



## START-UP

JOB SITE/SERIAL # \_\_\_\_\_

### Basic Start-up Overview and Checklist

Read this guide before starting the procedure! Failure to follow these guidelines could compromise warranty considerations on the part of Champion and Bi-line.

For specific information about vendor assemblies in this system supplied by Champion or Bi-line, refer to the respective manufacturers' documents included in the system manuals.

**WARNING! HIGH VOLTAGE DANGER!** Always be aware when performing mechanical or electrical maintenance procedures. Lockout and tag out the electrical disconnects if necessary.

**START-UP INSPECTION and PROCEDURE** This may include some peripheral and complementary equipment supplied by others that may be interconnected to the Bi-line system. Make sure these components have also been properly prepared for start-up.

- Remove any remaining protective film from the tables and troughs and panels.
- Check that all caulking and sealing has been done and trimmed except for those panels and covers that must remain off until start-up is completed.
- Check base assemblies for proper assembly, secured fasteners, and foot adjustment for good floor contact.
- Check table system for height, alignments, and check for proper drainage by applying reasonable amounts of water to the table sections. Make sure there are no areas that retain standing water. Check for leaks between adjoining sections and resolve as necessary.
- Check and ensure that any sight/sound barriers, window frames, and any other accessory pieces have been installed properly and that any adjoining components are joined properly to them.
- Check and ensure that all plumbing and piping connections are properly joined, are secure and stable, and that none of the fitted connections are cross-threaded.
- Check that all wiring supplied and completed by others is proper and completed.
- Check the wiring and plumbing of any peripheral equipment where it interfaces with the conveyor system. Ensure that the interface is proper and that its operation will not adversely affect the operation of any equipment supplied by Bi-line or Champion Industries.
- Check and ensure that all utilities voltages and pressures are as specified, both on the supply side as well as at the machine(s).
- Make sure all wire bundles are fed through the wireways and are secured.

- Check all machine mounted electrical boxes for proper field wiring connections.
- Inspect the motor and drive system components before start-up for damage, loose or missing components and fasteners, obstructions, and debris, etc.
- Check drive system for alignment of components and proper tension where applicable.
- Check that the motors are clean and the ventilation is unobstructed. Oily vapor, dust, lint, debris, etc., can accumulate and block motor ventilation which will cause overheating and premature motor failure.
- Check lubrication and oil levels of the components according to the manufacturer's recommendations and instructions. **NOTE! Some mechanical components do not require lubrication.** Consult the appropriate sections of the manuals for more information.
- Check for potential safety and mechanical hazards that may have been inadvertently created during the installation process.
- Open the drains (if equipped with valves) and then open the water supply valves and check for leaks BEFORE switching on any of the electrical supply. Resolve any problems found as necessary to meet codes and standards of operation.
- Turn on the main electrical supply to the machine at the machine disconnect or breaker panel and check for proper voltages and ground connections at the feed side of the control panel BEFORE turning on power at the machine. Resolve any issues found as necessary to meet codes and standards of operation.
- Turn ON the main power switch on the control panel.
- Confirm direction of motor rotation before operating the system! Improper direction of rotation will result in damage to equipment!** If any of the motors rotate in the wrong direction, check the wiring at the motor for proper phasing. If the wiring is proper on each end, check the wiring at the field interconnections.
- Start the conveyor and check all mechanical and utility operations. Make any necessary adjustments and ensure that the belt(s) run freely in the guides/tracks and that the tension is correct.
- Observe any stop, limit, fault, or accumulation switches for proper operation and adjust as necessary.
- Review the flow and drainage systems as the system operates and make adjustments as necessary. This includes the troughs and spray systems of any scrapping tables included.
- Observe the operation of any spray systems and gusher nozzles and the related drains. Take corrective actions or make adjustments as necessary. This includes any belt cleaning systems and the related drains.
- Apply the expected loading to the conveyor and check for proper operation and tracking. Adjust as necessary. Make sure all components run without vibration, shuddering, etc.
- Verify that all belt guides are aligned and tightened down to prevent the belt or slat conveyor from catching and being damaged.

- Check the operation of the peripheral equipment connections such as valves, piping, electrical, etc., and any disposals, pulpers, tray carts, lift systems, etc, that mechanically or electrically interface with the conveyor system.
- Observe the interaction of a dish machine and any peripheral equipment with the conveyor system. Make adjustments as necessary and document any discrepancies for later review.
- When inspection and start-up are completed and no issues regarding the conveyor or accumulator systems remain, put all remaining screens, access panels, and covers, etc. in place and seal where applicable.

Any issues that cannot be immediately resolved by the technicians and representatives on-site must be documented and reported to Bi-line Service as soon as possible.

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Comments or corrective actions needed:

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Bi-Line Service Technican \_\_\_\_\_ Date \_\_\_\_\_

Champion/Bi-Line Sales Representative (If Present):

\_\_\_\_\_ Date \_\_\_\_\_

Kitchen/Dish room Manager \_\_\_\_\_ Date \_\_\_\_\_

Send completed form to:  
**service@championindustries.com**  
**or attach it to the invoice when filing for payment.**