



partnered with



# **3.25", 4.5", 7.5"**

## **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	
	12 GA	Stainless Steel	#4 polish finish		
Standard Modules	Partss				
	<ul style="list-style-type: none"><li>• Idle ends</li><li>• Drive ends</li><li>• Center drives</li><li>• Standard turns</li><li>• Disc turns</li><li>• Intermediates</li><li>• Parallel &amp; Inline transfers</li><li>• Copes<ul style="list-style-type: none"><li>▶ Adjustable vertical turns</li></ul></li></ul>				
Wearstrips	Carryway	Carryway Options		Return	
	<ul style="list-style-type: none"><li>• 1⁄8” Thick UHMW in straights</li><li>• Turns:<ul style="list-style-type: none"><li>▶ UHMW outside</li><li>▶ Duravar inside &lt; 200 FPM</li></ul></li></ul>	Turns: Nylatron inside > 200 FPM		UHMW slider on tab in straights	
Motor/Reducer	Brand/Style	Voltage	Frame Body	Mounting	Options
	<ul style="list-style-type: none"><li>• Nord<ul style="list-style-type: none"><li>▶ "C" face motor</li><li>▶ Inverter-duty</li><li>▶ IP55</li></ul></li></ul>	230/460-3	Corrosion resistant aluminum	"C" face	<ul style="list-style-type: none"><li>• Below mount</li><li>• Washdown</li></ul>
	<ul style="list-style-type: none"><li>• Nord</li><li>• Hollow bore reducer</li></ul>	N/A	Corrosion resistant aluminum	Vertical shaft with torque arm	
Conveyor Speeds	Standard Nominal (FPM)	Minimum	Maximum		
	<ul style="list-style-type: none"><li>• 40</li><li>• 60</li><li>• 100</li><li>• 125</li><li>• 165</li><li>• 250</li><li>• 330</li></ul>	30 FPM*  *Speed obtained using a VFD	385 FPM*  *Speed obtained using a VFD		
Supports	Standard Style	Elevation Change	Elevation Range	Options	
	<ul style="list-style-type: none"><li>• “H” Formed 2”x2”</li><li>• Angled</li><li>• Bolt pad base</li></ul>	±2”	22" - 50"	<ul style="list-style-type: none"><li>• Ceiling hanger brackets</li></ul>	

## Conveyor Specifications

Bearings (Drive Ends)	Construction	Finish	Options
	<ul style="list-style-type: none"> <li>2-Hole flange</li> <li>Steel insert with set-screw</li> </ul>	<ul style="list-style-type: none"> <li>Painted</li> <li>Sealed for life</li> <li>General purpose lube</li> </ul>	<ul style="list-style-type: none"> <li>Polymer housing</li> <li>Food grade lube</li> <li>Zinc plated or Stainless Steel inserts</li> <li>Safety covers</li> </ul>
(Idle Ends)	<ul style="list-style-type: none"> <li>Stainless Steel bearings in hub of sprocket</li> </ul>		
Shafts	Diameter		
	<ul style="list-style-type: none"> <li>Idle = 1.0"</li> <li>Drive = 1.25"</li> </ul>		
Conveyor Accessories	Partss	Options	
	<ul style="list-style-type: none"> <li>Low Back Pressure (LBP) roller transfer</li> <li>Stainless Steel (SS) deadplate</li> </ul>	<ul style="list-style-type: none"> <li>Drip pans</li> <li>Tent covers</li> </ul>	
Guide Rail & Brackets		Tabletop Chains and Sprockets	
<ul style="list-style-type: none"> <li>See page 12</li> </ul>		<ul style="list-style-type: none"> <li>See page 13</li> </ul>	

## Part Specifications

### Drive End

#### Standard Configurations

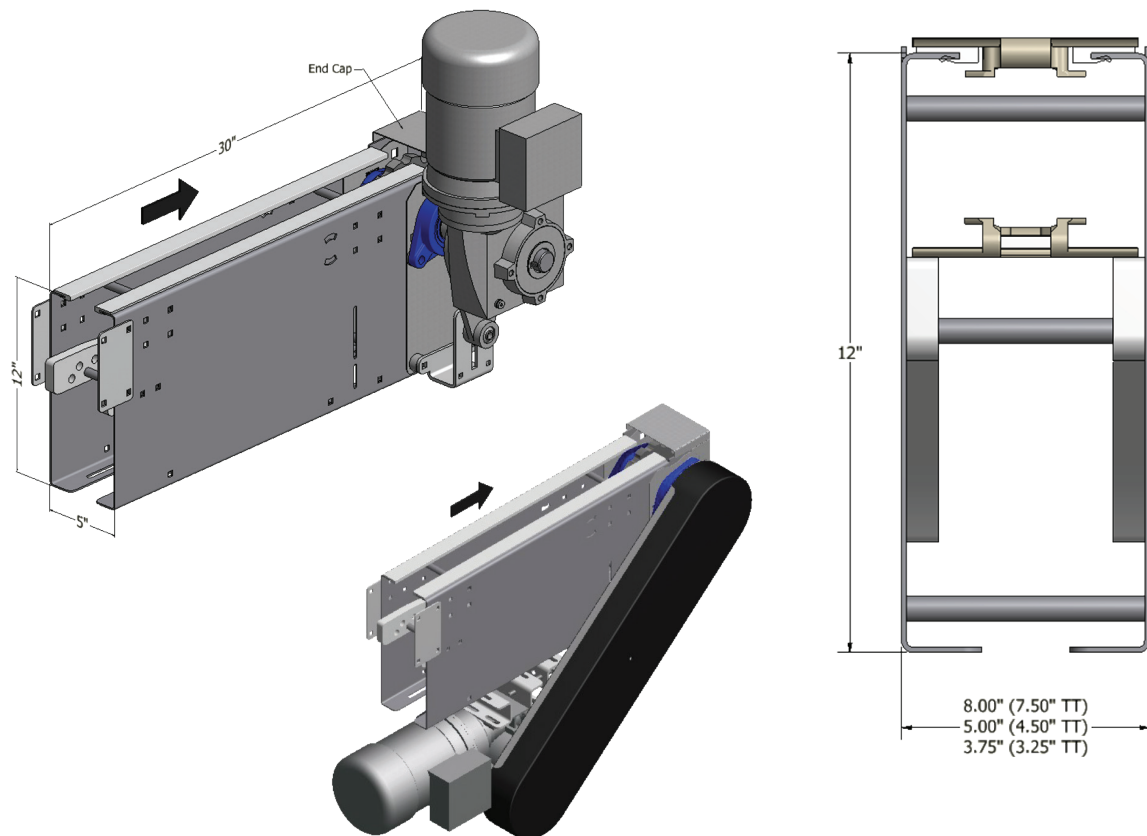
- Right-hand shaft mount (Illustrated below)
- Shaft mount includes torque arm
- End cap (finger guard) included

#### Optional Configurations

- Left-hand shaft mount
- Right or left-hand below mount (Illustrated below)

