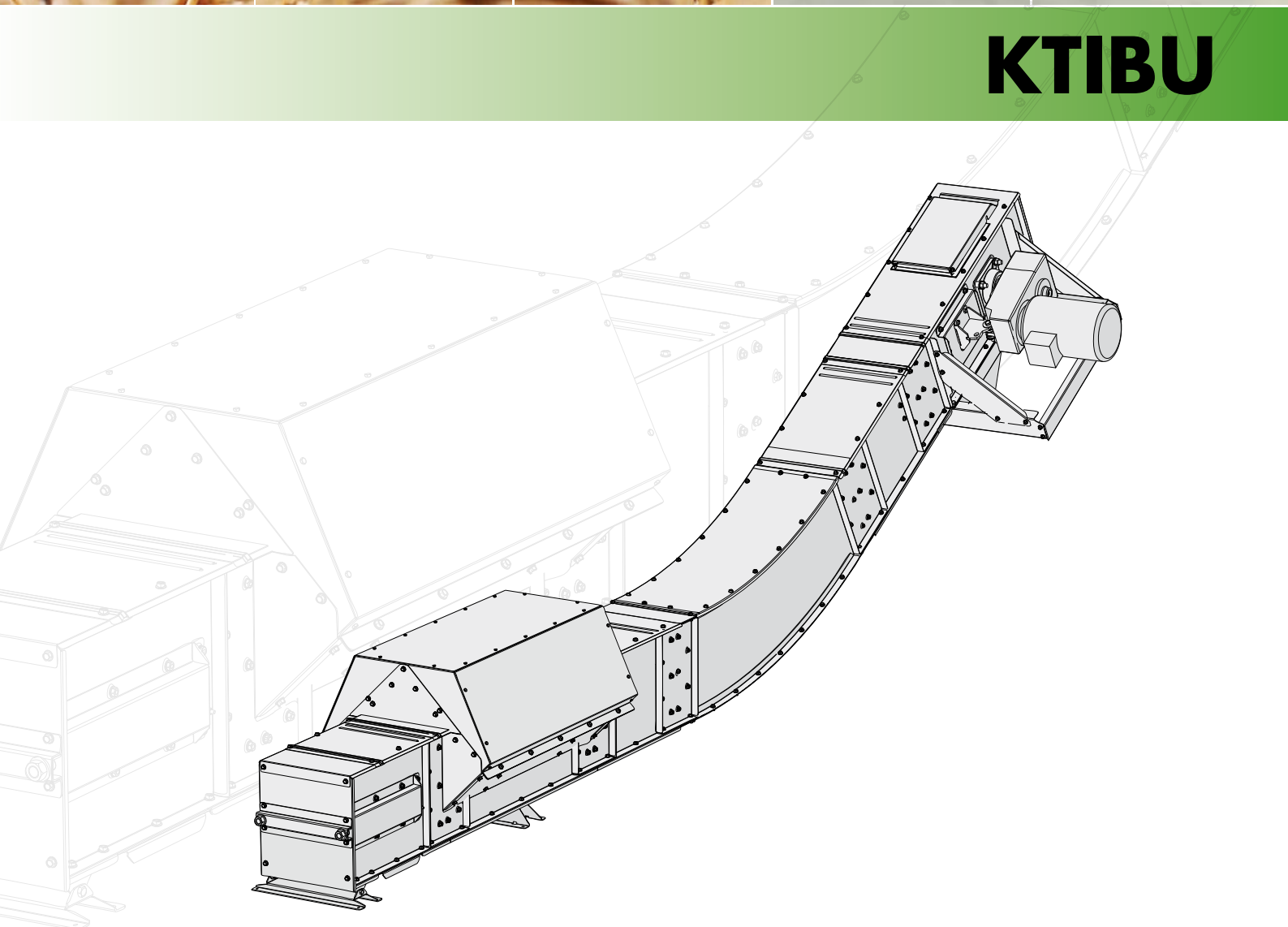


KTIBU



Goods inspection

Check that the number of packages agrees with the delivery note and that the packing and goods are not damaged. Make a note of any damage and missing materials on the consignment note and report it to the carrier and to us. Make sure the delivery is complete after unpacking the goods. Any materials that are found to be incorrect must not be assembled.

Warranty

A 2-year factory warranty from the day of delivery applies to all models of Skandia Elevator AB machinery. A condition of the warranty and any subsequent compensation is that Skandia Elevator AB is contacted and an agreement reached between the customer and Skandia Elevator AB on how any faults should be rectified. The warranty covers all parts that are damaged or break due to faulty design or manufacture. Faults and damage caused by faulty assembly, incorrect use or lack of maintenance will not be covered by the warranty.

CE mark

A CE mark is located on the right-hand side plate of the drive and is proof that the machine has been manufactured in accordance with EU machine directives and complies with safety requirements. The CE mark contains information concerning year of manufacture, model designation and order number. The order number is also specified on the CE declaration shown below. Always specify the order number in the event of a claim and on orders for spare parts.

EC Declaration

Skandia Elevator AB
Arentorp
S-53494 Vara
SWEDEN

declare under our sole responsibility that the product:

KTIBU

order number:

to which this declaration relates is in conformity with Council Directive of 29 December 2009 on the harmonisation of the member States relating to machinery, 2006/42/EC.

Unless otherwise specified on the CE mark, the product is manufactured in accordance with EU Machinery Directive and is classified as Category II 2D/OD. It is intended for the transport of materials that correspond with ATEX Zone 21 and the external environment is unclassified.

