

# ***Segmented Transfer Plate 1.5" - 3" Span Installation Instructions***

## **Parts Included in Transfer Plate Kit:**

- Extruded aluminum bar
- Center segments
- Vertical support brackets
- Angle bracket
- Mounting hardware
  - Carriage bolts (8)
  - Flat washers (8)
  - Split lock washers (8)
  - Flange nuts (8)
  - Square nuts (2)
  - Set screws (2)
  - Shims (8)
  - Button head 1/4-20 x1/4 (2)



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## **Tools Required for Installation:**

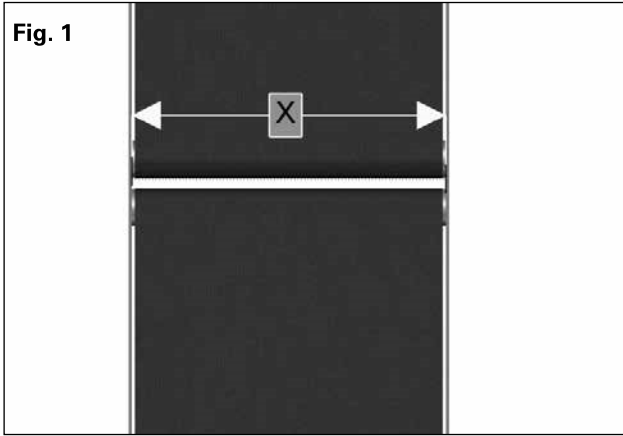
- 3/32" Allen Wrench
- 5/32" Allen Wrench
- 1/2" wrench plus socket and ratchet
- Tape measure
- Hammer
- Hand held Band Saw or Hack Saw
- Saw or universal cutters
- Marker or grease pen
- Drill
- 3/8" Drill Bit
- Welder

## **Optional:**

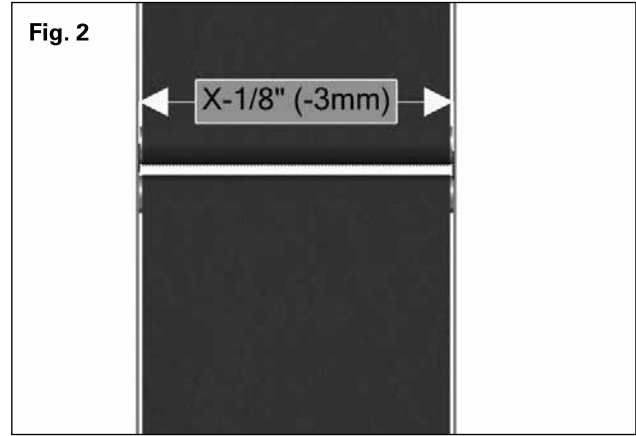
- Center Punch
- Flashlight

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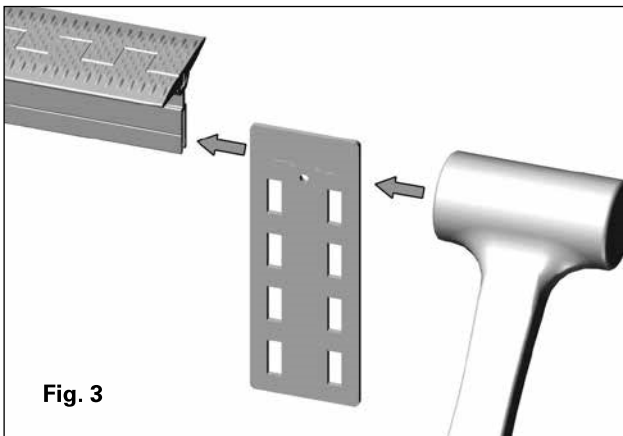
**Follow site lockout and tag out procedures prior to performing any work on the conveyor system.**



