



Technical Documentation

SRF-P 2045 ACCUMULATING ROLLER CHAIN CONVEYOR

Each serial number is unique to that specific conveyor and provides mk North America with complete order details.

The conveyor serial number is located on the frame at the drive end of the conveyor. See section 2 for more details.

Your serial number is also recorded above.

Ensure the serial number tag above matches the serial number on your conveyor.

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1 GENERAL INFORMATION

1.1 Foreword

Congratulations on purchasing a conveyor from mk North America, Inc., a leading manufacturer of quality low profile conveyors. Our more than 25 years experience in material handling allows us to offer robust solutions with long life and reliable operation. We strive to make the best products in the industry even better and we are committed to making sure our customers get top notch support before, during, and after each and every sale.

1.2 The importance of reading your manual

Inside this manual you will find the instructions on how to set up and maintain your mk conveyor properly, as well as maximize its performance. Please take the time to read this manual and familiarize yourself with these set up and maintenance instructions. These instructions will help assure a long product life that requires a minimum amount of service and keeps your conveyor working at its maximum capacity.

1.3 If you need assistance

If you need assistance there are a variety of ways to get it. You can contact our customer service team Monday through Friday, 8am-5pm (Eastern Time) at 860-769-5500. You can also visit our website for additional information and technical documentation at www.mknorthamerica.com. In addition, your local representative can provide support in many instances.

1.4 When your shipment arrives

- 1) Check your shipment
 - a) If you have not already done so, visually inspect the shipping crate/container for any damage caused during shipment.
 - b) Carefully unpack the crate/container making sure to inspect the components for damage that may have occurred inside the packaging materials.
 - c) If you find any damage, please contact the carrier and mk North America, Inc.
 - d) Lastly, check the contents against the packing slip provided by mk for any discrepancies. If you should find any, please contact mk North America, Inc.
- 2) Locate your ordered items
 - a) Each mk conveyor will ship in its own custom built container, carefully packaged in the most economical way.
 - b) Review the packing slip against your Purchase Order.

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2 DECODING YOUR SERIAL NUMBER

- The conveyor's serial number is located on the frame at the drive end of the conveyor.
- See image below for label example.
- **YOUR SERIAL NUMBER IS ON THE FRONT COVER OF THIS MANUAL.**
- We have provided an area in the back of this manual for you to add any notes about this unit.



Serial #: This number is unique to this item. With this number we can access all of the original order details.

Date: This is the date that the unit was scheduled to ship.

Type: This description refers to the type of unit that is associated with the particular serial number. The type should NOT be substituted for the serial number when inquiring.

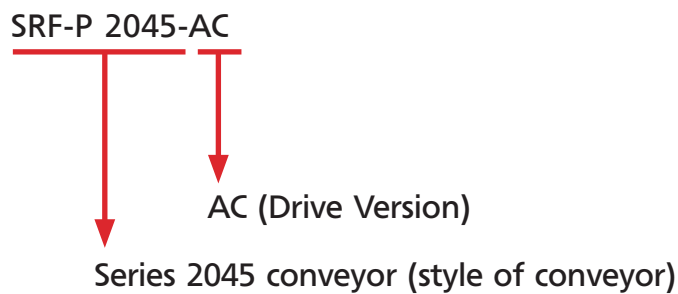
DWG#: This number, if applicable, refers to the specific drawing that was created for this unit. The first drawing number refers to the overall system. The second drawing number is for the specific conveyor.

SO#: This is the shop order number in which this unit was built. This is an mk North America, Inc. internal number. This number is also referenced on any related invoices, etc.

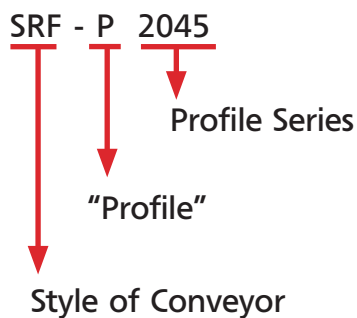
3 CONVEYOR DESCRIPTION

3.1 Conveyor Description

1.) Explaining the type of conveyor:



2.) Designations:



- GUF (Gurt Foerderer) Belt Conveyor
- KTF (Kettengurt Foerderer) Chain Conveyor
- KFG (Knickfoerderer Gurt) Bent Belt Conveyor
- KGF (Kurvengurt Foerderer) Curve Belt Conveyor
- MBF (Modulband Foerderer) Modular Belt Conveyor
- SBF (Scharnierband Foerderer) Hinged Belt Conveyor
- SRF (Staurollen Foerderer) Accumulating Roller Conveyor

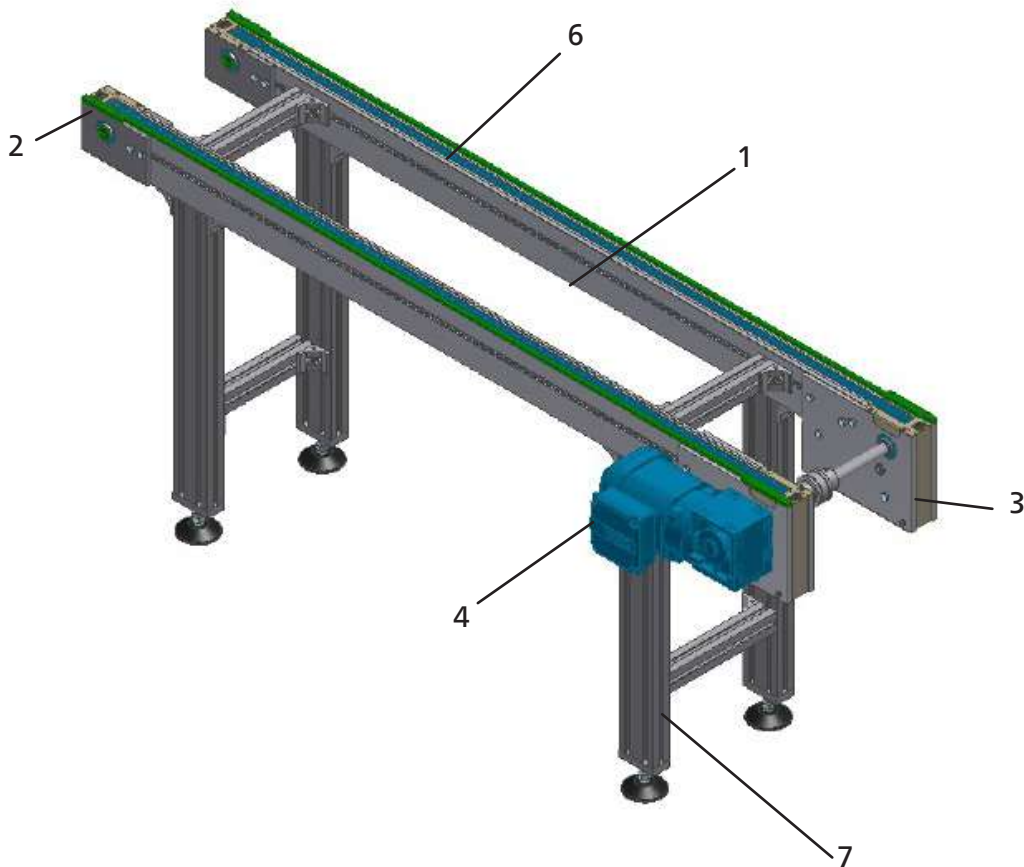
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3 CONVEYOR DESCRIPTION (CONT.)

3.2 Conveyor Components

The SRF-P 2045 has many typical conveyor components. Below is a description of the basic parts and options for the SRF-P 2045 conveyor. The items you receive will vary based on your actual purchase order. Items may appear different on your model based on your particular order requirements. Consult your approval drawing for specifics items included in your order.



Typical Components

- 1) Conveyor Frame
- 2) Idler End
- 3) Drive End
- 4) Gearmotor
- 5) Speed Control (Not Shown)
- 6) Conveyor Chain
- 7) Support Stand

4 WARRANTY INFORMATION

Limited Warranty

mk North America, Inc. (MKNA) warrants that our products are free from defects in workmanship and materials under normal use and with proper maintenance and cleaning for a period of ten (10) years from the date of shipping from MKNA's facility. This warranty is extended by MKNA only to the original purchaser of the equipment (Customer), and is non-transferable. All warranty requests shall be made by Customer.

