

# Assembly/Operating Instructions with Parts List



Bulletin No. 481

**MODEL  
PC**

**December, 2000**

(Supersedes April, 1998)

RECOMMENDED SPARE PARTS LIST HIGHLIGHTED IN GRAY

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## MODEL "PC" PARTS CONVEYOR PORTABLE OR PERMANENT

Usually the Model "PC" HYTROL Parts Conveyor is shipped completely assembled. The only procedure then is simply to move conveyor in place and connect the electrical controls to the power source. Because longer than listed sizes are available, the Model "PC" may be shipped knocked down. In this case, follow these instructions:

1. Remove all crating and strapping from crates. Check to see whether any loose foreign pieces, which could have dropped into conveyor during shipment, are removed.
2. Lay bed sections on floor, upside down and in sequence, according to number with all arrows pointing in the same direction.
3. Bolt bed sections together with splice plates and joint support angles.
  - a. When supplied with permanent floor supports, bolt one floor support to each end of conveyor bed.
  - b. When supplied with portable base, bolt portable base to angle brackets on bed sections.
4. Turn bed section assembly right side up.
5. Assemble belt around drive and tail pulleys, over slider pan, with arrows on bottom side of belt pointing in the same direction as arrows on top of bed sections. Pull belt until belt lacings are together and insert lacing pin.

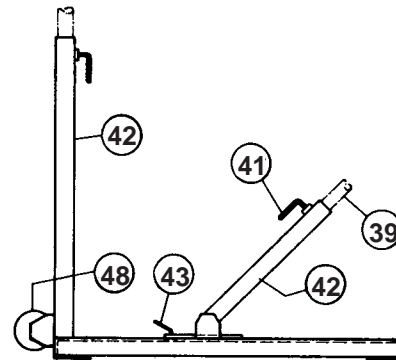
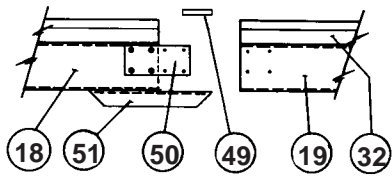
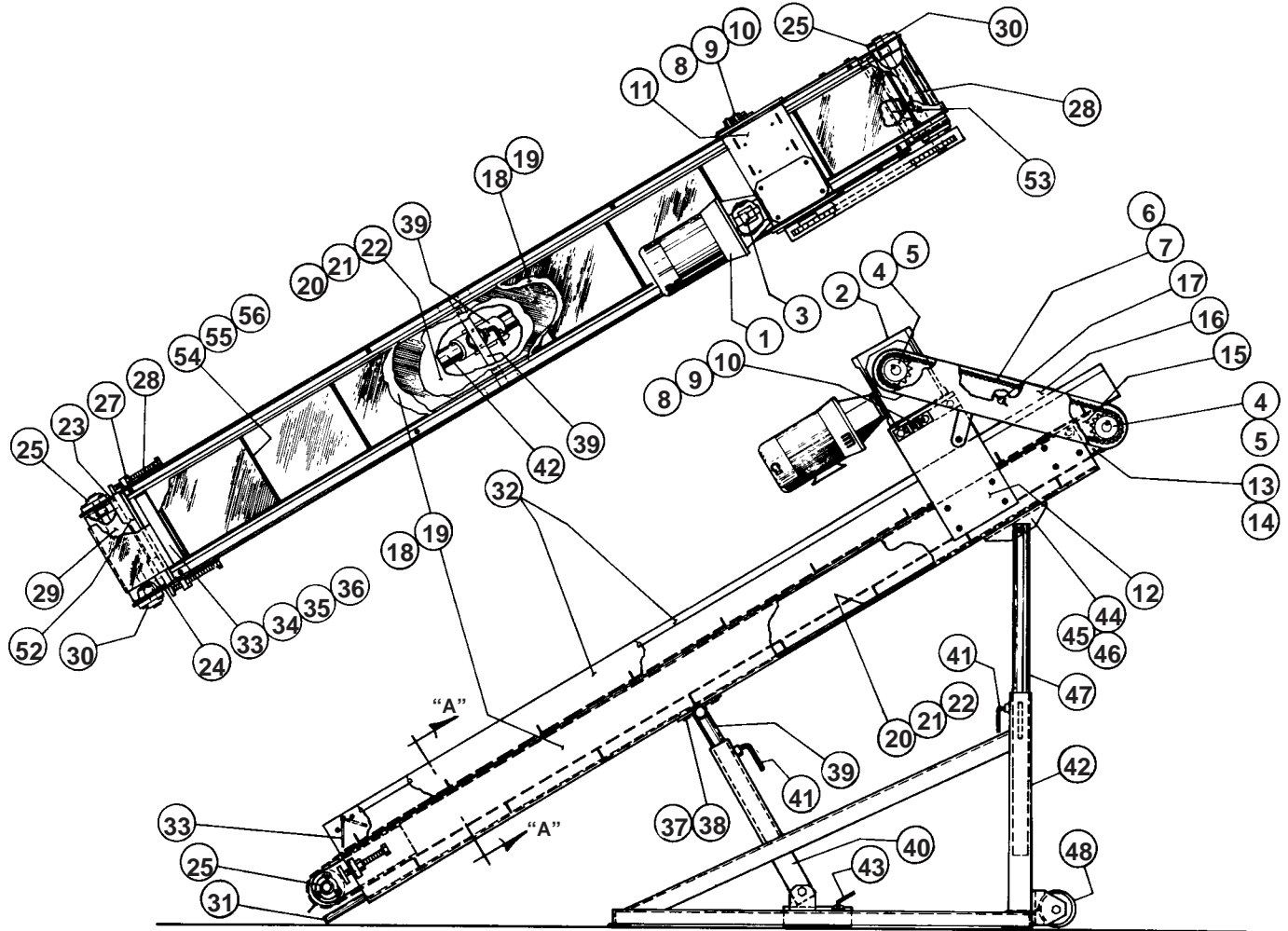
**BELT TENSION**—To insure maximum rated load capacity on conveyor belt, maintain enough tension so that drive pulley will not slip under belt when carrying full load. Screw take-ups on tail pulley will tighten belt. Because of climatic conditions or after lengthy service, it may be necessary to shorten belt and re-lace to maintain this tension. Alligator belt lacing is easily installed by following instructions provided with lacing.

