



# ASHLAND CDLR16F-17F Chain Driven Live Rollers Installation Guide

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**ASHLAND CDLR16F-17F Chain Driven Live Rollers**



## WARNING LABELS

In an effort to reduce injury, warning labels have been placed at various locations on the conveyor. Please check for and note all labels. Make sure personnel are alerted to and follow warning labels.

- Placed on removable chain guard.



- Placed at a maximum of 20 feet both sides.



- Placed at a maximum of 20 feet both sides.



- Placed on inside of chain guard.



## Receiving & Uncrating

- Examine the condition of the equipment for any damage which may have occurred during shipment or for any missing parts. Notify the carrier immediately concerning damaged or missing parts.
- This product is normally shipped as:
  - One section if 10 feet or less

- Two or more sections if longer than 10 feet
- Drive section
- Slave sections if required
- All product is normally supplied on one skid

3. Unpack product at area of assembly.

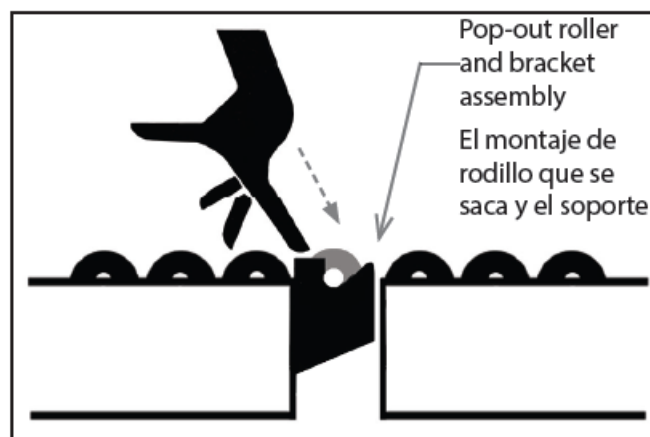
**Important:** The gear box (reducer) is shipped with the vent plug uninstalled. The vent plug is included with the gear box documentation and conveyor manual. Remove the solid plug and install the plastic vent plug in the location shown (see lubrication section).

## Installation Safety

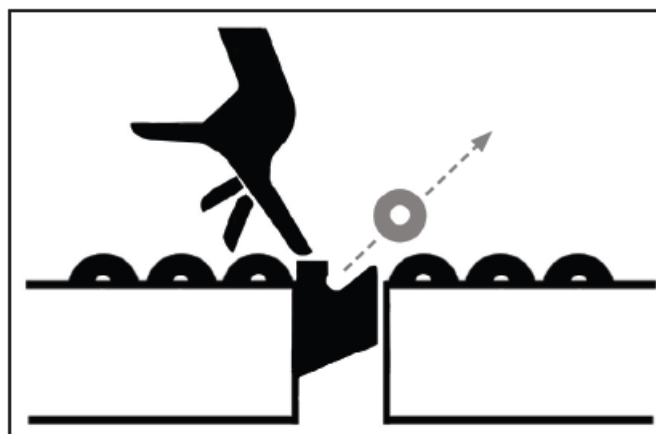
If this product is interfaced with other conveyors, machinery, or equipment, precautions must be taken. Placing this conveyor close to other conveyors or equipment may cause a hazardous pinch point.



This type of installation requires a pop-out roller and bracket assembly. This helps to protect personnel from entangling limbs between the power conveyor and other pieces of equipment.



Contact an Ashland Conveyor Products' representative to select the correct pop-out roller and bracket assembly.

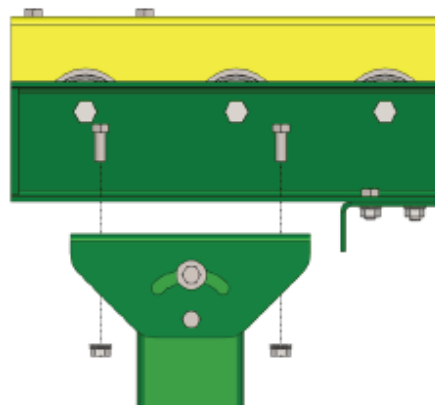


## Assembly

1. The drive section must be placed as close to the center of the conveyor run as possible. For example, if there are two slave sections the drive section must be placed in between the two slave sections.
2. Preassemble floor supports to the correct heights.
3. Attach floor supports to both ends of conveyor drive section, and at one end of any slave sections if required. Additional supports may be required at the center of each conveyor section if live loads dictate additional supports. Tighten bolts. One support is used to span the mating ends of a drive and slave section.
4. If attaching slave sections remove chain guards and remove chain end guards between sections so rollers can be chained together.
5. Attach butt plates together with included hardware if the conveyor system has multiple sections.
6. Adjust floor support height if necessary.