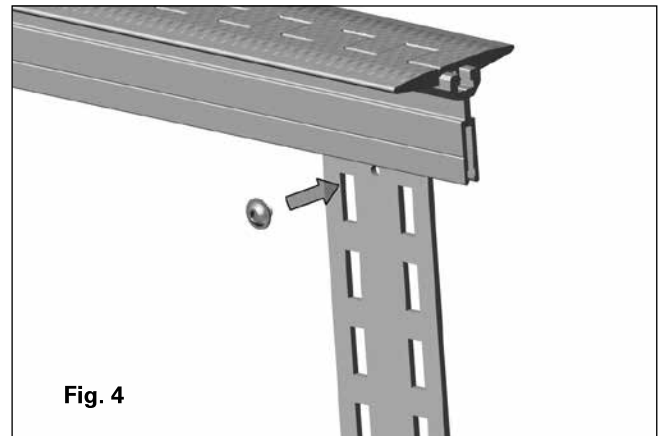
1. Measure inside structure width (**Fig. 1**).



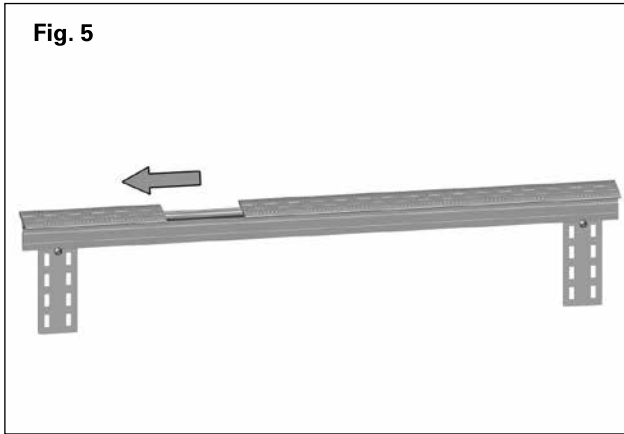
2. Cut extruded aluminum bar to length. Prior to cutting the bar:
- If bar and segments cannot pass through the side structure of conveyor, continue on to cutting the support bar to length, structure width minus 1/8" (3mm) (**Fig 2**).
  - If conveyor structure is open, allowing the extruded support bar to pass through, leave bar full length (if no other interference).
  - If conveyor structure opening is large enough for segment to also pass through, you will need to fix segments in position on extruded support bar. This is done after final segment pairs are installed. See step 16.



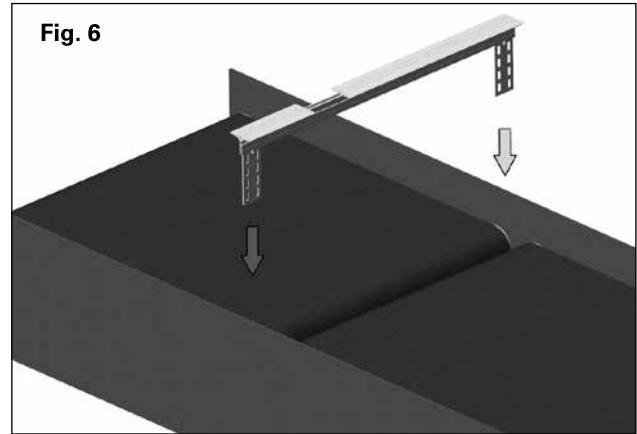
3. Insert vertical support mount into extruded support bar using light hammer taps (**Fig 3**). Position vertical support bracket in approximate final location, no further than 6"/150mm from end (final location to be determined in step 8).



