



# Best/Flex® ULTRA Gravity Conveyor

## Operation, Maintenance and Parts Manual

Factory Order Number: \_\_\_\_\_

Serial Number: \_\_\_\_\_

Ship Date: \_\_\_\_\_

### **BEST Conveyors**

4929 Krueger Drive

Jonesboro, AR 72401

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[www.bestconveyors.com](http://www.bestconveyors.com)

Please visit our Web site and click on downloads for the latest updates to this manual.

Please read entire manual before operating unit.

# Thank You

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Thank you for purchasing our BEST/FLEX conveyor. We realize you had a choice and are pleased that you selected a conveyor from BEST Conveyors.

We are providing you with a toll-free number, **800-327-9209**, to put you directly in touch with our Customer Service Department. Call us for any reason. We realize it's not our opinion of our products and service that counts—it's **your** opinion we live by!

We are in business to serve our customers. From the factory or the field, we are eager to help. Our service technicians have the experience and expertise to ensure a smooth transition between your fixed conveyors and your BEST system. You will receive the same high level service from BEST before and after the sale.

Again, we appreciate your purchase and hope you will continue to select the BEST solution for your material handling needs.

Sincerely,

The Associates of BEST Conveyors  
Jonesboro, Arkansas

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# Warranty Statement

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Your Best conveyor is protected by our premier warranty. Best Conveyors will replace, free of charge, parts that are damaged during the course of normal operation due to material or workmanship defects. This warranty extends for a period of two (2) years on all mechanical components and one (1) year on all electrical components (measured from the date you took possession of your conveyor.)

This warranty does not cover damage due to accident, misuse, abuse, and negligence. This warranty does not cover damage due to improper operation or maintenance, connection to improper voltage supply, or attempted repair/modification by anyone other than authorized Best Conveyors service personnel.

For specific warranty information or assistance, please contact your Best Conveyors sales representative at 800-327-9209.

## Maintenance Schedule

Your Best/Flex conveyor is designed to be virtually maintenance free. We do recommend that you regularly inspect the unit to ensure proper operation of mechanical and safety systems.

### **DAILY:**

- Keep your BEST conveyor clean of dirt, debris and grease accumulation
- Inspect leg elevations and adjust, as necessary, to ensure smooth product flow.
- Look for mechanical damage or worn components and replace as necessary.

### **MONTHLY:**

- Check to ensure that all bolts and nuts are moderately tight.

**Caution:** do not over torque as this may cause frame distortion and prevent the system from properly flexing.

### **Required tools to maintain your conveyor include:**

Two each of these size wrenches: 7/16", 1/2" and 9/16".

# Specifications

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Your Best/Flex Ultra conveyor is built according to the following standard specifications:

	<b><u>Best/Flex Ultra</u></b>
<b>Conveyor bed width</b>	
Inches	14, 18, 24
Millimeters	356, 457, 610
<b>Load capacity per linear foot (305 mm)</b>	
Pounds	175
Kilograms	80
<b>Skate wheels per axle</b> (1.8" steel or black nylon)	
14" (356 mm)	5
18" (457 mm)	6
24" (610 mm)	7
<b>Casters</b> (brake and non-brake swivel)	
Inches	5 x 1
Millimeters	127 x 25
<b>Adjustable conveyor height</b>	
Inches	28 ½ to 41 ½
Millimeters	724 to 1,054
<b>Expansion to compaction ratios</b>	
5" (127 mm) axle center	4.0:1
4" (102 mm) axle center	3.2:1
3" (76 mm) axle center	2.4:1

For custom applications, please see the Product Options pages or contact us: **800-327-9209**.

