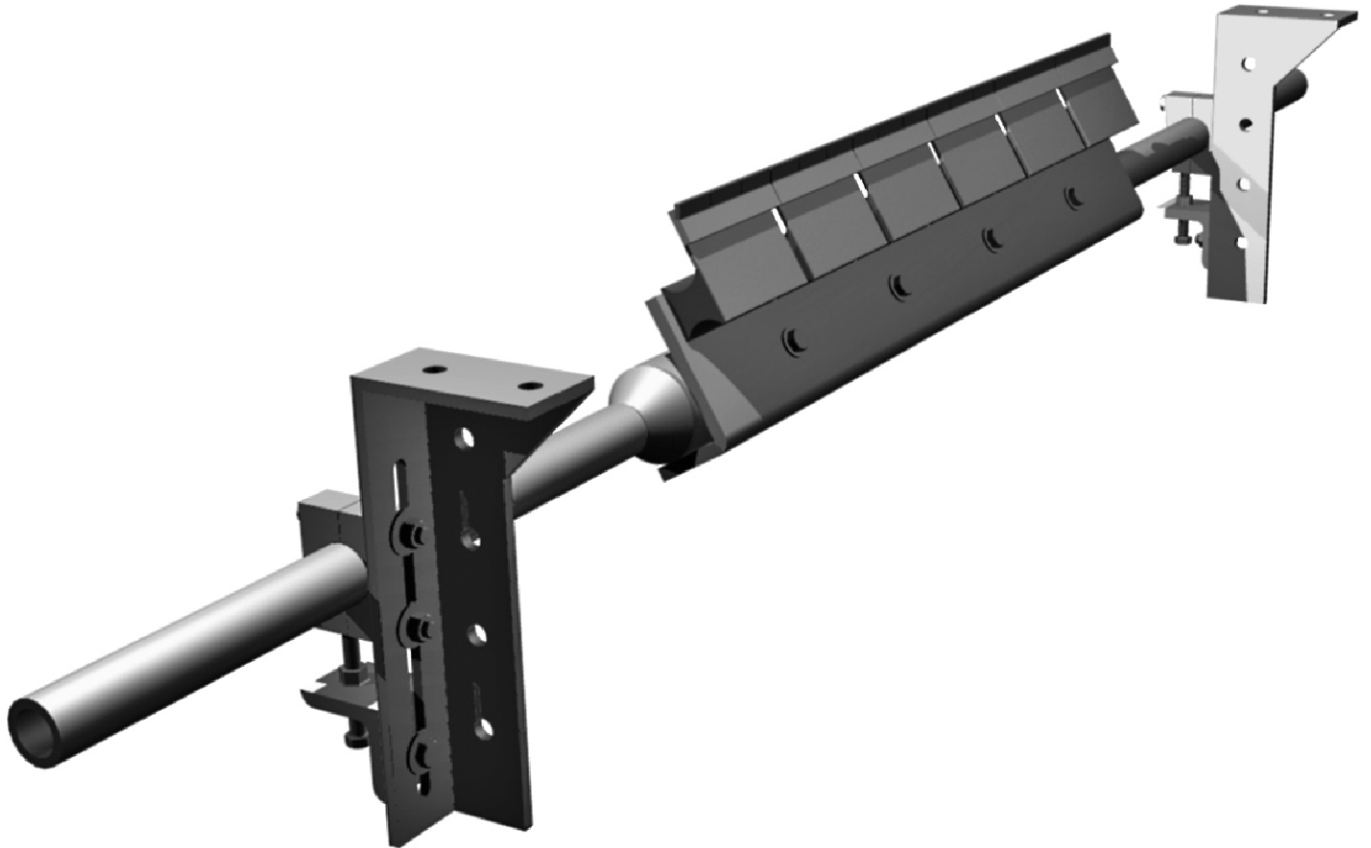


ASGCO

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SUPER HEAVY DUTY RAZOR-BACK SECONDARY BOLT-UP SYSTEM

INSTALLATION, OPERATION & MAINTENANCE INSTRUCTIONS



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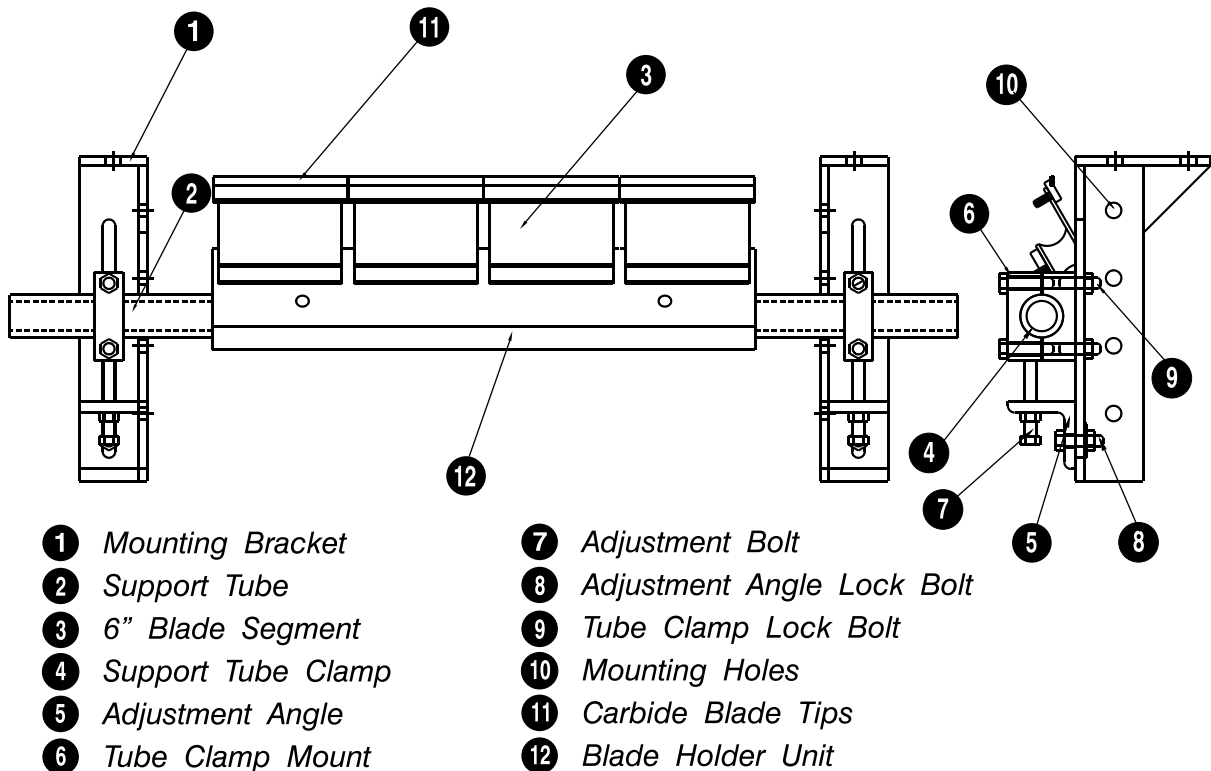
Important Safety Notice

Always observe the basic rules of safety when working with any conveyor system. To avoid injury and equipment damage, be sure that all controls to the conveyor are locked out and the power source is disconnected at all times during installation.

