Syntron® Rotary Orienting Feeders
ROF-S and ROF-D Series

■ Installation ■ Operation ■ ■ Maintenance ■

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Thank you for buying your equipment from Homer City Automation. This service instruction manual will help you to understand how your equipment operates and what is required to maintain peak performance. Please read it thoroughly and keep it on file for reference.

Your satisfaction is very important to us. Please direct any comments, questions or concerns to our Marketing Communications Department.

Date Purchased:_____
Serial No._____
Factory Order No._____

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INTRODUCTION

The Syntron® Rotary Orienting Feeder features a rotating outer bowl and an inclined rotating disk for positioning and feeding parts. The bowl and disk turn at different speeds. On single drive models, speed relationships are adjustable to a limited degree through the use of adjustable drive belt sheaves. Dual drive models provide the ability to easily vary the speeds of the bowl and disk independently, giving greater versatility and feed rate capacity. The ROF-118 standard model has single-drive capability only; consult the factory if dual capabilities are desired. The ROF-123, 232 and 242 models are available in either single or dual drives. ROF-257 is available only in dual drive.

ROF Feeders operate by the centrifugal force of the rotating disk and bowl in combination with the friction of the disk on the parts. The part is raised from the bottom of the bowl by the friction of the part on the disk. The centrifugal action of the rotating disk and bowl projects the parts to the bowl flange, orientating the parts into a single line of feed.

An adjustable fence keeps the parts within the confines of the feeder. Special features that may be incorporated into the fence assembly provide for parts orientation and may be included in supplementary instructions.

SAFETY INSTRUCTIONS

Refer to this instruction manual prior to installing, adjusting or performing any maintenance on the ROF Feeders.

⚠ WARNING: Failure to follow these service instructions could result in personal injury, unsatisfactory performance, damage, or shortened service life.

LONG-TERM STORAGE

When received, carefully unpack the feeder and control. Remove all packing, bands, paper, etc. Inspect the feeder for damage that may have occurred during shipment. If damage is found, contact the shipping carrier and Homer City Automation at once.

It is advisable to store the equipment in its original shipping carton, in a clean dry storage area. Do not drop the feeder; the impact could cause damage. To avoid distortion of the drive belts while in storage, release the tension of the belts. Belt tension is discussed in the Belt Replacement instructions on page 7.

INSTALLATION

⚠ CAUTION: The feeder assembly should be lifted by the frame only.

When selecting a location for the feeder, consider the supporting structure. Select a support that will safely carry the full weight of the unit under loaded operating conditions (refer to Table 1).

TABLE 1: FEEDER WEIGHTS

MODEL	WEIGHT lbs	(kg)
ROF-118S	285	(129)
ROF-123S ROF-123D	375	(170)
ROF-232S ROF-232D	775	(352)
ROF-242S ROF-242D	1250	(567)
ROF-257D	1620	(736)

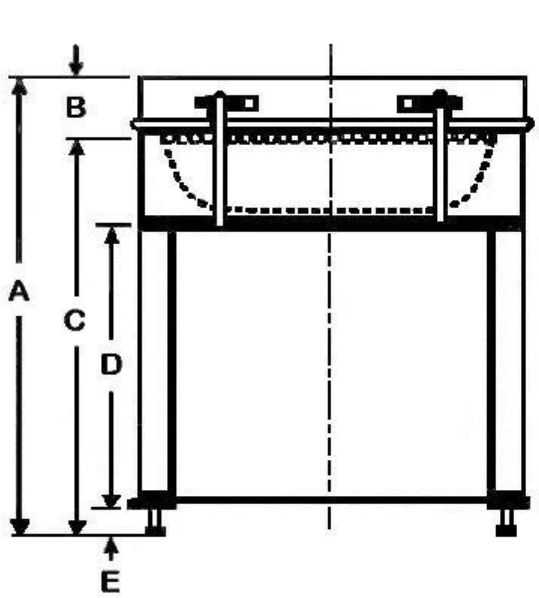
Prior to locating the feeder in its operating location, refer to Table 2 for dimensions.

⚠ CAUTION: Do not make any alterations to the feeder without first contacting Homer City Automation's Service Department. Unauthorized repairs will void the warranty.

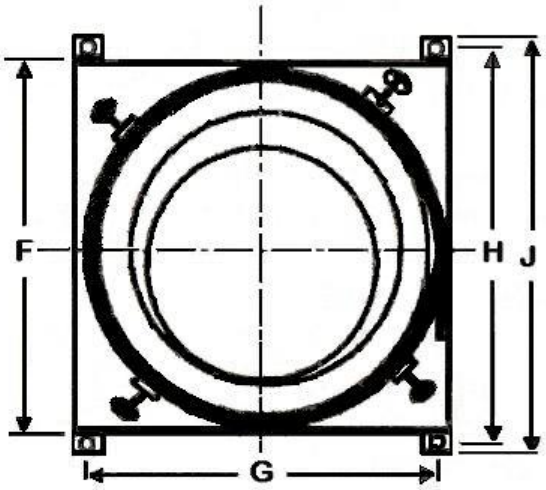
Alterations or additions to the feeder could reduce the capability of the feeder operation, or result in serious damage to the unit. Homer City Automation will not assume responsibility for feeder performance resulting from unauthorized alterations to the equipment.

Units equipped with air-operated orientation features require a regulated, dry air supply. This supply system should consist of an air filter, regulator, and air line. Unless otherwise specified, the air pressure supply at the manifold should always be set at 50 psi.

TABLE 2: OUTLINE DIMENSIONS



TOP VIEW



	ROF-118 Inch	ROF-123 Inch	ROF-232 Inch	ROF-242 Inch	ROF-257 Inch
A	Min: 26-1/8 Max: 27-1/4	Min: 26-1/8 Max: 27-1/4	Min: 37-7/16 Max: 38-7/8	Min: 37-7/16 Max: 38-7/8	Min: 41-13/16 Max: 43-1/4
B	Min: 3 Max: 3-3/8	Min: 3 Max: 3-3/8	Min: 4 Max: 3-3/8	Min: 4 Max: 3-3/8	Min: 6 Max: 6-7/16
C	Min: 23-1/8 Max: 23-7/8	Min: 23-1/8 Max: 23-7/8	Min: 33-7/16 Max: 34-7/16	Min: 33-7/16 Max: 34-7/16	Min: 33-13/16 Max: 35-1/4
D	12-3/4	12-3/4	17-3/8	17-3/8	17-1/2
E	Min: 3/4 Max: 1-1/2	Min: 3/4 Max: 1-1/2	Min: 7/8 Max: 1-7/8	Min: 7/8 Max: 1-7/8	Min: 7/8 Max: 1-7/8
F	23-1/4	28-1/2	40-1/2	50-1/2	70-1/2 Sq.
G	21	26-1/4	38-1/4	48-1/4	48-1/4
H	25-1/2	30-3/4	42-1/2	52-1/2	52-1/2
J	26-3/4	32	45	55	55

CONTROL INSTALLATION

Install the control on a wall, in a clean dry, well-ventilated location, as close to the feeder as possible. This will ensure prolonged component life.

WARNING: The electrical power supply connection to the Homer City Automation control must be made through a customer-supplied safety disconnect switch mounted next to the control. An emergency stop may be required, as per local codes.

The power supply voltage and frequency must meet the specifications on the nameplate. The line conductor and the conductor between the feeder and separate control must be of sufficient size to carry the current and voltage specified on the nameplate.

The wiring connections between the feeder, control, and power supply must be secure and in strict accordance with the wiring diagram supplied with the control.

WARNING: The equipment must be properly grounded.

OPERATION

WARNING: Before operating the equipment, the base covers, all guards, and the control must be in place and secured.

With the equipment properly installed in its operating location, all wiring completed, and the guard and covers in place, the equipment is now ready for operation.

Before starting the unit, check all bolts for tightness. Check the feeder support, making certain that it is substantial. Rotate the control knob counterclockwise to zero setting. Put the switch in the ON position, and gradually increase the control knob setting.

If the bowl and/or the disk are rotating in the wrong direction, turn the power off. Disconnect and lock out the power supply. At the control, remove the cover and disconnect and interchange the motor cable leads. Replace the control cover and connect the power to the feeder.

CAUTION: Under normal operating conditions, the bowl and disk should rotate in a smooth, quiet manner, and at a constant rate of speed. If there is excessive noise or if the operating speed is erratic, turn the unit off immediately. Refer to the Troubleshooting Guide on page 12.

Load the bowl with the parts to be conveyed. The quantity of parts loaded in the bowl should not interfere with the feed rate or orientation features of the bowl. Usually one layer of parts is satisfactory.