**TRACKING THE BELT**—In the event the belt does not track, follow these instructions: Center belt on drive pulley. When belt is running toward drive end, if belt runs to the right side of tail pulley, move take-up out on right side. If belt runs to the left side of tail pulley, move take-up out on left side.

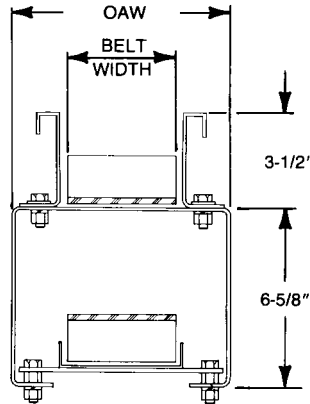
**DRIVE ROLLER CHAIN**—Can be adjusted by loosening speed reducer bolts and moving back with 3/8 in. take-up screw on base plate. Tighten speed reducer bolts before running. Remove a link out of chain if limit of adjustment is reached.

**LUBRICATION**—Drive and tail pulleys have sealed bearings greased for life. Keep roller chain oiled. Speed reducer is filled with SAE 90 (use lighter in freezing temperature) gear lubricant and sealed at the factory. If reducer runs too hot, check oil level.

# ● Model PC Parts Drawing



# ● Model PC Parts List



SECTION "A-A"

|                   |           |            |            |            |            |            |            |            |
|-------------------|-----------|------------|------------|------------|------------|------------|------------|------------|
| <b>Belt Width</b> | <b>4"</b> | <b>6"</b>  | <b>8"</b>  | <b>10"</b> | <b>12"</b> | <b>16"</b> | <b>18"</b> | <b>24"</b> |
| <b>OAW</b>        | <b>8"</b> | <b>10"</b> | <b>12"</b> | <b>14"</b> | <b>16"</b> | <b>20"</b> | <b>22"</b> | <b>28"</b> |

## RECOMMENDED SPARE PARTS LIST HIGHLIGHTED IN GRAY

| Ref. No. | Part No.    | Description                                       |
|----------|-------------|---|
| 1        | —           | Motor—C-Face                                      |
| —        | 030.7134    | 1/2 HP—230/460VAC—3 Ph.—60 Hz.—TEFC               |
| —        | 030.7244    | 3/4 HP—230/460VAC—3 Ph.—60 Hz.—TEFC               |
| —        | 030.7324    | 1 HP—230/460VAC—3 Ph.—60 Hz.—TEFC                 |
| 2        | —           | Speed Reducer                                     |
| —        | R-00153-30R | 4AC—RH—30:1 Ratio                                 |
| —        | R-00164-30R | 5AC—RH—30:1 Ratio                                 |
| 3        | 052.145     | Coupling Kit—Motor to Reducer (1/2-1 HP)          |
| 4        | —           | Sprocket  |
| —        | 028.115     | 50B15 x 1 in. Bore (4 AC)                         |
| —        | 028.117     | 50B15 x 1-1/4 in. Bore (5AC)                      |
| 5        | 090.203     | Shaft Key 1/4 in. Sq. x 1 in. Long                |
| 6        | 029.101     | #50 Riveted Roller Chain                          |
| 7        | 029.201     | Connector Link—#50 Roller Chain                   |
| 8        | B-06789     | Drive Take-Up Bracket                             |
| 9        | 040.307     | Take-Up Bolt—3/8-16 x 2-1/4 in. Long              |
| 10       | 041.300     | Hex Jam Nut—Heavy—3/8-16                          |
| 11       | B-06629     | Motor Base Assembly (Specify OAW)                 |
| 12       | B-07962     | Drive Support Side Plate                          |
| 13       | B-21423-L   | Drive Plate Assembly—LH                           |
| 14       | B-21423-R   | Drive Plate Assembly—RH                           |
| 15       | B-07961     | Chain Guard Back Plate Assembly                   |
| 16       | B-16265     | Chain Guard Front Plate Assembly                  |
| 17       | 041.919     | Acorn Nut—3/8-16                                  |
| 18       | —           | Bed Section Assembly                              |
| —        | B-02400     | 4 ft. Long for 5 ft. Model (Specify OAW)          |
| —        | B-02165     | 5 ft. Long for 6 ft. Model (Specify OAW)          |
| —        | B-02166     | 6 ft. Long for 7 ft. Model (Specify OAW)          |
| —        | B-02167     | 8 ft. Long for 9 ft. Model (Specify OAW)          |
| —        | B-02168     | 10 ft. Long for 11 ft. Model (Specify OAW)        |
| 19       | —           | Drive Bed Section                                 |
| —        | B-02045     | 6 ft. Long for 13 ft. Model (Specify OAW)         |
| 20       | —           | Slider Pan Assembly                               |
| —        | B-02401     | 4 ft. Long for 5 ft. Model (Specify Belt Width)   |
| —        | B-02175     | 5 ft. Long for 6 ft. Model (Specify Belt Width)   |
| —        | B-02176     | 6 ft. Long for 7 ft. Model (Specify Belt Width)   |
| —        | B-02177     | 8 ft. Long for 9 ft. Model (Specify Belt Width)   |
| —        | B-02178     | 10 ft. Long for 11 ft. Model (Specify Belt Width) |
| 21       | —           | Drive End Slider Pan                              |
| —        | B-08924     | 6 ft. Long for 13 ft. Model (Specify Belt Width)  |

