

ABS Conveyor Rebuild Kit Instructions

Part #19207

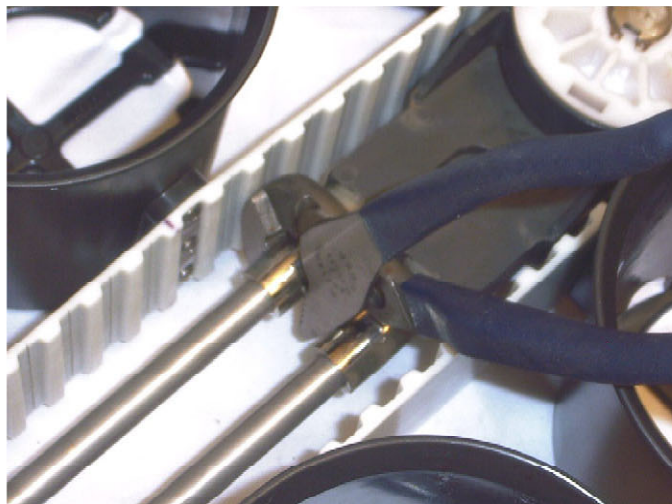
Approximate total time is 30-45 minutes

Tools Required:

- **#1 Phillips tip bit/screwdriver**
- **Snap Ring Pliers**
- **Small crescent pliers**
- **Cleaning Brush/Towel**
- **Tape Measure/Provided in Kit**

***Step 12 is very critical!!**

- 1. Inform the Manager that the unit will be in the "Manual" mode during this repair.**
- 2. Remove the Conveyor and locate a flat open area to perform this repair.**
- 3. Using counterclockwise rotation loosen the 2 round tension nuts all the way loose on the right side of the conveyor.**



4. Remove the belt and cup holders from the gears



5. Using Snap-Ring pliers, carefully remove both the left and right top retainer rings only. (2 extras provided in the kit)

