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Replacement of the conveyor belts

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For replacing the conveyor belt, it needs to uncouple the hexagon shaft by loosen the fixing screws by the following procedure.

NOTE Conveyor rail structures is symmetrical in front and rear.

Step1: **BF-3Di-L1**: Remove the twelve M4 flat head screws (six on each rail)
BF-3Di-Z1: Remove the thirty two M4 flat head screws (sixteen on each rail)
and remove the backup plates from each conveyor rail.

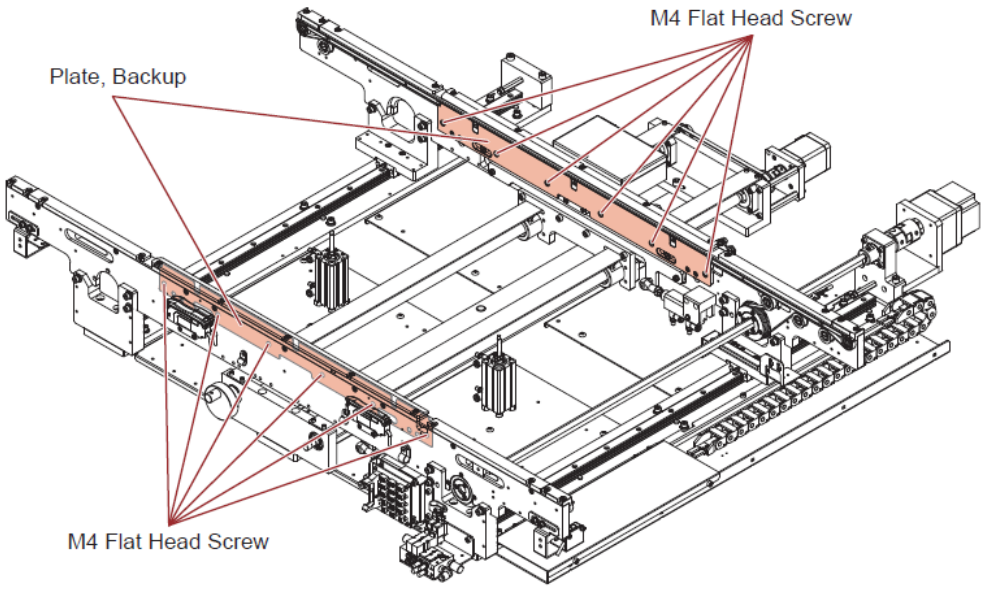

Figure 2-8 Replacement of Conveyor Belt 1 (BF-3Di-L1)

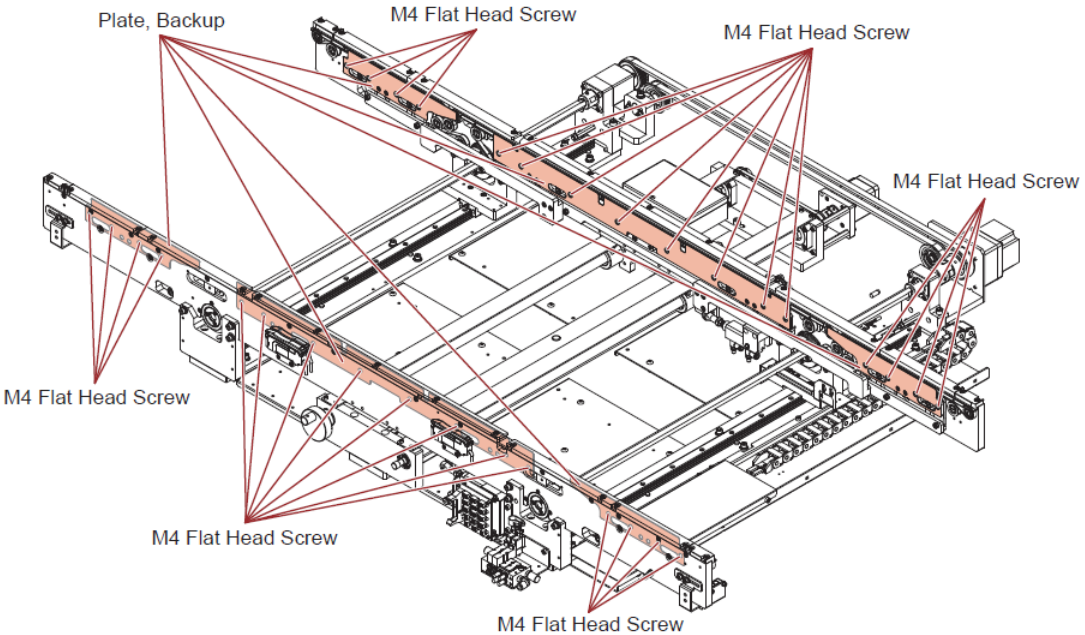

Figure 2-9 Replacement of Conveyor Belt 1 (BF-3Di-Z1)

Step2: Loosen the conveyor belt tension adjusting pulleys of each conveyor rail by a flathead screwdriver.