# Installation and Operating Instructions

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- 1) Unpack and inspect your BEST expandable conveyor.
- 2) Unlock the casters and roll the conveyor into the working area. Lock the casters.
- 3) If your BEST conveyor arrived in two or more sections that need reconnecting into one system, see connecting instructions below:
  - Required assembly tools include: E-Clip Tool.
  - a) Roll section "A" and section "B" together making sure outside side bars are on the outside and inside side bars are on the inside (both sides).
  - b) Slide axle of section "B" back and forth to connect section "A." Fasten E-Clips onto axle of both sides.
  - c) Connect section "A" bottom side bar to section "B" bottom side bar (both sides). Insert pin into hole and fasten E-Clip to pin.
- 4) The legs are adjustable from 28" to 41" (724 mm to 1,054 mm). The leg elevation is factory set at 28" (724 mm). For proper gravity flow, a 5/16" (8mm) decline per expanded foot (305 mm) is recommended. This may vary with carton weight or your specific applications.
- 5) To expand the conveyor:
  - a) Unlock the casters.
  - b) Grasp the handles on each side at both ends of the conveyor and pull until the conveyor is properly expanded.
  - c) Lock casters and begin use.
- 6) To set leg elevation for your application:
  - a) With the conveyor expanded, unscrew the adjustment knobs on the first leg set on the infeed end and lift up on the conveyor to height needed. Tighten adjustment knobs.
  - b) Do the same on the last leg set on the discharge end.
  - c) Adjust all legs in between to obtain proper gravity flow.
  - d) Close conveyor, check for slopes and valleys between the legs and readjust if needed.

# Troubleshooting Guide

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<b><u>Symptom</u></b>	<b><u>Possible Cause</u></b>	<b><u>Recommended Action</u></b>
Conveyor does not open or roll smoothly.	Casters are locked or clogged with debris.	Check casters and unlock or clear as necessary.
	Bolts and nuts have been over tightened.	Check bolt tension.
	Conveyor has suffered physical damage.	Check unit and replace damaged parts.
Product stops on conveyor or does not flow smoothly.	Leg elevations are out of height adjustment.	Readjust legs per the Installation section in this Manual (page 6)
	Skate wheels are jammed.	Check and clear debris as necessary.
	Conveyor has suffered physical damage.	Check unit and replace damaged parts.

## Service Instructions

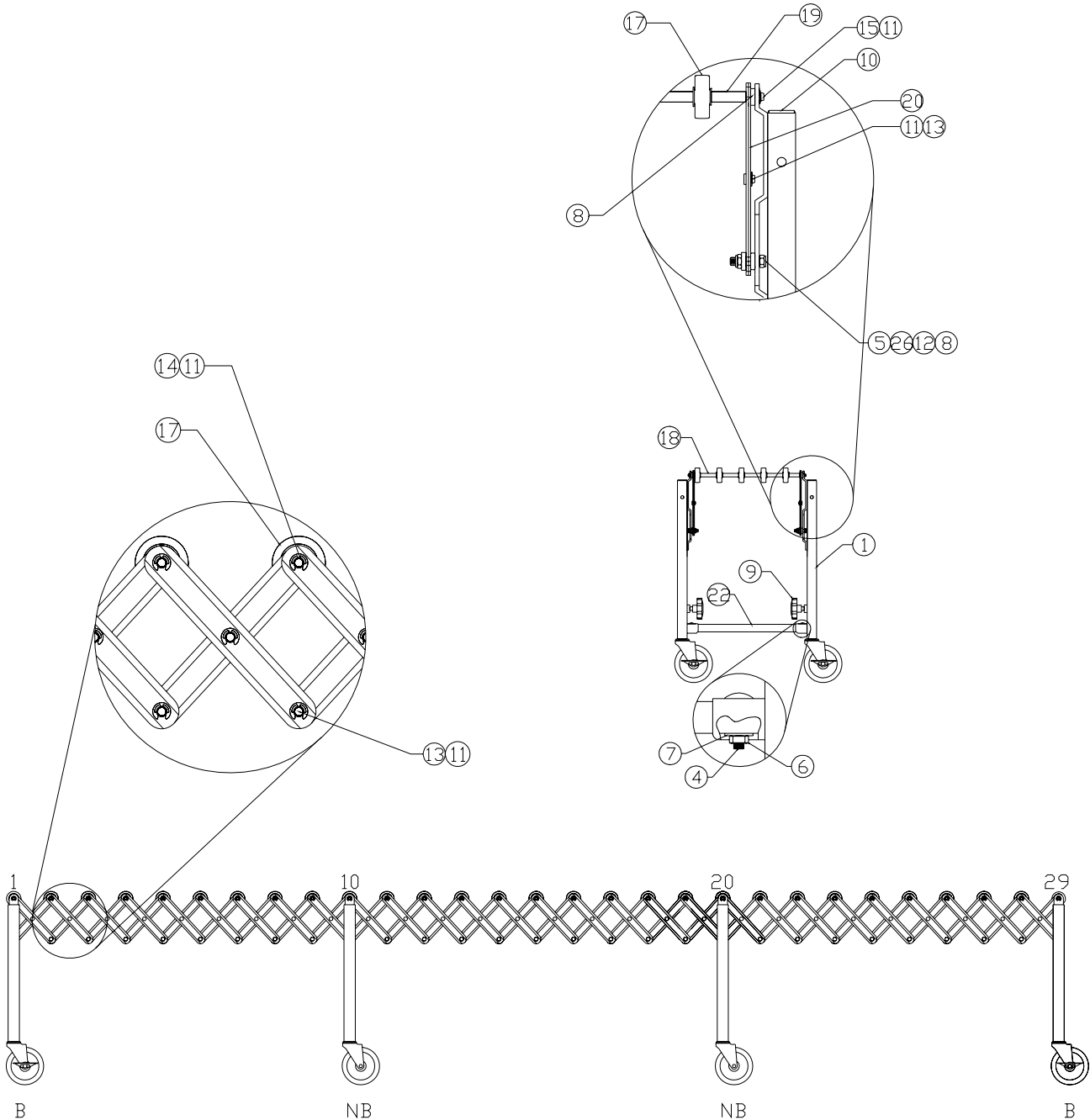
If your BEST conveyor needs service or replacement parts, please contact your distributor or our factory toll free at: **800-327-9209**.

