Service Instructions

Models: SLC-B & SXLC-B
Hopper Level Control
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IMPORTANT

Syntron Material Handling, LLC reserves the right to make changes at any time, without notice and without any liability or other obligation on its part, in materials, equipment, specifications and models, and also to discontinue the manufacture and sale of models and the parts and components thereof. For further detailed information, contact Syntron Material Handling, LLC.

Please be sure to include the following information when ordering replacement parts:

1. Machine model name
2. Factory order number
3. Quantity of parts required
4. Syntron part number (from manual)
5. Description of part
6. Shipping instructions
Safety Instructions

The purpose of safety symbols is to attract your attention to possible danger. Safety symbols, and their explanations, deserve careful attention and understanding. The safety warnings do not by themselves eliminate any danger. The instructions or warnings they give are not substitutes for proper safety procedures.

<table>
<thead>
<tr>
<th>SYMBOL</th>
<th>MEANING</th>
</tr>
</thead>
<tbody>
<tr>
<td>![Safety Alert Symbol]</td>
<td>Safety Alert Symbol: Indicates DANGER, WARNING, or CAUTION. Attention is required in order to avoid serious personal injury. This symbol may also be used in conjunction with other symbols or pictographs.</td>
</tr>
</tbody>
</table>

NOTE: Notes advise you of information or instructions vital to the operation or maintenance of the equipment.

IMPORTANT SAFETY INFORMATION

READ ALL INSTRUCTIONS BEFORE OPERATING

- Upon receipt, unpack and inspect the unit for damage that may have occurred during shipment. If damage is found, contact the shipping carrier and Syntron Material Handling immediately.

- Read instructions carefully. Be familiar with the controls and proper use of the unit.

- Do not operate the unit when tired, ill, or under the influence of alcohol, drugs or medication.

Product safety labels must remain highly visible on the equipment. Establish a regular schedule to check visibility. If you need to replace safety labels, contact Syntron Material Handling, LLC for an additional supply free of charge.

The instructions and data herein are vital to the proper installation and operation of this equipment. In order to avoid delays due to faulty installation or operation, please see that these instructions are read by the persons who will install, operate and maintain this equipment.

NOTE: Supporting information, such as drawings, may be attached to the manual. The information contained therein takes precedence over corresponding information printed in this manual.
INTRODUCTION

Models SLC-B and SXLC-B Syntron® Hopper Level Controls are used to control the level of materials in hoppers and bins. The required material level is maintained by the pressure of material against the paddle, actuating an internal switch to control supply and/or discharge feeders. Auxiliary functions such as indicating lamps and alarms can also be controlled by the Hopper Level Controls.

A Hopper Level Control consists of a motor with electrical connections (located in the control housing), a shaft connected to the motor and extending through the hopper wall to a paddle located inside the hopper.

The Model SLC-B is the standard unit, interchangeable with all commonly used controls. The Model SXLC-B is the same as the SLC-B model except for use in explosive atmospheres. The SXLC-B model is UL and CSA labeled for Class I, Div. 1 & 2, Groups C and D, Class II, Div. 1 & 2, Groups E, F and G explosion-proof locations.

WARNINGS

General Safety

Caution: It is essential that all instructions in this manual be followed to ensure proper operation of the equipment and safety of operating personnel. The use of this symbol is used throughout manual to highlight important safety issues. Please pay particular attention to these items.

Electrical Shock Caution

Certain SLC-B and SXLC-B Syntron® Hopper Level Controls are powered with HIGH VOLTAGE. No operator serviceable parts are inside. All servicing is to be performed by qualified personnel. Each SLC-B and SXLC-B is provided with a "protective conductor terminal" which shall be terminated to earth ground potential (see Electrical Installation).

Hazardous Location Caution

The SXLC-B Syntron® Hopper Level Control can be used in Hazardous Locations. This model shall only be used in applications covered by stated ratings. Failure to comply could result in damage to personnel and property.

The following must be maintained to assure safe operation:

1. Enclosure integrity - the dimensions of the housing, cover or drive shaft shall not be altered.

2. Maintenance - Power to all circuits must be disconnected before conducting any investigation, setup or maintenance.
INSTALLATION

Note: SLC-B and SXLC-B units have a maximum ambient rating of 200° F (93° C) and 300° F (149° C) inside the bin.