Adjust the control knob to the desired output. Clockwise rotation will increase the feed rate, while counterclockwise rotation will decrease it. The parts will move along the bowl in a smooth and controlled rate of feed toward the discharge. On dual drive units, adjust the disk control knob to a speed sufficient to move parts from the disk to the bowl.

Many units incorporate features such as special clips, rejectors, wipers, air jets, track modification etc., for positioning and orienting parts for specific applications. These devices, placed along the fence, are installed to exacting measurements.

Any damage or mechanical change to these features may hinder or stop the flow of parts or reduce orienting efficiency. These features are explained in separate instructions furnished with the unit.

FENCE ADJUSTMENT

Refer to the Parts Diagrams on pages 14 and 17. The fence adjustment features are normally used for initial setup of the fence relative to the bowl flange (D). In most cases, the fence should not be adjusted to fine tune orienting efficiency or to provide for multiple size part feeding. Internal tooling mounted to the fence is recommended. Spacers, adjustable walls, wipers, etc., should be mounted to the fence and should be individually adjustable if necessary.

The fence is normally set so that its inside diameter is the same as, or slightly smaller than, the outside diameter of the bowl. Repositioning the fence is accomplished by adjusting the fence carriage bolts (PP) in or out, or up and down in the fence support post slots (NN).

Vertical fence adjustment can be made by loosening one of the hex nuts that hold the carriage bolts to the fence support posts and sliding the carriage bolts up or down in the slot in each post.

During operation, the bowl flange must not contact the fence or any tooling features.

Slight horizontal adjustment of the fence can be performed by loosening either of the hex nuts at the fence support posts. To move the fence away from the center of the bowl, back off the hex nut nearest the end of each carriage bolt and turn the hex nuts on the opposite side of the posts in a counterclockwise direction. When the fence is in the proper location, tighten the hex nuts nearest the end of the carriage bolts. To move the fence towards the center of the bowl, back off the hex nut on the inside of each support post and turn the hex nut near the end of the bolt in a clockwise direction to move the fence. When the fence is in the proper location, tighten the hex nut on the inside of each post.

For significant horizontal adjustments, it may also be necessary to loosen the hex nuts that secure the carriage bolts to the fence (slotted brackets). Retighten the hex nuts after adjustment is complete.

For tooled units, adjusting the fence may require a readjustment of any tooling devices mounted to the fence. If difficulty is experienced in adjusting the fence and/or tooling, please contact Homer City Automation's Service Department.

MAINTENANCE

WARNING: Disconnect the power supply at the safety disconnect switch before performing any maintenance work.

ROF Feeders require minimum preventive maintenance. However, the following points should be given careful consideration:

Cleaning

All details of the feeder drive and control should be kept reasonably clean. Clean, dry compressed air is recommended for general cleaning of these units. Some materials stick to the bowl and disk surfaces. Material buildup on the bowl should be removed as often as required to maintain feeding efficiency. Look for material buildup particularly around and under the hopper openings and the discharge area of the feeder. A mild liquid detergent may be used to clean the urethane coating on the bowl and disk.

Lubrication

ROF Feeders contain prelubricated bearings (no grease fittings).

Reducer are factory lubricated so further lubrication is not necessary at initial startup. However, it is important that they are flushed and refilled with new oil after the first 100 hours of operation.

Drain out all oil and flush the gear case with an approved nonflammable, nontoxic solvent, and refill with new oil. Thereafter, the oil should be changed at least once every 2,500 operating hours or every 6 months, whichever occurs first. If the unit is operating in an extremely dirty environment or in high or low ambient temperatures, change the oil more often.

To lubricate, remove the base cover to gain access to the motor/reducer (Q). Unscrew the oil level plug from the side of the reducer and the breather from the top of the reducer. Add oil through the top hole until it starts to run out the side hole. Install the plugs securely.

The speed reducer must be lubricated with one of the recommended lubricants in Table 3.

TABLE 3: APPROVED LUBRICANTS FOR REDUCERS

Texaco	**-**	**Meropa No. 2**
Texaco	**-**	**650 Cylinder Oil**
American	**-**	**196L Cylinder Oil**
Gulf	**-**	**Senate 186**
Humble	**-**	**Cylesso TK-190**
Shell	**-**	**Valvata J82**
Mobil	**-**	**Super Cylinder 600W**
Chevron	**-**	**Gear Comp. 240**
Standard of Indiana	**-**	**Calument SH Cylinder Oil**
Standard of Ohio	**-**	**Sohicyl 650**
Hub City	**-**	**8-58-00-01-011**

For further information concerning reducers and motors, refer to the manufacturer's instructions.

BELT REPLACEMENT

WARNING: Disconnect the power supply at the safety disconnect switch before performing any maintenance work.

A worn or loose belt is evidenced by a reduction in feed rate, caused by the bowl and/or disk rotating at a slow speed. To replace or adjust the belt, refer to the Parts Diagrams on pages 14 and 17 as well as the appropriate belt replacement instructions.

BOWL DRIVE BELT REPLACEMENT

Single Drive Units

1. Remove the guards (E) from around the bowl (D) to gain access to the motor mounting slide. Remove the covers (N) from the frame (M) to gain access to the disk drive belt (AA) and the belt idler pulley (JJ).

2. At the motor mounting slide (MM), loosen, but do not remove, the four belts that hold the motor mount to the frame.

3. Turn the adjusting screw on the motor mount to move the motor/reducer (Q) towards the center of the frame to relieve belt tension.

4. To remove the belt, use needle-nose pliers to twist and push the ends of any two adjacent belt links back through the holes in the interlocking links.

5. Install the new belt.

   When releasing the tension on the bowl drive belt, the belt is also released on the disk drive belt. While adjusting the tension of the bowl drive belt, be sure that the disk drive belt is properly positioned on the three pulleys within the frame.

6. Turn the adjusting screw in the motor mounting slide to adjust the tension of the bowl drive belt. Tighten the four cap screws that secure the motor to the frame.

   If the disk drive belt tension needs adjusted, refer to the Belt Idler Adjustment instructions on page 9. Replace the covers and guards and reconnect the power. Run the parts feeder for one half-hour (while empty) to allow the belts to become seated on the sheaves. Check the belt tension and readjust if necessary.

The single unit bowl drive belt replacement is not complete.

Dual Drive Units

1. Remove the guards (E) from around the bowl (D) to gain access to the bowl motor mounting slide (MM). Remove the covers (N) from the frame (M) to gain access to the bottom belt (AA).

2. At the bowl motor mounting slide, loosen, but do not remove, the four belts that hold the motor mount to the frame.

3. Turn the adjusting screw on the motor mount to move the motor/reducer towards the center of the frame to relieve belt tension.

4. To remove the belt, use needle-nose pliers to twist and push the ends of any two adjacent belt links back through the holes in the interlocking links.

5. Install the new belt.

6. Turn the adjusting screw in the motor mounting slide to adjust the tension of the bowl drive belt. Tighten the four cap screws which secure the motor mount to the frame.

7. Replace the covers and the guards and reconnect the power. Run the parts feeder for one half-hour (while empty) to allow the belts to become seated on the sheaves. Check the belt tension and readjust if necessary.

The dual unit bowl drive belt replacement is now complete.

DISK DRIVE BELT REPLACEMENT

Single Drive Units

1. At the belt idler pulley (JJ), unhook the coil spring (GG) from the idler arm assembly (HH) and allow the pulley to move toward the center of the feeder assembly.

2. To remove the belt, use needle-nose pliers to twist and push the ends of any two adjacent belt links back through the holes in the interlocking links.

3. Install new belt.

4. At the belt idler assembly, replace the coil spring into the idler arm assembly. Adjust the tension according to the Belt Idler Adjustment instructions on page 9.

5. Replace the covers and the guards and reconnect the power. Run the parts feeder for one half-hour (while empty) to allow the belts to become seated on the sheaves. Check the belt tension and readjust if necessary.

The single disk drive belt replacement is now complete.

Dual Drive Units

1. Remove the guards (E) from around the bowl (D) to gain access to the bowl motor mounting slide (MM). Remove the covers (N) from the frame (M) to gain access to the bottom belt (AA).

2. At the bowl motor mounting slide, loosen, but do not remove, the four belts which hold the motor/reducer to the frame.

3. Turn the adjusting screw on the motor mount to move the motor/reducer towards the center of the frame to relieve belt tension.

4. To remove the belt, use needle-nose pliers to twist and push the ends of any two adjacent belt links back through the holes in the interlocking links.

5. Install the new belt.

6. Turn the adjusting screw in the motor mounting slide to adjust the tension of the belt. Tighten the four cap screws which secure the motor mount to the frame.

