

MUNCH
MACHINE

Conveyor 4' – Right Conveyance
Conveyor 7' – Left Conveyance
Conveyor 7' – Right Conveyance
Models: CON-1204R, CON-1207L, CON-1207R

Operator's Manual

Please read the operator's manual and all included warnings carefully and make sure you fully understand the instructions before using the machine

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WARNING

The operation, servicing and cleaning of a conveyor product by MUNCH Machine is hazardous and could cause severe injuries or worse. These conveyors are solely intended to be used for the harvesting and processing of cannabis and no other purpose. Do not operate, service or clean these conveyors without proper training, reading the instructions and fully understanding all aspects of these activities on these conveyors and fully knowing the risks involved. Your failure to abide these warnings is negligence on your part. As warned, you **assume all risks** associated with the lack of proper use, in any manner, of the conveyor products covered by this instruction manual by MUNCH Machine.

1. **WARNING** – This product is a piece of power equipment that if used in ways other than described by this instruction manual can result in operator injury or even death
2. **WARNING** – All users need to fully read this instruction manual and familiarize themselves with the conveyors before operation
3. **WARNING** – Keep all shields, guards and safety devices installed and in proper working order at all times.
4. **WARNING** – Keep all hands, feet and clothing away from power driven parts.
5. **WARNING** – This conveyor is capable of pulling body parts, hair, clothing, gloves, etc. into the belt or drive systems. Use extreme caution to prevent unintended items from entering the belt or drive systems.
6. **WARNING** – Unexpected energization or startup of the equipment is controlled by unplugging the equipment from the energy source; the plug must be under the exclusive control of the employee performing the servicing or maintenance.

Introduction

Thank you for your purchase of a conveyance product built by MUNCH Machine. Welcome to the best bucking team around! Our products are designed around years of real-world use and optimized for maximum reliability and durability. Every product we bring to market is designed, tested and manufactured 100% in the USA.

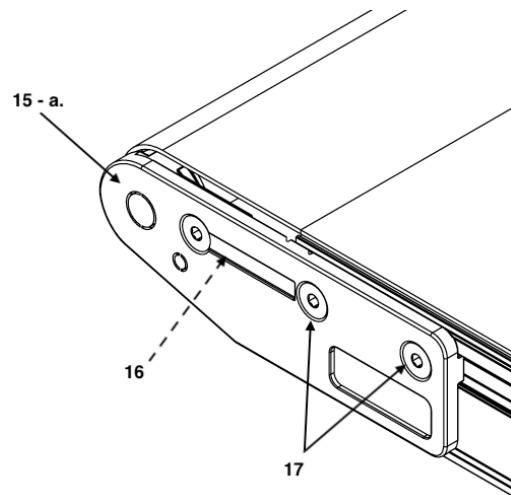
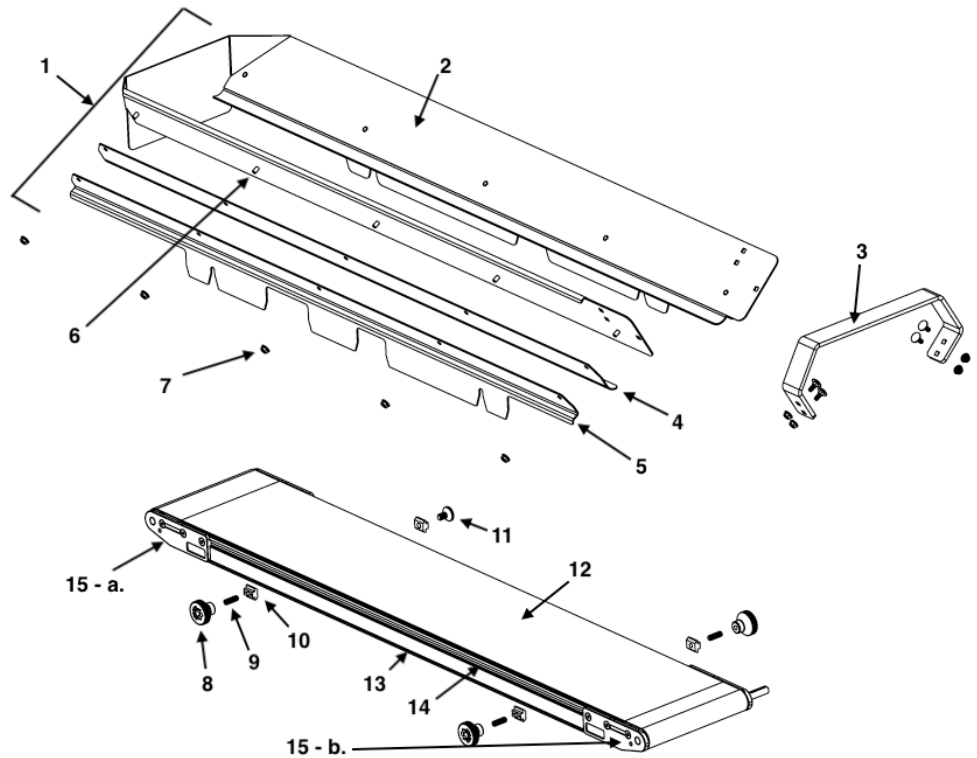
The Mother Bucker introduced mechanized bucking to the cannabis industry and remains the most powerful and reliable harvester on the market. We strive to take a different approach when building equipment for the cannabis industry. Our goals are to put the customer first when it comes to both sales and service. We maintain a close relationship with farmers to be sure we are offering the best products to improve efficiency and lower production costs.

Our parent company Dauenhauer Manufacturing has roots that go back 75+ years as pioneers of the first mechanical hops harvesting equipment. Dauenhauer continues to sell and service some of the top producers in the hops industry. We are proud of this heritage and committed to carrying this tradition forward with MUNCH Machine.

All persons operating these conveyors need to fully read this instruction manual and familiarize themselves with the conveyors before operation.

Machine Overview- *Models differ slightly, the overview may not exactly represent your conveyor, component names are the same.

1. Shield Assembly
2. Upper Shield
3. Over Nose Bar
4. Wipers
5. Lower Shields
6. M6 Stud
7. Serrated Flange Nut
8. Thumb Screw – Female
9. M8 Set Screw
10. M8 T-Nut
11. Shield Mount Peg
12. Conveyor Belt / Alligator Clip / Hinge Pin
13. Conveyor Frame
14. Conveyor Frame Channel
15. Head Plate –
 - a. Pinion Side
 - b. Drive Side
16. Belt Tension Adjustment Screw (2)
17. Belt Tension Set Screws (2)
18. Conveyor Mount Assembly
 - a. Mounting Brackets (2)
 - b. Pivot Brackets (2)
 - c. Pivot Bracket Channel
 - d. Conveyor Mount T Nut 30mm (4)
 - e. Conveyor Mount Spacer 30mm (4)
 - f. M8 Button Head Bolt
 - g. Machine Mounting Fasteners
 - h. 3/8" Flat Head (4)
 - i. 3/8" Split Washer (4)
 - j. 3/8" Hex Nut (4)
19. Pivot Thumb Screw – Male (2)
20. Pivot Thumb Screw Bushing
21. Motor
22. Coupler assembly
 - a. Conveyor Drive Shaft
 - b. Conveyor Cog
 - c. Spider