Vara 29/12 2009

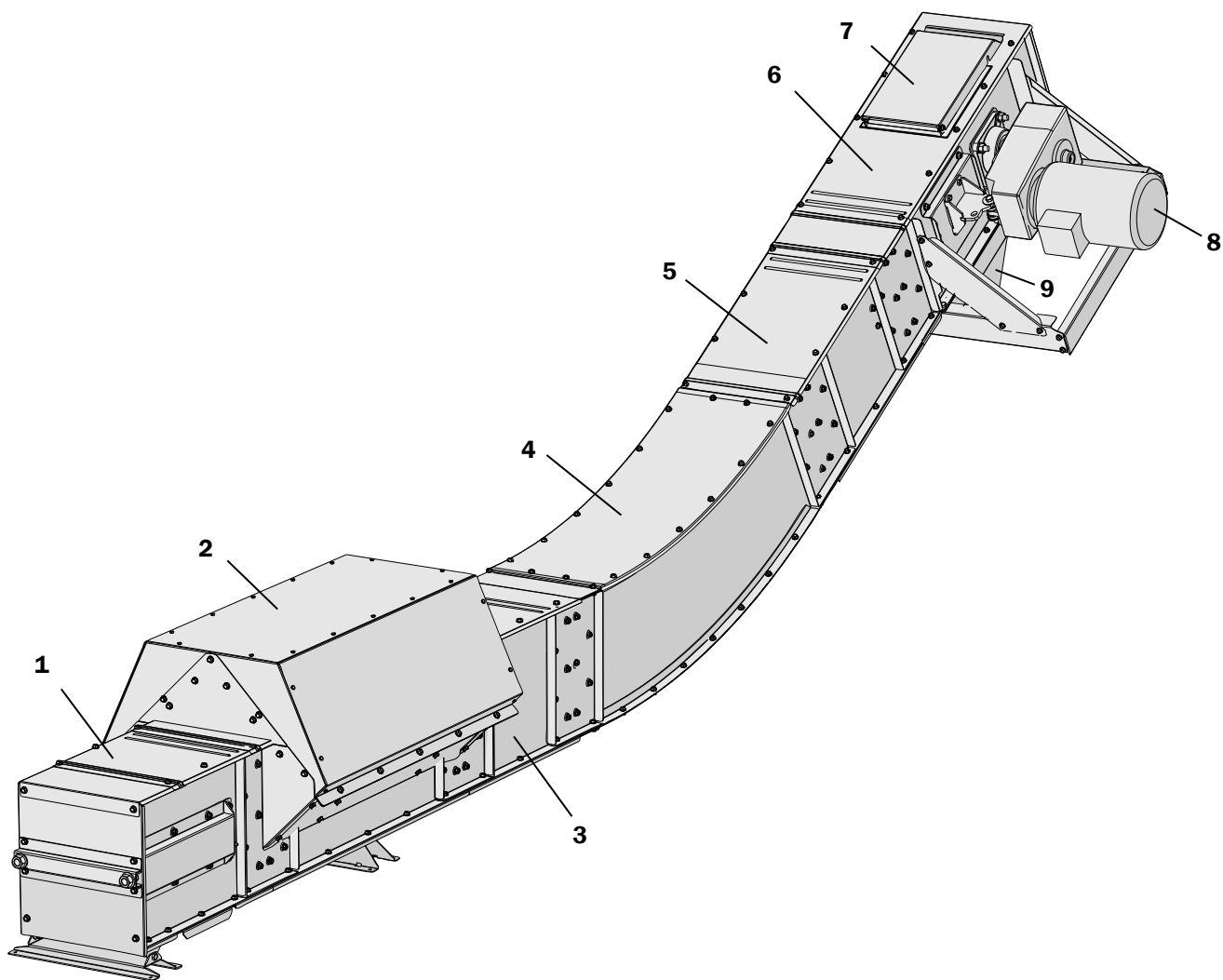
Joakim Larsson, CEO

Thank you for choosing Skandia Elevator!

Your conveyor system must be assembled correctly and maintained thoroughly if it is to operate satisfactorily. These assembly instructions and the separate maintenance instructions must be followed for the warranty to apply.

We hope you will be pleased with your Skandia conveyor equipment for a long time.

Machine overview	6
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Before assembly	9
Construction dimensions for bend and incline sections	11
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Side inlet	12
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Parts	Pos.
Tail end	1
Side inlet	2
Intermediate section	3
Bend section	4
Intermediate section	5
Drive	6
Pop-up overloading flap	7
Geared motor	8
Outlet	9

Incorrect assembly and/or operation may lead to personal injury or damage to the conveyor equipment and/or other equipment. It can also cause malfunctions or a reduction in capacity.

Read the assembly instructions thoroughly before proceeding with the assembly. The safety information is presented and interpreted as follows:



WARNING!

Ignoring the instructions given in a warning text may cause personal injury and risk of fatality in certain cases.



IMPORTANT!

Ignoring the instructions given in important texts may cause damage to the conveyor equipment and/or other equipment. It can also cause malfunctions or a reduction in capacity.

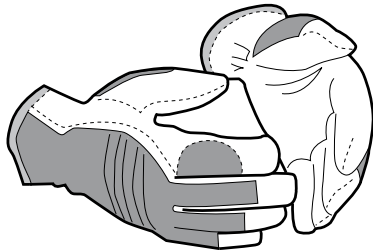
NB! indicates that the text contains information that will simplify the assembly process.

General safety information



WARNING!

Always use protective gloves when assembling and operating the conveyor equipment.



WARNING!

Ensure that the person responsible for the operation of the machine is well informed with its function and safety regulations.



WARNING!

The machine is equipped with guards and warning labels in accordance with EU machine directives. Read and make a note of all warning labels before taking the machinery into service.



WARNING!

Stop the machinery and turn off electric power before attempting any type of assembly or maintenance work.



WARNING!

Do not start the machinery without the lid, hatches, covers, guards and connections fitted in such a way they can only be opened with tools.



WARNING!

Connections to, from and between machinery must be permanently mounted and fully enclosed. If the design of the installation does not allow this at an outlet, finish off with a 1 m pipe.

**IMPORTANT!**

The conveyor cannot be operated in both directions.

**IMPORTANT!**

Ensure the micro switch for the pop-up overloading flap is engaged during operation.

**IMPORTANT!**

Refer to separate maintenance instructions for directions on maintenance and troubleshooting before taking the machine into service.

Electrical safety

**WARNING!**

The motor must be installed by a qualified electrician.

**WARNING!**

The power switch must be permanently mounted and located to allow easy access when carrying out maintenance work.

**IMPORTANT!**

Ensure the motor protection is set to the correct ampere setting for the motor.

**IMPORTANT!**

If the machine is being assembled outdoors, the motor/transmission/geared motor must be fitted with a weather cover.

The conveyor can be assembled directly in place in the installation or separately and then lifted in place. The design and space requirements of the installation and the length of the conveyor will determine which method is most suitable.

⚠ IMPORTANT!

- The conveyor length must not exceed 14 metres if being lifted after assembly. Its weight must be distributed over several lifting points with one supporting the support frame of the drive. The distance between the lifting points must be a maximum of 12 metres.
- The maximum span between supports for a standard conveyor is 6 metres. This distance is 12 metres if cable supports are used.
- Relieve the weight of the drive with braces to the ground and/or a nearby stable construction. If the machine has a geared motor, brace its support frame. Never use the motor/geared motor to brace on.