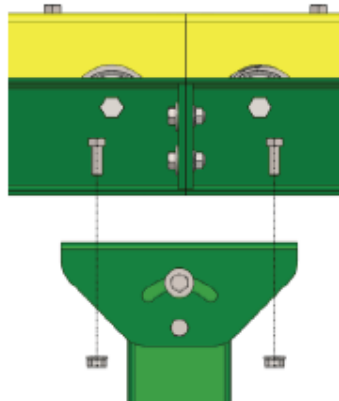
- End Support Attachment Fin



- Chain End Guard



- Slave Support Attachment



- Chain End Guard Removed



- Butt Plate Connection



7. The motor has been shipped separate from the reducer. You will find the motor in its original box. The motor was shipped separate to reduce the possibility of shipping damage. Remove the motor from the box, along with the shaft key, attaching bolts, and never-seize lubricant.
8. Rub the never-seize in the reduce bore where the motor shaft will be inserted. This is to keep the motor shaft from “sticking” to the reducer incase it ever needs to be removed.
9. Insert the motor key into the motor keyway, align motor shaft to reduce and slide the motor onto the reducer. Line-up the mounted holes, insert bolts, and tighten.
10. Motor rotation is determined when wired. The electrician will be able to reverse the motor rotation if necessary.

- Reducer as Shipped Without Motor Attached

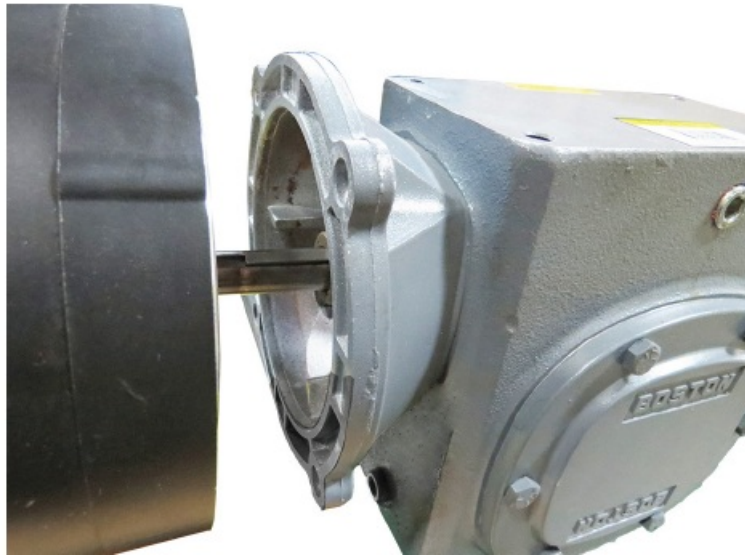


- Motor Shaft with Key Placed in Keyway



- Aligning Motor to Reducer





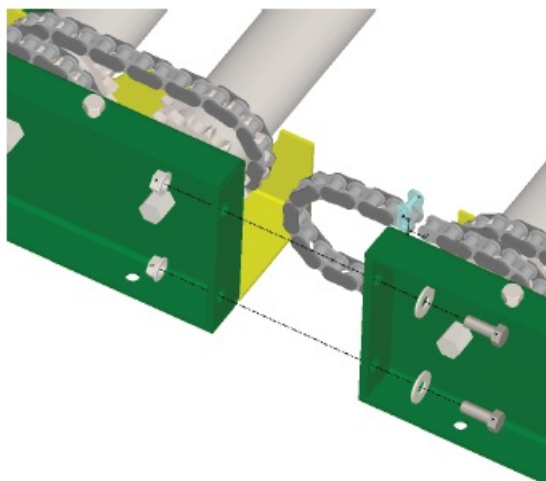
- Motor Bolted to Reducer



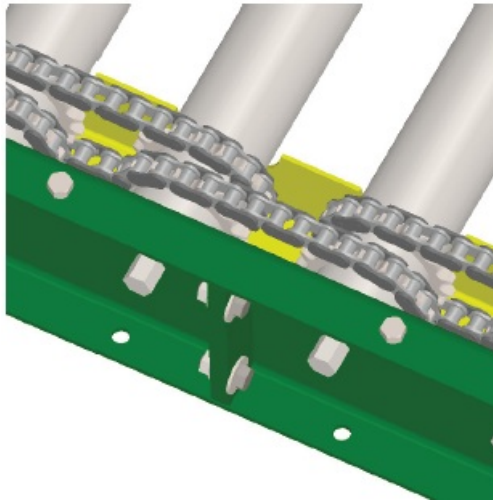
## Connecting Sections

1. With the chain guards removed, loop the roller chain provided with the slave section around the roller sprockets of the connecting sections.
2. Connect the ends of the chain loop with the provided master link.
3. Reinstall all chain guards. An chain end guard should be present at the beginning and end of the CDLR run.

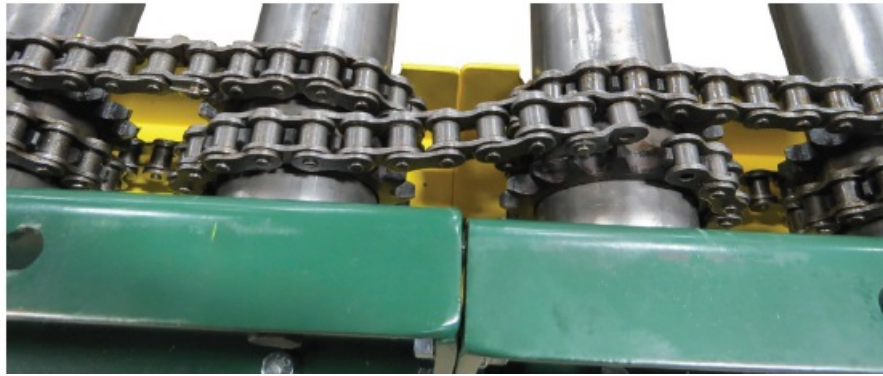
- Connect Slave Section



- Loop Roller Chain Around Sprockets – Connect Master Link Loop Roller



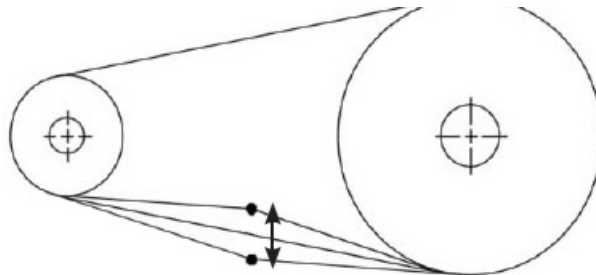
- Installing Roller Chain Connecting Slave Section



