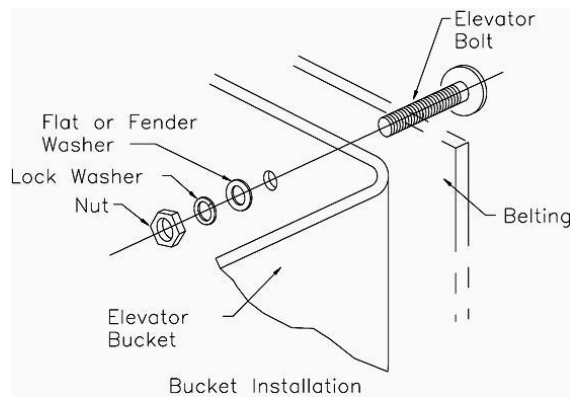


ELEVATOR BUCKET INSTALLATION INSTRUCTIONS



How to install elevator buckets on an elevator belt:

- For safety, “Lock-Out” and “Tag-Out” bucket elevator before starting installation!
- Install and tighten one elevator bolt assembly first so that the large flat head of the bolt fits flush with the belt back. If a “donut” appears around the head of the elevator bolt, assembly is too tight; adjust accordingly (a cure-all “optimum” torque setting can’t be given because all belts, even of the same lot may have different durometers resulting in the elevator bolts being too tight or too loose).
- Take the test bolts torque rating and set torque wrench. Proceed with the rest of the installation (use a torque wrench that uses a “click” when setting is met).
- Once all elevator buckets are installed on the elevator belt, proceed with running the bucket elevator *empty* for 4 hours.
- Shut bucket elevator down and double check all elevator bolts for proper torque.
- Due to elevator belts stretching over time, please schedule preventive maintenance to check elevator bolts and buckets ensuring long bucket life.

Maximum Elevator Bolt Torque Specifications:

| Bolt Diameter | Maximum Torque | |
|---------------|----------------|------------|
| | In. / Lbs. | Ft. / Lbs. |
| 1/4" | 84 | 7 |
| 5/16" | 168 | 14 |
| 3/8" | 288 | 24 |
| 1/2" | 708 | 59 |

WARNING: “Lock-Out” and “Tag-Out” bucket elevator before any maintenance begins. Failure to do so may result in death or serious injury!

TIP: When installing elevator buckets on rubber or PVC elevator belts, please use locking washers or locking nuts. This will help prevent the elevator buckets from coming loose prematurely over time.

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