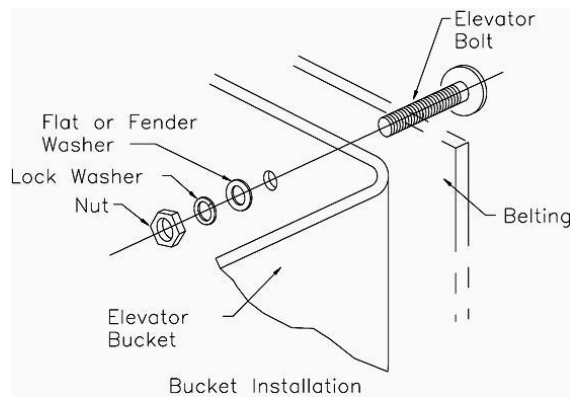


ELEVATOR BUCKET INSTALLATION INSTRUCTIONS



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.

Therm-O Plastic Suppliers, Inc.

Phone: 636-326-4700 • Toll-free: 1-877-326-4704 • Fax: 314-395-8671
website: www.topsinc.us • e-mail: tops@topsinc.us