| Ref. No. | Part No.    | Description  |
|----------|-------------|--|
| 22       | —           | Tail End Slider Pan  |
| —        | B-08922     | 6 ft. Long for 13 ft. Model (Specify Belt Width)           |
| 23       | B-00291-L   | Take-Up Plate Assembly—LH                                  |
| 24       | B-00291-R   | Take-Up Plate Assembly—RH                                  |
| 25       | 010.102     | 3-Bolt Flange Bearing—1 in. Bore                           |
| 26       | 040.409     | Take-Up Bolt—1/2-13 x 6 in. Long                           |
| 27       | 041.201     | Hex Jam Nut—1/2-13   |
| 28       | B-21417     | 4 in. Dia. Drive Pulley (Fully Lagged)(Spec. OAW)          |
| 29       | B-22221     | 4 in. Dia. Pulley (Specify OAW)                            |
| 30       | B-07987     | Bearing Spacer   |
| 31       | B-02170     | Take-Up Support Rod  |
| 32       | —           | Guard Rails  |
| —        | B-02059-003 | 53 in. Long for 5 ft. Model                                |
| —        | B-09350-003 | 60 in. Long for 11 ft. Model                               |
| —        | B-05555-003 | 65 in. Long for 6 ft. & 11 ft. Model                       |
| —        | B-09351-003 | 72 in. Long for 13 ft. Model                               |
| —        | B-09352-003 | 77 in. Long for 7 ft. & 13 ft. Model                       |
| —        | B-02180-003 | 101 in. Long for 9 ft. Model                               |
| 33       | B-02292     | Flapper Gate Assembly (Specify Belt Width)                 |
| 34       | B-16811     | Plastic Bumper   |
| 35       | 099.255     | Rubber Bumper  |
| 36       | 042.2072    | Flat Head Screw—#10-24 x 5/8 in. Long                      |
| 37       | B-02090     | Pivot Rod for Tail Support "T" (Specify OAW)               |
| 38       | —           | Tail Pivot Rod Bracket                                     |
| —        | B-16512     | 8 in. & 10 in. OAW   |
| —        | B-02093     | 12 in. thru 28 in. OAW                                     |
| 39       | —           | Tail Support "T"   |
| —        | B-02403     | 5 ft. Model (8 in. thru 20 in. OAW) (Specify)              |
| —        | B-02404     | 5 ft. Model (22 in. thru 28 in. OAW) (Specify)             |
| —        | B-02091     | 6 ft. Model (8 in. thru 20 in. OAW) (Specify)              |
| —        | B-02193     | 6 ft. Model (22 in. thru 28 in. OAW) (Specify)             |
| —        | B-02092     | 7 ft. thru 13 ft. Model (8 in. thru 20 in. OAW) (Specify)  |
| —        | B-02194     | 7 ft. thru 13 ft. Model (22 in. thru 28 in. OAW) (Specify) |
| 40       | —           | Tail Support Adjustment Tube                               |
| —        | B-02082-005 | 5 ft. Model  |
| —        | B-02082-006 | 6 ft. Model  |
| —        | B-02082-007 | 7 ft. Model  |
| —        | B-02082-009 | 9 ft. Model  |
| —        | B-02082-013 | 11 ft. & 13 ft. Model                                      |
| 41       | B-00804     | Locking Handle   |