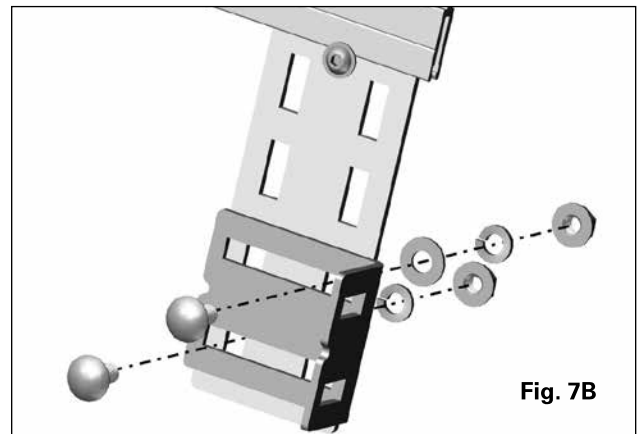
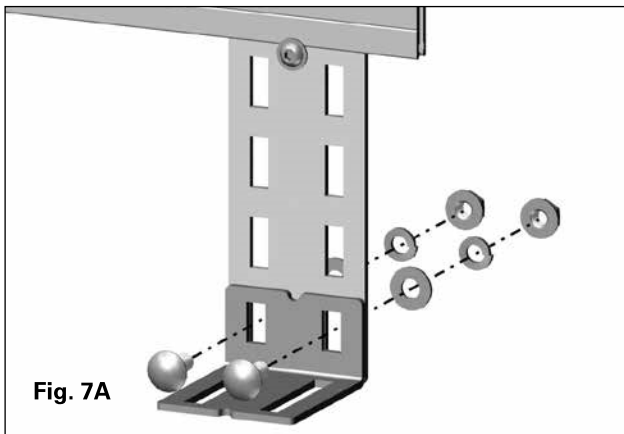
4. Use button head screw to lightly secure vertical support bracket to extruded support bar.  
**NOTE:** Do not fully seat/tighten screw at this time (**Fig 4**).



5. Slide two to three segment pairs down to the end of the extruded aluminum bar. (Fig. 5).



6. Place Segmented Transfer Plate into transfer opening. (Fig. 6).



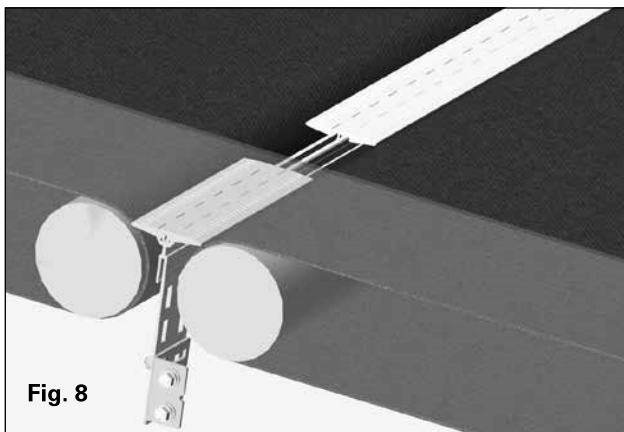
7. Determine desired position of angle bracket. (Fig. 7A). Use two bolts to loosely assemble angle bracket to vertical support at center of desired slot location (Fig. 7B).