## Before Start-Up

1. Check the drive roller chain for proper tension. The total drive chain slackness should be about 3/8" to 1/2". Check sprocket alignment by placing a straight edge along face of sprockets, adjust if necessary by loosening set screws.
2. Adjust drive chain tension using the four reducer base adjusting stand-offs. Loosen the two nuts and adjust accordingly to loosen or tighten the drive chain. Be sure all stand-offs are adjusted evenly. Tighten nuts when finished. Reinstall chain guard(s).

- Measuring Total Chain Slackness

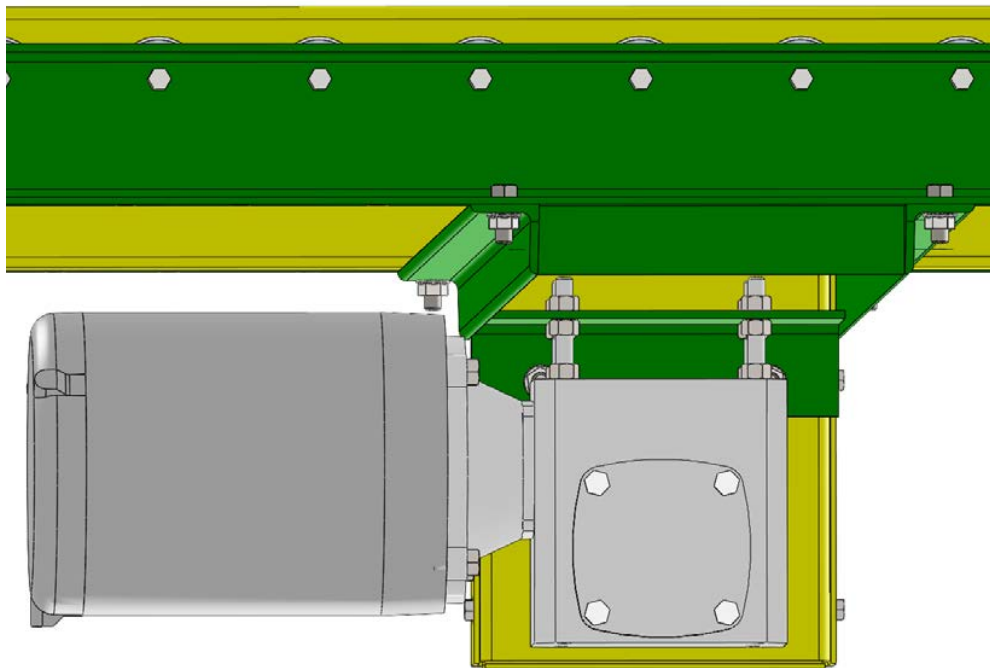


- View of Drive Chain (guard removed)