## Safety Information

- Move conveyor only by grasping the handles located on each side at both ends of the conveyor.
- When expanding or compacting your conveyor; keep hands, clothing and other items clear of the side bars.
- Do not exceed the conveyor load capacity, as it may result in possible operator injury or conveyor damage.
- Avoid wearing excessively loose clothing when working with moving equipment.
- Keep long hair pulled up to prevent it from becoming caught in moving parts.
- Broken or worn parts must be immediately replaced.
- BEST conveyors must only be serviced by properly trained and qualified technicians.

# Product Drawing: Best/Flex Ultra - 14"

NOTE: ⑩ USED ONLY ON BOTH ENDS OF CONVEYOR

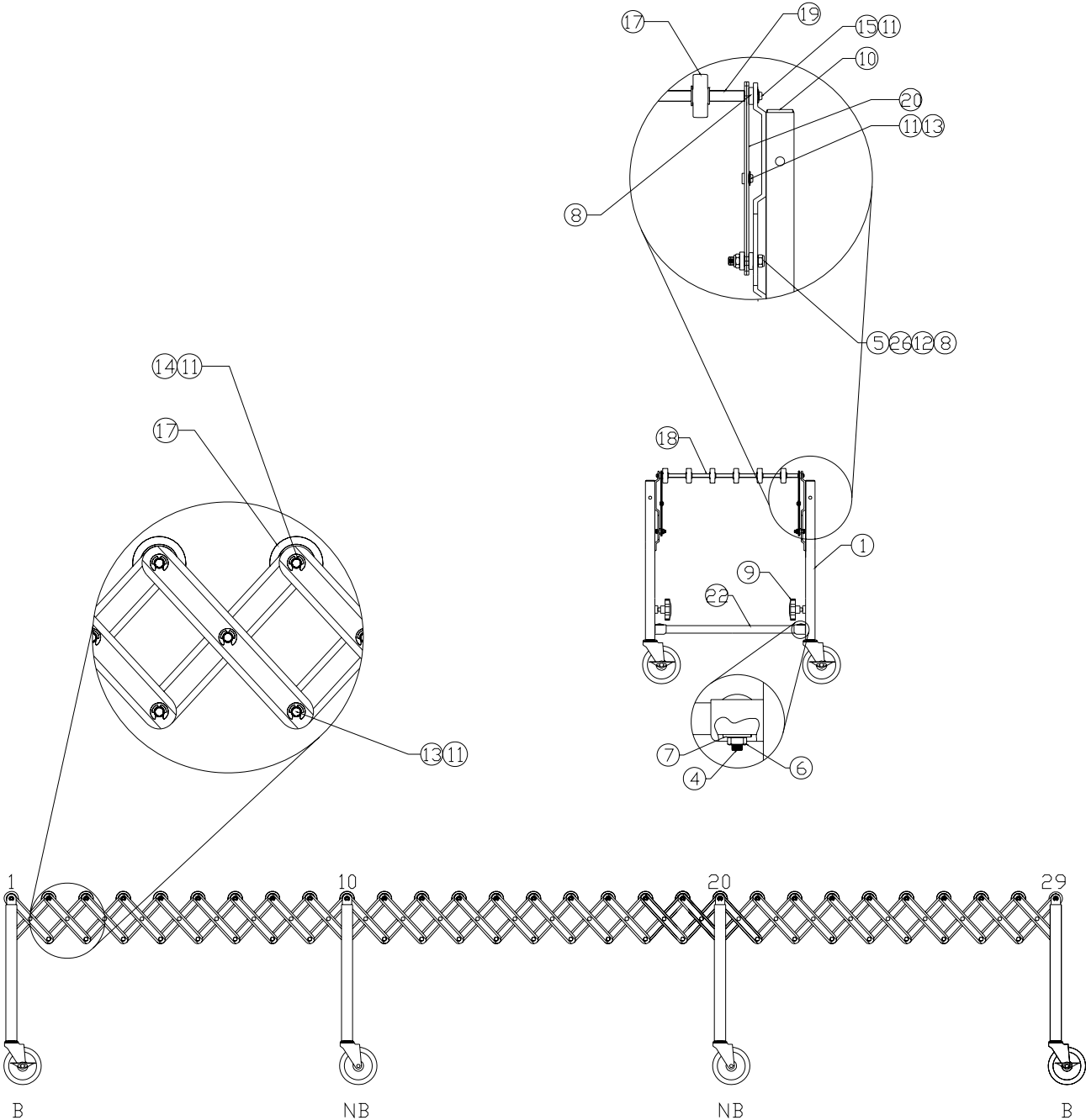


## Parts List: Best/Flex Ultra - 14"

Item	Part No.	Description
1	<b>04950-21</b>	Upper Leg Weldment 21" - 5" Center
1	<b>04940-21</b>	Upper Leg Weldment 21" - 4" Center
1	<b>04930-21</b>	Upper Leg Weldment 21" - 3" Center
2	<b>06713-SLC5</b>	Inner Leg Assembly w/ 5" x 7/8" Brake Caster
