

MINI-MOVER CONVEYORS

OWNER'S MANUAL

ROTARY TABLE ACCUMULATOR (RTA Series)



MADE IN THE U.S.A.



Visit us on the web at www.mini-mover.com

UNPACKING YOUR NEW RTA

Please read this instruction manual before assembly or operation.

Congratulations. You have purchased a high-quality Mini-Mover Rotary Table Accumulator (RTA). We suggest that you keep this manual and enclosed warranty information for future reference.

When Unpacking Your Rotary Table Accumulator (RTA)

Please note that the RTA unit will be partially disassembled to accommodate shipping. Typically, each rotary table is crated and mounted onto a shipping pallet. Inspect all areas of the crate and pallet top, to ensure you locate all RTA components, per the instructions below.

1. Do not invert the crate while unpacking.
2. To uncrate, first open the top, then open the sides.
3. Locate the tabletop:
 - a. For Model 60-024 (24" dia.) and 60-032 (32" dia.) the tabletop will be packed inside the crate.
 - b. For Model 60-048 (48" dia.) or custom tabletops larger than 36" dia., the tabletop is stowed in a labeled flat box, which is bolted in between the crate's bottom and the top of pallet.
4. Unbolt the crate from pallet.
 - a. For Model 60-024 or 60-032 shipment, these packing materials can now be set aside for future shipment.
 - b. For Model 60-048 or custom tabletop size, remove the tabletop from box, unbolt crate from pallet and set packing materials aside for future shipment.
5. For Model 60-048 or custom tabletop size, remove the tabletop from box, unbolt crate from pallet and set packing materials aside for possible future shipment.
6. Proceed to assembly instructions on pgs. 4-7 of this manual.

Should any questions arise from the initial unpacking, assembly or operation following assembly, refer call Customer Service — 866-380-5128 — for immediate assistance.

Please Remember!

Retain the empty crate and packing materials, in the event the RTA unit should require future repacking and shipment.



IMPORTANT!

**Read First, Before
Operating RTA**

Due to the variety of drive types, drive positioning & RTA configurations, point-of-installation guarding is the responsibility of the end user.

As a result, the purchaser and/or end user of this product acknowledges that Whipple Enterprises Mini-Mover Conveyors cannot reasonably foresee the methods employed by the purchaser and/or end user regarding point-of-installation guarding; as a result, the purchaser and/or end user agrees to hold Whipple Enterprises harmless in the event that any claim is made against Whipple Enterprises as a result of the purchaser's and/or end user's activities with respect to point-of-installation guarding, or any other aspect of the installation and use of this product that is not in conformity with the provisions of your Mini-Mover Owner's Manual.

Contents

Unpacking Your New RTA	i
Important Safety Instructions	2
Getting Started	2
RTA Components	3
Assembly Instructions - Model 60-024	4-5
Assembly Instructions - Models 60-032 & 60-048	6-7
Operating Instructions	7
Product Warranty	8
Customer Service	9
Checklist—Your RTA Model	10

IMPORTANT SAFETY INSTRUCTIONS

To reduce the risk of fire, electrical shock and injury, always follow these basic safety precautions when using your Rotary Table Accumulator (RTA).

1. Read and follow all instructions. Follow all warnings and instructions marked on your RTA unit.
2. Avoid jamming. Adjust your RTA so as not to allow parts to jam or lock the table from rotating. This condition may cause serious damage not covered by warranty.
3. Do not place the RTA on an unstable surface. A tip-over could cause serious damage to the unit or the operator.
4. Keep all loose clothing away from the unit while it is operating.
5. Ensure the collapsible handle or column is used to position or transport the assembled RTA, to avoid possible instability or damage to the unit. **Do not use the tabletop as a means of moving the RTA.**
6. Do not overload or unevenly load the unit. Damage or tip-over may occur.

The following precautions were written specific to Mini-Mover-supplied drives but are good general precautions for all electrical drives.

7. **Connect the RTA into a properly grounded power source only.** Operating the unit at voltage or frequency not specified will void the RTA product warranty. Check with a qualified electrician if you are not sure if the power source is grounded properly.
8. Do not overload the power source or use extension cords. This can increase the risk of fire or electrical shock.
9. Do not allow anything to rest on the power cord. Do not install the RTA where people will walk on or trip over the power cord.

GETTING STARTED

Tools You Need for Assembly (Supplied with Unit)

Your RTA unit comes with a tool kit containing the following items, which are used during installation and maintenance procedures. Two spare fuses are also provided as backups, and the amperage will match what's needed for gearmotor/controller option equipped on your unit.