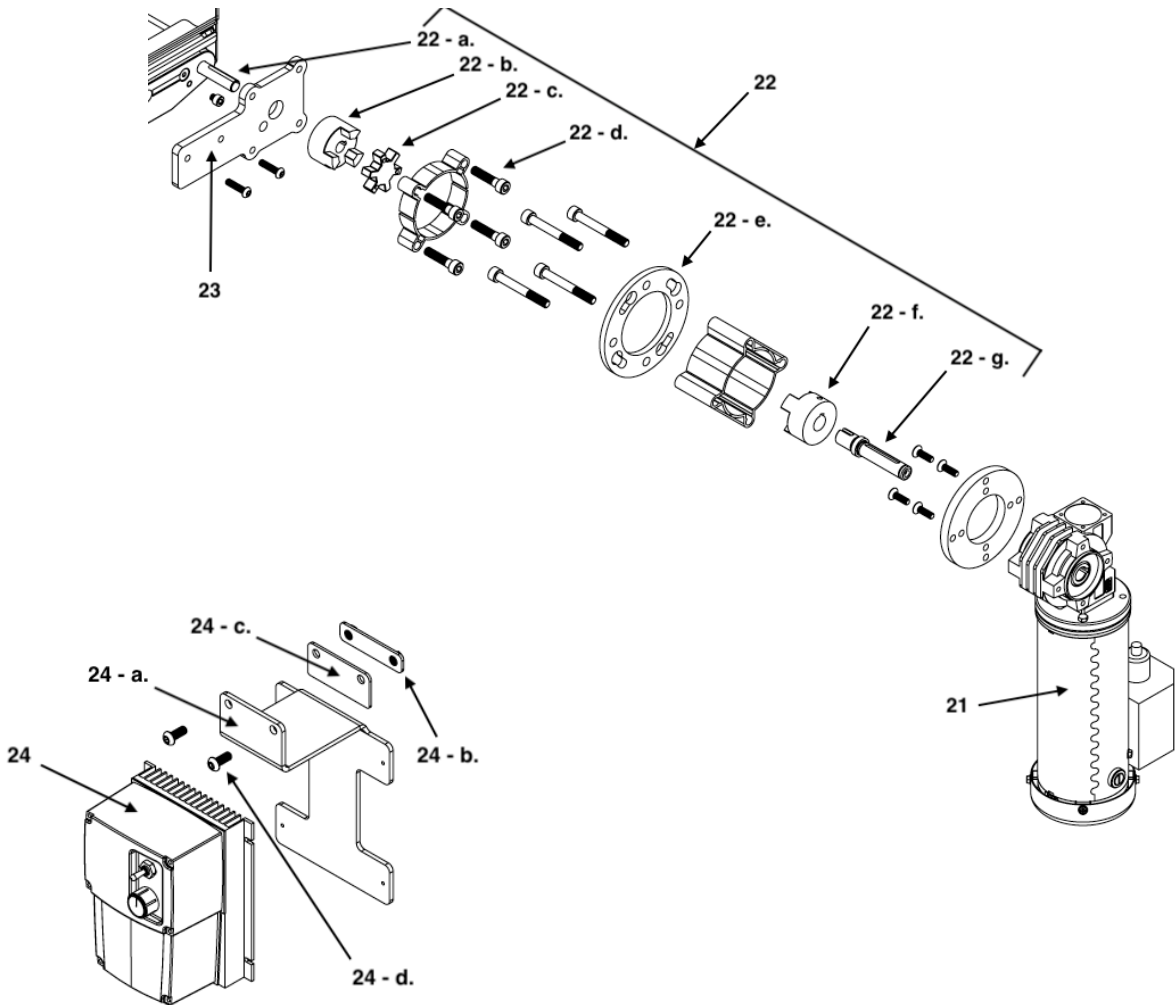
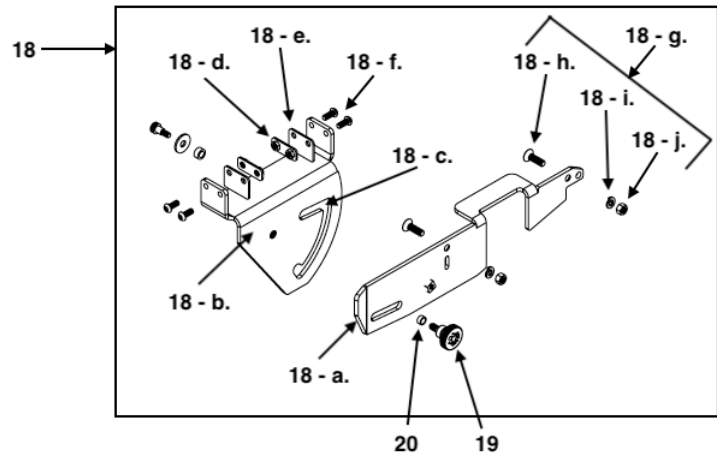


- d. M8 Coupling bolts (4)
- e. Keyhole Plate
- f. Motor Cog
- g. Motor Drive Shaft

23. Motor Mount Plate

24. Drive

- a. Drive Mount Bracket
- b. Drive mount T Nut 60mm
- c. Drive Mount Spacer 60mm
- d. M8 Button Head Bolt (2)



Operator Safety

Training

Operators must be properly trained in the correct use of these conveyors before taking part in any operation. It is up to the facility to determine guidelines based on these instructions for use. It is up to the organizations management structure to implement training programs, written procedures, and supervision that are compliant to local regulations.

Operation

- **WARNING** – This product is a piece of power equipment that if used in ways other than described by this instruction manual can result in operator injury or even death.
- **WARNING** – Keep all shields, guards and safety devices installed and in proper working order at all times.
- **WARNING** – Keep all hands, feet and clothing away from power driven parts.
- **WARNING** –These Conveyors are capable of pulling body parts, hair, clothing, gloves, etc. into power driven parts. Use extreme caution to prevent unintended items from entering any part of the conveyor.

All persons operating Conveyors need to fully read this instruction manual and familiarize themselves with the machine before operation. The Conveyor is designed to have 1-4 operators standing at the front allowing material to be transported directionally left or right away from the faceplate of the machine.

Installation

There is no need to fully unpack the crate prior to assembly, parts will be accessible from the crate as needed in assembly.

Installing Mounting Brackets:

Parts Needed:

Mount Bracket Assemblies (2)

Machine Mounting Fasteners:

3/8" Flat Head (4)

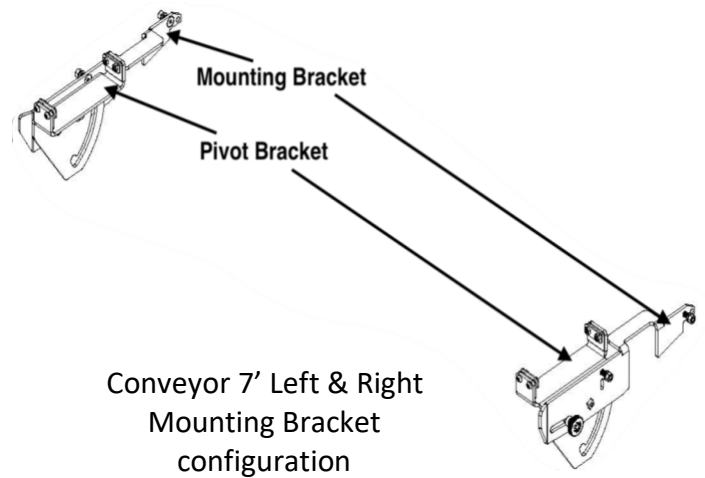
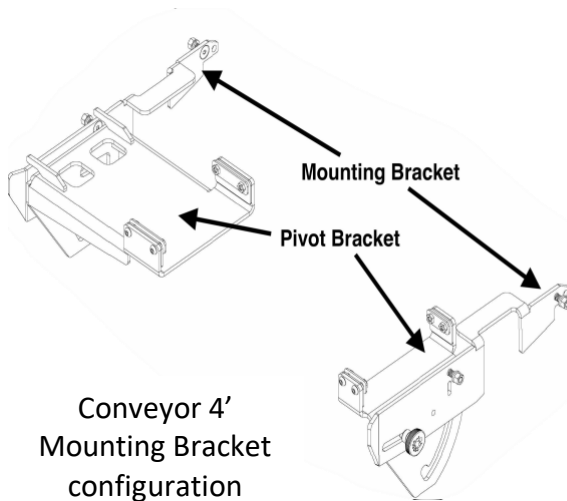
3/8" Split Washer (4)

3/8" Hex Nut (4)

1. Identify left and right orientation of the Mounting Bracket Assemblies. These assemblies are prebuilt with two main parts making up the assembly: The Mounting Bracket, and Pivot Bracket. The Mounting

Bracket will be oriented towards the outside of the machine and the Pivot Bracket will be located towards the inside of the machine on both left and right assemblies.

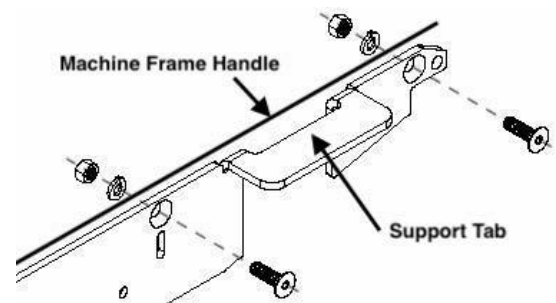
- The Conveyor 4' and Conveyors 7' have different left side Mounting Bracket Assemblies, the mounting process is the same.



2. Place the left Mounting Bracket Assembly onto the machine frame between the frame handle and motor assembly on the Mother Bucker, and between the frame handle and bucking head left on the Double Bucker. The Pivot Bracket should be towards the operator side of machine. The support tab located on the Mounting Bracket will sit on top of the machine frame and inside of the machine frame handle.

- **CAUTION** – Supporting the Mounting Bracket Assembly with one hand while installing the fasteners is crucial to prevent dropping the assembly and possibly causing injury.

3. Insert two of the 3/8" Flathead Bolts through the chamfered holes on the Mount Bracket. The 3/8" Flathead Bolts will align with and pass through two holes on the Machine Frame.



4. Install two of the - 3/8" Split Washers onto both the exposed threaded portion of the 3/8" Flat Head that passes through the frame. Install two of the 3/8" Hex Nuts and tighten to hand tight.

5. The right-side Mounting Bracket Assembly mirrors the left side assembly

6. With both left and right Mounting Brackets installed with all four fasteners hand tight, use a 9/16" socket or end wrench and a 7/32" Hex key to tighten nut until the Split washers are **pinched flat** between the nut and machine frame.