3	<b>06714-CNB5L</b>	Inner Leg Assembly 18" x 5" x 7/8" Non-Brake Caster
4	<b>10577</b>	Carriage Bolt, 5/16"-18 x 1-3/4"
5	<b>11700</b>	Nylon Jam Nut, 3/8"
6	<b>11701</b>	Lock Nut, 5/16"-18
7	<b>12085</b>	Flat Washer, 5/16"
8	<b>12185</b>	Spacer, 3/4" x 13/32" x 0.20"
9	<b>12291</b>	Height Adjustment Knob
10	<b>14070</b>	Leg Cap
11	<b>300778</b>	3/8" E-ring
12	<b>300779</b>	Double-Shafted Bolt
13	<b>300781</b>	3/8" Grooved Pin
14	<b>300784</b>	Axle for 14" Wide Best/Flex Ultra
15	<b>300785</b>	Axle Leg for 14" Wide Best/Flex Ultra
16	<b>300788</b>	Spacer, 3/4" OD x 13/32" x 0.089"
17	<b>300794</b>	Steel Skatewheel, 1.8" OD x 0.5" ID
17	<b>300791</b>	Black Nylon Skate Wheel, 1.8"OD x 0.5"ID
18	<b>300799</b>	Spacer, 0.625" OD x 0.515" ID x 2.115" Long (14" wide)
19	<b>300800</b>	Spacer, 0.625" OD x 0.515" ID x 1.455" Long (14" wide)
20	<b>400700</b>	Steel Sidebars, 1-1/4" x 8-5/8"
22	<b>60604-14</b>	Crosstube, Upperleg 14"
23	<b>99021-5</b>	Best/Flex Ultra Decal
24	<b>99022</b>	Best/Flex Ultra Warning Decal
25	<b>99023</b>	Made in the USA Decal
26	<b>11120</b>	Nylon Cap Locknut 1/4" - 20