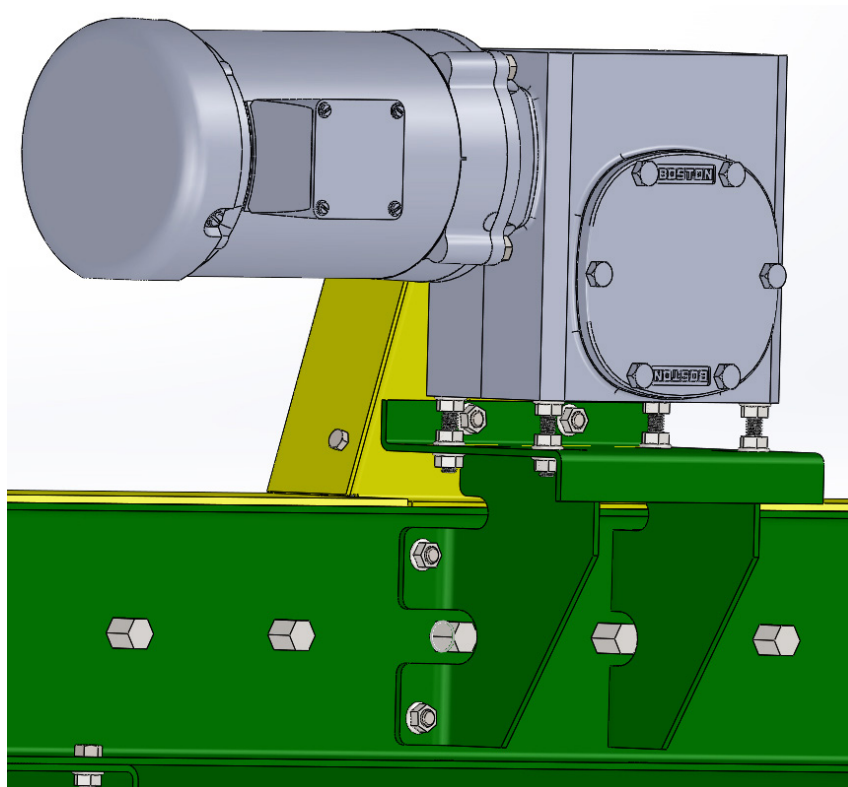




- Adjusting Drive Chain – Underslung Drive



- Adjusting Drive Chain – Overhead Drive



3. Check that the conveyor run is level & straight. Use surveyor's line (string) to check straightness.
4. Tighten all connector plates and floor supports. Lag supports to floor using 3/8" lags.
5. Check lubrication as noted in the Lubrication Section.
6. Install electrical controls. Note voltage and phase of motor. Wiring and controls shall conform to National Electric Code and any appli-cable OSHA re quirements.
7. After power supply has been connected make sure all power has been disconnected and locked out according to OSHA guidelines when further adjustments or maintenance is required.

## **Lubrication**

### **Bearings**

Bearings are supplied sealed and lubricated. No futher lubrication is required.

### **Chain**

Overall, clean high-quality, non-detergent, petroleum-based or synthetic oil is best. Lube that is too viscous (such as grease) cannot penetrate the critical pin-bushing joint. Properly lubricated chains minimize corrosion due to exposure and maximize chain life by avoiding direct metal-to-metal contact. Roller chain should never be dry to the touch. See table for recommended oil weight.

- Ambient Temperature : 15o-35oF 35o-105oF 105o-120oF
- Oil Weight : SAE10 SAE20 SAE30

### **Reducer**

The reducer is shipped pre lubricated with the vent plug uninstalled. Remove the solid plug and install the plastic vent plug as shown. Not installing the vent plug will void the reducer warranty.



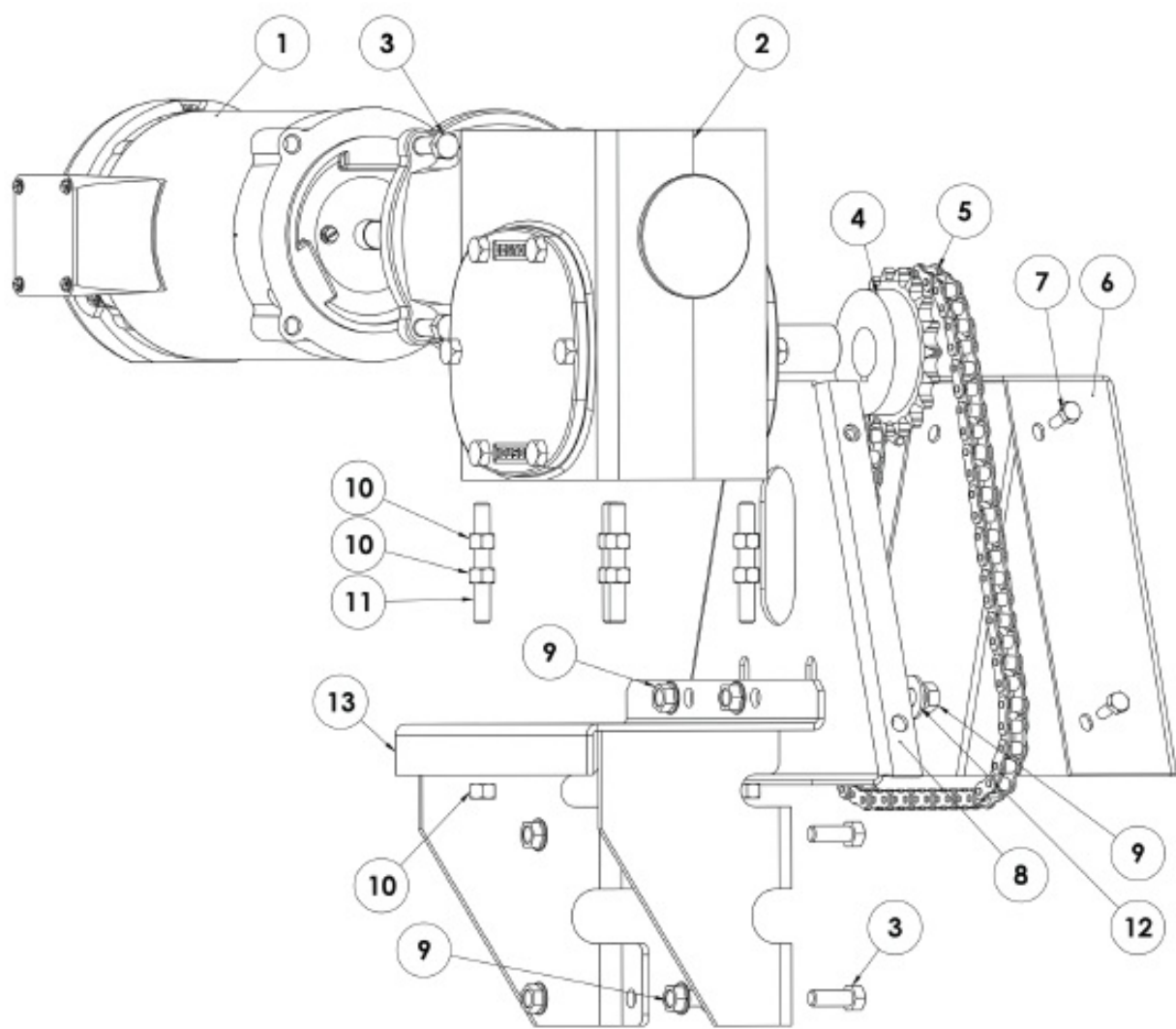
Remove solid plug and install plastic vent plug after conveyor is set-up and before operating.  
The vent location is the same for underslung drives.

