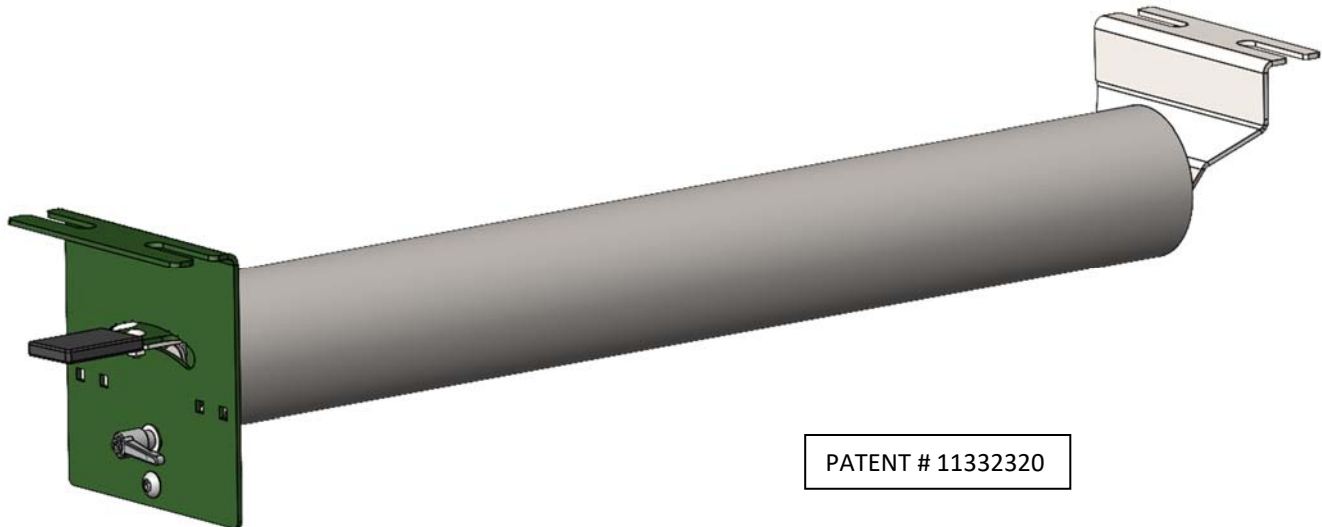


RETURN TRAINING BRACKET



PATENT # 11332320

IMPORTANT – SAFETY INSTRUCTIONS

Compliance with safety standards, including OSHA and other federal, state and local codes or regulations, is the responsibility of the user of the conveyor installation. Placement of guards and other safety equipment in accordance with safety standards is dependent upon the area and use of the system. A safety study should be made of the conveyor application and guards should be installed wherever appropriate. Safety Standards of Conveyors and Related Equipment ANSI B20.1 is a guide for safe construction, installation, operation and maintenance of conveyors and related equipment.

The stated purpose of ANSI Standard B20.1 is to present certain guidelines and safety practices that will assist in establishing a safe work place. It is important to realize that the best design and safety features can be useless in conjunction with faulty maintenance and operating practices.

The broad scope of ASME/ANSI Standard B20.1 precludes its inclusion in this manual. However, it is highly recommended that those responsible for assuring safety in the installation, operation and maintenance of belt conveyors and equipment, acquire and use Standard B20.1 as a reference and guide.

The Return Training Bracket should not be adjusted while the conveyor is in operation.

APPLICATION GUIDELINES

A belt training device will correct many belt alignment issues, but some issues require more extensive work to correct. Contact PPI for additional guidelines on belt misalignment and tracking.

The Return Training Bracket is designed to fit standard PPI CEMA B, C, and D shaft ends.

The Return Training Bracket should be placed ahead of areas where the belt is misaligning. Multiple brackets may be placed near each other in troublesome areas. It can be used in any area where return idlers are typically knocked.

