
MiTek[®]

SERVICE BULLETIN

Document ID:
SB273

Title:
Replacing the Chain Tensioner

Affected machinery: *RoofTracker III™* Roller Press

Distribution: Customers upon order

CAUTION:

MiTek recommends printing this document in high resolution using color ink. Many of the graphics may be unclear and may create an unsafe condition if this recommendation is not followed.

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Purpose and Scope

This service bulletin instructs how to retrofit an updated chain tensioner used in the equipment referenced on the title page.

Overview

Parts Included

The parts included in this kit are shown in [Table 1](#). Please make sure all parts and supplies are present before starting the procedure.

Table 1: Parts in SB273KIT

Quantity	Description	Part #
2	High Strength Chain, 80, 1" Pitch	554022-86.00
2	Master Link Connection	554187
2	Retrofit Assembly Kit	67824-601
1	Service Bulletin Document	SB273

If you have any questions, call MiTek Automation Support at 1-800-523-3380.





Supplies Needed

- Saw for metal
- Tape measure

Procedure

Electrical Lockout/Tagout Procedure

	 WARNING
	<p>ELECTROCUTION HAZARD.</p> <p>All electrical work must be performed by a qualified electrician.</p> <p>Verify that all power to the machine has been turned off and follow approved lockout/tagout safety procedures before performing any maintenance.</p> <p>If it is absolutely necessary to troubleshoot an energized machine, follow NFPA 70E for proper procedures and personal protective equipment.</p>

1. Engage an E-stop on the machine.
2. Turn the machine's disconnect switch to the Off position. This is usually required to open the main electrical enclosure's door.
3. Shut the power to the machine off at the machine's power source, which is usually an electrical service entry panel on the facility wall. One example of a locked-out power source panel is shown in [Figure 1](#).
4. Attach a lock and tag that meet OSHA requirements for lockout/tagout to the electrical service entry panel.
5. Open the door to the enclosure to which you need access. Using a multimeter, verify that the power is off.



Figure 1: Lockout/Tagout on the Power Source Panel



Removing the Previous Chain Tensioner



⚠ WARNING	
	<p>MOVING PARTS CAN CRUSH AND CUT.</p> <p>Always verify that power to the machine has been turned off and follow approved lockout/tagout procedures.</p>

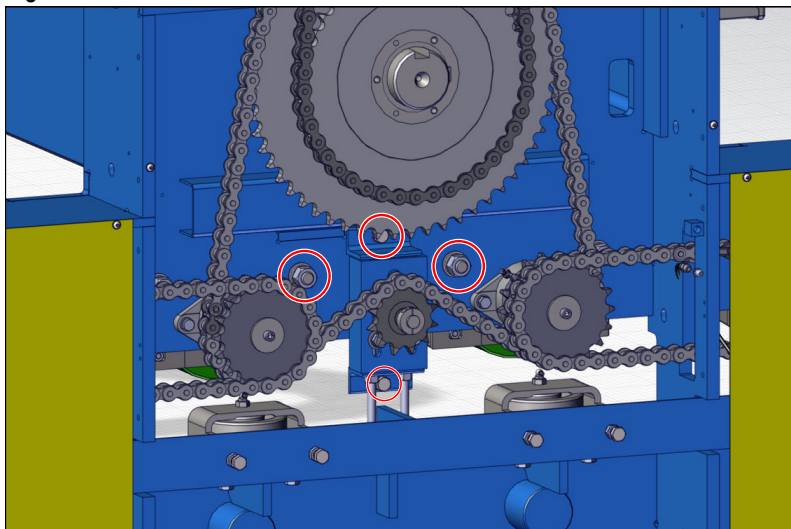
1. With power locked out as previously described, open the end guard on the *RoofTracker III*.

Figure 2: End Guard Bolts



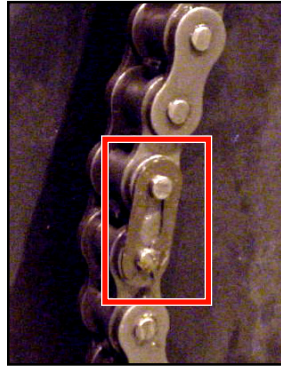
2. Remove the previous chain tensioner from the machine by undoing bolts circled in [Figure 3](#).
 - Do not lose the topmost bolt, as it will be used later.

