

Standard Modules

- Idle Ends; Drive Ends; Center Drives; Standard Turns; Disc Turns; Intermediates; Parallel & Inline Transfers; Copes (Adjustable Vertical Turns)

Frame Design & Material

- Open Top Design
- 12-Gauge, Mild Steel, "Stardust Silver" Powder Coat Paint
- 12-Gauge Stainless Steel, #4 Polish Finish

Wearstrips — Carryway

- Straights: 1/8" Thick UHMW
- Turns: UHMW Outside, Duravar Inside < 200 FPM

Wearstrip — Return

- UHMW Slider on Tab in Straights

Motor/Reducer - Dry Environment

- Nord "C" Face Motor, Inverter-Duty, IP55
- Voltage: 230/460-3-60 AC
- Nord Hollow Bore Reducer
- Corrosion Resistant Aluminum
- Vertical Shaft Mount w/ Torque Arm

Options:

- Below Mount
- Washdown

Conveyor Speeds

- Standard Nominal Speeds (FPM):
 - 40, 60, 100, 125, 165, 250, 330
 - Minimum: 30 FPM* Maximum: 385 FPM*
- *Speed obtained using a VFD

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:

- Compatible w/ most Support Styles, but Not Limited to:
- Pedestal, El. Range 30", 42" (± 3 ")
- Ceiling Hanger Brackets

Bearings

- Drive Ends: 2-Hole Flange, Painted, Sealed for Life, General Purpose Lube, Steel Insert w/ Set-Screw
- Idle Ends: Stainless Steel Bearing in Hub of Sprocket

Options:

- Polymer Housing, Food Grade Lube
- Zinc Plated or Stainless Steel Inserts
- Safety Covers

Shafts

- Idle Shaft Dia. 1.0"
- Drive Shaft Dia. 1.25"

Tabletop Chains & Sprockets

- See Data Sheet

Guide Rail & Brackets

- See Data Sheet

Conveyor Accessories

- LBP Roller Transfer, SS Deadplate
- ### Options:
- Drip Pans, Tent Covers

Note: The following technical pages are shown with 4.5" wide chain. The standard construction and availability remains the same for 7.5" & 3.25" wide chain unless otherwise specified.

Drive End

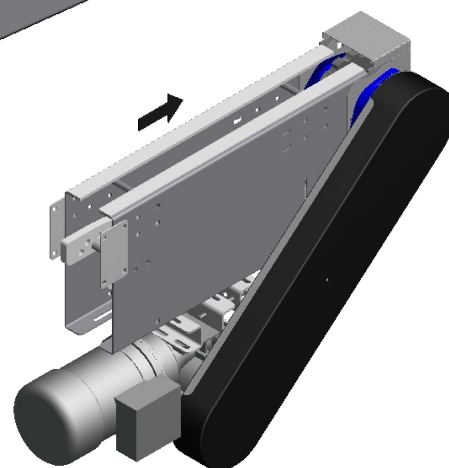
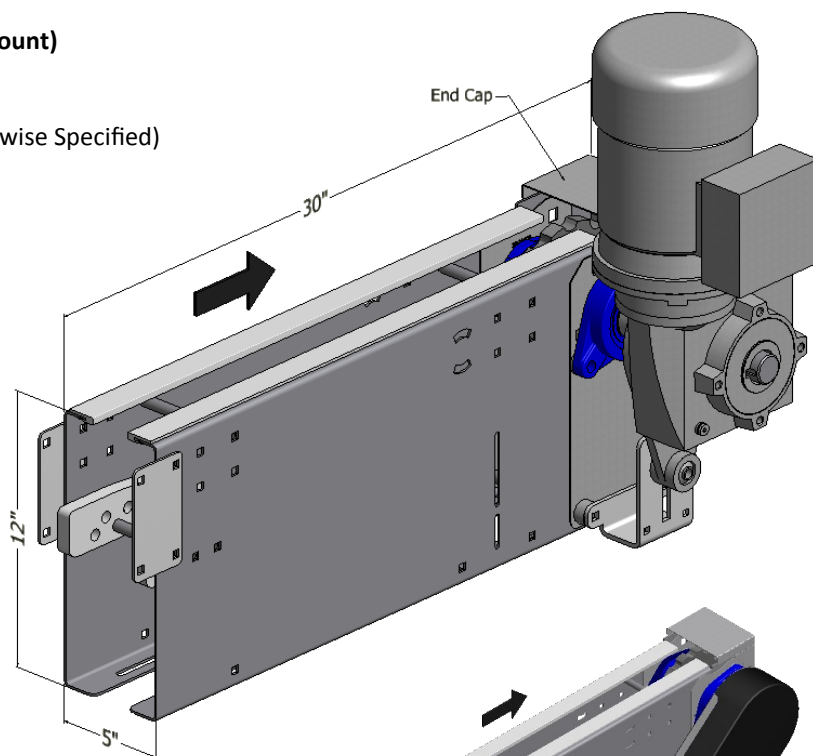
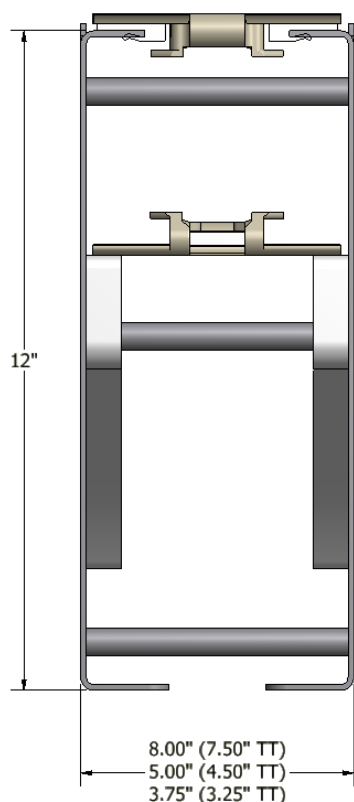
Standard Configuration Shown (Right-Hand Shaft Mount)

Specifications:

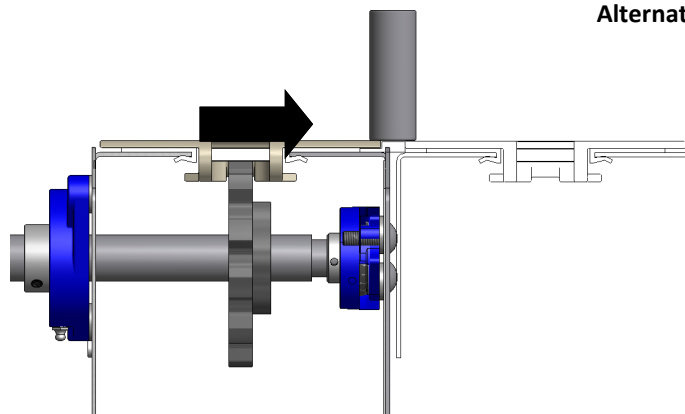
- Standard Drive Will be Right-Hand (Unless Otherwise Specified)
- Shaft Mount Includes Torque Arm
- See Spec Sheet for Standard Speeds (FPM)
- End Cap (Finger Guard) Included
- Support Incline Range $\pm 22^\circ$

Other Available Configurations:

- Left-Hand Shaft Mount
- Right- or Left-Hand Below Mount
- (See Alternate Configuration)



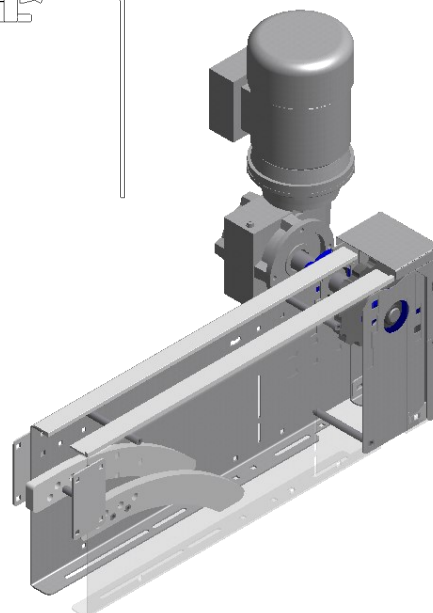
Alternate Below Mount Configuration



0750-2 Shown

Drive End Side Transfer Specifications:

- Left-hand & right-hand side transfer designs available
- Bearing installed on inside of frame on transfer side
- Fasteners will be carriage bolts on transfer side
- Deadplate wearstrip included to fill the gap (11/16") between chains (field trim to fit)
- Minimum typical product size to self clear transfer is 1.5"
 - Product stability through transfer is affected by height & base contour

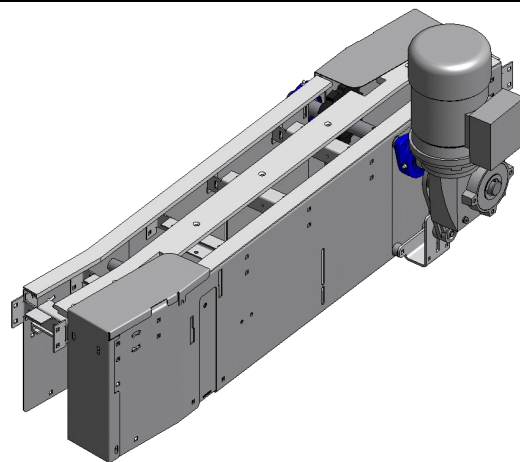
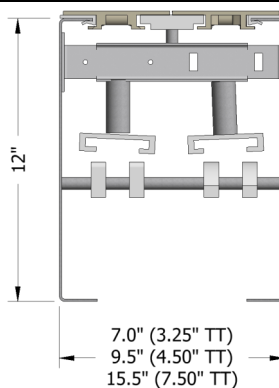


Transfers

Inline Transfer Specifications:

Standard Configuration Shown (Right-Hand Shaft Mount)

- 48" Long Section (4.5" & 3.25" Wide Chains)
- 60" Long Section (7.5" Wide Chain)
- Bearing: SS in hub of idle sprocket

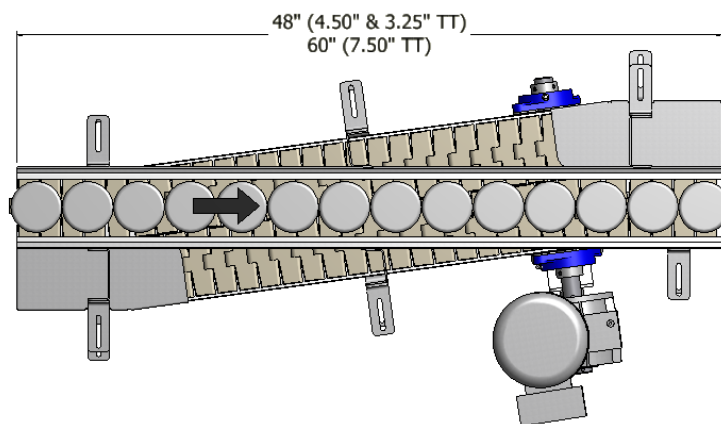


Other Available Configurations:

- Right-Hand Below Mount

Advantages:

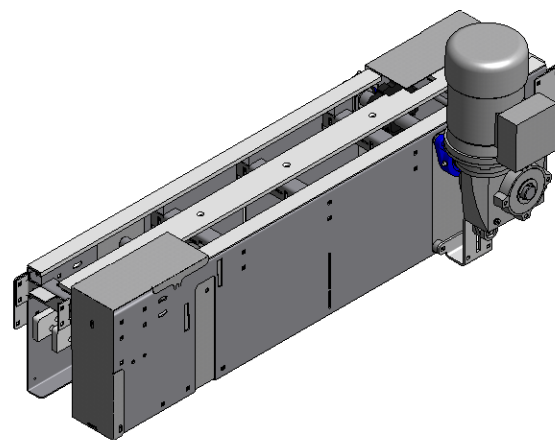
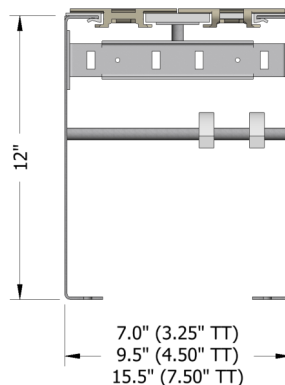
- Product travels in a straight line
- Used when product stability is critical
- Provides smooth transfer
- Best transfer when using tent covers



Parallel Transfer Specifications:

Standard Configuration Shown (Left-to-Right, Right-Hand Shaft Mount)

- 48" Long Section (4.5" & 3.25" Wide Chains)
- 60" Long Section (7.5" Wide Chain)
- Bearing: SS in hub of idle sprocket



Other Available Configurations:

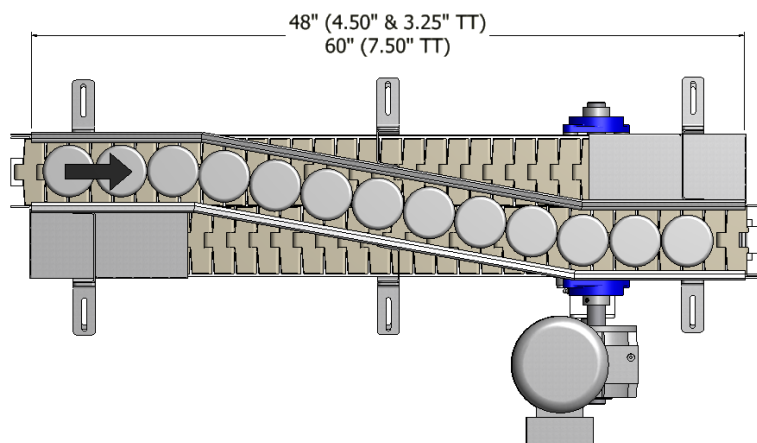
- Parallel Transfer: Right-to-Left RH
- Right-Hand Below Mount

Advantages:

- Used when product stability is not critical
- Helps reduce back pressure when accumulating

Additional Specifications (Parallel & Inline):

- Shaft Mount Will Include Torque Arm
- End Caps (Finger Guards) Included
- Standard Drive Will be RH (Unless Otherwise Specified)
- Support Incline Range $\pm 22^\circ$
- See Spec Sheet for Standard Speeds (FPM)



Idle End

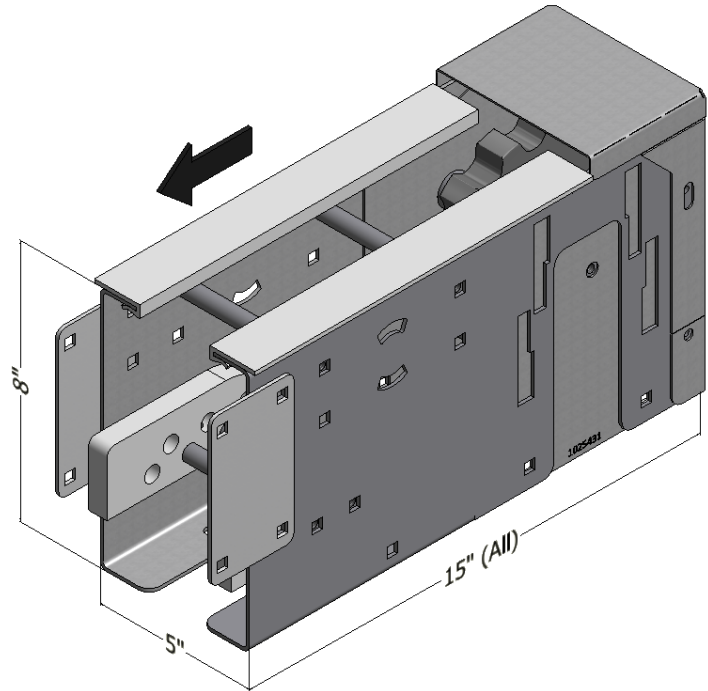
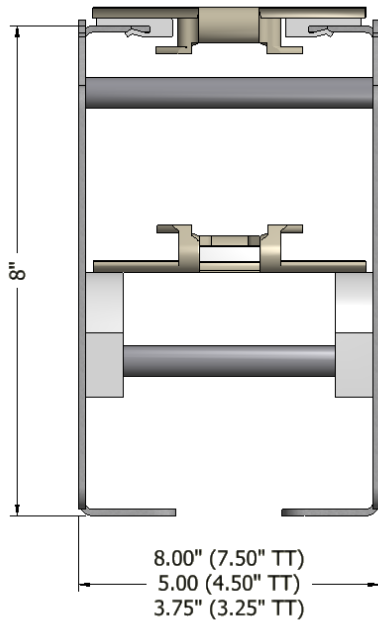
Standard Configuration Shown On Right