**NOTE:** Excess length of vertical or angle support brackets can be cut to proper length.

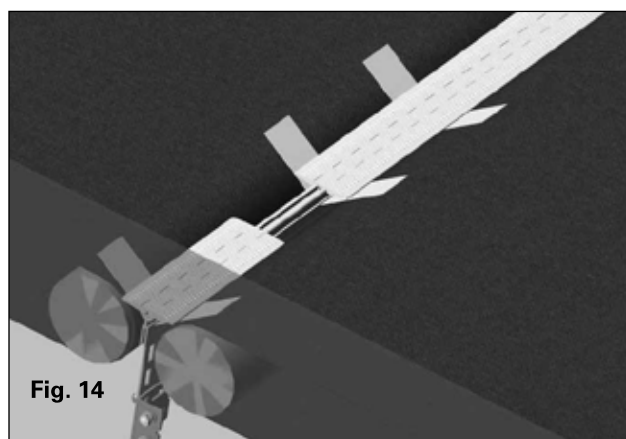
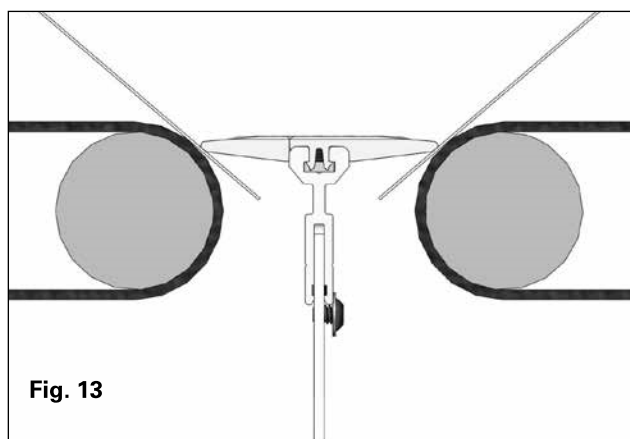
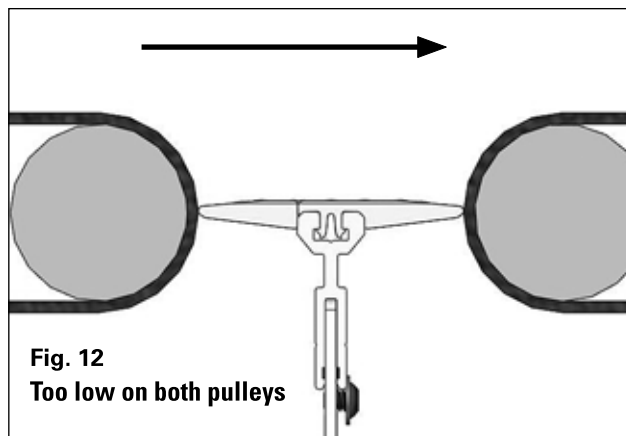
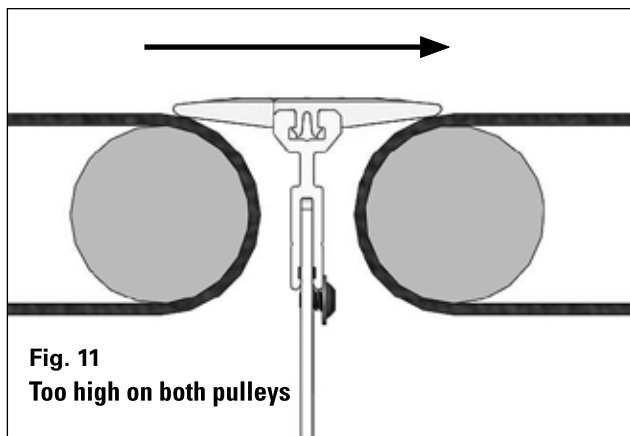
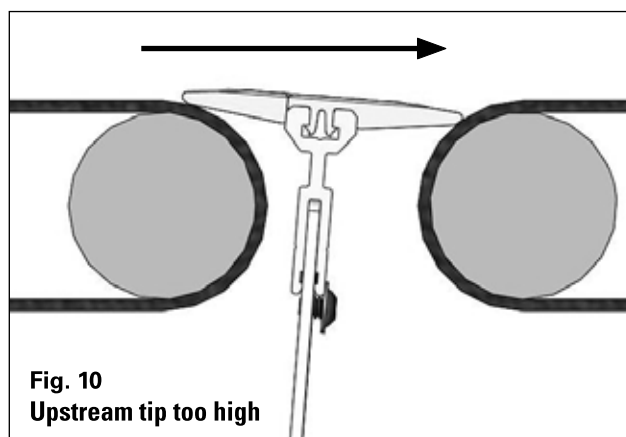
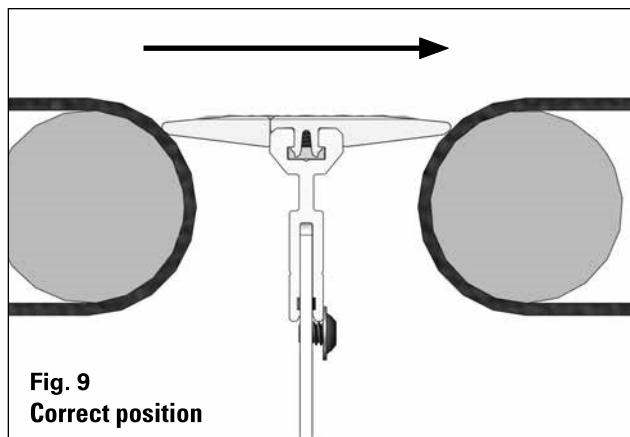
**NOTE:** Final set of bolts in Step 12C.