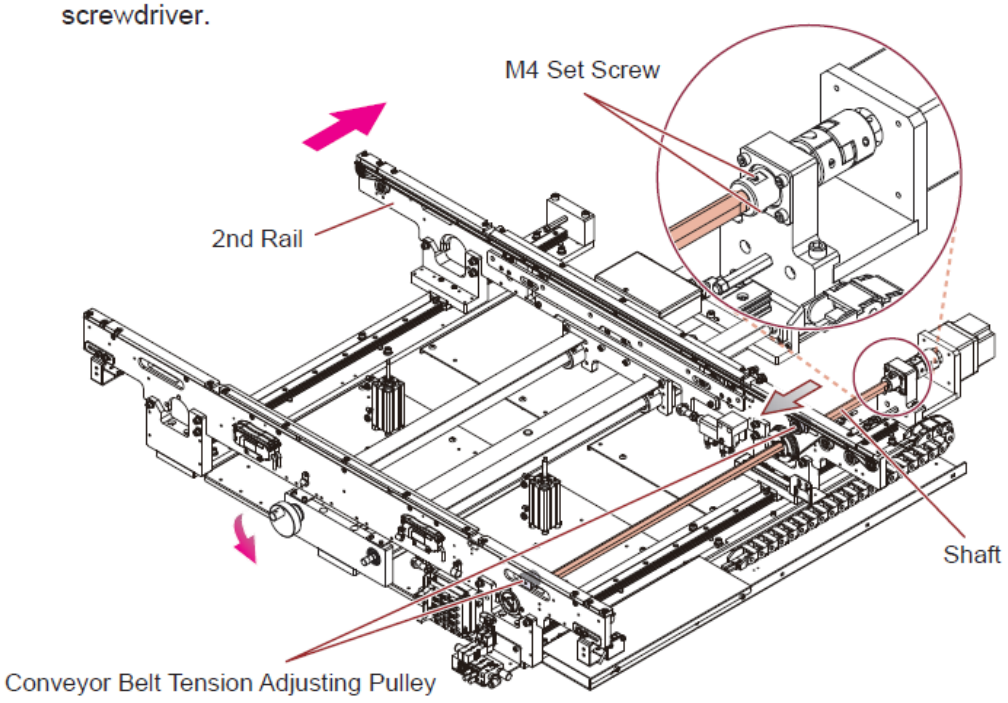

Figure 2-10 Replacement of Conveyor Belt 2 (BF-3Di-L1)

