The life of the conveyor chain will be shortened when the chain is allowed to sit in water or is operated in acidic conditions, so avoid these situations.

To extend chain life, spray a light coat of oil on the chain after each season's use. Use extreme caution; keep away from moving chain and paddles.

Regular inspections should be established in order to ensure that the conveyor chain is in good operating condition at all times.

1. Inspect the conveyor chain for loose bolts, missing chain parts, missing or damaged chain paddles and the overall chain condition.
2. Check chain tension; see below for chain adjustment.
3. Check conveyor sprocket to see that it is centered and setscrews are tight.

**CHAIN TENSION ADJUSTMENT**

Use the take-up bolts at the tail section to tighten the chain.

1. Loosen the four carriage bolts on each take-up slide.
2. Move the jam nuts on the conveyor chain adjustment bolts to tighten chain.
3. If the chain is still too loose after the adjustment, it may be necessary to remove one or more links from the chain.
4. Tighten carriage bolts to take-up slides. Make sure main shaft is square with chain and trunking.

**CAUTION: DO NOT OPERATE CONVEYOR WITHOUT COVERS ON THE CONVEYOR AND ALL MOVING DRIVE PARTS SHIELDED.**

Whenever you must service or adjust your equipment, make sure you stop the machine and lock out your power source!

It is important not to overtighten the conveyor chain. However, if the chain is not sufficiently tight, it will slip at the drive sprocket as capacity is increased. Should this occur, shut off the grain flow to the unit and shut down after the unit has emptied.

To check conveyor chain tension, grasp one of the top paddles at the intake end and attempt to rotate it up toward the chain. See Fig. A. Proper chain tension should allow only minimal rotation of the paddle. Inspect the conveyor chain for loose bolts, missing chain parts, missing or damaged chain paddles and the overall chain condition. Conveyor sprockets should be centered and setscrews tight.
13” MASS-TER FLOW
PARTS LIST

REF. NO. PART NO. DESCRIPTION
1 1005592 Paddle UHMW
2 1038005 81X Chain with Brackets (10’ 2-7/32” lg. 48 pitches)
3 420154 Connecting Link
4 420200 Offset Link (not shown)
5 4727-1 5/16” x 1-1/4” lg. Capscrew
6 33023 5/16” Flat Washer
7 33135 5/16” Lock Nut
-- 420092 16” Tooth 2” Bore Sprocket
-- 420065 16” Tooth 2-7/16” Bore Sprocket
-- 420066 16” Tooth 2-15/16” Bore

DIRECTION OF GRAIN MOVEMENT