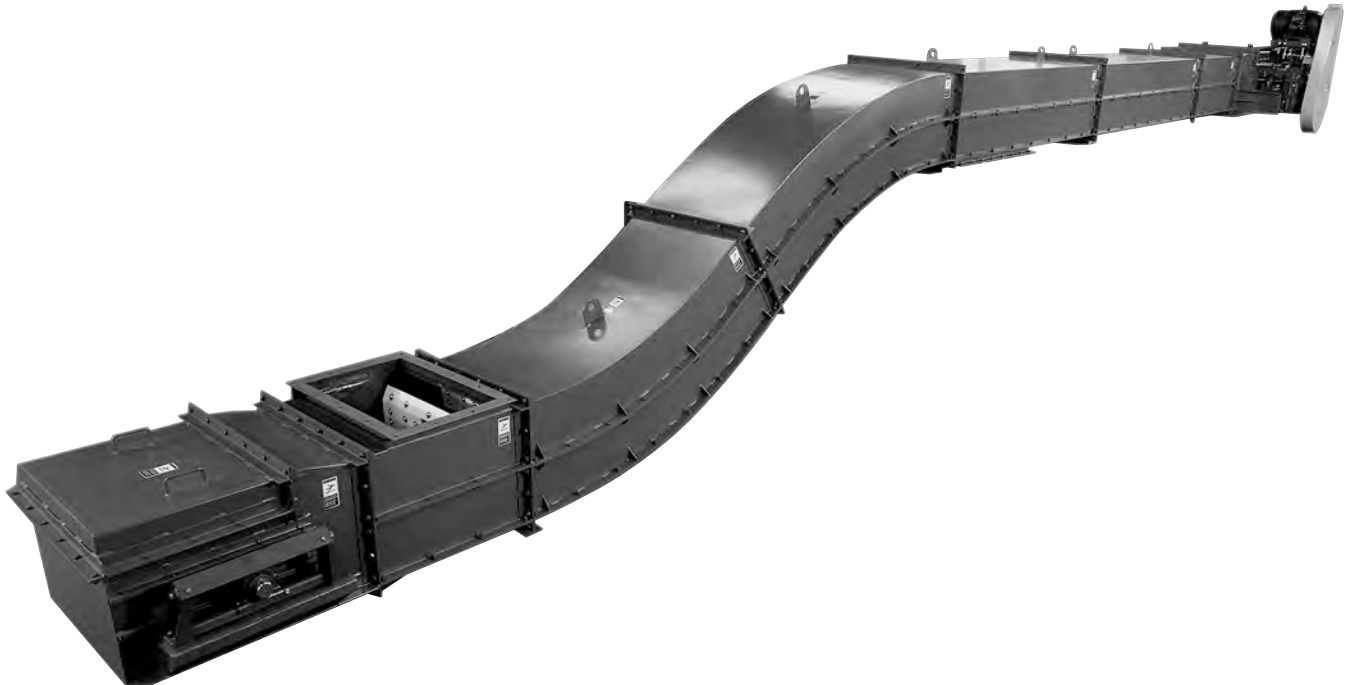




Martin Sprocket & Gear, Inc.
Conveyor Division

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DRAG CONVEYOR



SAFETY

**INSTALLATION • OPERATION • MAINTENANCE
INSTRUCTIONS**



WARNING AND SAFETY REMINDERS FOR SCREW , DRAG , AND BUCKET ELEVATOR CONVEYORS

APPROVED FOR DISTRIBUTION BY THE SCREW CONVEYOR SECTION OF THE
CONVEYOR EQUIPMENT MANUFACTURERS ASSOCIATION (CEMA)

Martin— is the responsibility of the contractor, installer, owner and user to install, maintain and operate the conveyor, components and conveyor assemblies in such a manner as to comply with the Williams-Steiger Occupational Safety and Health Act and with all state and local laws and ordinances and the American National Standard Institute (ANSI) B20.1 Safety Code.

In order to avoid an unsafe or hazardous condition, the assemblies or parts must be installed and operated in accordance with the following minimum provisions.