# Product Drawing: Best/Flex Ultra - 18"

NOTE: 16 USED ONLY ON BOTH ENDS OF CONVEYOR

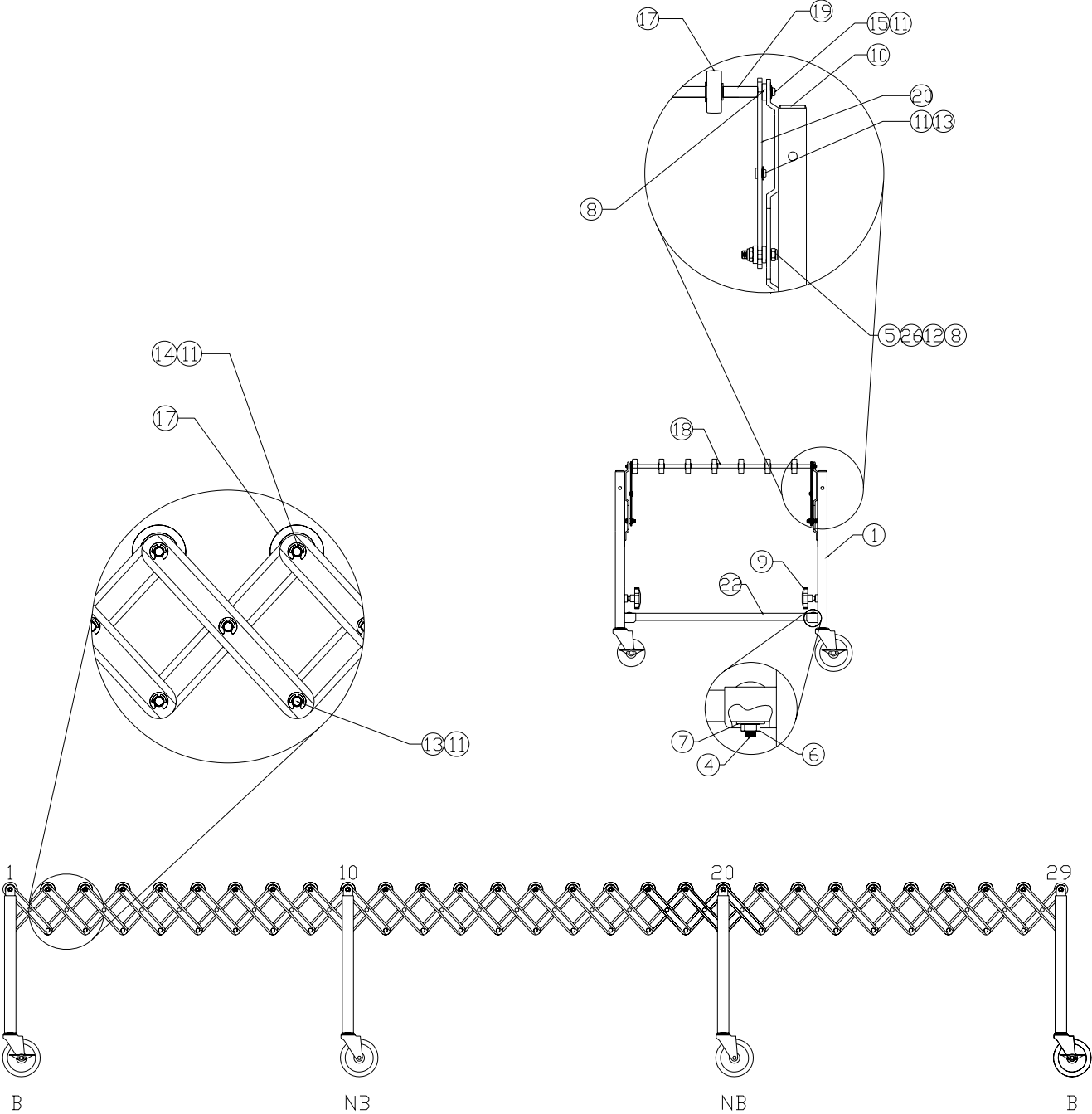


## Parts List: Best/Flex Ultra - 18"

Item	Part No.	Description
1	<b>04950-21</b>	Upper Leg Weldment 21" - 5" Center
1	<b>04940-21</b>	Upper Leg Weldment 21" - 4" Center
1	<b>04930-21</b>	Upper Leg Weldment 21" - 3" Center
2	<b>06713-SLC5</b>	Inner Leg Assembly w/ 5" x 7/8" Brake Caster
3	<b>06714-CNB5L</b>	Inner Leg Assembly 18" x 5" x 7/8" Non-Brake Caster
4	<b>10577</b>	Carriage Bolt, 5/16"-18 x 1-3/4"
5	<b>11700</b>	Nylon Jam Nut, 3/8"
6	<b>11701</b>	Lock Nut, 5/16"-18
7	<b>12085</b>	Flat Washer, 5/16"
8	<b>12185</b>	Spacer, 3/4" x 13/32" x 0.20"
9	<b>12291</b>	Height Adjustment Knob
10	<b>14070</b>	Leg Cap
11	<b>300778</b>	3/8" E-ring
12	<b>300779</b>	Double-Shafted Bolt
13	<b>300781</b>	3/8" Grooved Pin
14	<b>300782</b>	Axle for 18" Wide Best/Flex Ultra
15	<b>300783</b>	Axle Leg for 18" Wide Best/Flex Ultra
16	<b>300788</b>	Spacer, 3/4" x 13/32" x 0.089"
17	<b>300794</b>	Steel Skatewheel, 1.8" OD x 0.5" ID
17	<b>300791</b>	Black Nylon Skate Wheel, 1.8"OD x 0.5"ID
18	<b>300789</b>	Spacer, 0.625" OD x 0.515" ID x 2.30" Long (18" wide)
19	<b>300790</b>	Spacer, 0.625" OD x 0.515" ID x 1.55" Long (18" wide)
20	<b>400700</b>	Steel Sidebars, 1-1/4" x 8-5/8"
22	<b>60604-18</b>	Crosstube, Upperleg 18"
23	<b>99021-5</b>	Best/Flex Ultra Decal
24	<b>99022</b>	Best/Flex Ultra Warning Decal
25	<b>99023</b>	Made in the USA Decal
26	<b>11120</b>	Nylon Cap Locknut 1/4" - 20