Specifications:

- End Cap (Finger Guard) Included
- Support Incline Range $\pm 22^\circ$

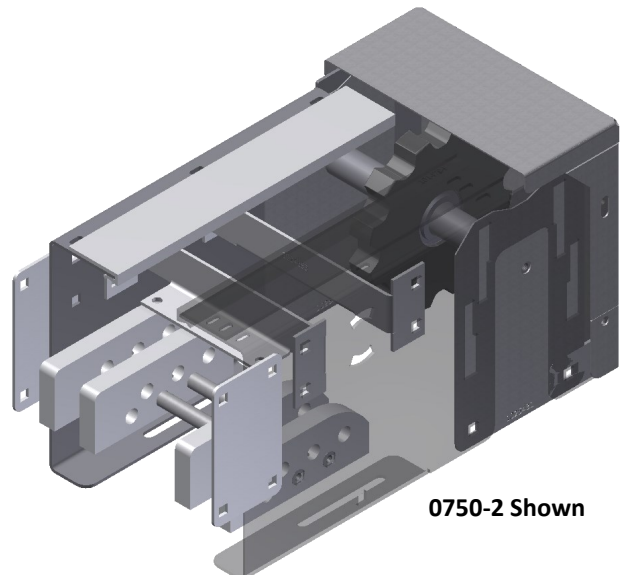
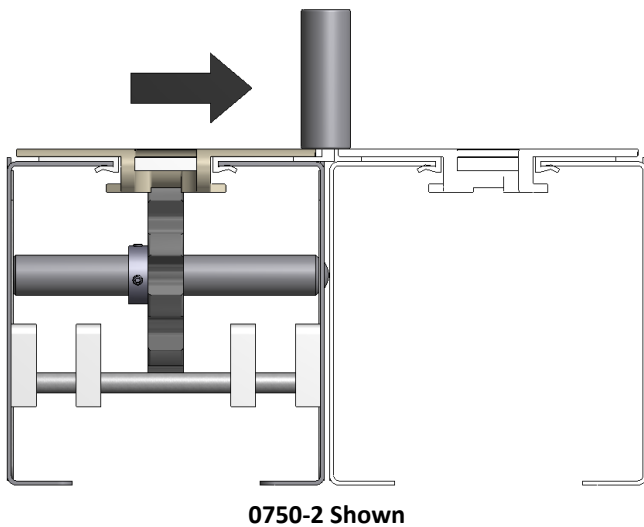
Other Available Configurations:

- Right/Left-Hand Side Transfer



Idle End Side Transfer Specifications:

- Standard design
- Bearing: SS in hub of sprocket
- Fasteners will be button head cap screws on transfer side
- Deadplate wearstrip included to fill the gap (1/2") between chains (field trim to fit)
- Minimum typical product size to clear transfer is 1.5"
- Product stability through transfer is affected by height & base contour



Center Drive

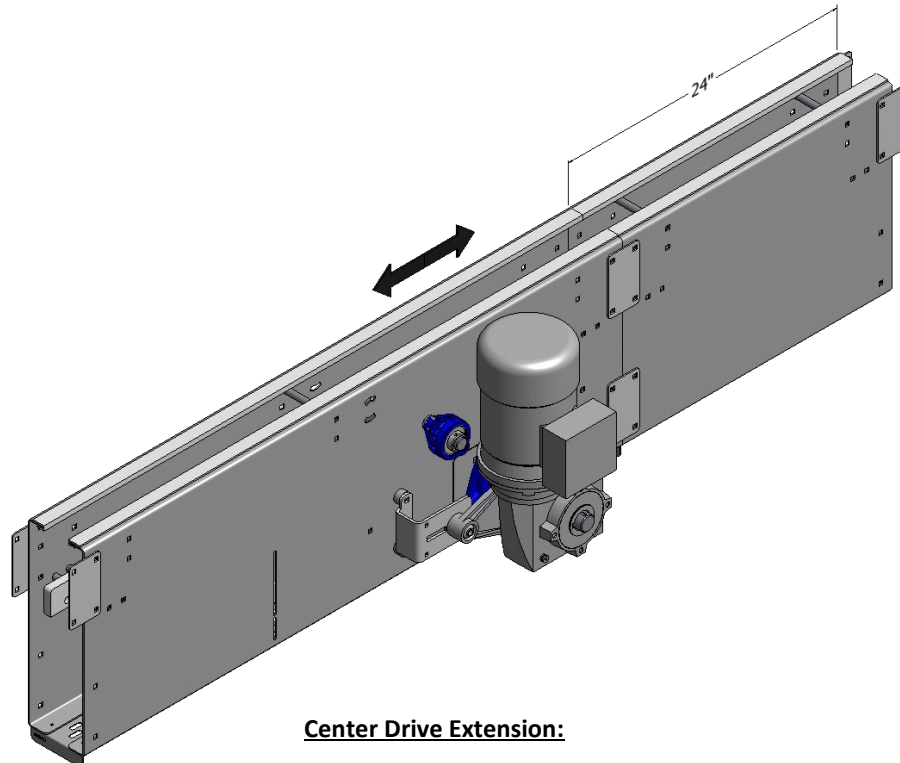
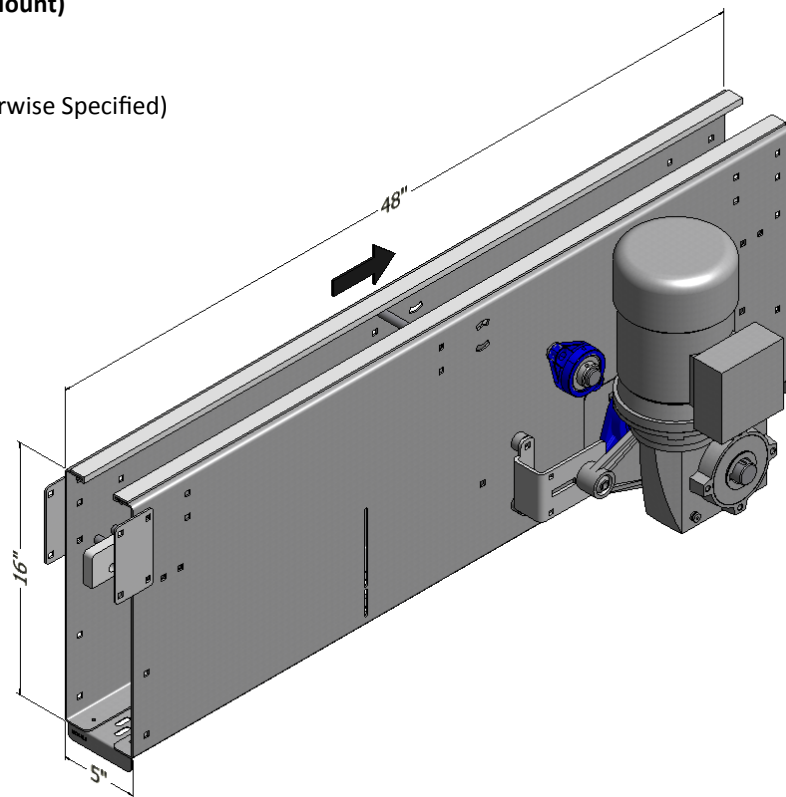
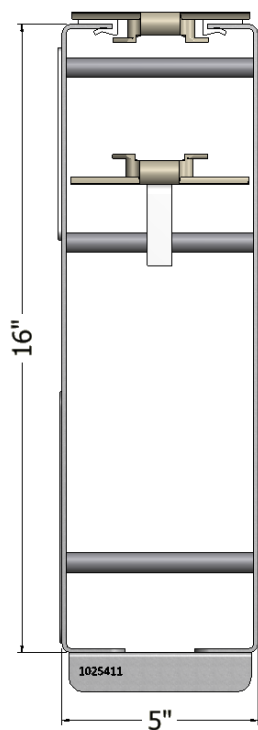
Standard Configuration Shown (Right-Hand Shaft Mount)