Installing the Conveyor

Parts Needed:

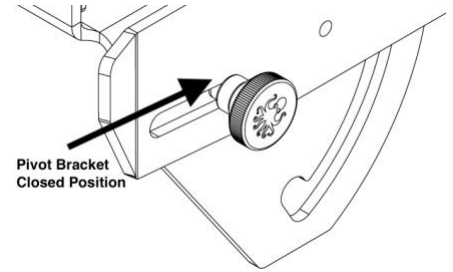
Spacers

Conveyor 4': 30mm (2), 60mm (2)

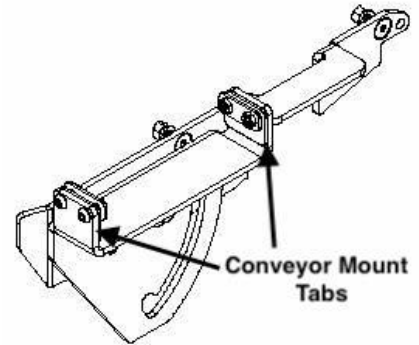
Conveyor 7' Left & Right: 30mm (4)

M8 Button Head Bolt (8)

1. Locate the Pivot Thumb Screw pre-installed on each Mount Bracket. Loosen the Pivot Thumb Screw **do not remove** and reposition the Pivot Bracket to the fully closed position. The Pivot Bracket should be as close to the machine as the adjustment slots will allow. Tighten the Pivot Thumb Screw to lock the Pivot Bracket into position.

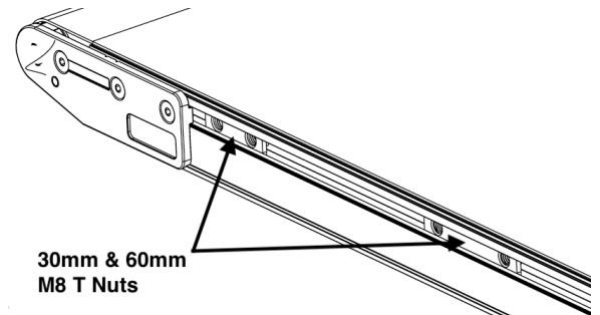


- **CAUTION** – Ensure that the Pivot Thumb Screw is hand tight prior to installing the conveyor. Failure to do so could allow for the conveyor to pivot possibly dropping the assembly and causing injury.



2. Locate the four Conveyor Mount Tabs, two are on each Mounting Bracket Assembly. Also locate the mounting hardware: four 30mm Spacers, and eight M8 Button Head Bolts. The 30mm M8 T Nuts are installed in the Conveyor Frame Side Channel.

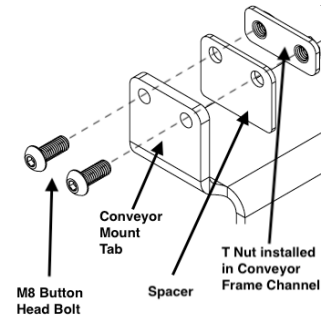
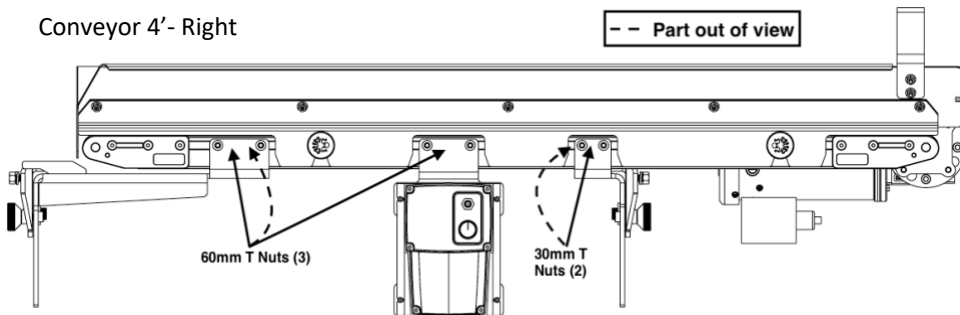
3. Conveyors will have multiple M8 T Nuts and Studs pre-installed within the Conveyor Frame Channel. M8 T Nuts have been taped in place; **Do not remove tape until later.**



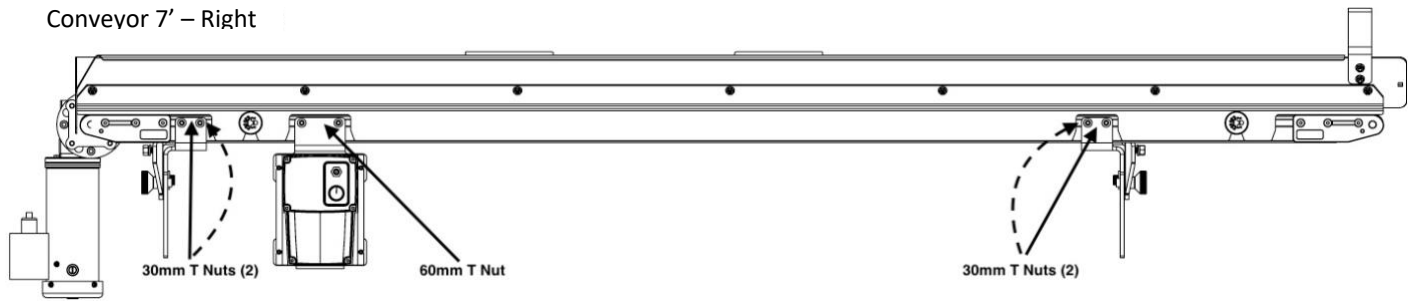
Identify the M8 T Nuts associated with the Conveyor 4' or Conveyor 7' Mounting tabs, these will be 30mm and 60mm M8 T Nuts within the Conveyor Frame Channel these have two threaded holes in each. The operator side of all conveyors will have one additional 60mm M8 T Nut, this will always be on the opposite side of the drive shaft.

Four of the M8 T Nuts installed within the Conveyor Frame Channel will align with the Conveyor Mount Tabs on each conveyor model as shown below:

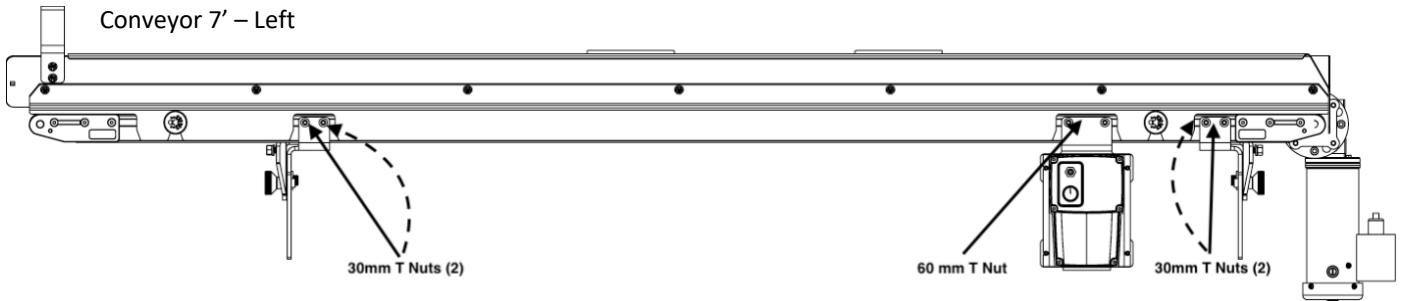
Conveyor 4'- Right



Conveyor 7' – Right



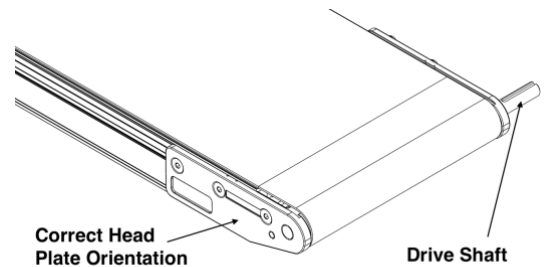
Conveyor 7' – Left



4. The Head Plate on the Conveyor has a flat top, the bottom of the Head Plate angles upwards (See Illustration below). Be sure the conveyor is lifted for installation in this orientation.
5. The best way to determine proper conveyor installation direction is to locate the Conveyor Drive Shaft. The Drive Shaft will be located towards the machine in all assemblies.