7. Replace the covers and the guards and reconnect the power. Run the parts feeder for one half-hour (while empty) to allow the belts to become seated on the sheaves. Check the belt tension and readjust if necessary.

The dual unit bowl drive belt replacement is now complete.

BELT IDLER REPLACEMENT

Perform the following steps to adjust the belt idler:

1. Remove the covers (N) from around the frame (M) in order to gain access to the belt idler assembly.

2. Loosen the hex nut (FF) that holds the cap screw (CC) in position, and release the spring tension. Do not remove the cap screw at this time.

3. While the spring (GG) is hooked around the cap screw (CC), pull the cap screw away from the center of the feeder, but only to the point where the spring coils begin to separate.

4. On the mounting bracket or base plate, mark the centerline of the cap screw while in this position. Release the tension of the coil spring and remove the spring from cap screw.\

5. From the mark, measure (toward the outside edge of the feeder) 13/16 inches for the ROF-118 and 123 drives, and 1-1/2 inches for the ROF-232, 242, and 257 drives. Move the cap screw to this point and securely tighten the hex nut.

6. Hook the loose end of the spring around the cap screw. The proper tension is now applied to the V-belt.

BEARING REPLACEMENT

Bearings used in the ROF Feeders are sealed, and the initial grease pack is usually good for the life of the bearing. However, if the bearings are worn, the disk and/or bowl will operate noisily and rotation will be erratic; in this case, the bearings may require replacement. Idler pulley bearings are not replaceable. If they become defective, it is necessary to replace the pulley.

Disk Support Bearings

Disk support bearings are press fit on the shaft. They can be reached by following the steps outlined in the replacement procedure below. Refer to the Parts Diagram on pages 14 and 17.

WARNING: Before performing any maintenance, disconnect the power supply at the safety disconnect switch.

1. Remove the covers (N) from the sides of the frame (M) and remove the hardware that secures the disk (B) to the shaft (U). Pull the disk from the shaft. Do not lose the key located in the shaft.

NOTE: For ease of reassembly, match-mark the position of the adjusting nut (Y) in relation to the shaft housing (T), and the shaft (U) in relation to the sheave (Z).

2. Remove the V-belt (AA) and the sheave (Z) from the bottom of the shaft.

2. Unscrew the disk-adjusting nut (Y) until it is free of the housing (T). When the adjusting nut is removed, the shaft can be drawn down from the housing.

3. Use retaining ring pliers to remove the retaining ring (X) that holds the bearing (W) to the adjusting nut. Remove the adjusting nut from the shaft assembly.

4. Remove the shaft and bearing assembly from the bottom of the housing.

5. Remove the bearings from the ends of the shaft.

6. Press new bearings onto the shaft and reassemble the feeder by reversing steps 1 through 5.

7. After replacement, a vertical adjustment of the disk is necessary. Clockwise rotation of the adjusting nut will raise the disk; counterclockwise rotation will lower the disk. The top edge of the disk must be even with, or just above, the rim of the bowl.

8. Replace all covers and reconnect the power. The feeder is now ready for operation.

Bowl Support Bearings

Bowl support bearings are press fit into the hub and slip fit onto the housing. They can be replaced by following the steps outlined in the replacement procedure below. Refer to the Parts Diagrams on pages 14 nd 17.

WARNING: Before performing any maintenance, disconnect the power supply at the safety disconnect switch.

CAUTION: Do not make any alterations to the feeder without first contacting Homer City Automation's Service Department. Unauthorized repairs will void the warranty.

1. Remove the fence (QQ) by loosening the hex nut nearest the end of the carriage bolt (PP) at the four fence support posts.

2. Remove the guard (E) by removing the four screws that hold it to the frame (M). Remove the covers (N) from the frame.

3. Remove the disk (B) and the bowl (D).

4. Remove the belt (K) from the hub (J).

5. Remove the clamping rings (F and G) from the hub, and pull the bearing (H) and hub assembly (J) from the housing (T).

6. Remove the bearing from the hub by tapping on the outer ring from underneath the housing. Replace with a new bearing.

7. Reassemble the feeder by reversing steps 1 through 6.

8. After reassembly is complete and the covers and guards are in place, reconnect the power supply to the feeder. The unit is now ready for operation.

TROUBLESHOOTING

PROBLEM	PROBABLE CAUSE	CORRECTIVE ACTION
Feeder operating below capacity (too slow)	Low voltage	Check power supply
	Loose bowl or disk	Tighten bowl and/or disk attachment hardware
	Loose or worn belts	* Adjust or replace
	Bowl or disk lining worn or damaged	* Repair or replace, as required
	Belts improperly tensioned	Refer to applicable belt replacement instructions
Feeder operating below capacity (sufficient speed, but feed rate too low)	Bowl overload or insufficient parts in bowl	A single layer of parts should be sufficient
	Bowl worn out	* Repair or replace, as required
	Tooling features out of position or missing	Adjust or add
	Air pressure at manifold (if supplied) improperly adjusted	Unless otherwise noted, air pressure at manifold should be 50 psi
	Bowl or disk dirty	Clean
Feeder fails to operate (no response)	Motor failure	* Replace
	Faulty control	* Replace or repair
	Short in electrical wiring	Repair
Feeder noisy; erratic motion	Worn bearings	* Replace
	Bowl rubbing fence or tooling	Adjust fence vertically or radially▲
	Loose bolts	Retorque or replace
	Control out of adjustment	Refer to instruction manual provided with control
	Belts loose or out of alignment	Refer to pages 7 through 10

* Replace only with parts supplied or recommended by Homer City Automation.

▲ Before adjusting fence, take note of critical feed tooling settings and adjust as required to maintain if the fence has been adjusted.

REPLACING SHEAVES AND BELTS

To determine correct replacement for sheaves and belts, proceed as follows:

1. Measure the outer diameter (OD) of the sheaves. Determine if the sheaves are adjustable or non-adjustable.

2. Count the number of links on the belt.

3. For ROF models 118S and 123S and D, select the correct part numbers from Table 4. For models 232S and D and 242S and D, select the correct part numbers from Table 5.

TABLE 4: SHEAVE AND BELT SELECTION, ROF MODELS 118S AND 123S AND D

BOWL DRIVE SHEAVE			DISK DRIVE SHEAVE			BOWL BELT			DISK BELT		
PART NO.	P.D. in (mm)	O.D. in (mm)	PART NO.	P.D. in (mm)	O.D. in (mm)	PART NO.	L in (mm)	No. of links	PART NO.	L in (mm)	No. of links
180X237	2.8-3.8 (71-97)	4.75 (121)	180X237	*2.8-3.8 (71-97)	4.75 (121)	211393-4	33 (838)	40	211393-1	26 (660)	31
180X239	4.0-5.0 (102-127)	5.35 (136)	180X239	*4.0-5.0 (102-127)	5.35 (136)	211393-5	34 (864)	41	211393-2	28 (711)	34
180X274	3.0 (76)	3.75 (95)	180X274	3.0 (76)	3.75 (95)	211393-6	36 (914)	43	211393-3	29 (737)	35
180X275	4.0 (102)	4.75 (121)	180X275	4.0 (102)	4.75 (121)	211393-7	35 (889)	42	211393-6	36 (914)	43
180X276	5.5 (140)	6.25 (159)	180X276	5.5 (140)	6.25 (159)						
			180X278	*5.2-6.2 (132-157)	6.55 (166)						

* Based on “A” Section Belt

TABLE 5: SHEAVE AND BELT SELECTION, ROF MODELS 232S AND D AND 242 S AND D, ROF-257-D

BOWL DRIVE SHEAVE			DISK DRIVE SHEAVE			BOWL BELT			DISK BELT		
PART NO.	P.D. in (mm)	O.D. in (mm)	PART NO.	P.D. in (mm)	O.D. in (mm)	PART NO.	L in (mm)	No. of links	PART NO.	L In (mm)	No. of links
180X275	4.4 (112)	4.75 (121)	180X275	4.4 (112)	4.75 (121)	211394-1	40 (1016)	42	211394-3	44 (1118)	47
180X276	5.9 (150)	6.25 (159)	180X276	5.9 (150)	6.25 (159)	211394-2	42 (1067)	45	211394-4	46 (1168)	49
180X277	7.4 (188)	7.75 (197)	180X277	7.4 (188)	7.75 (197)	211394-3	44 (1118)	47	211394-5	47 (1194)	50
			180X278	*5.5-6.5 (140-165)	6.55 (166)				211394-6	48 (1219)	51
			180X237	*3.1-4.1 (79-104)	4.15 (105)						
			180X239	*4.3-5.3 (109-135)	5.35 (136)						

