INSTALLERS, SERVICE & LINE MECHANICS: PLEASE READ THIS MANUAL AND FAMILIARIZE YOURSELF THOROUGHLY BEFORE ATTEMPTING TO INSTALL OR SERVICE THE DALEMARK EQUIPMENT DESCRIBED HEREIN. FOR FURTHER ASSISTANCE, CONSULT OUR FACTORY STAFF.

INSTRUCTION AND PARTS MANUAL

SERIES 825-TA
CONTAINER TRANSPORT SYSTEM
MODEL 825-TA MINI

SERIAL NO. 825-_____

When ordering, always provide the following information:

- MODEL NUMBER
- SERIAL NUMBER
- PART DESCRIPTION & PART NUMBER
  AS SHOWN IN PARTS LIST

DALEMARK INDUSTRIES, INC.
EXCEL PARK 2
575 PROSPECT ST., SUITE 211-212
LAKEWOOD, NEW JERSEY 08701
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Website: www.dalemark.com

Table of Contents

This Manual is designed to assist in making the installation, setup, operation and troubleshooting of your equipment as easy and informative as possible. We ask that you carefully review the procedures covered in this manual prior to contacting the technical staff here at Dalemark. We are here to assist you in resolving any issues you may have. Do not hesitate to contact us. We can be reached Mon. – Fri., 9:00 AM – 5:00 PM. Telephone: (732) 367-3100 x 105; Fax: (732) 367-7031; Email: sales@dalemark.com or tbecker@dalemark.com. We appreciate your business and we are pleased that you have chosen Dalemark for your packaging machinery needs.

I. SAFETY

To ensure the safety of qualified personnel it is imperative that they understand the dangers, warnings and caution notices. Therefore, it is important to understand the ***signal words,*** which will be seen throughout this Manual. The safety of equipment and plant facilities should be considered during equipment operation, change of product, and any approved equipment modification.
Before attempting to perform any operation, maintenance or inspection of this equipment, it is imperative that all safety precautions and warnings herein be adhered to. If you have any questions or concerns regarding the information in this Manual, do not hesitate to contact us.

Signal words and symbols that you should become familiar with before continuing:

Restricted use to Authorized Personnel Only. Use by any other person not qualified or trained in operations or procedures with a piece of equipment could result in serious personal injury or possibly death.

Alerts to a possible hazard, which could result in serious personal injury or death, if not avoided.

Alerts to an immediate possible hazard, which could result in serious personal injury or death, if not avoided.

Alerts to a potential hazard, which could result in a serious personal injury or death if not avoided. It also alerts against unsafe practices that could permanently damage equipment or property.

Points out proper procedures and operations that could avoid damage to the equipment, and could possibly extend the life of the equipment.

NOTE Important information included for correct operation, adjustments and procedures to be performed on the equipment during set up, operation, repair and maintenance.

Lock Out – Tag Out Standard Procedures

It is standard procedure that any individual engaging in the maintenance, repair, cleaning, servicing, or adjusting of machinery or equipment, will follow the procedures outlined in this document. These procedures are designed to meet or exceed applicable OSHA standards and SORM guidelines for safe work practices. The primary purpose is to help ensure that all individuals within the facility are protected from injury or death resulting from the accidental or unexpected activation of equipment during maintenance, repairing, cleaning, servicing, or adjustments.

Definitions:

Lock out - The practice of using keyed or combination security devices ("locks") to prevent the unwanted activation of mechanical or electrical equipment.

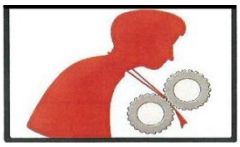
Tag out - The practice of using tags in conjunction with locks to increase the visibility and awareness that equipment is not to be energized or activated until such devices are removed. Tags will be non-reusable, attachable by hand, self-locking and not easily removed.

The Safety of personnel, equipment, and plant facilities should be considered with each change of product, and any approved machinery modifications.

The Safety of personnel, equipment, and plant facilities should be considered with each change of product, and any approved machinery modifications. Toxic, corrosive, and flammable materials could be processed through this machine, but only after you contacted your Dalemark Representative, and proper design considerations and modifications have been made. It is critical that these configurations meet all local, state, and federal codes and regulations.

Electricity always poses a danger to personnel working on machinery. For the sake of safety, ensure that the electrical source provides a properly grounded electrical source. When shielding is removed, and maintenance or repair is being performed, isolate the machine from the power source using your company's lock out / tag out procedures. Opening the Control Box does not disconnect the electrical power source. The electrical connections inside the Control Box are hot and are prone to cause possible DANGER FROM ELECTRICAL SHOCK. All measurements, adjustments, maintenance and inspections work must be performed by trained qualified personnel. It is critical that only trained qualified personnel

perform these tasks. Do not perform any type of electrical service to the equipment if it is in standing water, as this also could cause serious personal injury or death.

