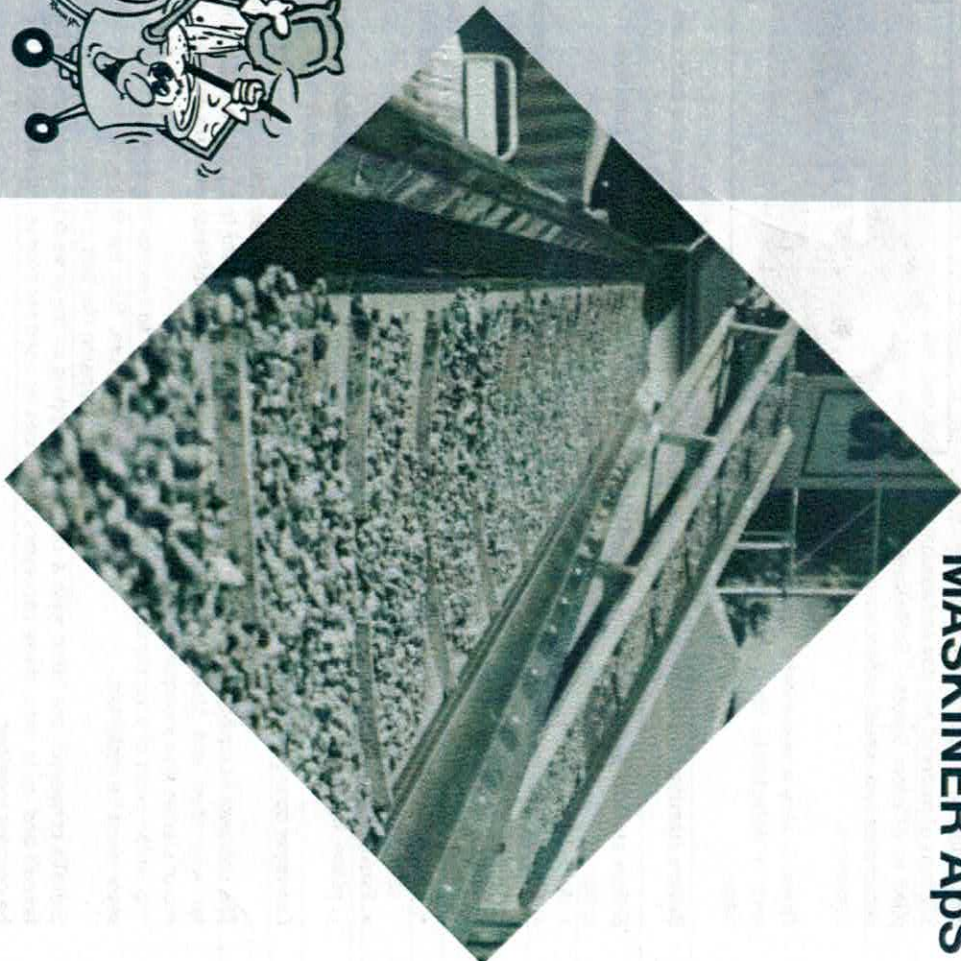


# Conveyor Manual

# SOROTO

MASKINER APS



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*ENGLISH*

**Application**

SoRoTo lightweight conveyors are ideal for transporting all materials within the building industry. They are able to convey up to 322 tons of material per day and can be supplied in different lengths. SoRoTo supply a detachable two-wheel undercarriage for the conveyors.

There is also a wet-mortar conveyor fitted with a detachable four-wheel undercarriage.

**Before starting.**

Before starting a conveyor, check the following:

- All rollers must be clean.
- Make sure there are no stones or other foreign bodies jammed in the conveyor.
- The belt must be able to run freely.
- There must be no visible belt damage.
- The PVC belt must run under the PVC side sealing strips.
- Ensure that the conveyor stands on a plane, firm surface.

**Conveyor operation.**

The conveyor is equipped with a motor starter with start and stop pushbuttons. The motor starter also incorporates a no-voltage trip. In the event of a supply failure, the conveyor must be restarted.

