

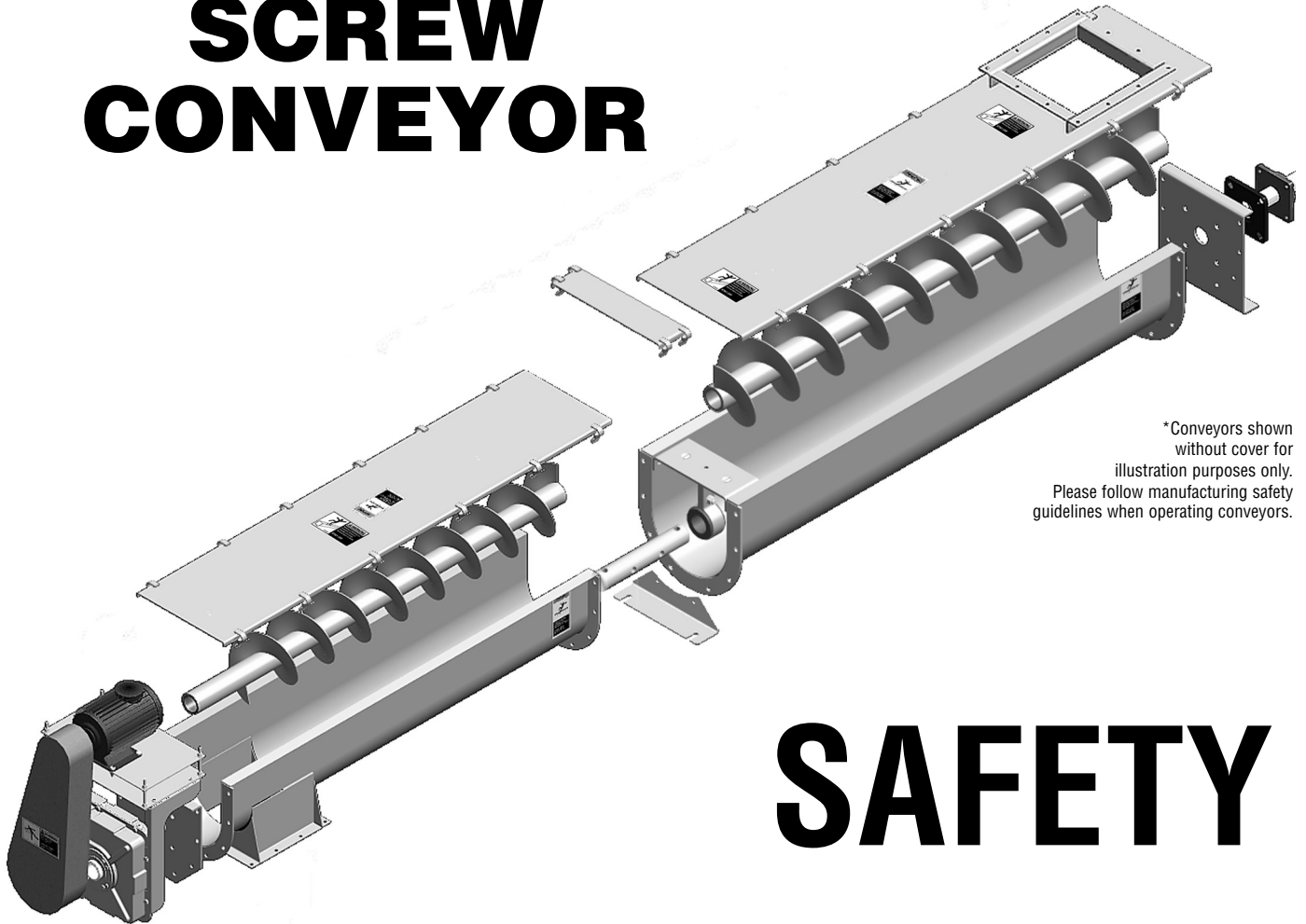


Martin

Sprocket & Gear, Inc.
Conveyor Division

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www.martinsprocket.com

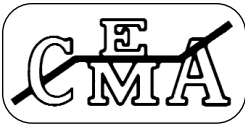
SCREW CONVEYOR



*Conveyors shown
without cover for
illustration purposes only.
Please follow manufacturing safety
guidelines when operating conveyors.