Drive Shaft orientation when installed:

- Conveyor 4' – right side of machine
- Conveyor 7' - Left – right side of machine
- Conveyor 7' - Right – left side of machine

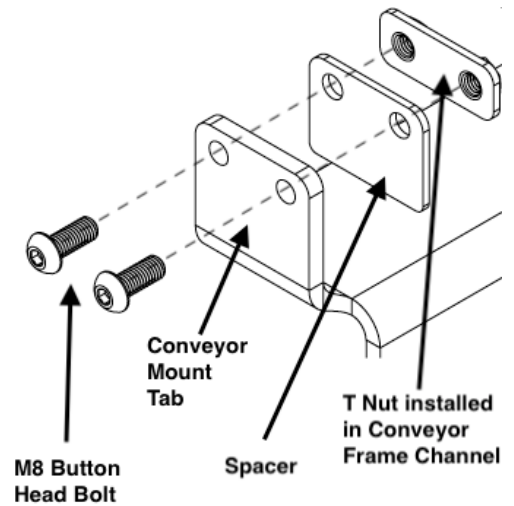


6. Carefully remove the Conveyor from the crate, picking it up on both ends. In some cases, this will require multiple people.
 - **CAUTION** – it is crucial to lift heavy equipment properly. Failure to do so could cause injury.
7. Set the conveyor onto the Mounting Bracket Assembly, between the Conveyor Mount Tabs.
 - **ATTENTION** - Ensure you have the correct Drive Shaft orientation.

Shift the conveyor left or right to align the Conveyor Mount Tabs with the four outermost taped 30mm or 60mm T Nuts within the Conveyor Frame Channel. Remove tape holding T Nuts in place.

- **CAUTION** – Continue to support conveyor until all fasteners are installed. Failure to do so could allow for the conveyor to fall causing injury.

Two M8 Button Head Bolts and one Spacer (30mm or 60mm) matching the width of the corresponding Conveyor Mount Tab will be installed. The Bolts will pass through the Conveyor Mount Tab, into the spacer then thread into the T Nut installed in the Conveyor Frame Channel - **Lightly Tighten**.



*On the Conveyor 7' – Right and Left configurations, only three of the Conveyor Mount Tabs will be accessible to install the fasteners. Installation of these fasteners happen in upcoming steps.

Installing the Shield Assembly

Parts Needed:

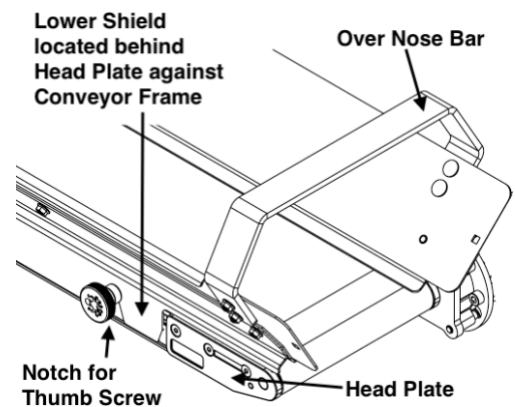
Shield Assembly

1. Loosen but **do not remove** the three Thumb Screws (female) that are installed on the Conveyor Frame. The Fourth attachment point for the Shield Assembly is a Mount Peg, no adjustment is needed for this part.
2. Loosen the Thumb Screws located on the Pivot Bracket (Mounting Bracket Assembly). Holding the conveyor frame squarely pull the entire conveyor away from the machine. Pull equally from the middle of the conveyor to prevent binding. Ensure that both Thumb Screw Bushings contact the forward most part of the Pivot Bracket Channel. **Do not let the conveyor tilt**, retighten the Pivot Bracket Thumb Screws with the Conveyor in the horizontal position.
 - **CAUTION** – Ensure that the Pivot Thumb Screw is tight securing the assembly from Pivoting. Failure to do so could allow for the conveyor to pivot possibly dropping the assembly and causing injury.

- Determine the correct installation position for the Shield Assembly:

Shield - Over Nose Bar orientation when installed:

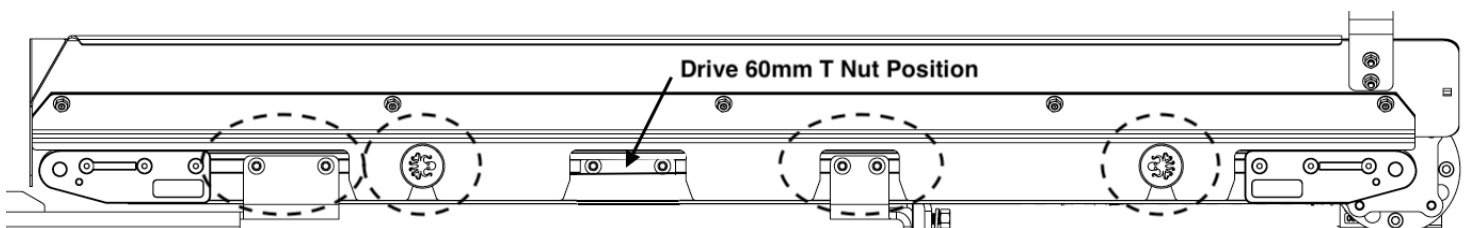
- Conveyor 4' – right side of machine
- Conveyor 7' - Left – left side of machine
- Conveyor 7' - Right – right side of machine



- Carefully remove the Shield Assembly from the crate, picking it up on both ends. In some cases, this will require multiple people.
- Holding the Shield above the conveyor, angle down the Over Nose Bar end so that it touches the conveyor before the rest of the Shield. Align both sides of the lower shield with the back of the Conveyor Head Plate, then guide the two Lower Shield edges over the outside of the Conveyor Frame. Notches should align with all Conveyor Mount Tabs and M8 Thumb Screw Studs.
 - **ATTENTION:** Be sure the Lower Shield sits in the neck of the Mount Peg contacting the Conveyor Frame, as well as the threaded portions of the M8 Thumb Screw Studs tight against the Conveyor Frame. The Thumb Screws will apply pressure and hold the Shield Assembly in place.

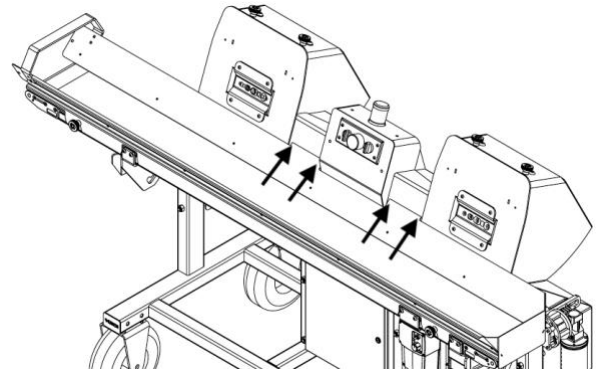
If the Lower Shield notches do not align with the Conveyor Mount Tabs preventing easy installation some adjustment of conveyor position may be necessary due to movement during shipping or adjustments to fit each machine. **Do Not Loosen the M8 Set Screw that hold the Thumb screws.**

- Slightly loosen the M8 Button Head Bolts, shift the position of the conveyor until the Conveyor Mount Tabs are close to centered within the Lower Shield notches, do not tighten the M8 Button Head Bolts and move to the next step.
- With the Shield Assembly sitting on the conveyor check that all Lower Shield notches have the Conveyor Mount Brackets within the cutout notch. The 60 mm Drive Mount T Nut for the Drive Mount Bracket should be visible within the middle Lower Shield notch.



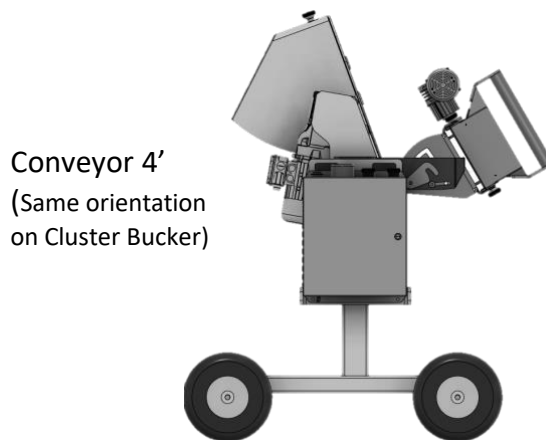
- Tighten the Thumb Screws holding the Shield to the Conveyor Frame.
- Loosen the Pivot Thumb Screw **do not remove** and slowly reposition the Conveyor Assembly to the operating position by pushing the Conveyor Frame/Lower Shield towards the machine Faceplate.

- **ATTENTION** - Conveyor 7' - Left and Right, while pushing the assembly in it will be necessary to shift the conveyor left or right to be sure the Shield Assembly aligns with the Faceplates and does not scratch or impact the Food Grade Powder Coating. (See Illustration)

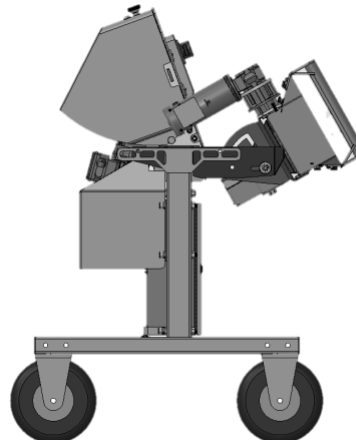


The Pivot Bracket should be as close to the machine as the adjustment slots will allow. The conveyor shield should be tight up against the faceplate of the machine. Tighten the Pivot Thumb Screw to lock the Pivot Bracket into position.