PRE-INSTALLATION CONSIDERATIONS
Choosing a Location: (See Figure 1)

1. Material Flow - When selecting a location for any Hopper Level Control, choose a point in the vessel where the paddle will be out of the direct flow of incoming and outgoing material to prevent any mechanical damage that may be caused by the pressure of the flow. This is particularly important for materials with large, lumpy characteristics. The paddle unit must be positioned at a point where incoming material will reach and cover the paddle in its normal flow, and when receding, will flow away from the paddle in an even manner.

2. Vibration Concerns - Mount at a location that is subject to limited vibration, away from bin vibrators thereby attaining maximum operational life. Consult the factory when questionable conditions exist.

3. Guard Reinforcement - When using rigid extensions and guards in top mounted applications, select a location where it is feasible to reinforce the guard to the vessel wall. See Mechanical Installation for further details.

Choosing a Location

<table>
<thead>
<tr>
<th>RECOMMENDED</th>
<th>NOT RECOMMENDED</th>
</tr>
</thead>
<tbody>
<tr>
<td>Guard Bracing</td>
<td>Guard Not Reinforced</td>
</tr>
<tr>
<td>Good Paddle Coverage, Not in Direct Material Flow</td>
<td>Poor Paddle Coverage</td>
</tr>
<tr>
<td>Away From Significant Vibration</td>
<td>Close To Excessive Vibration</td>
</tr>
</tbody>
</table>

Figure 1
Flexible Mounting Plates: (See Figure 2)

If the area of support for the hopper level control is too thin or curved too much to accommodate a pipe coupling, a flexible mounting plate is recommended. Mounting plates are available in carbon or stainless steel and include a pipe coupling and gasket.

1. Cut a 2 to 5 inch (50.8 to 127.0 mm) diameter hole where the hopper level control is to be located. (Hole diameter is based on the paddle style selected.)

2. Using the gasket as a template, mark the location where the mounting holes are to be drilled. Drill six clearance holes, 11/32 inch (8.73 mm) for 5/16 (7.93 mm) bolts. Nuts or bolt heads may be tack welded to the inside of the vessel.

3. Be sure the hopper level control is fastened tightly on the mounting plate.

4. Place the gasket and control assembly in its operating location and bolt into position with 5/16-inch (7.93 mm) bolts and nuts.

5. For Hopper Level Control mounting positions, refer to the “Horizontal Position” (page 8) or “Vertical Position” (page 9) instructions.

Figure 2
Flexible Mounting Plates Dimensions

**Half Coupling**

- 0.47" [11.94 mm] Width
- 8" [203.20 mm] O.D.
- 1.1/4" NPT

**Full Coupling**

- 0.93" [23.62 mm] Width
- 8" [203.20 mm] O.D.
- 1.1/4" NPT

(6) 0.34" [8.67 mm] Holes Eq. Spaced on 7" [177.80 mm] B.C.

Used Primarily on Side Wall Installations

For Bin Top Installations

**Figure 3**
Horizontal Position: (See Figure 4)

Note: If a flexible mounting plate is being used, follow steps 1-4 in the “Flexible Mounting Plates” instructions (page 7), then proceed to step 3 of these instructions.

1. Cut a 1.950 inch [49.5 mm] diameter hole where the hopper level control is to be located.
2. Insert one half of a standard 1-1/4” NPT pipe coupling through the hole and flush with the inside of the wall. Weld the half coupling to the wall.
3. Loosen the paddle lock pin on the shaft and remove the paddle.
4. Insert the hub into the half coupling and turn until the conduit opening is in the proper position. (Note: Use anti-seize compound on the hub and coupling threads.
5. Insert the paddle onto the end of the spring coupling shaft and tighten. Replace the lock pins. If baffles are required, refer to Protective Baffles on page 11. Refer to the wiring procedures on page 12.

![Figure 4](image-url)
Note: If a flexible mounting plate is being used, follow steps 1-4 in the “Flexible Mounting Plates” instructions (page 7), then proceed to step 3 of these instructions.