- | <u>Tool:</u> | <u>Where used:</u> |
|-----------------|---|
| • 1/4" hex key | Base, cross-frame and support column. Height adjustment for models 60-032 & 60-048 only. |
| • 3/16" hex key | Diverter arm height & angle and motor assembly. Height adjustment for Model 60-024 only. |
| • 5/32" hex key | Cross frame and bearing block assembly (for later maintenance only). |
| • Clamping knob | Secures tabletop to cross-frame. Packed in tool kit for Model 60-024. It is preinstalled on models 60-032 and 60-048 prior to shipping. |

RTA COMPONENTS

Fig. 1 below shows the locations of the main components that comprise a Rotary Table Accumulator (RTA) unit. Note that the 60-024 (24" dia. model) has a single support column used for height adjustment, without the telescoping column style used in models 60-032 and 60-048 (Item 5 in Fig. 1).

- 1 Clamping Knob.** Secures tabletop to the drive hub. Includes a washer.
- 2 Tabletop.** Working surface of the RTA unit.
- 3a Standard Fence.** One-inch high, integral rim with in-feed cushion, for accumulation usage. Equipped as standard unless the Stationary-Fence or other fence option is ordered.
- 3b Stationary-Fence Option, Single.** (*Stationary Exit Rail System*). One 1-inch suspended rail with cushion, for surge or transfer-station applications.
- 3c Stationary-Fence Option, Dual.** (*Stationary Exit Rail System*). Two 1-inch suspended rails with cushion, for surge or transfer-station applications.
- 4a Drive Package.** Energy-efficient motor and gearhead combination. Operates at a fixed speed as ordered unless the Variable-Speed (VS) option is ordered.
- 4b VS Controller.** Equipped on RTA units ordered with the variable-speed option. This provides an operating range within the RPM range as ordered.
- 5 Support Column.** Provides the vertical support and height adjustment.
- 6 Base.** Provides a stable point of attachment for support column and locking casters.
- 7 Locking Casters.** Four equipped as standard.
- 8 Diverter-Arm Support.** Provides horizontal stability and points of attachment for diverter arm (models 60-032 and 60-048 only).
- 9 Diverter Arm.** Acts to move parts from in-feed to the center of tabletop for accumulation. Angle and height are adjustable.
- 10 Collapsible Handle (models 60-032 and 60-048).** Unfolds from beneath the unit for positioning and transport. It is not recommended to move unit by grasping the tabletop itself, which can damage the gearmotor assembly. *If your RTA is not equipped with a handle or for Model 60-024, use the support column to move the unit.*