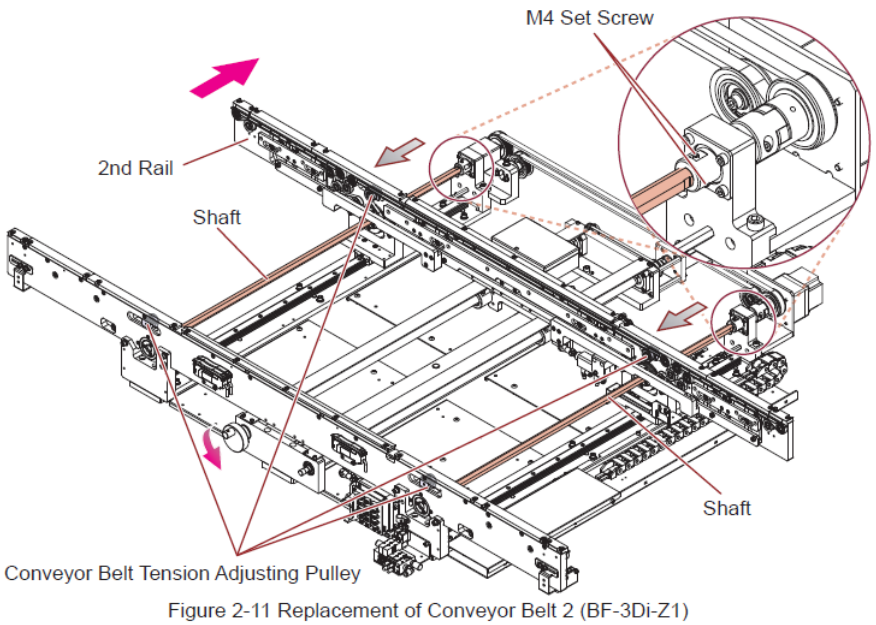

Figure 2-11 Replacement of Conveyor Belt 2 (BF-3Di-Z1)

Step3: Move the 2nd rail to the rear and loosen the M4 set screws which fix the hexagon shaft on the rear side of the machine (refer to Figure 2-10 and 2-11).
BF-3Di-L1: Loosen the two M4 set screws
BF-3Di-Z1: Loosen the four M4 set screws (two on each rail)

NOTE For the details on moving conveyor rails, refer to **1.4 Adjusting the Conveyor Rail**.

Step4: Uncouple the hexagon shafts by sliding the hexagon shafts to the front.

Step5: Clearance will be made between the hexagon shafts and drive pulleys as shown in the following illustration. Replace the conveyor belts.

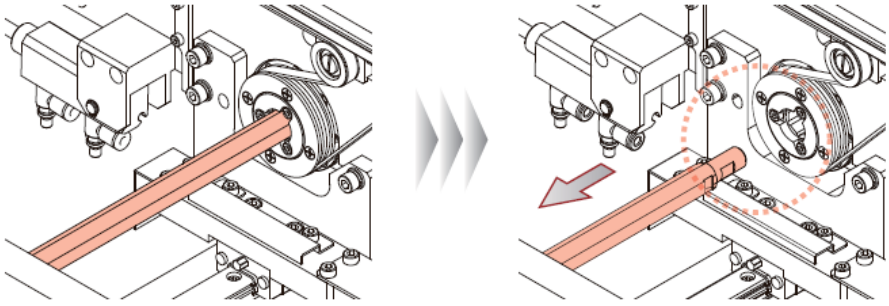

Figure 2-12 Replacement of Conveyor Belt 3

Step6: Adjust the conveyor belt tension adjusting pulley not to bend the belt. Adjust the pulleys so the distance between the T-type nut [SJ36RL016] and rail end becomes following illustration.

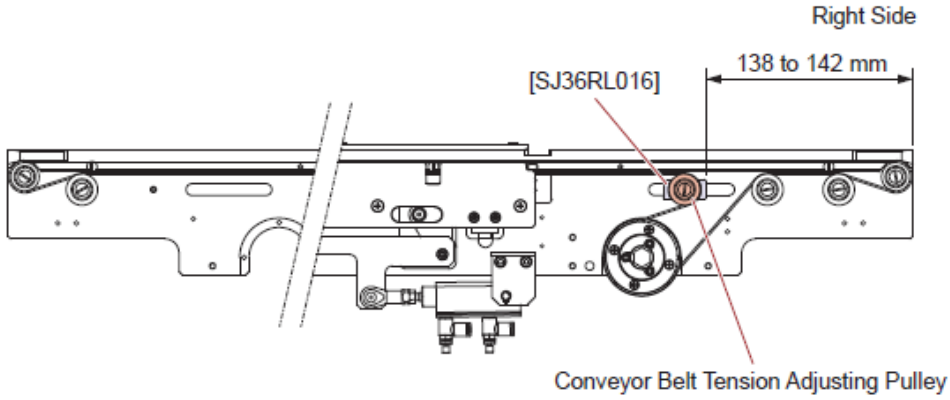

Figure 2-13 Adjust the Conveyor Belt Tension (BF-3Di-L1)