MKNA will repair or replace, at our factory, any defective part within the warranty period and without charge. It is at MKNA's sole discretion whether to repair or replace. Customer will provide MKNA prompt written notice of the defect, including the serial number of the unit (when applicable) and the ship date.

This warranty does not apply to equipment and components manufactured by others, whether or not such equipment and components if the other manufacturer are covered by a warranty. Such equipment and components are subject to any limitation contained in the original manufacturer's warranty and include, but are not limited to: bearings, belts, casters, controllers, motors and pneumatic devices.

At MKNA's request Customer will return all defective parts for evaluation at MKNA. MKNA will provide the Customer with a return goods authorization number (RGA#). No parts will be returned without a RGA#. The RGA# must clearly be marked on all labels, packages and packing slips.

Customer shall pay all costs for packaging, shipping, duties and/or any other related costs in the sending or receiving of parts. Customer is responsible for all labor associated with sending or receiving of parts.

No work will be performed by MKNA or an MKNA factory authorized service representative at the site of installation unless in MKNA's opinion it is impractical for Customer to remove and return the defective part to MKNA's factory.

MKNA PROVIDES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE; UNLESS IT IS AGREED TO BY MKNA AND CUSTOMER IN WRITING PRIOR TO PLACEMENT OF ORDER. Such agreement requires approval of MKNA management.

UNDER NO CIRCUMSTANCES SHALL MKNA BE LIABLE FOR DAMAGES OR LIABILITY FOR LOSS OF PRODUCTION, PRODUCT, EQUIPMENT OR PROFITS OR LIABILITY FOR DIRECT, INCIDENTAL, INDIRECT, SPECIAL OR CONSEQUENTIAL DAMAGES OR ANY DAMAGES TO PERSONS OR PROPERTY, WHATSOEVER. Customer agrees that Customer's sole remedy for liability of any kind, including negligence with respect to the equipment and services furnished by MKNA shall be limited to the remedies provided herein. This warranty shall not apply to any failure of the unit or its components caused by lack of maintenance and/or improper maintenance, incorrect adjustments, misuse or unreasonable use or exposure to chemicals and/or environments which the unit is not designed for. Unauthorized modification of the unit or the use of non-MKNA replacement parts and building components voids this warranty.

EXCEPT AS EXPRESSLY STATED HEREIN, THERE ARE NO WARRANTIES, EXPRESSED OR IMPLIED, BY OPERATION OF LAW OR OTHERWISE, OF THE EQUIPMENT OR SERVICES FURNISHED BY MK OR FACTORY AUTHORIZED SERVICE REPRESENTATIVE. THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF.

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5 SAFETY REQUIREMENTS

READ AND UNDERSTAND ALL OF THESE WARNINGS PRIOR TO OPERATING EQUIPMENT.



⚠ DANGER
Climbing, sitting, walking or riding on conveyor at any time will cause severe injury or death.
KEEP OFF.



⚠ DANGER
DO NOT OPERATE CONVEYORS IN AN EXPLOSIVE ENVIRONMENT.



⚠ WARNING
Exposed moving parts can cause severe injury.
LOCK OUT POWER before removing guard.



⚠ WARNING
Moving equipment can cause severe injury.
KEEP AWAY.



⚠ WARNING
Gearmotors may be **HOT**.
DO NOT TOUCH gearmotors.



⚠ WARNING
Loosening stand height or angle adjustment screws may cause conveyor to drop down, causing severe injury.
SUPPORT CONVEYOR SECTIONS PRIOR TO LOOSENING STAND HEIGHT OR ANGLE ADJUSTMENT SCREWS.

 **WARNING**

Injury is possible if the stands are not lagged to the floor, cross ties are not used, or angle braces are not present. Never place a conveyor in operation until all proper mounts are installed and secured. It is the end user's responsibility to ensure that the support system is safe and secure.

 **WARNING**

Never operate equipment unless all operating instructions are understood and all guards, interlocks, covers, safety devices or circuits and protective components are functioning properly.

 **WARNING**

Never operate or service this equipment if under the influence of alcohol, drugs or other substances or conditions which decrease alertness or judgement.

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6 WEAR ITEMS & MAINTENANCE

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6 WEAR ITEMS & MAINTENANCE (CONT.)

