partnered with

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12" Tabletop Conveyor Specifications

Complete Conveyor Systems and Equipment

Conveyor Specifications

Frame	*Material Thickness*	*Material*	*Finish*	*Design*	
	12 GA	Mild steel	"Stardust Silver" powder coat paint	• Open top • Safety design to prevent pinch points	
	12 GA	Stainless Steel	#4 polish finish		
Standard Modules	*Parts*				
	• Idle ends • Drive ends • 45°, 90° Turns • Intermediates • Copes ► Adjustable vertical turns				
Wearstrips	*Carryway*	*Carryway Options*	*Return*		
	• ⅜" Thick UHMW in straights • Turns: ► UHMW outside ► Duravar inside < 200 FPM	Turns: Nylatron inside > 200 FPM	Slider on tab in straights & turns		
Motor/ Reducer	*Brand/Style*	*Voltage*	*Body Frame*	*Mounting*	*Options*
	Nord • "C" face motor • Inverter duty • VFD & IP55 rated	230/460-3	Corrosion resistant aluminum	"C" face	• Below or above • Washdown-painted
	• Nord • Hollow bore reducer	N/A	Corrosion resistant aluminum	Vertical shaft with torque arm	
Conveyor Speeds	*Standard Nominal (FPM)*	*Minimum*	*Maximum*	*Above Maximum*	
	• 40 • 60 • 100 • 125 • 165 • 250	30 FPM* *Speed obtained using a VFD	300 FPM* *Speed obtained using a VFD	Consult factory for speeds above 300 FPM	
Supports	*Style*	*Elevation Change*	*Elevation Range*	*Options*	
	• "H" Formed 2"x2" • Angled • Bolt pad base • Formed sanitary channel w/spacers & bolt pad base	±2"	Nominal 22" - 50"	• Ceiling hanger brackets • 1½" Square tube, El. range 24-45" (±3)	

Conveyor Specifications

Bearings	*Construction*	*Finish*	*Options*
	• 2-Hole flange • Steel insert with set-screw	• Painted • Sealed for life • General purpose lube	• Polymer housing • Food grade lube • Zinc plated or Stainless Steel inserts • Safety covers
Shafts	*Diameter*		
	• Idle = 1.0” • Drive = 1.25”		
Conveyor Accessories	*Parts*	*Options*	
	• Low Back Pressure (LBP) roller transfer • Stainless Steel dead plate	• Single roller transfer • Powered transfer	

Guide Rail & Brackets

- *See page 9*

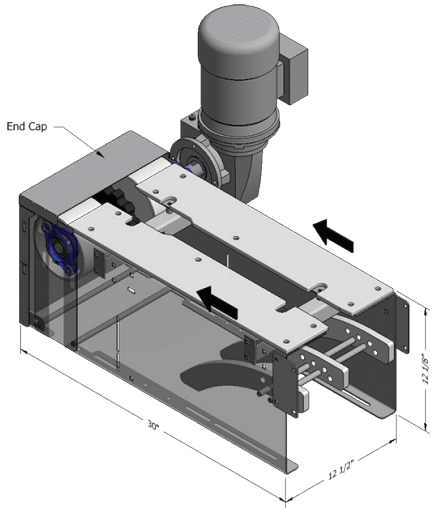
Tabletop Chains and Sprockets

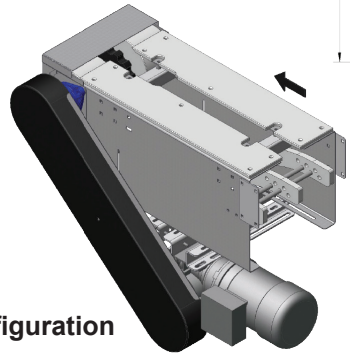
- *See page 10*

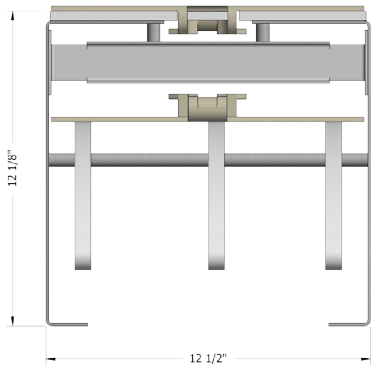
Part Specifications

Drive End

Standard Configurations	Optional Configurations	Specifications
• Right-hand (Illustrated below) • Flush mount on one side • Shaft mount includes torque arm • End cap (finger guard) included	• Left-hand shaft mount • Right or left-hand below mount (Illustrated below)	• See page 2 for standard speeds (FPM) • Support incline range ±8.5°