# ● Model PC Parts List

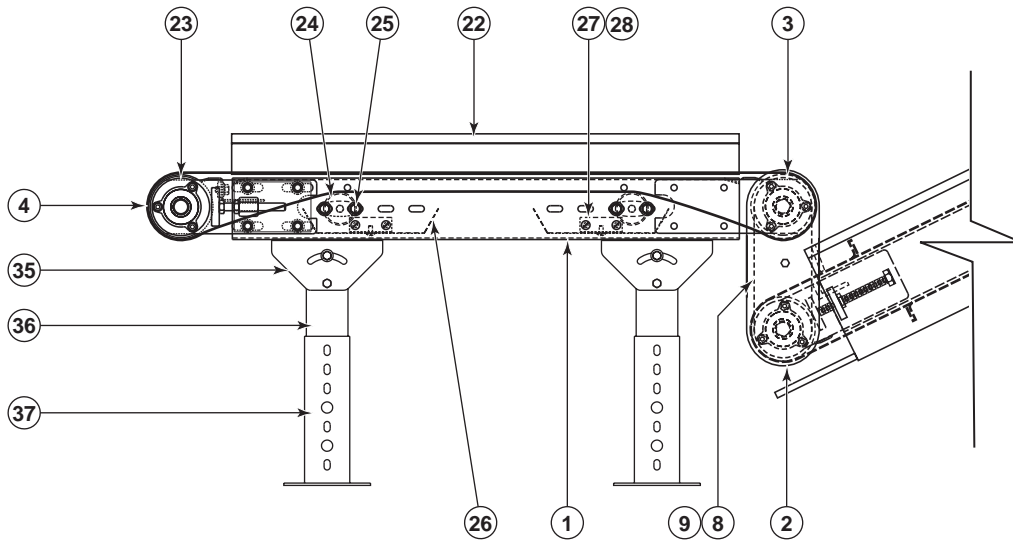
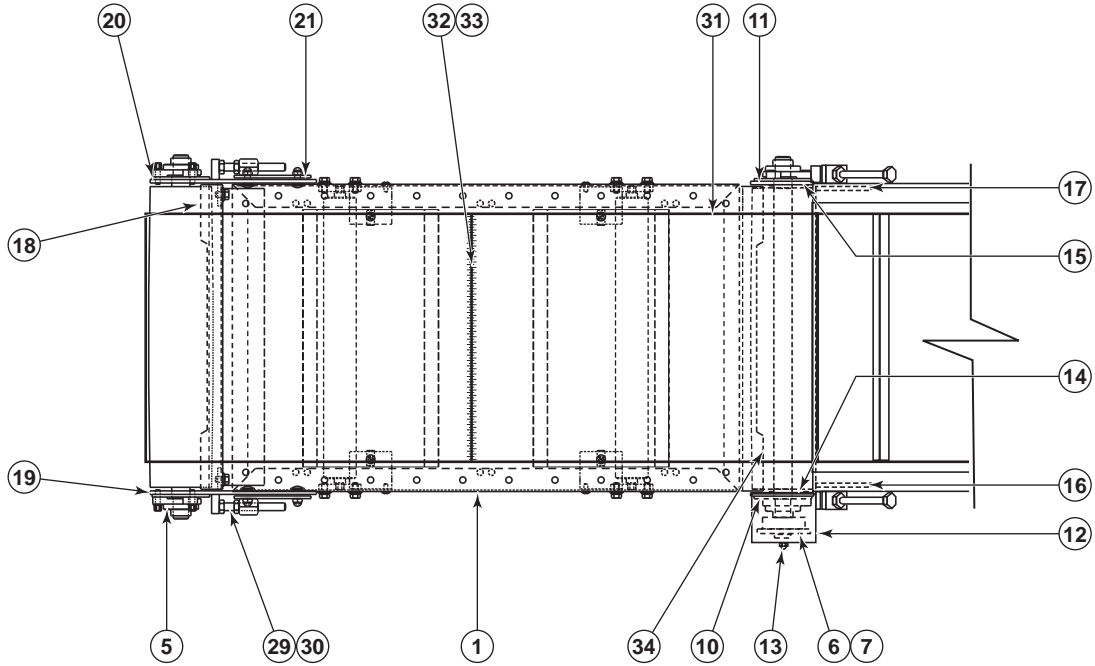