* Based on “A” Section Belt

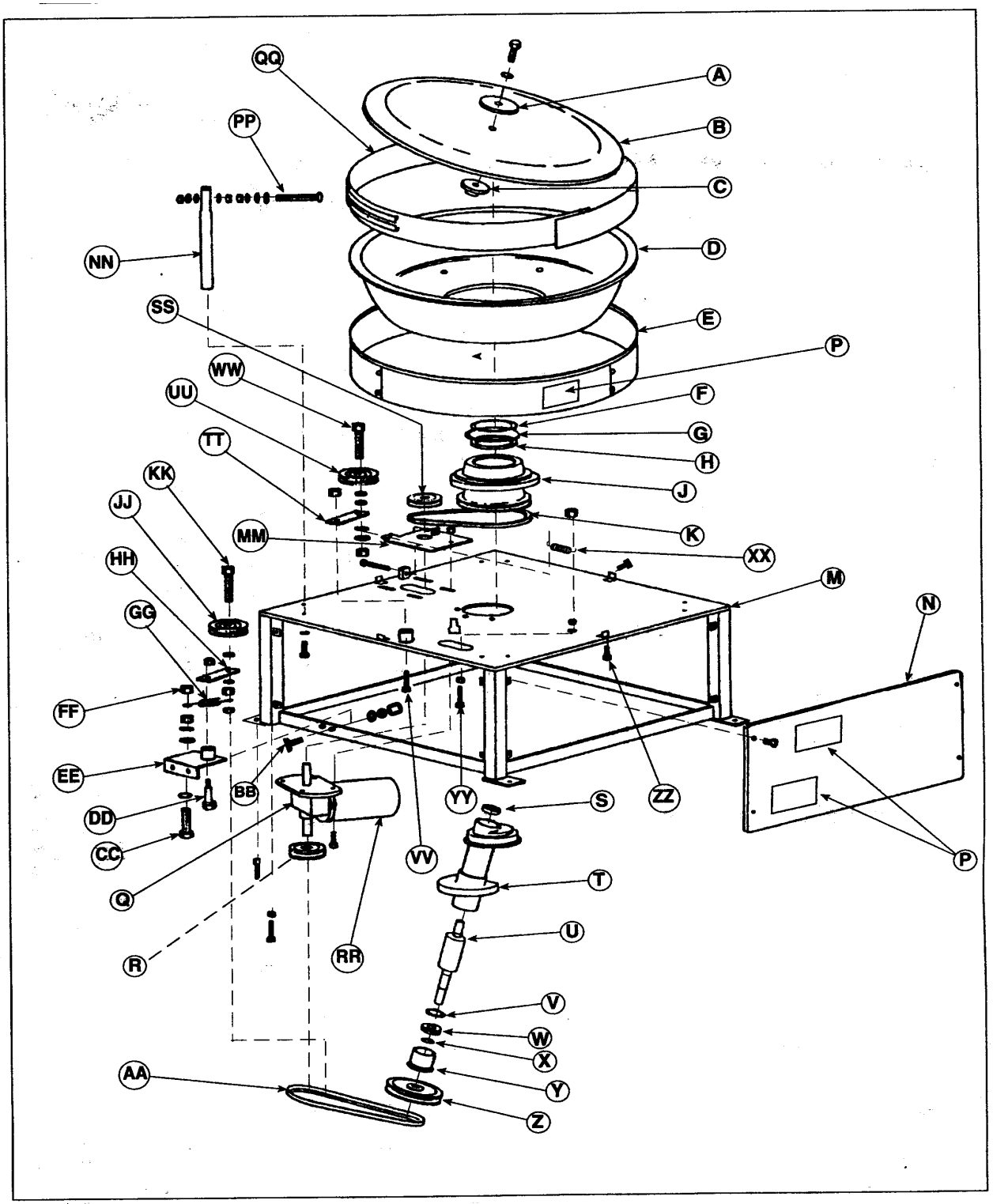


FIGURE 3: SINGLE DRIVE ROF FEEDER COMPONENTS

PARTS LIST – ROF 118S SINGLE DRIVE ROTARY PARTS FEEDER

Item	Description	Quantity	Part No.
A	Disk Clamp	1	B-208955-A
	Cap Screw, Hex Hd (3/8" – 16 x 1-1/2")	1	H0310603
	Lockwasher (3/8")	1	H0113210
B	Disk	1	D-208869-B
	Cap Screw, Hex Hd (3/8" – 16 x ¾")	4	H0310001
C	Disk Hub	1	A-187049-1
	Key	1	A-139112-BM
D	Bowl	1	D-187231-A
E	Guard	4	C-210884-B
	Mach Screw, Slot Hd (1/4" – 20 x 7/8")	8	H0205201
	Plainwasher (1/4")	8	H0116602
F	Clamp Ring, Housing (4-3/4" O.D.)	1	C-211931-1
G	Clamp Ring, Hub (6" O.D.)	1	C-211930-1
	Cap Screw, Hex Sock Hd (#10 – 32 x ½")	11	H0419600
	Lockwasher (#10)	11	H0112458
	Loctite (#271)	As Req'd	0185X006
H	Ball Bearing (4-1/2" Bore)	1	0031X180
J	Hub	1	C-186663-2
K	Belt (Bowl Drive)	1	See Table 4
M	Frame Assembly (CW)	1	D-213358-A
	Frame Assembly (CCW)	1	D-213359-A
	Cap Screw, Hex Hd (1/2" – 13 x 3-1/2")	4	H0335017
	Cap Screw, Hex Hd (1/2" – 13 x 2-3/4")	4	H0316201
	Hex Nut (1/2" – 13)	4	H0104001
N	Cover	3	C-208941-3
	Cover	1	C-208941-4
	Mach Screw, Slot Hd (1/4" – 20 x 7/8")	16	H0205201
	Plainwasher (1/4")	16	H0116602
	Fastener, Tinnerman, Type U (1/4" – 20)	16	H0118365
P	▲ Syntron Label	2	189525-D
	▲ Safety Label	1	125694
	▲ Safety Label	1	169336
	▲ Nameplate	1	198776
Q	Reducer, L.H. (30:1) (CW)]		C-201365-2
	Reducer, L.H. (15:1) (CW)]	1	C-201365-1
	Reducer, R.H. (30:1) (CCW)]	Only	C-201365-4
	Reducer, R.H. (15:1) (CCW)]		C-201365-3
	Cap Screw, Hex Hd (5/16" – 18 x 1-3/4")	4	H0307601
	Locknut w/ Nylon Insert (5/16" – 18)	4	H2100915
R	Sheave (Disk Driver)	1	See Table 4
	Key	1	A-139112-AZ
S	Bearing Med. Series (.787" Bore)	1	0031X181
T	Housing	1	D-186662-2
	Set Screw, Br Tip (3/8" – 16 x ½")	1	0034X077
U	Disk Shaft	1	B-187029-1
V	Retaining Ring (1.85" Dia.)	1	0175X130
W	Bearing, Lt. Series (.787" Bore)	1	0031X182
X	Retaining Ring (.781" Dia.)	1	0175X010
Y	Disk Adjusting Nut	1	B-187046-1
Z	Sheave, Disk Driver (4.8" P.D.)	1	0180X249
	Bushings, P (11/16" Bore)	1	0182X092
	Key	1	A-139112-AZ

PARTS LIST – ROF 118S SINGLE DRIVE ROTARY PARTS FEEDER (cont'd)