#### Specifications

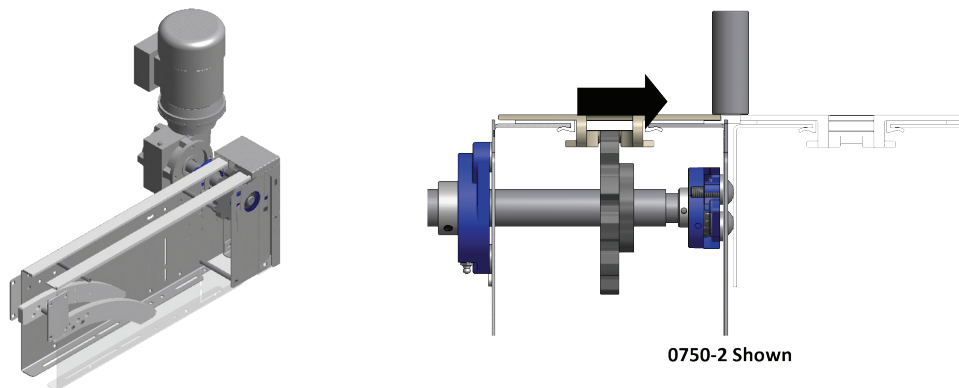
- See page 2 for standard speeds (FPM)
- Support incline range  $\pm 22^\circ$ 
  - **WARNING:** potential for product tipping and/or slipping at steep inclines



**Alternate Below Mount Configuration**

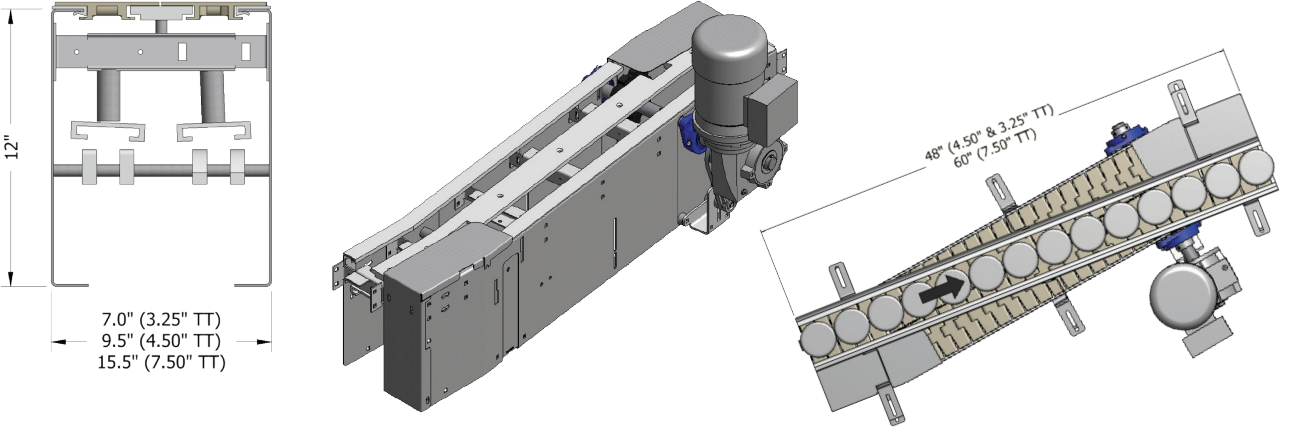
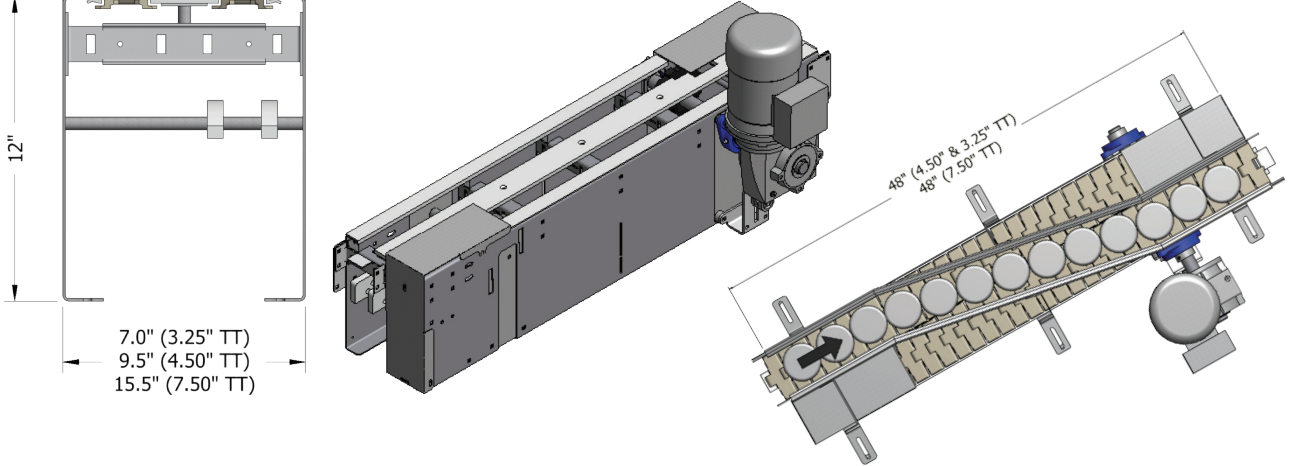
#### Side Transfer Configurations

- Left-hand and right-hand side transfer available
- Bearing installed on inside of frame on transfer side
- Carriage head bolt fasteners on both transfer sides
- Deadplate wearstrip included to fill the gap ( $11/16$ " 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

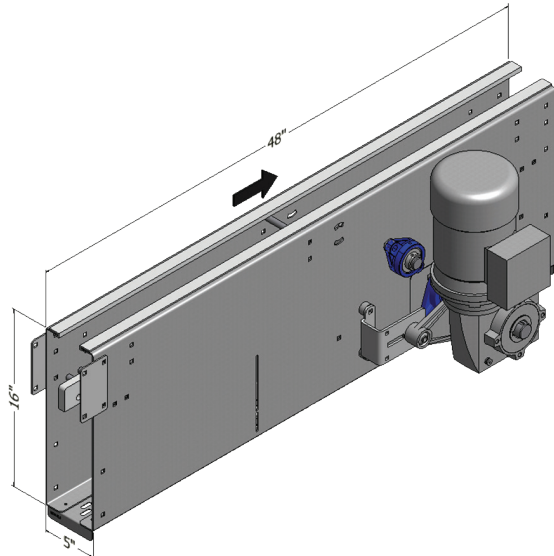
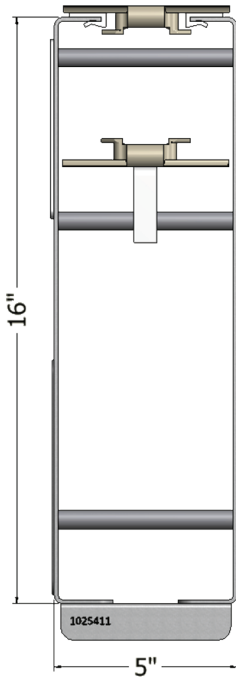
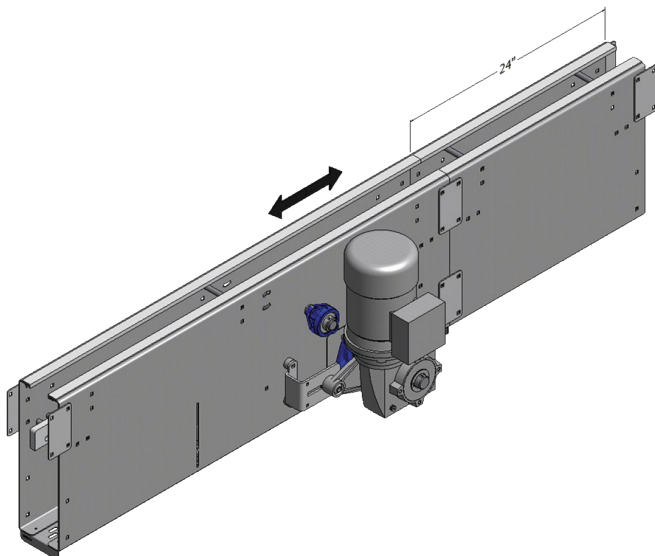


