Frame
- 12-Gauge, Mild Steel, “Stardust Silver” Powder Coat Painted
- 12-Gauge Stainless Steel, #4 Polish Finish

Turn
- Available in 30°, 45°, & 90°
- UHMW Wearstrip
- Duravar Wearstrip (Inside of Turn)

Intermediate
- Standard Lengths in 120”, 92”, 64”, 36”, 18”
- Also Available 6”-33 ½” (1/2” Increments)
- Tab Return
- Adjustable Cope for Elevation Changes
  - Single Cope for Changes < 15°
  - Double Cope for Between 15° & 30°

Drive End
- 45” Overall Length
- Endcap/Finger Guard
- Contained Catenary
- 2-hole, 1 1/4” Bore Bearing

Idle Ends
- 15” Overall Length
- Endcap/Finger Guard
- 2-hole, 1” Bore Bearing
Standard Modules
- Idle Ends; Drive Ends; Center Drives; 30°, 45°, 90° Turns; Intermediates; Copes (Adjustable Vertical Turns)

Frame Material & Design
- 12-Gauge, Mild Steel, “Stardust Silver” Powder Coat Paint
- 12-Gauge Stainless Steel, #4 Polish Finish
- Open Top Design

Supports
- “H” Style Formed 2” x 2” Angle w/ Bolt Pad Base
- ±4” Elevation Change
- Nominal Elev. Range 24”, 28”, 32”, 36”, 40”, 44”, 48”
Options:
- Ceiling Hanger Brackets

Wearstrips — Carryway
- 1/8” Thick UHMW in Straights
- Turns: UHMW Outside, Duravar Inside

Wearstrip — Return
- 5/8” x 5/8” UHMW Edge Guide

Bearings
- 2-Hole Flange, Painted, Sealed for Life, General Purpose Lube, Steel Insert w/ Set-Screw
Options:
- Polymer Housing, Food Grade Lube
- Zinc Plated or Stainless Steel Inserts
- Safety Covers

Motor/Reducer
- Nord “C” Face Motor, Inverter Duty, VFD & IP55 Rated
- Motor Voltage: 230/460-3-60 AC
- Nord Hollow Bore Reducer
- Corrosion Resistant Aluminum
- Vertical Shaft Mount w/ Torque Arm
Options:
- Below or Above
- Washdown Painted
- Stainless/TuPh Finish

Shafts
- Idle Shaft Dia. 1.0”
- Drive Shaft Dia. 1.25”

Shafts
- See Data Sheet

Conveyor Speeds
- Standard Nominal Speeds (FPM): 40, 60, 100, 125, 165, 250
- Minimum: 30 FPM* Maximum: 290 FPM*
  *Speed obtained using a VFD
- Consult Factory for Speeds Above 300 FPM

Conveyor Accessories
- LBP Roller Transfer
- SS Deadplate
Drive End

Specifications:
- Standard Drive Will be 45” long, Right-Hand (shown), (Unless Otherwise Specified)
- Standard Drive Will be Flush Mount on Left Side
- Shaft Mount Will Include Torque Arm
- See Spec Sheet for Standard Speeds (FPM)
- Support Incline Range ±22°
- Shoes must be moved to outside edge of frame to run friction top chain

Other Available Configurations:
- Left-Hand Shaft Mount
- 30” Long Available (Consult Factory)

Drive End Side Transfer Specifications:
- Bearing will be installed on inside of frame on flush side
- Fasteners will be carriage head bolts on both sides
- Extended wearstrip w/ a gap filling leg will be provide on flush side
- Minimum typical product size to clear transfer is 3”
  - Product stability through transfer is affected by height & base contour
Center Drive

Standard Configuration Shown (Right-Hand Shaft Mount)

Specifications:
- Standard Drive Will be Right-Hand, (Unless Otherwise Specified)
- Shaft Mount Will Include Torque Arm
- See Spec Sheet for Standard Speeds (FPM)
- Support Incline Range \( \pm 22^\circ \)

Other Available Configurations:
- Left-Hand Shaft Mount

Center Drive Extension:
- 24" long extension assembly allows the conveyor to be bi-directional
Idle End

Standard Configuration (Shown On Right)

Specifications:
- Standard Idle End Will Be Side Transferrable Both Sides
- Support Incline Range ±22°
- Shoes must be moved to outside edge of frame to run friction top chain

Other Available Configurations:
- None

Idle End Side Transfer Specifications:
- Bearing will be installed on inside of frame on both sides
- Fasteners will be carriage head bolts on both sides
- Extended wearstrip w/ a gap filling leg will be provided on flush side
- Minimum typical product size to clear transfer is 3"
- Product stability through transfer is affected by height & base contour
Intermediate

<table>
<thead>
<tr>
<th>Available Lengths</th>
</tr>
</thead>
<tbody>
<tr>
<td>Std. 18”</td>
</tr>
<tr>
<td>Std. 36”</td>
</tr>
<tr>
<td>Std. 64”</td>
</tr>
<tr>
<td>Std. 92”</td>
</tr>
<tr>
<td>Std. 120”</td>
</tr>
<tr>
<td>1/2” Increments</td>
</tr>
</tbody>
</table>

