



## Centering Plates

### Installation Guide

1. Centering plates should be installed back from the end of the chute extension approximately three feet. This will allow centered material time to settle before leaving the chute area. If they are installed any further back it may cause undue wear on the skirtboard side.
2. Centering plates will be welded one on each side to the last piece of protector plate (wear liner) inside the chute. Use the following directions for each side.
3. It will be necessary to trim the back edge of the centering plate with a torch to obtain the proper angle so that the back edge will butt up against the protector plate for easy welding. To determine how much needs to be trimmed position the centering plate as follows: Start by butting the back edge of the centering plate against the protector plate. Pull the front edge away from the skirtboard side two inches and then tip the front edge down to a clearance of 1/8" off the belt. Measure the gap between the top edge of the centering plate and the top edge of the protector plate. Use this measurement and cut the back edge of the centering plate to the proper angle.
4. Position the back edge of the centering plate tight against the protector plate and pull the front edge away from the skirtboard side two inches. Check to make sure there is 1/8" clearance between front edge and conveyor belt. Tack weld the plate in place and double check measurements.
5. Insert at least a 2" x 4" x 1/4" piece of metal for a support brace between front edge of centering plate and skirtboard side and full weld in place. Finish welding seam between protector plate and centering plate.
6. Make sure that centering plates are installed parallel across from each other so that material is centered properly.

Note: These are typical installation guidelines and should be followed. However, these guidelines may have to be modified at times to allow for the variances in chute designs. Each job has to be examined to determine the appropriate installation guidelines.