- **CAUTION** – Ensure that the Pivot Thumb Screw is hand tight prior to installing the conveyor. Failure to do so could allow for the conveyor to pivot possibly dropping the assembly and causing injury.
9. Double check that the Pivot Bracket is as close to the machine as the adjustment slots will allow. If not correct and retighten Thumb Screws.
 10. Tighten all accessible Conveyor Mount Bracket M8 Button Head Bolts to 4.5ft-lb (6Nm).
 11. Loosen the Pivot Thumb Screw **do not remove** and pull the assembly away from the machine and allow it to pivot down into the near vertical position. Tighten previously not accessible Conveyor Mount Bracket M8 Button Head Bolts to 4.5 ft-lb (6Nm).



Conveyor 4'
(Same orientation on Cluster Bucker)



Conveyor 7' –
Left & Right

12. Cycle the Conveyor from the horizontal position operating position to the pivoted position multiple times to be sure that the bearings are traveling smoothly. If you are feeling binding you may need to follow the additional steps below:
 - Starting from the Operating Position, loosen the Thumb Screws located on the Pivot Bracket, holding the conveyor frame squarely pull the entire conveyor away from the machine. Pull equally from the middle of the conveyor to prevent binding. Ensure that both Thumb Screw Bushings contact the forward most part of the Pivot Bracket Channel. **Do not let the conveyor tilt**, retighten the Pivot Bracket Thumb Screws with the Conveyor in the horizontal position.

- Loosen all Conveyor Mount Bracket M8 Button Head Bolts **do not remove** without moving the conveyor from its left to right position wiggle the conveyor slightly. And retighten all eight Conveyor Mount Bracket M8 Button Head Bolts to 4.5 ft-lb (6 Nm).
- Repeat as necessary until the conveyor moves smoothly from horizontal to pivoted without binding.

13. Pivot conveyor back to operating position and tighten Pivot Bracket Thumb Screws.

Installing the Drive Assembly

Parts Needed:

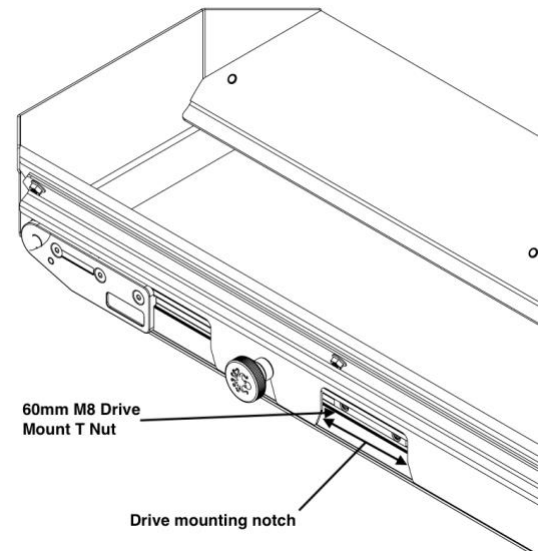
Drive / Drive Mount Bracket

Drive installation fasteners:

M8 Button Head (2)

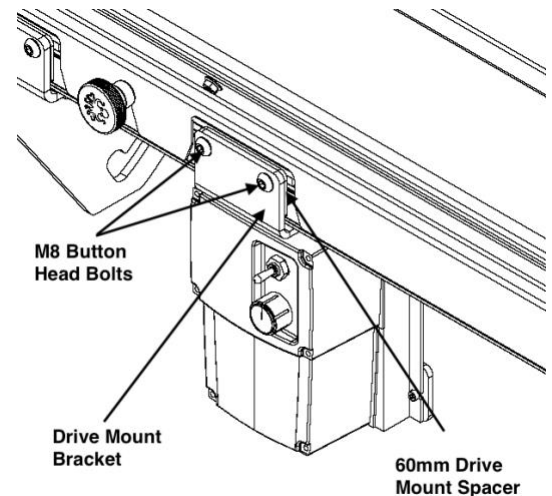
Drive Mount Spacer 60mm

1. Locate the Drive Mount Bracket mounting notch on the operator side of the Shield Assembly, position the 60mm M8 Drive Mount T Nut, pre-installed within the Conveyor Frame Channel, in the center of this slot.
 - If the 60mm M8 Drive Mount T Nut has shifted position it may be necessary to lift the Shield Assembly to slide this T Nut into position. If Shield is loosened, ensure thumb screws are tight before continuing.



2. Remove the Motor and Drive Assembly from the box, set the Motor on the ground below the conveyor in the center of the machine.

3. The Drive will have the Drive Mounting Bracket pre-installed. Using the two M8 Button Head Bolts, and 60mm Drive Mount Spacer mount the Drive Assembly to the Conveyor Frame. The Drive Mount Spacer should be located between the Drive Mount Bracket and the Conveyor Frame, the M8 Button Head Bolts will pass through both the bracket and Spacer to thread into the 60mm M8 Drive Mount T Nut. Center the Drive Mount Bracket within the Shield notch and tighten M8 Button Head Bolts to 4.5ft-lb (6 Nm).

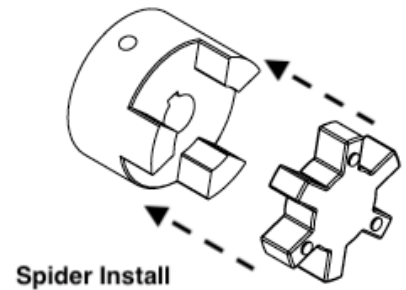


Installing the Motor

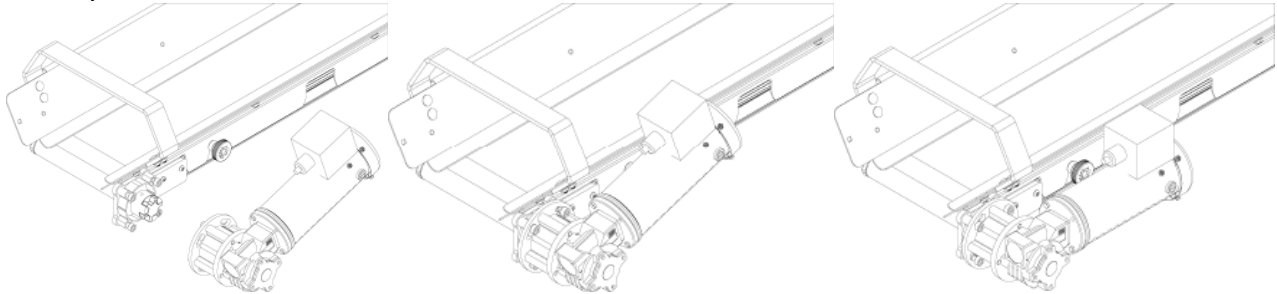
Parts Needed:

Motor Assembly
Spider Element

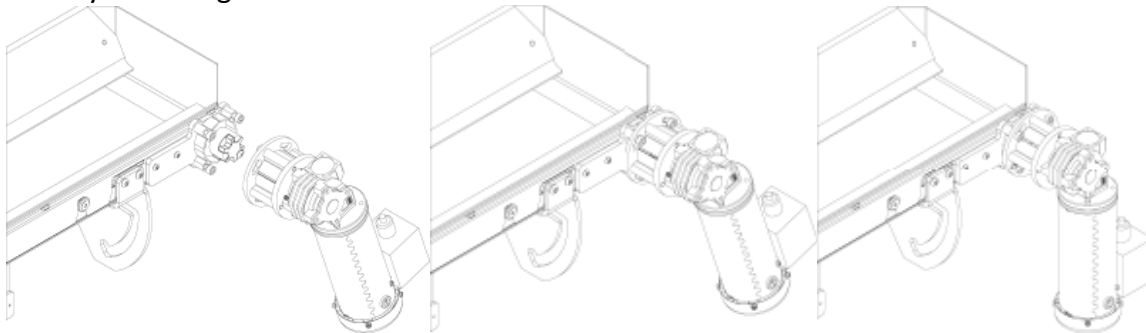
1. With the conveyor in the operating position with the Pivot Bracket Thumbs Screws tight securing the conveyor in place.
2. Find the Spider Element within the Motor & Drive parts box within the crate and install into the center of the Coupling Cog on the conveyor.
3. Passing the cord below the conveyor bring the motor up to the Drive Shaft on the back side of the conveyor. Installed on the motor assembly is a Keyhole Plate which will align with the four M8 Coupling Bolt heads surrounding the Coupler Cog on the conveyor. Proper Motor orientation is essential to operation, the Motor will rotate $\pm 20^\circ$ from unlocked to its locked position within the Keyhole Plate.