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 $\pm 22^\circ$
- **NOT** compatible with LBP style chain

Other Available Configurations:

- Left-Hand Shaft Mount

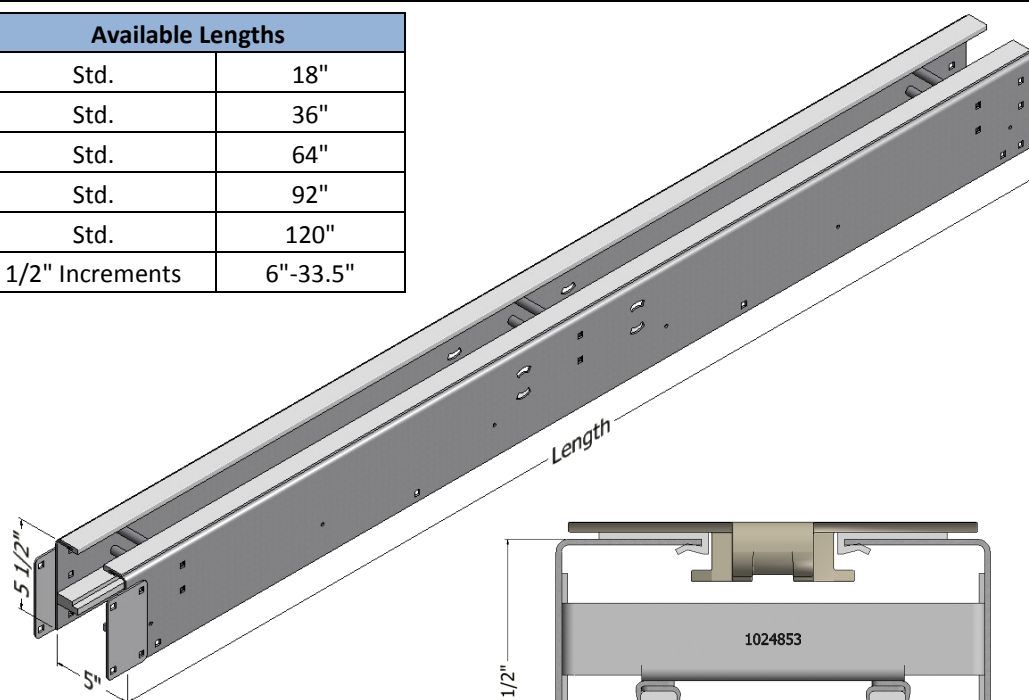


Center Drive Extension:

- 24" long extension assembly allows the conveyor to be bi-directional

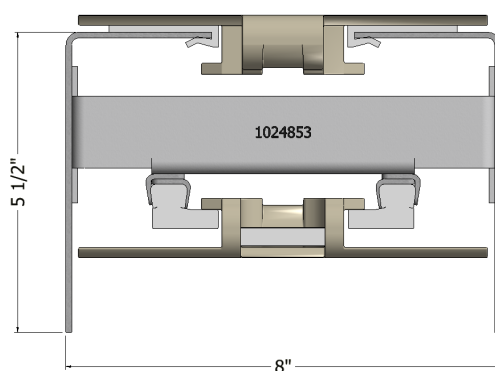
Intermediate

Available Lengths	
Std.	18"
Std.	36"
Std.	64"
Std.	92"
Std.	120"
1/2" Increments	6"-33.5"

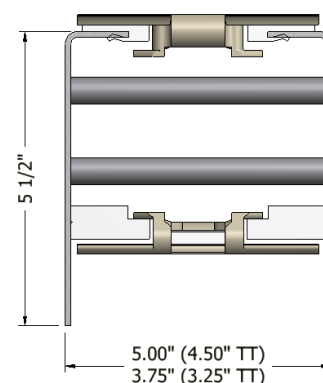


Specifications:

- Support Incline Range $\pm 20^\circ$



0750-2

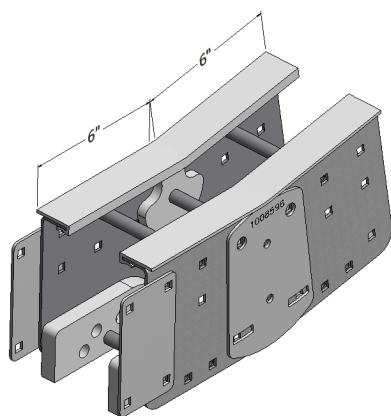


0450-1 (shown)

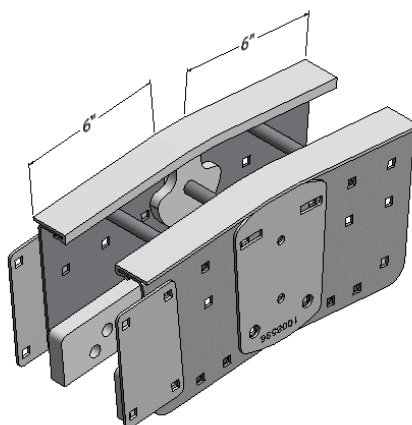
0450-2

0325-1

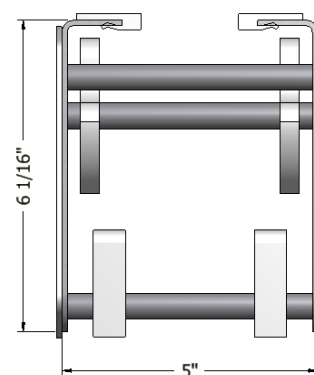
Cope (Adjustable Vertical Turn)



Cope Up



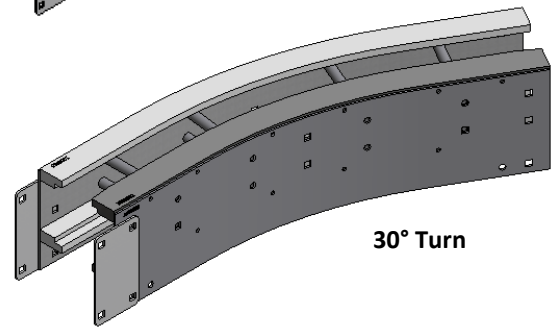
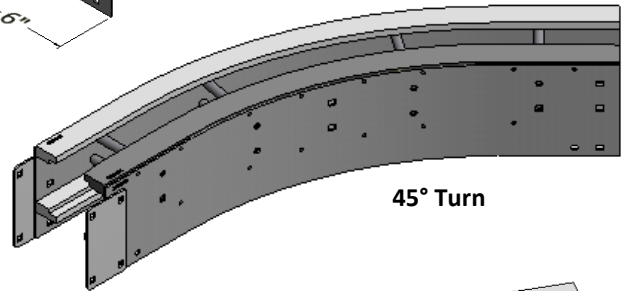
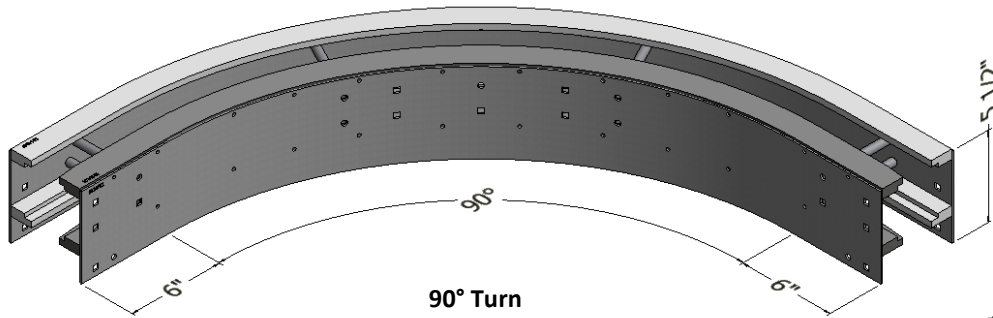
Cope Down