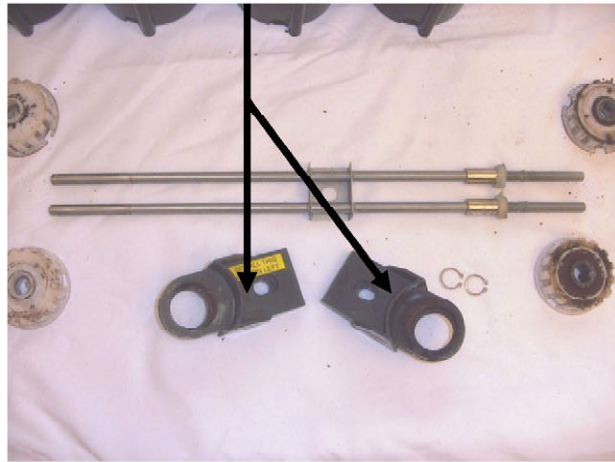


6. Remove the 4 gears, 2 bearings and 2 axles



7. Clean both the Left Keyed Axle and Right Axle (Remember Keyed Axle on Left side)

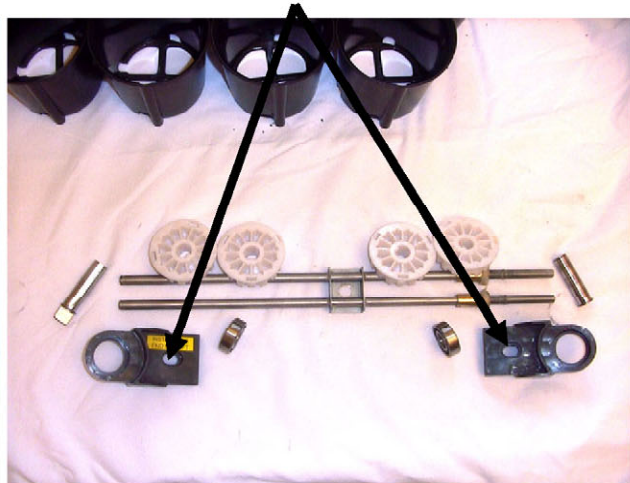
8. Remove both gray housings and clean



9. Begin to assemble the gear housings, axles, gears, bearings and retainer rings.

*****Keyed Axle on Left Side*****

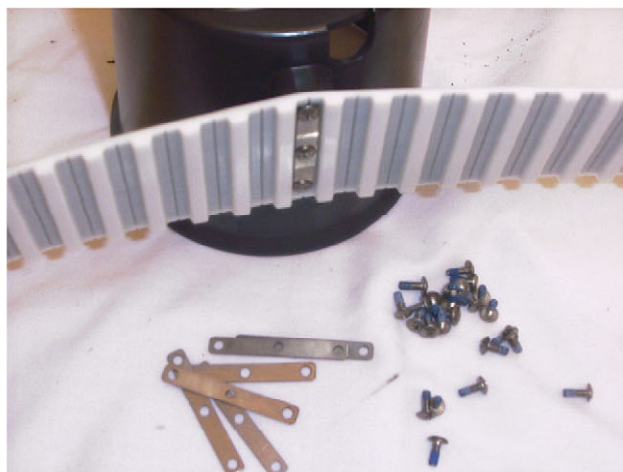
*****SINGLE OVAL UP*****



10. Remove all 9 Cup holders from the defective belt (#1 Phillips tip works best) and set the cup holders aside

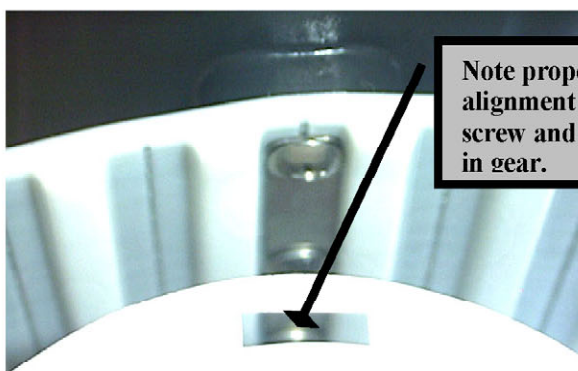


- 11. CAREFULLY attach all 9 cups to the new belt using the backing plates and screws provided (If a cordless drill is used, ensure the screws are NOT over-tightened)**

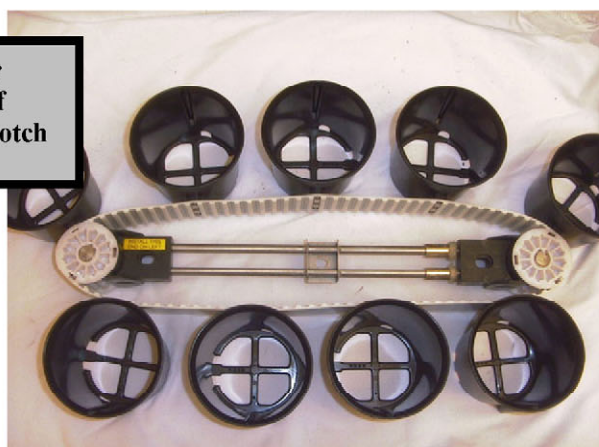


***** IMPORTANT *****

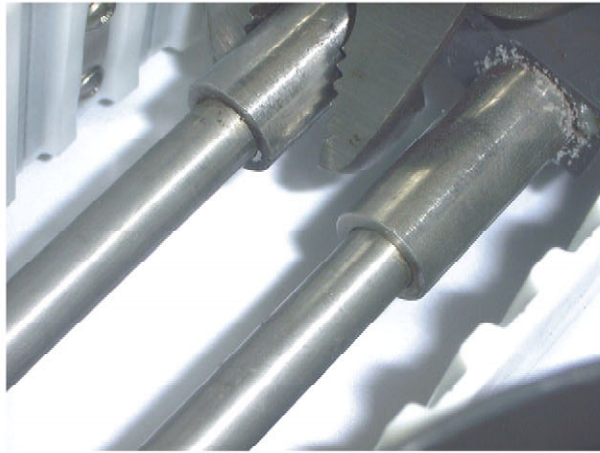
- 12. Position Belt, aligning cup holder screw with outermost notch on gear.**



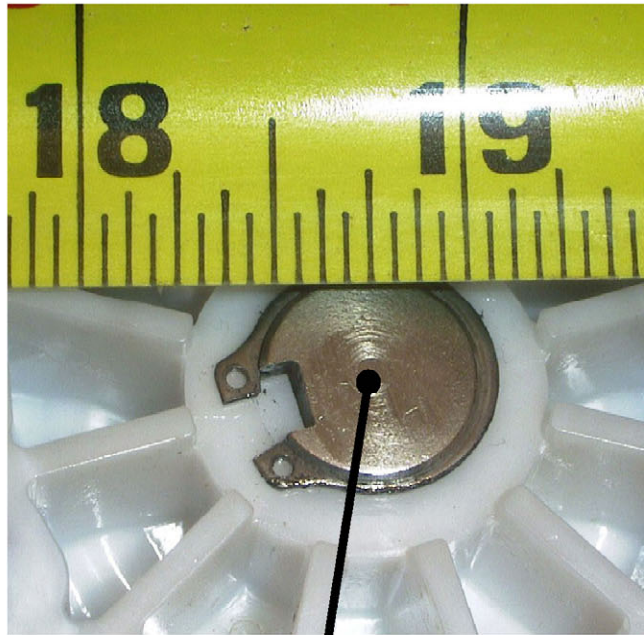
Note proper alignment of screw and notch in gear.



- 13. Once belt is properly positioned, using clockwise rotation on tension nuts tighten until the belt is firm and taut.**



- 14. Use the provided tape measure to accurately achieve the correct tension ($18 \frac{3}{4}$ ".... Left axle center to right axle center **MUST** be ($18 \frac{3}{4}$ ")**



$18 \frac{3}{4}$ "

15. Verify the measurement again with a tape measure

- **Optional: Silicone Tension Nut to Housing**

16. Re-install Conveyor and TEST