8. Determine final mounting structure location.

9. Position vertical support brackets so that the angle brackets are in position for final attachment to structure. Tighten the vertical support bracket to the extruded aluminum bar using the supplied button head screw. This will prevent extruded aluminum bar from migration.



10. Bolt or weld the angle brackets to the structure (Fig 8).

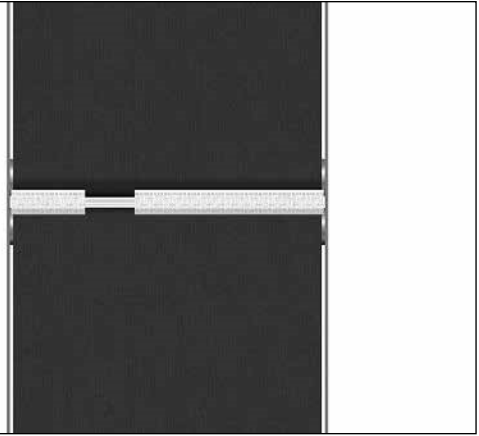


**11. Final positioning of segment to extruded aluminum bar assembly.**

- a. For non-textured belts, position so segments make light contact with the surface of the belt (**Figure 9**).
- b. For textured belts such as linear rib, rough top, or mini rough top, please use provided shims (.030"/.75mm) under segments, spaced evenly across belt width (**Figures 13-14**).

**NOTE:** Remove shims prior to running conveyor.

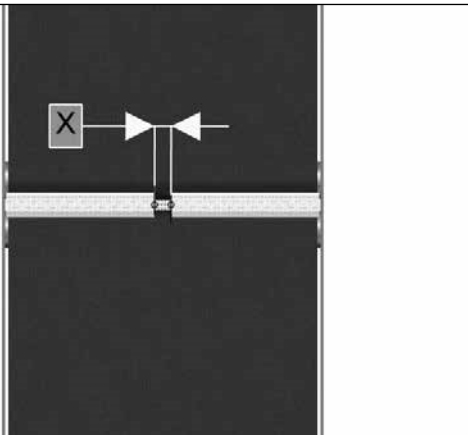
**Fig. 15**



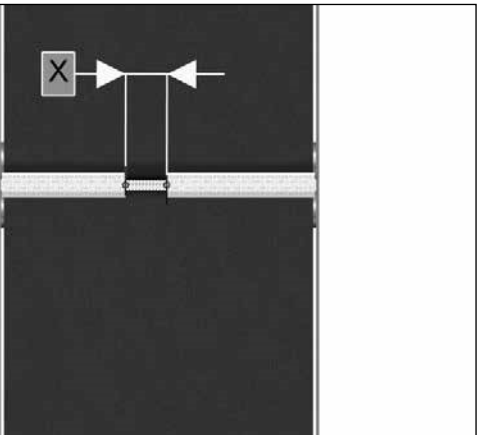
**12.** Tighten bolts connecting vertical support bracket to angle bracket.