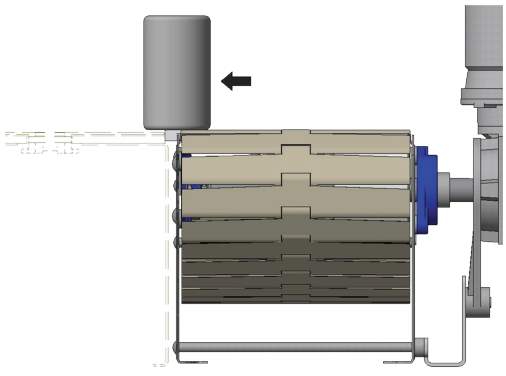




Alternate Below Mount Configuration

Side Transfer Configurations

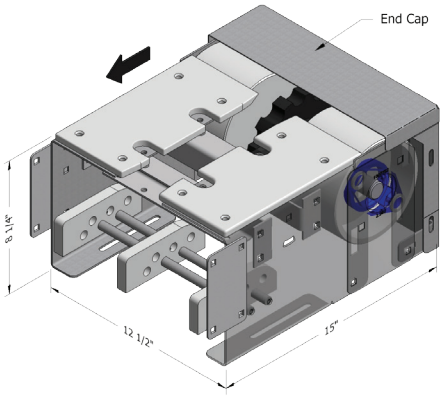
- Bearing installed on inside of frame on transfer side
- Carriage head bolt fasteners on both sides
- Deadplate wearstrip included to fill the gap between chains (field trim to fit)
- Minimum typical product size to clear transfer is 3"
  - ► Product stability through transfer is affected by height & base contour

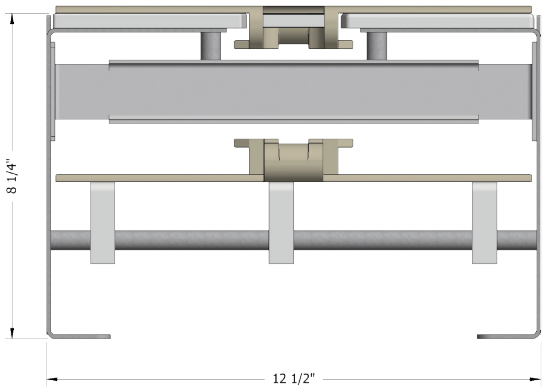


Part Specifications

Idle End

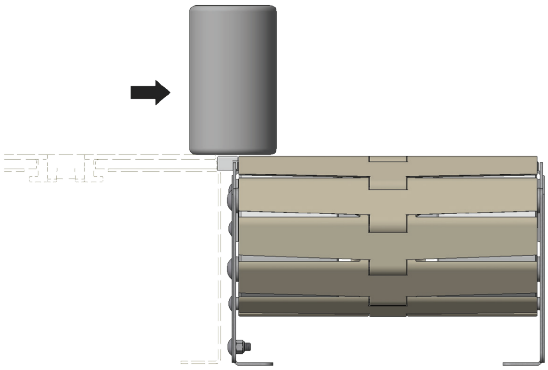
Standard Configurations	Specifications
• Flush mounted on both sides (Shown below) • End cap (finger guard) included	• Support incline range ±8.5°