6.1 Important Notes About Wear Items & Maintenance

The following information regarding life of the wear items and service or adjustment intervals of the functional elements are only GUIDELINES. Conveyors are application-specific products whose life expectancy can vary depending on their relative loads and speeds, and which can be significantly influenced by environmental factors.

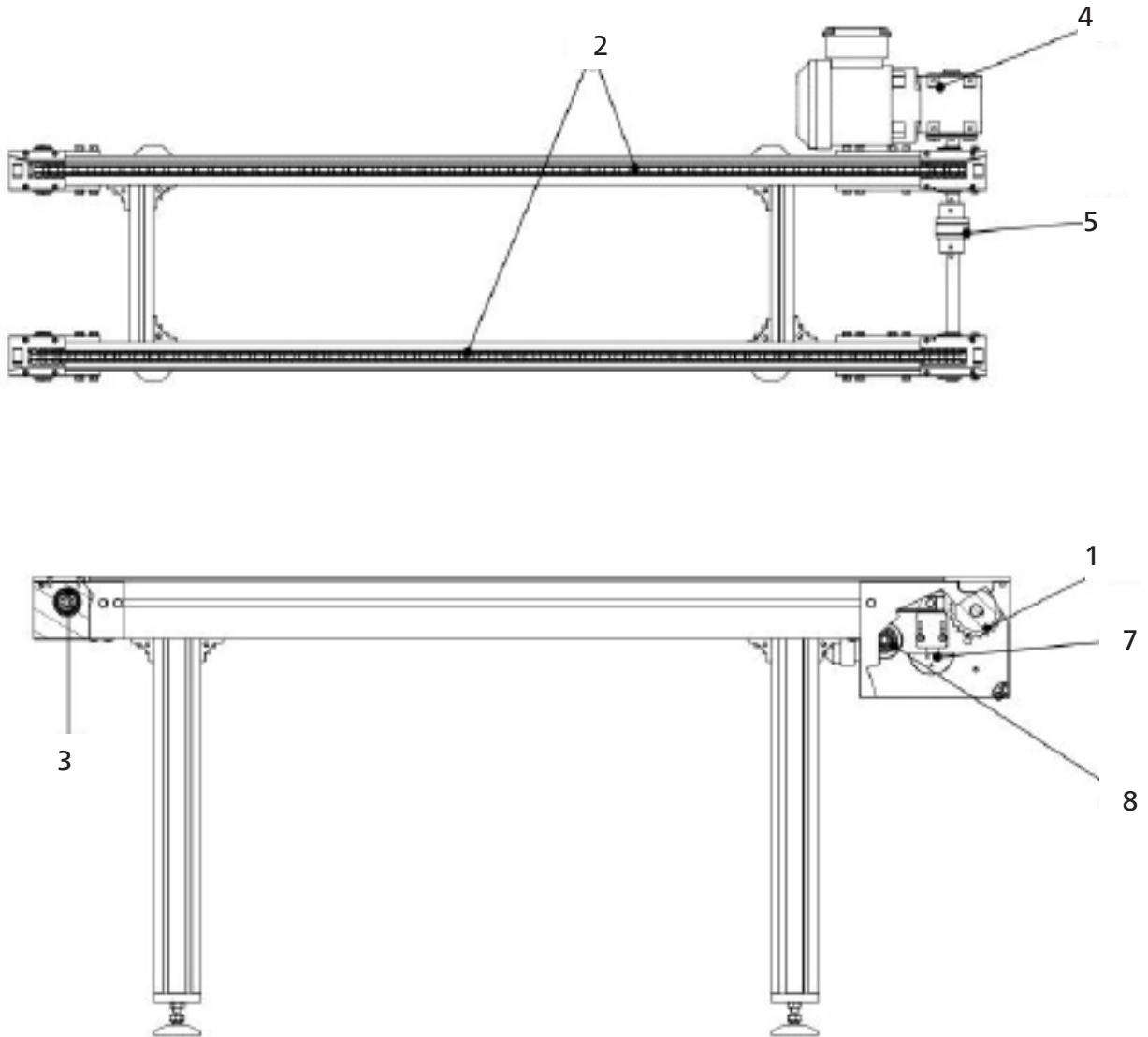
- All moving components and screw connections should be checked every 6 months.
- All safety-relevant components should be part of a regularly scheduled weekly inspection
- The proper function of these components must be confirmed at all times.
- Do NOT operate conveyors if safety-relevant components are damaged or missing.
- All parts which contact the product should be cleaned weekly (example: chain).