# Product Drawing: Best/Flex Ultra - 24"

NOTE: 16 USED ONLY ON BOTH ENDS OF CONVEYOR



## Parts List: Best/Flex Ultra - 24"

<b>Item</b>	<b>Part No.</b>	<b>Description</b>
1	<b>04950-21</b>	Upper Leg Weldment 21" - 5" Center
1	<b>04940-21</b>	Upper Leg Weldment 21" - 4" Center
1	<b>04930-21</b>	Upper Leg Weldment 21" - 3" Center
2	<b>06713-SLC5</b>	Inner Leg Assembly w/ 5" X 7/8" Brake Caster
3	<b>06714-CNB5L</b>	Inner Leg Assembly 18" X 5" X 7/8" Non-Brake Caster
4	<b>10577</b>	Carriage Bolt 5/16"-18 x 1-3/4"
5	<b>11700</b>	Nylon Jam Nut 3/8"
6	<b>11701</b>	Lock Nut 5/16"-18
7	<b>12085</b>	Flat Washer 5/16"
8	<b>12185</b>	Spacer, 3/4" x 13/32" x 0.20"
9	<b>12291</b>	Height Adjustment Knob
10	<b>14070</b>	Leg Cap
11	<b>300778</b>	3/8" E-ring
12	<b>300779</b>	Double Shafted Bolt
13	<b>300781</b>	3/8" Grooved Pin
14	<b>300786</b>	Axle for 24" Wide Best Flex Ultra
15	<b>300787</b>	Axle Leg for 24" Wide Best Flex Ultra
16	<b>300788</b>	Spacer, 3/4" x 13/32" x 0.089"
17	<b>300794</b>	Steel Skatewheel, 1.8" OD x 0.5" ID
17	<b>300791</b>	Black Nylon Skate Wheel, 1.8"OD x 0.5"ID
18	<b>300797</b>	Spacer, 0.625" OD x 0.515" ID x 2.742" Long (24"wide)
19	<b>300798</b>	Spacer, 0.625" OD x 0.515" ID x 1.773" Long (24" wide)
20	<b>400700</b>	Steel Sidebars, 1-1/4" x 8-5/8"
22	<b>60604-24</b>	Crosstube, Upperleg 24"
23	<b>99021-5</b>	Best/Flex Ultra Decal
24	<b>99022</b>	Best/Flex Ultra Warning Decal
25	<b>99023</b>	Made in the USA Decal
26	<b>11120</b>	Nylon Cap Locknut 1/4" - 20