1. Cut a 1.950 inch [49.5 mm] diameter hole where the hopper level control is to be located.

2. Insert a full standard 1-1/4” NPT pipe coupling halfway through the hole. Weld the coupling into place.

3. Loosen the paddle lock pin on the shaft and remove the paddle.

4. Insert the hub in the coupling and turn until the conduit opening is in the proper position. (Note: Use anti-seize compound on the hub and coupling threads.)

5. Add a 1/4” pipe extension, cut to desired length, to the spring coupling.

6. Add a 1/4” NPT pipe coupling to the end of the extension pipe.

7. Cut a 1-1/4” support pipe approximately 4” shorter than the overall length of the shaft and extension.

8. Slide the 1-1/4” support pipe over the shaft and extension and tighten into the welded 1-1/4” coupling.

9. Insert the paddle onto 1/4” pipe coupling and tighten.

10. Drill holes for lock pins. Replace pins. Refer to the wiring procedures on page 12.
Spring Coupling:

The spring coupling works to absorb heavy loads, side loads and loads caused by product surges. This will protect the internal workings and extend the life of the Hopper Level Control. A spring coupling should be used with heavy materials and in top mount installations, if a solid shaft extension is utilized.

Protective Baffles: (See Figure 6)

The installation of protective baffles for low level monitoring is recommended for materials that weigh more than 65 lbs/ft³ (104 kg/m³), have a tendency to pack, bridge, arch, or have unusual flow characteristics. This baffle can be created using a number of materials including angle iron, welded plates and pipe sections. This structure will keep the full weight of the material from damaging the bin monitor. The baffle should be welded to the bin wall and should not extend more than 7 inches [177.8 mm] into the bin. Also, the lowest point of the baffle should be approximately 6 inches [152.4 mm] above the top of the paddle arc.

Figure 6
Wiring Procedures: (See Figure 7)

1. **Explosion Proof Precautions** - Observe the regulations listed in the National Electrical Code regarding equipment in hazardous locations. In particular, install a conduit seal fitting within 2 inches of the Hopper Level Control, ensure power is disconnected whenever the cover is removed, and upon completion ensure cover is completely re-attached.

2. **Factory Wiring** - The industry exclusive motor shutoff feature is pre-wired at the factory and must not be altered in the field. The jumper wire from the main terminal block to the motor switch must not be removed.

3. **Permanently Connected Equipment** – Disconnecting devices shall be included in the system installation. In installations were multiple circuits are used, individual disconnects are required. Each of the disconnects shall be within close proximity of the equipment, accessible to operators, and marked appropriately as the disconnect for the associated circuit. Assure the disconnect ratings are appropriately sized for the circuit protected (See Specifications).

4. **Circuit Separation** - Since the SLC-B / SXLC-B single wiring compartment cannot absolutely protect against physical contact between multiple circuits, it is required that all wiring used must have an insulation rating of 300v minimum, and a temperature rating of 221 °F (105° C) minimum.

5. **Protective Earthing** - Each SLC-B / SXLC-B is provided with a “protective conductor terminal” which shall be terminated to the local earth ground potential to eliminate shock hazard. Select wire size that can carry in excess of the sum of all circuit’s maximum amperage.

6. **Power Input** - Verify the intended voltage supply is compatible with the voltage configuration indicated on the external nameplate. Connect power as shown in Figures 7.

7. **Output Contacts** - (See Figure 7) When the paddle is free to turn, the two switches in the SLC-B / SXLC-B are in their normal condition (i.e. N.C. contacts are closed to COM, and N.O. contacts are open to COM). However, when material surrounds the paddle preventing it from turning, the motor rotates on a switch actuating plate which activates the switches into opposite from normal condition (i.e. N.C. contacts are open to COM, and N.O. contacts are closed to COM). When selecting which switch to wire, the following should be considered:

   **Motor Switch: (Right Hand Switch)**
   a. The load must be capable of operating at the same voltage as the unit's motor.
   b. The load must be tolerant of periodic “on and off” switching, which is caused by minor paddle motion during sensing condition.
   c. The load must not exceed the rated current capacity of the switch.

