

TT-610 & TT-620 SERIES BAG CLOSING CONVEYOR

INSTALLATION AND REPAIR MANUAL



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VENDOR SPECIFICATION SHEETS

- KBIC DC CONTROLLER BOARD
- LEESON GEAR BOX

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 or 220 volt/single phase power. The voltage for which the unit has been wired is shown on the specification sheet and marked on the control box. Be sure that the voltage supplied matches the voltage of the equipment. A power cord has been provided.

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.

OPERATION INSTRUCTIONS

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

CONTINUOUS OPERATIONAL PROCEDURE

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

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 or button has been provided, it can be used to stop the conveyor. If an emergency foot pedal or button 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. Hang bag #1 on the spout 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 spout 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.

ONE PERSON OPERATIONAL PROCEDURE

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

Operational Steps:

1. Hang bag #1 on the spout 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 spout 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 closure. 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 and 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 bag closure device, depress and hold the foot pedal all the way down (position #2). This will turn on the bag closure device.
6. Once the bag is closed, release the foot pedal. The bag closure device 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 bagging scale and repeat steps 2 through 7.

MAINTENANCE

Apply a general purpose grease once a week to the flange mount bearing on the head pulley.

Check the conveyor belt and lacing for signs of wear monthly. Repair and/or replace if necessary.

The gear box on the conveyor should be serviced and lubricated according the manufacturers suggested maintenance procedure. This can be found on pages for Leeson.

NOTE: The gear box has been lubricated at the factory prior to shipment. However, occasionally lubrication may be lost in transit. 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

Conveyor Running Too Slow

- On variable speed units, adjust the DC speed control potentiometer located inside the control panel clockwise until the desired belt speed is achieved.
- On fixed speed units, increase the size of the sprocket on the gear box or decrease the size of the sprocket on the head pulley.

Conveyor Running Too Fast

- On variable speed units, adjust the speed control potentiometer located inside the control panel counter-clockwise until the desired belt speed is achieved.
- On fixed speed units, increase the size of the sprocket on the head pulley or decrease the size of the sprocket on the gear box.

Unit does not function when turned to “on” position

- Check the AC Power Supply. Is the circuit breaker turned on?
- Check the supply fuse on the terminal strip.

PART#	DESCRIPTION	CODE	QTY
0005000001	Sprocket-Table Top		1
0005000021	Chain, Table Top 6"	R	Varies
0005000038	Chain, Table Top 12"	R	Varies
0005000037	Idler Wheel		1
0012003330	Motor-1/2 HP=90VDC		1
0302406602	Drive Shaft		1
0302406603	Tail Shaft		1
3700210003	Leg Bracket		2
3700210004	Tripod base		2
3700210005	Post Cap		2
3700210006	Leg		2
3700210009	Brk leg conveyor 600-12		
3700210015	Leveler		6
3700210008	Spacer		7
3700210010	Spacer Conv 600-12		
3700210013	Motor plate		
3700270004	Guide Roller		4
3700270011	Guide roller 11/16"		
3700320000	Vertical Adjust Rod 1/2" x 3/8" (short rod)		4
3700320015	Vertical Adjust Rod 1/2" x 3/8" (tall rod)		4
3700330000	Horizontal Rod 1/2" 600		4
3700340000	Rail Bracket Base & Washer		4
3700330050	Rod and Rail Clamp 600		4
3700360000	Cross Block		4
3700380000	Guide Rail 600		2
3700380005	Track		2
3700520000	Bracket for Potentiometer		1
3700560112	Male Cord	N	1
3700580005	Gear Box		1
3700610003	Resistor 1 HP for KB	R	2
3700610004	Potentiometer for KB		1
3700610005	Terminal Board for KB		1
3700610006	Knob for Potentiometer		1
3700610012	KBIC DC Controller	R	1
7623140004	Bearing Spout AO	R	1
9400010011	Enclosure		1
9500150070	Contact Block	N,R	1
9500150100	Selector Switch	N,R	1
9500150110	Legend	N	1
9500150120	Legend Holder	N	1
9500380000	Terminal Block		6
ABC8	AMC8 Fuse for KB	R	2
GMA10	GMA10 Fuse	R	1