Cope Specifications:

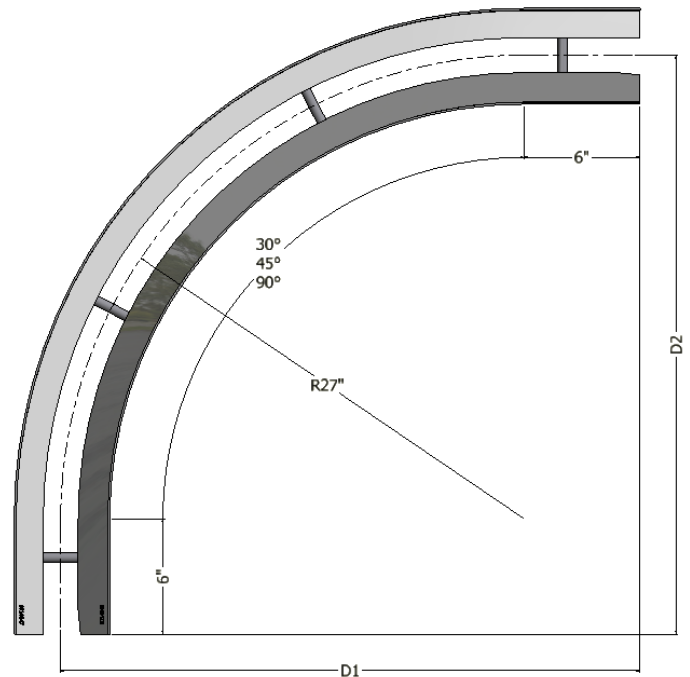
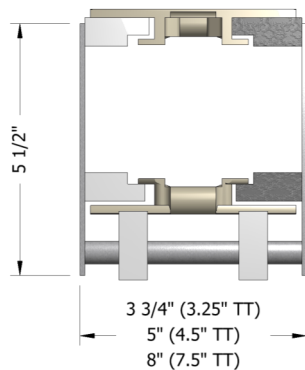
- Adjustable $\pm 15^\circ$
- Use double copes for elevation changes between 15° & 30°

Turns



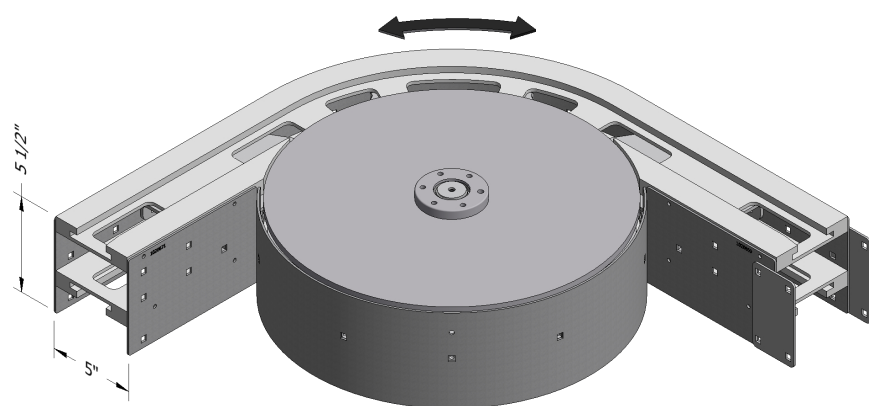
Turn Specifications:

- 4.5" Wide (27" Centerline Radius)
- 7.5" Wide (24" Centerline Radius)
- 3.25" Wide (18" Centerline Radius)
- 6" Straight Tangents on Both Ends
- Inside Wearstrip — Duravar < 200 FPM
- Slider on Tab Returns
- Available in 90°, 45°, & 30° Turns
- Custom Angled Turns Available (Consult Factory)
- Spiral Incline/Decline Turns Available (Consult Factory)
- Support Incline Range $\pm 0^\circ$
 - Inclines Require Spiral Turn (Consult Factory)

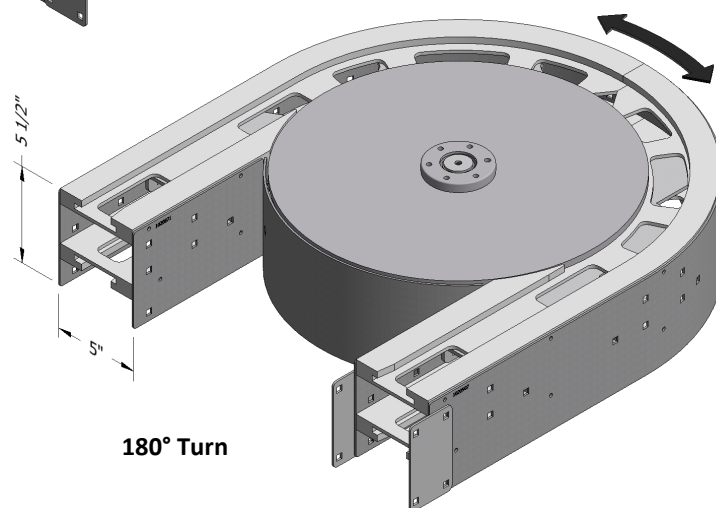


		30°		45°		90°	
Width	R	D1	D2	D1	D2	D1	D2
7.5"	24"	6 3/16"	23 3/16"	11 1/4"	27 3/16"	30"	30"
4.5"	27"	6 5/8"	24 5/8"	12 1/8"	29 5/16"	33"	33"
3.25"	18"	5 7/16"	20 3/16"	9 1/2"	23"	24"	24"

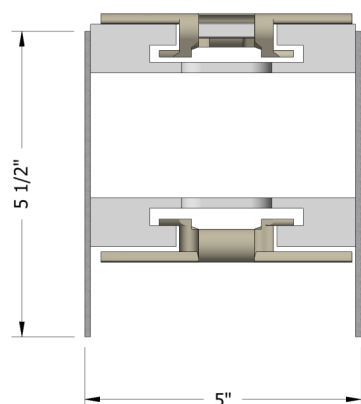
Disc Turns (3.25" & 4.5" TT Only)



