with varying discharge heights. Each Drag Conveyor assembly is supplied with an all bolted adjustable Support Leg Structure that can be installed at any point along the bottom of the Drag Conveyor Incline Section other than at the location of the Trunk Section Splice Channels.

Assembly instructions:

Attach the Main Brackets (Item 2) and determine which pivot bolt holes that you will be using based on the degree of the incline. Next attach the Main Angles (Item 5) and install the Brace Plate (Item 3) to create a stabilized upper assembly. The remaining space below this assembly is a variable and with the Extension Angles (Item 4) you will complete the connection onto the Foot (Item 1). With the 2" hole spacing on the Extension Angles and the 1/2" hole spacing on the Foot you can achieve a proper fit of the Leg Structure. You may want to use a hydraulic jack to apply some lift pressure under the Conveyor Head Section while assembling the Support Leg Structure and release when the assembly is completed. Tighten all bolts and nuts and install (2) concrete anchors to securely anchor the Foot Angle.



Item	Description	HD-F13IC	HD-F16IC	HD-F22IC
1	Foot: 1/4" HR	A = 36"	A = 39"	A = 45"
2	Main Bracket: 1/4" HR	(1) Right Hand and (1) Left Hand		
3	Brace Plate: 14 Ga Galv.	B = 11 ³ / ₄ ", C = 10 ¹ / ₄ "	B = 14 ³ / ₄ ", C = 13 ¹ / ₄ "	B = 20 ³ / ₄ ", C = 19 ¹ / ₄ "
4	Extension Angles *	(2) 2" x 2" x 1/4" x 22"		
5	Main Angles	(2) 2" x 2" x 1/4" x 34"		
6	1/2" x 1/4" Bolt & Nut	(14) Required		
7	Height Below Grade	33" w/Grates	33" w/Grates	40" w/Grates

* Extension Angles available in the following lengths: 22", 34", 46" & 58"

