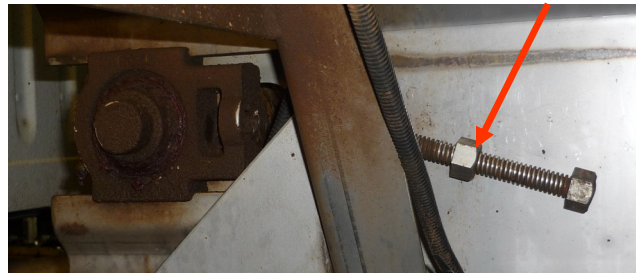
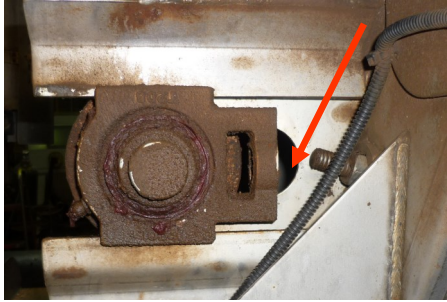


A Guide to Replacing Conveyor Chain

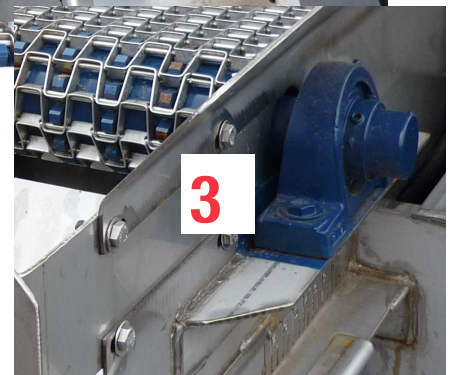
Step 1:

Using a 15/16 wrench, loosen nut on take-up screw. A 15/16 socket removes nut to allow front roller to slide all the way in toward the spreader body to remove tension from conveyor chain



Step 2:

Using wrench, remove the bolts from gate screw brace (1). Slide brace off end of handle.



Step 3:

Using wrench, remove the bolts (2 & 3) from side of chute.



**NEWTON
CROUCH**

© 2023 Newton Crouch Co. Rev 7.18.2023 This information is the property of Newton Crouch Co. and is loaned confidentially to our customer for his sole use. It must not be used in any way detrimental to our interest or shared with outside parties. Technical Tips\Conveyor Chain Replacement

Step 4:
Slide chute straight out (includes chute screw) and put to the side. This allows unrestricted access to rear roller.

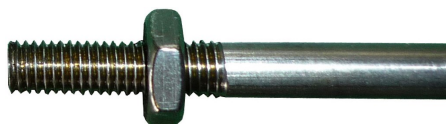
Shown here Rear Roller and Bearings have been removed



Step 5:
Grasping ends of rear roller rotate roller so that the splice pin is visible on the rear roller.



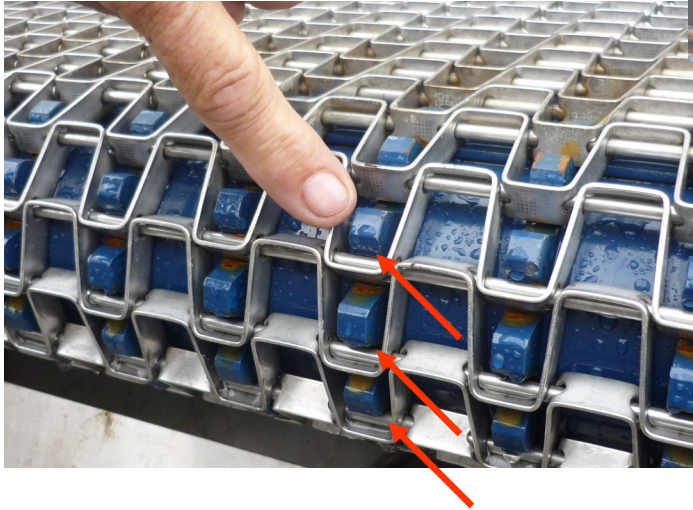
Step 6:
Depending on the splice pin, pliers will remove nut on splice pin OR a bolt cutter will cut the welded end off splice pin. Slide pin out of chain links and remove



**NEWTON
CROUCH**

© 2023 Newton Crouch Co. Rev 7.18.2023 This information is the property of Newton Crouch Co. and is loaned, confidentially to our customer for his sole use. It must not be used in any way detrimental to our interest or shared with outside parties. Technical Tips\Conveyor Chain Replacement

Step 7:
Starting at rear roller, place chain in floor of bed. Chain will cup under front roller and over bed supports to end at rear roller.



Step 8:
Be sure that sprocket tooth is pressing against the pin in the chain.