Figure 3: Bolts for Removal of Previous Tensioner



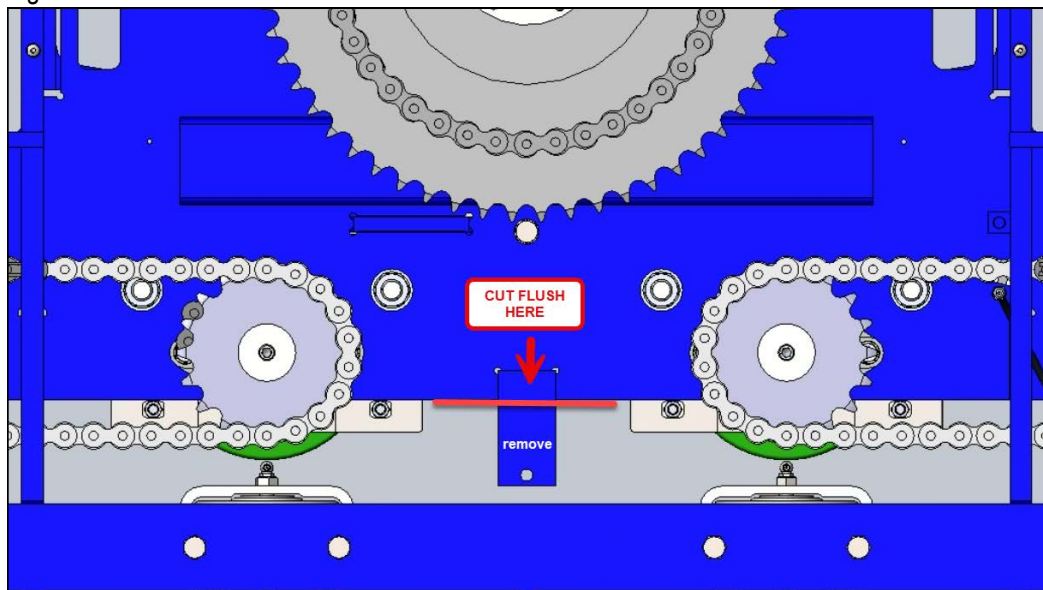
3. Remove the chain by removing the master link. Dispose of the chain.