**0750-2 Shown**

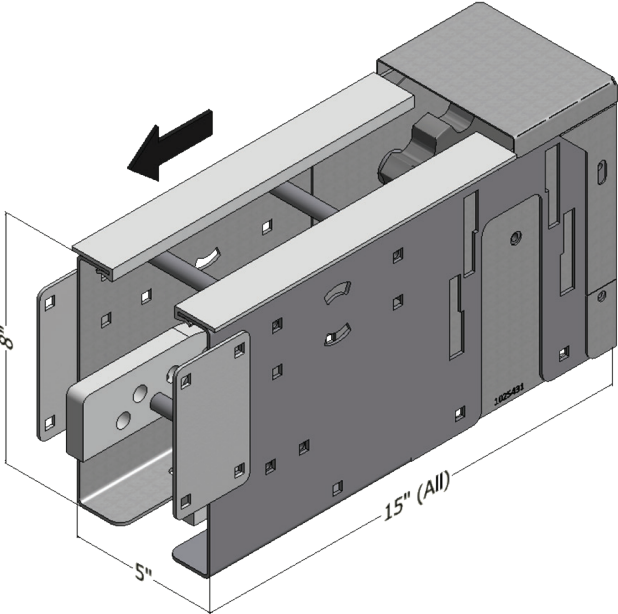
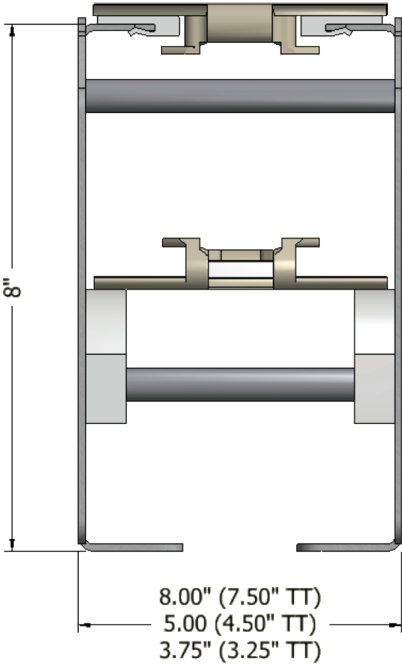
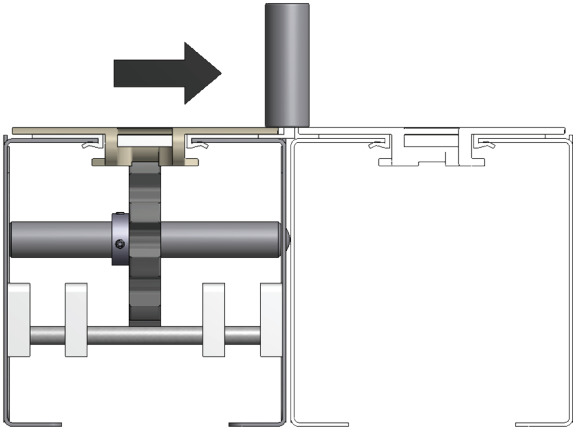
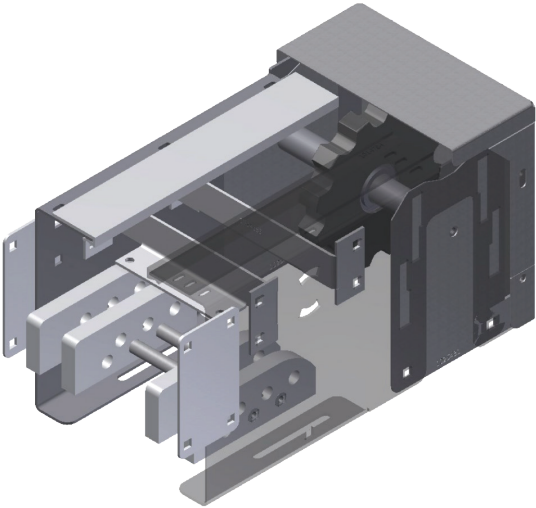
## Part Specifications

Inline Transfer	Standard Configurations	Optional Configurations	Advantages
	<ul style="list-style-type: none"> <li>Right-hand shaft mount (Illustrated below) <ul style="list-style-type: none"> <li>48" long section (3.25" &amp; 4.5" wide chains)</li> <li>60" long section (7.5" wide chain)</li> <li>Bearings: SS in hub of idle sprocket</li> </ul> </li> </ul>	Right-hand below mount	<ul style="list-style-type: none"> <li>Product travels in straight line</li> <li>Used when product stability is critical</li> <li>Provides smooth transfer</li> <li>Best transfer when using tent covers</li> </ul>
			
Parallel Transfer	Standard Configurations	Optional Configurations	Advantages
	<ul style="list-style-type: none"> <li>Left-to-right, right-hand shaft mount (Illustrated below) <ul style="list-style-type: none"> <li>48" long section (3.25" &amp; 4.5" wide chains)</li> <li>48" long section (7.5" wide chain)</li> <li>Bearings: SS in hub of idle sprocket</li> </ul> </li> </ul>	<ul style="list-style-type: none"> <li>Right-to-left Right-hand shaft mount</li> <li>Right-hand below mount</li> </ul>	<ul style="list-style-type: none"> <li>Used when product stability is not critical</li> <li>Helps reduce back pressure when accumulating</li> </ul>
			
Both Inline and Parallel	Additional Specifications (Inline & Parallel)		
	<ul style="list-style-type: none"> <li>Shaft mount will include torque arm</li> <li>End caps (finger guards) included</li> <li>Standard drive will be Right-hand (unless otherwise specified)</li> <li>Support incline range <math>\pm 22^\circ</math></li> <li>See page 2 for standard speeds (FPM)</li> </ul>		