	Air pressure, necessary to operate your equipment, should also be disconnected when performing service to the equipment and isolated using your company's lock out / tag out procedures. In many situations, the pressure in the line could be very high and could pose the potential for serious personal injury or death.
	Keep any loose garments, clothing, hair or appendages away from moving or rotating parts while operating, performing, maintenance, adjustments or servicing your equipment. It is also highly recommended that all jewelry be removed when performing these tasks.

Alert you to the possibility of moving or rotating parts that could cause severe harm to appendages if caution is not used when operating the machinery. Keep hands clear when machine is running.

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II. SPECIFICATIONS

The Dalemark 825-TA Mini Transport Conveyor allows the user to mount their Ink Jet for bottom, top or side product coding during one operation with various Optional Standard or Custom Mounting Brackets. The conveyor has variable speeds that will capture a container from one conveyor and transport it to another conveyor using matched frequency Gripper Belts. The 36" long Gripper Belts allow access to the bottom of the container for ink jet or laser coding. The Transport uses direct drive motors. No transmissions, gears, or pulleys for the drive train are used, almost eliminating any maintenance. The AC Motors used are frequency controlled, so belt speeds are matched, further reducing any maintenance issues and ensuring that all codes are straight and legible. The Gripper Belts are independently adjustable and can accommodate containers from 1mm to over 8"in diameter.

Key Features:

- Variable Speed
- 1/6 HP Drive Motor
- Stainless Steel Construction
- Available in 110v or 220v Power
- Easily Adjustable Height
- User Friendly Control Box
- Thick and forgiving long life gripping belts
- Easy bottle size adjustment with hand wheel
- Height adjustable

Specifications:

Dimensions:
Height: 34-40"
Length: 37"
Depth: 20"
Weight: Approx 165 lbs
Speed: From 0-200 Liner FPM
Electrical: 110 VAC - 5 AMP (220 VAC optional)

Optional Features

- Extended Length Models
- Double Wide Gripper Belts
- Print head Mounting Bracket

III. SETUP

1. Position your Transport Conveyor where it is needed, typically at the end of another conveyor. 11OVAC electricity will be required near the electrical box.
2. Level the machine, making sure that all four feet are firmly on the floor to assure that the machine cannot teeter or rock.
3. Adjust the height of the Floor Rails of the Transport Conveyor to match the floor height of the conveyor upstream of it, and level the Floor Rail(s). Be careful not to create a bump where containers transfer from one conveyor to the next - the smoother the transition, the fewer problems downstream.
4. Adjust the gap between the conveyance belts a little wider than your container. Use a container to check that the transition between conveyors is as smooth as you can get it, and then tighten the floor rails down.
5. Adjust the height of the belts - they should engage the containers just above the center of their height, but the geometry of your containers may dictate where the belts engage the containers. You want the belts to be near the center of the containers. Take care to set an equal distance from the frame members to the bottom of the conveyor plates, so the belts remain level and parallel to the machine frame.
6. Now let's adjust the two belts perfectly parallel. To do so, use a straight edge or level between the two belts.
7. Use your straight-edge to check that the top surfaces of the two belt covers are precisely aligned with each other. This is important to belt life and to consistent operation. Adjust one or both if necessary, then gently tighten all the fasteners that hold the belts in place.
8. Set a container at about the middle of the Transport Conveyor and use the crank handle to bring the belts in to just lightly touch the sides of the container. Slide it forward and backward, there should be equal resistance throughout the gap between the belts. Make any tiny adjustment necessary.
9. Move the container so it is positioned between the pulleys at the feed end of the conveyor. Adjust the belts inward using the crank handle, so the belts have an adequate hold on the container- not tight enough to dent in the sides, but firm enough that it would be difficult to pull the container out.

IMPORTANT

Verify that the feet of the Transport Conveyor are firmly positioned and the feet do not rock or teeter, thus eliminating any possibility of movement, which could cause misalignment. Check the gripper belts. Make sure they are firmly grasping your container and that they are parallel, and tension is maintained throughout the length of the conveyor.