**13.** Install remaining segments until last gap remains. Gap will likely be smaller than segment width. (Fig 15).

**Fig. 16**

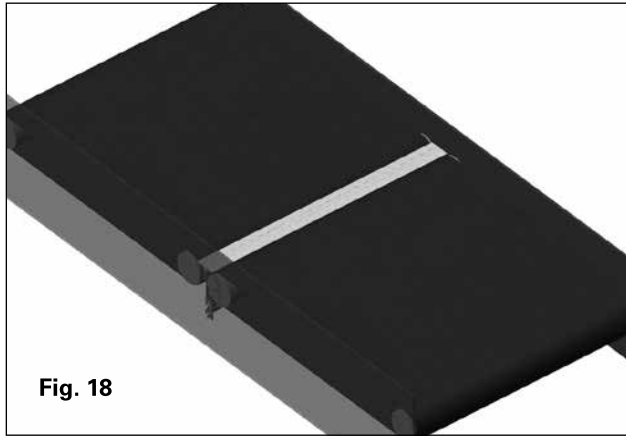


**Fig. 17**

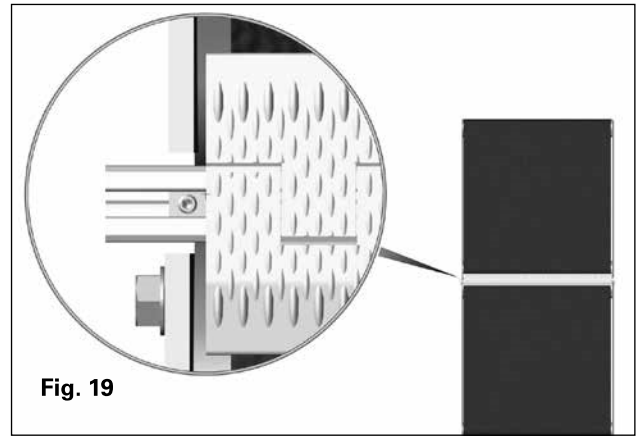


**14.** Measure remaining gap and determine if final segment sizing is required.

- a. If segment sizing is required, cut segment pair down to the size required, but no smaller than 1.5" (38mm) (Fig 16).
- b. If remaining gap is less than 1.5" (38mm), remove one set of segments and take a measurement of remaining larger gap. Subtract 1/8" (3mm) from the measurement. Divide the final number by 2. Cut two segment pairs down to this dimension. (Fig 17).