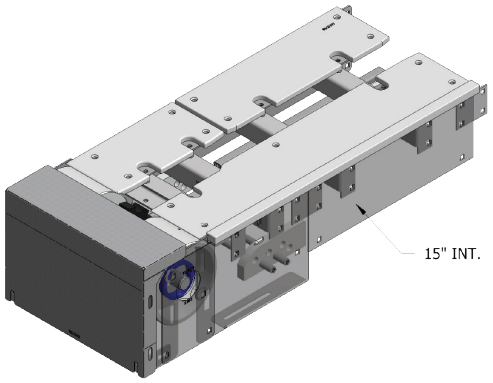




Side Transfer Configurations

- Add a 15" intermediate for 24" transfer area
- Bearing installed on inside of frame on both sides
- Carriage head bolt fasteners on both sides
- Deadplate wearstrip included to fill the gap between chains (field trim to fit)
- Minimum typical product size to clear transfer is 3"
  - ► Product stability through transfer is affected by height & base contour



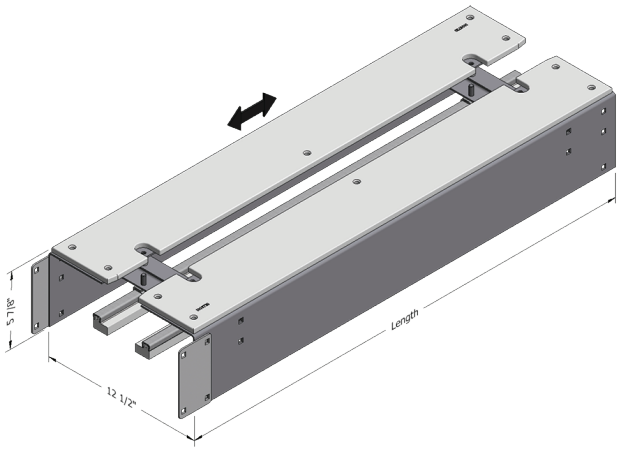


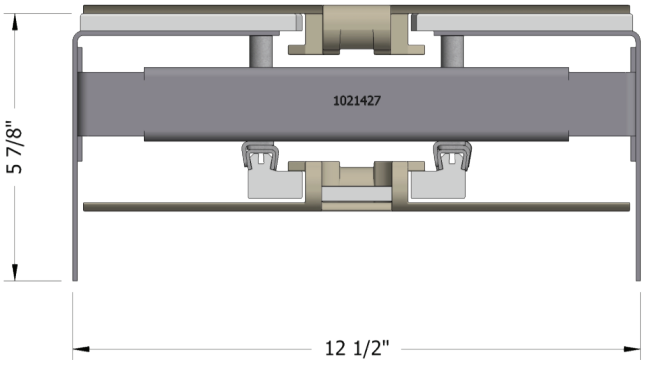
Part Specifications

Intermediate

Available Standard Lengths

- 18"
- 36"
- 64"
- 92"
- 118"
- ½" increments from 6" to 41½"

