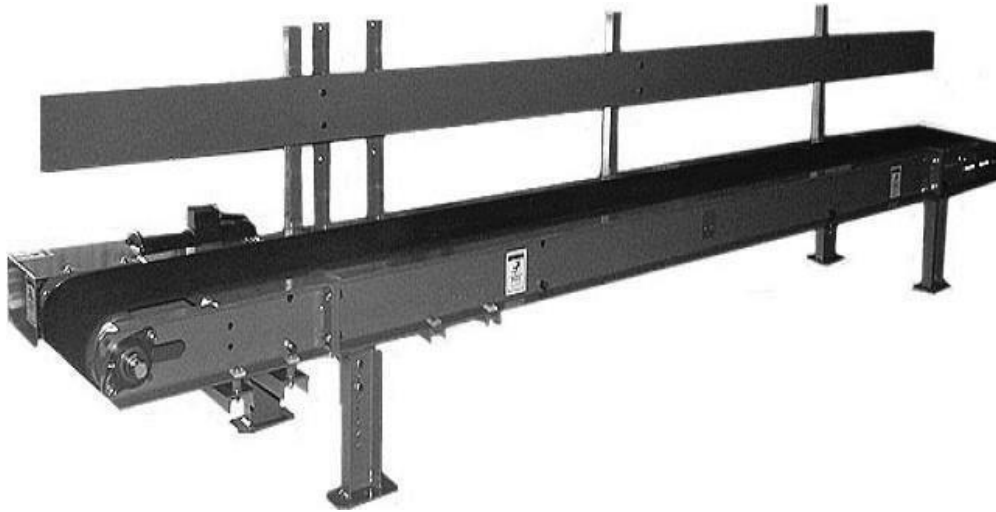


# OPERATION MANUAL BC SERIES CONVEYOR



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# BC SERIES CONVEYOR

## INSTALLATION INSTRUCTIONS

### Positioning of the conveyor

Install the conveyor with the back board and control panel opposite the operator station. The conveyor will travel from the operator's right to the operator's left.

### Installing Electrical Supply

The units have been supplied for either 110 volt/single phase, 220 volt/single phase, 220 volt/3 phase, 380/3 phase, or 480/3 phase power. The voltage for which the unit has been wired is shown on the specification sheet and marked on the control cabinet and on the motors. Be sure that the voltage supplied matches the voltage of the equipment. A power cord has not been provided and the equipment must be hard wired to your control panel according to local electrical approved codes.

## OPERATION SET-UP

### Pre-operation Checks

- Apply electrical power to the unit.
- Turn the on/off switch located on the control box to the "on" position.
- The conveyor should now be running from the operators right to their left.
- If the conveyor is running in the opposite direction, and the unit has been supplied for 3 phase electricity, remove the electrical power from the unit. Swap any two legs of the incoming 3-phase power. Re-apply the electrical power to the unit, and the conveyor will run in the opposite direction. The sewing motor, if supplied, has been tested at the factory to run the same direction as the bag closing conveyor.

## OPERATION INSTRUCTIONS

The conveyor system has been set up for either a one person operation or a two person operation according to the purchase order specifications. Both operating procedures are detailed as follows:

### ONE PERSON OPERATIONAL PROCEDURE

This conveyor system is designed to work with a gross weigh bagging scale and is designed to close 4 bags per minute using one operator.

### **Operational Steps:**

1. Hang bag #1 on the gross weigh bagging scale or on your existing scale and begin the fill cycle.
2. When the scale reaches weigh complete, drop bag #1 on the moving conveyor. The bag will move to the operators left until it strikes the wand switch, which will automatically stop the conveyor.
3. Hang bag #2 on the gross weigh bagging scale or on your existing scale and begin the fill cycle.
4. While the scale is automatically filling bag #2, snap the gusset closed on bag #1 and prepare it for sewing. The operator must make sure to keep the bag in contact with wand switch during this process; otherwise, the conveyor will automatically start.
5. Depress & hold the two position foot pedal approximately half way down (position #1). This will override the wand switch and start the conveyor moving. Just before the bag enters the sewing head, depress & hold the foot pedal all the way down (position #2). This will turn the sewing head on.
6. Once the bag is sewn, release the foot pedal. The sewing head will stop, but the conveyor will continue to run. Unless the unit is equipped with a pneumatic thread cutter, the operator must push the thread into the cutter blades on the sewing head in order to cut the sewing thread.
7. Place bag #1 on a pallet.
8. Return to gross weigh bagging scale and repeat steps 2 through 7.

## **TWO PERSON OPERATIONAL PROCEDURE**

This conveyor system is designed to work with either a gross weigh bagging scale or a net weigh bagging scale using two operators.

### **Operational Steps:**

1. Turn the conveyor on. The belt should be running from the operator's right to their left. The belt will run continuously during the operation. (If an emergency foot pedal has been provided, it can be used to stop the conveyor. If an emergency foot pedal has not been provided, the on/off switch located on the control box at the rear of the conveyor will be utilized for this purpose).
2. The first operator should hang bag #1 on the gross weigh bagging scale or on your existing scale and begin the fill cycle.
3. When the scale reaches weigh complete, drop bag #1 onto the moving conveyor. The bag will move to the operator's left.
4. The first operator should hang bag #2 on the gross weigh bagging scale or on your existing scale and begin the fill cycle.
5. The second operator should snap the gusset closed on bag #1 and prepare it for closure. This operator should then start bag #1 into the bag closure device.
6. After the bag is closed, place the bag on a pallet and repeat steps 3 through 6.