## Planned Maintenance

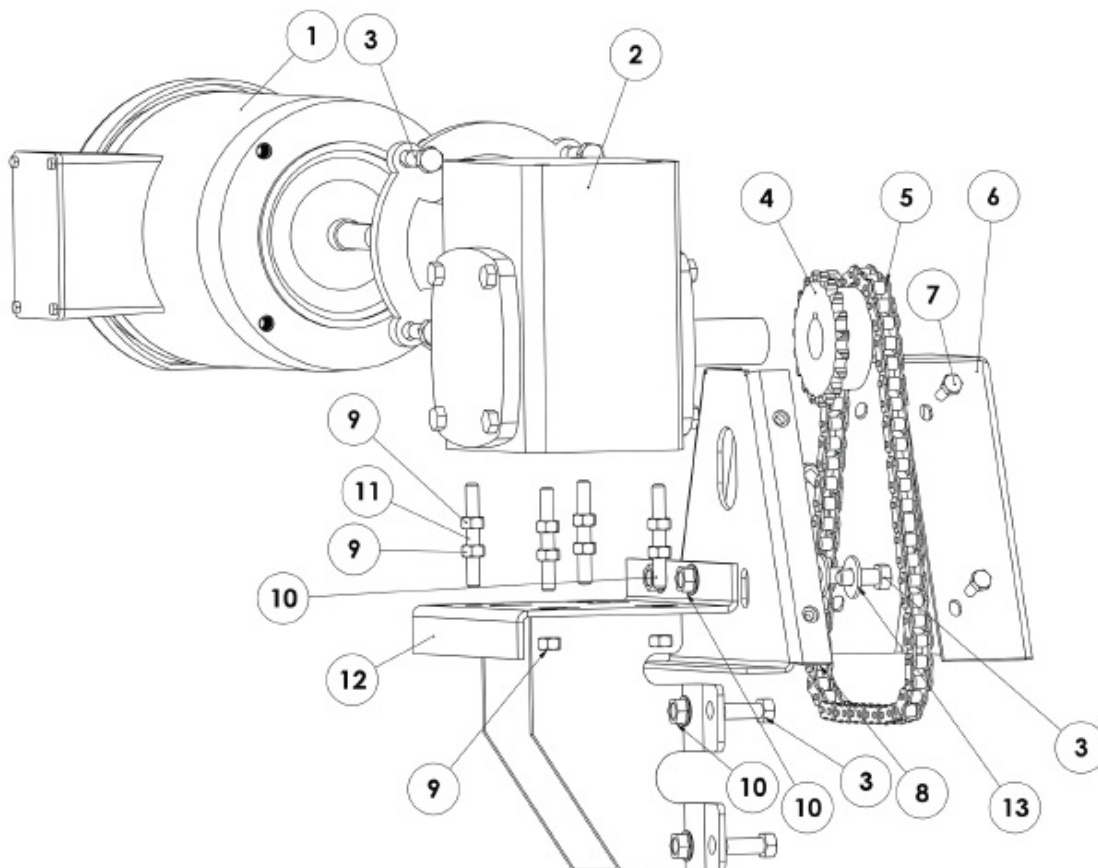
Component	Suggested Action	Frequency
<b>Reducer</b>	Check Oil Level	Refer to manufacturer's recommendation
	Change Oil	
<b>Drive Roller Chain</b>	Check Tension	Quarterly
<b>All Roller Chains</b>	Lubricate	Monthly
	Check for Wear	Quarterly
<b>Sprockets</b>	Check for Wear	Quarterly
	Check Set Screws & Keys of Reducer Sprocket	Quarterly
	Check Drive Sprocket Alignment	Quarterly
<b>Sprocketed Rollers</b>	Replace Bent or Dented Rollers	Monthly
<b>Structural</b>	General Check: Tighten all Loose Bolts	Monthly