Item	Description	Quantity	Part No.
AA	Belt (Disk Driver)	1	See Table
BB	Cap Screw, Hex Hd (3/8" – 16 x 1-1/4")	2	H0310301
	Plainwasher (3/8")	2	H0117012
	Lockwasher (3/8")	2	H0113201
	Hex Nut (3/8" – 16)	2	H0113001
CC	Cap Screw, Hex Hd, Gr 5 (3/8" – 16 x 1-1/4")	2	H0310309
	Plainwasher (3/8")	4	H0117001
	Lockwasher (3/8")	2	H0113201
	Hex Nut (3/8" – 16)	2	H0103001
DD	Disk Idler Adjustment, Shoulder Screw (3/8" – 1-1/4")	1	H04134004
	Bowl Idler Adjustment, Shoulder Screw (3/8" – 1")	1	H0420400
EE	Idler Mounting Bracket Assembly (CW)	1	B-213391-C
	Idler Mounting Bracket Assembly (CCW)	Only	B-213391-A
FF	Lock Nut, EXNA, Lt Thin (3/8" – 16)	2	H2109564
GG	Extension Spring	1	A-187327-1
HH	Idler Arm	1	A-187294-1
JJ	Idler Pulley	2	0180X0226
KK	Cap Screw, Hex Hd, Gr 5 (3/8" – 16 x 2")	2	H0321410
	Plainwasher (3/8")	2	H0117012
	Lockwasher (3/8")	2	H0113201
NN	Fence Support Post	4	B-208989-1
	Plainwasher (1/2")	4	H0117304
	Cap Screw, Hex Hd (1/2" – 13 x 1-1/4")	4	H0315201
PP	Carriage Bolt (3/8" – 16 x 3-1/2")	4	H0512907
	Plainwasher (1/2")	4	H0117304
	Plainwasher, S.S. (3/8")	4	H0117012
	Lockwasher, S.S. (3/8")	8	H0113210
	Plainwasher, S.S. (3/8")	8	H0117004
	Hex Nut, SS (3/8" – 16)	12	H0113002
	End Cap	4	188X021
QQ	Fence	1	-----
RR	Motor and Cable Assembly	1	C-194192-A
SS	Sheave (Bowl Driver)	1	See Table 4
	Key	1	A-139112-AZ
TT	Idler Arm	1	A-213393-1
UU	Idler Pulley	1	180X226
VV	Shoulder Screw (3/8" x 1)	1	H0420400
	Hex Nut (5/16" – 18)	1	H0102401
WW	Hex Hd Cap Screw (3/8" – 16 x 2")	1	H0321410
	Plainwasher (3/8")	2	H0117012
	Lockwasher (3/8")	1	H0113201
	Hex Nut (38" – 16)	1	H0103001
	Lock Nut (3/8" – 16)	1	H2109564
XX*	Extension Spring	1	A-187327-1
YY*	Hex Hd Cap Screw (3/8" – 16 x 1-1/4")	1	H0310309
	Plainwasher (3/8")	2	H0117001
	Hex Nut (3/8" – 16)	1	H0103001
	Lock Nut (3/8" – 16, Lt.)	1	H2109564
ZZ*	Guard Clip	4	A-208877-A
	Cap Screw, Hex Soc Hd (1/4" – 20 x 7/8")	4	H0449300
	Machine Screw, Slotted Rd Hd (1/4" – 20 x 7/8")	4	H0205201
	Plainwasher (1/4")	4	H0116602

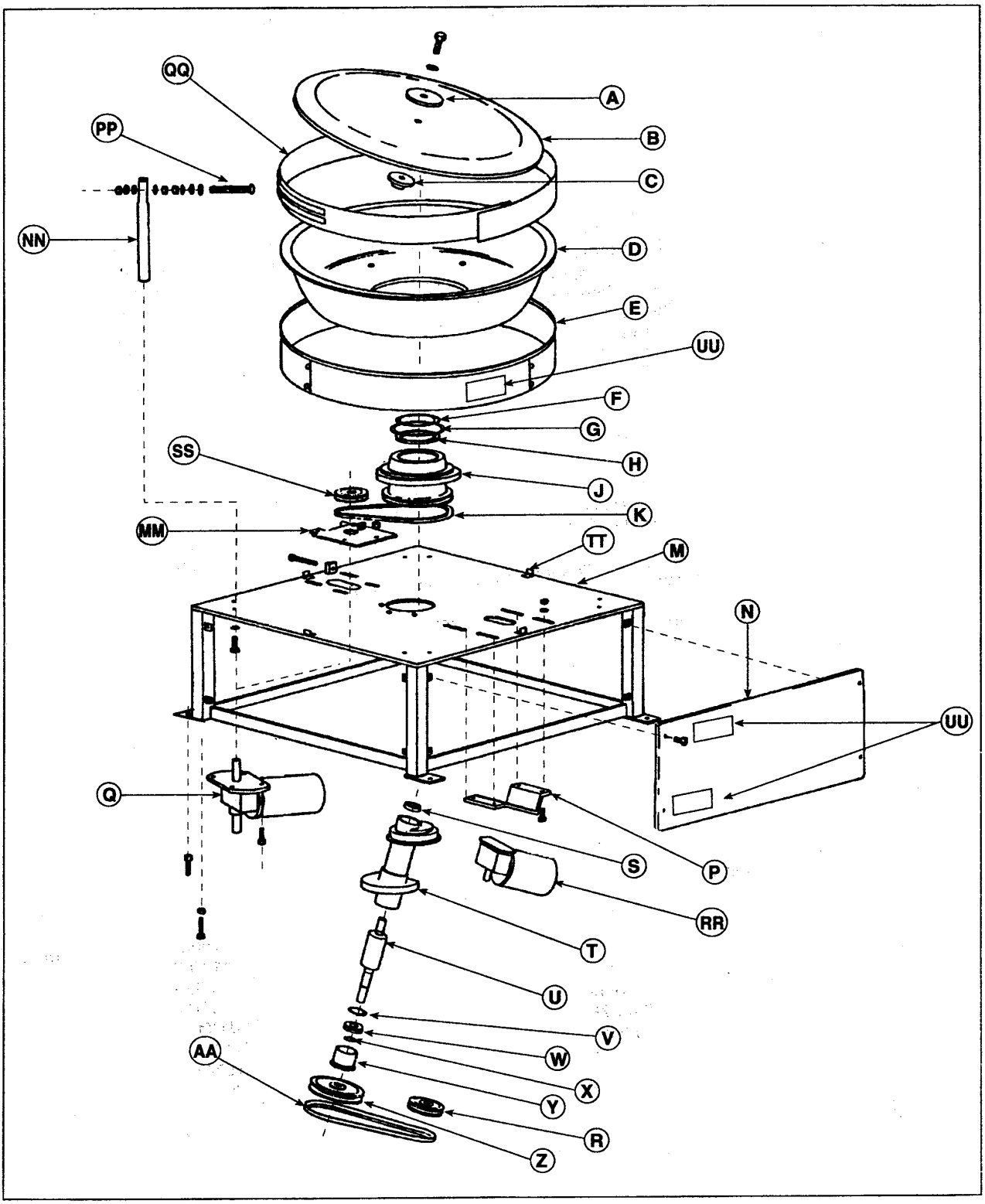


FIGURE 4: DUAL DRIVE ROF FEEDER COMPONENTS (ROF-123D, 232S AND D AND 242S AND D)

PARTS LIST – ROF-123S and ROF-123D ROTARY PARTS FEEDERS

Item	Description	Quantity	Part No. SINGLE DRIVE	Part No. DUAL DRIVE
A	Disk Clamp	1	B-208955-A	B-208955-A
	Cap Screw, Hex Hd (3/8" – 16 x 1-1/2")	1	H0310603	H0310603
	Lockwasher (3/8") SS	1	H0113210	H0113210
B	Disk	1	D-208869-D	D-208869-D
	Cap Screw, Hex Hd (3/8" – 16 x 3/4")	4	H0310001	H0310001
C	Disk Hub	1	A-187049-2	A-187049-2
	Key	1	A-139112-BM	A-139112-BM
D	Bowl	1	D-187639-A	D-187639-A
E	Guard	4	C-210884-A	C-210884-A
	Mach Screw, Slot Hd (1/4" – 20 x 7/8")	8	H0205201	H0205201
	Plainwasher (1/4")	8	H0116602	H0116602
F	Clamp Ring, Housing (4-3/4" O.D.)	1	C-211931-1	C-211931-1
G	Clamp Ring, Hub (6" O.D.)	1	C-211930-1	C-211930-1
	Cap Screw, Hex Soc Hd (#10 – 32 x 1/2")	11	H0419600	H0419600
	Lockwasher (#10)	11	H0112458	H0112458
	Loctite (#271)	As Req'd	0185X006	0185X006
H	Ball Bearing (4-1/2" Bore)	1	0031X180	0031X180
J	Hub	1	C-186663-3	C-186663-3
K	Belt (Bowl Driver)	1	See Table 4	See Table 4
M	Frame Assembly (CW)]	1	D-211024-A	D-208970-A
	Frame Assembly (CCW)]	Only	D-211023-A	D-208970-A
	Cap Screw, Hex Hd (1/2" – 13 x 2-1/2")	4	H0335017	H0335017
	Cap Screw, Hex Hd (1/2" – 13 x 2-3/4")	4	H0316201	H0316201
	Hex Nut (1/2" – 13)	4	H0104001	H0104001
N	Cover	3	C-208941-1	C-208941-1
	Machine Screw, Slot Hd (1/4" – 20 x 7/8")	16	H0205201	H0205201
	Plainwasher (1/4")	16	H0116602	H0116602
	Fastener, Tinnerman Type U (1/4" – 20)	16	H0118365	H0118365
P	Reducer Mounting Bracket	1	-----	D-211375-A
	Cap Screw, Hex Hd (5/16" – 18)	4	-----	H0307601
	Plainwasher (5/16")	4	-----	H0116801
	Lock Nut w/ Nylon Insert (5/16" – 18)	8	-----	H2100915
Q	Reducer, L.H. (CW) 30:1]		C-201365-2	C-201365-2
	Reducer, L.H. (CW) 15:1]	1	C-201365-1	C-201365-1
	Reducer, L.H. (CCW) 30:1]	Only	C-201365-4	C-201365-4
	Reducer, L.H. (CCW) 15:1]		C-201365-3	C-201365-3
	Cap Screw, Hex Hd (5/16" – 18 x 1-3/4")	4	H0307601	H0307601
	Lock Nut w/ Nylon Insert (5/16" – 18)	4	H2100915	H2100915
R	Sheave (Disk Driver)	1	See Table 4	See Table 4
	Key	1	A-139112-BM	A-139112-BM
S	Bearing, Medium Series (.787" Bore)	1	0031X181	0031X181
T	Housing	1	D-186662-2	D-186662-2
	Set Screw, Br Tip (3/8" – 16 x 1/2")	1	0034X077	0034X077
U	Disk Shaft	1	B-187029-1	B-187029-1
V	Retaining Ring (1.85" Dia.)	1	0175X130	0175X130
W	Bearing, Light Series (.787" Bore)	1	0031X182	0031X182
X	Retaining Ring (.781" Dia.)	1	0175X010	0175X010
Y	Disk Adjusting Nut	1	B-187046-1	B-187046-1
Z	Sheave, Disk Driven (4.8" P.D.)	1	0180X249	0180X249
	Bushings, P (11/16" Bore)	1	0182X092	0182X092
	Key	1	A-139112-AZ	A-139112-AZ