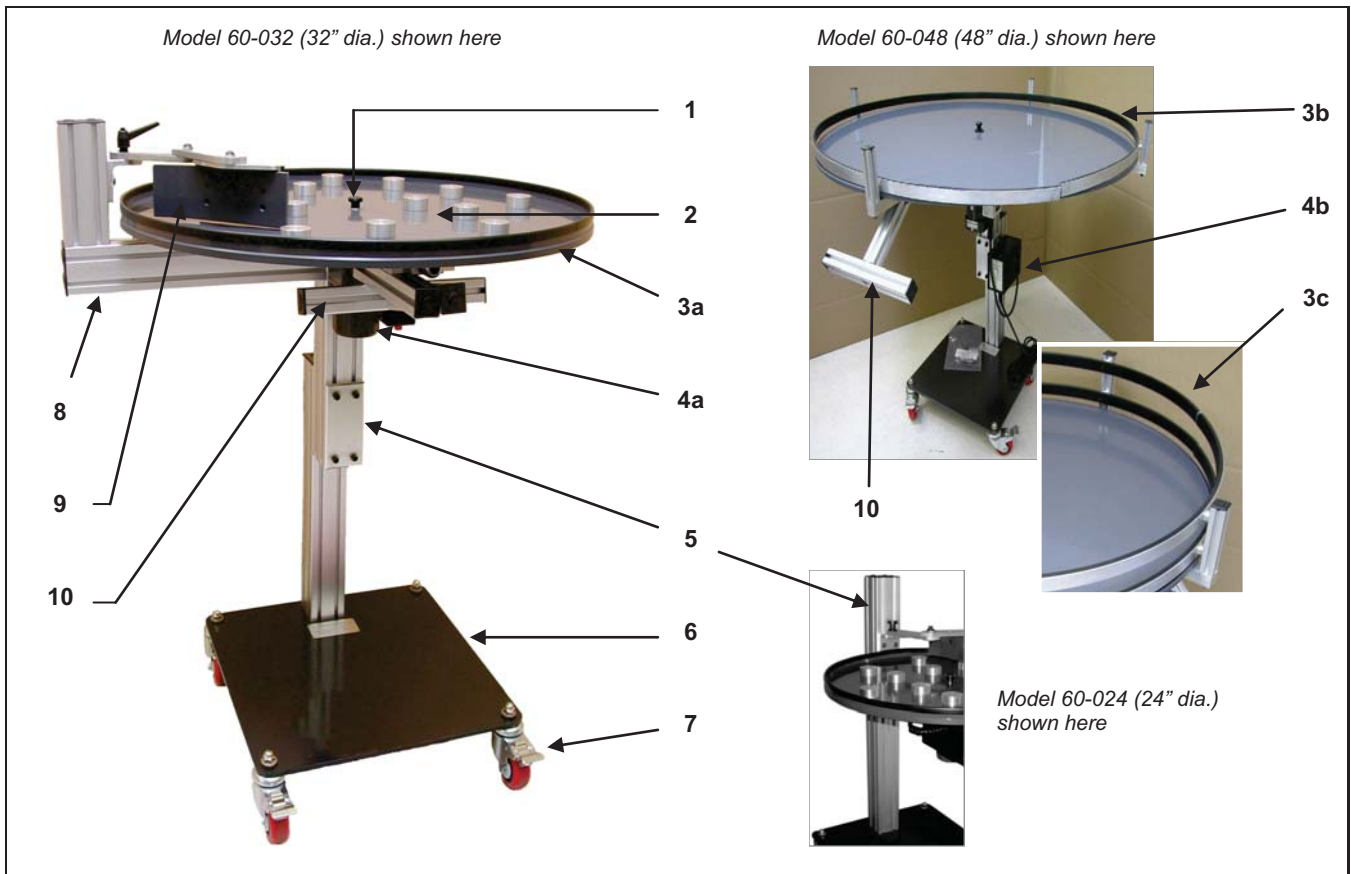


Fig. 1 - RTA Components

ASSEMBLY INSTRUCTIONS

For Model 60-024 Only

1. After unpacking, locate the base and column/cross-frame assembly (Fig 2). Orient the column to the base, as shown in Fig. 2a. Assemble using the four (4) 5/16" x 1" SHCS. Use the 1/4" hex key.



Fig. 2
Base & column



Fig. 2a
Attaching base

2. Set the base and column/cross-frame assembly upright per Fig. 3. The unit is now ready for installation of the tabletop (Step 3).



Fig. 3
Cross-frame assembly

ASSEMBLY INSTRUCTIONS

For Model 60-024 Only

3. Install the tabletop to the cross-frame assembly, using the following steps.
 - a. Lower the tabletop onto the drive hub and carefully align with the drive pin.
 - b. Ensure the tabletop is seated evenly atop the drive hub.
 - c. Install the clamping knob and its washer (supplied in the Model 60-024 factory tool kit), and screw it down securely, but finger tight.

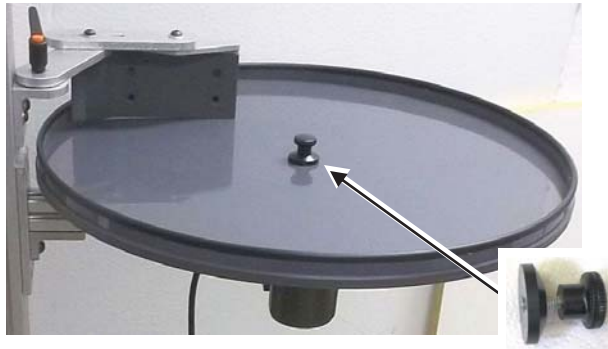


Fig. 4
Tabletop seated

4. Install the diverter arm assembly to the support column, as shown in Fig. 5. Use the 3/16" hex key.

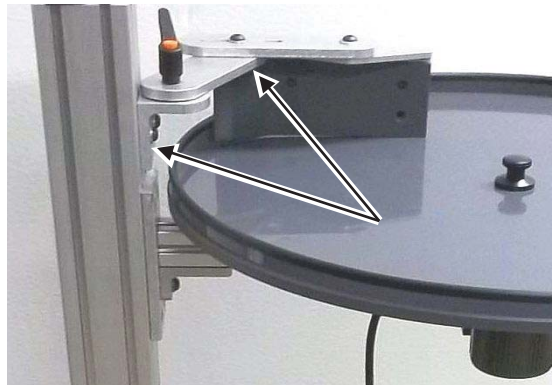


Fig. 5
Diverter arm assembly

Note:
The diverter arm assembly is adjustable and can be positioned to best suit your application.