**Note:** Check drive chain tension and sprocket set screws for tightness after the first 24 hours of operation

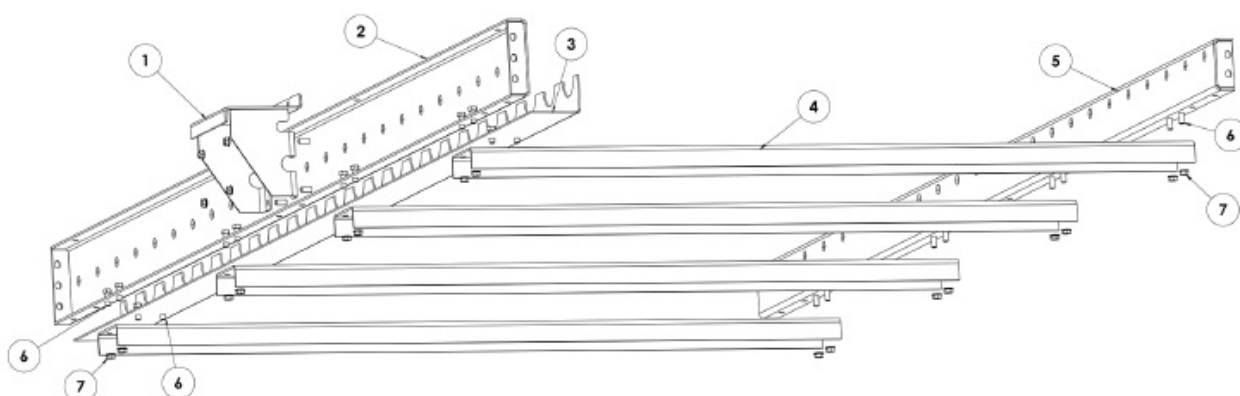
**Spare Parts for 16F CDLR Standard Construction**



Item	Part Number	Description	Qty
1	60635	MTR1HPID230/46056C1800	1
2	49772	RED 40:1 F726 40 KT B5 G 1	1
3	10616	BOLTHEX3/8-16X1ZG5	10
4	10406	SPKT 50BS18 1.125	1
5	49766	ROLLER CHAIN NO 50 53P	1
6	49757	DG CDLR FRT CVR P	1
7	10595	BOLT HEX 1/4-20 .75 Z	4
8	49747	DG CDLR BCK PLT WN P	1
9	10631	NUTHEX3/8-16FLGLKZ	6
10	37467	NUT 3/8-16 HEX Z	12
11	49746	SCR SET CUP PNT 3/8-16 2.75Z	4
12	10669	WASHER3/8FLATZ	2
13	54053	CDLR RED MNT BRKT F715-F726	1



Item	Part Number	Description	Qty
1	60635	MTR1HPID230/46056C1800	1
2	25992	RED 30:1 F724 30 KT B5 G 3	1
3	10616	BOLTHEX3/8-16X1ZG5	10
4	60452	SPKT 40BS19 1.125	1
5	60362	ROLLER CHAIN NO 40 58P	1
6	60446	DG CDLR FRT CVR 1.9 4C6C P	1
7	10595	BOLT HEX 1/4-20 .75 Z	4
8	60382	DG CDLR BCK PLT WN 1.9 4C6C	1
9	37467	NUT 3/8-16 HEX Z	12
10	10631	NUTHEX3/8-16FLGLKZ	6
11	49746	SCR SET CUP PNT 3/8-16 2.75Z	4
12	50970	CDLR RED MNT 17F F721 F724	1
13	10669	WASHER3/8FLATZ	2

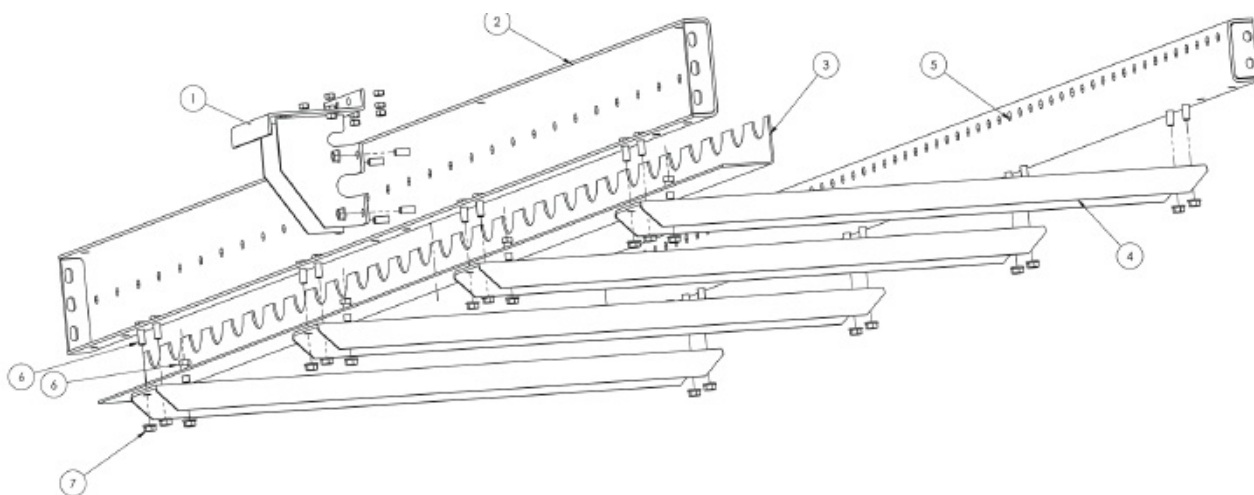


Item	Part Number	Description	Qty
1	54053	CDLR RED MNT BRKT F715-F726	1
2	49753	C 6X1.5 8GA11/16X05 120 BP P	1
3	49756	CD CG 5C 2.5R 120 B P	1
4		CD CB 1-1/2X5 8GA _BF P	4
5	49754	C 4X1.5 8GA11/16X05 120 BP P	1
6	10616	BOLTHEX3/8-16X1ZG5	18
7	10631	NUTHEX3/8-16FLGLKZ	18