## Recommended Spare Parts for Best/Flex Ultra

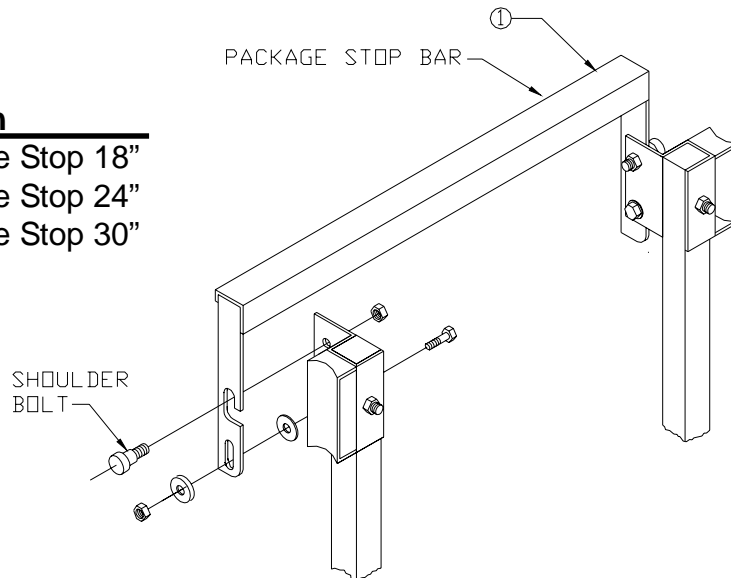
Part No.	Description	Quantity
<b>04950-21</b>	Upper Leg Weldment 21" - 5" Center	1
<b>04940-21</b>	Upper Leg Weldment 21" - 4" Center	1
<b>04930-21</b>	Upper Leg Weldment 21" - 3" Center	1
<b>60604-14</b>	Cross Tube, 1" SQ. x 14"	1
<b>60604-18</b>	Cross Tube, 1" SQ. x 18"	1
<b>60604-24</b>	Cross Tube, 1" SQ. x 24"	1
<b>06713-SLC5</b>	Inner Leg Assembly w/ 5" x 7/8" Brake Caster	1
<b>06714-CNB5L</b>	Inner Leg Assembly 18" x 5" x 7/8" Non-Brake Caster	1
<b>08018</b>	Best/Flex Ultra Kit for 14" Wide	1
<b>08019</b>	Best/Flex Ultra Kit for 18" Wide	1
<b>08020</b>	Best/Flex Ultra Kit for 24" Wide	1
10577	Carriage Bolt 5/16"-18 x 1-3/4"	1
11700	Nylon Jam Nut, 3/8"	1
11701	Lock Nut, 5/16"-18	1
12085	Flat Washer, 5/16"	1
12185	Spacer, 3/4" x 13/32" x 0.20"	1
12291	Height Adjustment Knob	1
14070	Leg Cap	1
300778	3/8" E-ring	1
300779	Double-Shafted Bolt	1
300781	3/8" Grooved Pin	1
300784	Axle for 14" Wide Best/Flex Ultra	1
300785	Axle Leg for 14" Wide Best/Flex Ultra	1
300782	Axle for 18" Wide Best/Flex Ultra	1
300783	Axle Leg for 18" Wide Best/Flex Ultra	1
300786	Axle for 24" Wide Best/Flex Ultra	1
300787	Axle Leg for 24" Wide Best/Flex Ultra	1
300788	Spacer, 3/4" x 13/32" x 0.089"	1
300794	Steel Skatewheel, 1.8" OD x 0.5" ID	1
300791	Black Nylon Skate Wheel, 1.8" OD x 0.5" ID	1
300799	Spacer, 0.625" OD x 0.515" ID x 2.115" Long (14" wide)	1
300800	Spacer, 0.625" OD x 0.515" ID x 1.455" Long (14" wide)	1
300789	Spacer, 0.625" OD x 0.515" ID x 2.30" Long (18" wide)	1
300790	Spacer, 0.625" OD x 0.515" ID x 1.55" Long (18" wide)	1
300797	Spacer, 0.625" OD x 0.515" ID x 2.742" Long (24" wide)	1
300798	Spacer, 0.625" OD x 0.515" ID x 1.773" Long (24" wide)	1
400700	Steel Sidebars, 1-1/4" x 8-5/8"	1

# Product Options: Package Stop Kit and Swivel Caster

## Package Stop

The Package Stop is a unique design that stops cartons at the end of the conveyor and folds down easily when not in use.