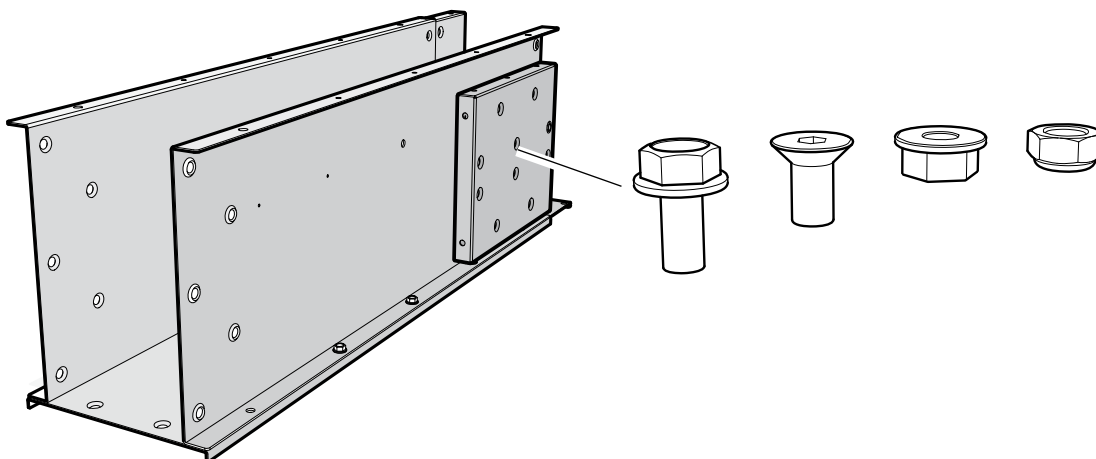
1.

Remove joining plates that are fitted the wrong way round inside/outside intermediate sections and in the drive. Screws for assembling the conveyor are underneath.

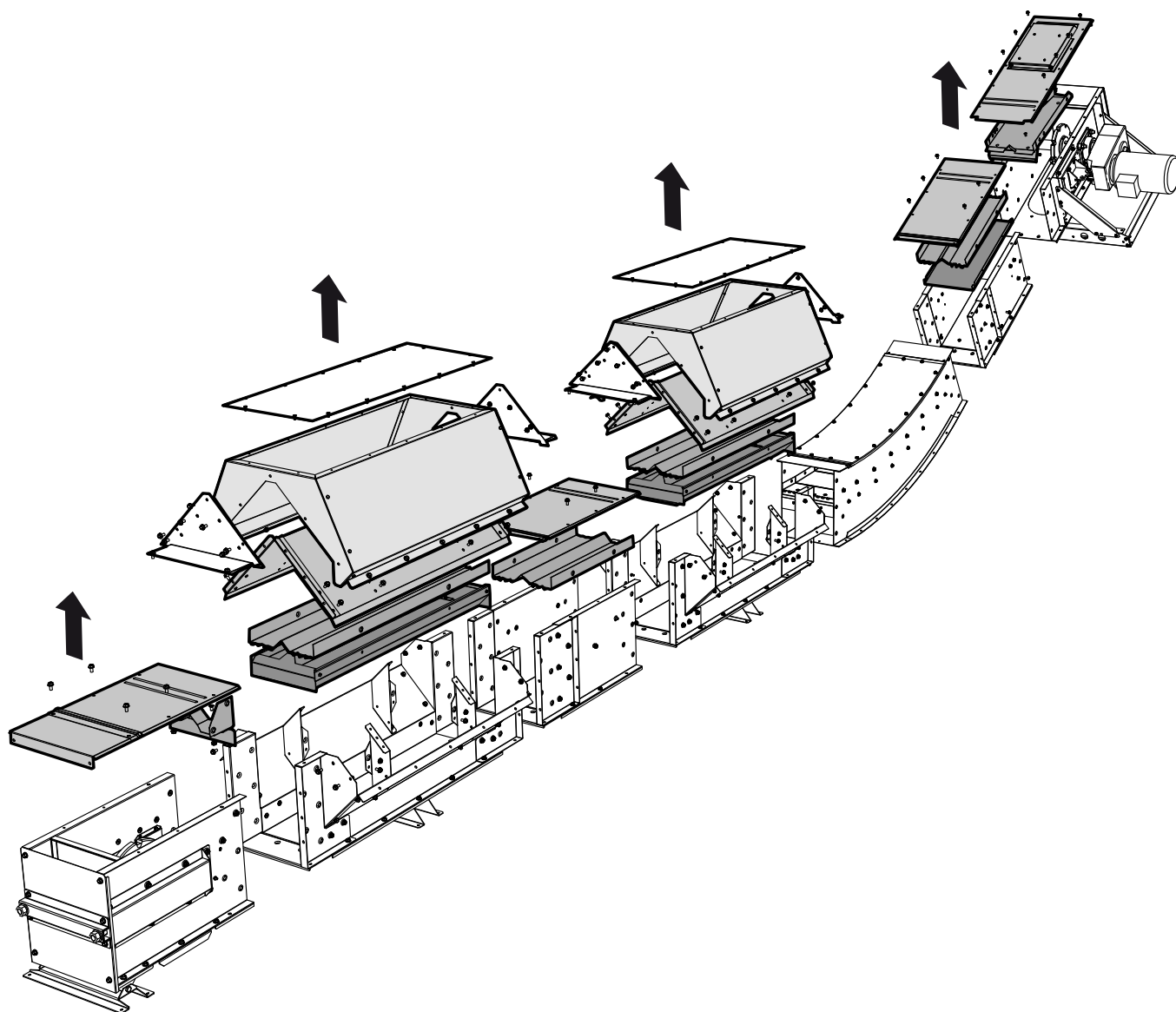
NB! The screw used to fasten the joining plate is not needed for assembly.

2.

Fit joining plates that have been removed in the same manner and at the same end as the preassembled joining plates.