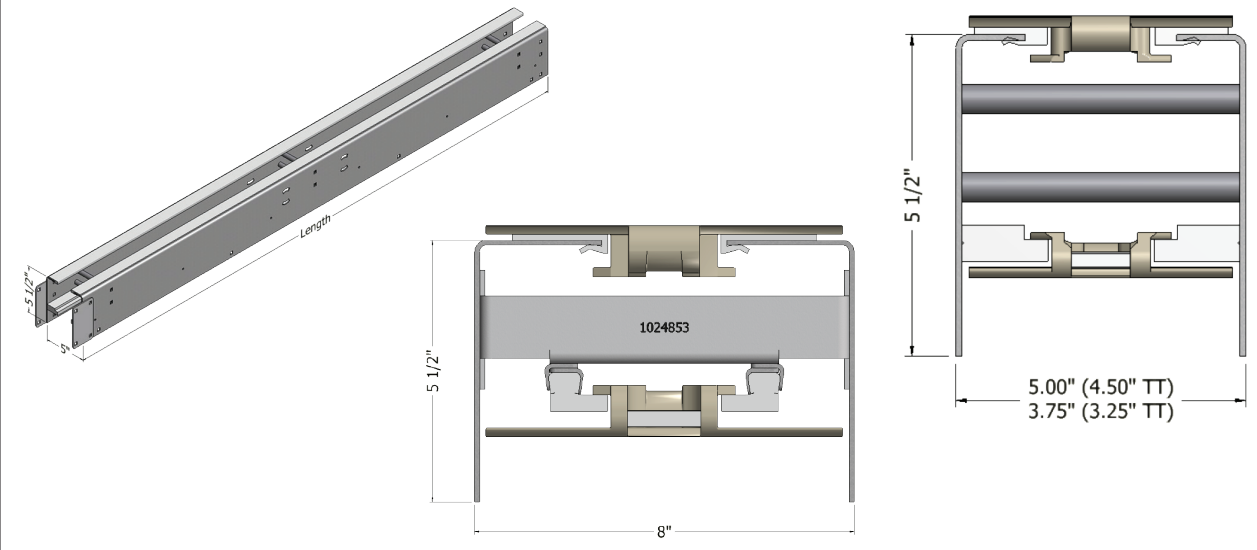
Part Specifications

Center Drive	Standard Configurations	Optional Configurations	Specifications
	<ul style="list-style-type: none"><li>• Right-hand shaft mount (Illustrated below)</li><li>• Standard drive is right-hand (unless otherwise specified)</li><li>• Shaft mount includes torque arm</li><li>• See page 2 for standard speeds (FPM)</li></ul>	<ul style="list-style-type: none"><li>• Left-hand shaft mount</li><li>• Below mount</li></ul>	<ul style="list-style-type: none"><li>• Support incline range <math>\pm 22^{\circ}</math></li><li>• NOT compatible with LBP style chain</li></ul>
	<div></div> <div></div>		
	Extension Specification		
24" long extension assembly allows the conveyor to be bi-directional			
<div></div>			

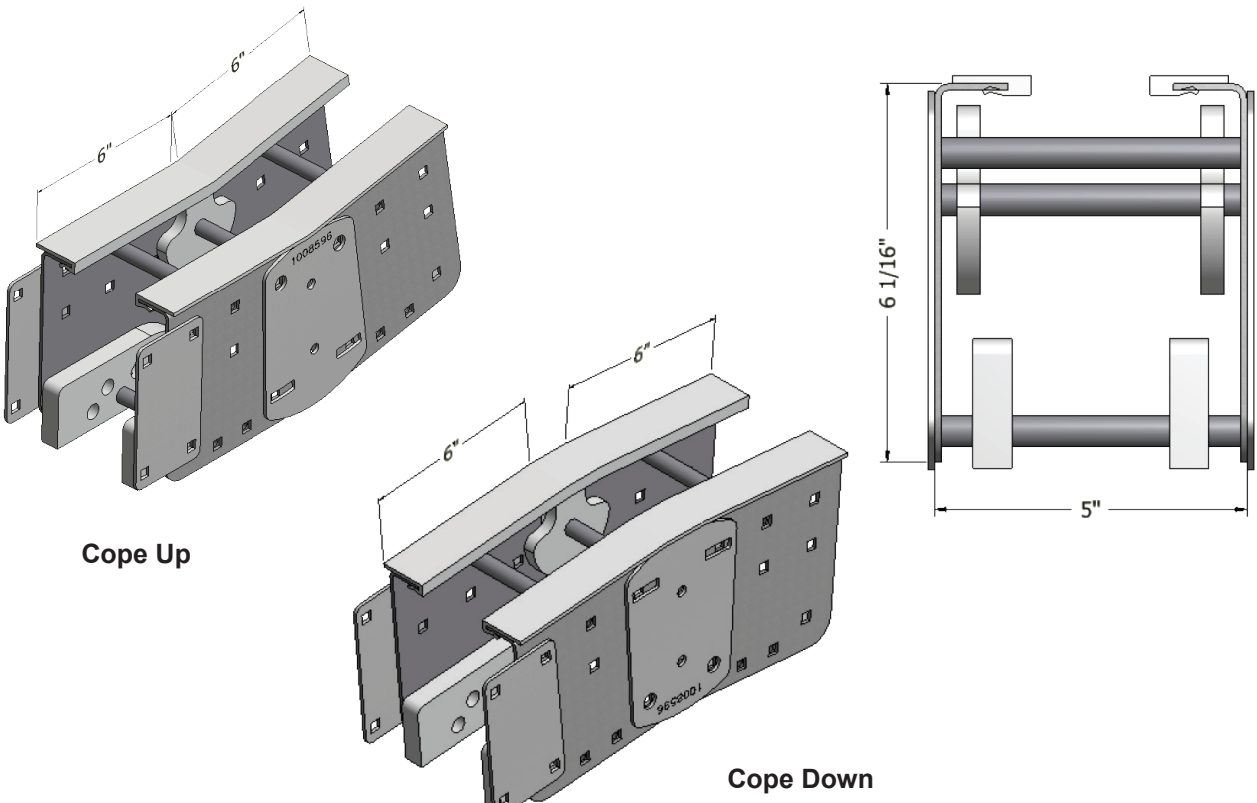
Part Specifications

Idle End	Standard Configurations	Optional Configurations	Specifications
	<ul style="list-style-type: none"><li>• Standard configuration (Shown below)</li><li>• End cap (finger guard) included</li></ul>	Right/Left-hand side transfer	Support incline range +22°
	<div></div> <div></div>		
	<div><p><i>Side Transfer Configurations</i></p><ul style="list-style-type: none"><li>• Standard design</li><li>• Bearing SS in hub of sprocket</li><li>• Button head cap screw fasteners on transfer side</li><li>• Deadplate wearstrip included to fill the gap (1/2") between chains (field trim to fit)</li><li>• Minimum typical product size to clear transfer is 1.5"<ul style="list-style-type: none"><li>▶ Product stability through transfer is affected by height &amp; base contour</li></ul></li></ul></div> <div></div> <div><p>0750-2 Shown</p></div> <div></div> <div><p>0750-2 Shown</p></div>		

Part Specifications

Intermediate	Available Standard Lengths	Specifications
	<ul style="list-style-type: none"><li>• 18"</li><li>• 36"</li><li>• 64"</li><li>• 92"</li><li>• 118"</li><li>• ½" increments from 6" to 41½"</li></ul>	Support incline range ±22°
		