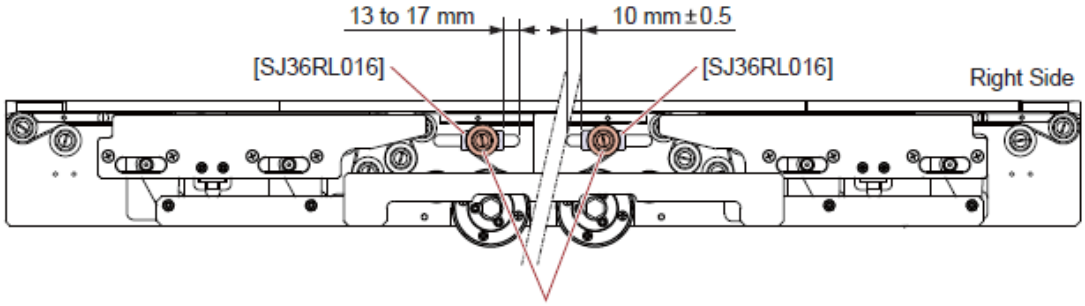

Figure 2-14 Adjust the Conveyor Belt Tension (BF-3Di-Z1)

Step7: After the replacement is completed, reassemble the parts in an opposite procedure.

Step8: Make sure that a PCB can be conveyed smoothly.

There are two kinds of pulleys.

Turn the pulley by a flathead screwdriver to remove it.

NOTE Conveyor rail structures are the same in symmetry. The same parts are used on all rails.

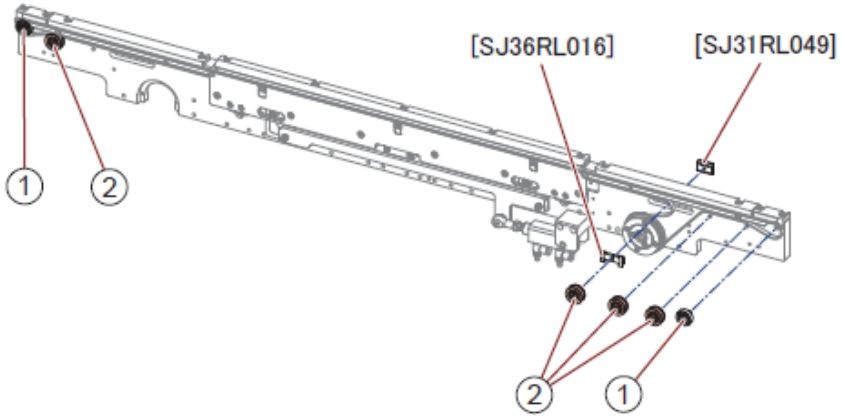

Figure 2-15 Replacement of the Pulley (BF-3Di-L1)

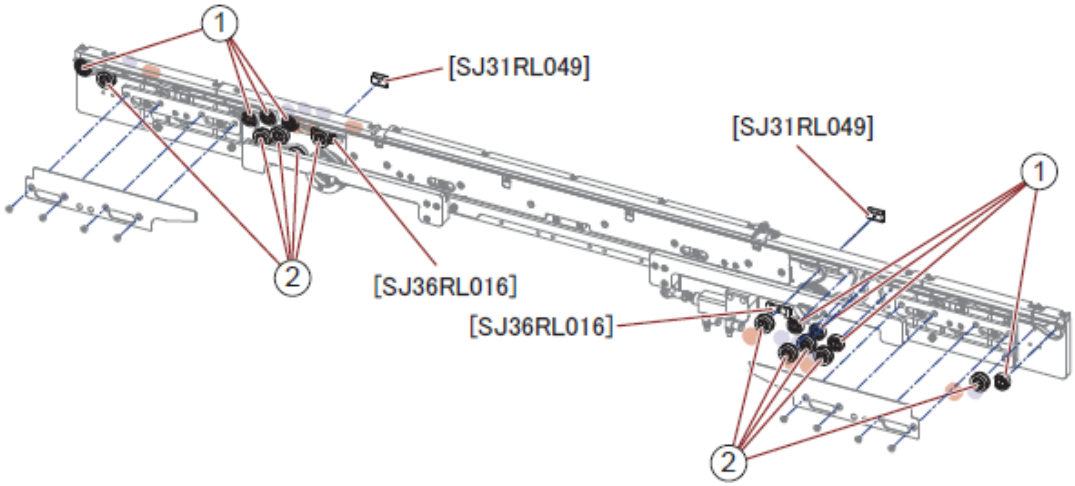

Figure 2-16 Replacement of the Pulley (BF-3Di-Z1)

No.	Item	Qty (BF-3Di-L1)	Qty (BF-3Di-Z1)
1	Pulley 1 (without flange) [SJ36GRE0]	4 (2 on each rail)	16 (8 on each rail)
2	Pulley 2 (with flange) [SJ36GRD0]	8 (4 on each rail)	16 (8 on each rail)

Table 2-8 Pulley