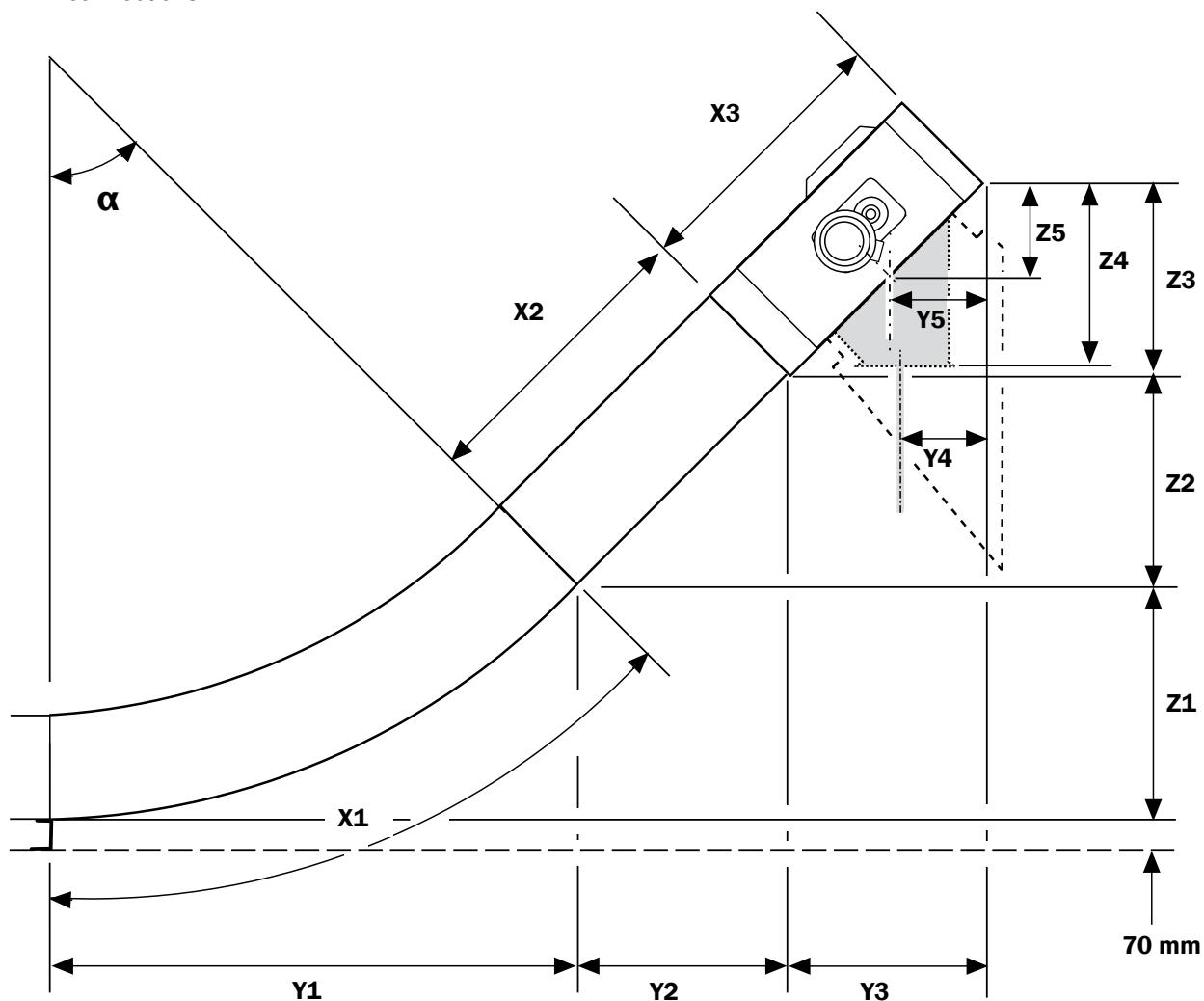
3.
Lay out the machine parts in the order they are to be assembled.
4.
Remove the lid plates and the intermediate trays.



Construction dimensions for bend and incline sections

IMPORTANT!

Ensure the machine is situated correctly in relation to the planned connections.



α	X1	Y1	Z1	X2	Y2	Z2	X3	Y3	Z3	20/30		30/40		40/40		Y5	Z5
										Y4	Z4	Y4	Z4	Y4	Z4		
15°	645	647	85	600	580	155	1000	966	259	553	343	474	412	346	455	483	128
				1000	966	259											
				1400	1352	362											
				2000	1932	518											
				13600	13136	3520											
30°	1309	1250	335	600	520	300	1000	866	500	518	465	438	534	329	577	433	250
				1000	866	500											
				1400	1212	700											
				2000	1732	1000											
				7000	6062	3500											
45°	1963	1768	732	600	424	424	1000	707	707	483	922	414	991	304	1034	354	354
				1000	707	707											
				1400	990	990											
				2000	1414	1414											
				5000	3535	3535											



WARNING!

Connections to, from and between machinery must be permanently mounted and fully enclosed. If the design of the installation does not allow this at an outlet, finish off with a 1 m pipe.



IMPORTANT!

- Use only recommended inlet, outlet and connecting components.
- Ensure the ducting is dimensioned sufficiently and that its angle of inclination is at least 45°.

Side inlet

Side inlets are self-regulating and used for feeding from a silo/storage bin.

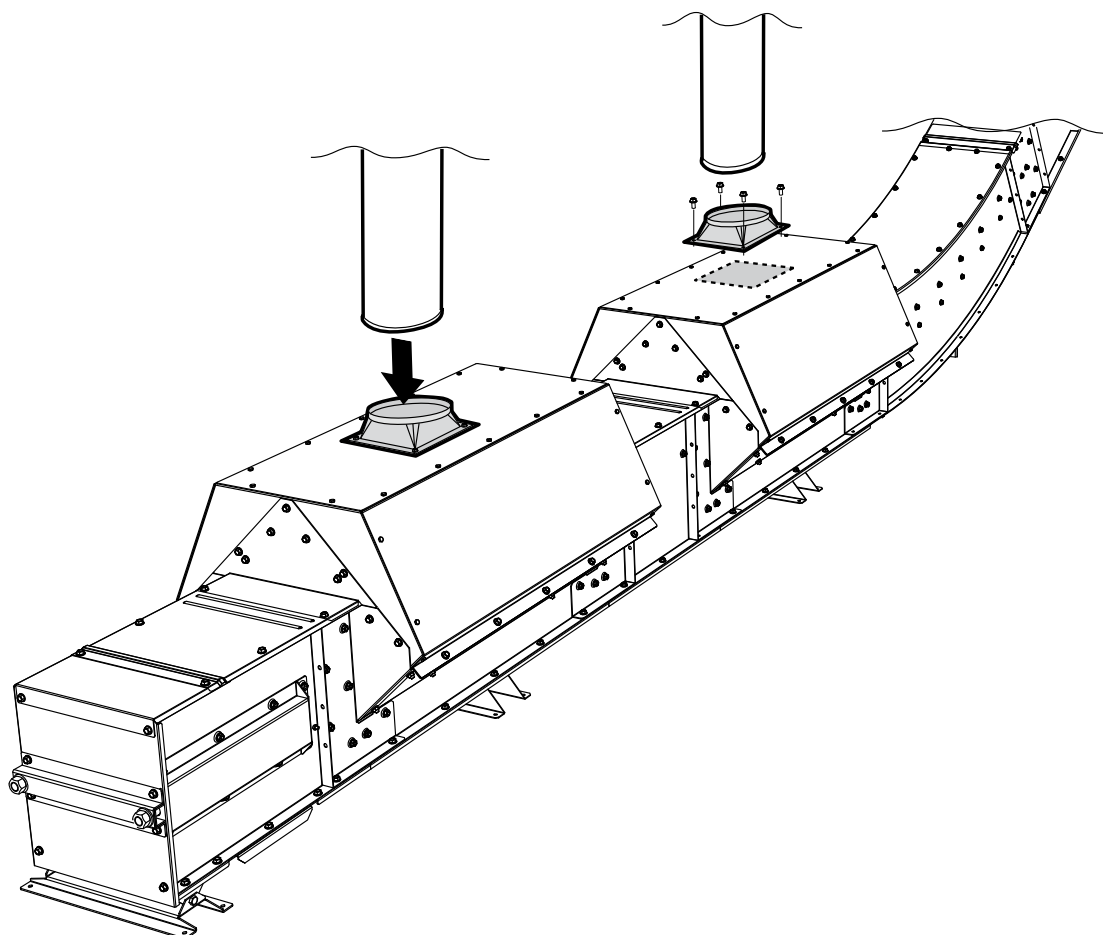
Connection between side inlet and silo/storage bin