SoRoTo conveyors are fitted with a current takeoff and up to max. three conveyors can be coupled together.

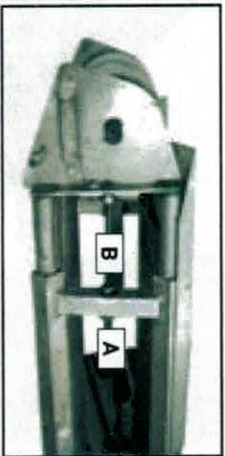
The conveyor must not be stopped before all material on the belt has been discharged.

**Warning !**

**Never place your hand or any object in the conveyor while it is connected to the electricity supply.**

**Belt replacement**

Before removing the PVC belt, remove the conductive lead from the plug.



Remove the feed box, release the belt completely by loosening locknut A. Now, with a spanner on nut B, turn the threaded rod counter-clockwise.

With a rubber hammer tap the motorised drum and bracket right back to the frame. Lift the frame onto its side with junction box upwards. On 4.5 m - 8 m models the slide must also be removed. Remove the old belt and fit a new one.

**Note!** Clean platemwork and side sealing strips before placing the new belt.

Refit the slide and lay the conveyor down again. It is important to chock up the frame so that it does not twist while on its side.

Use nut B to tension the belt at the motorised drum. Turn the threaded rod clockwise. Tension the belt sufficiently to prevent it slipping on the drive drum under load (a rule can be used for coarse adjustment).

Adjust the belt so that it tracks centrally by turning the threaded rods at the tail roller.

Fine adjustment **MUST** always be carried out at the tail roller. Remember to retighten the locknuts at both ends. Before refitting the feed box, check to make sure that the belt tracks correctly at both ends of the conveyor.

7. Start the conveyor and allow it to run for a minimum of 2 minutes without adjustment.

8. If the belt runs out of track at the normal feed box position, adjust one of the two adjustment screws. Adjust carefully - a half turn at a time can be more than enough.

Allow the conveyor to run for a minimum of 2 minutes after each adjustment. It can take a little while before the belt begins to track squarely.

9. The belt width must be at least 33 cm so that it is able to run under the side sealing strips. If the belt is narrower, replacement is recommended.

10. Side sealing strips must be at least 5 cm wide and undamaged. If this is not the case, they should be replaced.

11. Check to ensure that the emergency stop operates correctly.

12. Check all visible cables for fractures.

13. Inspect the remainder of the conveyor for defects and deficiencies.

14. Refit the feed box. The conveyor is now ready for use.

Comments in general:

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Date of service:

Performed by:



# Spare parts list For Belts Conveyor

Pos nr.	Description	Spare part no.
1.	Aluminium frame	200 001
2.	Rust free keys	200 002
3.	PVC side bolters 8mm x 55mm	200 003
4.	Aluminium side bolters	200 004
5.	Motor fittings (2 items)	200 005
6.	Front scraper	200 006
7.	Handle for motor fittings (single item)	200 007
8.	Roller fittings (2 items)	200 008
9.	Back scraper	200 009
10.	End pieces "Horn" (2 items)	200 010
11.	Threaded rod, long Ø 12	200 011
12.	Threaded rod, short Ø 12	200 012
13.	Leads protector	200 013
14.	Power box start/stop	200 014
15.	Power box P1	200 015
16.	Protective motor switch 230 V	200 016
17.	Thermal circuit breaker	200 017
18.	Self-adjusting safety relay	200 018
19.	Starting capacitor 60 µF	200 019
19 A	Operation capacitor 25 µF	200 019A
20.	Lead - 7 leads	200 020
20 A	Lead - 3 leads	200 020A
21.	EG adapter w/ plastic bolts	200 021
22.	Rubber leading in	200 022
23.	Power intake	200 023
24.	Power outlet	200 024
25.	Connector box at motor end	200 025
26.	Motor	200 026
27.	Back roller	200 027
28.	PVC ball	200 028
29.	Side plates	200 029
30.	Feeder box	200 030
31.	Handle for feeder box	200 031
32.	Complete PVC for feeder box	200 032
33.	Complete inner PVC for feeder box	130 x 220 mm
34.	Separate side PVC for feeder box	200 033
35.	Separate back PVC for feeder box	200 034
36.	Aluminium side bolters for feeder box	200 035
37.	Aluminium back bolters for feeder box	200 036
38.	Tightener	200 037
39.	Undersledge complete	4,5m = 6 items, m6, 8m = 12 items M8
40.	Separate runner for undersledge	4,5m = 1 item, 6 m = 2 items, 8m = 3 items,
41.	Underrriage	4,5m = 1 stk., 6 m = 2 stk., 8m = 3 items.
42.	Wheel Ø 300 mm	200 041
42 A	Coller keys	200 042
43.	Feeder for wheelbarrow	200 042A
	EXTRA	200 043