Figure 4: Master Link Closeup



4. Use a saw to cut off the noted section of the machine frame.

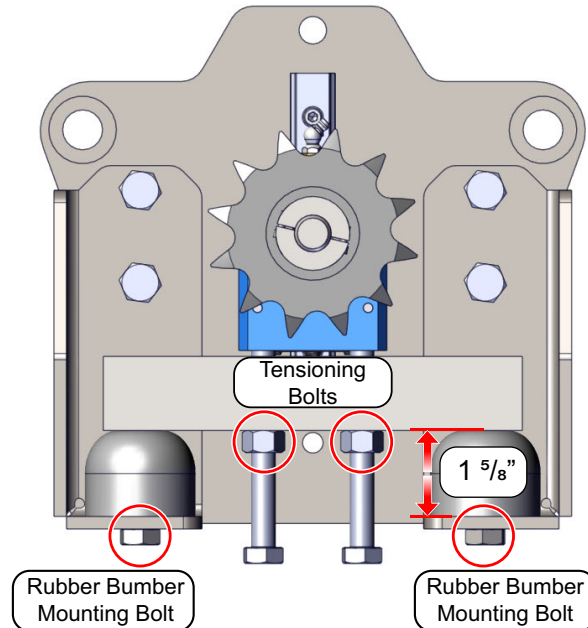
Figure 5: Where to Cut



Installing the Tensioner Assembly

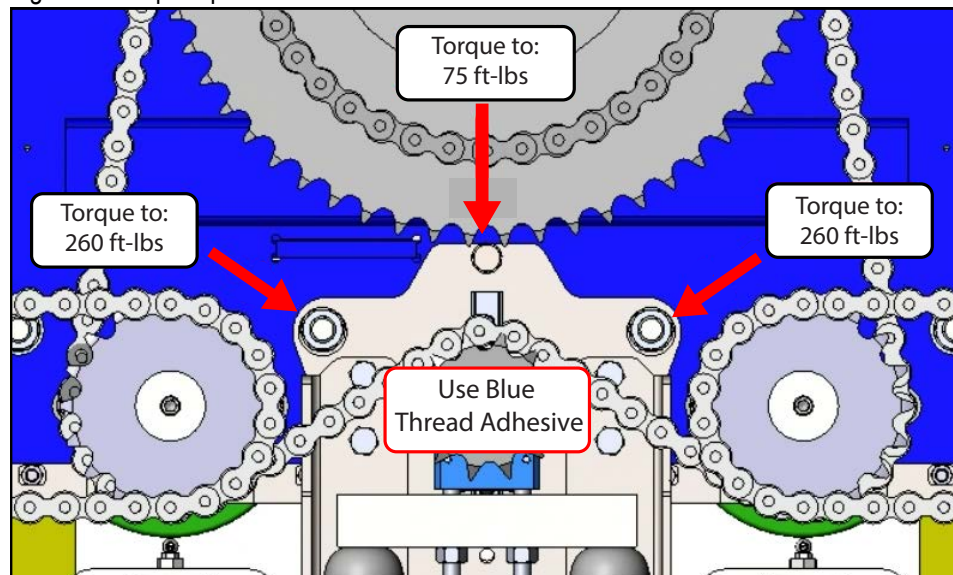
1. Adjust the bumper mounting bolts so that the rubber bumpers are 1-5/8" in height.
2. Ensure the tensioning assembly is at its loosest (lowest) possible position by adjusting the two tensioning bolts.

Figure 6: Rubber Bumpers



3. Apply blue thread adhesive to the top bolt that was removed in [Step 2 on page 4](#), and the bolts provided with this kit.
4. Follow the torque specifications in [Figure 7](#) to install the new tensioner assembly onto the machine.