IMPORTANT!

- Centre the connection hole on the lid plate of the side inlet if possible.
- Connecting/feeding via one of the inclined lids on the side inlet can result in loss of capacity.

Assemble the connection components as described in the section "Assemble the machine".



Connection to subsequent machine

Connect the conveyor to the subsequent machine according to its assembly instructions.

Assemble the conveyor from the bend and outwards.

⚠ IMPORTANT!

Ensure the machine parts are assembled in a straight line and are not twisted.

1.

Fit the bottom screws.

Fit bottom joining plates where the bottom plates do not overlap.

NB! Use lock nuts.

⚠ IMPORTANT!

Ensure the bottom joints are smooth.

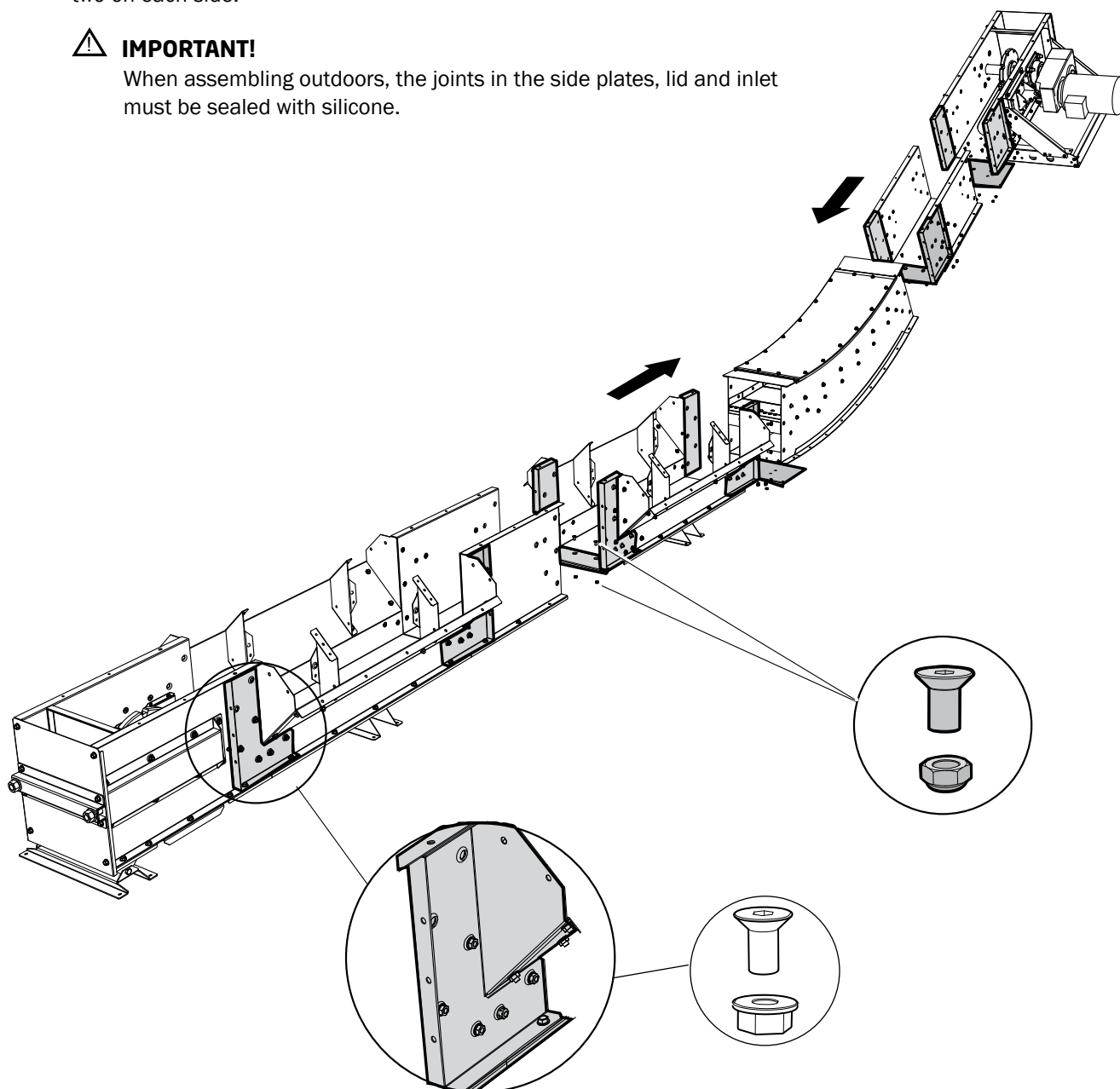
2.

Fit the side screws.

NB! Do not fit the screws yet that fasten the intermediate tray in the tail end, two on each side.

⚠ IMPORTANT!

When assembling outdoors, the joints in the side plates, lid and inlet must be sealed with silicone.