Item No.	Part No.	Description
1	06360-18	Kit, Package Stop 18"
	06360-24	Kit, Package Stop 24"
	06360-30	Kit, Package Stop 30"

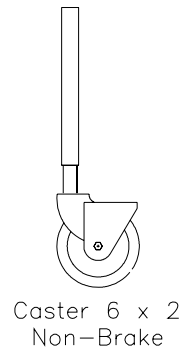
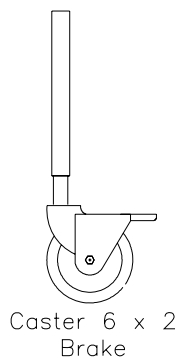


## Operating Instructions

To operate the Package Stop, simply pull upward on the Package Stop Bar until it clears the Shoulder Bolt located on each side of the conveyor. Then rotate the Package Stop downward until it is parallel to the legs of the conveyor. To engage the Package Stop simply rotate the Package Stop Bar upward and lock over the Shoulder Bolt on each side of the conveyor. Be sure that the Package Stop is secured to prevent damage to product being conveyed.

## 6" Swivel Caster

The 6" Swivel Casters provide easier rolling over uneven surfaces. 6" x 2" (152 mm x 51 mm) casters add 1 1/2" (28 mm) to conveyor height.



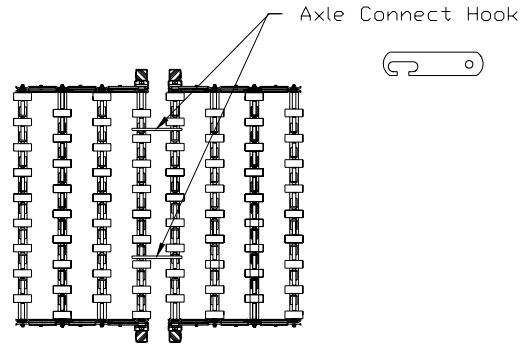
Note: For more information about 6" Swivel Casters, please consult the factory.

# Product Options: Axle Connect and Leg Connect Hooks

## Axle Connect Hooks

Axle Connect Hooks link two or more conveyors together to serve as one continual conveying surface.

Item No.	Part No.	Description
1	60276	Axle Connect Hooks (Qty. required: 2)



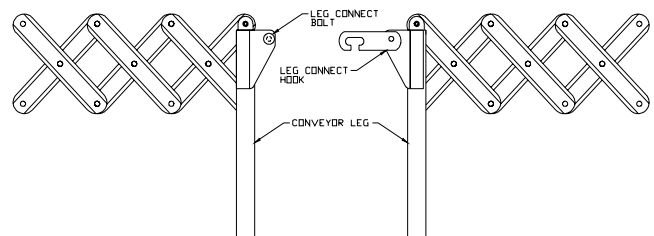
### Operating Instructions

Axle Connect Hooks link two or more conveyors. Simply push the conveyors together and engage the Axle Connect Hooks located on the last or end axle of the conveyor onto the first or end axle of the mating conveyor.

## Leg Connect Hooks

Leg Connect Hooks link two or more conveyors together to serve as one continual conveying surface.

Item No.	Part No.	Description
1	06301-4	Kit, Leg Connect Hooks 5" Axle Centers
	06301-3	Kit, Leg Connect Hooks 4" Axle Centers
	06301-2	Kit, Leg Connect Hooks 3" Axle Centers



### Operating Instructions

Leg Connect Hooks link two or more conveyors. Push the conveyors together and engage the Leg Connect Hooks located on each side of the conveyor legs onto the Leg Connect Bolts located on each side of the mating conveyor.



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