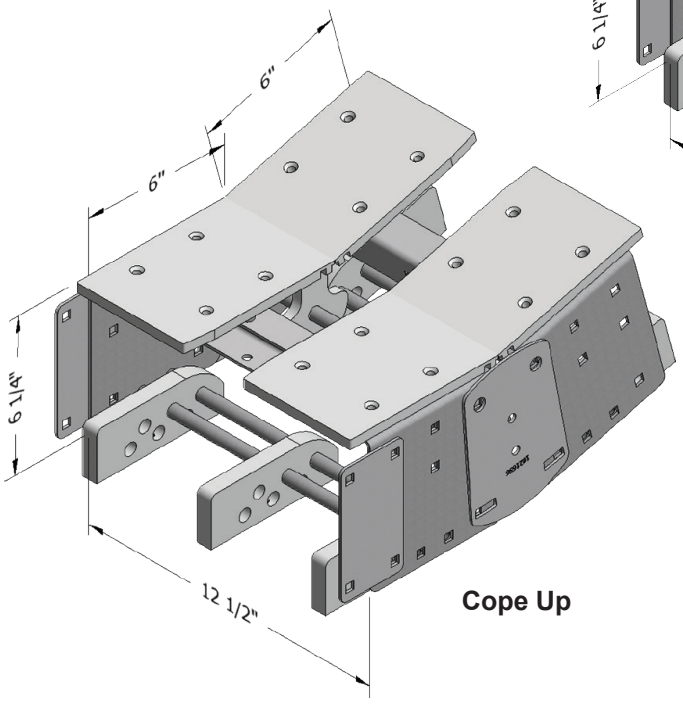




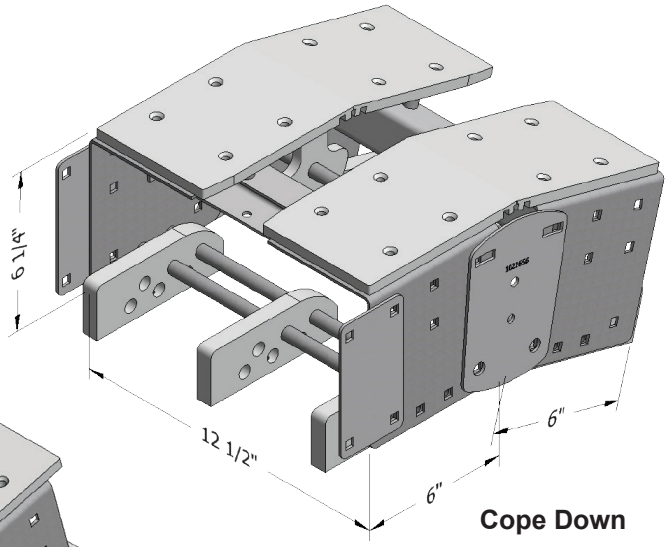
Cope (Adjustable Vertical Turns)

Specifications

- Copes are adjustable ±15°
- Use two copes for elevation changes between 15° and 30°