   **Isolated Switch: (Left Hand Switch)**
   a. Any voltage within limits of the switch can be connected independent of the motor voltage.
   b. This switch permits minor amounts of paddle motion without constant "on and off" signaling.
   c. The load must not exceed the rated current capacity of the switch.
Any Load & Any Voltage Source Within Switch Specifications (115 to 250 VAC / 15A)

Load 1

Load 2

Line

(LH) Isolated Switch

(RH) Motor Switch

Drive Motor

Loads to be Rated at Same Voltage as Power Source

Factory Wiring Do Not Remove

Not Used (Spare)

N  H  (115V ~ (AC) )
L2  L1  (230V ~ (AC) )

Figure 7
SETUP PROCEDURE

Paddle Selection
The best "calibration" can be achieved by proper paddle selection. Incorrect paddle selection may lead to false sensing and therefore a poor "calibration". Syntron Material Handling, LLC offers a variety of interchangeable paddle assemblies to meet the needs of a wide variety of applications. Different material densities, particle sizes and flow characteristics require specific paddles to provide optimum performance. Refer to page 19 for proper paddle selection or contact the factory.

CAUTION: Do not make any alterations to the control without first contacting the Syntron Service Department. Unauthorized alterations will void the warranty. Syntron will not assume responsibility for damage that may occur due to unauthorized alterations to the control. Any alterations will void the UL, CSA, CE, and explosion proof rating of the control.

SENSITIVITY ADJUSTMENT

The SLC-B and SXLC-B Hopper Level Controls contain a sensitivity adjustment and are shipped from the factory, set to actuate at approximately 9 ounces (280 g) of material resistance at the paddle. This is the normal setting for material weighing 50 lbs/ft³ (800 kg/m³). Material weighing more or less than 50 lbs/ft³ (800 kg/m³) may require a change in the sensitivity setting. The control may be used as a Low Level device with materials as low as 6 lbs/ft³ (96 kg/m³) and as a High Level device with materials as low as 10 lbs/ft³ (160 kg/m³). An alternate paddle may be required to obtain the desired switching characteristics for your material. Refer to page 19 for proper paddle selection.

To adjust the sensitivity of your control:

1. Setting Upon Receipt - (See Figure 8) All rotary paddle bin monitors are shipped from the factory with the spring tension preset at the mid-range sensitivity setting. In most applications this setting results in acceptable operation assuming proper paddle selection. Setting can be verified by locating the cotter pin holding the spring to the switch bracket frame. The cotter pin will be inserted into the middle hole.

2. To Increase the Sensitivity - When sensing extremely light materials (less than 10 lbs/ft³ (160 kg/m³) or 5 ounces (155 g) of material resistance), it is desirable to move the cotter pin to the hole, which exerts minimum spring tension. The reduced spring tension will permit switch actuation with less material restriction at the paddle.

3. To Decrease the Sensitivity - When sensing extremely heavy materials (greater than 75 lbs/ft³ (1201 kg/m³) or 12 ounces (373 g) of material resistance) or materials which have a tendency to stick or build up around shaft seal, it is desirable to move the cotter pin to the hole which exerts maximum spring tension. The increased spring tension will require greater material restriction at the paddle but will prevent cases of the sensor remaining in the activated condition when material is absent.
OPERATION

After installation and adjustments are complete, the operation of the hopper level control is automatic.

In operation, the paddle is held immovable by the surrounding material. As the level of material decreases in the hopper, the material falls away from the paddle blades. Once free, the paddle begins a slow rotation simultaneously triggering a signal that can be used to perform a variety of functions.
MAINTENANCE

Syntron® Hopper Level Controls are virtually maintenance free.

The motor does not require lubrication.

⚠️ WARNING: Disconnect the electrical supply before performing any type of maintenance work.

Motor Replacement: (See figure 9)

1. Disconnect power source from Hopper Level Control.
2. Disconnect motor leads from incoming terminal block and from motor switch.
3. Remove the four screws holding the switch bracket assembly to the housing. Drape switch bracket over the side of the housing so the motor is completely accessible. DO NOT over extend the spring.
4. Remove the two screws holding the motor to the actuator plate thereby freeing motor.
5. Install new motor and retain with two screws.
6. Install the switch bracket and fasten with four screws.
7. Fasten motors leads to terminal block and motor switch. (Lead orientation does not matter on SLC_B / SXLC-B motors.)
8. Reconnect the power source to the Hopper Level Control.