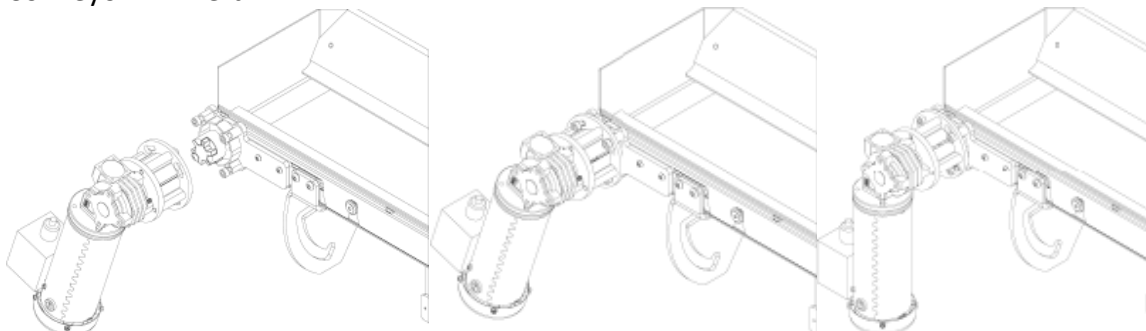
Conveyor Motor Installation: Conveyor 4'



Conveyor 7' – Right



Conveyor 7' – Left



Conveyors have different Motor orientations:

Motor Orientation – Once **locked** in place:

Conveyor 4' – horizontal, Parallel with conveyor frame

Conveyor 7' - Left – Vertical, perpendicular to conveyor

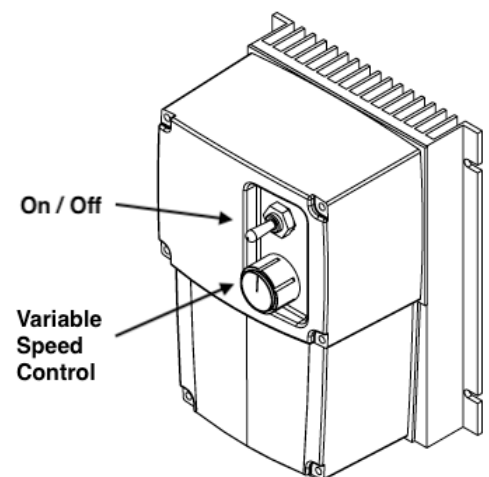
Conveyor 7' - Right – Vertical, perpendicular to conveyor

4. The Keyhole Plate will align with the four M8 Coupling Bolts surrounding the Coupler Cog on the conveyor.
 - **ATTENTION** – The M8 Coupling bolts have been set in place to the correct length and have had reusable thread locker applied to allow for easy installation, but these bolts must be tightened once assembly is complete and before use.
5. Pass all four M8 Coupling Bolt heads through the widest part of the keyhole and beyond the keyhole plate. The belt will need to be rolled to align the Coupler/ Spider for the assembly to fit together. Once the head of the bolt has cleared the Keyhole Plate Rotate the assembly 20° to the correct motor orientation (See Above).
6. Tighten the four M8 Coupling Bolts to 7.38 ft-lb (10 Nm)

Testing Conveyor Operation

- **WARNING** – Keep all shields, guards and safety devices installed and in proper working order at all times.
 - **WARNING** – Keep all hands, feet and clothing away from power driven parts.
 - **WARNING** – This conveyor is capable of pulling body parts, hair, clothing, gloves, etc. into the belt or drive systems. Use extreme caution to prevent unintended items from entering the belt or drive systems.
 - **WARNING** – Unexpected energization or startup of the equipment is controlled by unplugging the equipment from the energy source; the plug must be under the exclusive control of the employee performing the servicing or maintenance.
1. Plug Conveyor in to a circuit having sufficient current capacity and correct voltage.
 2. Adjust Variable Speed Control knob to the lowest setting.
 3. Turn Conveyor On.
 4. Adjust conveyor speed to desired speed. Ensure conveyor is operating properly.
 5. Turn off Conveyor, Conveyor is ready for operation.

If any questions arise during installation, please contact MUNCH Machine Customer Service.



Conveyor Controls

Drive

The Drive on a MUNCH Machine conveyor provides the user the ability to control power and speed to the conveyor.

The Drive is NEMA 4x Rated and provides protection from splashed water and hose directed water but should not be directly pressure washed. Do not open the Drive enclosure this will allow water intrusion and void the warranty.

The operating controls for this conveyor are made up of two switches the ON / OFF Switch and the Variable Speed Control Knob

Shielding

The Shield Assembly on a MUNCH Machine Conveyor protects the operator, while directing material to the end of the conveyor belt.

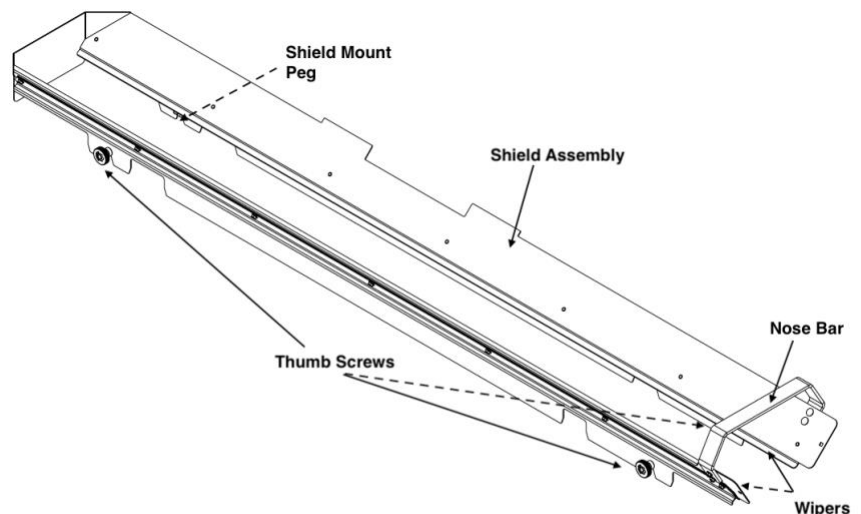
The Shield is made up of food-grade stainless steel, and FDA Approved Wiper material.

Shield Removal

1. Loosen the Thumb Screws located on the Pivot Bracket (Mounting Bracket Assembly). Pull the entire conveyor away from the machine. Pull equally from the middle of the conveyor to prevent binding. Retighten the Pivot Bracket Thumb Screws with the Conveyor in the horizontal position but pulled away from the machine.
2. Loosen but **do not remove** the three Thumb Screws (female) that are installed on the Conveyor Frame. The Fourth attachment point for the Shield Assembly is a Mount Peg, no adjustment is needed for this part.
3. Lift the Shield Assembly off the conveyor frame and set aside.
 - **ATTENTION:** Be sure the Shield Assembly is protected from damage when off the conveyor, if bent or deformed the shield can be challenging to reinstall.

Shield Installation

1. With the Conveyor in a horizontal position, ensure that the two Thumb Screws located on the Pivot Bracket (Mounting Bracket Assembly) are tight and securing the Conveyor Frame in position.
2. Loosen but **do not remove** the three Thumb Screws (female) that are installed on the Conveyor Frame. The Fourth attachment point for the Shield Assembly is a Mount Peg, no adjustment is needed for this part.



3. Holding the Shield above the conveyor, angle down the Nose Bar end so that it touches the conveyor before the rest of the Shield. Align both sides of the lower shield with the back of the Conveyor Head Plate, then guide the two Lower Shield edges over the outside of the Conveyor Frame. Notches should align with all Conveyor Mount Tabs and M8 Thumb Screw Studs.
 - **ATTENTION:** Be sure the Lower Shield sits in the neck of the Mount Peg as well as the threaded portions of the M8 Thumb Screw Studs tight against the Conveyor Frame. The Thumb Screws will apply pressure and hold the Shield Assembly in place.
4. Ensure Shield is resting on the Mount Peg, then tighten the three Thumb Screws to secure the Shield in place.

Wipers

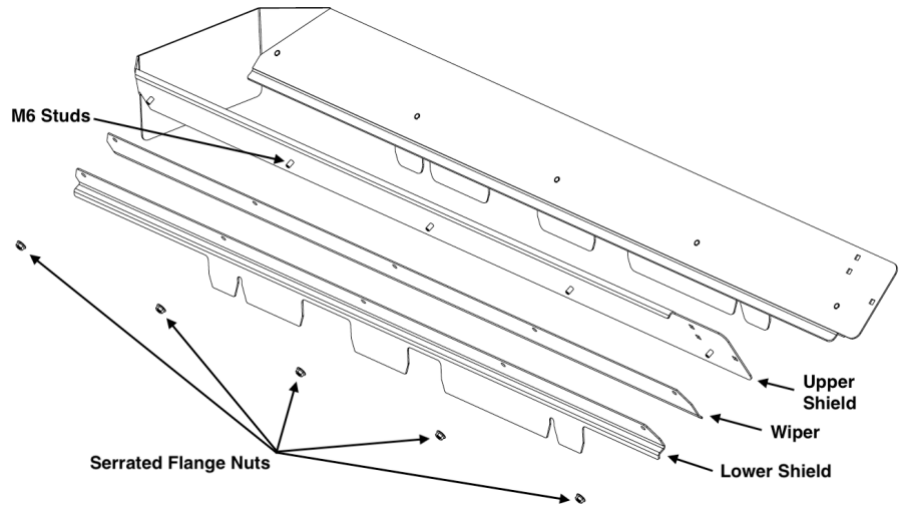
The Wipers direct product into the middle of the conveyor and ease the cleaning process, the Wipers are a wear-part, over time the wipers will need to be replaced to maintain proper function.