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AMT100100 www.gb-hemp.com

It is important to allow the conveyor to run under observation for a minimum of 30 minutes after each adjustment to the PVC belt.

Note! Small adjustments at the motor end result in major adjustments at the tail end.

### Cleaning

Dust, dirt and other foreign bodies must be removed from the motorised drum and tail roller.

It might be a good idea to remove the feed box, clean the plough and adjust the belt so that it tracks centrally.

When cleaning the conveyor with a high-pressure cleaner, the jet must not be directed at electrical parts or the control box.

Transportation (not wet-mortar conveyor)

To move the conveyor, place the undercarriage at the centre - as indicated.

## Undervogn her

The conveyor will now be in balance, and can be easily moved around.

### Servicing

A major service must be performed on the conveyor at least once every year. The service must be performed by the supplier or another authorised person.

### Safety

The emergency stop can always be activated without risk of injury or damage to personnel, machinery or product. When the emergency stop has been activated, the cause must be remedied. The conveyor can then be reset and started in the normal way.

Where conveyors are coupled together, the danger of crushing or jamming between them must be prevented.

The minimum permissible clearance between conveyors is 120 mm.

Max. conveyor incline is approx. 30°, depending on the type and quantity of material being handled.

The emergency stop is located on the operating panel and when activated stops all movement immediately. The emergency stop can always be activated without risk of injury or damage to personnel, machinery or product. When the emergency stop has been activated, the cause must be remedied. The conveyor can then be reset and started in the normal way.

### Technical information

- Height: 0.23 m
- Belt width: 0.45 m
- Length/weight: 2.0 m/30 kg
- 3.3 m/55 kg (wet-mortar conveyor)
- Motor: 230 V - 0.50 kW - 50 Hz

- 3.3 m/45 kg
- 4.5 m/65 kg
- 6.0 m/80 kg
- 8.0 m/100 kg
- Motor: 230 V - 0.55 kW - 50 Hz
- The weight is inclusive of undercarriage.
- Belt speed: 0.32 m/s
- LAeq < 75dB(A).

### Technical support :

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# Service checklist for lightweight conveyors

## Important

The following steps must be followed precisely. Clean and adjust the conveyor at regular intervals. This is important in prolonging the life of wearing parts, and to avoid expensive repair work becoming necessary.

1. Start with general cleaning of the whole conveyor, with a high-pressure cleaner if thought necessary. **IMPORTANT – Never direct the jet onto electrical parts !**
2. Take off the feed box first, check to ensure that no stones, earth, etc. are caught at the tail roller or the rear scraper. Clean these parts if necessary.
3. Inspect the PVC/rubber at the feed box for wear. Replace if necessary.
4. Inspect remainder of belt for foreign bodies and remove them. **It might be necessary to remove the PVC belt entirely to remove all earth, etc. Follow the instructions given for removing the belt.**
5. Start the conveyor to ensure that the belt does not wander. This can be checked by seeing whether the belt tracks properly in the steel trough. If it does, proceed with step 8, if not, continue to the next step.
6. If the belt runs out of line, first check the alignment of the motorised drum brackets. The distance between drum brackets and frame must be the same on both sides. ( coarse adjustment) See Fig. 1

The belt can now be fine-adjusted so that it leaves the steel trough cleanly on both sides.

	OK	Further service requirements	Comments

Fig. 1, A = distance between bracket and frame