Switch Replacement: (See Figure 9)

1. Disconnect power source from the Hopper Level Control.
2. Remove the four screws holding the switch bracket assembly to the housing. Raise the bracket out of housing far enough to access the switches. DO NOT over extend the spring.
3. Disassemble the switch from the switch bracket by removing the screws and nuts. Replace switch and reassemble using the same insulation barriers and hardware.
4. Install the switch bracket and fasten with four screws. Twist the external drive shaft and verify both switches are actuating. The isolated switch should always activate before the motor switch.
5. Reconnect the power source to the Hopper Level Control.
SENSITIVITY ADJUSTMENT

The SLC-B and SXLC-B Hopper Level Controls contain a sensitivity adjustment and are shipped from the factory, set to actuate at approximately 9 ounces of material resistance at the paddle. This is the normal setting for material weighing more or less than 50 pounds per cubic foot. Material weighing more or less than 50 pounds per cubic foot may require a change in the sensitivity setting.

To adjust the sensitivity of your control:

WARNING: Before performing any maintenance work, the electrical supply must be disconnected.

1. Disconnect the control from the main power source and remove the cover from the unit.
2. Locate the spring fastened by a cotter pin between the motor and the switch bracket. Using a pair of needle-nose pliers, remove the cotter pin and release the spring from the support bracket.
3. Relocate the spring to one of the other holes and refasten the cotter pin. Three holes are provided for sensitivity adjustment. The hole located nearest the edge of the switch support bracket will provide approximately 12 ounces of resistance; the middle hole – 9 ounces; the remaining hole – 5 ounces. If a stronger setting than the maximum is required, please contact the factory for additional information.
## TROUBLESHOOTING:

<table>
<thead>
<tr>
<th>PROBLEM</th>
<th>CAUSE / SOLUTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>The paddle does not rotate when material is absent and the sensor is in “no sensing” mode</td>
<td>Verify electrical power is connected to the proper terminations (See wiring procedure, page 12) and that it is the proper voltage as depicted on the cover. Verify jumper wire is in place between the power terminal and the motor switch (See wiring diagram, page 13). Verify motor operation by connecting the two motor leads directly to the incoming power. Motor will rotate if operational. Reconnect motor leads. Verify condition of motor switch by measuring voltage between its COM and NC terminals. Replace the switch if a voltage reading equivalent to the power source exists. Verify if motor is rotating. Replace the clutch mechanism if the motor is turning but the paddle is not.</td>
</tr>
<tr>
<td>The paddle does not rotate when material is absent and the sensor is in “sense” mode.</td>
<td>Verify condition of sensitivity spring. It should not be cut, broken or excessively stretched to the point that it loses its ability to retract motor to “no sense” condition. Replace if necessary. Verify status of material around shaft and hub of Hopper Level Control. Excessive buildup may restrict shaft from returning to “no sense” condition. Clean material buildup. Verify if drive shaft is free to rotate by manually twisting paddle. If rotation is restricted, replace the outer seal and the two internal bearings.</td>
</tr>
<tr>
<td>The paddle rotates but material is not sensed when the paddle is covered.</td>
<td>Verify isolated switch is activated prior to the motor switch when the paddle is halted. If sequence is incorrect, realign switches on the bracket. Consult the factory if problem persists. Verify switch operation by measuring continuity while in the &quot;sense&quot; and &quot;no sense&quot; modes. Replace switches if contact states are incorrect. Verify that the paddle being used in the application follows the guidelines outlined in the Paddle Selection Guide (page 19). Change paddle to one capable of sensing lighter material.</td>
</tr>
</tbody>
</table>
Paddle Selection Guide

Proper selection of Paddle Assembly is essential for reliable operation. All Paddle Assemblies are interchangeable.