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



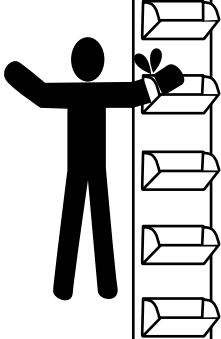
CVS930010

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

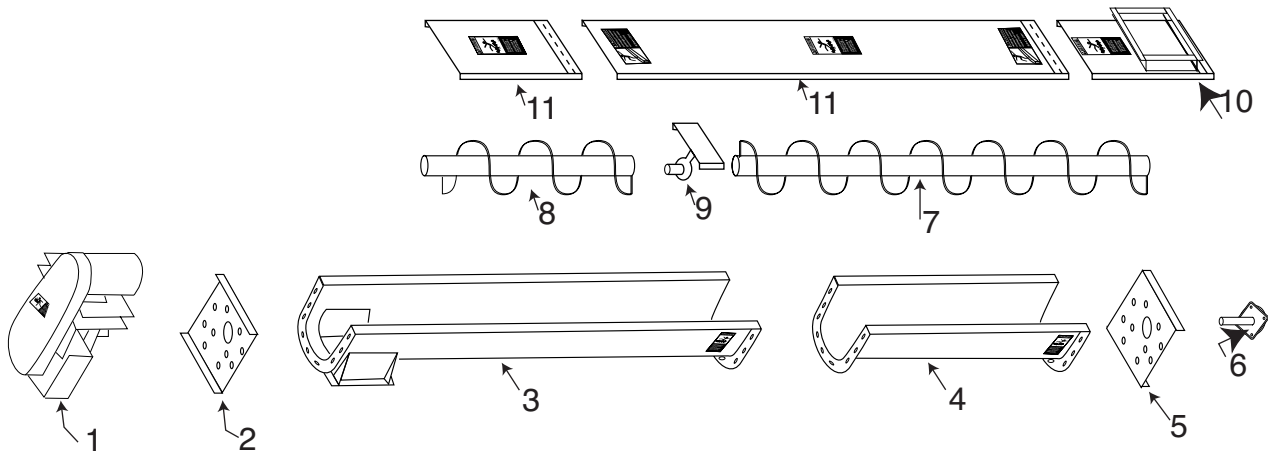
RECEIVING

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, pipes, hangers, guards, drives, etc. Note claims for damaged parts on shippers papers 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



- | | | |
|--|--|---|
| 1. Screw Conveyor Drive, Motor Mount, V-Belt Drive and Guard | 2. End Plate for Screw Conveyor Drive | 3. Trough with Fitted Discharge Spout |
| 4. Trough | 5. End Plate for Ball Bearing | 6. Seal Plate, Flanged Ball Bearing Unit and Tail Shaft |
| 7. Screw | 8. Screw with Bare Pipe at Discharge End | 9. Hanger with Bearing and Coupling Shaft |
| 10. Flanged Cover with Inlet | 11. Flanged Covers with Buttstrap | |

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

For safety and proper operation screw 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.

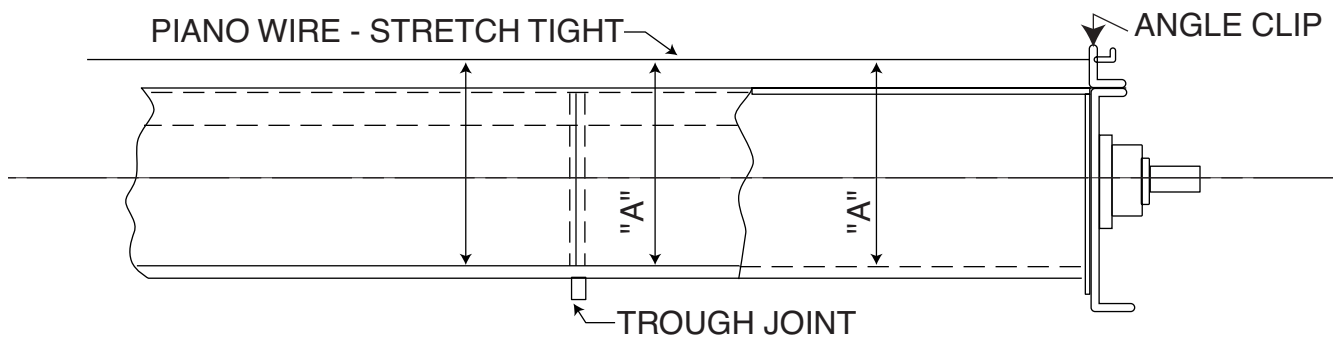
All component pieces (or conveyor sections) should be placed in proper sequence before assembly is started.

Sub-assemblies such as trough end and seal/bearings should be assembled (if not shipped preassembled) and alignment of seals and bearings and seal direction should be checked.

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.

For Conveyor assemblies purchased as parts or merchandise, assemble as follows: Place conveyor troughs in proper sequence with inlet and discharge spout properly located. Connect the trough flanges loosely. Do not tighten bolts. Align the trough bottom center-lines perfectly using piano wire (or equivalent) then tighten flange bolts. Tighten all anchor bolts.



Assembly of conveyor screws should always begin at the thrust end. If the thrust end is not designated, assembly should begin at the drive end. If a thrust end is designated, assemble trough end and thrust bearing. Insert the end, or drive shaft, in the end bearing. Do not tighten set screws until conveyor assembly is completed.