R=RECOMMENDED SPARE PART
N=NOT SHOWN IN PICTURES

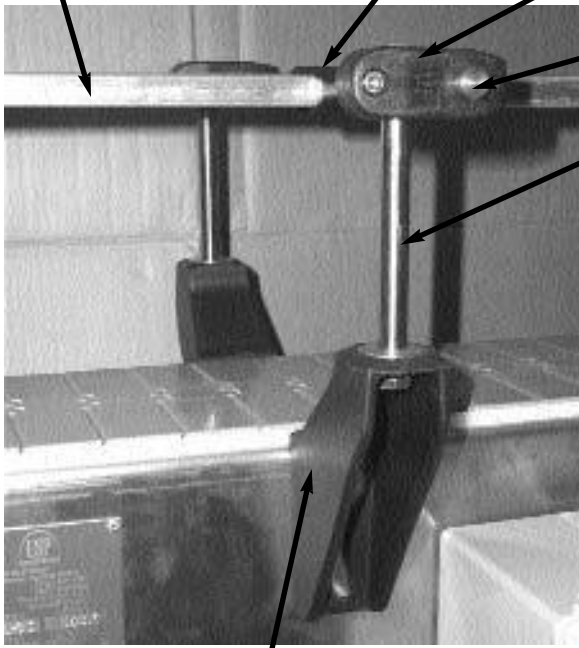
Guide Rail
3700380000

Rod and Rail Clamp
3700330050

Cross Block
3700360000

Horizontal Rod
3700330000

Vertical Rod
3700320000



Rail Bracket Base
and Washer
3700340000

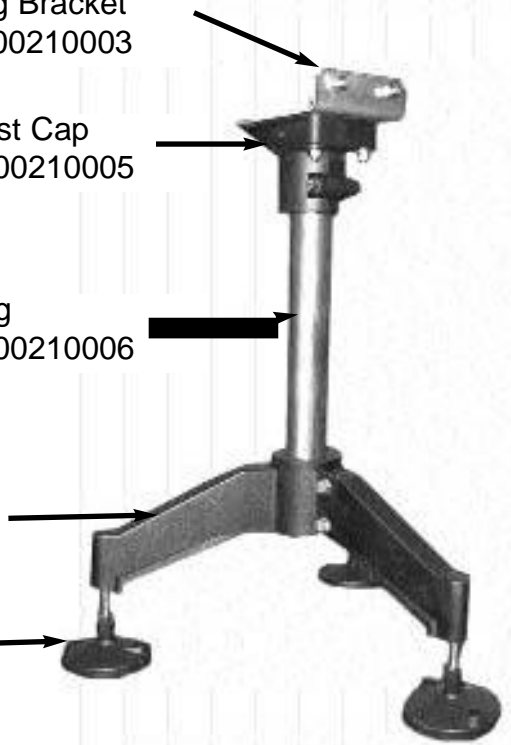
Leg Bracket
3700210003

Post Cap
3700210005

Leg
3700210006

Tripod Base
3700210016

Leveler
3700210015

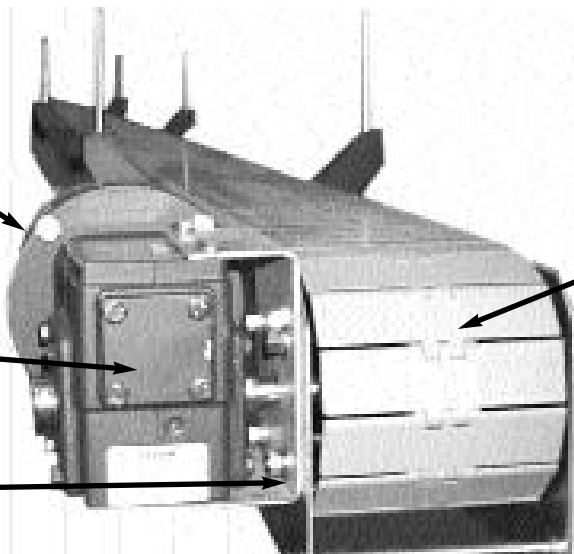


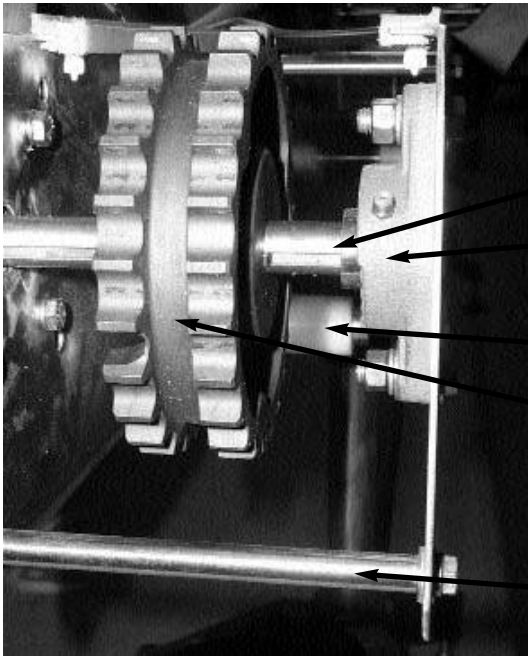