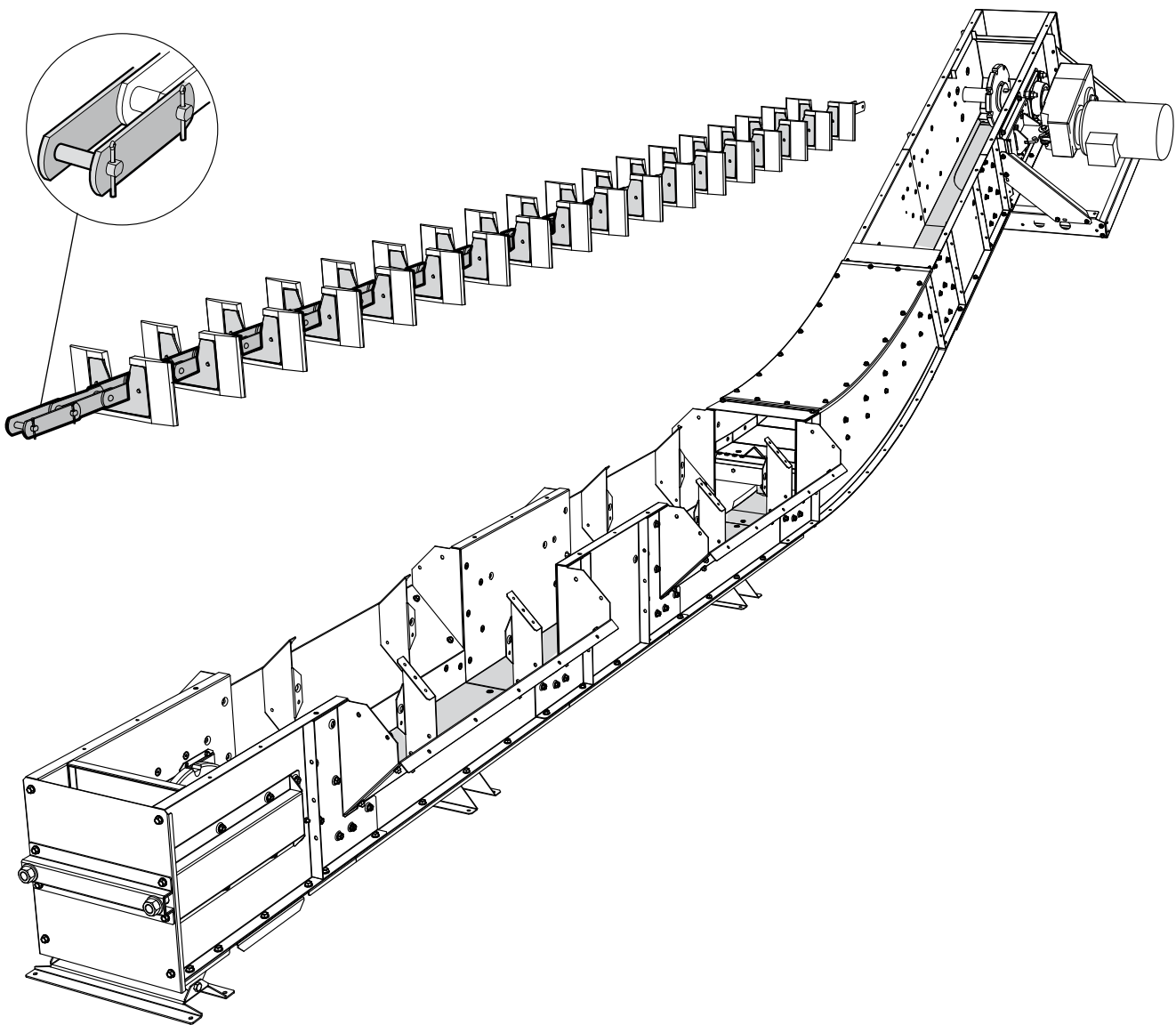


3.

Assemble the lengths of chain in the bottom of the conveyor.

NB! The chain brackets "push" the flights against the drive.

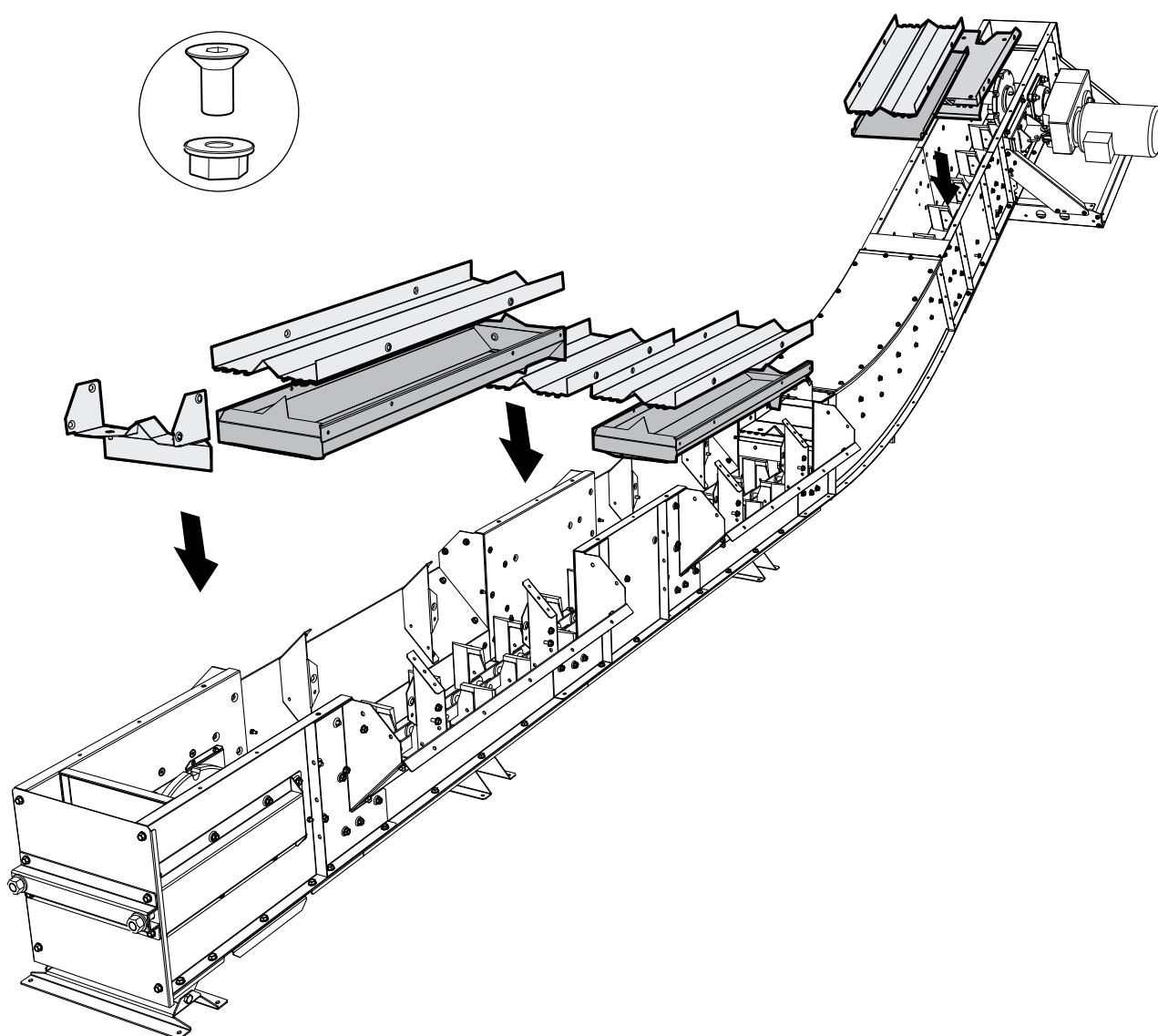
NB! Use a rope to pull the chain through the bend.