PARTS LIST – ROF-123S and ROF-123D ROTARY PARTS FEEDERS (cont'd)

Item	Description	Quantity	Part No. SINGLE DRIVE	Part No. DUAL DRIVE
AA	Belt (Disk Driver)	1	See Table 4	See Table 4
BB	Cap Screw, Hex Hd (3/8" – 16 x 1-1/4")	1	H0310301	-----
	Plainwasher (3/8")	2	H0117012	-----
	Lockwasher (3/8")	2	H0113201	-----
	Hex Nut (3/8" – 16)	2	H0103001	-----
CC	Cap Screw, Hex Hd, Gr 5 (3/8" – 16 x 1-1/4")	1	H0310301	-----
	Plainwasher (3/8")	2	H0117012	-----
	Lockwasher (3/8")	1	H0113201	-----
	Hex Nut (3/8" – 16)	1	H0103001	-----
DD	Shoulder Screw (3/8" x 1-1/2")	1	H0420500	-----
	Hex Nut (5/16" – 18)	1	H0102401	-----
EE	Idler Mounting Bracket Assembly (CW)]	1	C-211046-B	-----
	Idler Mounting Bracket Assembly (CCW)]	Only	C-211046-A	-----
FF	Lock Nut, Light Thin (3/8" – 16)	1	H2109564	-----
GG	Extension Spring	1	A-187372-1	-----
HH	Idler Arm	1	A-187294-1	-----
JJ	Idler Pulley	1	0180X226	-----
KK	Cap Screw, Hex Hd, Gr 5 (3/8" – 16 x 2-1/2")	1	H0311109	-----
	Plainwasher (3/8")	1	H0117012	-----
	Lockwasher (3/8")	1	H0113201	-----
	Hex Nut (3/8" – 16)	1	H0103001	-----
	Lock Nut, ESNA, Light Thin (3/8" – 16)	2	H2109564	-----
MM	Bowl Motor Slide (CW)	1	B-211042-A	B-210416-A
	Bowl Motor Slide (CCW)	1	B-210416-A	B-210416-A
	Cap Screw, Hex Hd (3/8" – 16 x 4-1/2")	1	H0334917	H0334917
NN	Fence Support Post	4	B-208989-1	B-208989-1
	Plainwasher (1/2")	4	H0117304	H0117304
	Cap Screw, Hex Hd (1/2" – 13 x 1-1/2")	4	H0315201	H0315201
PP	Carriage Bolt (3/8" – 16 x 3-1/2")	4	H0512907	H0512907
	Plainwasher (1/2")	4	H0117310	H0117310
	Plainwasher, SS (3/8")	12	H0117004	H0117004
	Lockwasher, SS (3/8")	8	H0113210	H0113210
	Hex Nut, SS (3/8" – 16)	12	H0103002	H0103002
	End Cap	4	188X021	188X021
QQ	Fence	1	-----	-----
RR	Motor and Cable Assembly	♦	C-194192-A	C-194192-A
SS	Sheave (Bowl Driver)	1	See Table 4	See Table 4
TT	Guard Clip	4	A-208877-A	A-208877-A
	Cap Screw, Hex Soc Hd (1/4" – 20 x 7/8")	4	H0449300	H0449300
	Mach Screw, Slotted, Rd Hd (1/4" – 20 x 7/8")	4	H0205201	H0205201
	Plainwasher (1/4")	4	H0116602	H0116602
UU	▲ Syntron label	2	189525-D	189525-D
	▲ Safety Label	1	125694	125694
	▲ Safety Label	1	169336	169336
	▲ Nameplate	1	198776	198776

PARTS LIST – ROF-232S and ROF-232D ROTARY PARTS FEEDERS

Item	Description	Quantity	Part No. SINGLE DRIVE	Part No. DUAL DRIVE
A	Disk Clamp	1	B-208956-A	B-208956-A
	Cap Screw, Hex Hd (1/2" – 13 x 2-1/2")	1	H0305703	H0305703
	Lockwasher (1/2") SS	1	H0113610	H0113610
B	Disk	2	D-208852-B	D-208852-B
	Cap Screw, Hex Hd (3/8" – 16 x 3/4")	4	H0310001	H0310001
C	Disk Hub	1	B-208954-1	B-208954-1
	Key	1	A-139112-AQ	A-139112-AQ
D	Bowl	1	D-188323-A	D-188323-A
E	Guard	4	C-208882-C	C-208882-C
	Mach Screw, Slot Hd (1/4" – 20 x 7/8")	8	H0205201	H0205201
	Plainwasher (1/4")	8	H0116602	H0116602
F	Clamp Ring, Housing (6.6" O.D.)	1	C-211956-1	C-211956-1
G	Clamp Ring, Hub (8" O.D.)	1	C-211955-1	C-211955-1
	Cap Screw, Hex Soc Hd (#10 – 32 x 1/2")	4	H0419600	H0419600
	Lockwasher (#10)	4	H0112458	H0112458
	Loctite (#271)	As Req'd	0185X006	0185X006
H	Ball Bearing (6-1/2" Bore)	1	0031X183	0031X183
J	Hub	1	D-188362-2	C-188362-2
K	Belt (Bowl Driver)	1	See Table 5	See Table 5
M	Frame Assembly (CW)	1	D-210783-A	D-210693-A
	Frame Assembly (CCW)	Only	D-210782-A	D-210693-A
	Cap Screw, Hex Hd (3/4" – 10 x 2-1/2")	4	H0335217	H0335217
	Cap Screw, Hex Hd (3/4" – 10 x 3")	4	H0322001	H0322001
	Hex Nut (3/4" - 10)	4	H0105401	H0105401
N	Cover	4	C-210696-1	C-210696-1
	Machine Screw, Slot Hd (1/4" – 20 x 7/8")	16	H0205201	H0205201
	Plainwasher (1/4")	16	H0116602	H0116602
	Fastener, Tinnerman Type U (1/4" – 20)	16	H0118365	H0118365
P	Reducer Mounting Bracket	1	-----	D-211218-A
	Cap Screw, Hex Hd (3/8" – 16 x 1-1/2")	4	-----	H0310601
	Plainwasher (3/8")	4	-----	H0117001
	Lock Nut w/ Nylon Insert (3/8" – 16)	4	-----	H2100515
Q	Reducer, L.H. (CW) 30:1	1	0044X426	0044X426▲
	Reducer, L.H. (CCW) 30:1	Only	0044X424	0044X424▲
	Cap Screw, Hex Hd (3/8" – 16 x 1-1/2")	4	H0310601	H0310601
	Lock Nut w/ Nylon Insert (3/8" – 16)	4	H2100515	H2100515
R	Sheave (Disk Driver)	1	See Table 5	See Table 5
	Key	1	A-139112-AQ	A-139112-AQ
S	Bearing, Light Series (1.378" Bore)	1	0031X185	0031X185
T	Housing	1	D-188363-2	D-188363-2
	Set Screw, Br Tip (3/8" – 16 x 1/2")	1	0034X077	0034X077
U	Disk Shaft	1	B-188492-1	B-188492-1
V	Retaining Ring (1.375" Dia.)	1	0175X015	0175X015
W	Bearing, Light Series (1.375" Bore)	1	0031X184	0031X184
X	Retaining Ring (2.440" Dia.)	1	0175X133	0175X133
Y	Disk Adjusting Nut	1	B-188494-1	B-188494-1
Z	Sheave, Disk Driven (7.9" P.D.)	1	0180X273	0180X273
	Bushings, H (1-5/16" Bore)	1	0182X095	0182X095
	Key	1	A-139112-AZ	A-139112-AZ
AA	Belt (Disk Driver)	1	See Table 5	See Table 5