| Ref. No. | Part No.    | Description                             |
|----------|-------------|---|
| 42       | —           | Base Assembly—5 ft. Model               |
| —        | B-02405-012 | 8 in. & 10 in OAW                       |
| —        | B-02405     | 12 in. thru 20 in. OAW (Specify)        |
| —        | B-02406     | 22 in. thru 28 in. OAW (Specify)        |
| —        | —           | Base Assembly—6 ft. Model               |
| —        | B-02181-012 | 8 in. & 10 in OAW                       |
| —        | B-02181     | 12 in. thru 20 in. OAW (Specify)        |
| —        | B-02182     | 22 in. thru 28 in. OAW (Specify)        |
| —        | —           | Base Assembly—7 ft. Model               |
| —        | B-02183-012 | 8 in. & 10 in OAW                       |
| —        | B-02183     | 12 in. thru 20 in. OAW (Specify)        |
| —        | B-02184     | 22 in. thru 28 in. OAW (Specify)        |
| —        | —           | Base Assembly—9 ft. Model               |
| —        | B-02185-012 | 8 in. & 10 in OAW                       |
| —        | B-02185     | 12 in. thru 20 in. OAW (Specify)        |
| —        | B-02186     | 22 in. thru 28 in. OAW (Specify)        |
| —        | —           | Base Assembly—11 ft. & 13 ft. Models    |
| —        | B-02187-012 | 8 in. & 10 in OAW                       |
| —        | B-02187     | 12 in. thru 20 in. OAW (Specify)        |
| —        | B-02188     | 22 in. thru 28 in. OAW (Specify)        |
| 43       | B-02915     | Locking Handle for Tail Support Bracket |
| 44       | B-02197     | Pivot Plate—Drive End                   |
| 45       | —           | Pivot Rod—Upper Legs                    |
| —        | B-02195-012 | 8 in. & 10 in OAW                       |
| —        | B-02195     | 12 in. thru 28 in. OAW (Specify)        |
| 46       | B-02196     | Spacer—8 in. OAW Units Only             |
| 47       | —           | Upper Leg                               |
| —        | B-02085-005 | 5 ft. Model                             |
| —        | B-02089-006 | 6 ft. Model                             |
| —        | B-02089-007 | 7 ft. Model                             |

| Ref. No. | Part No.    | Description                                       |
|----------|-------------|---|
| —        | B-02089-009 | 9 ft. Model                                       |
| —        | B-02089-013 | 11 ft. & 13 ft. Models                            |
| 48       | 014.108     | 4 in. Dia. Steel Wheel with Axle Kit              |
| 49       | B-20465     | Attachment Strap                                  |
| 50       | B-01944     | Splice Plate (13 ft. Model)                       |
| 51       | B-00350     | Joint Support Angle (13 ft. Model)                |
| 52       | B-09859     | Nip Point Guard (Specify OAW)                     |
| 53       | B-18909     | Nip Point Guard (Specify OAW)                     |
| 54       | —           | Belt with 1-1/2 in. High Cleats on 12 in. Centers |
| —        | 069.550     | 4 in. Wide Belt—8 in. OAW                         |
| —        | 069.551     | 6 in. Wide Belt—10 in. OAW                        |
| —        | 069.552     | 8 in. Wide Belt—12 in. OAW                        |
| —        | 069.553     | 10 in. Wide Belt—14 in. OAW                       |
| —        | 069.554     | 12 in. Wide Belt—16 in. OAW                       |
| —        | 069.555     | 16 in. Wide Belt—20 in. OAW                       |
| —        | 069.556     | 18 in. Wide Belt—22 in. OAW                       |
| —        | 069.557     | 24 in. Wide Belt—28 in. OAW                       |
| 55       | —           | U4 Clipper Unibar Lacing (Specify Length)         |
| 56       | —           | #13 Lacing Pin (Specify Length)                   |