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6 WEAR ITEMS & MAINTENANCE (CONT.)

6.2 SRF-P 2045 AF



NOTE: Not all items shown in all views for clarity. Not all views are to scale.

(Cont.)

6 WEAR ITEMS & MAINTENANCE (CONT.)

6.2 SRF-P 2045 (Cont.)

Maintenance Work for SRF-P 2045 AF

| Position | Description | Action* | Interval in Hours (Months) | Lubricant |
|----------|------------------------|---------|--|-------------|
| 1 | Pulley | I, C | 500 Hours (Max. 3 Months) | |
| | | R | If wear is indicated | |
| 2 | Chain | I, C, L | 500 Hours (Max. 3 Months) | SAE20-SAE50 |
| | | R | If stretch is greater than 3% | |
| 3 | Bearing | I | 1,000 Hours (Max. 6 Months) | |
| 4 | Gearmotor | I | Service & Maintenance per manufacturer's documentation | |
| 5 | Coupling | I | 500 Hours (Max. 3 Months) | |
| 6 | Wear strip (not shown) | I, C | 500 Hours (Max. 3 months) | |
| | | R | If wear is indicated | |
| 7 | Tensioner | I, C | 500 Hours (Max. 3 Months) | |
| | | R | If wear is indicated | |
| 8 | Roller | I, C | 1,000 House (Max. 6 Months) | |
| | | R | If wear is indicated | |

* LEGEND: *Inspect, Replace, Tension, Clean, Lubricate (grease).*

Wear Items for SRF-P 2045 AF

| Position | Description | Part Number |
|----------|-------------------------|-------------------------------|
| 1 | Pulley | 58.12.0046 |
| 2 | Chain & Connecting Link | Inquire with mk North America |
| 3 | Bearing | 7-20.002-462-006 |
| 4 | Gearmotor | Inquire with mk North America |
| 5 | Coupling | Inquire with mk North America |
| 6 | Wear strip | Inquire with mk North America |
| 7 | Tensioner | 7-20.002-402-007 |
| 8 | Roller | 7-20.002-402-004 |

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7 CONVEYOR CHAIN MAINTENANCE - TENSIONING



All work to be performed by qualified personnel only.
Conveyor power must be disconnected before servicing.



7 CONVEYOR CHAIN MAINTENANCE - TENSIONING (CONT.)



All work to be performed by qualified personnel only.

Tensioning Device - General Notes

The chain is adjusted and tensioned by an automatic tensioner.

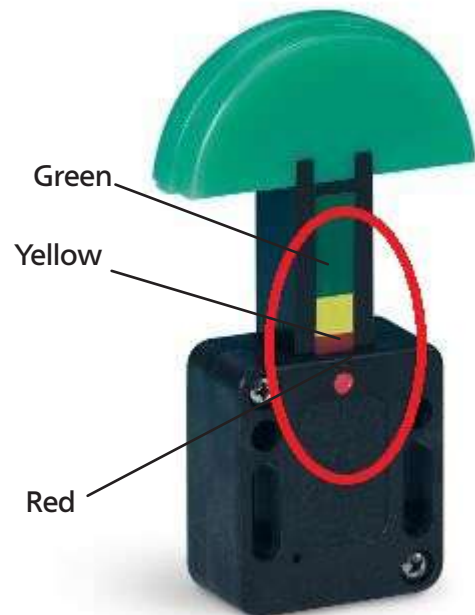
To check the chain tension, it is necessary to view the color scale on the tensioner, see below for location.

Color Scale

Green: Chain is Ok.

Yellow: Chain is elongated, but still OK.

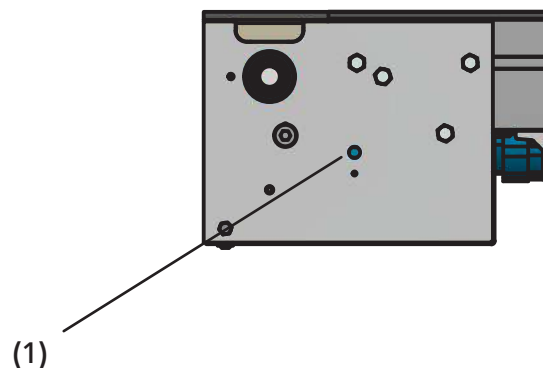
Red: Chain is elongated more than recommended. It is necessary to replace the chain.