1. Conveyors shall not be operated unless all covers and/or guards for the conveyor and drive unit are in place. If the conveyor is to be opened for inspection cleaning, maintenance or observation, the electric power to the motor driving the conveyor must be LOCKEDOUT in such a manner that the conveyor cannot be restarted by anyone; however remote from the area, until conveyor cover or guards and drive guards have been properly replaced.
2. If the conveyor must have an open housing as a condition of its use and application, the entire conveyor is then to be guarded by a railing or fence in accordance with ANSI standard B20.1-1993, with special attention given to section 6.12.
3. Feed openings for shovel, front loaders or other manual or mechanical equipment shall be constructed in such a way that the conveyor opening is covered by a grating. If the nature of the material is such that a grating cannot be used, then the exposed section of the conveyor is to be guarded by a railing or fence and there shall be a warning sign posted.
4. Do not attempt any maintenance or repairs of the conveyor until power has been LOCKEDOUT.
5. Always operate conveyor in accordance with these instructions and those contained on the caution labels affixed to the equipment.
6. Do not place hands or feet in the conveyor.
7. Never walk on conveyor covers, grating or guards.
8. Do not use conveyor for any purpose other than that for which it was intended.
9. Do not poke or prod material into the conveyor with a bar or stick inserted through the openings.
10. Keep area around conveyor drive and control station free of debris and obstacles.
11. Always regulate the feeding of material into the unit at a uniform and continuous rate.
12. Do not attempt to clear a jammed conveyor until power has been LOCKEDOUT.
13. Do not attempt field modification of conveyor or components.
14. Screw conveyors are not normally manufactured or designed to handle materials that are hazardous to personnel. These materials which are explosive, flammable, toxic or otherwise dangerous to personnel. Conveyors may be designed to handle these materials. Conveyors are not manufactured or designed to comply with local, state or federal codes for unfired pressure vessels. If hazardous materials are to be conveyed or if the conveyor is to be subjected to internal or external pressure, manufacturer should be consulted prior to any modifications.

CEMA insists that disconnecting and locking out the power to the motor driving the unit provides the only real protection against injury. Secondary safety devices are available; however, the decision as to their need and the type required must be made by the owner-assembler as we have no information regarding plant wiring, plant environment, the interlocking of the screw conveyor with other equipment, extent of plant automation, etc. Other

devices should not be used as a substitute for locking out the power prior to removing guards or covers. We caution that use of the secondary devices may cause employees to develop a false sense of security and fail to lock out power before removing covers or guards. This could result in a serious injury should the secondary device fail or malfunction.

There are many kinds of electrical devices for interlocking of conveyors and conveyor systems such that if one conveyor in a system or process is stopped other equipment feeding it, or following it can also be automatically stopped.

Electrical controls, machinery guards, railings, walkways, arrangement of installation, training of personnel, etc., are necessary ingredients for a safe working place. It is the responsibility of the contractor, installer, owner and user to supplement the materials and services furnished with these necessary items to make the conveyor installation comply with the law and accepted standards.

Conveyor inlet and discharge openings are designed to connect to other equipment or machinery so that the flow of material into and out of the conveyor is completely enclosed.

One or more caution signs (as illustrated below) are attached to conveyor housings, conveyor covers and screw elevator housings. Please order replacement caution labels should the labels attached to this equipment become illegible.

The label shown below has been reduced in size. The actual size is printed next to the label. For more detailed instructions and information, please request a free copy of our "Screw Conveyor Safety, Installation, Operation, Maintenance Instructions."

The Conveyor Equipment Manufacturer's Association (CEMA) has produced an audio-visual presentation entitled "Safe Operation of Screw Conveyors, Drag Conveyors, and Bucket Elevators." CEMA encourages acquisition and use of this source of safety information.

CEMA Safety Labels

The CEMA safety labels shown below should be used on screw conveyors, drag conveyors, and bucket elevators. Safety labels should be placed on inlets, discharges, troughs, covers, inspection doors & drive guards. See CEMA Safety brochure for proper label placement.