5. Your Mini-Mover RTA is now ready for operation. It is strongly recommended that the support column be used to move the unit, rather than pulling by the tabletop (Fig. 6).



Fig. 6
Transport using the support column

ASSEMBLY INSTRUCTIONS

For Models 60-032 and 60-048 Only

1. After unpacking, locate the base and column assembly. Orient the column to the base, as shown in Fig. 7. Assemble using the four (4) 5/16" x 1" SHCS. Use the 1/4" hex key.



Fig. 7
Base & column

2. Set the base and column assembly upright. Orient the cross-frame/motor assembly to the column assembly, as shown in Fig. 8. Assemble using the four (4) 5/16" x 1" SHCS. Use the 1/4" hex key.



Fig. 8
Cross-frame assembly

3. Install the tabletop to the cross-frame assembly, using the following steps. Fig. 9 shows the completed result.
 - a. Remove the clamping knob and washer from the drive hub, which is located in the center of the cross-frame (see arrow in Fig. 9).
 - b. Lower the tabletop onto the drive hub and carefully align with the drive pin.
 - c. When the tabletop is seated atop the drive hub, reinstall the clamping knob finger tight to secure it.



Fig. 9
Tabletop seated

Important Note for 48" dia. Tabletops



The tabletop for Model 60-048 is packed atop the pallet. Access it by first unbolting and removing the shipping crate.

ASSEMBLY INSTRUCTIONS

For Models 60-032 and 60-048 Only

4. Install the diverter arm assembly, as shown in Fig. 10. Use the 3/16" hex key.



Fig. 10
Diverter arm assembly

Note:
The diverter arm assembly is adjustable and can be positioned to best suit your application.

5. Your Mini-Mover RTA is now ready for operation. It is strongly recommended that the collapsible handle is used to move the unit (Fig. 11), rather than pulling by the tabletop.



Fig. 11
Assembly completed

OPERATING INSTRUCTIONS

A. To Operate

1. Connect the power cord to a properly grounded power source.
2. For fixed-speed controllers, move the On/Off switch to the On position.
3. For variable-speed controllers, refer to the operating guide provided for your VS control unit.

B. To Reverse the Direction of Table Rotation

1. Disconnect from the power source and wait two (2) minutes.
2. Fixed-speed tables: Open the electrical box and use wiring diagram inside the case (also see Fig. 12).
3. Variable-speed tables: Flip the directional switch, or consult the manual for your VS control unit.

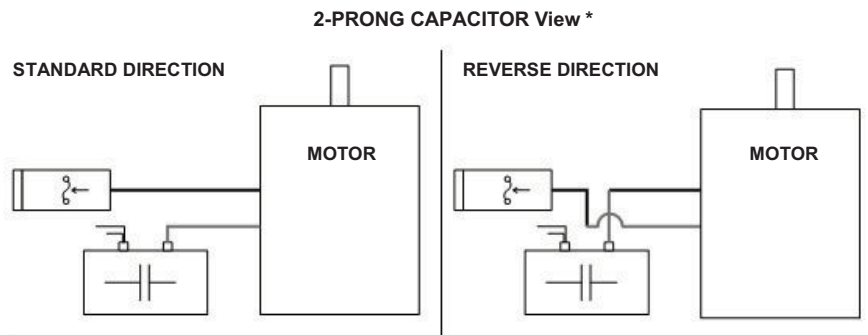


Fig. 12 — Fixed-Speed Only: Control Box Wiring Diagram

PRODUCT WARRANTY

MINI-MOVER CONVEYORS
div. of Whipple Enterprises, Inc.

Rotary Table Accumulator (RTA) Conveyor Limited Lifetime Warranty

Warranty Service Provided

Whipple Enterprises warrants its Mini-Mover Lite Series Rotary Table Accumulators (RTA) against defects in material or workmanship for the usable lifetime of the product following the original date of purchase. Whipple Enterprises' responsibility under this warranty is limited to the repairing or replacing, at its sole option, any defective product. The warranty begins on the date of the original purchase from the factory for its usable lifetime and is not transferrable to any third parties. This lifetime warranty is voided once the original purchaser sells or rents the unit, the unit has been significantly abused or has been used for purposes beyond the intended parameters of conveyor design and operation. However, in cases where ownership of the unit should transfer to a third party, that party may contact Whipple Enterprises for consideration of possible transfer of this warranty, on a case-by-case basis.