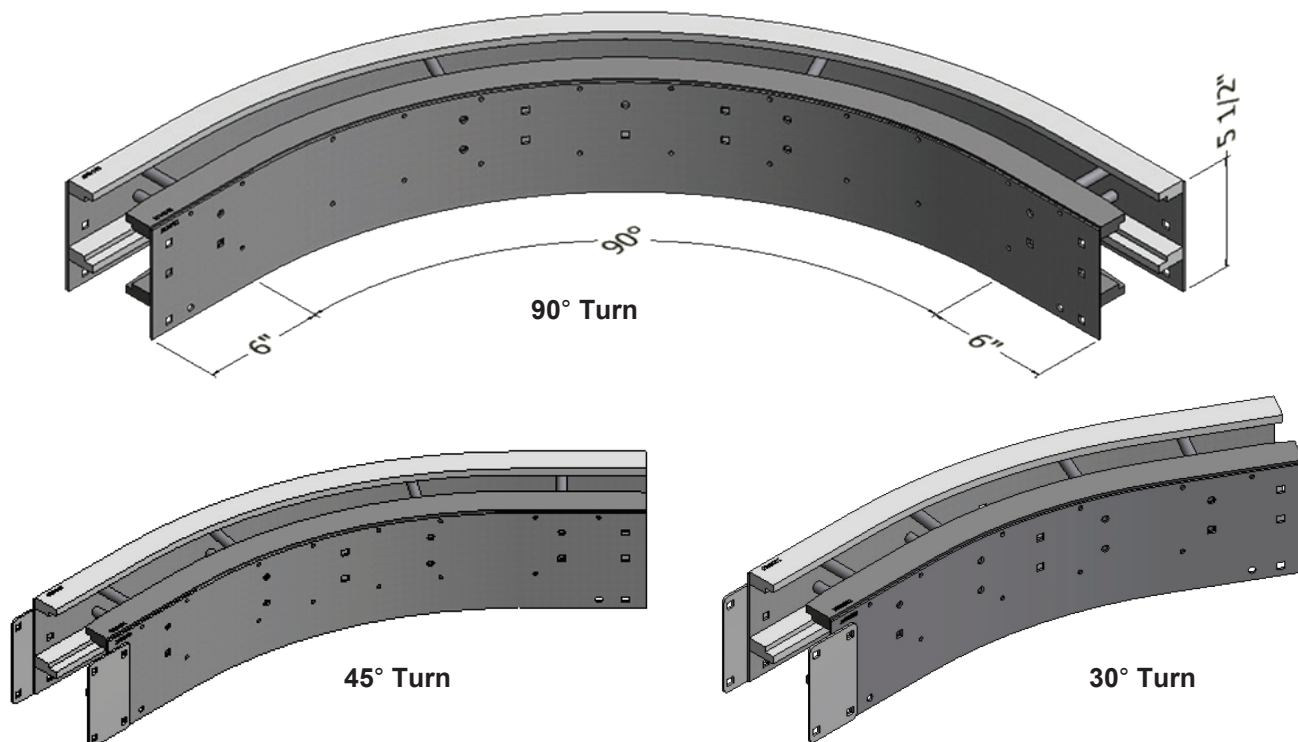
Cope  
(Adjustable  
Vertical  
Turns)

Specifications
<ul style="list-style-type: none"><li>• Copes are adjustable ±15°</li><li>• Use two copes for elevation changes between 15° and 30°<ul style="list-style-type: none"><li>▶ WARNING: potential for product tipping and/or slipping at steep inclines</li></ul></li></ul>


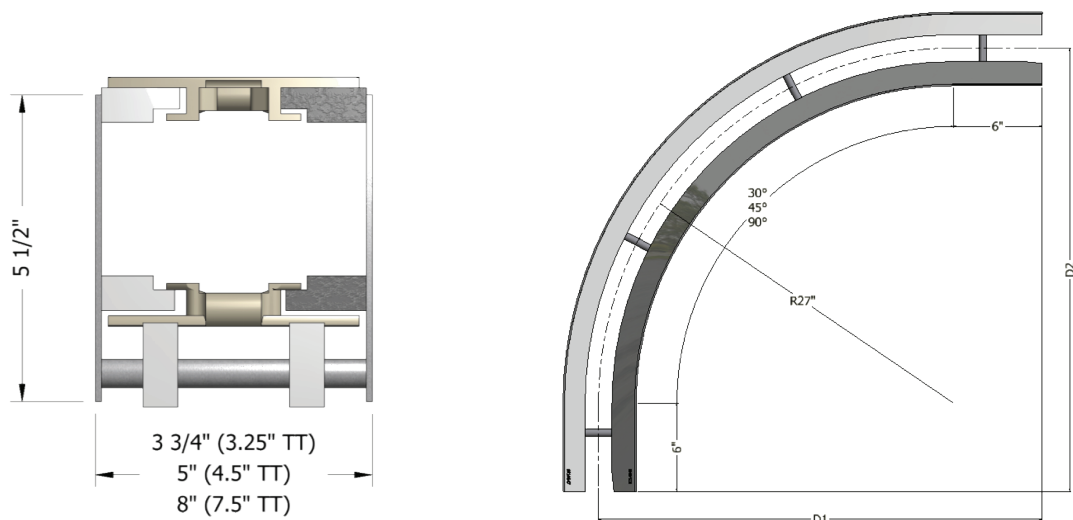


## Part Specifications

Turns	Standard Configurations	Optional Configurations	Specifications
	<ul style="list-style-type: none"> <li>4.5" wide (27" center line radius)</li> <li>7.5" wide (24" center line radius)</li> <li>3.25" wide (18" center line radius)</li> <li>6" straight tangents on both ends</li> <li>Inside wearstrip - Duravar &lt; 200 FPM</li> <li>Available in 30°, 45° &amp; 90°</li> <li>Slider on tab returns</li> </ul>	<ul style="list-style-type: none"> <li>Custom angled turns available (consult factory)</li> <li>Spiral incline/decline turns available (consult factory)</li> </ul>	<ul style="list-style-type: none"> <li>Support incline range <math>\pm 0^\circ</math> <ul style="list-style-type: none"> <li>Incline requires spiral turn design (consult factory)</li> </ul> </li> </ul>

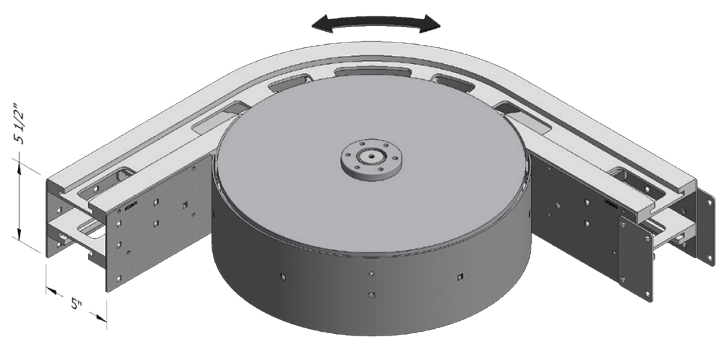


Width	R	30°		45°		90°	
		D1	D2	D1	D2	D1	D2
7.5"	24"	6 <sup>3</sup> / <sub>16</sub> "	23 <sup>3</sup> / <sub>16</sub> "	11 <sup>1</sup> / <sub>4</sub> "	27 <sup>3</sup> / <sub>16</sub> "	30"	30"
4.5"	27"	6 <sup>5</sup> / <sub>8</sub> "	14 <sup>5</sup> / <sub>8</sub> "	12 <sup>1</sup> / <sub>8</sub> "	29 <sup>5</sup> / <sub>16</sub> "	33"	33"
3.25"	18"	5 <sup>7</sup> / <sub>16</sub> "	20 <sup>3</sup> / <sub>16</sub> "	9 <sup>1</sup> / <sub>2</sub> "	23"	24"	24"