⚠ WARNING



CVS930010

Exposed conveyors and moving parts can cause severe injury

LOCK OUT POWER
before removing cover or servicing

CVS930010
(3" Wide x 8" High)
Drag Conveyors

⚠ WARNING



CVS930012

Exposed buckets and moving parts can cause severe injury

LOCK OUT POWER
before removing cover or servicing

CVS930012
(3" Wide x 8" High)
Bucket Elevators

⚠ WARNING



CVS930011

Exposed screw and moving parts can cause severe injury

LOCK OUT POWER
before removing cover or servicing

CVS930011
(3" Wide x 8" High)
Screw Conveyors

⚠ WARNING



CVR930001

Exposed moving parts can cause severe injury

LOCK OUT POWER
before removing guard

CVR930001
(3" Wide x 8" High)
Drive Guards

**WARNING
AND
SAFETY
REMINDER
PROMINENTLY
DISPLAY SAFETY
LABELS IN
WORK AREAS**

Installation

RECEIVING

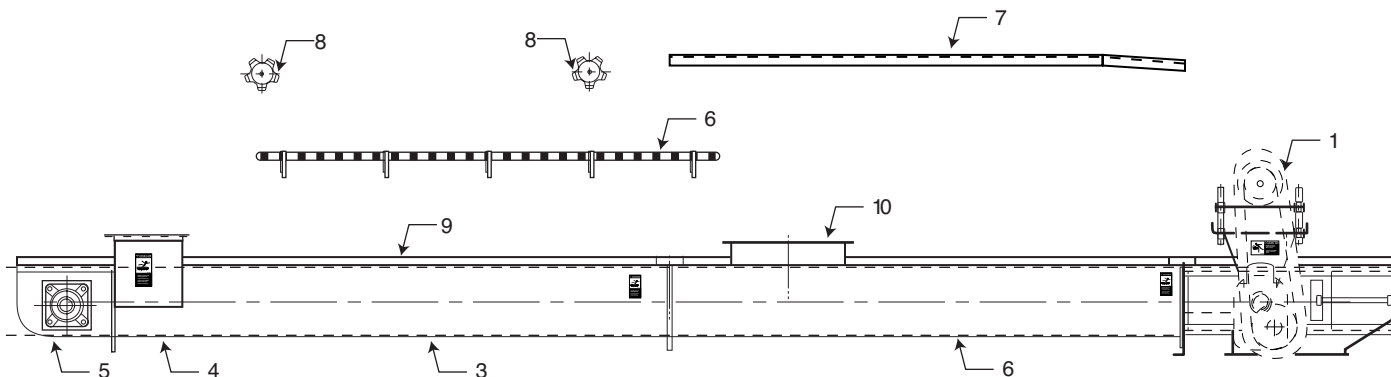
Immediately upon receipt all items in the conveyor or component shipment should be checked against shipping papers for shortages and inspected for damage. Items to be checked include bent or dented troughs, covers, flights, chain, guards, drives, etc. Note claims for damaged parts on shippers and immediately file a claim. DO NOT ATTEMPT TO INSTALL A DAMAGED ITEM OR CONVEYOR.

LIFTING AND MOVING

Extreme care must be taken to prevent damage when moving assembled conveyors or components. Spreader bars with slings are the recommended support method for lifting. The unsupported span should be no longer than 10 to 12 feet. Never lift a conveyor with only one support point. Unusually heavy items such as drives or gates shall be considered when choosing support points because of load balance and their bending effect.

ASSEMBLY

The above diagram is representative only. It is the responsibility of the purchaser to consult contract drawings for specific items on each conveyor.



- | | | | |
|---|---------------------------------|----------------|------------------------------|
| 1. Shaft Mounted Drive, Motor Mount
V-Belt Drive and Guard | 2. Head Section with Take-up | 3. Trough | 4. Trough with By-Pass Inlet |
| 5. Tail Section (self cleaning) | 6. Chain with Flight Attachment | 7. Rail Return | 8. Idler Return |
| 9. Hip Roof Cover | 10. Standard Inlet | | |

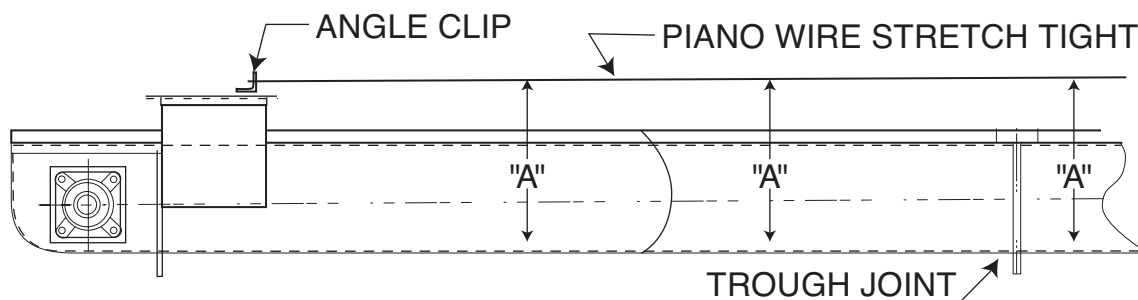
For safety and proper operation drag conveyors must be assembled and erected straight and true. It is the responsibility of the purchaser to insure all support and mounting surfaces are level and true so there is no distortion in the conveyor.