Tensioning Device - Locating

On the drive end of the conveyor, on the side opposite of the motor there is a viewing hole for the chain tensioner. It is located (1) in the image to the right.

There is a chain indicator sticker around it for identification (see image below).



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8 CONVEYOR MAINTENANCE - CHAIN REPLACEMENT



All work to be performed by qualified personnel only.

Conveyor power **must** be disconnected before replacing the chain.



Chain Replacement - Replace on Both Sides of Conveyor

Loosen screws (1) and remove the upper guard (3) and wear strip (2).

Loosen screws (4) and remove the bottom guard (5).

Turn on the shaft until the connecting link is in position (6). NOTE: It may be necessary to remove the coupling in order to turn the shaft.

Press the tensioner back, with the appropriate tool to remove tension from the roller chain. Then put a #3 Allen wrench into hole (7) to hold the tensioner in place.

The tension has been released from the chain; the chain can now be removed.

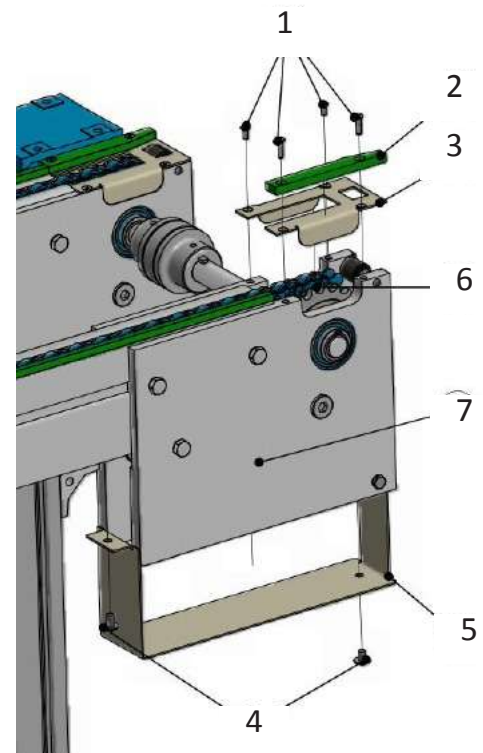
Open chain at the connecting link with the appropriate tool.

Thread chain through conveyor, joining as necessary using connecting links (master link).

Remove the allen wrench from hole (7) to engaged the tensioner.

Reassemble the conveyor in reverse order, ensuring all of the guards are in place prior to powering back on.

NOTE: When replacing the belt on the motor side, you will need to remove the motor first.



9 AUTOMATIC LUBRICATION - OPTIONAL ACCESSORY

Lubrication Station (Optional)

To check:

Check for oil leaks at both valves (2).

To Replace Oil Cartridge:

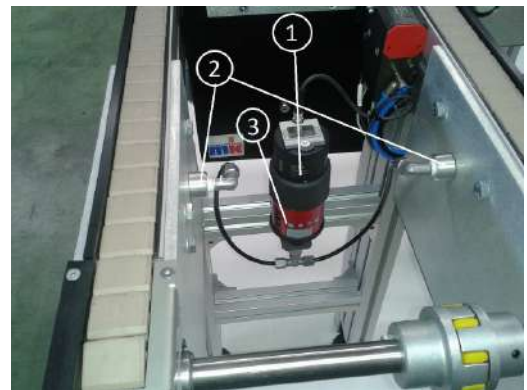
See "Instructions Manual" of the manufacturer.

The model is Star Control, from PERMA.

The oil cartridge is LC-M120-SO14, of reference 101096.

NOTE: Item 1 is the programming unit and may not be on all models.

Note: Item 3 is the oil cartridge.



10 NOTES & CONTACT INFORMATION

10.2 Contacting mk North America, Inc.



Email: sales@mknorthamerica.com



Phone: 860.769.5500



Fax: 860.769.5505

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SRF-P 2045
Accumulating Roller Chain
Conveyor

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