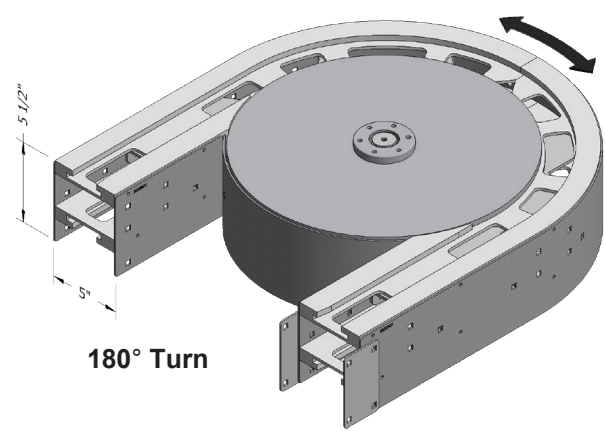


Part Specifications

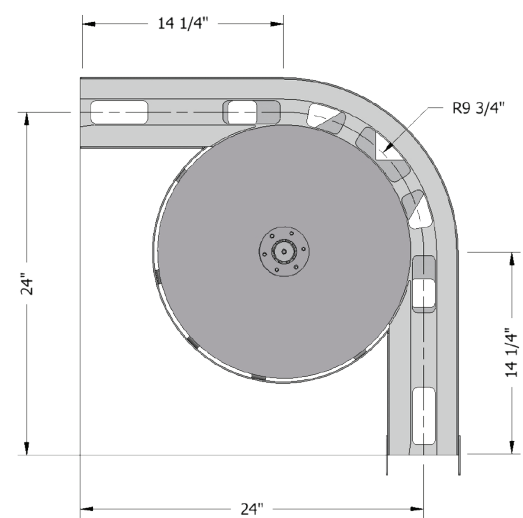
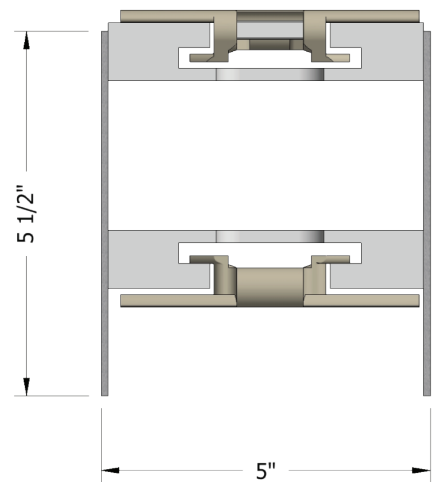
Disc Turns	Standard Configurations for 3.25" and 4.5" ONLY	Specifications
	<ul style="list-style-type: none"><li>• 4.5" wide (shown below)</li><li>• 3.25" wide</li><li>• Available in 90° &amp; 180°</li><li>• Requires BO tight radius tab chain (see page 13)</li></ul>	<ul style="list-style-type: none"><li>• 9.75" center line radius</li><li>• Support incline range <math>\pm 0^\circ</math></li></ul>



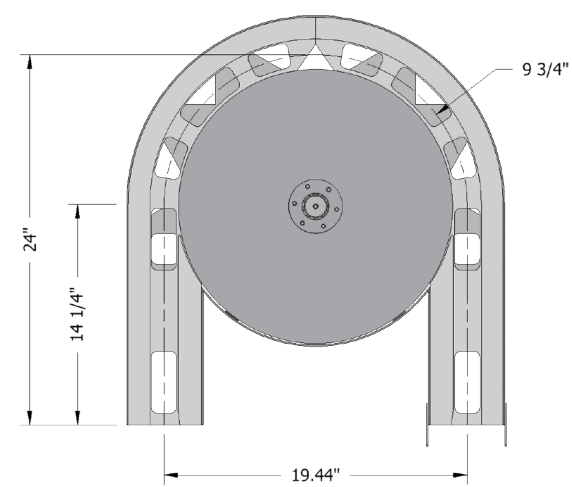
90° Turn



180° Turn

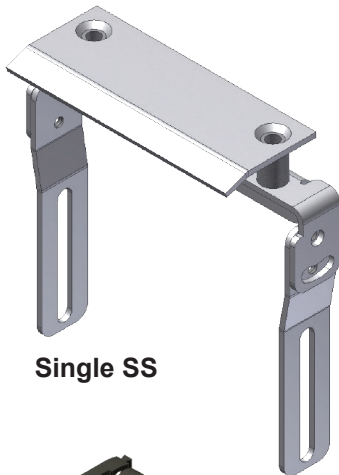
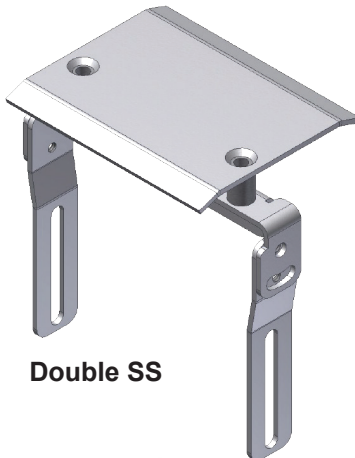
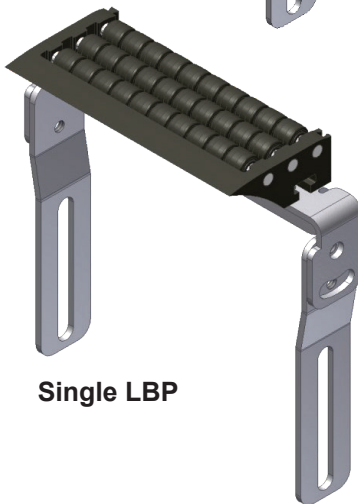
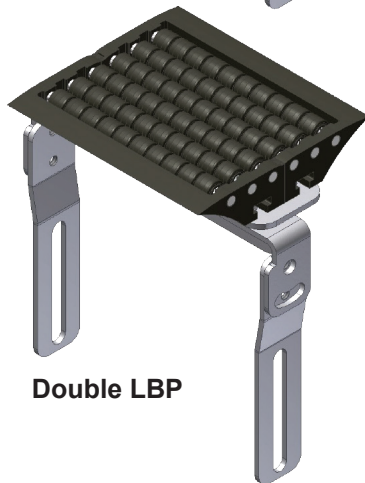



90° Turn



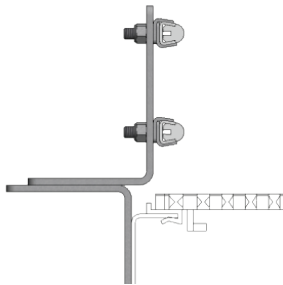
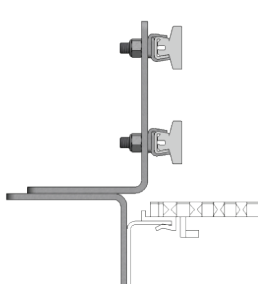
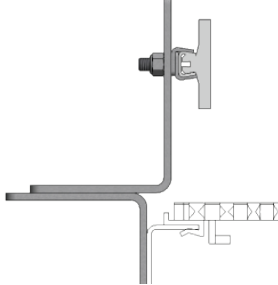
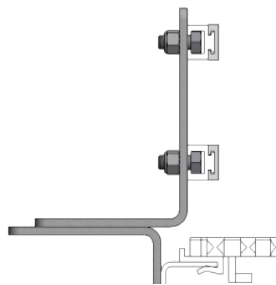
180° Turn


Part Specifications



End Transfers	Standard Design		Optional Design (Consult Factory)	
	<ul style="list-style-type: none"><li>• Single &amp; double LBP roller transfers</li><li>• Single &amp; double SS deadplate</li><li>• Mounting brackets adjustable for angle and elevation</li></ul>		<ul style="list-style-type: none"><li>• Single roller transfer (not shown)</li><li>• Bolt-on powered transfer (not shown)</li></ul>	
	<div><div><p>Single SS</p></div><div><p>Double SS</p></div><div><p>Single LBP</p></div><div><p>Double LBP</p></div></div>			

End Caps	Standard Design		
	<ul style="list-style-type: none"><li>• 16 GA Mild &amp; Stainless Steel</li><li>• Standard on all drive, idle and transfer sections</li><li>• Perforated edges allow manual removal of end cap segments for end transfers on drive/idle ends</li></ul>		
			