All component pieces (or conveyor sections) should be placed in proper sequence before assembly is started.

Installation

For shop assembled conveyors, units are match marked and shipped in longest sections practical for shipment. Field assembly can be accomplished by connecting marked joints and in accordance with packing list and or drawing if applicable. In field erection, the mounting surfaces for supporting the conveyor must be level and true so there is no distortion in the conveyor. Shims or Grout should be used when required. Check for straightness as assembly is made. the mounting surfaces for supporting the conveyor must be level and

For conveyor assemblies purchased as parts or merchandise, assemble as follows: Place conveyor troughs in proper sequence with tail, bypass inlet and head in proper location. Connect the trough flanges loosely. Do not tighten bolts. Align the trough bottom centerlines perfectly using piano wire (or equivalent) then tighten flange bolts. Tighten all anchor bolts.



“A” dimension should be equal for full length of trough, bottom to be smooth through joints.

Before connecting the top section of chain, loosen take-up as much as possible. Check sprocket alignment, set screws, and bearing mounting bolts for tightness.

- 1.) Connect top section of the chain (on long conveyors, a come-a-long may be necessary)
- 2.) Adjust take-up to remove excess slack from chain, being sure that adjustment screws have been tightened equally to prevent any misalignment.
- 3.) Install trough covers in proper sequence. Handle covers with reasonable care to avoid warping or bending. Covers should be securely fastened.
- 4.) Install drive at proper location and in accordance with separate instructions provided.
- 5.) Rotate conveyor by hand to insure that no binding occurs.
- 6.) Check for proper direction of chain and flight travel after electrical connections have been made, before attempting to handle material. If necessary after **LOCK OUT/TAG OUT ALL POWER** then reconnect electrical leads to reverse direction of material flow. Material should be pushed by the flight and attachment.

Operation

Lubricate all bearings and drives per service instructions. Gear reducers are normally shipped without lubricant. Refer to service instructions for lubrication.

Check conveyor to insure all tools and foreign materials have been removed.

Check conveyor to insure all covers, guards, and controls to other equipment is installed and operating properly.

In start-up of the conveyor, operate several hours empty as a break in period. Observe for bearing heat up, unusual noises or drive misalignment. Should any of these occur, check the following and take necessary corrective steps.

- 1.) When anti-friction bearings are used, check for proper lubrication. Insufficient or excess lubricant will cause high operating temperatures.
- 2.) Misalignment of troughs, loose chain and misalignment of sprockets can require excessive maintenance and cause poor life expectancy.
- 3.) Check assembly and mounting bolts; tighten if necessary.

After the conveyor has been run per the above instructions, stop the conveyor. **LOCK OUT/TAG OUT ALL POWER**, and check discharge to insure it is clear and material flow through the discharge will not be impeded in any way.

Restart the conveyor and gradually begin to feed material. The feed rate should be gradually increases until the design capacity is reached.

Do not overload conveyor. Do not exceed conveyor speed, capacity, material density, or rate of flow for which the conveyor and drive were designed.

Cut off feed and allow the conveyor to empty. **LOCK OUT/TAG OUT ALL POWER SUPPLY.**

Check all bolts and all alignments. Realign as necessary, tighten all bolts and check chain adjustment.

If the conveyor is to be inoperative for a prolonged period of time, operate conveyor until cleared of all material. This is particularly important when the material conveyed tends to harden or become more viscous, or sticky if allowed to stand for a period of time.

It may be necessary to readjust chain tension after running material in conveyor.

Check motor amperage frequently.

It is extremely important the following precautions be followed to prevent personal or property damage:

- 1.) Only persons properly trained and familiar with drag conveyors be permitted to operate or maintain the unit.
- 2.) **LOCK OUT/TAG OUT ALL POWER** prior to any inspection or maintenance, refer to ANSI Standard ANSI Z244.1.
- 3.) Periodically run the conveyor empty for a few minutes to check for excessive vibration, loose fasteners, security of covers and guards, noise, and bearing and drive temperature.
- 4.) **ALWAYS** operate the conveyor with covers, guards, safety labels in place.
- 5.) **NEVER** walk on or across conveyor covers, guards or grating.
- 6.) **DO NOT** place hands, feet or clothing in conveyor openings.
- 7.) **DO NOT** poke or prod the conveyor or material in the conveyor.