4.
Fit the intermediate trays from the bend and outwards.

⚠ IMPORTANT!

Fit the finger joints together correctly.



5.
Assemble the chain lengths on the upper level of the conveyor.

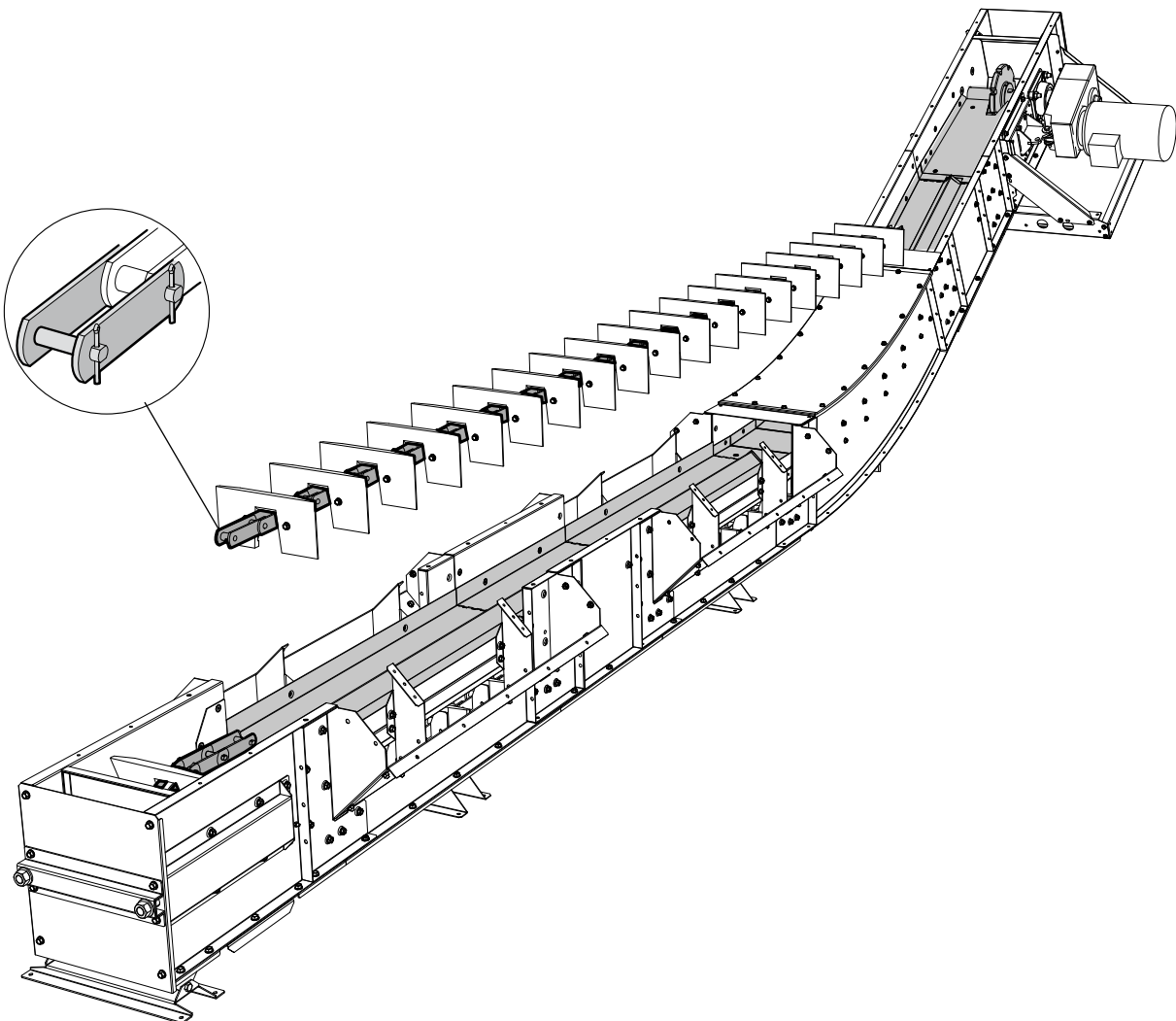
6.
Assemble the conveyor chain over the drive's chain sprocket.

7.
Slide the tail end shaft to forward position, towards the drive.

Position the conveyor chain over the tail end's chain sprocket. Shorten it if necessary to the correct length and then assemble it.

⚠ IMPORTANT!

Ensure the conveyor chain is centred, runs freely and does not foul the sides of the conveyor.



8.