Cope Up

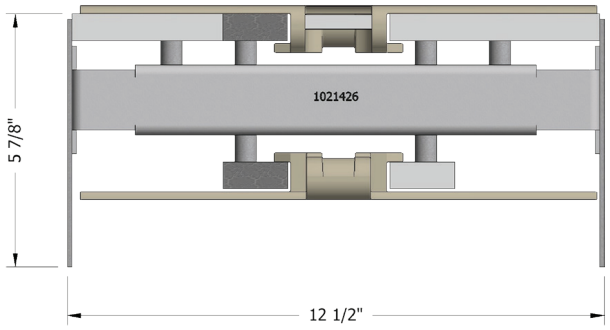


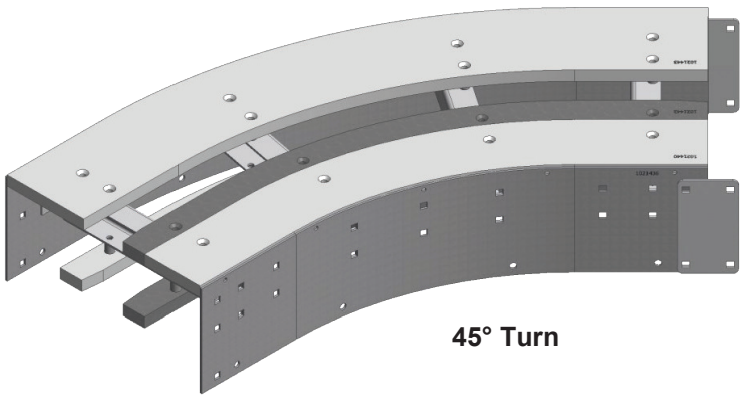
Cope Down

Part Specifications

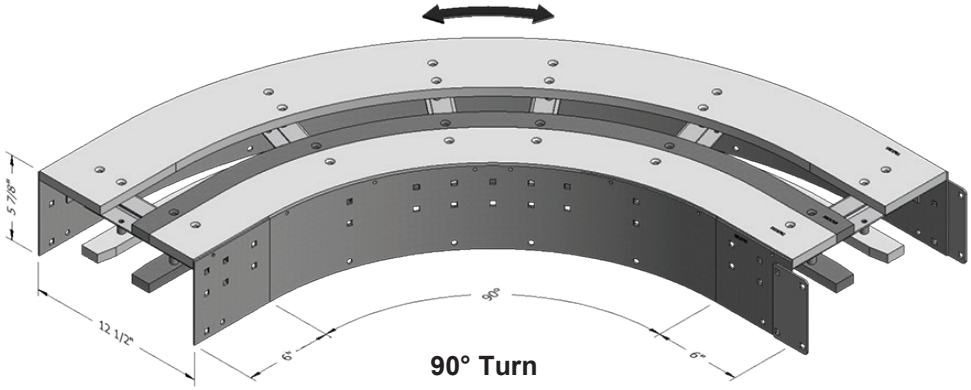
Turns

Standard Configurations	*Specifications*
• Available in 45° & 90° and 30° (not shown) • Slider on tab returns	• 24" center line radius • Support incline range ±0°