1. Place the first screw section in the trough, slipping the end or drive shaft into the pipe end. Secure tightly with coupling bolts. Install so that conveyor end lugs are opposite the carrying side of the flight.
2. Place a coupling shaft into the opposite end of conveyor pipe. Tighten coupling bolts.
3. Slide hanger with bearing over coupling shaft and clamp hanger to trough.
4. Assemble alternately, conveyor screws, couplings and hangers until all screws are installed repeating steps 1, 2, and 3.
 - a) With Hangers: Assemble screw section so that flighting at each end is approximately 180° from ends of flighting of adjacent sections. Also, adjust conveyor screw and thrust unit so that hangers are equally spaced between adjacent screws. After each hanger is installed, rotate the conveyor by hand to insure that no binding occurs. Remove hanger clamps and bolt hanger to trough with the bearing centered between conveyor screws.
 - b) Without Hangers: (close coupled) Assemble screws so that flighting at adjoining ends of screw sections align to produce a continuous helix surface. (Note coupling holes have been drilled in assembly to allow for flight alignment.)
5. The end shaft should be inserted through the trough end bearing/seal into the terminal screw section. Install and tighten coupling bolts. The bearing and seal should be adjusted to be true and concentric on the shaft and bolts tightened. If packing gland type seals are used, they should be tightened only enough to prevent leakage. Check waste pack type seals to insure packing is loose but sufficiently tight to prevent leakage.

Installation

6. Install trough covers in proper sequence. Properly locate inlet openings. Handle covers with reasonable care to avoid warping or bending. Attach covers securely to trough. Do not overtighten as cover damage may result.
7. Rotate conveyor by hand to insure no binding occurs.
8. Install drive at proper location and in accordance with separate instructions or drawing provided. Install all guards.
9. Check screw rotation for proper direction of material travel after electrical connections have been made, but before attempting to handle material. Incorrect screw rotation can result in serious damage to the conveyor and to related conveying and drive equipment.
If necessary, reconnect electrical leads to reverse rotation of conveyor and direction of material flow.
10. Attach all gates, feed chute, discharge chute, etc. and connect all safety devices and controls. CAREFULLY TEST TO INSURE PROPER OPERATION.
11. Support the conveyor at 10 to 12 foot intervals and at each end. Heavy or long drives may require additional support.

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, safety devices and controls are installed and operating correctly.

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. (non-lubricated hanger bearings may cause some noise)

- 1) When anti-friction bearings are used, check for proper lubrication. Insufficient or excess lubricant will cause high operating temperatures.
- 2) Misalignment of trough ends, screws, hangers and trough end 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 increased 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 and tighten all bolts.

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 re-center hanger bearings 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 screw 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 Z244.1.244.I.
 - 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 cross 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.
- B) Always practice good housekeeping and keep a clear view of the conveyor loading and discharges.

Problem Cause/Remedy Chart

PROBLEM	CAUSE	REMEDY
PREMATURE TROUGH FAILURE	A) Gauge too light	A) Increase thickness. Consult catalog materials table / component series for recommendation.
	B) Screw deflection	B) Eliminate excessive deflection. Consult catalog for calculation procedure to determine proper pipe size and screw length.
	C) Bent screw	C) Straighten or replace. Check before operation.
ACCELERATED FLIGHT TIP WEAR	A) Gauge too light	A) Increase thickness. Consider hardfacing.
	B) RPM's too high	B) Slow conveyor down. Consult catalog engineering section to determine proper trough loading.
COUPLING SHAFT BREAKAGE	Torque capacity insufficient	Increase torque capacity or use larger shaft. Check motor amp demand for torque requirements.
SHAFT HOLE ELONGATION	A) Insufficient number of bolts	A) Increase number of bolts.
	B) Conveyor subject to "jogging" or too frequent stop/start, or frequent overloads	B) Cease jogging or frequent stop/start or overload. If this is not possible increase bearing capacity of shaft and/or increase number of bolts.
DRIVE SHAFT BREAKAGE	Excessive torque insufficient torque capacity. Obstruction in conveyor	Recalculate HP requirements. Increase torque capacity. Check screw alignment.