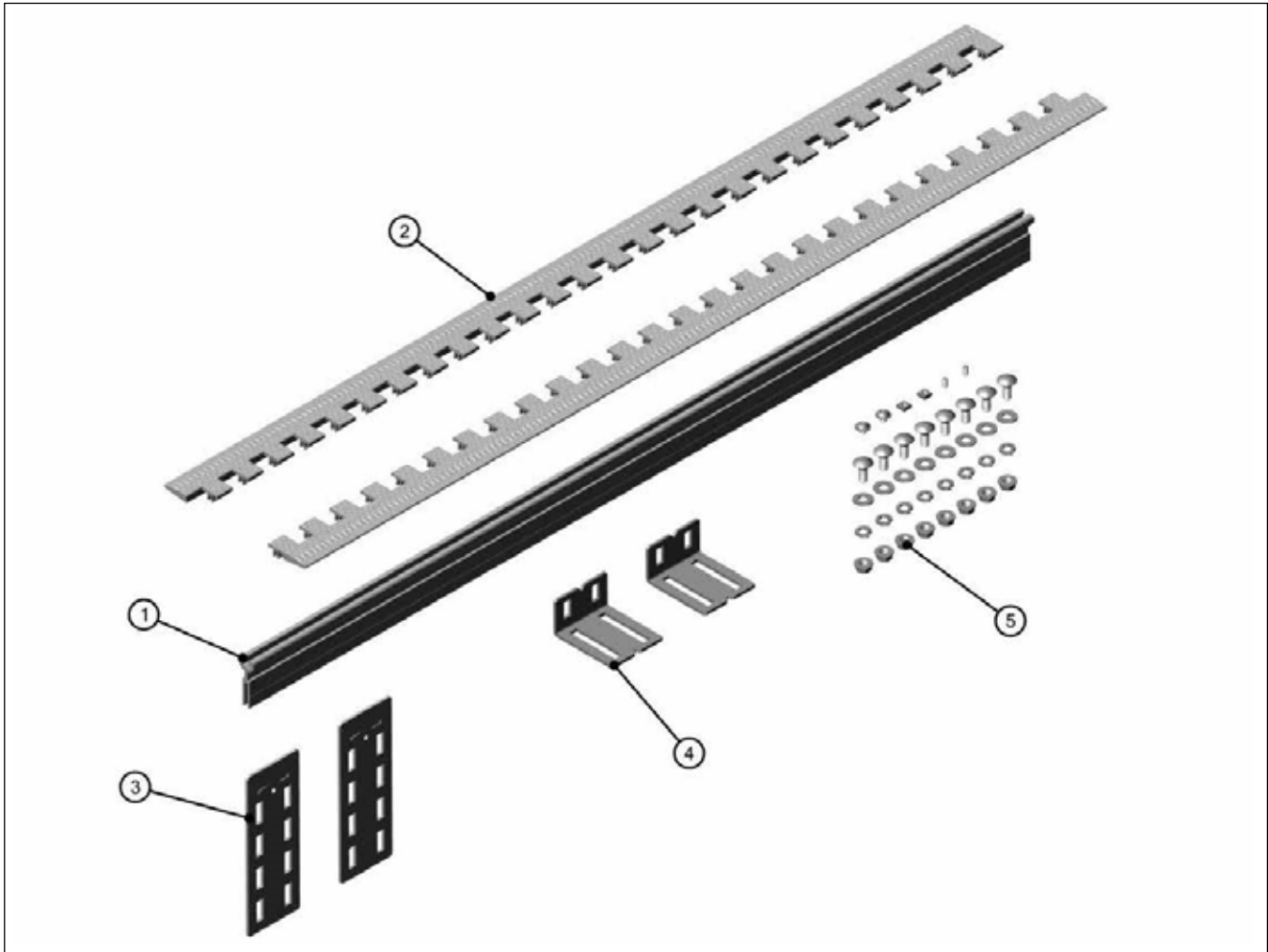
**15.** Install final segments (**Fig. 18**).



**16.** If side structure is open and extruded aluminum bar is cut longer than inside wall of conveyor structure, use included square nut and set screw to fix segments at both ends in place. This will prevent segment migration. (**Fig. 19**).

**17.** Test run conveyor.

**18.** Make final adjustments as needed.



Item	Description	Item Code	Ordering Number
1	Extruded Aluminum Bars	56639	TGB-EXT-ALUM-BAR-24/610
		56640	TGB-EXT-ALUM-BAR-36/914
		56641	TGB-EXT-ALUM-BAR-42/1067
		56642	TGB-EXT-ALUM-BAR-48/1219
		56643	TGB-EXT-ALUM-BAR-60/1524
2	Center Segments	56636	TGB-SEG-CENTER-.75/19MM
		56637	TGB-SEG-CENTER-1/25MM
		56638	TGB-SEG-CENTER-1.5/38MM
3	Mounting Kit Parts	56645	TGB-1.5-3.0-VERT-SUPPT-BRKT-KIT
4		56646	TGB-1.5-3.0-ANGLE-BRKT-KIT
5		56648	TGB-1.5-3.0-MTNG-HARDWARE-KIT
	Mounting Bracket Kit (Includes 2-#3, 2-#4, 1-#5)	56644	TGB-1.5-3.0-IN-GAP-MTNG-KIT

**Visit our website or contact your local distributor to learn more.**

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