PARTS LIST – ROF-232S and ROF-232D ROTARY PARTS FEEDERS (cont'd)

Item	Description	Quantity	Part No. SINGLE DRIVE	Part No. DUAL DRIVE
BB	Cap Screw, Hex Hd (3/8" – 16 x 1-1/2")	2	H0310601	-----
	Plainwasher (3/8")	2	H0117001	-----
	Lockwasher (3/8")	2	H0113201	-----
	Hex Nut (3/8" – 16)	2	H0103001	-----
CC	Cap Screw, Hex Hd, Gr 5 (3/8" – 16 x 1-1/4")	1	H0310309	-----
	Plainwasher (3/8")	2	H0117001	-----
	Lockwasher (3/8")	1	H0113209	-----
	Hex Nut (3/8" – 16)	1	H0103001	-----
DD	Shoulder Screw (3/8" x 1-1/2")	1	H0420500	-----
	Hex Nut (5/16" – 18)	1	H0102401	-----
EE	Idler Mounting Bracket Assembly (CW)]	1	C-210691-B	-----
	Idler Mounting Bracket Assembly (CCW)]	Only	C-210691-C	-----
FF	Lock Nut, Light Thin (3/8" – 16)	1	H2109564	-----
GG	Extension Spring	1	0241X011	-----
HH	Idler Arm	1	A-187294-1	-----
JJ	Idler Pulley	1	0180X242	-----
KK	Cap Screw, Hex Hd, Gr 5 (3/8" – 16 x 2-1/2")	1	H0311109	-----
	Plainwasher (3/8") (SAE)	4	H0117010	-----
	Lockwasher (3/8")	1	H0113209	-----
	Hex Nut (3/8" – 16)	1	H0103001	-----
	Lock Nut, ESNA, Light Thin (3/8" – 16)	1	H2109564	-----
MM	Bowl Motor Slide	1	B-210699-A	B-210699-A
	Cap Screw, Hex Hd (1/2" – 13 x 4")	1	H0300101	H0300101
NN	Fence Support Post	4	B-208989-2	B-208989-2
	Plainwasher (1/2")	4	H0117304	H0117304
	Cap Screw, Hex Hd (1/2" – 13 x 1-1/4")	4	H0315201	H0315201
PP	Carriage Bolt (3/8" – 16 x 5")	4	H0511901	H0511901
	Plainwasher (1/2")	4	H0117310	H0117310
	Plainwasher, SS (3/8")	12	H0117004	H0117004
	Lockwasher, SS (3/8")	8	H0113210	H0113210
	Hex Nut, SS (3/8" – 16)	12	H0103002	H0103002
	End Cap	4	188X021	188X021
QQ	Fence	1	-----	-----
RR	Motor and Cable Assembly	♦	C-194194-B	C-194194-B
SS	Sheave (Bowl Driver)	1	See Table 4	See Table 4
TT	Guard Clip	4	A-208877-A	A-208877-A
	Cap Screw, Hex Soc Hd (1/4" – 20 x 7/8")	4	H0449300	H0449300
	Mach Screw, Slotted, Rd Hd (1/4" – 20 x 7/8")	4	H0205201	H0205201
	Plainwasher (1/4")	4	H0116602	H0116602
UU	▲ Syntron label	2	189525-D	189525-D
	▲ Safety Label	1	125694	125694
	▲ Safety Label	1	169336	169336
	▲ Nameplate	1	198776	198776

When ordering parts, please provide all information given on the equipment nameplate.
] For dual drive, one each CW and CCW
♦ Single Drive – 1 required; Dual Drive – 2 required
▲ Do not paint over safety labels. If safety labels need replaced, contact Homer City Automation for an extra supply free of charge.

PARTS LIST – ROF-242S and ROF-242D ROTARY PARTS FEEDERS

Item	Description	Quantity	Part No. SINGLE DRIVE	Part No. DUAL DRIVE
A	Disk Clamp	1	B-208956-A	B-208956-A
	Cap Screw, Hex Hd (1/2" – 13 x 1-1/2")	1	H0315403	H0315403
	Lockwasher (1/2") SS	1	H0113610	H0113610
B	Disk	2	D-208852-D	D-208852-D
	Cap Screw, Hex Hd (3/8" – 16 x 3/4")	4	H0310001	H0310001
	Lockwasher (3/8")	4	H0113201	H0113201
C	Disk Hub	1	B-208954-2	B-208954-2
	Key	1	A-139112-AQ	A-139112-AQ
D	Bowl	1	D-188324-A	D-188324-A
E	Guard	4	C-208882-D	C-208882-D
	Mach Screw, Slot Hd (1/4" – 20 x 7/8")	8	H0205201	H0205201
	Plainwasher (1/4")	8	H0116602	H0116602
F	Clamp Ring, Housing (6.6" O.D.)	1	C-211956-1	C-211956-1
G	Clamp Ring, Hub (8" O.D.)	1	C-211955-1	C-211955-1
	Cap Screw, Hex Soc Hd (#10 – 32 x 1/2")	4	H0419600	H0419600
	Lockwasher (#10)	4	H0112458	H0112458
	Loctite (#271)	As Req'd	0185X006	0185X006
H	Ball Bearing (6-1/2" Bore)	1	0031X183	0031X183
J	Hub	1	D-188362-2	C-188362-2
K	Belt (Bowl Driver)	1	See Table 5	See Table 5
M	Frame Assembly (CW)	1	D-210778-A	D-210787-A
	Frame Assembly (CCW)	Only	D-210777-A	D-210787-A
	Cap Screw, Hex Hd (3/4" – 10 x 2-1/2")	4	H0335217	H0335217
	Cap Screw, Hex Hd (3/4" – 10 x 3")	4	H0322001	H0322001
	Hex Nut (3/4" - 10)	4	H0105401	H0105401
N	Cover	4	C-210696-4	C-210696-4
	Machine Screw, Slot Hd (1/4" – 20 x 7/8")	16	H0205201	H0205201
	Plainwasher (1/4")	16	H0116602	H0116602
	Fastener, Tinnerman Type U (1/4" – 20)	16	H0118365	H0118365
P	Reducer Mounting Bracket	1	-----	D-211218-A
	Cap Screw, Hex Hd (3/8" – 16 x 1-1/2")	4	-----	H0310601
	Plainwasher (3/8")	4	-----	H0117001
	Lock Nut w/ Nylon Insert (3/8" – 16)	4	-----	H2100515
Q	Reducer, L.H. (CW) 30:1	1	0044X426	0044X426▲
	Reducer, L.H. (CCW) 30:1	Only	0044X424	0044X424▲
	Cap Screw, Hex Hd (3/8" – 16 x 1-1/2")	4	H0310601	H0310601
	Lock Nut w/ Nylon Insert (3/8" – 16)	4	H2100515	H2100515
	Plainwasher (3/8")	4	H0117001	H0117001
R	Sheave (Disk Driver)	1	See Table 5	See Table 5
	Key	1	A-139112-AQ	A-139112-AQ
S	Bearing, Light Series (1.378" Bore)	1	0031X185	0031X185
T	Housing	1	D-188363-2	D-188363-2
	Set Screw, Br Tip (3/8" – 16 x 1/2")	1	0034X077	0034X077
U	Disk Shaft	1	B-188492-1	B-188492-1
V	Retaining Ring (1.375" Dia.)	1	0175X015	0175X015
W	Bearing, Light Series (1.375" Bore)	1	0031X184	0031X184
X	Retaining Ring (2.440" Dia.)	1	0175X133	0175X133
Y	Disk Adjusting Nut	1	B-188494-1	B-188494-1
Z	Sheave, Disk Driven (7.9" P.D.)	1	0180X273	0180X273
	Bushings, H (1-5/16" Bore)	1	0182X095	0182X095
	Key	1	A-139112-AQ	A-139112-AQ

PARTS LIST – ROF-242S and ROF-242D ROTARY PARTS FEEDERS (cont'd)

