

Glass Equipment Development 1943 Midway Drive Twinsburg, Ohio 44087	Document No. APN-0027	Revision Level: A	Date: 09/19/02
Description: GED Intergrid Payout Conveyor Extension Assembly Procedure			
Written By: Tim Smith			
Approved By: Bill Briese			
	Changed By:	Date:	

GED Intergrid Payout Conveyor Conveyor Extension Assembly Procedure

This procedure provides work instructions for the following:

- 1) Upgrades intergrid payout conveyor (P/N 1-13411) to facilitate production of muntins produced in excess of 108 inches, and up to 156 inches. This upgrade requires use of GED upgrade kit P/N K500-0086.

1.0 SCOPE

The original design of the GED Intergrid Payout Conveyor has been supplemented to facilitate the installation of the GED Intergrid Payout Conveyor Extension Kit (P/N K500-0086).

The purpose of the conveyor extension is to provide lineal support for, and organized transfer of, muntins produced in excess of 108 inches in length. The conveyor extension prevents the material from becoming bent or twisted as it exits the standard payout conveyor.

The material support and transfer is accomplished by adding an extended frame containing two additional support belt assemblies and an extended material guide to the existing Intergrid payout conveyor. The extended material guide provides lineal support of the extended material lengths as they are being fed from the Intergrid rollformer into the payout conveyor assembly. After the cutoff operation has been performed the extended conveyor provides lineal support, transfer, and offload capability to the extended material lengths without damaging the material.

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2.0 Applicable Drawings:

- 1- 13411 (Existing Payout Conveyor DWG.)
- 5-14519 (Payout Conveyor Extension Kit DWG.)

3.0 Tools and Materials:

- 1) Set of standard hex wrenches
- 2) Set of metric hex wrenches
- 3) Socket wrench w/ 9/16 socket
- 4) Adjustable wrench (10" minimum)
- 5) 1 3/4" open end wrench or equivalent
- 6) Machine level
- 7) Flathead screwdriver
- 8) Straight edge approximately 100" (a straight piece of muntin works well for this)

4.0 GED Payout Conveyor Extension Upgrade Parts (P/N K500-0086)

4.1 Prepare The Existing Payout Conveyor:

- 1) Remove the applicable guards and gates so there is free access to the work end of the existing conveyor and a reasonable amount of work area to perform the conveyor extension installation.
- 2) Remove the pulley guard from the existing conveyor and set aside.
- 3) Loosen the taperlock on the existing conveyor pulley furthest from the rollformer.
- 4) Loosen the set screws located on bearing at the drive shaft support flange furthest from rollformer.
- 5) Loosen the conveyor drive motor belt tension screws. Slide the motor forward just enough to relieve the tension on the drive belt. Once the tension is relieved retighten the motor.

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- 6) Refer to the top view of the Frame Assembly drawing (DWG.# 5-14519). Remove the (6) 3/16-18 SHCS from the conveyor assembly support plates. Leave the support plates attached to the conveyor assembly. Note: Support the conveyor assembly to insure that it does not fall away from its existing position.
- 7) After removing the conveyor assembly support plate screws from the frame raise the conveyor assembly above the mounting plates and slide the assembly down the drive shaft towards the rollformer until the conveyor assembly is on the opposite side of the mounting plates. Using the T-nuts (supplied with the kit) reattach the conveyor assembly to the mounting plates.
- 8) Tighten the mount screws and the bearing set screws.
- 9) Refer to drawing 5-14519 Section D-D. Replace the upper and lower frame mounting brackets using the 90 degree gussets (P/N 150-1354), and the T-nuts supplied with the kit. For ease of installation the gussets should be installed prior to removing the existing frame mounting brackets. After removing the existing frame mounting brackets they may be discarded.
- 10) The existing conveyor frame is now ready to be coupled with the conveyor extension kit.

4.2 Mounting The GED Intergrid Payout Conveyor Extension Kit To The Existing Itergrid Payout Conveyor

- 1) Loosen the mounting screws for the 90 degree gussets pre-mounted near the open end of conveyor extension.
- 2) Slide the gussets forward until the flat edge of the gussets that are to be mounted to the existing conveyor frame are flush with the edge of the extended conveyor frame rail.
- 3) Lightly tighten the gussets.
- 4) Remove the pulley guard and set aside.
- 5) Refer to the Frame Assembly section of drawing 5-14519. Slide the conveyor extension into position so that the extended conveyor gussets line up with the existing conveyor frame.
- 6) With the T-nuts provided, mount the extended conveyor frame to the existing conveyor frame. NOTE: Be sure extended conveyor frame is flush and aligned with top and bottom frame rails on existing conveyor frame.
- 7) Tighten all T-nuts.

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- 8) Using a quality machine level, level the extended conveyor.
- 9) Loosen the conveyor drive motor and slide the motor back, tension the drivebelt and retighten the motor.
- 10) Using a straightedge that will reach across existing conveyor, and fit between conveyor tabs, align the conveyor belts on the existing conveyor.
- 11) Tighten the existing conveyor pulley furthest from the rollformer (previously loosened in the existing conveyor set up procedure). NOTE: Be sure the pulley to belt / belt to belt alignment is not compromised during this tightening procedure. This taper lock pulley tends to drift during tightening. It is recommended a spacer be used to prevent the pulley from drifting out of alignment.
- 12) Using the straightedge, align the conveyor belt tabs on the extended conveyor with the conveyor belt tabs on the existing conveyor.
- 13) Loosen and slide the drive shaft coupler across the extended conveyor drive shaft toward and over the existing conveyor drive shaft until one half of the coupler is over existing conveyor drive shaft.
- 14) Tighten the drive shaft coupler from the inside screws to the outside screws.
- 15) Verify the alignment of the conveyor belts.
- 16) Verify all of the pulleys are tight.

4.3 Adjust The Extended Conveyor Material Guides

- 1) Locate the material guides. Refer to Detail C of the Conveyor Assembly section of drawing 5-14519.
- 2) Feed the material through existing conveyor using the rollformer jog switch. NOTE: Stop just short of the conveyor extension material guide.
- 3) Visually inspect area where the existing conveyor material guide, and the extended conveyor material guide meet. Be sure there is enough clearance to pass material into extended conveyor material guide without any obstruction. If an obstruction exists determine source of the obstruction and correct.
- 4) Adjust the extended conveyor material guides to meet the material from one end of the guide to the other without redirecting the material flow in such a way as to bend or deform the material.

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5.0 Check The Machine Operation

- 1) Run a series of 156 inch muntins.
- 2) Confirm the Intergrid machine is operating properly and producing a quality muntin according to the material specifications. Material specifications are provided by GED and are available in the GED Intergrid manual.
- 3) Replace all guards and gates.