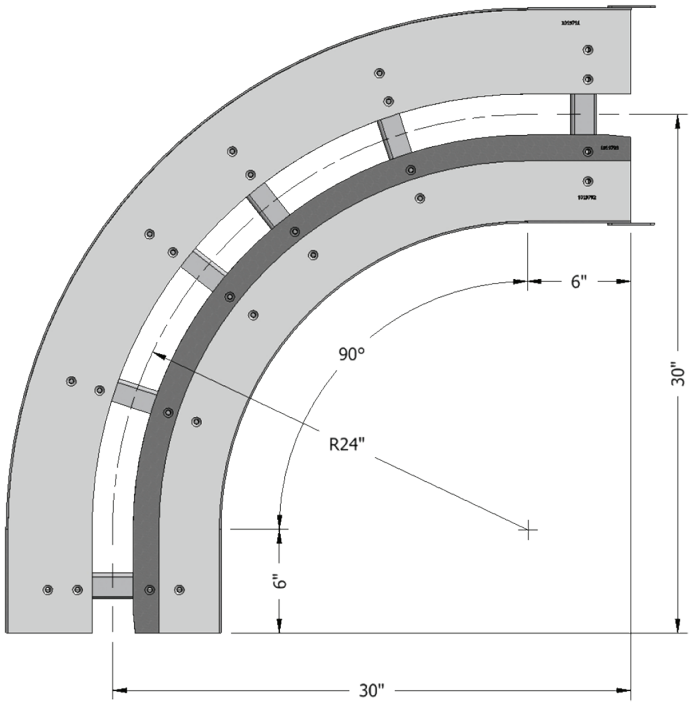


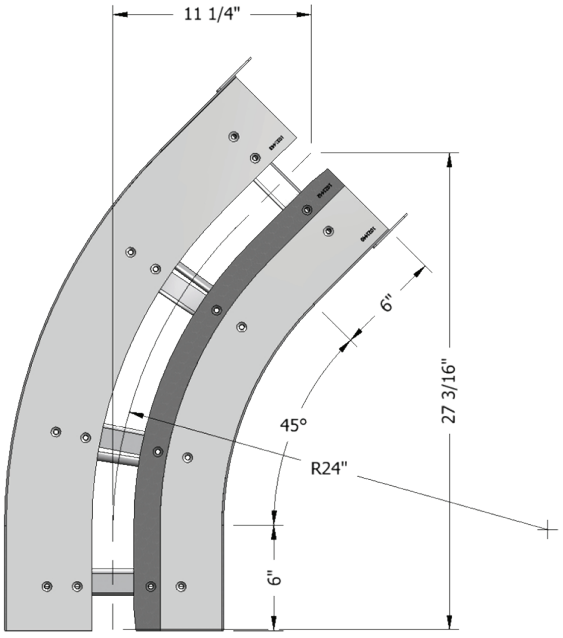


45° Turn



90° Turn

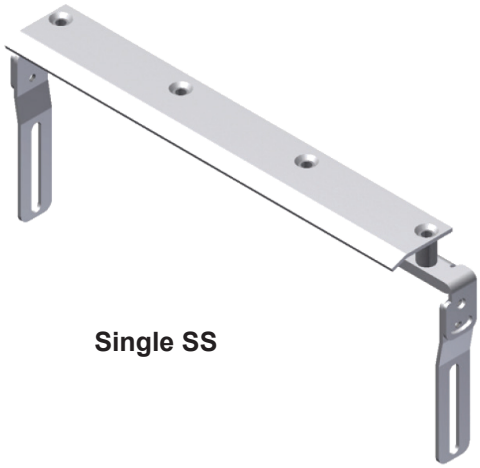




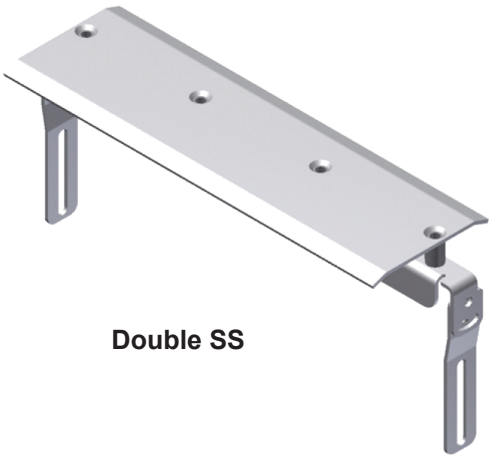
Part Specifications

End Transfers

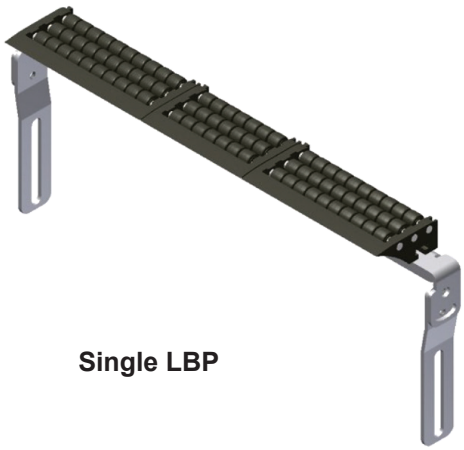
Standard Design	*Optional Design (Consult Factory)*
• Single & double LBP roller transfers • Single & double SS deadplate • Mounting brackets adjustable for angle and elevation	• Single roller transfer (not shown) • Bolt-on powered transfer (not shown)



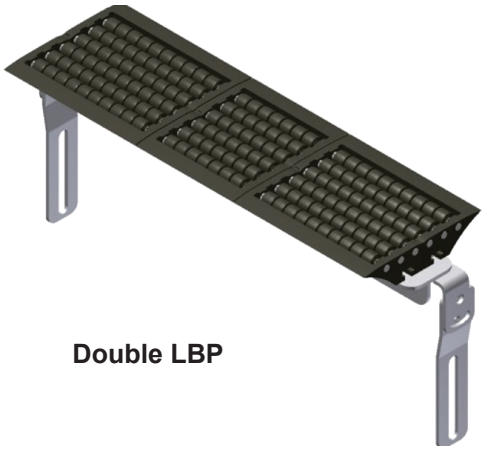
Single SS



Double SS



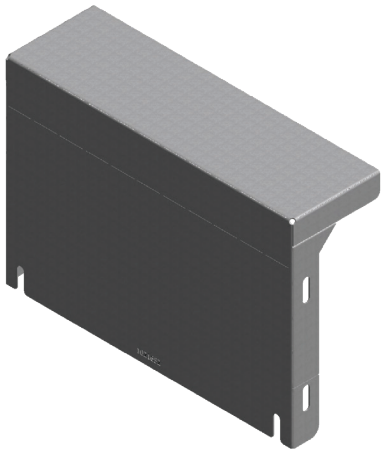
Single LBP



Double LBP

End Caps

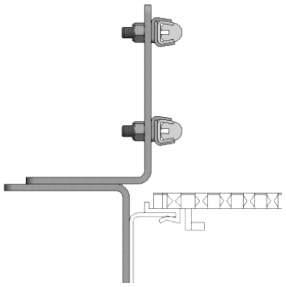
Standard Design
• 16 GA Mild & Stainless Steel • Standard on all drive, idle and transfer sections • Perforated edges allow manual removal of end cap segments for end transfers on drive/idle ends