# ● Model PC Powered Feeder Parts Drawing



# ● Model PC Powered Feeder Parts List



## RECOMMENDED SPARE PARTS LIST HIGHLIGHTED IN GRAY

| Ref. No. | Part No.  | Description                                    |
|----------|-----------|--|
| 1        | —         | Bed Assembly                                   |
| —        | B-24782   | 18 in. Long (8 in. thru 16 in. OAW) (Specify)  |
| —        | B-24780   | 33 in. Long (20 in. thru 30 in. OAW) (Specify) |
| 2        | —         | Conveyor Tail Pulley                           |
| —        | B-04309   | 4 in. Dia. (8 in. thru 20 in. OAW) (Specify)   |
| —        | B-04310   | 4 in. Dia. (24 in. thru 30 in. OAW) (Specify)  |
| 3        | —         | Feeder Drive Pulley                            |
| —        | B-22222   | 4 in. Dia. (Specify OAW)                       |
| 4        | —         | Feeder Tail Pulley                             |
| —        | B-22221   | 4 in. Dia. (Specify OAW)                       |
| 5        | 010.102   | Bearing—3-Bolt Flange, 1 in. Bore              |
| 6        | 028.133   | Sprocket—50B14 x 1 in. Bore                    |
| 7        | 090.203   | Shaft Key—1/4 in. Sq. x 1 in. Long             |
| 8        | 029.101   | #50 Riveted Roller Chain                       |
| 9        | 029.201   | Connector Link—#50 Roller Chain                |
| 10       | B-11517   | Pivot Bracket Assembly—RH                      |
| 11       | B-08211   | Pivot Bracket—LH                               |
| 12       | B-11516   | Chain Guard                                    |
| 13       | 041.919   | Acorn Nut—3/8-16                               |
| 14       | B-09759-R | Feeder Drive Plate—RH                          |
| 15       | B-09759-L | Feeder Drive Plate—LH                          |
| 16       | B-00291-R | Conveyor Take-Up Plate—RH                      |
| 17       | B-00291-L | Conveyor Take-Up Plate—LH                      |
| 18       | B-09859   | Nip Point Guard (Specify OAW)                  |
| 19       | B-19616-R | Feeder Take-Up Plate—RH                        |
| 20       | B-19616-L | Feeder Take-Up Plate—LH                        |
| 21       | B-19619   | Attachment Plate Assembly                      |
| 22       | B-18916   | PC Type A Guards Rail                          |
| 23       | B-07987   | Bearing Spacer                                 |
| 24       | B-06742   | 2-1/8 in. Dia. Snub Roller (Specify OAW)       |

| Ref. No. | Part No. | Description                                |
|----------|----------|--|
| 25       | 093.215  | Return Roller Bracket                      |
| 26       | B-14443  | Snub Roller Guard (Specify OAW)            |
| 27       | B-14445  | Snub Roller Guard Mounting Bracket         |
| 28       | 049.310  | U-Type Speed Nut—1/4-20                    |
| 29       | 040.407  | Take-Up Bolt—1/2-13 x 4 in. Long           |
| 30       | 041.201  | Hex Jam Nut—1/2-13                         |
| 31       | —        | Belt—Black Trackmate 140 BOS (Spec. Width) |
| 32       | —        | #2 Unibar Lacing (Specify Length)          |
| 33       | —        | #13 Lacing Pin (Specify Length)            |
| 34       | B-18909  | Nip Point Guard (Specify OAW)              |
| 35       | —        | MS Type Pivot Plate—1-1/2 in. Flange       |
| —        | B-00913  | 3-11/16 in. High                           |
| —        | B-02112  | 1-9/16 in. High                            |
| 36       | —        | Floor Support Frame                        |
| —        | B-00914  | 6 in. High (Specify OAW)                   |
| —        | B-12777  | 7 in. High (Specify OAW)                   |
| —        | B-12778  | 8 in. High (Specify OAW)                   |
| —        | B-00915  | 9 in. High (Specify OAW)                   |
| —        | B-00916  | 11-1/2 in. High (Specify OAW)              |
| —        | B-00917  | 14-1/2 in. High (Specify OAW)              |
| —        | B-02098  | 18-1/2 in. High (Specify OAW)              |
| —        | B-00919  | 22-1/2 in. High (Specify OAW)              |
| —        | B-00921  | 32-1/2 in. High (Specify OAW)              |
| —        | B-00923  | 44-1/2 in. High (Specify OAW)              |
| —        | B-00925  | 56-1/2 in. High (Specify OAW)              |
| —        | B-02107  | 68-1/2 in. High (Specify OAW)              |
| —        | B-02109  | 78-1/2 in. High (Specify OAW)              |
| —        | B-02111  | 90-1/2 in. High (Specify OAW)              |
| 37       | B-00911  | Adjustable Foot Assembly (Specify Length)  |



**HYTROL CONVEYOR COMPANY, INC.**  
**2020 Hytrol Drive**  
**Jonesboro, Arkansas 72401**

**Phone: (870) 935-3700**

[www.hytrol.com](http://www.hytrol.com)

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