



Chute Extension

Installation Guide

1. First you must lay out the location for the vertical support legs. The support legs are designed to be installed in the center of each chute section. This may vary due to obstructions such as conduit, beams, mechanical items, etc... If a change in spacing is required on one side and not the other, make the adjustment on both sides to remain consistent with the spacing on each side.
2. Once the layout for the support legs is complete, weld in place the vertical support leg brackets (3" x 3" X 6"). The brackets should be welded square to the side of the conveyor frame. Weld across both the top and bottom of the bracket as well as the side against the conveyor frame.
3. Attach the vertical support legs to the brackets that have been welded to the conveyor frame. The legs will attach using 1/2" bolts with flat washers and 1/2" nylock nuts. Leave the bolts only finger tight so that the legs may be adjusted.
4. Attach the horizontal support leg brackets to the upper part of the support legs. These brackets are also 3"x3"x6" and will attach using 1/2" bolts with flat washers and 1/2" nylock nuts. Also only tighten these finger tight so that they may also be adjusted.
5. Stand a chute extension side in place on each side of the conveyor at the tail end of the conveyor where the new chute extension will begin. Install a spreader bar at each end to get the correct spacing between the sides. The spreader bars should only be tacked in place.
6. With the spreader bars in place the section will need to be set in place. The chute extension sides should be approximately 2" off of the belt. If possible, try to also center the chute extension sections over the troughing idlers. This will help to keep the sealed area consistent along the conveyor for the skirtboard.
7. Now check that the vertical support legs and chute sides are centered over the belt. With the sides suspended or lifted in place you are ready to attach the support leg assemblies. Place the horizontal support leg braces flush against the side of the chute and weld on each 3" side. Once they are welded in place all fasteners can be tightened.

8. Each chute extension side has connection tabs at each end. These tabs allow you to bolt each new 4' or 5' section to the next. This will help to keep all sides flush and allow for easier installation of the Pos-A-Seal skirtboard and protector plate.
9. The chute extension lids are generally left off until the sides are all up and the protector plate has been installed inside the chute extension. Once this is done you can bolt the lids to the chute extension sides. This will help to square up the chute extension. Once all lids are on and fastened and any adjustments that may have been needed are done you can run a bead of silicone along the seams between the chute extension lids and sides and the seam between each of the lids.

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 conveyor designs. Each job has to be examined to determine the appropriate installation guidelines.