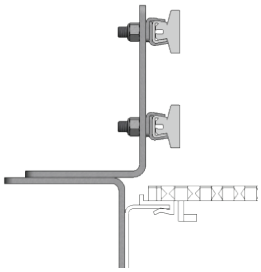
Part Specifications

Guide Rail

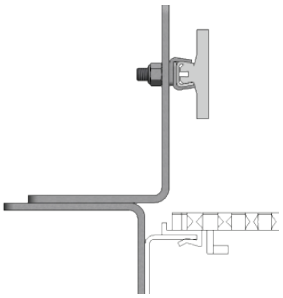
Standard Configurations (Illustrated below)	*Optional Configurations*
• Single high • Double high	• Sheet rail • UHMW



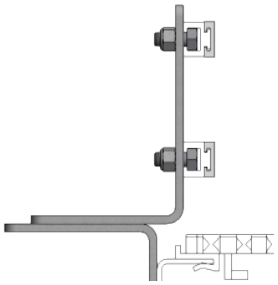
VG-SSR Round Face



VG-SST 1.25" T- Face



VG-SST 2.25" T- Face



Aluminum Channel w/UHMW Cover

Guide Rail Openings					
VG-SSR		**VG-SST**		**Alum. Channel**	
Min.	*Max.**	*Min.*	*Max.**	*Min.*	*Max.**
6⅞"	14⅝"	6⅝"	14⅜"	7⅛"	14⅞"
*Consult factory for wider openings					

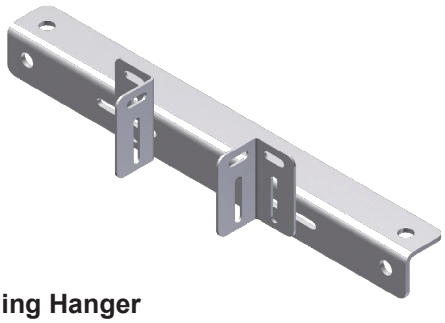
Bracket

Standard Configuration	*Optional Configurations*
• Adjustable formed "L" shaped brackets • 7 GA Mild or Stainless Steel ► Mild Steel is "Stardust Silver" powder coated painted	• Gusseted "L" shaped brackets • Molded plastic brackets • Tool-less adjust-ability

Supports

Standard Configuration	*Optional Configurations*
• "H" style formed 2"x 2" angled with bolt pad base • ±4 elevation change • Normal elevation range 22" - 50" • 7 GA Mild or Stainless Steel ► Mild Steel is "Stardust Silver" powder coated painted • Drop rods PROVIDED BY CUSTOMER	• Mild or Stainless Steel