Overall View

If mounting structure is not available, additional steel may have to be added. *Note: Excess mounting tube may be trimmed after installation.*

Components Diagram

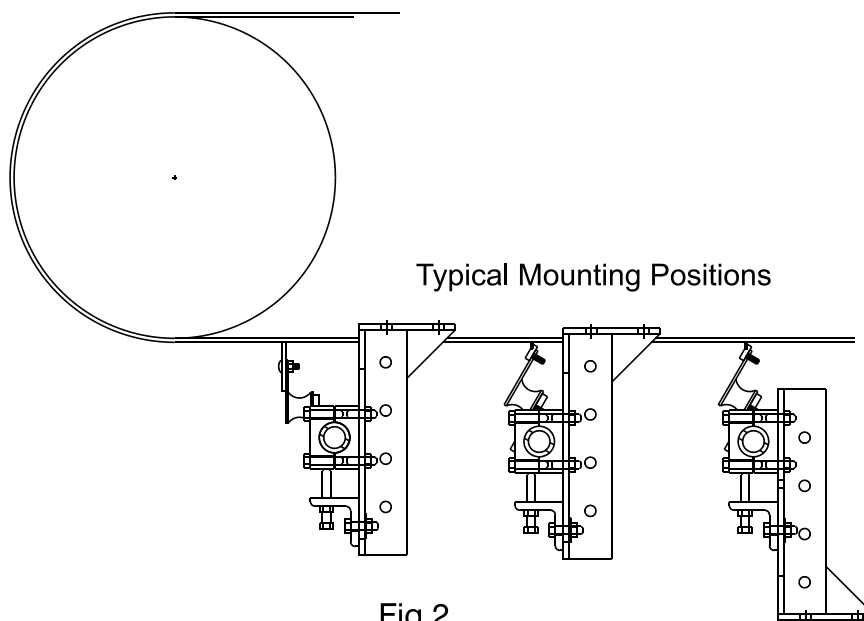


The RazorBack is a Secondary Cleaner designed to be installed on the return side of the belt.

1. Determine Cleaner Location

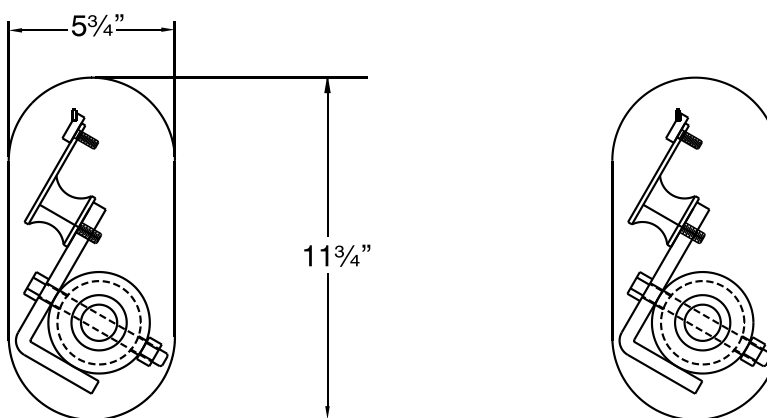
The RazorBack is a Secondary Cleaner and as such should be located on the return side of the belt after the belt leaves the head pulley as shown below. Preferably not much further from the confines of the head or dribbled chute.

Note that the bracket can be flipped either way to bolt to existing structure. See Fig. 2.



2. Cut Chute Openings

If brackets are to be mounted to an enclosed chute a slotted hole will have to be cut into the chute $11\frac{3}{4}$ " x $5\frac{3}{4}$ " to allow the blades and the mounting tube to pass through from one side of the conveyor to the other side of the conveyor See Fig. 3.



OPERATION

After the mounting bracket is attached to the conveyor frame, assemble the cleaner to the bracket.

Bolt the support tube clamp to the bracket using the tube clamp lock bolts as shown in Fig. 4 Position the support tube into the fixed half of the support tube clamp as shown in Fig. 5 Bolt the top half of the support tube clamp into place and make sure that the blade tip is perpendicular to the belt as shown in Fig. 6

Raise both the Support tube clamp and the Adjustment angle in the slot of the mounting bracket until the tip of the blade touches the belt as shown in Fig. 7

Once belt contact has been made, tighten the adjustment angle lock bolt. Turn the adjustment bolt until the blade tip has moved about $\frac{1}{4}$ ". Tighten the tube clamp lock bolts.