## **MAINTENANCE**

- Apply a general purpose grease once a week to the two 1-1/4" flange mount bearings on the head pulley and the two 1" take-up bearings on the tail pulley.
- The gear box on the conveyor should be serviced and lubricated according the manufacturers suggested maintenance procedure.

NOTE: The gear box has been lubricated at the factory prior to shipment. However, in transit, occasionally lubrication has been lost. Check carefully for any signs of oil in packing or loss of oil in the first hours of operation. Do not use equipment if in low oil condition).

## **TROUBLE SHOOTING**

### **Belt Not Tracking**

- Adjustments are on the right end of the conveyor through adjustable bearings. If the belt is tracking to the back side of the conveyor, tighten the bearing on the back side. Check the alignment of the conveyor belt closely when first installed as belt mistracking can occur during transportation. The tightness of the belt should be set so that the operator could pull up from the center of the belt 2" to 4" (50 to 100 cm) easily by hand.
- Conveyor is not plained and leveled.

### **Conveyor Running Too Slow**

- Increase the "A/UI" setting on the Variable Speed Drive until desired belt speed is achieved.

### **Conveyor Running Too Fast**

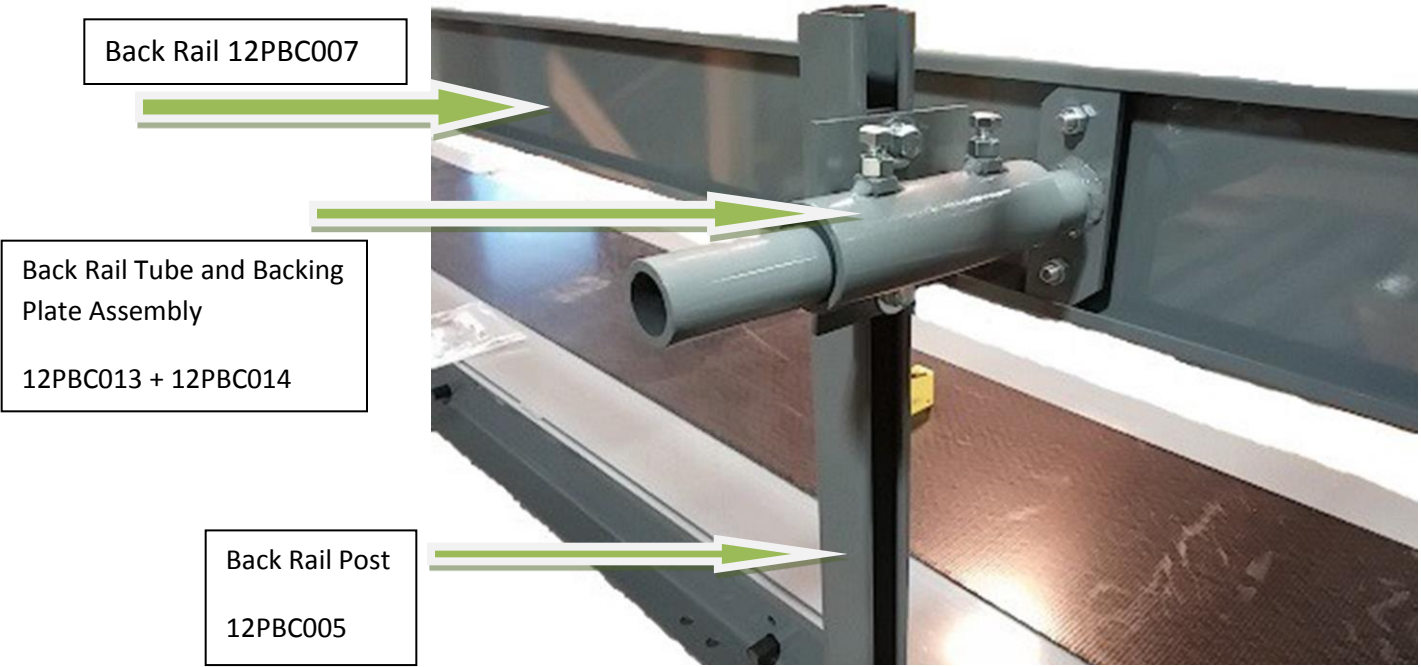
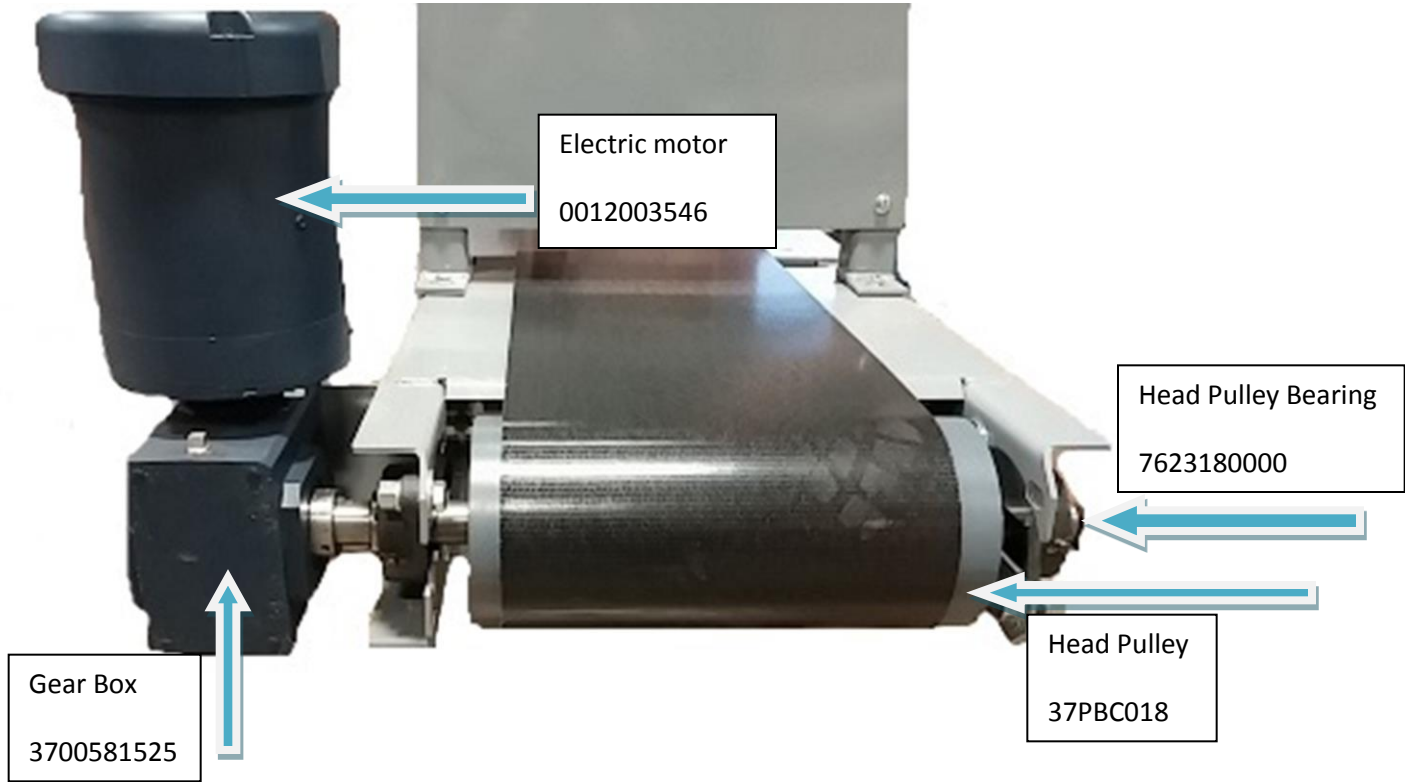
- Decrease the "A/UI" setting on the Variable Speed Drive until the desired belt speed is achieved.