Step 9:
Place a block of wood under gate to apply pressure to chain after it is draped onto rear roller



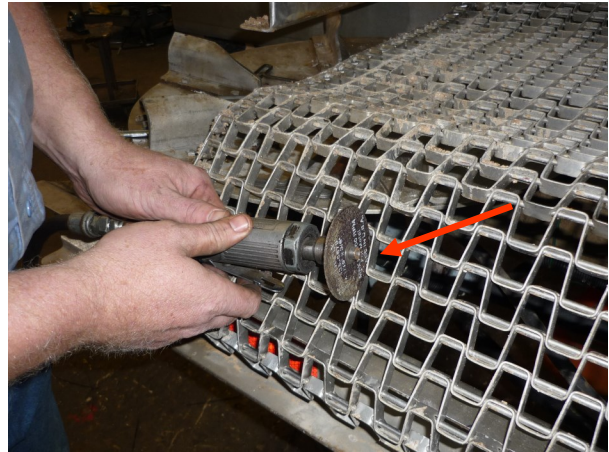
Step 10:
Pulling chain under rear roller, remove as much slack as possible before cutting chain.



**NEWTON
CROUCH**

© 2023 Newton Crouch Co. Rev 7.18.2023 This information is the property of Newton Crouch Co. and is loaned, confidentially to our customer for his sole use. It must not be used in any way detrimental to our interest or shared with outside parties. Technical Tips\Conveyor Chain Replacement

Step 11:
Mark proper length with marker and
cut chain to correct length



Step 12:
Pull chain pin out. This
leaves correct length
chain. Push chain
end up and thread
new splice pin
through starting from
the right



Step 13:
Put nut on end of splice pin. Using pliers
hold pin immobile and tighten nut using
wrench.



**NEWTON
CROUCH**

© 2023 Newton Crouch Co. Rev 7.18.2023 This information is the property of Newton Crouch Co. and is loaned confidentially to our customer for his sole use. It must not be used in any way detrimental to our interest or shared with outside parties. Technical Tips\Conveyor Chain Replacement

Step 14:
Trim off the end of the splice pin
flush with the nut.



Step 15:
Spot welding the nut onto the splice pin will ensure the chain is securely fastened together when under load.

When welding on a truck unit, batteries **MUST** be disconnected. Failure to do this may “blow” any electronics installed in your truck!!



Place a ground on the truck bumper



Completely remove wiring and
battery connections



Wear protective gear when welding



Completed weld



**NEWTON
CROUCH**

© 2023 Newton Crouch Co. Rev 7.18.2023 This information is the property of Newton Crouch Co. and is loaned confidentially to our customer for his sole use. It must not be used in any way detrimental to our interest or shared with outside parties. Technical Tips\Conveyor Chain Replacement

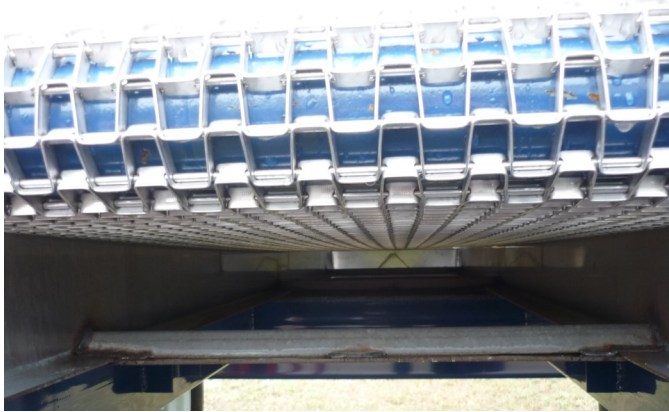


Step 16:

Push front roller into correct position. It should be 3 ½" from front of front roller bearing bracket. The lock nut should be tightened securely to prevent roller from sliding back.

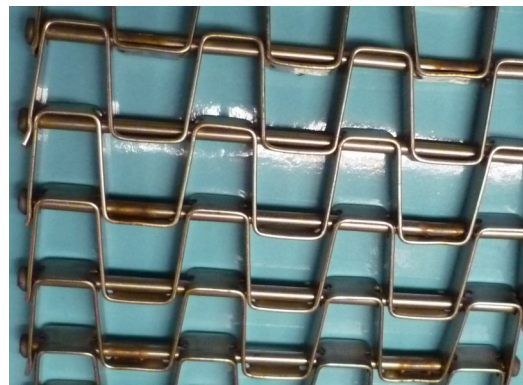


Looking under front roller at properly installed bed chain



Bed chain may sag slightly to one side. This is acceptable. DO NOT attempt to pull chain straight by inserting pin at an angle into chain. This will damage your conveyor!

Straight pin chain is welded every other link. When removing slack from conveyor, the chain cannot end on a welded link. If the correct length causes you to end on a welded link, you must cut the chain short. Using an extra splice pin, insert an extra loose link.



**NEWTON
CROUCH**

© 2023 Newton Crouch Co. Rev 7.18.2023 This information is the property of Newton Crouch Co. and is loaned confidentially to our customer for his sole use. It must not be used in any way detrimental to our interest or shared with outside parties. Technical Tips\Conveyor Chain Replacement