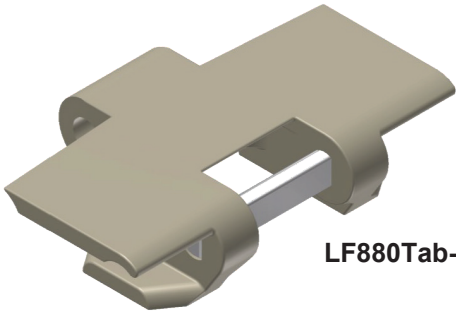
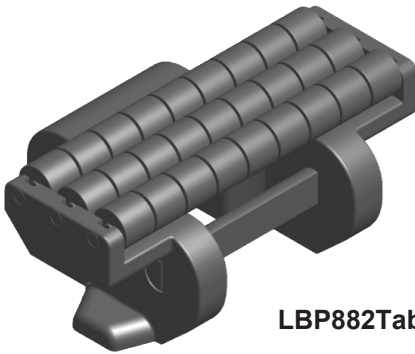
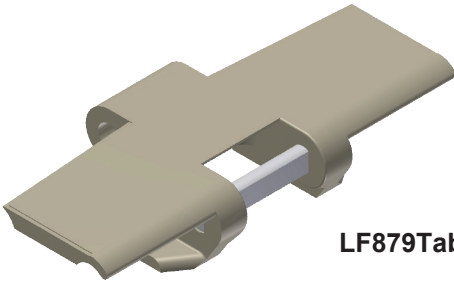
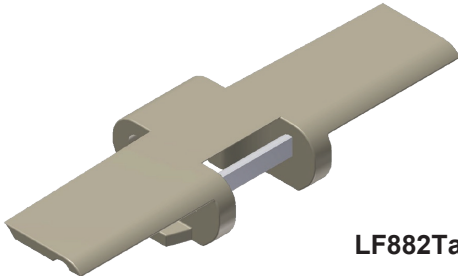
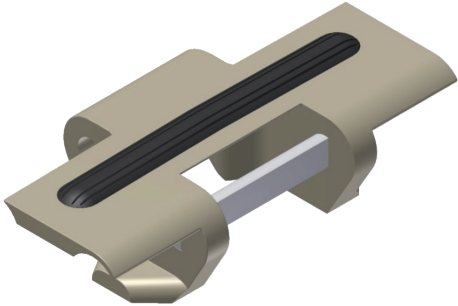
## Part Specifications



Guide Rail	Standard Configurations (Illustrated below)				Optional Configurations																																										
	<ul style="list-style-type: none"><li>• Single high</li><li>• Double high</li></ul>				<ul style="list-style-type: none"><li>• Sheet rail</li><li>• UHMW</li></ul>																																										
																																															
	VG-SSR Round Face	VG-SST 1.25" T- Face	VG-SST 2.25" T- Face	Aluminum Channel w/UHMW Cover																																											
	<table><thead><tr><th></th><th colspan="6">Guide Rail Openings</th></tr><tr><th></th><th colspan="2">VG-SSR</th><th colspan="2">VG-SST</th><th colspan="2">Alum. Channel</th></tr><tr><th>Width</th><th>Min.</th><th>Max.*</th><th>Min.</th><th>Max.*</th><th>Min.</th><th>Max.*</th></tr></thead><tbody><tr><td>3.25"</td><td>0"</td><td>5<sup>7</sup>/<sub>8</sub>"</td><td>0"</td><td>5<sup>5</sup>/<sub>8</sub>"</td><td>0"</td><td>6<sup>1</sup>/<sub>8</sub>"</td></tr><tr><td>4.5"</td><td>0"</td><td>7<sup>1</sup>/<sub>8</sub>"</td><td>0"</td><td>6<sup>7</sup>/<sub>8</sub>"</td><td>0"</td><td>7<sup>3</sup>/<sub>8</sub>"</td></tr><tr><td>7.5"</td><td>2<sup>3</sup>/<sub>8</sub>"</td><td>10<sup>1</sup>/<sub>8</sub>"</td><td>2<sup>1</sup>/<sub>8</sub>"</td><td>9<sup>7</sup>/<sub>8</sub>"</td><td>2<sup>5</sup>/<sub>8</sub>"</td><td>10<sup>3</sup>/<sub>8</sub>"</td></tr></tbody></table> <p>*Consult factory for wider openings</p>							Guide Rail Openings							VG-SSR		VG-SST		Alum. Channel		Width	Min.	Max.*	Min.	Max.*	Min.	Max.*	3.25"	0"	5 <sup>7</sup> / <sub>8</sub> "	0"	5 <sup>5</sup> / <sub>8</sub> "	0"	6 <sup>1</sup> / <sub>8</sub> "	4.5"	0"	7 <sup>1</sup> / <sub>8</sub> "	0"	6 <sup>7</sup> / <sub>8</sub> "	0"	7 <sup>3</sup> / <sub>8</sub> "	7.5"	2 <sup>3</sup> / <sub>8</sub> "	10 <sup>1</sup> / <sub>8</sub> "	2 <sup>1</sup> / <sub>8</sub> "	9 <sup>7</sup> / <sub>8</sub> "	2 <sup>5</sup> / <sub>8</sub> "
	Guide Rail Openings																																														
	VG-SSR		VG-SST		Alum. Channel																																										
Width	Min.	Max.*	Min.	Max.*	Min.	Max.*																																									
3.25"	0"	5 <sup>7</sup> / <sub>8</sub> "	0"	5 <sup>5</sup> / <sub>8</sub> "	0"	6 <sup>1</sup> / <sub>8</sub> "																																									
4.5"	0"	7 <sup>1</sup> / <sub>8</sub> "	0"	6 <sup>7</sup> / <sub>8</sub> "	0"	7 <sup>3</sup> / <sub>8</sub> "																																									
7.5"	2 <sup>3</sup> / <sub>8</sub> "	10 <sup>1</sup> / <sub>8</sub> "	2 <sup>1</sup> / <sub>8</sub> "	9 <sup>7</sup> / <sub>8</sub> "	2 <sup>5</sup> / <sub>8</sub> "	10 <sup>3</sup> / <sub>8</sub> "																																									

Bracket	Standard Configuration		Optional Configurations	
	<ul style="list-style-type: none"><li>• Adjustable formed "L" shaped brackets</li><li>• 7 GA Mild or Stainless Steel<ul style="list-style-type: none"><li>▶ Mild steel is "Stardust Silver" powder coated painted</li></ul></li></ul>		<ul style="list-style-type: none"><li>• Gusseted "L" shaped brackets</li><li>• Molded plastic brackets</li><li>• Tool-less adjust-ability</li></ul>	
				

Supports	Standard Configuration	Optional Configurations	
	<ul style="list-style-type: none"><li>• "H" style formed 2"x 2" angled with bolt pad base</li><li>• ±2 Elevation change</li><li>• Normal elevation range 22" - 50",</li><li>• 7 GA Mild or Stainless Steel<ul style="list-style-type: none"><li>▶ Mild steel is "Stardust Silver" powder coated painted</li></ul></li></ul>	<ul style="list-style-type: none"><li>• Mild or Stainless Steel</li><li>• Drop rods NOT provided</li></ul>	
	 Formed Angle	 Ceiling Hanger	

## Part Specifications

Tabletop Chain	Standard	Optional
	<ul style="list-style-type: none"> <li>• LF882Tab-K7.5"</li> <li>• LF879Tab-K4.5"</li> <li>• LF879/880Tab-K3.25"</li> </ul>	<ul style="list-style-type: none"> <li>• LF880Tab BO-K3.25"</li> <li>• LF880Tab BO-K4.5"</li> <li>• HPM882Tab-K4.5" w/Friction inserts</li> <li>• HPM882Tab-K7.5" w/Friction inserts</li> <li>• LBP882Tab-K3.25" w/Low back pressure rollers</li> <li>• LBP882Tab-K7.5" w/Low back pressure rollers</li> </ul>
	<div>  <p>LF880Tab-3.25"</p>  <p>LBP882Tab-3.25"</p>  <p>LF879Tab-4.5"</p>  <p>LF882Tab-7.5"</p>  <p>HPM882Tab-K4.5"</p> </div>	