Test Run

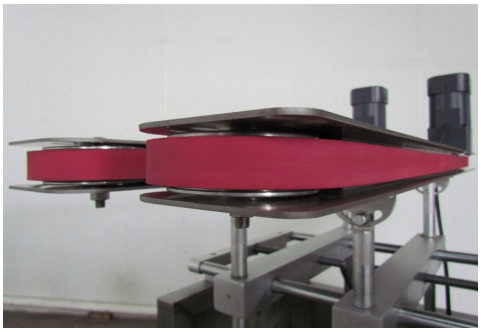
Turn your Transport Conveyor on and let it run for a little while. Now that your Transport Conveyor is set up to run your containers, the only variable is belt speed. In most circumstances you will want it to run just a little faster than the machine that feeds it-whether it's a bottle Orientator, or a filler, or capper. By running a little faster than the machine that feeds it, a gap will be created between containers, rather than having them bunch up at the entrance to this conveyor.

Speed adjustments are easily made during the course of a run, but production supervisors often keep a sheet of notes on machine settings to optimize production rates and reduce set-up times. It is recommended therefore that the machine that feeds this conveyor be turned on, set at its normal production speed, and then the belt speed of the 825-TA Conveyor be set just a little faster and noted for future set-ups.

IV. MAINTENANCE:

The 825-TA Mini Transport Conveyor system is virtually maintenance free. The motors and bearings are permanently lubricated from the factory. Maintenance is reduced to keeping the machine clean and adjusted.
We recommend a thorough weekly cleaning, with a mild detergent, and adjusting, checking that the feet all touch the ground, that the conveyors stay parallel to the machine frame and to each other. Check the belts for damage, and keep spares on hand.
There are large adjustment screws beneath the conveyor belts - we recommend that they be lubricated (food grade if necessary) periodically. It may be necessary to occasionally adjust the belt tension on the gripper belts. If so, please refer to the belt tensioning procedure given below.

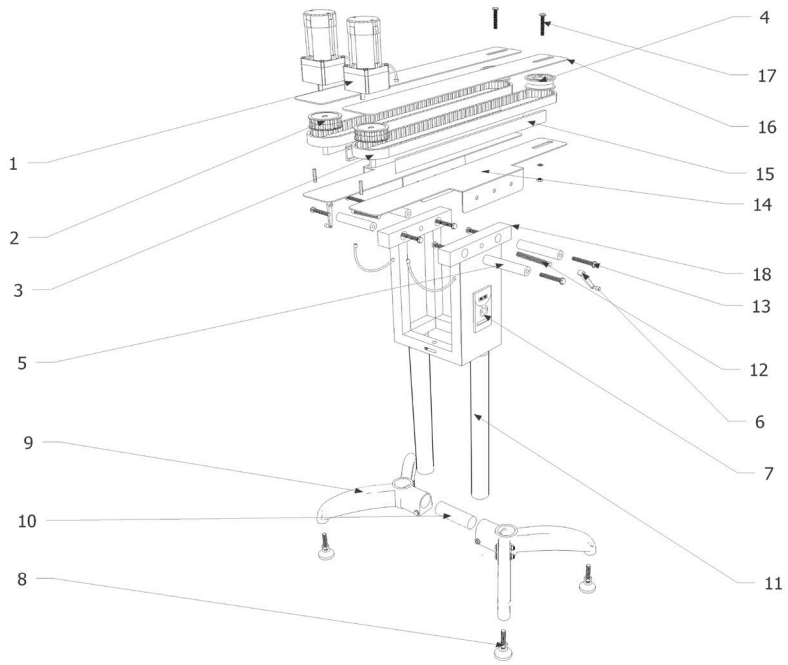
Belt Tensioning Procedure



Using an Allen wrench, loosen the sprocket. This is a carriage bolt so you will not need to back the screw up with another wrench. On the inside of the rail, carefully place a flat head screwdriver between sprocket and the delrin rail, carefully prying the sprocket away from the rail, and then tighten screw. This belt does have teeth to drive it, so you do not need to over tighten it. This could shorten the life of the belt

Belt Changing Procedure

Using an Allen wrench remove the screw from the sprocket completely. With an Allen wrench remove the 6 screws on top of the motor plate. Lift the motor plate slightly and you will have access to the belt in order to remove it safely from the unit. Place new belt aligned with sprockets. With Allen wrench place 6 screws a top motor plate and with W wrench screw sprocket completely.



PARTS LIST

1. MOTORS	10. STAINLESS STEEL 2” PIPE
2. TIMING PULLEY	11. FRAME
3. TIMING BELT	12. THREADED ROD
4. IDLER	13. SCREWS
5. SPACERS	14. C CHANNELS MOTOR MOUNT
6. CRANK HANDLE	15. ALUMINUM SPACER
7. VARIABLE SPEED CONTROL	16. TOP MOTOR PLATE
8. ARTICULATED FEET	17. SCREWS
9. 120° TRIPOD BASE	18. CROSS BLOCK