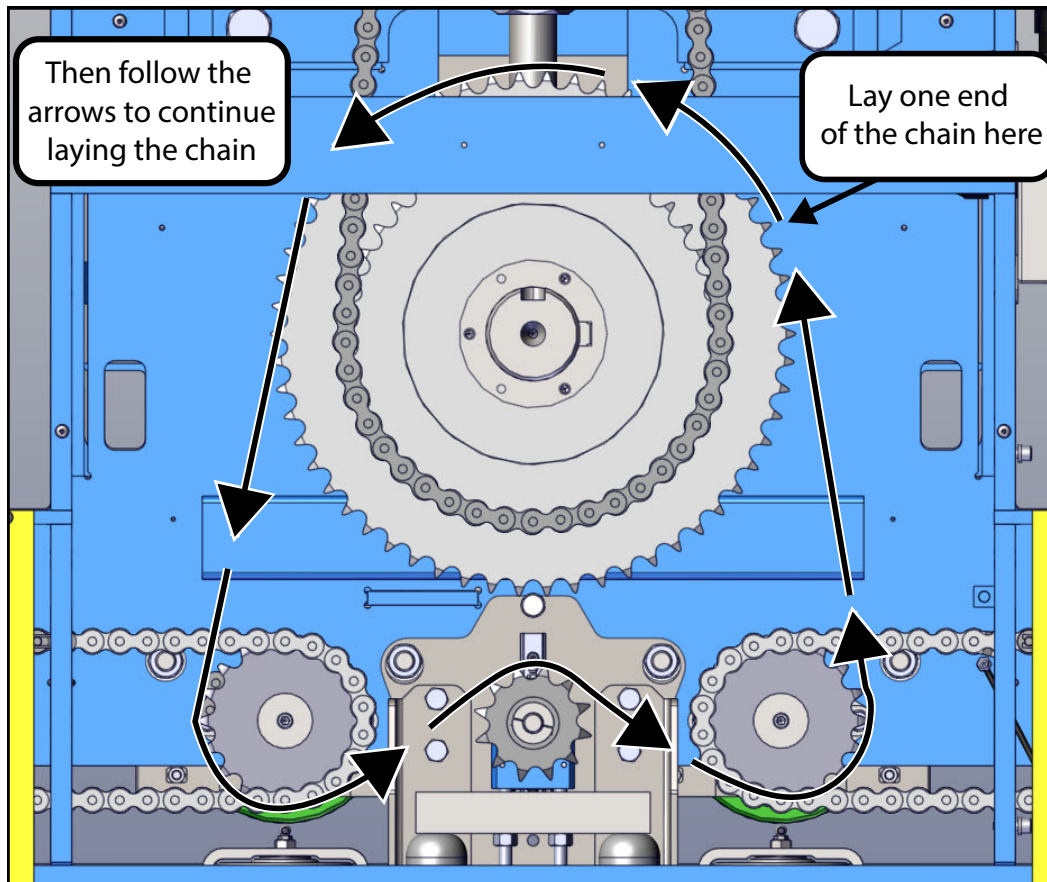
Figure 7: Torque Specifications



Re-Installing the Chain

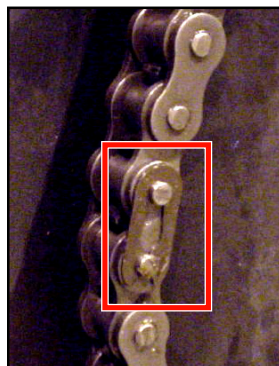
1. Place the chain, just offset from the midpoint, on top of the tensioner sprocket.
2. Then, wind the ends of the chain around the drive wheel sprockets, and rest each end on the main drive sprocket.

Figure 8: Laying the Chain



3. Install the master link to join the ends of the chain.

Figure 9: Master Link Closeup





4. Adjust the tensioning bolts so that the drive wheel chain play is approximately 1/2" (1/4" movement to both sides of center) with a maximum of 3/4" (3/8" movement to both sides of center).
5. Check the chain tensioning in three different sprocket rotations. Push the gantry with the brakes released or power up the gantry to rotate the sprocket.



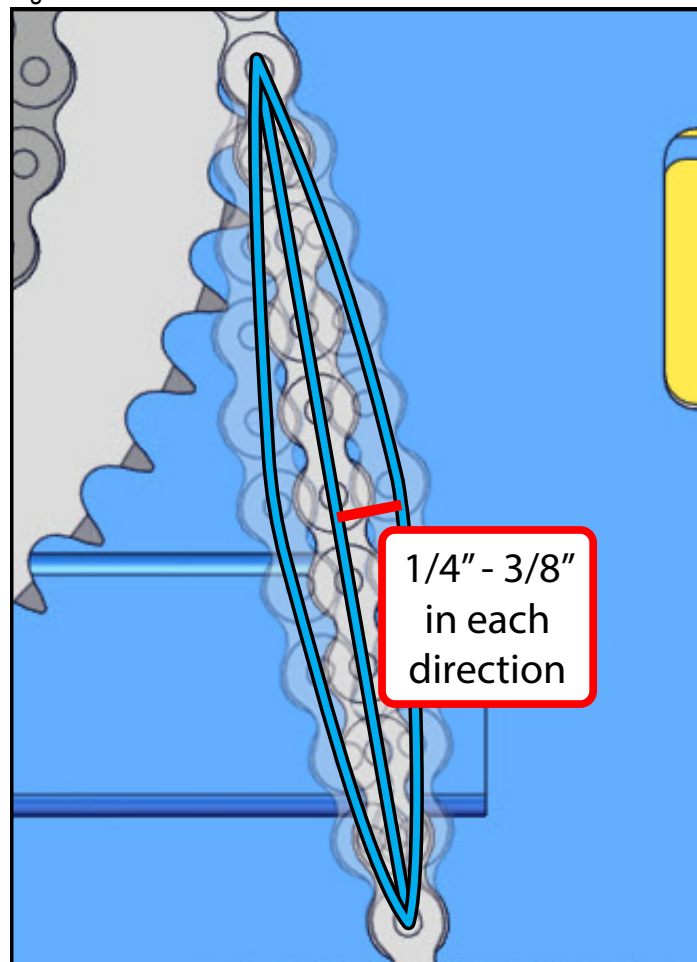
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Figure 10: Chain Deflection



Repeat

Repeat from [Removing the Previous Chain Tensioner on page 4](#) through [Re-Installing the Chain on page 7](#) for the other side of the *RoofTracker III* gantry head.

END OF SERVICE BULLETIN