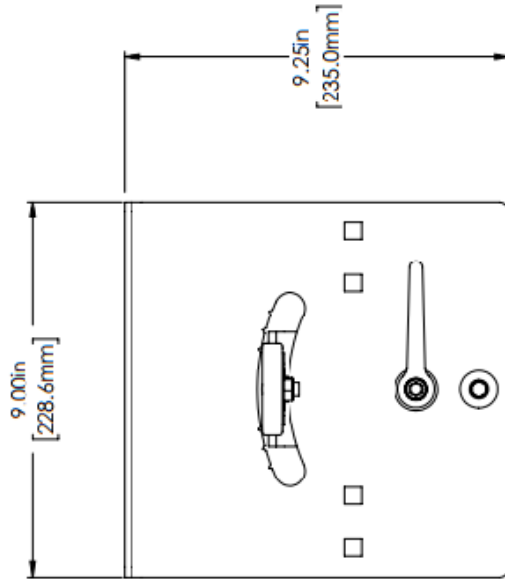
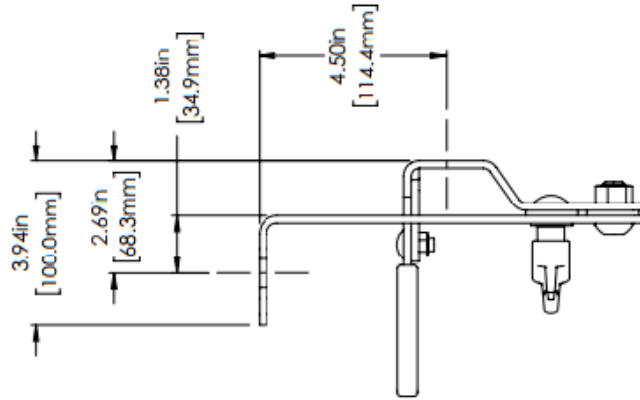
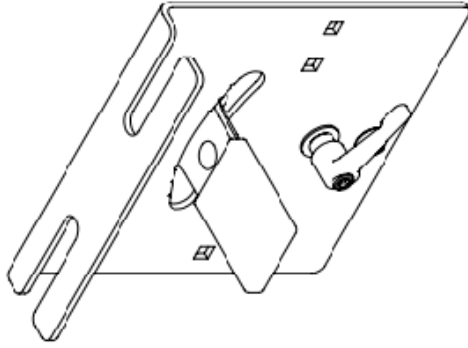
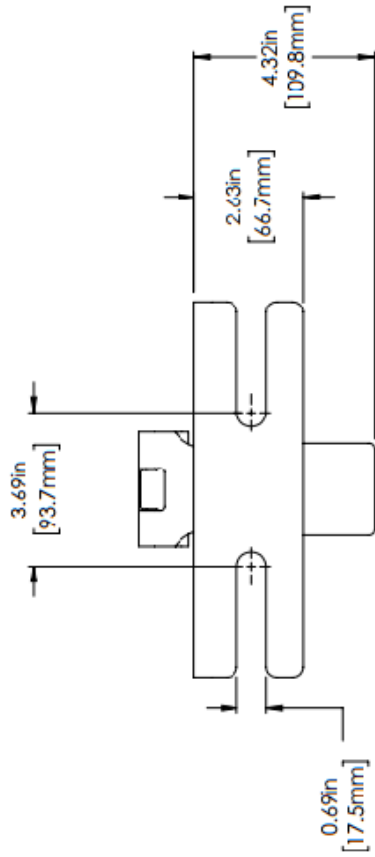
The Return Training bracket will not be as effective in areas of high belt tension or near pulleys. It should not be used in belt transition areas or in a vertical or horizontal curve.

The Return Training Bracket should not be used with a reversing belt.

The Return Training Bracket should be installed in an area of the conveyor that is easily accessible and will not interfere with the bracket's manual adjustment.