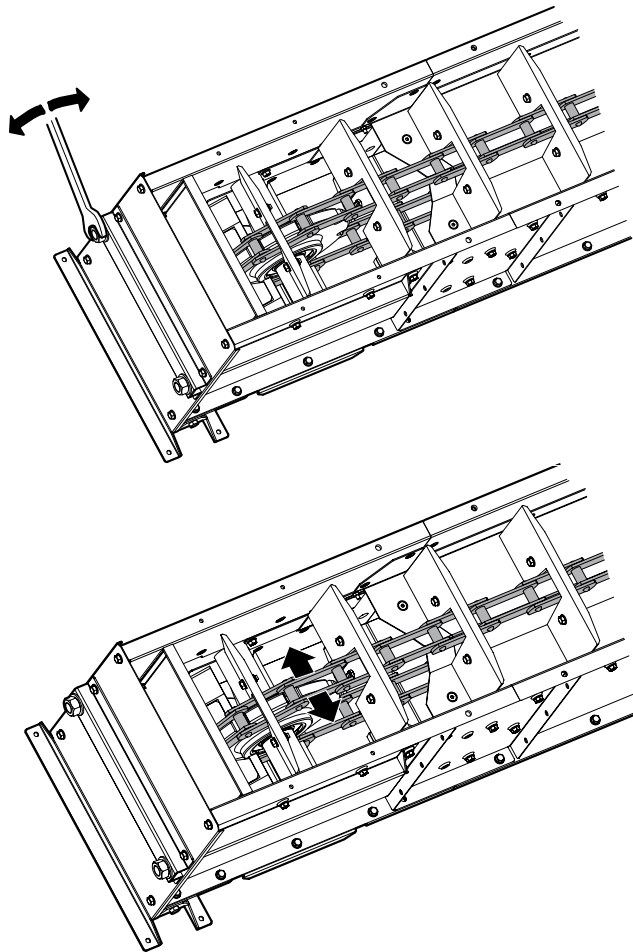
Tighten the conveyor chain with the tensioning screws in the tail end.

NB! The tensioning screws have self-locking fixed nuts inside the conveyor.

⚠ IMPORTANT!

- Ensure the tail end shaft is at right angles to the conveyor chain.
- Ensure the conveyor chain is not tensioned too much.

The conveyor chain is too taut if it cannot be pulled sideways at the tail end shaft. Release the tension until it can be pulled slightly sideways.



9.

Once assembly of the conveyor is complete, test run it for a while and then check the tension once again.

NB! If the bend lid plate gets warm after a short period of operation, it means that the conveyor chain is too tight.

A new conveyor chain must be run for a period and then readjusted.

⚠ IMPORTANT!

Check the conveyor chain after 50 operating hours. See separate maintenance instructions for information on maintenance.

10.

Mark up and cut holes for connecting to the side inlet lid plate.

 **IMPORTANT!**

Centre the connection hole on the lid plate of the side inlet if possible.

11.

Fit the connecting transition piece (A).

12.

Cut the lid plate between the side inlets to the same length as the distance between the side inlets. See pos. X in illustration.

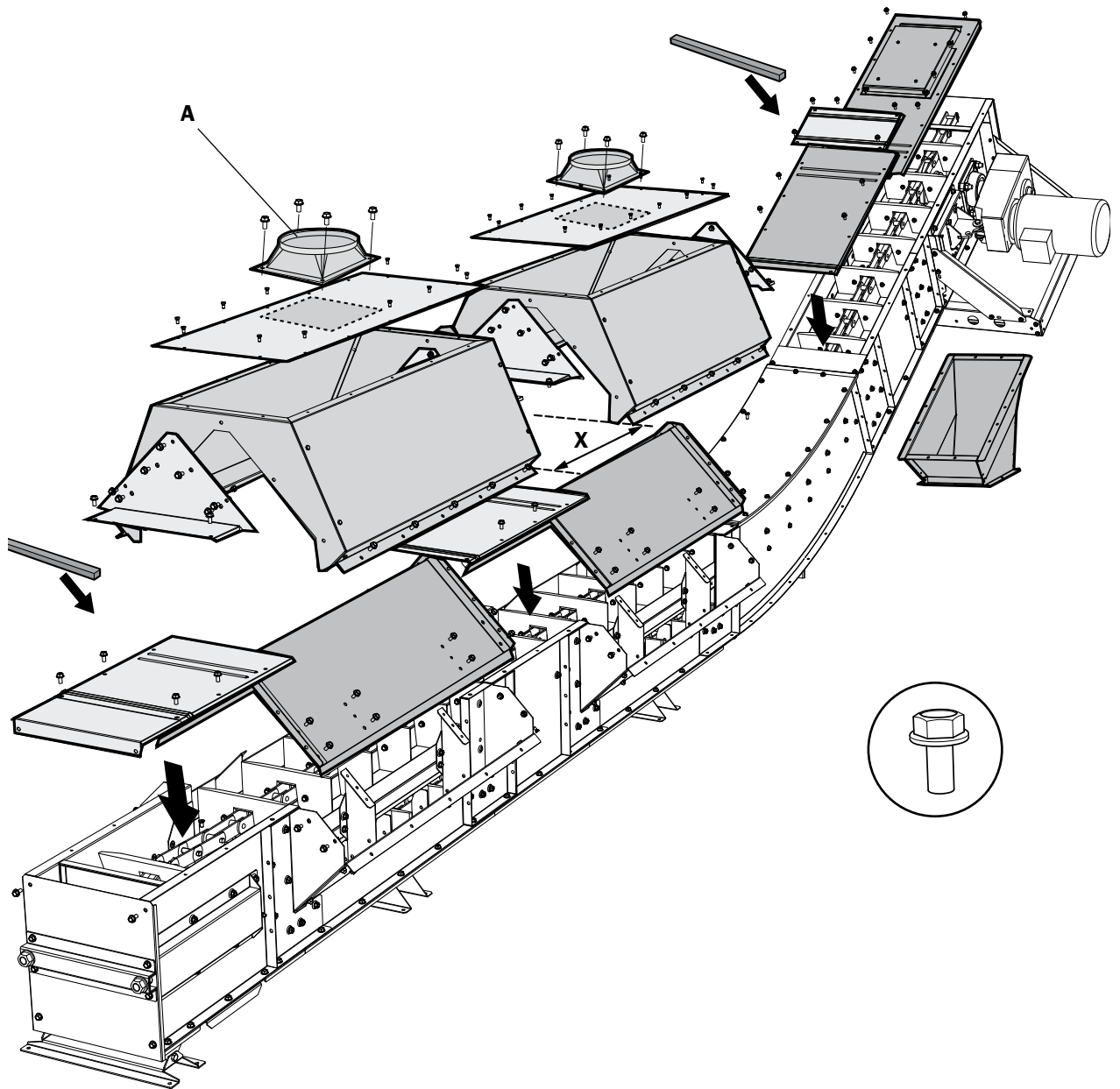
13.

Stagger the lids when fitting.

NB! Use the joining plate to cover joints in the lid that do not overlap.

 **IMPORTANT!**

- Fit rubber mouldings in the joint grooves.
- When assembling outdoors, the joints in the side plates, lid and inlet must be sealed with silicone.





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