90° Turn

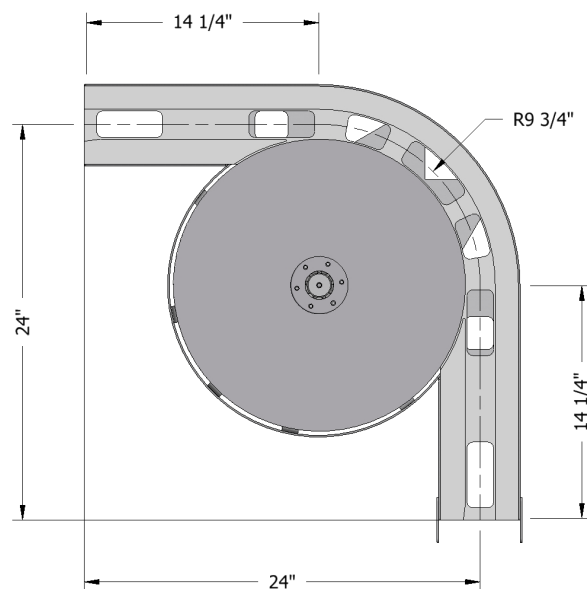


180° Turn

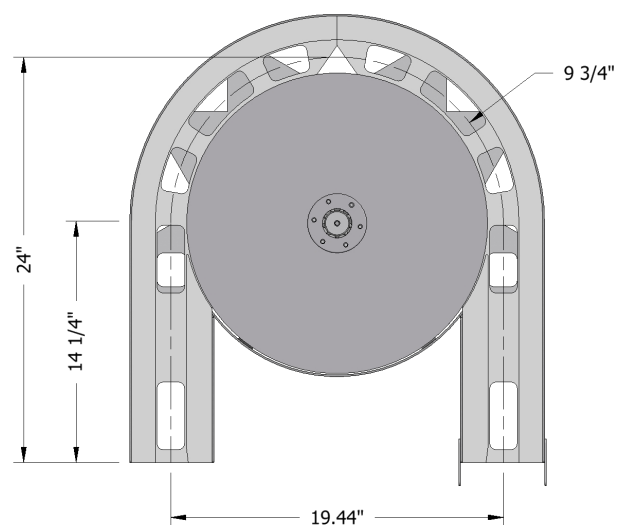


Disc Turn Specifications:

- Available for 4.5" (shown) & 3.25" Wide
- 9.72" Centerline Radius
- Available in 90° & 180° Turns
- Requires BO Tight Radius Tab Chain (See Chain Data Sheet)
- Support Incline Range $\pm 0^\circ$



90° Turn



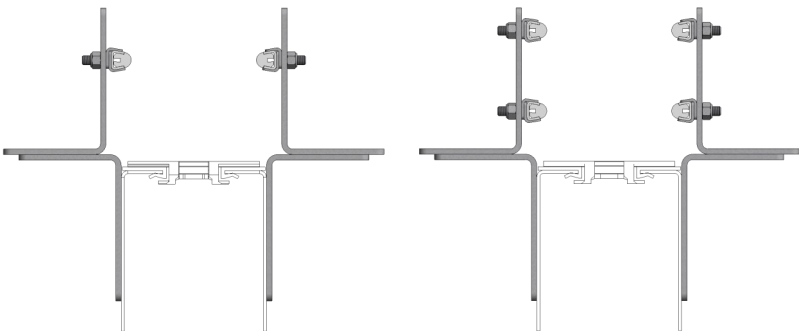
180° Turn

Guide Rail & Brackets

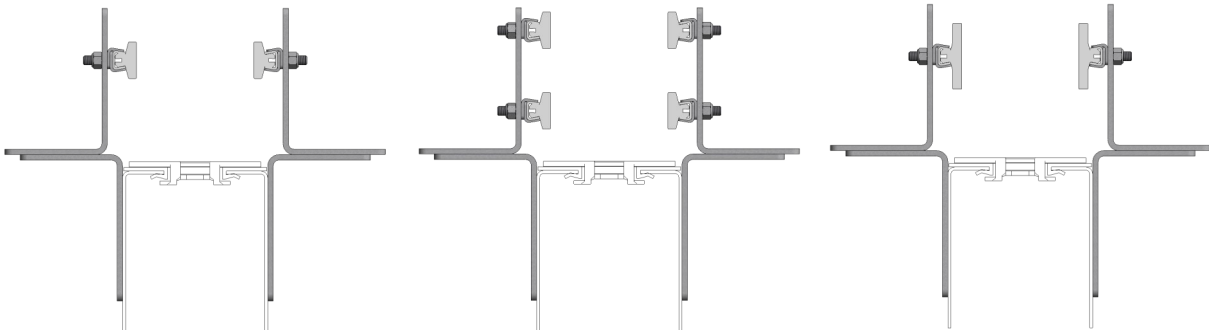


Standard Guide Rail Brackets:

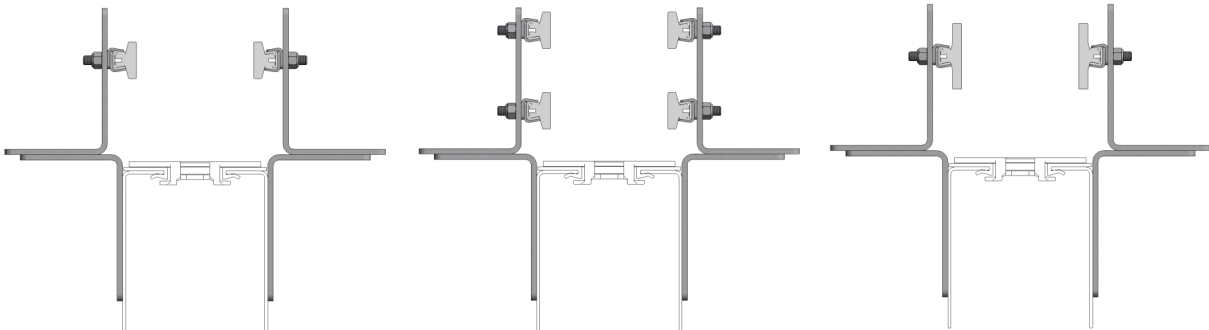
- Adjustable Formed “L” Shaped Brackets
- 7 Ga. Mild or Stainless Steel
- Mild Steel is “Stardust Silver” Powder Coat Painted



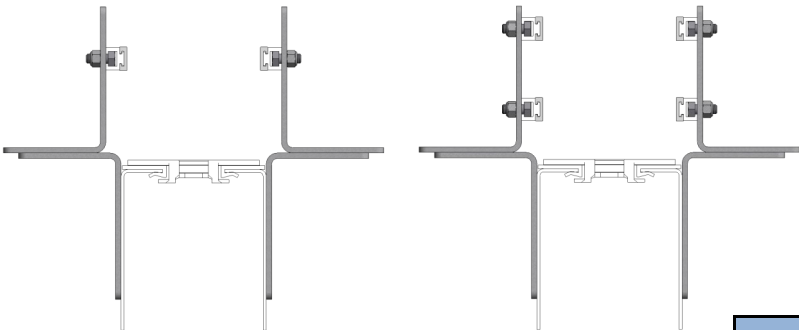
VG-SSR Round Face



VG-SST 1.25" T-Face



VG-SST 2.25" T-Face



Aluminum Channel
w/ UHMW Cover

**Consult Factory for Wider Openings*

Guide Rail Openings						
Width	VG-SSR		VG-SST		Alum. Channel	
	Min.	Max.*	Min.	Max.*	Min.	Max.*
3.25"	0"	5 7/8"	0"	5 5/8"	0"	6 1/8"
4.5"	0"	7 1/8"	0"	6 7/8"	0"	7 3/8"
7.5"	2 3/8"	10 1/8"	2 1/8"	9 7/8"	2 5/8"	10 3/8"

Supports



Formed Angle

Standard Supports:

Formed Angle - Best Value

- “H” Style Formed 2” x 2” Angle w/ Bolt Pad Base
- ± 4 ” Elevation Change
- Nominal Elev. Range 24”, 28”, 32”, 36”, 40”, 44”, 48”
- 7 Ga. Mild or Stainless Steel
 - Silver Powder Coat Painted Mild Steel



Aluminum Pedestal

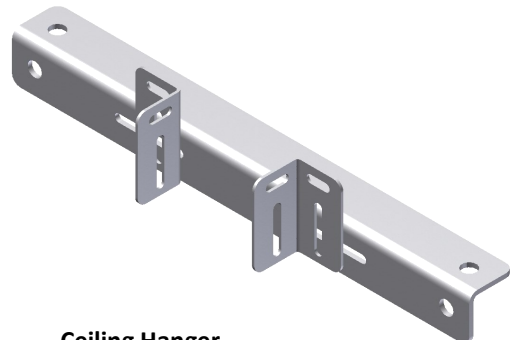
Alternate Supports:

Pipe & Yoke w/ Polished Aluminum Pedestal Base

- ± 3 ” Elevation Change
- Nominal Elev. Range 30”, 42”
 - To Obtain Other Elevations, Pipe Must be Cut
- Mild or Stainless Steel Pipe & Yoke

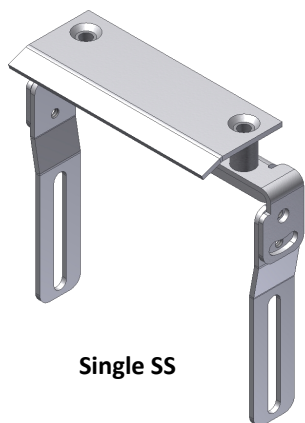
Ceiling Hanger Brackets

- Mild or Stainless Steel
- Drop Rods Provided by Customer

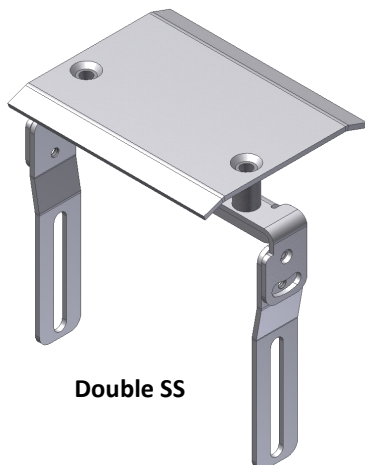


Ceiling Hanger

End Transfers



Single SS



Double SS



Single LBP



Double LBP

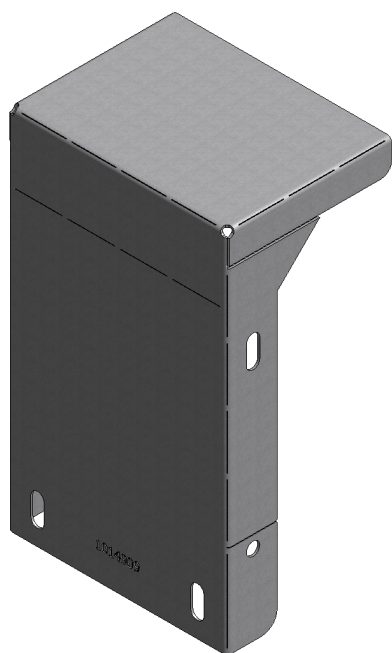
Standard End Transfers:

- Single & Double LBP Roller Transfers
- Single & Double SS Deadplate
- Adjustable mounting brackets for vertical & angle adjustability

Optional End Transfers (Consult Factory):

- Single Roller Transfer (Not Shown)
- Bolt-on Powered Transfer (Not Shown)

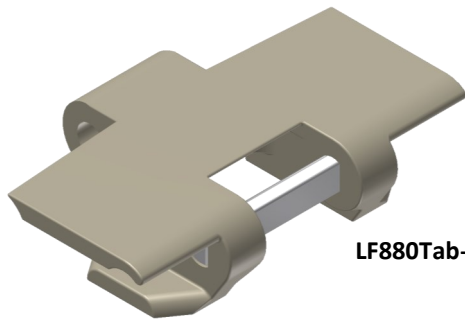
End Caps



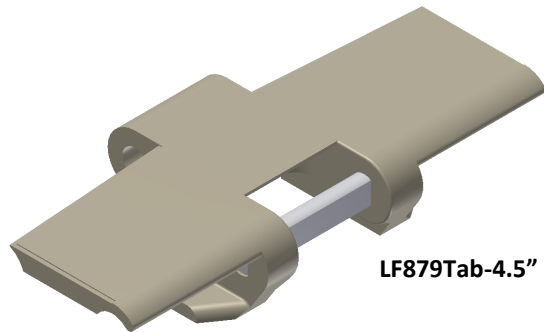
Standard End Caps:

- 18 Ga. Mild & Stainless Steel
- Standard on all Drive, Idle, & Transfers Sections
- Perforated edges allow manual removal of end cap segments for end transfers on drive/idle ends.

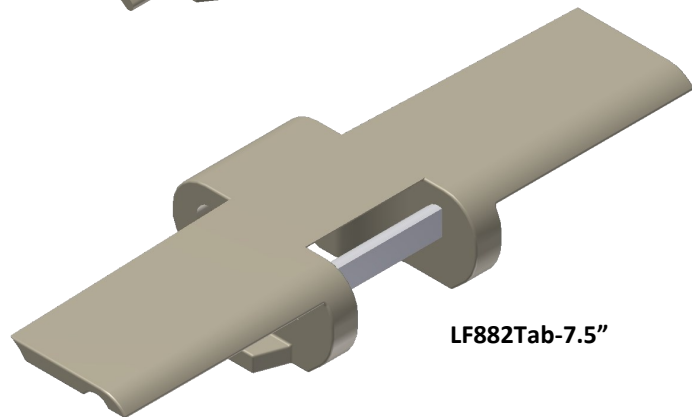
Tabletop Chain & Sprockets



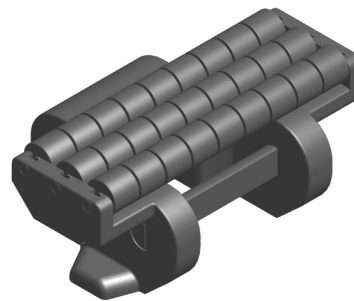
LF880Tab-3.25"



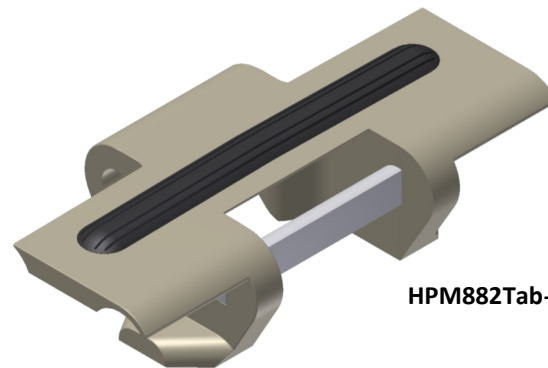
LF879Tab-4.5"



LF882Tab-7.5"



LBP882Tab-K7.5"



HPM882Tab-K7.5"



Drive Sprocket



Idle Sprocket

Standard Chains:

- LF882Tab-K7.5"
- LF879Tab-K4.5"
- LF879/880Tab-K3.25"

Additional Chains:

- LF880Tab BO-K3.25"
- LF880Tab BO-K4.5"
- HPM882Tab-K7.5" w/ Friction Inserts
- LBP882Tab-K7.5" w/ Low Back Pressure Rollers