Wiper Removal

1. With the Shield Assembly removed from the machine and sitting on a flat surface remove the Serrated Flange Nuts located on the outside of the Shield Assembly.
 - **ATTENTION:** Ensure you pay attention to the Lower Shield and Wiper installation side and orientation. Parts are very similar from side to side, but different and will prevent proper assembly and installation if not reinstalled correctly.
2. The Lower Shield and Wipers will lift off of the M6 Studs.

Wiper Installation

1. Install Wiper on to Upper Shield M6 Studs, the wiper holes will be closer to the top surface of the wiper, the textured surface will be oriented towards the conveyor belt (facing the installer, for installation).
2. Install Lower Shield onto Upper Shield M6 Studs sandwiching the wiper.
3. Adjust wiper to have a consistent reveal along the top edge. Install the Serrated Flange Nuts and torque to 2.95 ft-lb (4 Nm).

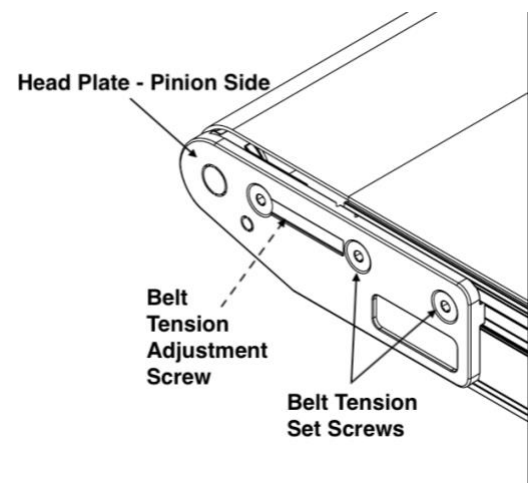


Conveyor Belts

The Conveyor Belts on all MUNCH Machine Conveyor products are food grade (FDA Approved) PVC, Conveyor Belts are built using a stainless-steel Alligator Clip lacing system and stainless-steel Hinge Pin to ensure easy cleaning and compliance. The Conveyor Belt is a wear-part and will need to be replaced with use. Conveyor Belts can be purchased through MUNCH Machine Customer Service.

Conveyor Belt Removal

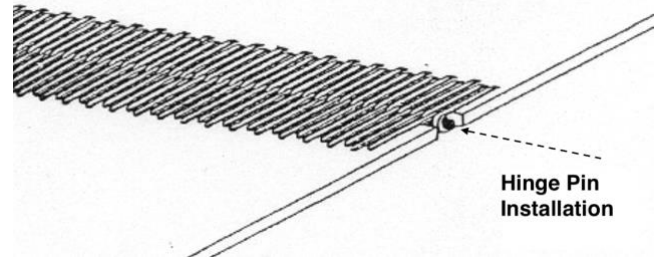
1. With the Conveyor in a horizontal position, pulled away from the machine, ensure that the two Thumb Screws located on the Pivot Bracket (Mounting Bracket Assembly) are tight and securing the Conveyor Frame in position.
2. Turn on the conveyor and run until the Alligator Clip Lacing is on the top surface of the conveyor for easy access.
3. Unplug the conveyor from its power source.
 - **WARNING** – Unexpected energization or startup of the equipment is controlled by unplugging the equipment from the energy source; the plug must be under the exclusive control of the employee performing the servicing or maintenance.
4. Remove the Shield Assembly and set aside.
5. Locate the Pinion side of the Conveyor Frame, located on the opposite end of the conveyor from the Motor.
6. On the pinion end of the Conveyor the Head Plate will have Two Belt Tension Set Screws on the Plate Surface, and one Additional Belt Tension Adjustment Screw located within the Head Plate Channel. Loosen **do not remove** the two Belt Tension Set Screws closest to the Conveyor Frame on both sides. This will release tension of the belt.
7. Apply pressure on the end of the conveyor belt to remove all Conveyor Belt tension.
8. While applying pressure lightly tighten the four (two each side) Belt Tension Set Screws to prevent the pinion system and Head Plates from falling out of the Conveyor Frame once the belt is removed.
9. Within the Alligator Clip Lacing there is a stainless-steel Hinge Pin that passes between the two sides of the conveyor lacing. Using your fingers or a pair of needle nose pliers slowly pull the Hinge Pin from the lacing. **Do not bend or deform the Hinge Pin.**
10. With the Hinge Pin removed grab one side of the Conveyor Belt and pull through the remaining length until the belt is free.



Conveyor Belt Installation

1. With tension removed from the Conveyor Frame (see Conveyor Belt Removal), and all Shielding removed.
2. Determine the top and bottom surface of the Conveyor Belt. The bottom surface will have a ridge that aligns with a channel on the Conveyor Frame. The top surface will be smooth.
3. Working clockwise, with the loose Conveyor Belt sitting on top of the Conveyor Frame feed the Conveyor Belt down between the Mounting Bracket and Conveyor Frame, across the bottom span, and up between the Conveyor Frame and Mounting Bracket on the other side. Be careful not to allow the loose end of the Conveyor Belt to fall and undo the work previously completed.
4. Bring the two Conveyor Belt ends together, one hand on each end and slide the conveyor belt back and forth to ensure smooth travel. The Ridge on the bottom of the Conveyor Belt should be seated within the channel on the Conveyor Frame, and Channels on the end rollers. The edges of the Conveyor Belt should seat within the highest and lowest edges of the Conveyor Frame sides.
5. After smooth travel of the belt is verified lay both ends together on the flat Conveyor Frame. This process is easiest in the middle of the conveyor span. The Alligator Clip needs to be aligned so that both edges of the conveyor are equal.

6. Insert the Hinge Pin from the operator side through the center channel of the aligned Alligator Clips pushing back towards the machine. The Hinge Pin will fit with equal spacing front and back within the width of the conveyor. If the Hinge Pin is bent or deformed please replace, additional Hinge Pins were included with the purchase, and are available through MUNCH Machine.

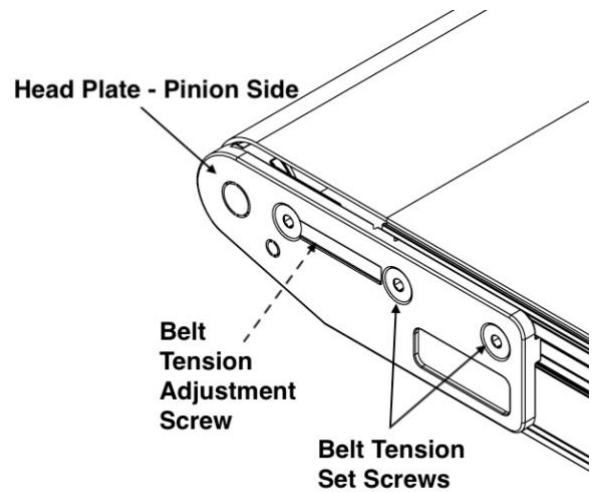


7. With the Hinge pin in place check again for proper alignment and smooth travel of the Conveyor Belt. The Conveyor Belt should not guide itself up onto the Conveyor Frame edges or work its way out of alignment in any direction. If the Conveyor Belt is out of alignment return to step 5 and repeat the process until the Conveyor Belt has smooth, straight travel.

Conveyor Belt Tension

1. With the Conveyor Belt Installed loosely around the Conveyor Frame and the Hinge Pin Installed.

2. Locate the pinion side of the Conveyor Frame, located on the opposite end of the conveyor from the Motor.
3. On the pinion end of the Conveyor the Head Plate will have two Belt Tension Set Screws on the Plate Surface, and one Belt Tension Adjustment Screw located within the Head Plate Channel. Be sure the the two Belt Tension Set Screws closest to the Conveyor Frame on both sides are loose.



4. Insert the 4mm hex key into the Belt Tension Adjustment Screw on one side of the Conveyor Frame. Have the correct size Hex key for the Belt Tension Set Screws easily accessible.
5. Apply 2.06 ft-lb (2.8 Nm) of torque to the Belt Tension Adjustment Screw, while holding this torque, tighten the two Belt Tension Set Screws on this side. Repeat this process for the other side.
6. By hand roll the Conveyor Belt to ensure proper alignment. If the Conveyor Belt is out of alignment return to step 5 and repeat the process until the Conveyor Belt has smooth, straight travel.
7. Reinstall the Shielding, and test for proper operation of the Conveyor.

Direct Contact Surfaces

The food-grade stainless steel Shield and food-grade Conveyor Belt and Wiper material are designed to be the only surfaces in contact with product and are compatible with a cGMP compliant workflow. Daily cleaning of these components with the proper cleaning products (See Cleaning) will reduce the potential for contamination of your product.

Machine Guarding

All guards and Shields must be in place before any operation of the Conveyor.