Item	Description	Quantity	Part No. SINGLE DRIVE	Part No. DUAL DRIVE
AA	Belt (Disk Driver)	1	See Table 5	See Table 5
BB	Cap Screw, Hex Hd (3/8" – 16 x 1-1/2")	2	H0310601	-----
	Plainwasher (3/8")	2	H0117001	-----
	Lockwasher (3/8")	2	H0113201	-----
	Hex Nut (3/8" – 16)	2	H0103001	-----
CC	Cap Screw, Hex Hd, Gr 5 (3/8" – 16 x 1-1/4")	1	H0310309	-----
	Plainwasher (3/8")	2	H0117001	-----
	Lockwasher (3/8")	1	H0113209	-----
	Hex Nut (3/8" – 16)	1	H0103001	-----
DD	Shoulder Screw (3/8" x 1-1/2")	1	H0420500	-----
	Hex Nut (5/16" – 18)	1	H0102401	-----
EE	Idler Mounting Bracket Assembly (CW)]	1	C-210691-B	-----
	Idler Mounting Bracket Assembly (CCW)]	Only	C-210691-C	-----
FF	Lock Nut, Light Thin (3/8" – 16)	1	H2109564	-----
GG	Extension Spring	1	0241X011	-----
HH	Idler Arm	1	A-187294-1	-----
JJ	Idler Pulley	1	0180X242	-----
KK	Cap Screw, Hex Hd, Gr 5 (3/8" – 16 x 2-1/2")	1	H0311109	-----
	Plainwasher (3/8") (SAE)	4	H0117010	-----
	Lockwasher (3/8")	1	H0113209	-----
	Hex Nut (3/8" – 16)	1	H0103001	-----
	Lock Nut, ESNA, Light Thin (3/8" – 16)	1	H2109564	-----
MM	Bowl Motor Slide	1	B-210699-A	B-210699-A
	Cap Screw, Hex Hd (1/2" – 13 x 4")	1	H0300101	H0300101
NN	Fence Support Post	4	B-208989-2	B-208989-2
	Plainwasher (1/2")	4	H0117304	H0117304
	Cap Screw, Hex Hd (1/2" – 13 x 1-1/4")	4	H0315201	H0315201
PP	Carriage Bolt (3/8" – 16 x 5")	4	H0511901	H0511901
	Plainwasher (1/2")	4	H0117310	H0117310
	Plainwasher, SS (3/8")	12	H0117004	H0117004
	Lockwasher, SS (3/8")	8	H0113210	H0113210
	Hex Nut, SS (3/8" – 16)	12	H0103002	H0103002
	End Cap	4	188X021	188X021
QQ	Fence	1	-----	-----
RR	Motor and Cable Assembly	♦	C-194194-B	C-194194-B
SS	Sheave (Bowl Driver)	1	See Table 5	See Table 5
TT	Guard Clip	4	A-208877-A	A-208877-A
	Cap Screw, Hex Soc Hd (1/4" – 20 x 7/8")	4	H0449300	H0449300
	Mach Screw, Slotted, Rd Hd (1/4" – 20 x 7/8")	4	H0205201	H0205201
	Plainwasher (1/4")	4	H0116602	H0116602
UU	▲ Syntron label	2	189525-D	189525-D
	▲ Safety Label	1	125694	125694
	▲ Safety Label	1	169336	169336
	▲ Nameplate	1	198776	198776

When ordering parts, please provide all information given on the equipment nameplate.
▲ For dual drive, one each CW and CCW
♦ Single Drive – 1 required; Dual Drive – 2 required
▲ Do not paint over safety labels. If safety labels need replaced, contact Homer City Automation for an extra supply free of charge.

PARTS LIST – ROF-257-D ROTARY PARTS FEEDER

Item	Description	Quantity	Part No. Dual Drive
A	Disk Clamp	1	B-208956-A
	Cap Screw, Hex Hd (1/2" – 13 x 1-1/2")	1	H0315403
	Lockwasher (1/2") SS	1	H0113610
B	Disk	1	D-223141-002
	Cap Screw, Hex Hd (3/8" – 16 x 3/4")	4	H0310001
	Lockwasher (3/8")	4	H0113201
C	Disk Hub	1	221850-001
	Key	1	A-139112-AQ
D	Bowl	1	221820-003
	Weadment Spoked Hub	1	221841-A
E	Guard	4	208882-B
	Mach Screw, Slot Hd (1/4" – 20 x 7/8")	8	H0205201
	Plainwasher (1/4")	8	H0116602
F	Clamp Ring, Housing (6.6" O.D.)	1	C-211956-1
G	Clamp Ring, Hub (8" O.D.)	1	C-211955-1
	Cap Screw, Hex Soc Hd (#10 – 32 x 1/2")	4	H0419600
	Lockwasher (#10)	4	H0112458
	Loctite (#271)	As Req'd	0185X006
H	Ball Bearing (6-1/2" Bore)	1	0031X183
J	Hub	1	C-188362-2
K	Belt (Bowl Driver)	1	See Table 5
M	Frame Assembly (CW)	1	223106-A
	Frame Assembly (CCW)	Only	223106-A
	Cap Screw, Hex Hd (3/4" – 10 x 2-1/2")	4	H0335217
	Cap Screw, Hex Hd (3/4" – 10 x 3")	4	H0322001
	Hex Nut (3/4" - 10)	4	H0105401
N	Cover	4	C-210696-4
	Machine Screw, Slot Hd (1/4" – 20 x 7/8")	16	H0205201
	Plainwasher (1/4")	16	H0116602
	Fastener, Tinnerman Type U (1/4" – 20)	16	H0118365
P	Reducer Mounting Bracket	1	D-211218-A
	Cap Screw, Hex Hd (3/8" – 16 x 1-1/2")	4	H0310601
	Plainwasher (3/8")	4	H0117001
	Lock Nut w/ Nylon Insert (3/8" – 16)	4	H2100515
Q	Reducer, R.H. 30:1	1	0044X615
	Reducer, L.H. 30:1	Only	0044X614
	Cap Screw, Hex Hd (3/8" – 16 x 1-1/2")	4	H0310601
	Lock Nut w/ Nylon Insert (3/8" – 16)	4	H2100515
	Plainwasher (3/8")	4	H0117001
R	Sheave (Disk Driver)	1	See Table 5
	Key	1	A-139112-AQ
S	Bearing, Light Series (1.378" Bore)	1	0031X185
T	Housing	1	D-188363-2
	Set Screw, Br Tip (3/8" – 16 x 1/2")	1	0034X077
U	Disk Shaft	1	B-188492-1
V	Retaining Ring (1.375" Dia.)	1	0175X015
W	Bearing, Light Series (1.375" Bore)	1	0031X184
X	Retaining Ring (2.440" Dia.)	1	0175X133
Y	Disk Adjusting Nut	1	B-188494-1
Z	Sheave, Disk Driven (7.9" P.D.)	1	0180X273
	Bushings, H (1-5/16" Bore)	1	0182X095
	Key	1	A-139112-AQ

PARTS LIST – ROF-257-D ROTARY PARTS FEEDER (cont'd)

Item	Description	Quantity	Part No. DUAL DRIVE
AA	Belt (Disk Driver)	1	See Table 5
MM	Bowl Motor Slide	1	B-210699-A
	Cap Screw, Hex Hd (1/2" – 13 x 4")	1	H0300101
NN	Fence Support Post	4	B-208989-2
	Plainwasher (1/2")	4	H0117304
	Cap Screw, Hex Hd (1/2" – 13 x 1-1/4")	4	H0315201
PP	Carriage Bolt (3/8" – 16 x 5")	4	H0511901
	Plainwasher (1/2")	4	H0117310
	Plainwasher, SS (3/8")	12	H0117004
	Lockwasher, SS (3/8")	8	H0113210
	Hex Nut, SS (3/8" – 16)	12	H0103002
	End Cap	4	188X021
QQ	Fence	1	-----
RR	Motor and Cable Assembly	♦	C-194194-B
SS	Sheave (Bowl Driver)	1	See Table 5
TT	Guard Clip	4	A-208877-A
	Cap Screw, Hex Soc Hd (1/4" – 20 x 7/8")	4	H0449300
	Mach Screw, Slotted, Rd Hd (1/4" – 20 x 7/8")	4	H0205201
	Plainwasher (1/4")	4	H0116602
UU	▲ Syntron label	2	189525-D
	▲ Safety Label	1	125694
	▲ Safety Label	1	169336
	▲ Nameplate	1	198776

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▲ For dual drive, one each CW and CCW
♦ Single Drive – 1 required; Dual Drive – 2 required
▲ Do not paint over safety labels. If safety labels need replaced, contact Homer City Automation for an extra supply free of charge.

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