Problem Cause / Remedy Chart

PROBLEM	CAUSE	REMEDY
PREMATURE TROUGH FAILURE	A) Gauge too light B) Worn flights C) Excessive chain speed	A) Increase thickness. Consult catalog materials table / component series for recommendation. B) Replace flights C) Check speed
ACCELERATED FLIGHT WEAR	A) Excessive heat B) Speed too high	A) Change flight material. UHMW limited to 175°F B) Slow drag down. Consult catalog engineering section to determine proper speed.
CHAIN BREAKAGE	A) Worn chain B) Take-up loose	A) Change chain if worn B) Adjust take-up
DRIVE SHAFT BREAKAGE	A) Excessive torque B) Insufficient torque capacity C) Obstruction in conveyor	A) Recalculate HP requirements B) Increase torque capacity C) Check sprocket alignment
MOTOR/HEATERS OVERLOAD	A) Amp demand excessive for motor	A) 1. Recheck horsepower calculations 2. Check material characteristics 3. Check capacity. Assure regulated feed.
INLET TROUGH END BEARING FAILURE	A) Material getting into bearing B) Insufficient lubrication	A) Add or upgrade seal to keep material out of bearing. Change to outboard bearing. B) Lubricate properly
DISCHARGE TROUGH END BEARING FAILURE	A) Material getting into bearing	A) 1. Add or upgrade seal. 2. Change to outboard bearing.

Maintenance

Before any maintenance or inspection is performed, refer to ANSI Standard ANSI Z244.1 for minimum safety requirements covering **LOCK OUT/TAG OUT ALL POWER** or energy sources for personal safety.

Practice good housekeeping. Keep the area around the conveyor and drive clean and free of obstacles to provide any access and to avoid interference with the function of the conveyor and drive.

Establish routine periodic inspections of the entire conveyor to insure continuous maximum operating Performance.

To replace or shorten conveyor chain section, proceed as follows:

- 1.) Locate the cotter pin section of chain and rotate the chain until it is on the top (**LOCK OUT/TAG OUT ALL POWER**).
- 2.) Loosen take-up fully and remove cotter pin and remove desired length.
- 3.) To reassemble, follow the above steps in reverse order.

Replacement parts can be identified from a copy of the original packing list, invoice or drawing.

Periodic inspections should be made of the following:

- 1.) Trough. Check for wear and alignment. Tighten all bolts.
- 2.) Shafts. Check for wear.
- 3.) Flights. Check edges for wear or damage.
- 4.) Bolts and nuts. Check all for wear and tightness.
- 5.) Seals. Check for leakage, adjustment and wear.
- 6.) Guards. Check for oil level (if applicable). Check nuts and bolts for tightness.
- 7.) Bearings. Check for lubrication.
- 8.) Sprockets. Check for wear and alignment.
- 9.) Chain. Check for worn pins and damaged side bar.
- 10.) Take-up. If take-up fully adjusted, a link of chain will need to be removed.

Extended Shutdown / Storage

If the conveyors are to have an extended shutdown or storage (beyond one month) the following should be performed:

- 1) Insure all foreign material is removed from the conveyor and surface coatings are in good order.
- 2) All bearings and drives are lubricated and protected per manufacturer's instructions.
- 3) The conveyor is protected from weather, moisture and extreme temperatures. Do not use plastic or other coverings which promote condensation under the covering.
- 4) All exposed metal surfaces are coated with a rust preventative oil that is applied per instructions.
- 5) Prior to start-up, installation and operation instructions contained in this manual must be

Suggested Inspection Schedule

Before any maintenance or inspection is performed, refer to *Martin* Drag Conveyor Safety • Installation • Operation • Maintenance Instructions and to any pertinent ANSI standards.

Practice good housekeeping. Keep the area around the conveyor and drive clean and free of obstacles to provide easy access and to avoid interference with the function of the conveyor and drive.