- **WARNING** – Operation of equipment without the proper guarding installed could result in serious injury and possibly death

Operation

Operation of this equipment should only be carried out by operators that have been fully trained in the proper use of this equipment, and that have read this manual in full.

Daily Start Up

- Plug equipment into appropriate power sources.
- Turn “ON” Bucking Equipment
- Turn “ON” Conveyor
- Adjust Variable Speed control Knob to appropriate setting

Daily Use

- Continuous monitoring of the machinery and outfeed of product is essential to safe operation of this machine.
- Adjustment of speed can protect final product quality

Daily Shut Down

- Turn Bucking Machine to “OFF” position.
- Turn Conveyor to “OFF” Position
- Unplug the machine.
- Clean the Conveyor
- Store Clean and Dry using the method described below.

Cleaning

This Conveyor will perform at its best when cleaned after each use. The Conveyor is built to wash-down rated specifications, but some precautions need to be adhered to.

Recommended cleaning materials

- Rubber gloves
- Stiff plastic bristle brush
- 70% rubbing alcohol, or citrus based cleaner, in a spray bottle
- **ATTENTION** - Do not use alcohol stronger than 70%. Anything higher will have an adverse effect on the components and cause premature breakdown. Use of high content alcohol will void the warranty.
- Clean, low-lint rags
- Plastic Scraper or application squeegee

With the Conveyor and Machine powered off, remove the Shielding. Cleaning can be done with the conveyor in the horizontal or tilted position. Use 70% alcohol in a spray bottle to spray down belt, Shield, Wipers and Conveyor Frame. Use a stiff bristle brush to scrub components. Cleaning the Conveyor Belt is easiest when tensioned on the conveyor frame. Use a stiff bristle brush to scrub the Conveyor Belt, then rotate the belt by hand and repeat with additional alcohol. Depending on the amount of use or material being transported it may be necessary to remove the Conveyor Belt to clean the underside of the Conveyor Belt and the Conveyor Frame thoroughly. Do the same for any debris on the motor, coupler assembly and Drive taking care to avoid spraying directly into electrical components. Once everything has been scrubbed down, apply 70% alcohol to a clean rag and wipe scrubbed components until clean.

Pressure Washers

The entire machine may be washed using water from a hose. A Pressure washer can be used to clean specific components. Do not direct a high-pressure stream at any electrical components, Drive, Control Buttons, Motor, Cables or Bearings.

- **ATTENTION** – Improper use of a pressure washer may cause damage to your conveyor. Avoid spraying directly into any electrical components, Drive, Control Buttons, Motor, Cables or the Bearings.

Use of a pressure washer is not recommended for daily cleaning of the machine. An annual deep clean with a pressure washer will keep the machine running properly, while not creating additional wear on the components.

- **ATTENTION** - Properly dry and protect and lubricate all components of the machine after using a pressure washer for cleaning.

Maintenance

General maintenance on the conveyor is minimal. The conveyor does have a few wear parts that the user needs to be aware of and maintain to keep the machine in good working order.

Coupler/Spider

The Spider within the coupler assembly is a wear component that reduces wear on the drive train components. This Nylon Spider should be removed and inspected prior to high use scenarios or inspected monthly in the event of perpetual harvest. With high wear the Spider should be replaced. Additional Spiders can be purchased from MUNCH Machine Customer Service. **It is recommended to keep a spare Spider on hand at all times.**

- **CAUTION** – Do not run the machine without a complete Coupler assembly.

Wipers

Wipers are a wear-part, over time the wipers will need to be replaced to maintain proper function. Additional conveyor specific Wipers can be purchased from MUNCH Machine Customer Service.

Conveyor Belts

The Conveyor Belt is a wear-part and will need to be replaced with use. Conveyor Belts can be purchased through MUNCH Machine Customer Service.

- **Belt Stretching**
Conveyor Belts will stretch over time, use of the pinion tensioning system can prolong use with Conveyor Belts that have experienced stretching. Refer to the Belt Tension portion of this manual for instructions on proper belt tension.
- **Belt Wear**
Use of the proper cleaning methods, and proper upkeep can keep a conveyor belt in good working order for a long time. Misuse or neglect can cause premature wear and deterioration. Conveyor Belts should be replaced with any signs of deep wear, groves, fraying, or any loss of material that could contaminate final product.

Compliance

Current Good Manufacturing Practices (cGMP) Compliance

MUNCH Machine Conveyance equipment supports compliance to cGMP requirements through the use of food grade materials for the portion of the machine that contacts the useable plant material. Detailed use

and cleaning instructions are provided with the equipment to assist plant growers and harvesters in developing their internal cGMP procedures.

Storage

This conveyor must be cleaned before storage and stored in a clean and dry environment. Issues arising from improper storage are not covered under warranty.

Limited Warranty

We warrant for 5 years from purchase date and only to the original buyer (Buyer) that our products (Products) are free from defects in material and workmanship. If Buyer discovers a defect, the Product will be repaired or replaced at our discretion. That is the extent of our liability and obligations under this Warranty and, upon expiration of the applicable warranty period, all such liability and obligations shall terminate. We reserve the right to require proof of purchase for all warranty claims.

WARRANTY EXCLUSIONS:

We do not warranty Products against normal wear and tear (such as rollers, belts, wipers, bearings, or coupler wear, etc.), unauthorized modifications or alterations, improper use, improper maintenance, accident, misuse, negligence, damage, or if the Product is used for a purpose for which it was not designed. This Warranty gives you specific rights, and you may also have other rights which vary from state to state. Except for expressly stated in this Warranty, we shall not be liable for direct, indirect, consequential, incidental, lost profits, lost revenue or failure to realize expected savings, as well other damages arising out of, or resulting from the/your choice to use and the use of the Product. This Warranty is in lieu of all other warranties, express or implied, including, but not limited to, implied warranties of fitness for a particular purpose (some states do not allow the exclusion or limitation of incidental or consequential damages or allow limitations on the duration of an implied warranty, so the above exclusions may not apply to you).

Customer Service

Phone:

541-371-2825

Email:

Info@MunchMachine.com

Mailing Address:

Frazer Industries, LLC

DBA: MUNCH Machine

PO Box 6764

Ketchum, ID 83340

Technical Specifications

Leeson Motor	D/C 1/4 hp 120V 1phase
Volts / Hz / Circuit / Amps	90 / 60 / 15A / 2.6
Torque - @ 250 rpm	46in-lbs
Speed Range	0-250 rpm
Listing	UL, CSA Certified
Rating	Wash guard Features
Motor Weight	13lbs
Motor Dimensions	13.16"Length x 3.43" width x 6.74" height

Drive	Adjustable speed DC Drive 120V
Volts / Hz / Circuit / Amps	90 / 60 / 15A / 1
Speed Range	0-10
Listing	UL/cUL Listed Equipment, file # E132235
Rating	NEMA 4x
Drive Dimensions	5.63" x 7.50" x 4.56"
Cord Length	32"
Plug Length	60"

Conveyor 4'	
Listing	CE, EMC, UL, CSA
Manufactured in accordance with	RoHS
Noise Level	70dB at full operating speed
Conveyance Direction	Right
Belt Material	PVC (FDA Approved)
Conveyance Length	48"
Total Length	51.5"
Conveyor Width	8.5"
Conveyor Belt Width	8"
Shield Width	13.2"
Maximum Conveyor Load	70 lbs
Bearings	Sealed for Life
Working height from Ground	38.3"
Bottom of conveyor to ground	32.8"
Conveyor only - Weight	28 lbs
Total conveyor weight (motor, drive, cords, shield, conveyor)	95.6 lbs
Shipped Weight	160 lbs
Shipping Container	62.5"Length x 22" Width x 16" Height
Tools required for operation	None
Tools required for Cleaning	4mm hex, 5mm hex (Belt removal and Tension Only)

Tools required for installation	6mm hex, 7/32" Hex, 9/16" wrench or Socket
Tools Included	4, 5, 6 mm hex keys
Conveyor 7'	
Listing	CE, EMC, UL, CSA
Manufactured in accordance with	RoHS
Noise Levels	70dB at full operating speed
Conveyance Direction	Left & Right
Belt Material	PVC (FDA Approved)
Conveyance Length	84"
Total Length	85.8"
Conveyor Width	8.5"
Conveyor Belt Width	8"
Shield Width	13.2"
Maximum conveyor Load	40 lbs
Bearings	Sealed for Life
Working height from Ground	41.7"
Bottom of conveyor to ground	36.1"
Conveyor only - Weight	40.1 lbs
Total conveyor weight: (motor, drive, cords, shield, conveyor)	114.1 lbs
Shipped Weight	200 lbs
Shipping container	92.5" Length x 22" Width x 16" Height
Tools required for operation	None
Tools required for Cleaning	4mm hex, 5mm hex (Belt removal and Tension Only)
Tools required for installation	6mm hex, 7/32" Hex, 9/16" wrench or Socket
Tools Included	4, 5, 6 mm hex keys