Parts for 60" Frame



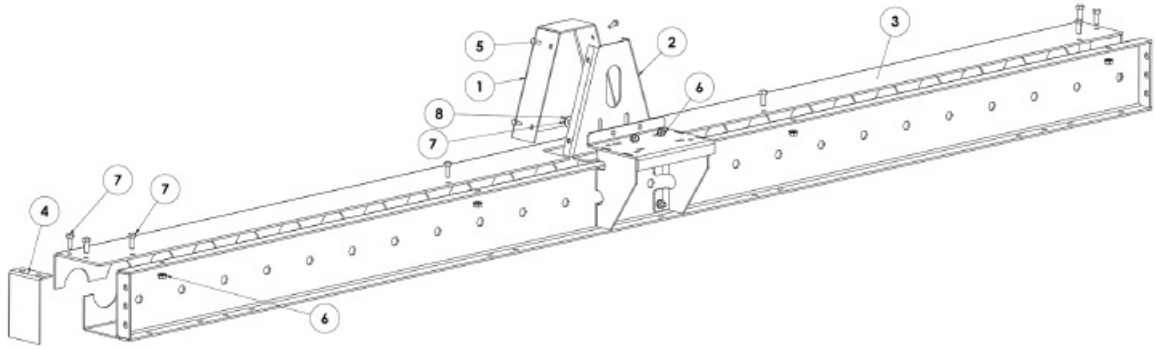
Item	Part Number	Description	Qty
2	49753	C 6X1.5 8GA11/16X05 60 BP P	1
3	49998	C 4X1.5 8GA11/16X05 60 BP P	1
5	49997	CD CG 5C 2.5R 60 B P	1



Item	Part Number	Description	Qty
1	50970	CDLR RED MNT 17F F721 F724	1
2	60375	C 5.5X1.5 8GA7/16X04 120 BP P	1
3	60449	CD CG 4C 1.9R 120 T DR P	1
4		CD CB 1-1/2X5 8GA _BF1.9P	4
5	60377	C 3.5X1.5 8GA7/16X04 120 BP P	1
6	10616	BOLTHEX3/8-16X1ZG5	20
7	10631	NUTHEX3/8-16FLGLKZ	20

#### Parts for 60" Frame

Item	Part Number	Description	Qty
2	60363	C 5.5X1.5 8GA7/16X04 60BP P	1
3	60454	CD CG 04C 1.9R 60 B P	1
5	60365	C 3.5X1.5 8GA7/16X04 60BP P	1



Item	Part Number	Description	Qty
1	49757	DG CDLR FRT CVR P	1
2	49747	DG CDLR BCK PLT WN P	1
3	49755	CD CG 5C 2.5R 120 T DR P	1
4	49726	CD CG END CAP P	2
5	10595	BOLT HEX 1/4-20 .75 Z	4
6	10631	NUTHEX3/8-16FLGLKZ	6
7	10616	BOLTHEX3/8-16X1ZG5	10
8	10669	WASHER3/8FLATZ	2

#### Parts for 120" Non Drive Guards

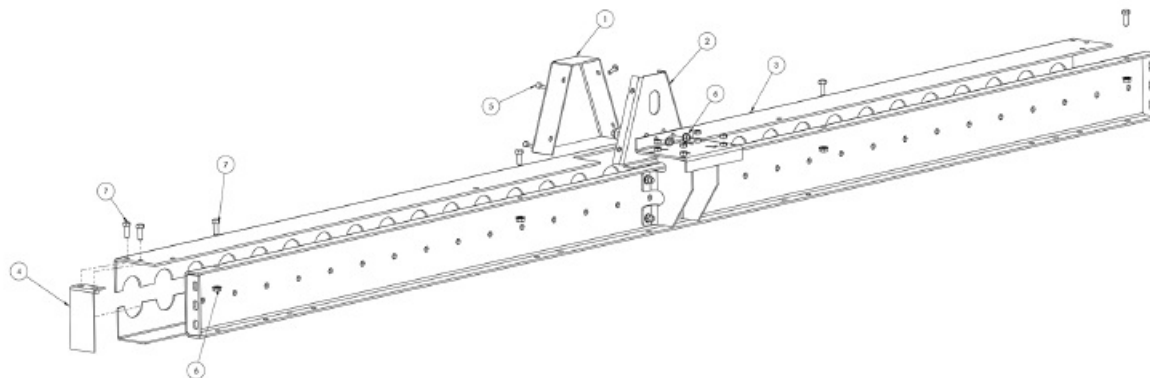
Item	Part Number	Description	Qty
3	49759	CD CG 5C 2.5R 120 T ND P	1

#### Parts for 60" Drive Guards

Item	Part Number	Description	Qty
3	50007	CD CG 5C 2.5R 60 T DR P	1
6	10631	NUTHEX3/8-16FLGLKZ	4
7	10616	BOLTHEX3/8-16X1ZG5	8

#### Parts for 60" Non Drive Guards

Item	Part Number	Description	Qty
3	50079	CD CG 5C 2.5R 60 T ND P	1



Item	Part Number	Description	Qty
1	60446	DG CDLR FRT CVR 1.9 4C6C P	1
2	60382	DG CDLR BCK PLT WN 1.9 4C6C	1
3	60449	CD CG 4C 1.9R 120 T DR P	1
4	50634	CD CG 3 END CAP P	2
5	10595	BOLT HEX 1/4-20 .75 Z	4
6	10631	NUTHEX3/8-16FLGLKZ	6
7	10616	BOLTHEX3/8-16X1ZG5	10
8	10669	WASHER3/8FLATZ	2