Periodic inspections should be made of the following:

- 1) Trough Check for wear and alignment. Tighten all bolts. MONTHLY
- 2) Shafts Check for wear and misalignment. MONTHLY
- 3) Flights Check edges for wear or damage and tightness of bolts & nuts. MONTHLY
- 4) Bolts and Nuts Check all for wear and tightness. MONTHLY
- 5) Seals. Check for leakage, adjustment, and wear. MONTHLY
- 6) Guards Check for oil level (if applicable). Check nuts and bolts for tightness.
MONTHLY
Check that all guards are securely fastened. WHENEVER OPERATING !!!
- 7) Bearings Check for lubrication. Refer to specific instructions as various types of bearings require varying frequency of lubrication and varying types of lubrication. All bearings should be checked for wear MONTHLY.
- 8) Chain Check for for wear and alignment. MONTHLY
- 9) Covers Check that all covers are securely fastened or the conveyor is guarded.
WHENEVER OPERATING !!!
- 10) Safety Labels. Check that all labels are properly installed and clearly visible.
MONTHLY
- 11) Drives. All drives to be checked and maintained per manufacturers recommendation

The above recommended inspection schedule is only advisory and your inspection schedule may need to be adjusted to meet actual operating conditions.

Vendor Contact

Please use the following list of contacts concerning maintenance or troubleshooting questions associated with components not manufactured by *Martin*, but supplied on your conveyor equipment.

GEAR REDUCERS			
SUPPLIER		PHONE NUMBER	ALTERNATE CONTACT
DODGE		803-297-4800	Fax: 864-281-2381
FALK		414-342-3131	Fax:414-937-4359
NORD		608-849-7300	www.nord.com
SUMITOMO		757-485-3355	Fax: 757-485-3075
DORRIS		800-325-2520	Intbtedorrisco.com
EURO-DRIVE		905-639-7873	Fax: 905-639-4895
MOTORS			
SUPPLIER		PHONE NUMBER	ALTERNATE COMNTACT
RELIANCE		803-297-4800	Fax:864-281-2381
BALDOR		501-646-4711	www.baldor.com
SIEMANS		800-964-4114	www.sea.siemens.thomasrcgistr.com
U.S.		414-251-7724	Fax:414-251-2748
TOSHIBA		800-663-3117	Fax: 847-593-1616
BEARINGS			
SUPPLIER		PHONE NUMBER	ALTERNATE CONTACT
DODGE		803-297-4800	Fax: 864-281-2381
SKF		800-275-5416	Fax:219-546-0448
COOPER		757-460-0925	Fax: 757-464-3067
MISCELLANEOUS			
SUPPLIER	EQUIPMENT	PHONE NUMBER	ALT. CONTACT
MILTRONICS	MOTION SENSOR	817-277-3543	www.milltronics.com
ALAN BRADLEY	MOTION SENSOR	414-382-2000	Fax: 414-382-4444
CONTROL CONCEPTS	MOTION SENSOR	800-745-6551	Fax: 860-928-9450
ELECTRO-SENSORS	MOTION SENSOR	800-328-6170	www.electrosensors.com
ALLEN AIR	AIR CYLINDERS	516-747-5450	Fax:516-747-5481

If you cannot find the information required with the above listing of contacts, please contact your local *Martin* service center.

Recommended Spares

The list of components provided below is our recommendation for spares required for general maintenance. Please use the enclosed bill of materials from the drawings or planning sheets to identify components specific to your equipment. Quantities should be equal to the previous amount given unless specified otherwise.

DRAG CONVEYOR

Bearings

V-belts

Flights (qty for 1 section of chain)

Chain (1 section)

Cover Clamps (spring, screw, toggle)

Please call *Martin* if you need additional information or help in determining your required spares.

Bolt Torque

General Bolt Tightening Torque

Thread	Tensile Stress Area	SAE Grade 2		SAE Grade 5		SAE Grade 8	
Size	Tsa	75% Yield Strength (PSI) - 43000		75% Yield Strength (PSI) - 69000		75% Yield Strength (PSI) = 98000	
		Plain	Zinc Plated	Plain	Zinc Plated	Plain	Zinc Plated
	Square Inches	Ft.Lb.	Ft.Lb.	Ft.Lb.	Ft.Lb.	Ft.Lb.	Ft.Lb.
1/4-20.	0.0318	6	6	9	10	13	14
1/4-28.	0.0364	7	7	10	12	15	16
5/16-18.	0.0524	12	13	19	21	27	29
5/16-24.	0.0580	13	14	21	23	30	33
3/8-16.	0.0775	21	23	33	37	47	52
3/8-24.	0.0878	24	26	38	42	54	59
7/16-14.	0.1063	33	37	53	59	76	83
7/16-24.	0.1187	37	41	60	66	85	93
1/2-13.	0.1419	51	56	82	90	116	127
1/2-20.	0.1599	57	63	92	101	131	144
9/16-12.	0.1820	73	81	118	129	167	184
9/16-18.	0.2030	82	90	131	144	186	205
5/8-11.	0.2260	101	111	162	179	231	254
5/8-14.	0.2560	115	126	184	202	261	287
3/4-10.	0.3340	180	197	288	317	409	450
3/4-16.	0.3730	200	221	322	354	457	503