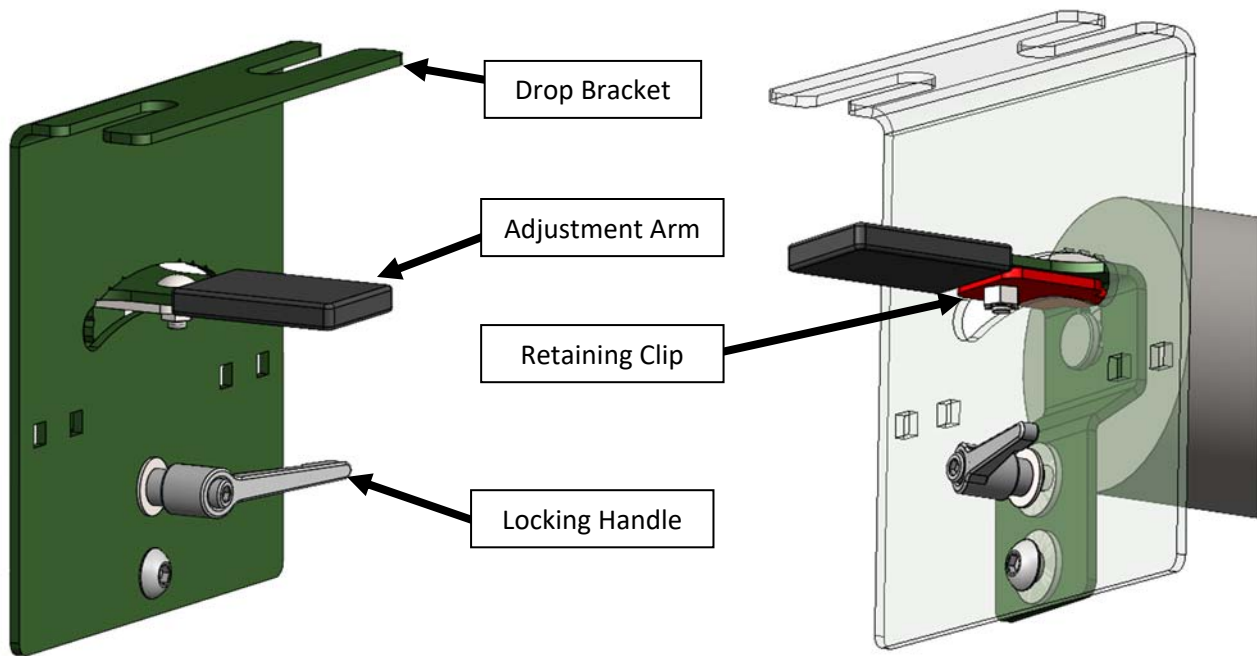
CERTIFIED DRAWING

This drawing is intended to verify the form and fit of this product and is not intended to show performance, construction, or manufacturing details. Contact PPI if more information is desired.



Dimensions are in inches	WT: 6.65	lbs	PROPERTY IS CONFIDENTIAL AND UNCLASSIFIED IN THE DRAWING IS THE SOLE PROPERTY OF PPI. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF PPI IS PROHIBITED.	ITEM DESCRIPTION	Rev: 0	Date:	PRECISION PULLEY & IDLER	
	SCALE: N/A	RETURN TRAINING BRKT BCD 4.5					BY: CAB	DWG NO: TE985-4.500C
							DATE: 12/06/23	PART NC: TE985-4.500