#### Parts for 120" Non Drive Guards

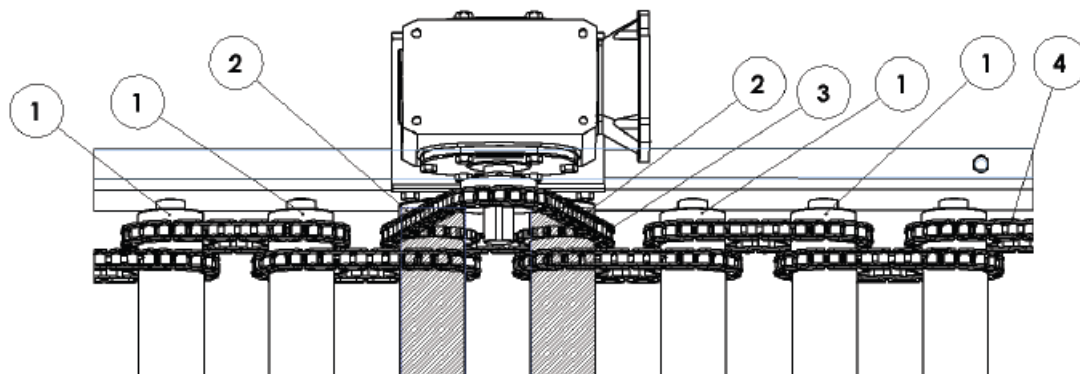
Item	Part Number	Description	Qty
3	60456	CD CG 4C 1.9R 120 T ND P	1

#### Parts for 60" Drive Guards

Item	Part Number	Description	Qty
3	60453	CD CG 4C 1.9R 60 T DR P	1
6	10631	NUTHEX3/8-16FLGLKZ	4
7	10616	BOLTHEX3/8-16X1ZG5	8

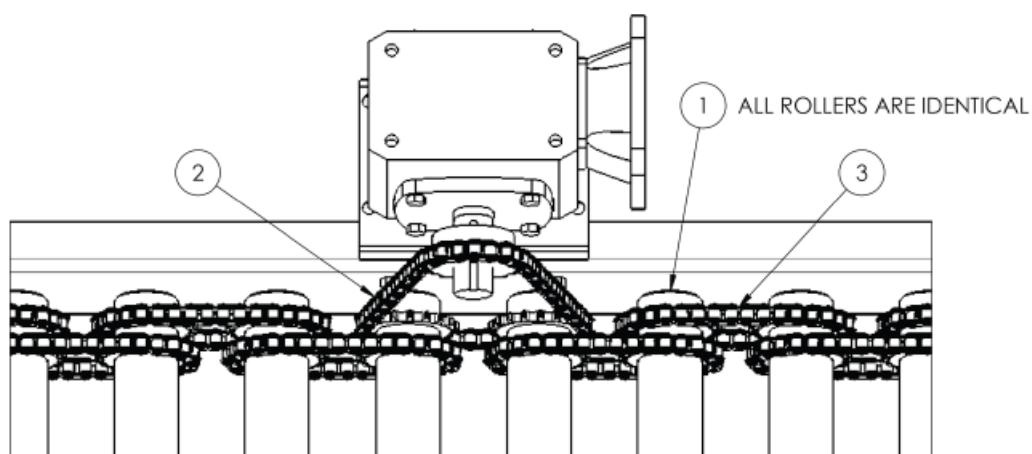
#### Parts for 60" Non Drive Guards

Item	Part Number	Description	Qty
3	60455	CD CG 4C 1.9R 60 T ND P	1



Item	Part Number	Description	Qty
1		S__ CO GP FTS 2-50A17 *	
2		S__ AB1 2-50A17 *	2
3	49766	ROLLER CHAIN NO 50 53P	1
4	49749	ROLLER CHAIN NO 50 33P	

- Dependent on BF of frame



Item	Part Number	Description	Qty
1		KD_ CO GP TS 2 40A18*	
2	60362	ROLLER CHAIN NO 40 58P	1
3	60331	ROLLER CHAIN NO 40 34P	

- Dependent on BF of frame

## Trouble Shooting

**Trouble: Cause: Solution**

- Conveyor will not start.
  - Motor overloaded
    - Check for overloading of conveyor.
- Drive chain & sprockets wear excessively.
  - Lack of lubrication.
  - Poor alignment.
  - Loose chain.
    - Replace chain and sprockets, provide lubrication.
    - Align sprockets.
    - Tighten chain correctly.
- Motor or reducer over-heating.
  - Conveyor overloaded.
  - Low voltage to motor.
  - Low lubricant in reducer.
    - Reduce load.
    - Have electrician check as necessary.
    - Lubricate per manufacturers recommendations.


Phone 800-587-0045

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

## Documents / Resources

	<p><a href="#">ASHLAND CDLR16F-17F Chain Driven Live Rollers</a> [pdf] Installation Guide CDLR16F-17F, CDLR16F-17F, CDLR16F-17F Chain Driven Live Rollers, CDLR16F-17F, Chain Driven Live Rollers, Live Rollers, Rollers</p>
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