<table>
<thead>
<tr>
<th>Paddle Part Number</th>
<th>Weight of Bulk Material *</th>
<th>Description</th>
<th>Dimensions</th>
</tr>
</thead>
<tbody>
<tr>
<td>A-110898-B</td>
<td>Less Than 24 lbs/ft³ (384 kg/m³)</td>
<td>Large 3 – vane Stainless Steel</td>
<td>[Diagram]</td>
</tr>
<tr>
<td>A-110898-A</td>
<td>24 - 74 lbs/ft³ (384 - 1185 kg/m³)</td>
<td>Standard 3 – vane Stainless Steel</td>
<td>[Diagram]</td>
</tr>
<tr>
<td>A-110898-C</td>
<td>More Than 74 lbs/ft³ (1185 kg/m³)</td>
<td>2 – vane Stainless Steel</td>
<td>[Diagram]</td>
</tr>
<tr>
<td>A-110898-D</td>
<td>For Aggregate or Other Heavy Irregular Materials</td>
<td>Ex-Flex With 3 – Ply Belt Vane</td>
<td>[Diagram]</td>
</tr>
<tr>
<td>A-110898-E **</td>
<td>More Than 32 lbs/ft³ (512 kg/m³)</td>
<td>Insertable Paddle Stainless Steel</td>
<td>[Diagram]</td>
</tr>
</tbody>
</table>

*Hopper level controls installed at a low level in bin or hopper should be protected by a baffle if bulk material weighs over 65 lbs/ft³ (1041 kg/m³).

**Paddle will slip through one–half of a standard pipe coupling welded to bin wall. Installation, inspection, and servicing can be performed from outside the bin.
3/4" NPT
(2) Holes
NOTE: 1 Hole Is
Shipped Plugged

(6) Holes Equally
Spaced on a 7"
[178 mm] Dia. B.C.
for 5/16" [7.93 mm] Bolts

REF: Bin Wall
<table>
<thead>
<tr>
<th>ITEM</th>
<th>DESCRIPTION</th>
<th>QTY.</th>
<th>PART NO.</th>
</tr>
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<tbody>
<tr>
<td>A</td>
<td>♦ SLC Name Plate w/ Warning Labels</td>
<td>1</td>
<td>110900-A</td>
</tr>
<tr>
<td></td>
<td>♦ SXLC Name Plate w/ Warning Labels</td>
<td>1</td>
<td>110900-B</td>
</tr>
<tr>
<td>B</td>
<td>Micro Switch (125 / 250 VAC / 15A)</td>
<td>2</td>
<td>0051X538</td>
</tr>
<tr>
<td>D</td>
<td>Drive Motor Assembly (115V / 4W 50/60 Hz)</td>
<td>1 Only</td>
<td>0044X153</td>
</tr>
<tr>
<td></td>
<td>Drive Motor Assembly (240V / 4W - 50/60 Hz)</td>
<td>1 Only</td>
<td>0044X157</td>
</tr>
<tr>
<td>C</td>
<td>Return Spring Assembly</td>
<td>1</td>
<td>0372X005</td>
</tr>
<tr>
<td>E</td>
<td>Bearing</td>
<td>2</td>
<td>0372X008</td>
</tr>
<tr>
<td>F</td>
<td>Mounting Plate – Full Coupling (Carbon Steel)</td>
<td>110899-A</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Mounting Plate – Half Coupling (Carbon Steel)</td>
<td>110899-B</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Mounting Plate – Half Coupling (AISI 304 Stainless Steel)</td>
<td>1 Only</td>
<td>110899-A1</td>
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<tr>
<td></td>
<td>Mounting Plate – Half Coupling (AISI 304 Stainless Steel)</td>
<td>110899-B1</td>
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</tr>
<tr>
<td>G</td>
<td>Spring Coupling</td>
<td>1</td>
<td>0206X014</td>
</tr>
<tr>
<td>H</td>
<td>Paddle (Standard 3 vane, 7 in diam.)</td>
<td>1</td>
<td>110898-A</td>
</tr>
<tr>
<td></td>
<td>Paddle (3 vane, 9 in diam.)</td>
<td>1</td>
<td>110898-B</td>
</tr>
<tr>
<td></td>
<td>Paddle (2 vane, 1 in x 5 in)</td>
<td>1</td>
<td>110898-C</td>
</tr>
<tr>
<td></td>
<td>Paddle (Ex-Flex with 3-Ply Belt Vane)</td>
<td>1</td>
<td>110898-D</td>
</tr>
<tr>
<td></td>
<td>Paddle (7 in x 6 -¼ in)</td>
<td>1</td>
<td>110898-E</td>
</tr>
</tbody>
</table>

♦ Do not remove or paint over safety labels. Should safety labels require replacement, contact Syntron Material Handling, LLC. for an additional supply free of charge.
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