This item is purchased "as -is." There are no warranties that extend beyond the description on the face thereof. Whipple Enterprises makes no other warranty. Whipple Enterprises specifically disclaims any implied warranties, including warranties of merchantability and fitness for any particular purpose. In no event shall Whipple Enterprises be liable for direct, indirect, special or consequential damages.

In addition to the foregoing, Whipple Enterprises specifically disclaims and not honor any warranties with respect to the purchasers and corporation of this product as a component of the purchaser's product sold to other users as an integrated unit. Whipple will only be responsible, under its warranty, for the performance of its product only, and not for any other product in which this product is incorporated. Additionally, the purchaser of this product agrees to hold Whipple harmless and defend and indemnify Whipple Enterprises should any claims be made against Whipple for the use of any such product sold to an end user that incorporated this product in this fashion.

Warranty Service Not Provided

This warranty does not cover normal wear and tear of parts as a result of normal operation over time, nor damage resulting from accident, misuse, abuse, improper installation, unauthorized modification and/or loss of parts. This warranty is voided if any unauthorized person opens, alters, or repairs the unit beyond that which is directed in this manual.

Obtaining Service under Warranty

You must obtain a Return Goods Authorization (RGA) number from Whipple Enterprises' customer service. The product must be returned to Whipple Enterprises with transportation charges prepaid and must be accompanied by a brief description of the problem encountered and proof of purchase.

Product Return Policy

The Return Goods Authorization (RGA) number is required for return of any product to Whipple Enterprises. This number must be clearly visible on the packing carton. Please retain the original shipping carton and packing materials. The original shipping carton is the best shipping container for returning your unit, if required.

CUSTOMER SERVICE

Mini-Mover Conveyors offers you customer service and support throughout all phases of the sale, delivery, setup and ongoing maintenance for the life of your RTA product. Call or email us if you need any assistance, such as the following areas.

- New RTA delivery — to report damage during shipment
- New RTA setup support or operating questions
- Troubleshooting assistance
- Add-on accessories or options for your RTA
- Spare parts for your stock bin
- Returns or exchanges
- Applications consultation

Please note that for returns or exchanges, you will need to contact us for a Returned Goods Authorization (RGA) before shipping anything back to the factory. The RGA gives you more detailed shipping instructions and allows us to track your items for proper credit or exchange.

If you have a question or need that is specific to you conveyor, please have the Serial Number of the unit on hand when contacting us. Each conveyor is built to order, and the serial number allows us to identify each component and manufacturing note regarding your unit and its service history..

Mailing and Shipping Address:

Mini-Mover Conveyors
division of Whipple Enterprises
21150 Shake Ridge Rd.
Volcano, CA 95689

Customer Service:

Phone: 866-380-5128

Fax: 866-900-5124

Email: service@mini-mover.com

CHECKLIST—YOUR RTA MODEL

Rotary Table Accumulator Model *(fill in applicable features)*

60-024 (24" dia.)

60-032 (32" dia.)

60-048 (48" dia.)

Standard Specifications:

<u>Model</u>	<u>Weight</u>	<u>Table Dia.</u>	<u>Load Capacity</u>
60-024	95 lbs	24 inches	60 lbs
60-032	120 lbs	32 inches	100 lbs
60-048	145 lbs	48 inches	100 lbs

Table Rotation Option:

- Fixed Speed — 1 rpm
- Variable Speed — 1 to 3 rpm
- Custom Speed *(fill in below)*:

Fixed _____ rpm

Variable _____ rpm

Height Option:

	Standard	A	B	C
60-024	16" to 34"	—	—	—
60-032	—	20" to 28"	28" to 36"	36 to 42"
60-048	—	20" to 28"	28" to 36"	—

Height Option

Equipped: Std A B C Custom _____

Other Components:

- Roller Base — 19.5" square
- Collapsible Handle
- Part Stop Cushion — height and angle adjustable
- Diverter Arm — height and angle adjustable
- Fixed Fence Option:
 - Single Rail
 - Dual Rail

MINI-MOVER CONVEYORS

Important Notes for your Service Records:

Date of Installation: _____

Serial Number _____

Purchased from: _____
(if other than factory-direct)

*Read instructions for unpacking your RTA
on the inside front cover of this manual.*

*Read assembly and safety instructions
before using.*

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