Motor 1/2 HP
90VDC
0012003330

Gear Box
3700580005

Motor plate
3700210013

Flat Top Chain 6"
0005000021





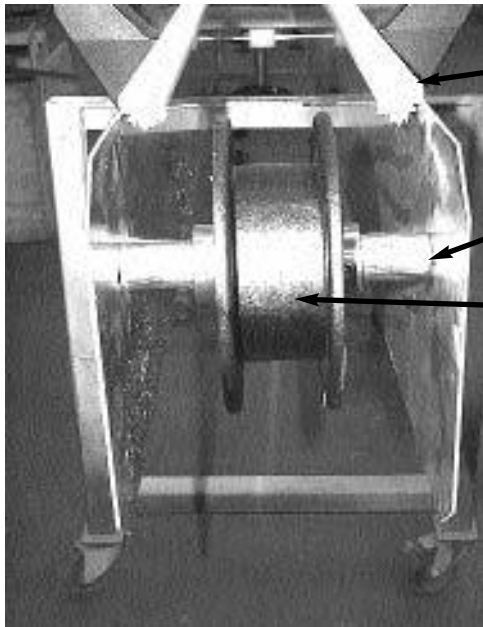
Drive Shaft
0302406602

Bearing
7623140004

Guide Roller
3700270004

Drive Sprocket
0005000001

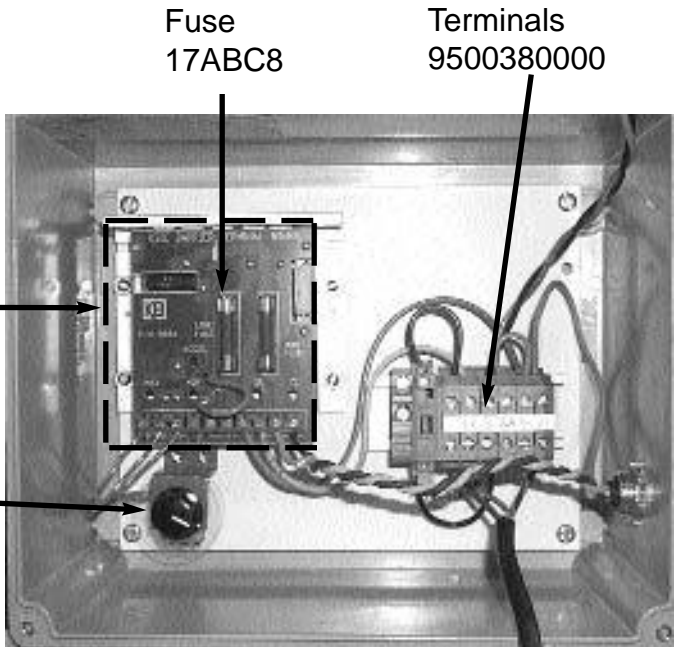
Spacer
3700210008



Track
3700380005

Tail Shaft
0302406603

Idler Wheel
0005000037



Fuse
17ABC8

Terminals
9500380000

KB Controller
Assembly
3700610012

Knob
3700610006
Potentiometer
(behind knob)
3700610004