Cope (Adjustable Vertical Turns)

Cope Specifications:
- Copes are adjustable for up to 15°
- Use double copes for elevation changes between 15° & 30°
- Provisions For Supports -- None

Cope Up
Wearstrips removed for clarity

Cope Down
Wearstrips removed for clarity
Turns

**Turn Specifications:**
- 32 1/8” Centerline Radius
- Slider on Tab Returns
- Available in 30°, 45° & 90° Turns
- Support Incline Range ±0°
  - Inclines Require Spiral Turn

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90° Turn

45° Turn

30° Turn

---

55°
End Transfers

Standard End Transfers:
- Single & Double LBP Roller Transfers
- Single & Double SS Deadplate
- Mounting brackets adjustable for angle and elevation

Optional End Transfers (Consult Factory):
- Single Roller Transfer (Not Shown)
- Bolt-on Powered Transfer (Not Shown)

End Caps

Standard End Caps:
- 18 Ga. Mild & Stainless Steel
- Standard on all Drive, Idle, & Transfer Sections
- Perforated edges allow manual removal of end cap segments for end transfers on drive/idle ends.
Guide Rail & Brackets

**Standard Guide Rail Brackets:**
- Adjustable Formed “L” Shaped Brackets
- 7 Ga. Mild or Stainless Steel
  - Mild Steel is “Stardust Silver” Powder Coat Painted

**Additional Configurations:**
- Gusseted “L” Shaped Brackets
- Molded Plastic Brackets
- Tool-less Adjustability

**Standard Guide Rail Configurations:**
- Single or Double High
- Aluminum Channel w/ UHMW Cover
- VG-SSR Round Face
- VG-SST 1.25” & 2.25” T-Face

**Additional Configurations:**
- Sheet Rail
- UHMW

**Guide Rail Openings**

<table>
<thead>
<tr>
<th>VG-SSR</th>
<th>VG-SST</th>
<th>Alum. Channel</th>
</tr>
</thead>
<tbody>
<tr>
<td>Min.</td>
<td>Max.*</td>
<td>Min.</td>
</tr>
<tr>
<td>7 5/8”</td>
<td>15 3/8”</td>
<td>7 3/8”</td>
</tr>
</tbody>
</table>

*Consult Factory for Wider Openings*
Supports

**Standard Supports:**
- **Formed Angle**
  - “H” Style Formed 2” x 2” Angle w/ Bolt Pad Base
  - ±4” Elevation Change
  - Nominal Elev. Range 24”–48”, 4” increments
  - 7 Ga. Mild or Stainless Steel
  - Silver Powder Coat Painted Mild Steel

**Alternate Supports:**
- Ceiling Hanger Brackets
  - Mild or Stainless Steel
  - Drop Rods Provided by Customer
Tabletop Chain & Sprockets

**Standard Chains:**
- M2500 Series

All M2500 Series chains are directly interchangeable without changing

**Standard Sprockets:**
- Approx. 6.0” Pitch Diameter
- M2500 Series Sprocket
- Sprocket Locations Vary Depending on Chain Type
- Roller Top sprocket locations vary from other chain types within the same series

Flat Top  
Radius Flush Grid  
LBP Roller Top  
Flat Friction Top
## Maintenance Information

### Pre-Start Checklist
- Fasteners – Some may have loosened during shipment. Re-tighten as required
- Inspect all splice points for proper wear strip alignment.
- Hand run a 48” long chain section through conveyor, both carry way and return paths, to check for binding.
- Verify motor rotation
- Verify chain direction is correct (See Figure 1)
- Guide Rail – Check for proper product width before operation.

### Startup / Break-In
- During first 250 hours of operation – Monitor the following
  - Initial chain stretch – Chain will have an initial stretch. Monitor catenary length, as described below, and remove excess links.
  - Chain dusting – Normally occurring issue that subsides after the first 250 hours of run time. Clean as required

### Maintenance
- Catenary length – (See Figure 2)
- Chain length – Replace when catenary sag reaches lower indicator slot
- Sprocket wear – Look for excessive wear or hooked teeth
- Bearings – sealed for life
- Reducer – Nord reducers – sealed for life
  - Look for leaking seals
- Wear strip wear
  - **Inside turn – add indicator line**
- Chain Surging (Slip – Stick)
  - Hard to predict natural phenomenon that depends on speed, load, construction and lubrication.
  - Most common in long and/or slow running conveyors.
  - Poses no operational concerns unless it causes product tipping.
    - Look for chain binding at turns and copes in both the carry way (product path) and the return path.
- Motor Hop & Wobble
  - Natural phenomenon that is desirable
  - Poses no operational concerns with life expectancy of conveyor or reducer
  - Wobble releases stress build up due to normal machining tolerances in rotating shaft.
  - Increases equipment longevity compared to rigidly mounted reducers where misalignments are trapped.
    - Longer reducer life
    - Longer bearing life
    - Longer shaft life