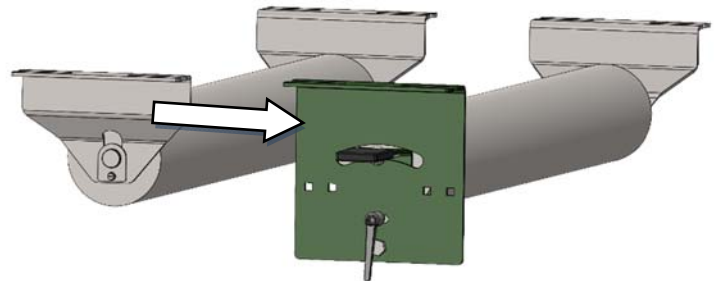
COMPONENTS



INSTALLATION

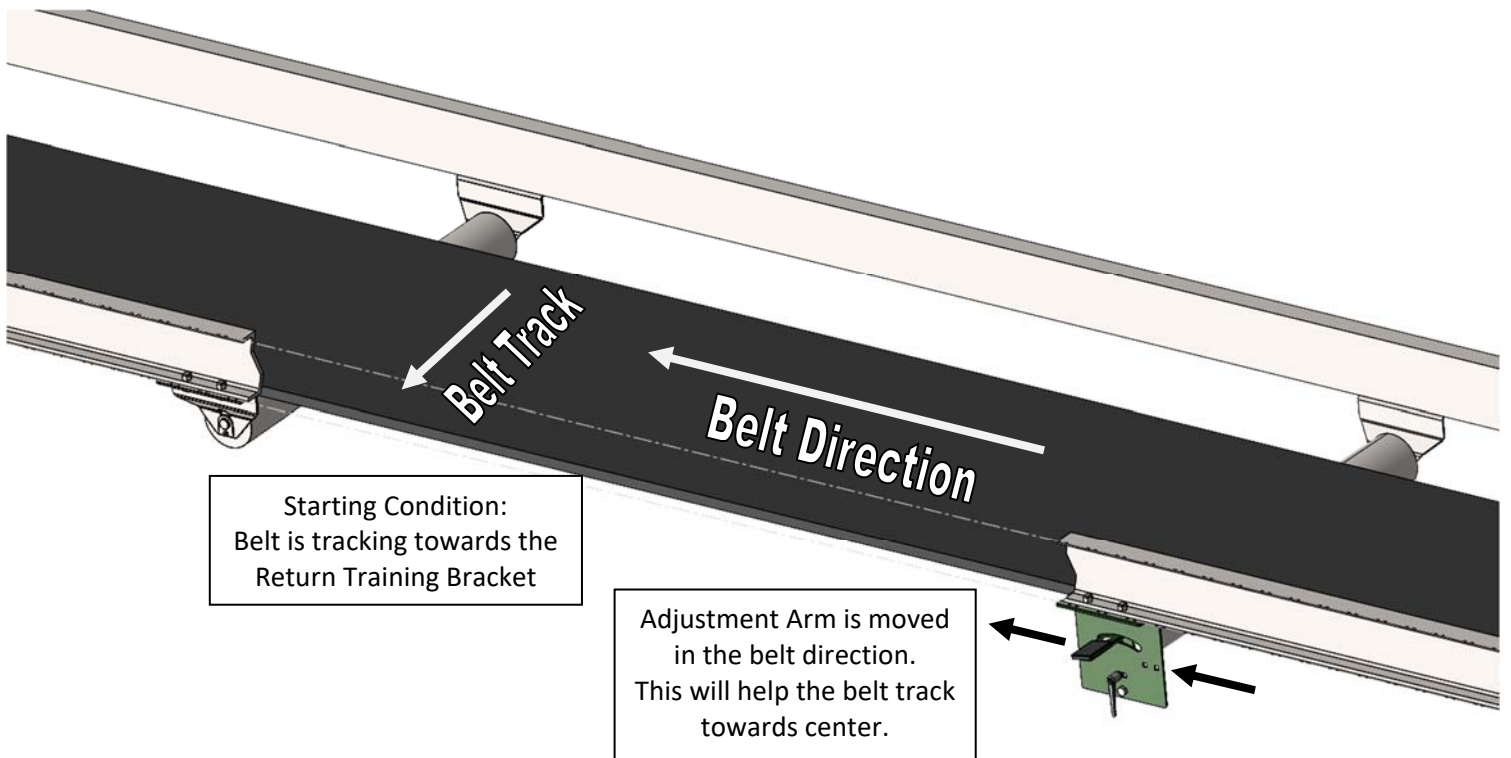
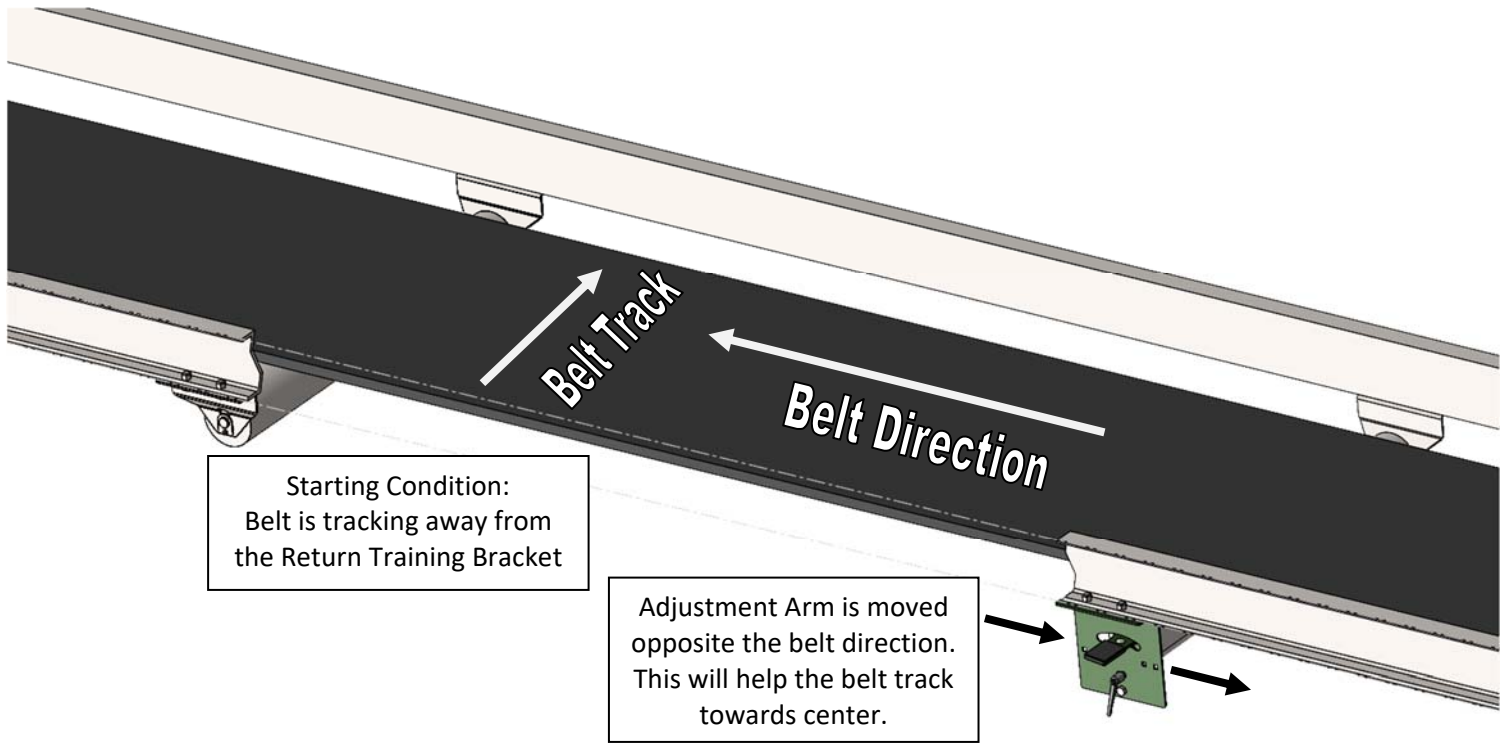
1. Stop the conveyor and lock it out according to site specific safety procedures.
2. Remove the current return roll and one of the current drop brackets from the conveyor.
3. Install the Return Training Bracket.
4. Install the Return Roll. The Retaining Clip on the Return Training Bracket may need to be removed before installing the roll.
5. Install the Retaining Clip
6. Position the Adjustment Arm at neutral / 0 degrees. The roll should be square with the belt.
7. Tighten the Locking Handle to lock the Adjustment Arm in place.

Recommended: Square all idlers with the conveyor structure before operating the Return Training Bracket for the first time



OPERATION

1. Run the conveyor and check belt alignment over several full cycles of the belt. Note the belt movement direction. If the belt is misaligning, also note the direction of misalignment relative to the training bracket:
 - A. Belt tracks away from the Return Training Bracket
 - B. Belt tracks towards the Return Training Bracket
2. Stop the conveyor and lock it out according to site specific safety procedures.
3. Loosen the Locking Handle of the Return Training Bracket. Move the adjustment arm according to the direction the belt was tracking in Step 1:
 - A. Belt tracks away from the Return Training Bracket: Move the adjustment arm 2-5 degrees opposite the belt movement direction.
 - B. Belt tracks towards the Return Training Bracket: Move the adjustment arm 2-5 degrees in the belt movement direction.
4. Tighten the Locking Handle to lock the adjustment arm in place.
5. Restart the conveyor and repeats Steps 1-4 until the belt is properly aligned. As the belt gets closer to acceptable alignment, adjust the angle by smaller amounts to fine-tune the tracking.



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