Problem Cause/Remedy Chart

PROBLEM	CAUSE	REMEDY
MOTOR/HEATERS OVERLOAD	Amp demand excessive for motor	Recheck horsepower calculations. Check material characteristics. Check capacity. Regulate feed.
INLET TROUGH END BEARING FAILURE	A) Material getting into bearing B) Insufficient lubrication C) Shaft slope	B) Lubricate properly C) Align screw. Check for excessive screw deflection and for bent screw.
DISCHARGE TROUGH END BEARING FAILURE	A) Material getting into bearing	A) 1. Add or upgrade seal. 2. Change to outboard bearing. 3. Cut off flight at center of discharge.
HANGER BEARING FAILURE	A) Incorrect alignment B) Heat due to hot material being conveyed C) Heat due to insufficient lubrication D) Thrust due to pipe pressing on bearing insert E) Improper material causing premature wear	A) Align hanger. B) Use appropriate bearing material. C) Properly lubricate D) Check coupling bolts and holes for elongation and wear. Replace as necessary. Readjust screw/ hanger assembly to get proper clearances. E) Consult catalog for proper material due to temperature, trough loading, and speed. Check to insure coupling shaft material and bearing material are compatible.

Maintenance

Before any maintenance or inspection is performed, refer to ANSI Standard ANSI Z 244A.4. 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 easy 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 conveyor screw section, proceed as follows:

- 1) Removal of a section, or sections, usually must proceed from the end opposite the drive. Make sure drive and electrical power are disconnected before starting to disassemble.
- 2) Remove the trough end, sections of screws, coupling shafts, and hangers until all sections have been removed, or until the damaged or worn sections is reached and removed.
- 3) To reassemble follow the above steps in reverse order.
- 4) Quick Detachable conveyor screws can be removed at intermediate locations without first removing adjacent sections.

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

The coupling bolt lock nut may become damaged when removed. It is recommended practice to replace them rather than re-use them when changing conveyor screw sections.

Periodic inspections should be made of the following:

- 1) Trough. Check for wear and alignment. Tighten all bolts.
- 2) Shafts. Check for wear. Check for bolt hole elongation and 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. Refer to specific instructions as various types of bearings require varying frequency of lubrication and varying types of lubrication. The following types of bearing materials may or may not require lubrication.

- Bronze
- Hard iron
- Oil impregnated wood
- Nylon
- Hard surfaced bearings
- Teflon

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) Screws are rotated every two weeks.
- 4) The conveyor is protected from weather, moisture, and extreme temperatures. Do not use plastic or other coverings which promote condensation under the covering.
- 5) All exposed metal surfaces are coated with a rust preventative oil that is applied per instructions.
- 6) Prior to start-up, inspection and service instructions contained in this manual must be performed.

Suggested Inspection Schedule

Before any maintenance or inspection is performed, refer to *Martin* Screw 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. Check for bolt hole elongation and wear. MONTHLY
- 3) Flights Check edges for wear or damage. 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

- 7) Bearings Check for lubrication. Refer to specific instructions as various types of bearings require varying frequency of lubrication and varying types of lubrication. The following types of bearing materials may or may not require lubrication. Bronze, Hard Iron, Nylon, Teflon, Oil impregnated wood and Hard Surface bearings. All bearings should be checked for wear MONTHLY.
- 8) Hangers Check for proper alignment and tightness of bolts & nuts. MONTHLY
- 9) Covers Check that all covers are securely fastened or the conveyor is guarded.

WHENEVER OPERATING !!!

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
SIEMENS		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.

SCREW CONVEYOR

Bearings (End Bearings, Type "E" Bearings, Pillow Block Bearings)

Hanger Bearings

Coupling Bolts

Shafts (Coupling, Drive, Tail)

V-Belts

Seals

Waste Packing

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 Size	Tensile Stress Area Tsa Square Inches	SAE Grade 2		SAE Grade 5		SAE Grade 8	
		75% Yield Strength (PSI) - 43000		75% Yield Strength (PSI) - 69000		75% Yield Strength (PSI) = 98000	
		Plain	Zinc Plated	Plain	Zinc Plated	Plain	Zinc Plated
		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: $T = K \times D \times P$

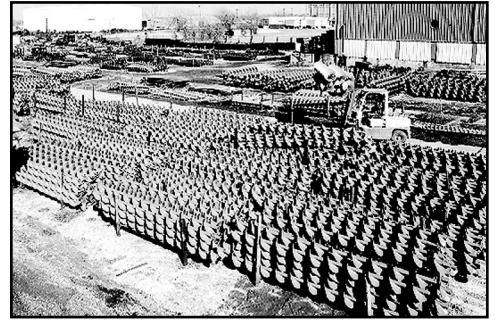
- T Target tighten torque (the result of this formula is in inch pounds, dividing by 12 yields foot pounds)
- K Coefficient of friction (nut factor), always an estimation in this formula
- D Bolts nominal diameter in inches
- P Bolt's desired tensile load in pounds (generally 75% of yield strength) -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

3100 Sprocket Drive 76015-2898
P.O. Box 91588
Arlington, Texas 76015-0088
817-258-3000 (FAX 817-258-3333)

Sales and Manufacturing

Danielsville, PA

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

Ft. Worth, TX

(Conveyor & Tool Divisions)

3600 McCart Ave.
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
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