The reason all applications should be evaluated to determine the optimum tightening torque is that the K factor in this formula is always an estimate.

The most commonly used bolting K factors are 0.20 for plain finished bolts, 0.22 for zinc plated bolts, and 0.10 for waxed or highly lubricated bolts

Formula: $T = K \times D \times P$

- T Target tighten torque (the result of this formula is in inch pounds, dividing by 12 yields foot pounds)
- K Coefficient of friction (nut factor), always an estimation in this formula
- D Bolts nominal diameter in inches
- P Bolt's desired tensile load in pounds (generally 75% of yield strength) - [P(lbs) = (75%) Yield Strength * Tensile Stress Area]



Our Headquarters operation in Arlington, Texas serves as backup inventory for our Service Centers throughout North America.



Product availability rests on keeping finished inventory ready for quick delivery anywhere in the nation.



Screw conveyor inventories support the local distributors.

USA

General Offices Sales and Manufacturing

Arlington, TX

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P.O. Box 91588
Arlington, Texas 76015-0088
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3376 Delps Road 18038
P.O. Box 267 • Danielsville, PA 18038-0267
610-837-1841 (FAX 610-837-7337)

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Ft. Worth, TX 76110-4692
817-258-3000 (FAX 817-258-3173)

Montpelier, OH

350 S. Airport Road
Montpelier, OH 43543-9329
419-485-5515 (FAX 419-485-3565)

Sacramento, CA

1199 Vine Street
Sacramento, CA 95814-0426
916-441-7172 (FAX 916-441-4600)

Scottsdale, GA

3303 Church Street 30079-1395
P.O. Box 886 • Scottsdale, GA 30079-0886
404-292-8744 (FAX 404-292-7771)

Mini Manufacturing Centers

Boston, MA

357 Fortune Boulevard
Milford, MA 01757
508-634-3990 (FAX 508-634-3998)

Charlotte, NC

3901 Scott Futrell Drive

Charlotte, NC 28208-3539
704-394-9111 (FAX 704-394-9122)

Chicago, IL

1505 Birchwood Avenue
Des Plaines, IL 60018-3001
847-298-8844 (FAX 847-298-2967)

Denver, CO

10800 East 54th Avenue
Denver CO 80239
303-371-8466 (FAX 303-371-7116)

Detroit, MI

12555 Belden Ct.
Livonia, MI 48150
734-367-0238 (FAX 734-367-0547)

Houston, TX

9910 Bent Oak Drive
Houston, TX 77040
713-849-4330 (FAX 713-849-4807)

Kansas City, MO

1520 N. Commerce Avenue
Kansas City, MO 64120-4961
816-231-5575 (FAX 816-231-1959)

Los Angeles, CA

5920 S. Triangle Drive
Commerce, CA 90040-3639
323-728-8117 (FAX 323-722-7526)

Minneapolis, MN

10601 Hampshire Avenue South
Bloomington, MN 55438-2395
952-829-0623 (FAX 952-944-9385)

Portland, OR

3030 N.W. Industrial
Portland, OR 97210-1734
503-223-7261 (FAX 503-221-0203)

Tampa, FL

3201 Queen Palm Drive
Tampa FL 33619
813-623-1705 (FAX 813-626-8953)

Wayne, NJ

7 High Point Drive
Wayne, NJ 07470-7432
973-633-5700 (FAX 973-633-7196)

Manufacturing Only

Abilene, TX

Clarksville, TX

Dallas, TX

Mansfield, TX

Paragould, AR (Includes the Plastics Div.)

CANADA

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Martin Sprocket & Gear Canada Inc.

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For more information, contact your nearest *Martin* Distributor or Service Center.