Formed Angle



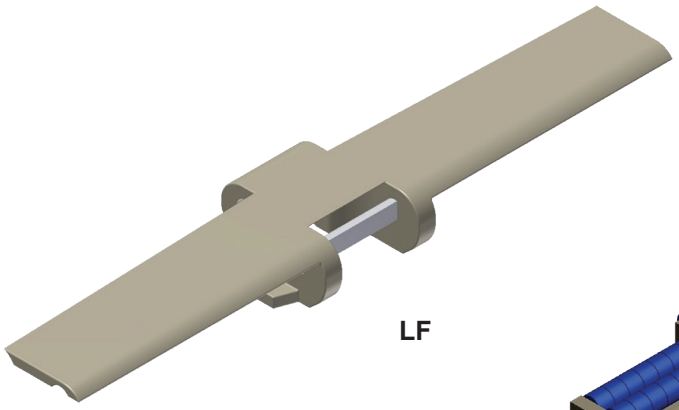
Ceiling Hanger

Part Specifications

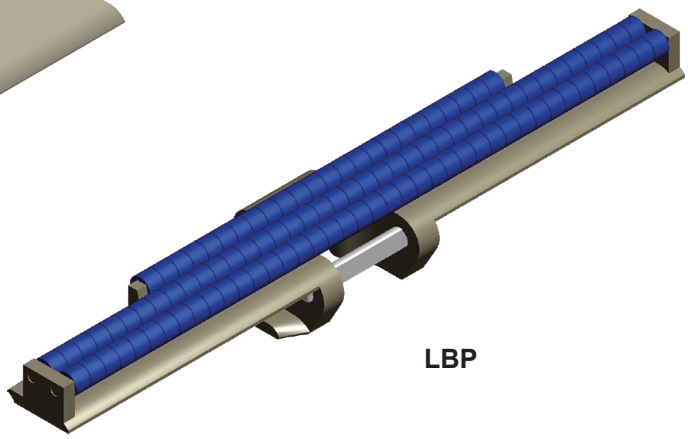
Tabletop Chain

Standard

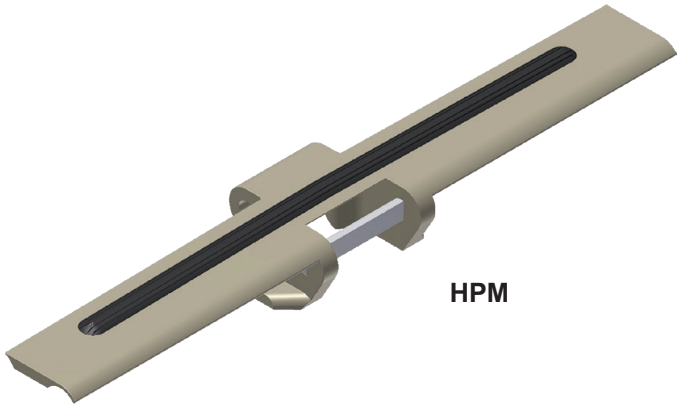
- LF882Tab-K12"
- HPM882Tab-K12" (Friction inserts)
  - ► Inserts every link
  - ► Inserts every other link
  - ► Inserts every 3rd link
- LBP882Tab-K12"



LF



LBP



HPM

Sprockets

Specifications

- Nylatron material
- Approx. 6.0" pitch diameter
- 882 sprocket

Maintenance Information

1. Pre-Start Checklist

- Fasteners - Some may have loosened during shipment. Re-tighten as required
- Inspect all splice points for proper wearstrip alignment
- Hand run a 48” long chain section through conveyor, both carryway 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

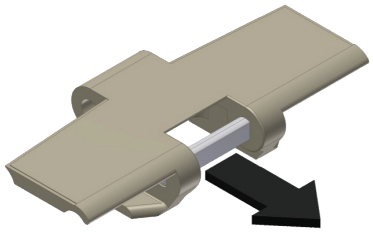


Figure 1

2. Start-up/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 - Normal occurring issue that subsides after the first 250 hours of run time. Clean as required

3. 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
  - ► Reducer - 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 (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 carryway (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

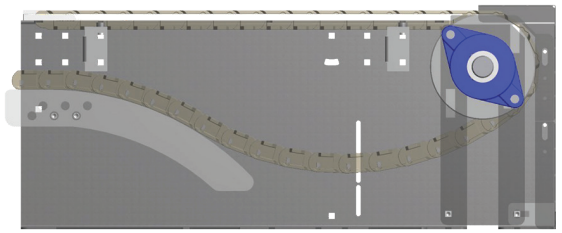


Figure 2

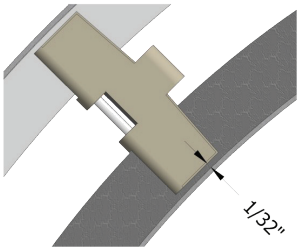


Figure 3

Warranty

MODULAR CONVEYOR EXPRESS WARRANTY

MODULAR CONVEYOR EXPRESS will repair or replace any products that have failed under normal use due to faulty material or defective workmanship for 1 year. Motors and chain carry the manufacturer's warranty. No other warranty is expressed or implied unless otherwise set forth in writing and approved by representative duly authorized to extend such approval by MODULAR CONVEYOR EXPRESS. All rights of design and invention are reserved.

1/3/2013

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