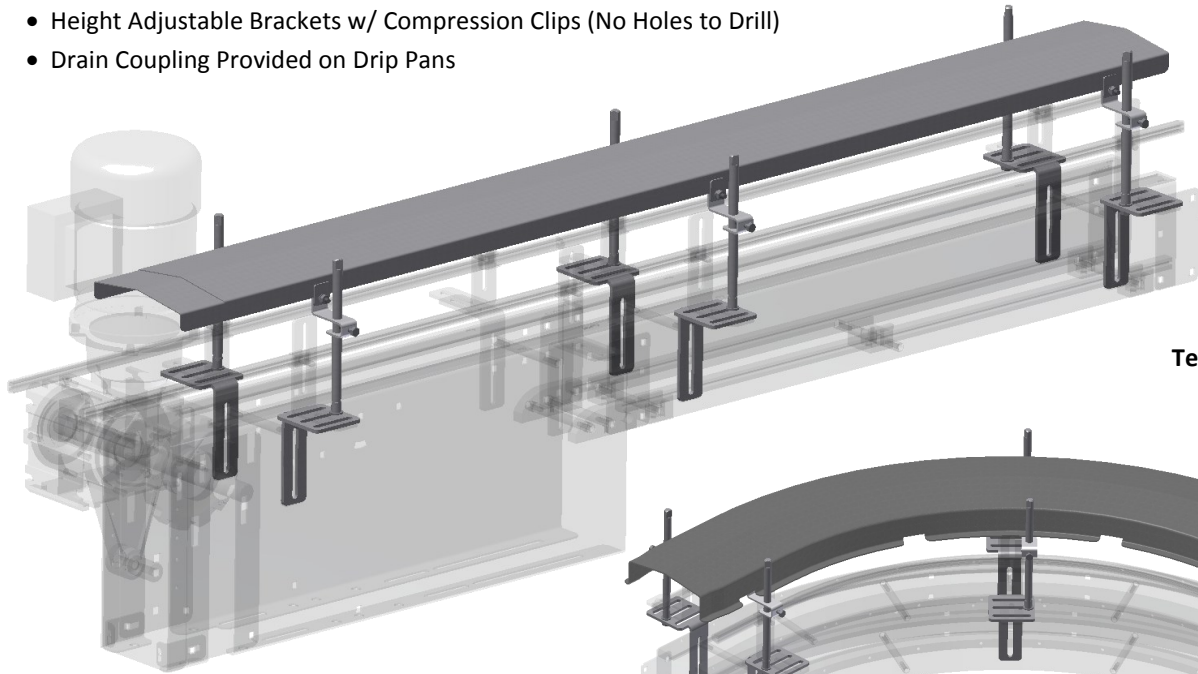
Standard Sprockets:

- Nylatron Material
- Approx. 6.0" Pitch Diameter
- 880 Sprocket for 879Tab-K4.5" & 879/880Tab-K3.25"
- 882 Sprocket for 882Tab-K7.5"

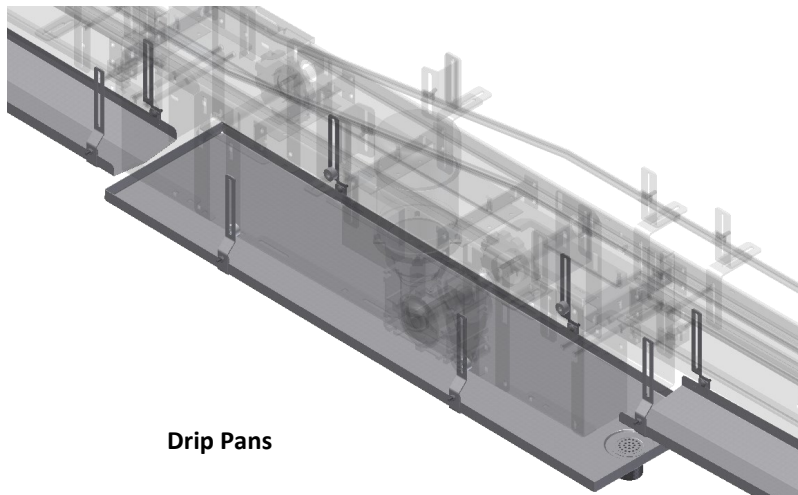
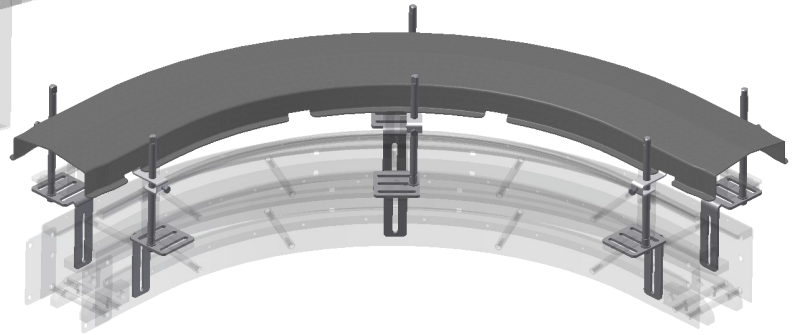
Tent Covers & Drip Pans

Notes:

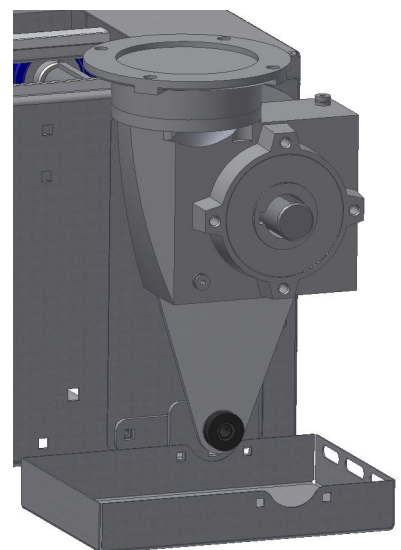
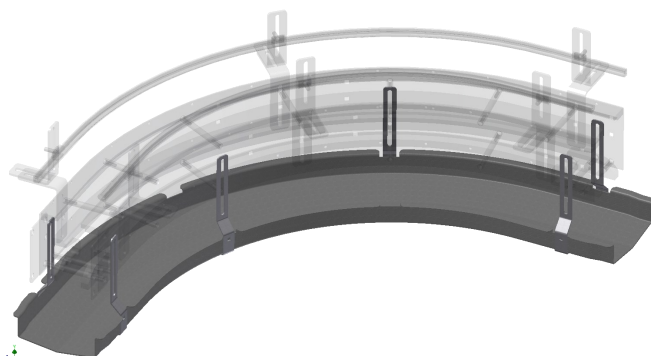
- Only Available on 4.5" & 3.25" Conveyors
- 18 Ga. Stainless Steel (Straights & Transfers)
 - Standard 60" Length Designed for Unlimited Overlap
- Molded Plastic (24" Radius Turns Only)
- Height Adjustable Brackets w/ Compression Clips (No Holes to Drill)
- Drain Coupling Provided on Drip Pans



Tent Covers



Drip Pans



**Reducer Drip Pan
(Shaft Mount Shown)**

Maintenance Information

Pre-Start Checklist

- Fasteners may have loosened during shipping. Check all sprockets and pulley set screws prior to chain installation.
- 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)
 - If intermixing chain manufacturers (Habasit/Rexnord), always match pin to chain as shown (See Figure 1)
- Guide Rail – Check for proper product width before operation.

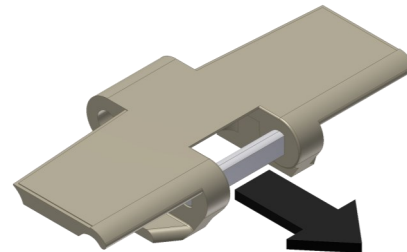


Figure 1

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 80 links > 123" or 40 links > 61.5"
- Sprocket wear – Look for excessive wear or hooked teeth
- Bearings – sealed for life
- Reducer – Nord reducers – sealed for life
 - Look for leaking seals
- Wearstrip wear
 - Inside turn – When edge of chain is 1/32" or less from inside edge of frame, it is time to replace wearstrip (See Figure 3)
- 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

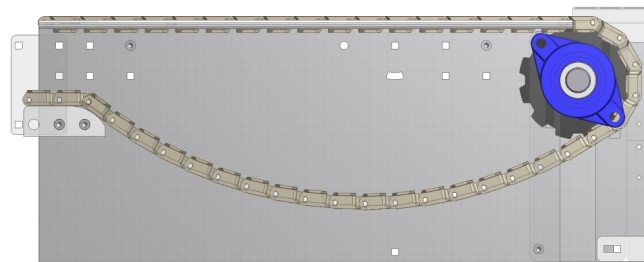


Figure 2

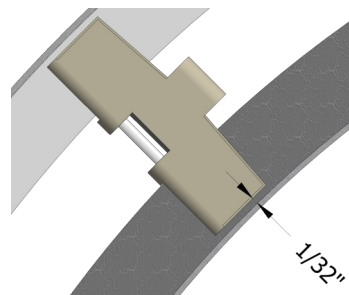


Figure 3

Notes