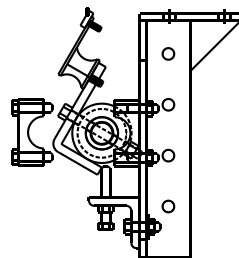


Fig 4

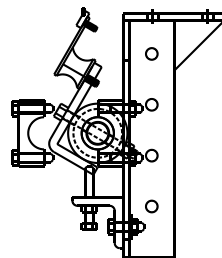


Fig 5

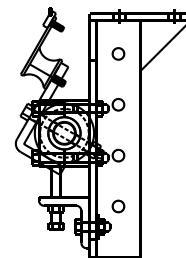


Fig 6

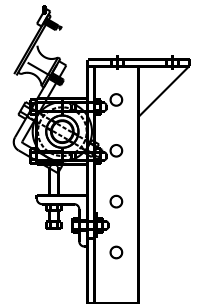


Fig 7

Test run the conveyor. If chattering occurs, loosen the tube clamp bolts and rotate the blade tip about 5 deg in the direction of belt travel.

MAINTENANCE

After one day of operation:

- 1.) Inspect the cleaner for proper belt cleaning and operation.

Weekly:

- 1.) Frequent inspection is the key to proper belt cleaning and easy Scraper servicing. Weekly inspections are recommended, but actual service frequency may vary widely depending on various plant operating conditions.
- 2.) Wash the entire cleaner regularly to prevent excessive buildup. If material tends to accumulate on the Scraper Assembly then possible scraper relocation may be in order.
- 3.) Carefully inspect the wear tips of the cleaner blades. Make sure blades are not chipped or worn out.
- 4.) Inspect the belt surfaces and edges for cracks, splits, tears, holes or any other worn or damaged condition occurring on the surfaces or edges of the belt itself. If necessary make repairs to the belt.

REPLACEMENT AND RE-TENSIONING OF CLEANER BLADES

- 1.) Lower mounting tube to disengage the cleaner blades from the belt.
- 2.) Remove the clamp cap as shown in Fig. 5 to remove the tube from the mounting bracket.
- 3.) Loosen and remove the bolts holding the blades onto the mounting tube.
- 4.) Remove the worn blades and discard.
- 5.) Position new blades on the mounting tube and reinstall the bolts to hold the blades on the mounting tube.
- 6.) Install and tension mounting tube according to directions

Information

Key	Description	Part Number
1	RazorBack Blade Holder	ASG-RBBH-[BW]-SS [BW] = Belt Width
2	RazorBack Mounting Tube	ASG-RBMT - [BW]-SS
3	Cushion 6" AR RZ	ASG-CUS-RZ-6C
4	New Wave 3 Bolt Up Tensioner	M-NW3-BU
5	Carriage Bolt 3/8" X 1	ASG-BOLT-3/8X1-CAR
6a	Blade (6" segments)	ASG-BLD-RZ-6-TC (Tungsten Carbide)
6b	Blade (6" segments)	ASG-BLD-RZ-6-AR (AR-Steel)

TROUBLE SHOOTING

PROBLEM	SOLUTION
<i>Excess vibration of the scraper.</i>	<p>Make certain all bolts are tight.</p> <p>If belt is non-reversing, rotate the blade about 5 degrees in the direction of the belt movement.</p>
<i>Excess carryback.</i>	<p>Check for proper Scraper tension. Put additional tension on cleaner.</p> <p><i>Check for wear on the cleaning tips</i></p> <p>Check thickness of carryback. If the cleaner must remove more than about 1/8" of material then an additional cleaner may be needed.</p>
<i>Excess belt movement, cupping</i>	<p>Install a hold down roller to stabilize the belt surface.</p>
<i>Unable to tension scraper properly, belt moves away from blades.</i>	<p>Install a hold down roller to reduce sag of the belt when tensioning.</p>
<i>Frozen material on scraper.</i>	<p>Place heaters near scraper to melt frozen material. <i>(Use caution not to burn belt or cleaner)</i></p>