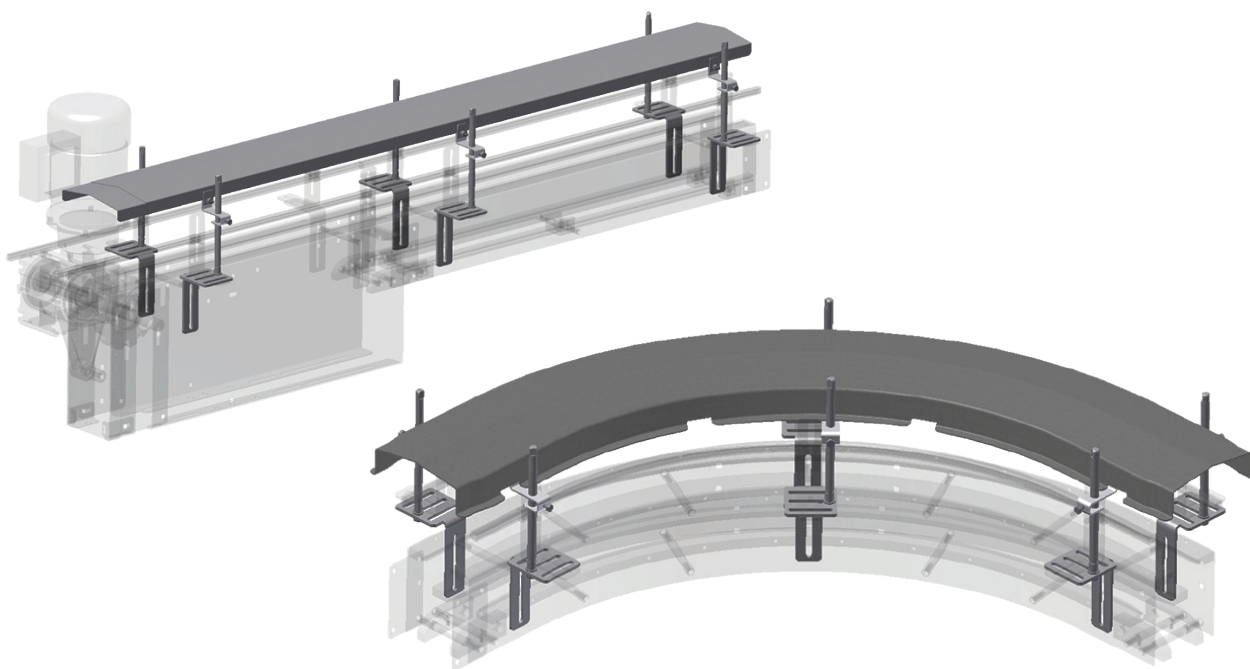
Sprockets	Specifications
	<ul style="list-style-type: none"> <li>• Nylatron material</li> <li>• Approx. 6.0" pitch diameter</li> <li>• 880 Sprocket for 879Tab-K4.5" &amp; 879/880Tab-K3.25"</li> <li>• 882 Sprocket for 882Tab-K7.5"</li> </ul>
	<div>  <p>Drive Sprocket</p>  <p>Idle Sprocket</p> </div>

## Part Specifications

### Tent Covers

*Standard for 3.25" and 4.5" ONLY*

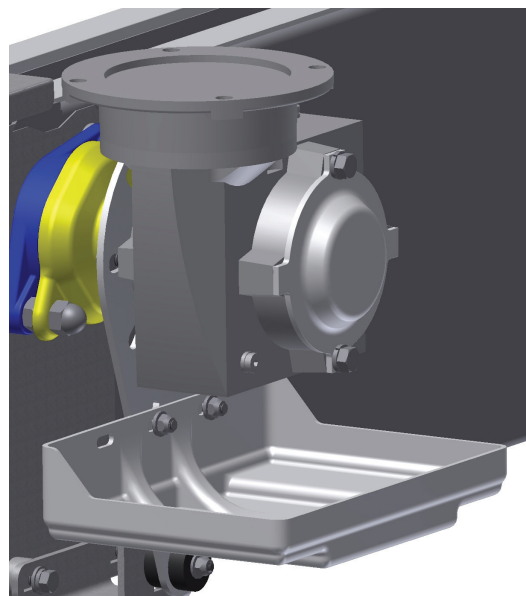
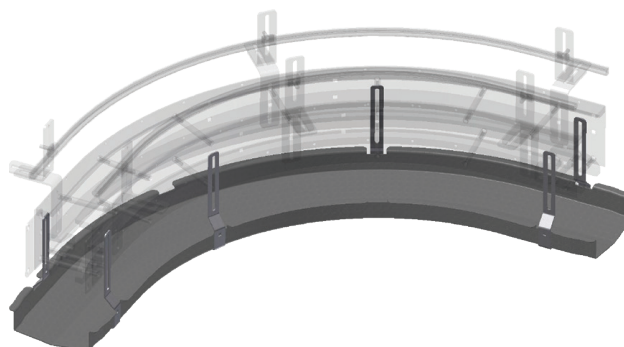
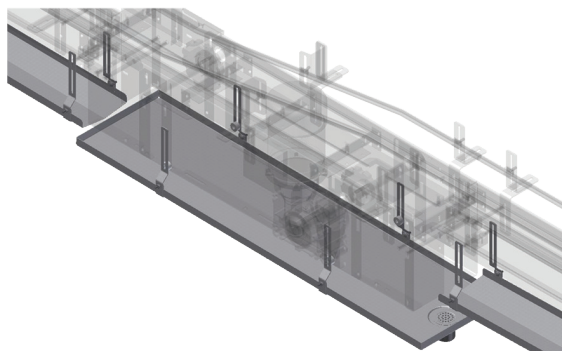
- 18 GA Stainless Steel (straight & transfers)
  - Standard 60" length designed for unlimited overlap
- Molded plastic (24" radius turns only)
- Height adjustable brackets w/compression clips (no holes to drill)



### Drip Pans

*Standard for all chain widths when conveyor is not floor mounted or upon request*

Drain coupling provided on drip pans



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



# Maintenance Information

## 1. Pre-Start Checklist

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

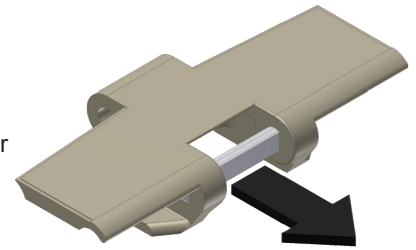


Figure 1

## 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  $\frac{1}{32}$ " 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

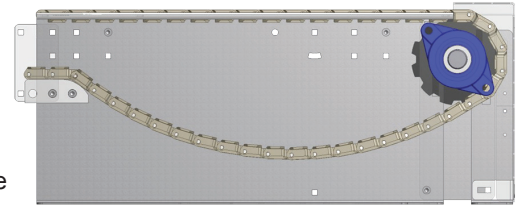


Figure 2

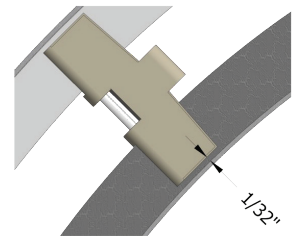


Figure 3

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

## 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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