Unit does not function when turned to “on” position

- Check the AC Power Supply. Is the circuit breaker turned on?
- Check for loose wire termination and secure.
- If the unit still fails to function, call JEM Service at 913-441-4788.

### **TYPICAL CONVEYOR HEIGHTS AND ADJUSTMENTS**

The bottom of the bagging scale is normally 48” (1.2 meters) from floor level. The height of the sewing needle is normally 42” (1.05 meters) from floor level. It is generally advantageous to adjust the height of the bag closing conveyor to meet these heights in order to satisfy the typical worker’s ideal position. The BC series conveyors have adjustable legs on each corner.



Item not shown: Tail Pulley - 37PBC019  
Take-up Frame - 7623160020  
Take-up Bearing - 7623160021

# Control for stand alone LP conveyor (less pedestal)

Drive  
3700619960

Speed control  
adjustment



Start stop switch



## BC Conveyor Parts List

PART #	DESCRIPTION	CODE	QTY.
0005001116	Return Roller 14"	Rec	1
12PBC013	Adjustment Bracket		2
12PBC005	Upright Support		2
12PBC012	Back Rail Upright		
12PBC014	Standoff Tube		2
12PBC015	Stop Bracket		
0012003546	Motor 1 HP	Rec	1
3700581525	Gear Box 40:1; 1 HP	Rec	1
7623160021	Bearing, narrow-slot take up	Rec	2
7623160020	Take up Frame		
3800000010	Belt, Black Smooth-top	Rec	12"x 12'- 4-1/2"
5022750001	Belt lacing SS		
7623180000	Bearing head pulley	Rec	2
9500380000	Terminal Block		
37PBC018	Head pulley		
37PBC019	Tail Pulley		
17SDS114	Taper-lock Bushing 1-1/4"		
17SDS1	Taper-lock Bushing 1"		
37144-2000	Keyed shaft 1-1/4"		
37144-1600	Keyed Shaft 1"		